

## PLC Predefined (Reserved) Procedure names

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	<b>Emergency Stop</b> Handler - procedure executed if Emergency Stop Button pressed. <b>Emergency Stop Input</b> is General purpose binary input assigned as Emergency in <a href="#">Alarms configuration dialog</a>
OFF	<b>OFF moving</b> procedure executed when <b>Stop</b> 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	<b>Spindle Speed</b> 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 <a href="#">Triggers configuration dialog</a> and activated in PLC procedure.

Additionally, different M-codes are typically reserved for certain procedures. It's recommended to use codes M101-M999 for custom procedures.

Name	M-code number
G_M_USER_BEGIN_1	75
G_M_USER_END_1	88
G_M98_SUB_RUN	98
G_M99_SUB_END	99
G_M_USER_BEGIN	101
G_M_USER_END	199
G_M_MYUSER_BEGIN	200
G_M_MYUSER_END	999

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Last update: **2021/08/26 15:18**

