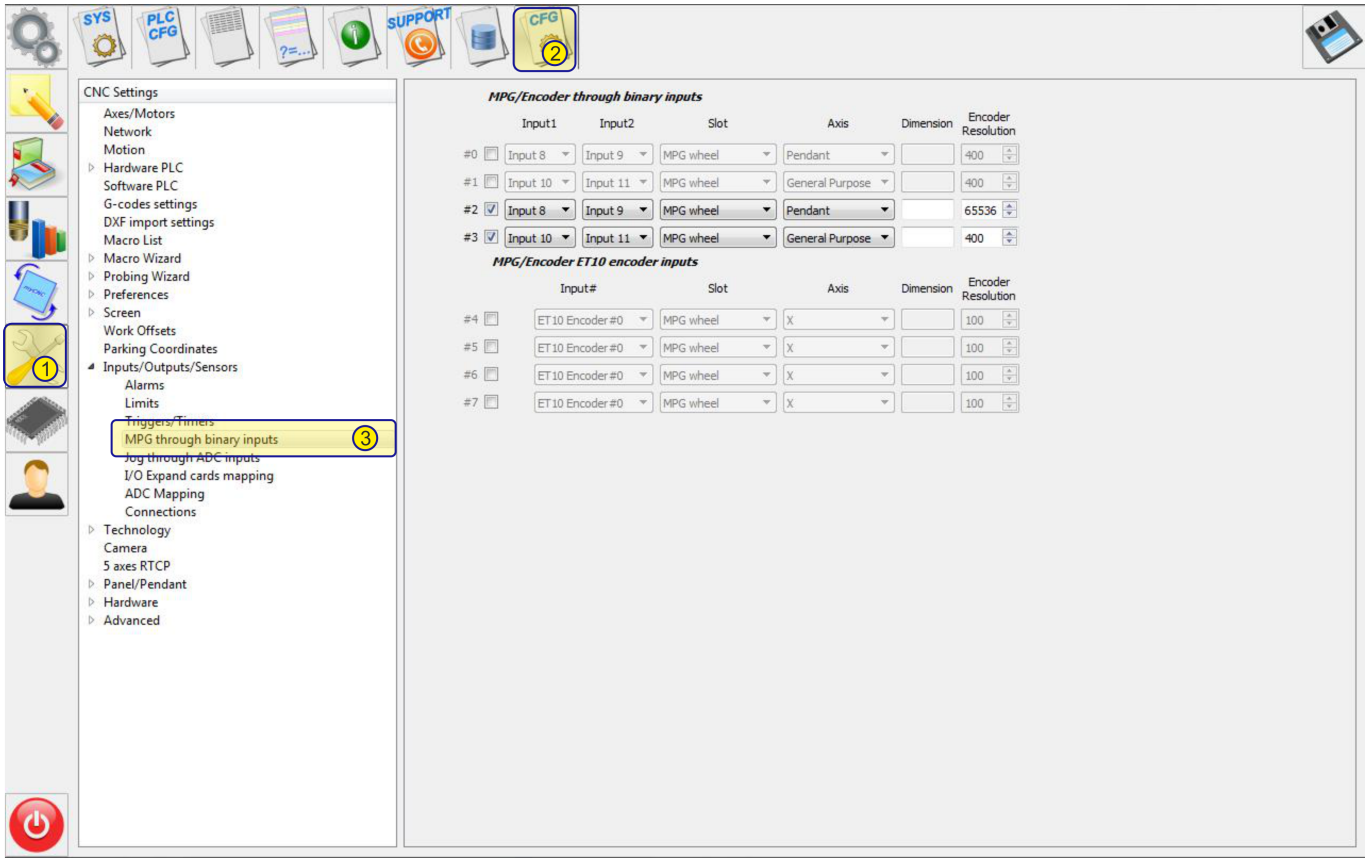
