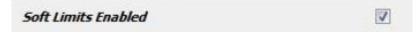
Limits

μ (22:46:19) myCNC control software. Ver:1.88.2	176- [lb-shape-012.nc]	Soft limits 1 on/off		
CNC Settings Axes/Motors Network	Soft Limits Enabled Soft Limits	Limit Switch -	Limit Switch +	
Image: Software PLC Software PLC Grodes settings DXF import settings Macro Uits Macro Witard Proferences Software Parking Coordnates Parking Coordnates Inputs/outputs/Sensors Alarmos Inputs/outputs/Sensors ADC Mapping -AOC Mapping Connections Technology Camera	Min Limit Max Limit X 0 3010 Y 0 1510 Z -300 0 A - B - C - U - V -	7 9 ** Normally dosed V R 6 ** Normally dosed V F 4 ** Normally dosed V F 0 ** Normally dosed V F 0 ** Normally opened V F	7 8 4 Normally closed ▼ 10 4 Normally closed ▼ 4 4 Normally closed ▼ 0 4 Normally closed ▼ 0 4 Normally opened ▼	Hard limits activation
5 axes RTCP	Slow down distance X 50	Y 50 Z 20	A 5 B 5	C 5
Hardware Hardware	Slow down value, % X 20	🕂 Y 20 🕂 Z 20	🕂 A 20 🕂 B 20	🛨 C 20 🛨
	<u>↑</u>			
Turn on and off for each axis	Percentage reduction of Setting the coordinates after			
Enabling function «Jog slow down when limits are triggered				×

Soft Limits Enabled

- "Soft Limits Enabled" this function allows you to set a software limit on the movement of the machine, as well as install and configure hard limit switches for each of the axes.
- To activate the function "Soft Limits Enabled" , it is necessary to check the box next to its name:



• To set the limits for each of the axes, you must check the selected axis. The photo shows an example of the choice of this function for the "X". With the parameters MihLimit = 0 and MaxLimit = 3010, the machine will move along the X axis only within the specified coordinates, i.e. from 0 to 3010.

Soft Limits	Enable	ed			1	V
			Soft Limit	5		
			Min Limit		Max Limit	
x	V	0		3010		

• If there are mechanical limits on the machine, the type of the limit switch and the input number for this switch on the controller is set as shown in the example below.

Soft Limits Enabled		V			
	Soft Limits			Limit Switch -	Limit Switch +
	Min Limit	Max Limit			
x 🔽 o	3010		5	Normally closed 🔻	▼ 8 ▼ Normally closed ▼

For example, the minus limit sensor is applied to the controller input 5, and the positive limit sensor is applied to the 8 input of the controller. Both shoots are normally closed.

• The sensor type is selected as shown below.

oft Limit	s Enab	led		V								
		50	oft Limits			Li	mit Switch -				Limit Switch +	
		r	Min Limit	Max Limit								
x		0	3010		5	* *	Normally closed	•		8	Normally closed	
Y		0	1510		6	A V	Normally opened			10	Normally opened	1
		-300			mG	A.	Normally closed	-		a [Normally closed	-
z ne sett			axes (X, Y, I	Z) is given k	belov		Normally closed	*		4	 Normany closed 	
	ing o	f several		Z) is given t			I Informativ Closed			4	Normany closed	
ne sett	ing o	f several <i>led</i>		-		N	nit Switch -				mit Switch +	
ne sett	ing o	f several Ied 50	axes (X, Y, I	-		N						
ne sett	ing o s Enabl	f several Ied 50	axes (X, Y, 1	▼ Max Limit		N		•	8	Lii		•
ne sett <i>Soft Limit</i>	ing o s Enabl	f several <i>led</i> 50	axes (X, Y, I <i>ft Limits</i> lin Limit	Max Limit	belov	N Lin	nit Switch -	=		Lin	nit Switch +	•

Jog slow down

- Function "Jog slow down" when this function is activated, the machine during the movement will reduce the speed at the entrance to the above specified software limits. The distance at which the speed decreases and the percentage reduction in speed is set in the corresponding table.
- To activate the function "Jog slow down", it is necessary to check the box next to its name:

	Jog slow down										V							
 The example below sh 	nows the setti	ng c	of the	f	unct	ion fo	or	sev	eral a	эх	es (X,	Υ,	Ζ,	, A, E	3)			
Jog slow down																		
Slow down distance	x	50		Y	50		Z	20		A	5		в	5		С	5	
Slow down value, %	x	20	×	Y	20	×	z	20	×	A	20	*	в	20	×	С	20	×

• Taking into account the settings of software limits and settings of the function, the machine will move with a speed reduced to 20% in the coordinates from 0 to 50 (0 + 50) and from 2960 to 3010 (2960 + 50 = 3010). Similarly, when moving along the coordinate Y in coordinates from 0 to 50 (0 + 50) and from 1460 to 1510 (1460 + 50 = 1510) it will move with a speed reduced to 20%.

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In the same way, when moving along the coordinate Z, in the coordinates from -300 to -280 (-300 + 20 = -280) and from -20 to 0 (0-20 = -20) it will move with a speed reduced to 20%.

	mits Enabled Soft Limits				Lin	nit Switch -		Limit Switch +						
			Min Limit	Max Limit										
X		0	301	10		5	(A) (V)	Normally closed	•		8	(A) (V)	Normally closed	-
Y	V	0	151	10		6	*	Normally closed	•		10	A V	Normally opened	-
Z	V	-300	0		V	4	¥	Normally closed	•	V	4		Normally closed	-

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