

Centroid CNC12 New Parameter Cheat Sheet (REV 1)

Description	Parameter Number	Value	Value Description	Comments
Allow Cycle Start in Run Menu	400	0	Disabled	
		1	Enabled	
Forget Last Job Loaded	401	0	<v4.14 yes, v4.14 no	set to "no"
		1	<v4.14 no, v4.14 yes	
Virtual Control Panel (VCP)	219	0	Disabled	Requires software restart
		1	Enabled	
Default feed rate override percentage	170	5	Sets Default Feed rate to 100%	systems without physical jog panel
Mini PLC Add Devices. "unconfigured Mini PLC _ found" message	900	0	No PLCADD device	Turn off "unconfigured Mini PLC _ found" message
		1	1 PLCADD	
		3	2 PLCADD	
		7	3 PLCADD	
		15	4 PLCADD	
MPG 1 Encoder Input	348	0	No MPG Installed	Turn off "MPG 1 Encoder Error" Message
		15	USB MPG or Wired MPG	

Wired MPG			
MPG 1 Encoder Input	348	15	Sets MPG encoder input to MPG Connector
	349	100	100 detents (clicks)/rev
	350	400	400 counts/rev

Wireless MPG				
MPG Type	411	0	CWP-4	Requires Software restart
		1	WMPG-4	
USB MPG Options Requires Software unlock (#14688)	218	0	Disabled	
		3	Lathe	
		7	3 Axis Mill/Router	
		15	4 Axis Mill	
MPG 1 Encoder Input	348	15	Sets MPG encoder input to USB MPG	
	349	100	100 detents (clicks)/rev	
	350	100	100 counts/rev	

Active G Code				
Oak/Allin1DC Mill	46	0	Always	
		1	MDI Only	
		2	Never	
Oak/Allin1DC Lathe	404	0	Always	Parameter 408 is labeled Active G code but set 404 instead. (known bug)
		1	MDI Only	
		2	Never	
Acorn Mill	46	0	Always	Set in Wizard
		1	MDI Only	
		2	Never	
Acorn Lathe	408	0	Always	Set in Wizard
		1	MDI Only	
		2	Never	