



Sherline/Acorn Controller Live PLC I/O Display Screen

About the Live PLC I/O Display Screen

On our Sherline/Acorn Controllers, the Acorn Wizard settings are set to show the Advanced Input/Output display screen (see Figure 1).



FIGURE 1

- 1. To turn the Live PLC I/O display on, push (ALT+I) on the keyboard. Pressing ALT+I brings up the Live PLC I/O display screen (see the image above). On this screen, you can view the real-time status of all the different inputs, outputs, etc.
- 2. Use the arrow, F11, and F12 keys to navigate the Live PLC I/O screen.
- 3. "With proper PLC support," pressing CTRL+ALT+I will allow you to toggle the value of Inputs 1 through 80.
- 4. Similarly, pressing CTRL+ALT+F allows you to toggle outputs.
- 5. To turn the I/O Display off, press (ALT+I) again.
- 6. If you would rather have the Simple PLC Diagnostic Display shown on your screen, do the following.
 - A. Enter the utilities menu (F7).
 - B. Enter the Acorn Wizard menu (F10)

C. Select "CNC Control" under the "Preferences" header, and then toggle the option "Enable Simple PLC Diagnostic as Yes" (see Figure 2).

Homing and Travel Axes Pairing Advanced	x .	Display Active G&M Codes	Always 🗸
		Feedrate Override: Maximum percentage	100
Spindle Spindle #1 Rigid Tapping PWM Setup		Feedrate Override: Minimum percentage to invoke FEED HOLD	0
		"Clean Filter" reminder message frequency in days. (default is OFF = 0)	0
Touch Devices E Probe Tool Touch Off		Run Time Graphics on start up	Yes
		Remember Last G Code program after restart	No
		Allow CYCLE START in Run Menu and Graph Menu	Yes
Control Peripheral Input Devices Wireless MPG		Display Keyboard Jogging Legend on Alt+J press	Yes
		Part G code Preview on Job Load	Yes
DB25 Connector	C	Popup Pins Deactivate on Cycle Start	No
		Disable Worklight on Startup	No
ATC L ATC Setup		*PC Keyboard <enter key=""> = CNC Machine <cycle start=""></cycle></enter>	No
		*USB/Keyboard Jogging active on CNC12 start up	No
		Enable Simple PLC Diagnostic as default	Yes
Preferences CNC Control VCP Preferences Wizard VCP Aux Keys Lube Pump		Force Rehoming After Estop condition	No
		DRO Display Units	Imperial
		Custom Tool Change Macro (M6) in use	No
		*Safety Warning: For testing only, not for use with commissioned	for use with commissioned CNC machines



D. After making the change, click on "write setting to CNC control configuration." Then click "OK." Restart the Acorn controller and then restart the software (see Figure 3).



FIGURE 3—Simplified I/O PLC Diagnostic Display.

FYI: Acorn On Board INPUTS 1, Numbers 1, 2, 3, and 4 are the limit switch signals for axes X, Y, Z, and A. They should be green when the switch is inactive, and they will turn red when the switch is engaged.

Thank you, Sherline Products Inc.