

Lathe Profile developing blog

m5_turning_func.h

```
check_m5_encoder()
{
    count=200;
    do
    {
        a=gvarget(9048+enumber); //Encoder; 9048+enumber
        timer=5; do { timer--; } while (timer>0);
        b=gvarget(9048+enumber); //Encoder; 9048+enumber
        if (a==b) { count=0; };
    } while (count>0);
};

m19_encoder_stop()
{
    timer=0;
    timeout=timer+3000;
    do
    {
        timer++;
        a=gvarget(9048+enumber); //Enc Position relative to Z-label
        if (a<0) {a+=emax;};

        delta=a-stop_position;
        if (delta<eposition)
        {
            m=0-eposition;
            if (delta>m) { timer=timeout+1; };
        };
    } while (timer<timeout);
};
```

m5_turning_et10_func.h

```
m5_et10()
{
    pwm02=0;

    speed=0;
    channel=2;
    message=PLCCMD_SET_CNC_EXTVAR;
```

```
command=0x32;
parameter=1988+speed+(channel<<12);
timer=10;do{timer--;}while(timer>0);
};

et10_slow_speed()
{

speed=200;
channel=2;
message=PLCCMD_SET_CNC_EXTVAR;
command=0x32;
parameter=1988+speed+(channel<<12);
timer=500;do{timer--;}while(timer>0);

};
```

M05.plc

```
//Spindle Stop
#define command    var00
#define parameter var01

#include pins.h

#include m5_turning_et10_func.h
#include m5_turning_func.h

main()
{

    if (gvarget(8265)!=0)    //8265
    {
        //modbus_slow_speed();
        et10_slow_speed();

        enumber=1; //Encoder ID number
        emax=8192;
        eposition=20;
        stop_position=3000;

        m19_encoder_stop();
    };

    m5_et10();
    //m5_modbus();

    proc=plc_proc_idle;
```

```
check_m5_encoder();

gvarset(7370,0); timer=30;do{timer--;}while (timer>0); //Spindle
State

exit(99);    //normal exit
};
```

M03.plc

```
//Turn on Spindle clockwise

#include pins.h
#include vars.h

#include turning_func.h

main()
{
    speed=eparam;

    gvarset(7370,1); timer=30;do{timer--;}while (timer>0); //Spindle
State
    gvarset(7371,eparam); timer=30;do{timer--;}while (timer>0); //Spindle
Speed Mirror register

    //check_shoulder();
    proc=plc_proc_spindle;

    //m3_modbus();
    m3_et10();

    check_m3_encoder();

    exit(99);
};
```

From:
<http://docs.pv-automation.com/> - **myCNC Online Documentation**

Permanent link:
<http://docs.pv-automation.com/examples/plasma-x1366l>

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