
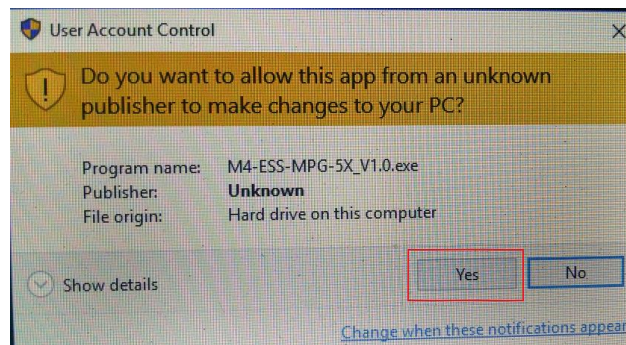

CNC⁴PC

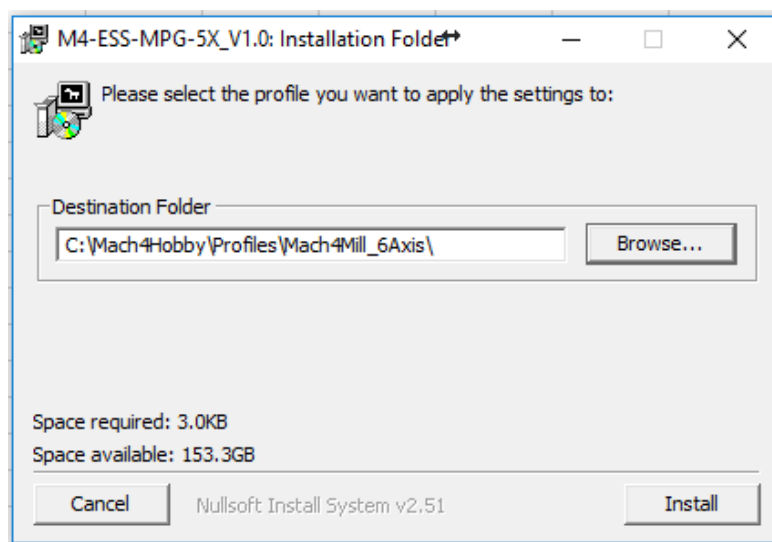
Integration Solutions for CNC Projects

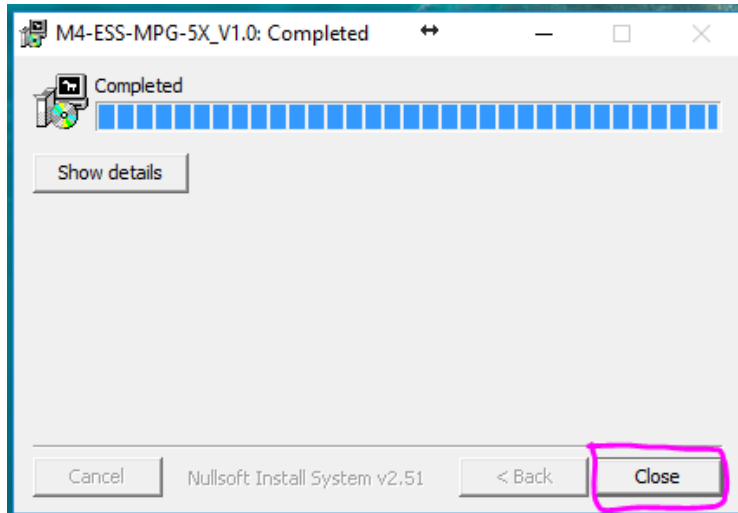
CNC4PC Pendant for Mach4

- Run the installer  **M4-ESS-MPG-5X_V1.0.exe** to configure Mach4 and the plugin:

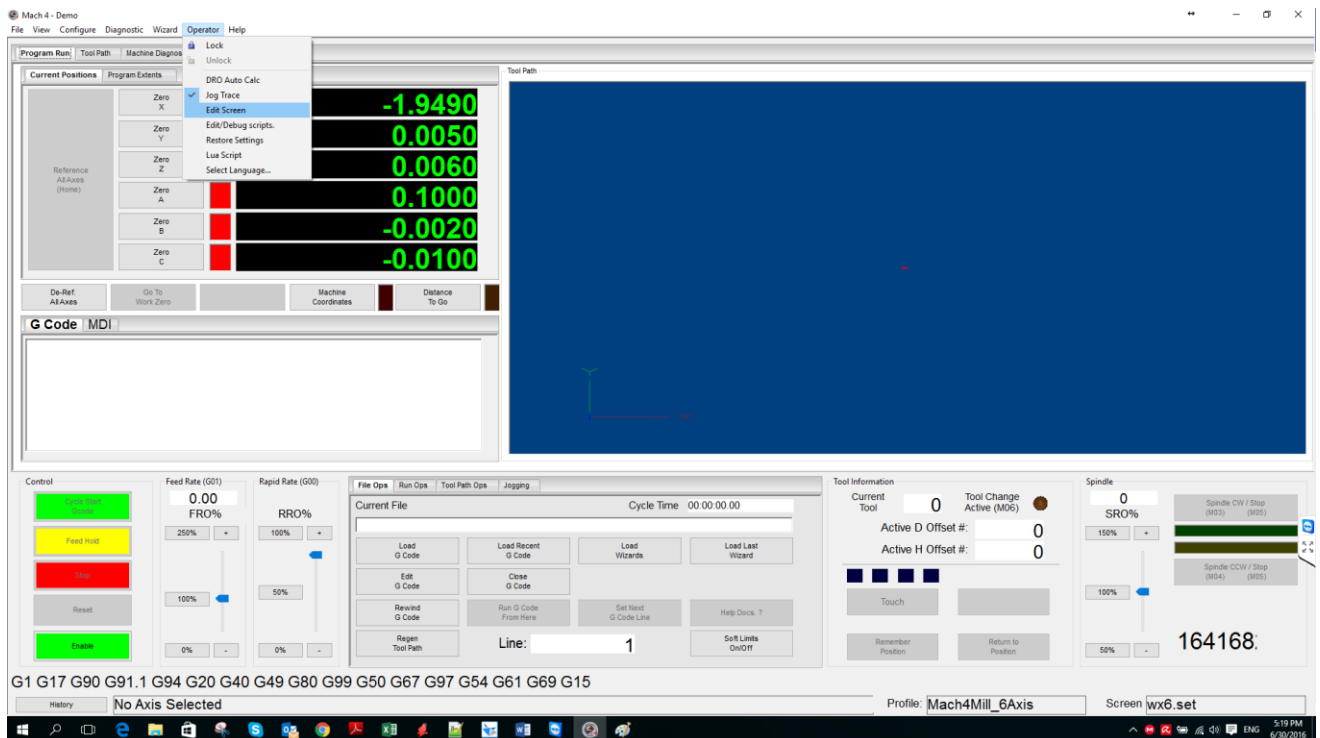


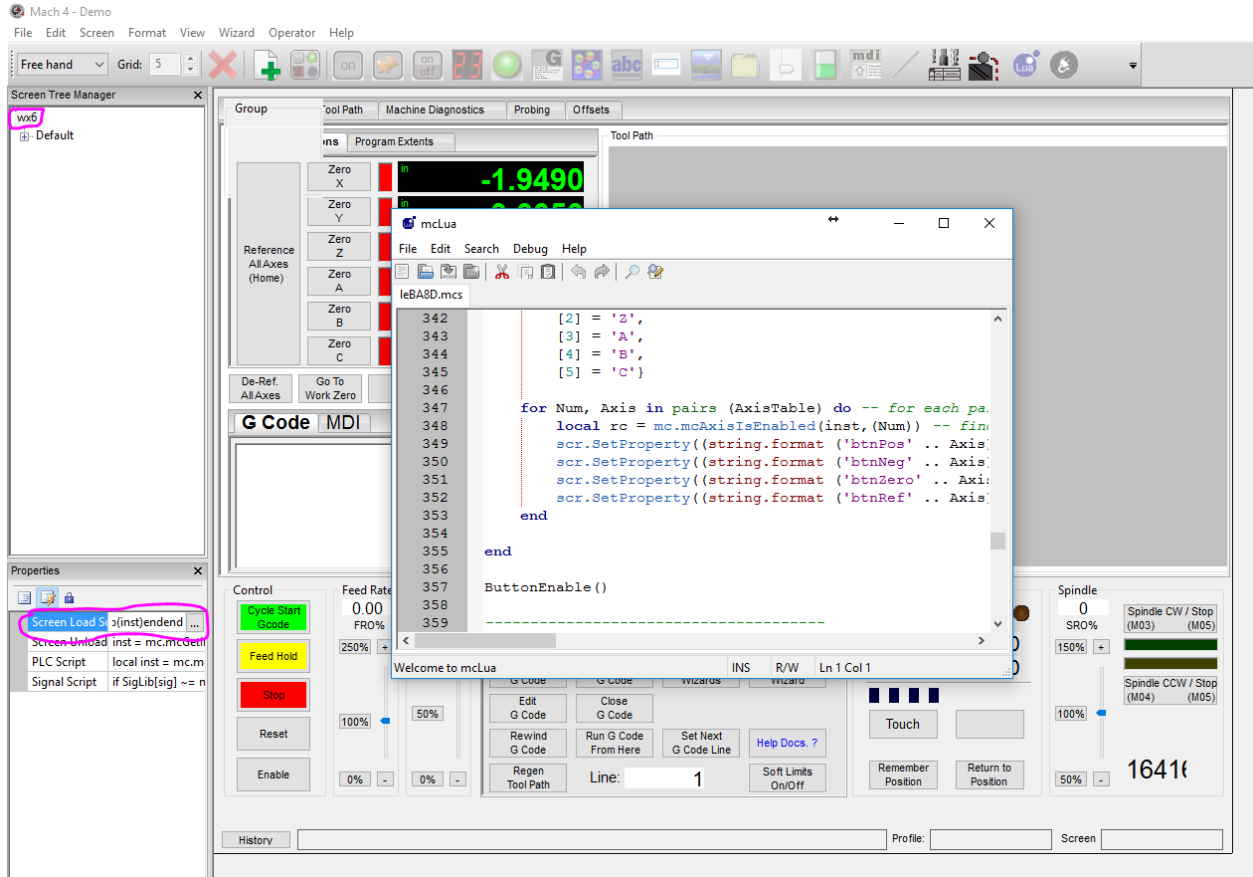
- Select the profile to configured and press install.





- Edit Screen to add the lua code.