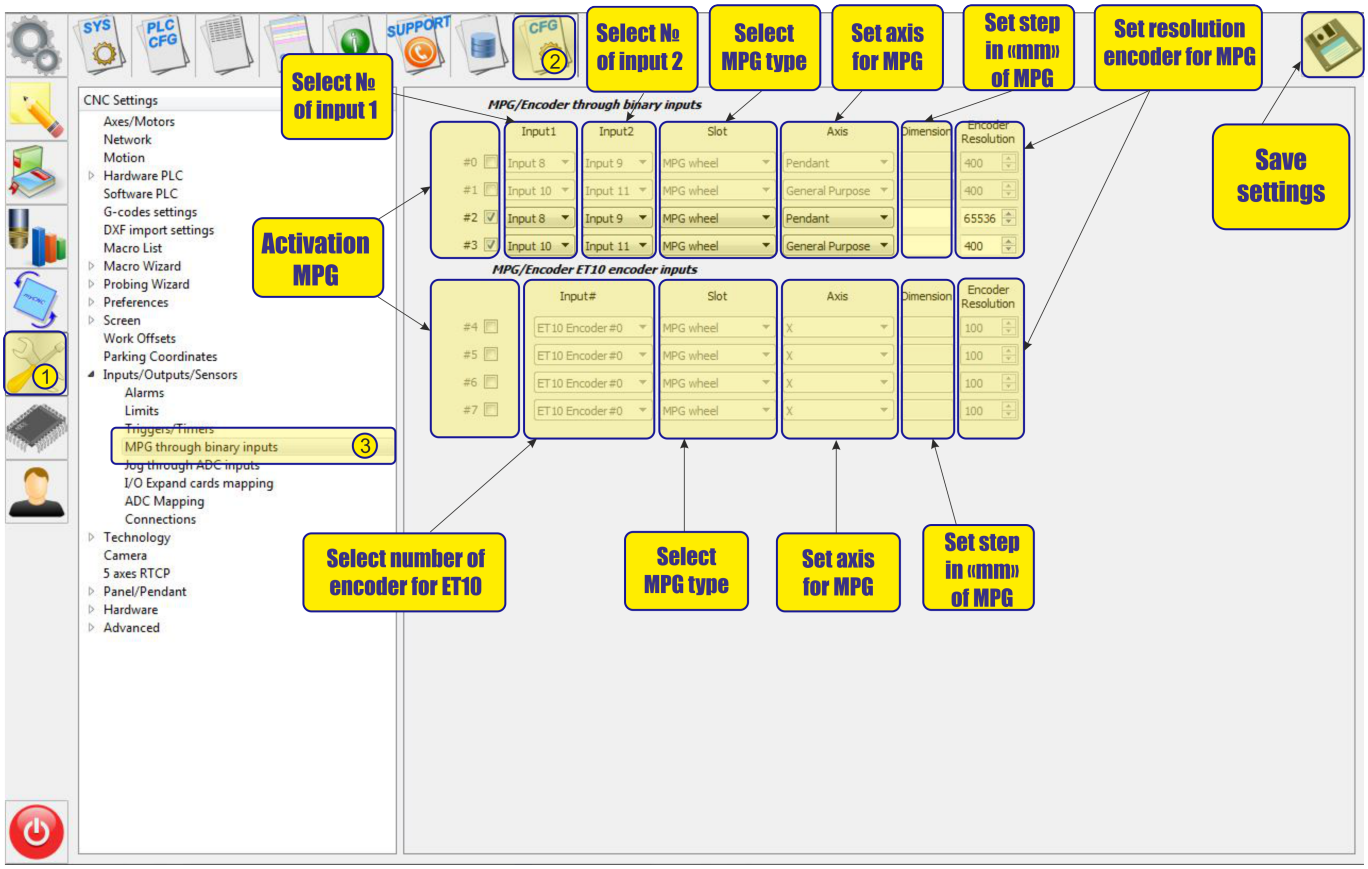
MPG through binary inputs

