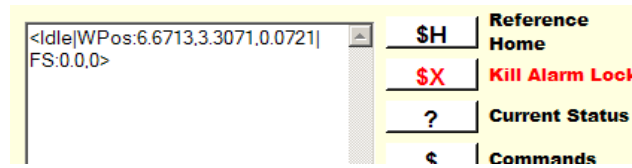


Limit Switch Testing
John Champlain
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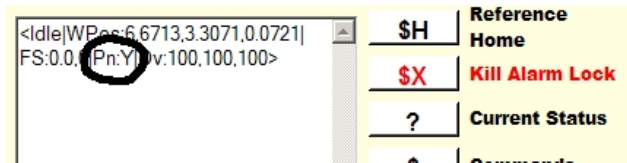
Here is a simple and easy way to test the action of limit switches using PicSender.

1 – Start up PicSender and connect to your controller. Home (\$H) the machine if so enabled.

2 – Click and release the “?” button, and this message (or similar) should be displayed in the “Messages” box.



3 – Manually actuate and hold a limit switch, and click the “?” button again, and this message will be displayed.



4 – The “Pn:Y” indicates that one of the Y limit switches was actuated. If an “X” axis switch is actuated, then “Pn:X” will display. And for a “Z” axis switch, “Pn:Z” will be displayed.

A failure of the “Pn: _” message to display with the above procedure indicates that a switch may be either faulty, or has a wiring error.

If two or more limit switches are actuated when the “?” button is clicked, then a letter for each actuated switch will be displayed (ex: “Pn:XY” or “Pn:XYZ”).

Please note:

1 - Grbl will not indicate whether or not the limit switches are plus (+) or minus(-).

2 – If switches are wired in a NO (normally open) configuration, then the grbl setting \$5 should be \$5=0, and if wired in a NC (normally closed”) configuration, then \$5 should be \$5=1. Using switches wired with mixed (NO and NC) configurations is not allowed.