TB173 (Rev3) - How to Compile a PLC Program

Purpose:

Show how to compile a PLC source code file for CPU and PC programs in CNC7, CNC10, & CNC11 software.

Compiling a PLC program in CNC7 software:

1. From the main screen on the control press **Ctrl + Alt + x** to exit to DOS.
2. Type: **cd plc** (press **enter**) to go to the PLC directory.
3. Verify the name(s) for your PLC programs and that they are in the PLC directory. Type: **dir *.src** (press **enter**), which will display the PLC source files in the PLC directory.
4. To compile the CPU PLC program type: **plccomp xxxxxx.src c:\cnc7\cnc7.plc** (press **enter**).
ex. plccomp m400scpu.src c:\cnc7\cnc7.plc (sources code names for CPU programs have "cpu", "cp", or "c")
Note: If compiling in lathe software, the destination path will change to c:\cnc7t\cnc7.plc
5. If the control was shipped with CNC7 v8.20 or higher, you will probably need to compile the PC PLC program as well. To do this type: **xplccomp xxxxxx.src c:\cnc7\pc.plc** (press **enter**).
ex. xplccomp m400spc.src pc.plc (source code names for PC programs have "pc" or "p")
Note: There are some systems that only use the CPU PLC program - some after v8.20 and almost all systems before v8.20 software.
6. Once both source files have been compiled successfully, you will need to power cycle the control.
7. If running v8.20 or higher you can verify the PLC programs by pressing **F7 - Utilities**, then **F8 - Options** to check the CPU and PC PLC programs.

Compiling PLC programs in CNC10 software:

1. From the main screen on the control press **F10 - Shutdown**, then **F9 - Exit CNC10** software. Then press **F4 - System Prompt**.
2. Verify the name of your source code files. Type: **ls *.src** to display the source files in the CNC10 directory.
3. To compile the CPU PLC program type: **plccomp xxxxxx.src cnc10.plc** (press **enter**).
ex. plccomp m400dc3c.src cnc10.plc (Notice most CPU source file names end with a "c")
Note: Systems upgraded to CNC10 that only run the CPU PLC program will need the pc.plc file deleted.
4. To compile the PC PLC program type: **xplccomp xxxxxx.src pc.plc** (press **enter**).
ex. xplccomp m400dc3p.src pc.plc (Notice most PC source file names end with a "p")
5. Once both source files have been successfully compiled, exit out of the system prompt screen by typing **exit** (press **enter**). Then press **F1 - CNC10** to load the CNC10 software.
6. Verify the PLC programs by pressing **F7 - Utilities**, then **F8 - Options** to check the CPU and PC PLC programs.

Note: Do not compile a CPU source file with xplccomp or a PC source file with plccomp as they will not compile correctly.

Compiling a PLC program in CNC11 Windows software:

1. Press**F10 - Shutdown**, then **F9 - Exit CNC11** to exit the CNC11 software.
2. Press the Windows key on the keyboard or click the start button (lower left corner). Type**cmd**, then select the Command prompt from the list.
3. Type:**cd\cncm** to get to the CNC11 mill directory or **cd\cnct** to get to the CNC11 lathe directory.
4. To compile the PLC program type:**mpucomp xxxxx.src mpu.plc** (press **enter**).
5. If the file compiled correctly type:**exit** (press **enter**) to close the Command prompt window.
6. Power cycle the control. Once your back into the CNC11 software, press**F7 - Util**, then **F8 - Options** to verify the correct PLC program compiled.

Document History

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