Main window:

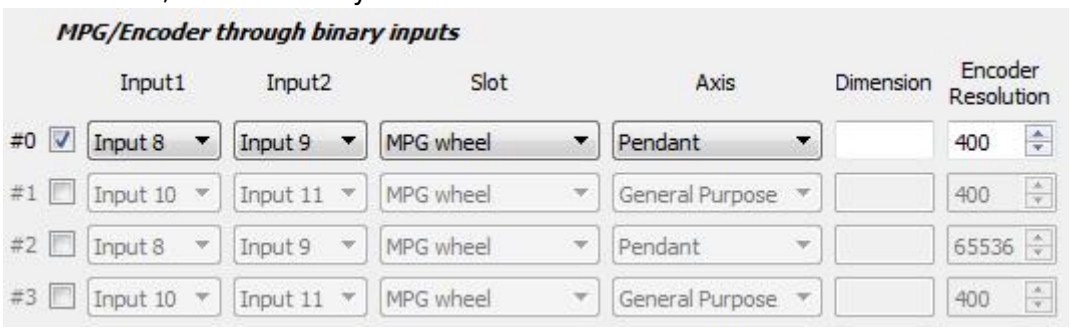


Basic functions:



Mpg/Encoder throught binary inputs

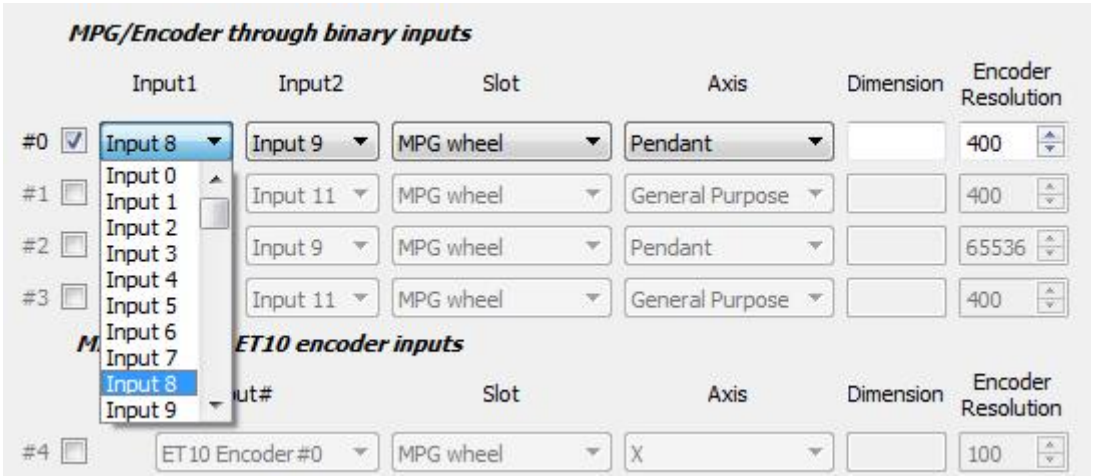
- To activate the MPG, it is necessary to check the box next to the MPG number:



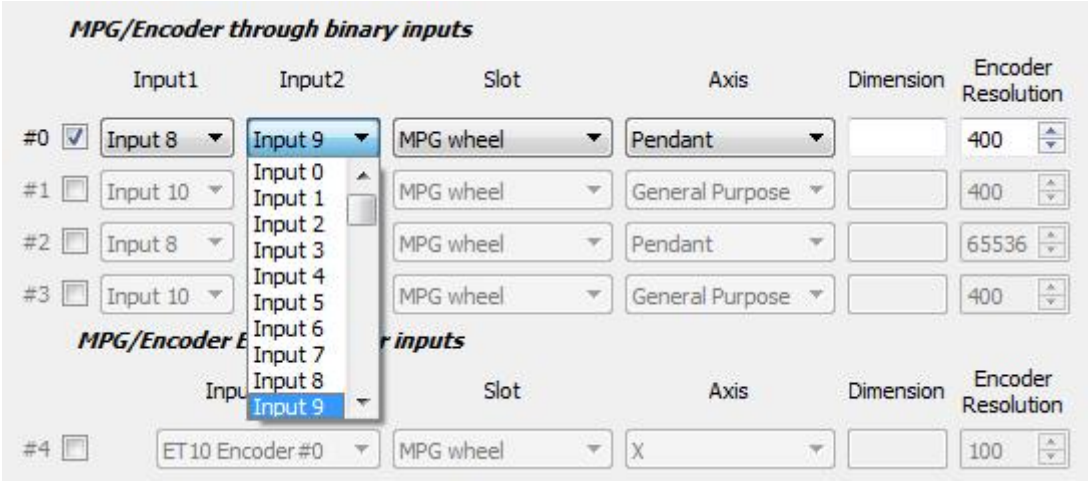
- MPG - designed for manual control of the CNC without resorting to controlling the system from the operator panel. With the help of the control panel, the operator of the CNC machine can change the position of the axes, change the feedrate, adjust the spindle operation, set “0” and perform other operations while in close proximity to the workpiece.
- examples of MPG are presented below:

- After activation, you can select the operating input numbers for the MPG on the controller - input1 and input2

