PLC Predefined Procedures

Most of PLC procedure names represent miscellaneous code. However there are a few reserved PLC names used as a standard event handlers.

Table. List of reserved PLC Procedures

PLC name	PLC description
EST	**Emergency Stop** Handler - procedure executed if Emergency Stop Button pressed. **Emergency Stop Input** is General purpose binary input assigned as Emergency in Alarms configuration dialog
OFF	**OFF moving** procedure executed when **Stop** button pressed. Procedure may contain Stop Handler - stop motion program, clear motion buffer, lift tool to safe height, Off spindle (plasma power source, laser, gas cutting or so)
SPN	**Spindle Speed** Control - Procedure executed if on-screen Spindle button pressed (Spindle speed +, -, set) or single "S" code executed when g-code program running
TRIG01 - TRIG08	Trigger #1-#8 Activated Handler procedures. Procedure executed when if corresponding trigger activated. Trigger is General purpose input defined in Triggers configuration dialog and activated in PLC procedure.

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