- Copy the following code at the end of the screen script.

```
-----
-- CNC4PC Pendant --
-----
```

```
-- These simply run the CNC4PCPendant function if their state changes.
```

```
SigLib = {
[mc.ISIG_INPUT10] = function (state)
CNC4PCPendant()
end,
[mc.ISIG_INPUT11] = function (state)
CNC4PCPendant()
end,
[mc.ISIG_INPUT12] = function (state)
CNC4PCPendant()
end,
[mc.ISIG_INPUT13] = function (state)
CNC4PCPendant()
end,
[mc.ISIG_INPUT14] = function (state)
CNC4PCPendant()
end,
[mc.ISIG_INPUT15] = function (state)
```

```

CNC4PCPendant()
end,
[mc.ISIG_INPUT16] = function (state)
CNC4PCPendant()
end,
[mc.ISIG_INPUT17] = function (state)
CNC4PCPendant()
end,
[mc.ISIG_INPUT18] = function (state)
CNC4PCPendant()
end,
[mc.ISIG_INPUT19] = function (state)
CNC4PCPendant()
end
}
-----
-- CNC4PC Pendant function.
-----
function CNC4PCPendant()
local hSig, rc = mc.mcSignalGetHandle(inst, mc.ISIG_INPUT10) -- Is mapped to Port 2 Pin 4 *X Selection
local XSelection, rc = mc.mcSignalGetState(hSig)
local hSig, rc = mc.mcSignalGetHandle(inst, mc.ISIG_INPUT11) -- Is mapped to Port 2 Pin 5 *Y Selection
local YSelection, rc = mc.mcSignalGetState(hSig)
local hSig, rc = mc.mcSignalGetHandle(inst, mc.ISIG_INPUT12) -- Is mapped to Port 2 Pin 6 *Z Selection
local ZSelection, rc = mc.mcSignalGetState(hSig)
local hSig, rc = mc.mcSignalGetHandle(inst, mc.ISIG_INPUT13) -- Is mapped to Port 2 Pin 7 *A Selection
local ASelection, rc = mc.mcSignalGetState(hSig)
local hSig, rc = mc.mcSignalGetHandle(inst, mc.ISIG_INPUT14) -- Is mapped to Port 2 Pin 8 *.001
Selection
local Step001, rc = mc.mcSignalGetState(hSig)
local hSig, rc = mc.mcSignalGetHandle(inst, mc.ISIG_INPUT15) -- Is mapped to Port 2 Pin 9 *.010
Selection
local Step010, rc = mc.mcSignalGetState(hSig)
local hSig, rc = mc.mcSignalGetHandle(inst, mc.ISIG_INPUT16) -- Is mapped to Port 2 Pin 10 *.100
Selection
local Step100, rc = mc.mcSignalGetState(hSig)
local hSig, rc = mc.mcSignalGetHandle(inst, mc.ISIG_INPUT17) -- Is mapped to Port 2 Pin 15 *Estop
local PenStop, rc = mc.mcSignalGetState(hSig)
local hSig, rc = mc.mcSignalGetHandle(inst, mc.ISIG_INPUT18) -- Is mapped to Port 2 Pin 12 *B
Selection
local BSelection, rc = mc.mcSignalGetState(hSig)
local hSig, rc = mc.mcSignalGetHandle(inst, mc.ISIG_INPUT19) -- Is mapped to Port 2 Pin 13 *C
Selection
local CSelection, rc = mc.mcSignalGetState(hSig)
local PenJogOn, rc = mc.mcSignalGetHandle(inst, mc.OSIG_OUTPUT10)-- Is mapped to Port 2 Pin 1
*Jog on LED
if XSelection == 1 then
mc.mcMpgSetAxis(inst, 0, 0) --X Axis
mc.mcCntlSetLastError(inst, "X Selected")
mc.mcSignalSetState(PenJogOn, 1)
elseif YSelection == 1 then
mc.mcMpgSetAxis(inst, 0, 1) --Y Axis
mc.mcCntlSetLastError(inst, "Y Selected")
mc.mcSignalSetState(PenJogOn, 1)
elseif ZSelection == 1 then
mc.mcMpgSetAxis(inst, 0, 2) --Z Axis

```

```

mc.mcCntlSetLastError(inst, "Z Selected")
mc.mcSignalSetState(PenJogOn, 1)
elseif ASelection == 1 then
mc.mcMpgSetAxis(inst, 0, 3) --A Axis
mc.mcCntlSetLastError(inst, "A Selected")
mc.mcSignalSetState(PenJogOn, 1)
elseif BSelection == 1 then
mc.mcMpgSetAxis(inst, 0, 4) --B Axis
mc.mcCntlSetLastError(inst, "B Selected")
mc.mcSignalSetState(PenJogOn, 1)
elseif CSelection == 1 then
mc.mcMpgSetAxis(inst, 0, 5) --C Axis
mc.mcCntlSetLastError(inst, "C Selected")
mc.mcSignalSetState(PenJogOn, 1)
else
mc.mcMpgSetAxis(inst, 0, -1) --No Axis
mc.mcCntlSetLastError(inst, "No Axis Selected")
mc.mcSignalSetState(PenJogOn, 0)
end
if Step001 == 1 then
mc.mcMpgSetInc(inst, 0, .001)
elseif Step010 == 1 then
mc.mcMpgSetInc(inst, 0, .010)
elseif Step100 == 1 then
mc.mcMpgSetInc(inst, 0, .100)
end
if PenStop == 1 then
mc.mcCntlEStop(inst)
end
end

```

- Exit and save the screen and it will be ready.