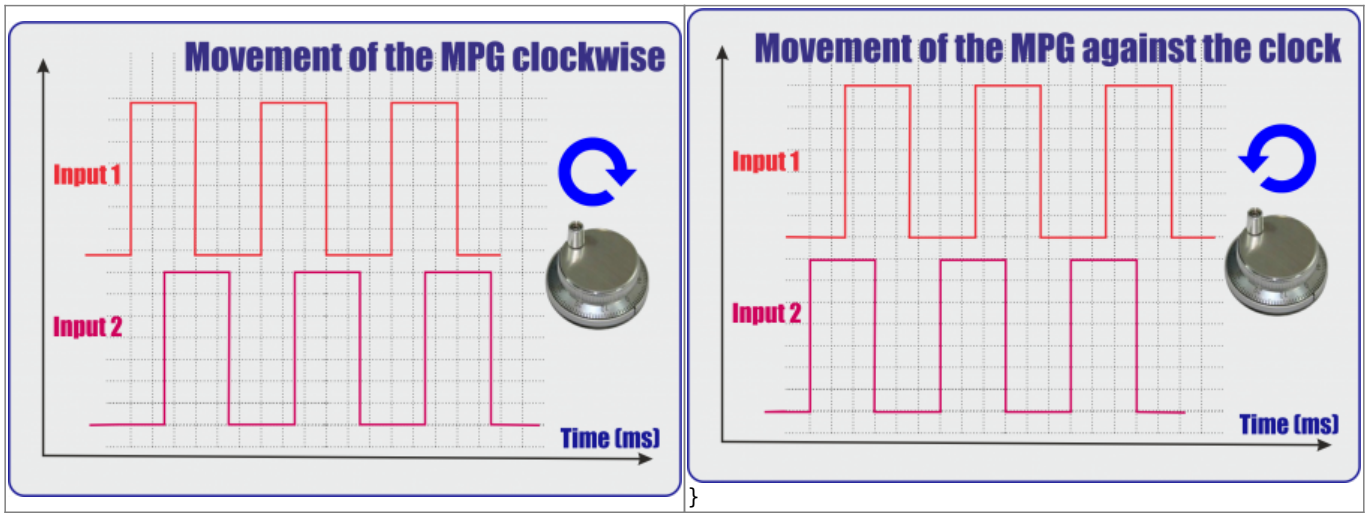
input1:



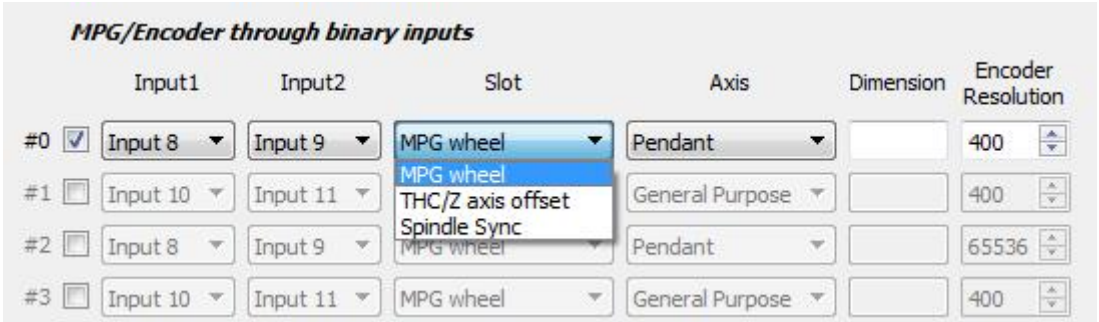
input2:



- Timing diagram for the MPG signals:

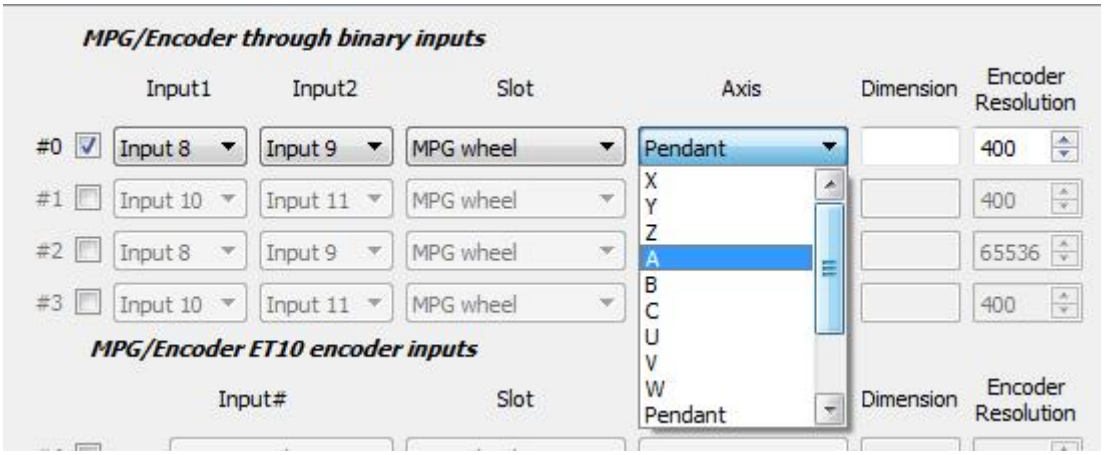


- It is also necessary to select the MPG function:



Functions	Discriptions
MPG wheel	Direct control of the MPG
THC/Z axis offset	Controlling the tracking (torch height control) while cutting with the help of an MPG
Spindle Sync	Spindle control, via the analog output to control the spindle speed.

- If necessary, select the coordinate axis, which will be controlled by the MPG



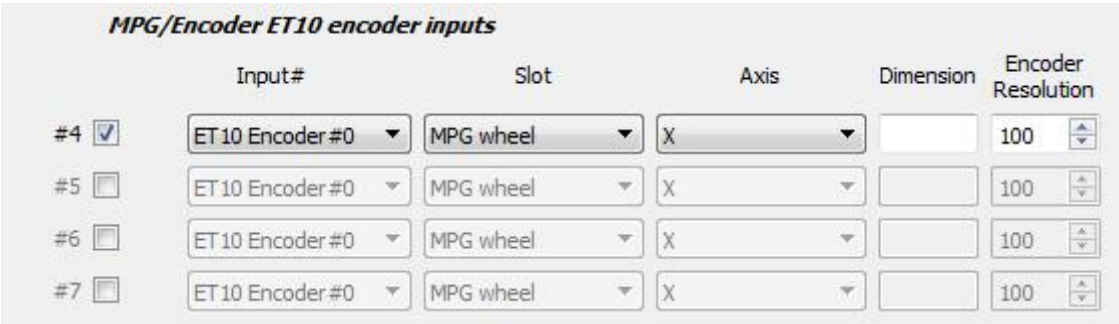
- Next we select the length of displacements with the help of an MPG. Number of movements in mm per pulse MPG:

- We set the resolving power of the MPG - the number of pulses per one revolution of MPG

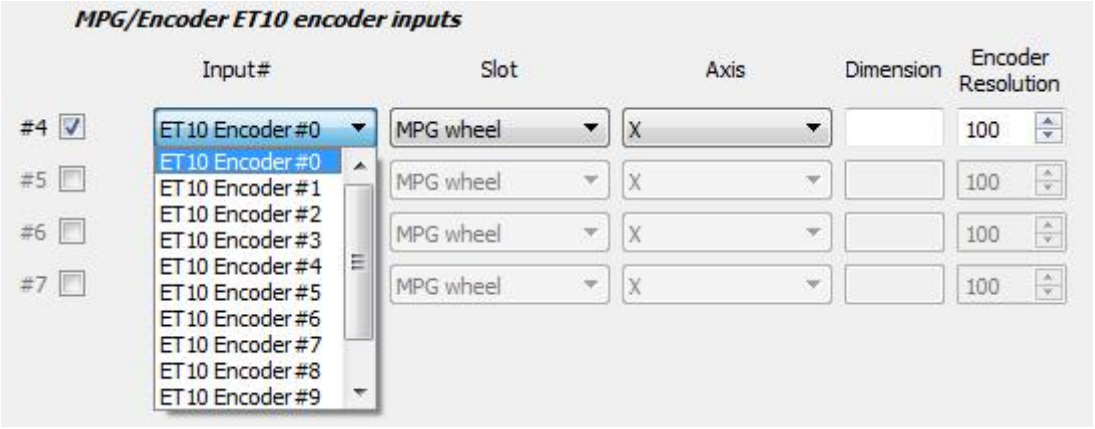
Mpg/Encoder ET10 throught binary inputs

If you use the ET10 controller https://shop.pv-automation.com/et10/9-mycnc-et10.html, you can utilize not only the MPG function, but also the encoders, to monitor the position of any of the axes.

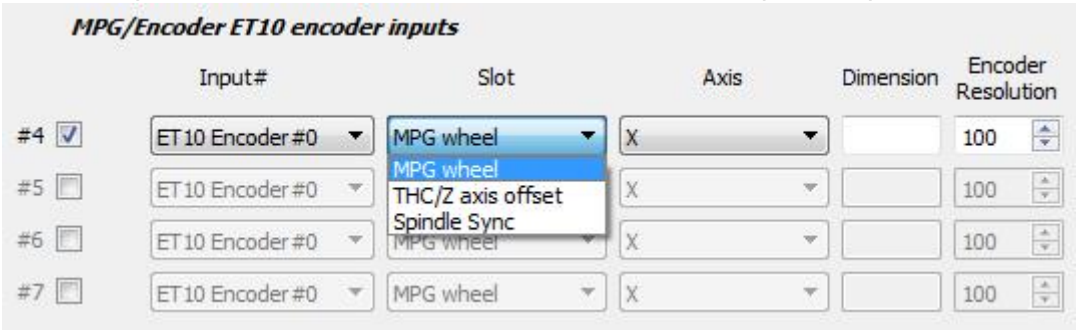
- To activate the MPG or Encoder, it is necessary to check the box next to required MPG/encoder number:



- After activation, you can select the encoder number on the controller for to specify which encoder will be operated

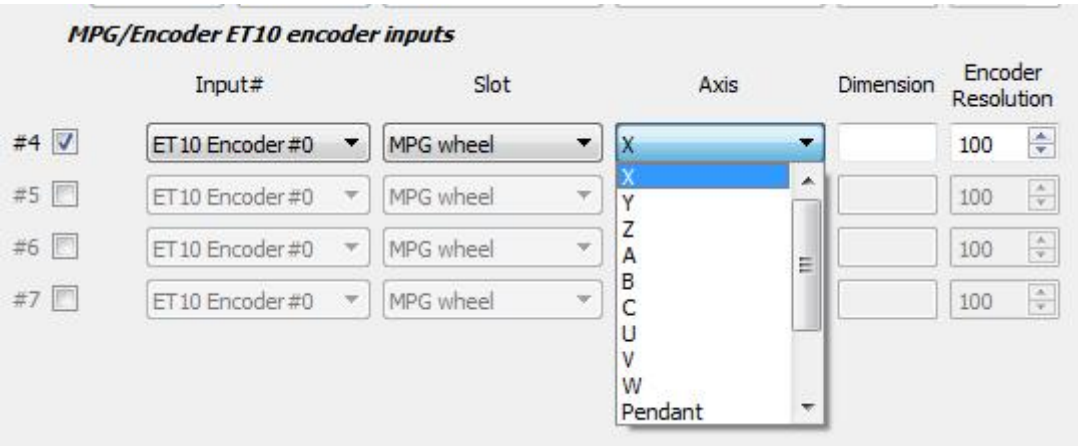


- It is also necessary to select the MPG function (MPG wheel/THC/Spindle Sync):

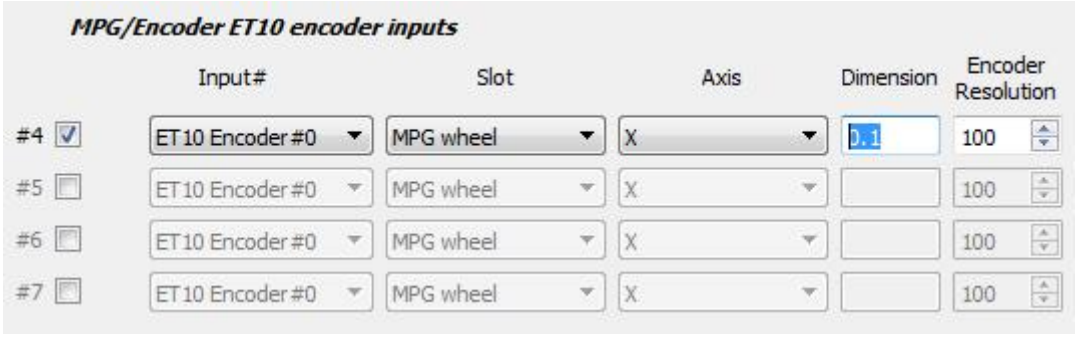


Functions	**Discriptions**
MPG wheel	Direct control of MPG
THC/Z axis offset	Controlling the tracking (THC) while cutting with the help of an MPG
Spindle Sync	Spindle control, via the analog output to control the spindle speed.

- If necessary, select the coordinate axis, which will be controlled by MPG



- Next we select the length of displacements with the help of MPG. Number of movements in mm per pulse MPG:



- We set the resolving power of the PGM - the number of pulses per one revolution of PGM