

PLC MEMORY ADDRESSING LIST'S DISPLAY

When the maintenance display UNIT is selected, any PLC memory address can be monitored on the PLC I/O screen. The screen of the display is similar to, but radically different than, the diagnostic display that is found on earlier MAGNETROL CNC's. In the M-22 maintenance UNIT display you will not find reference to an R bit "M" address. Also missing is the "Q" function that was used to force address bits ON & OFF.

The PLC I/O screen is primarily used to check the status of the PLC memory addresses that are used in the PLC ladder sequence. It can also be used to force the memory addresses ON or OFF. How to use this screen will be explained in this section of this book.

The PLC memory addresses and their purpose in life are listed below:

1. "I" ADDRESS TO THE PLC (Input-Declarable).

1. 00 THRU 007: INPUTS FROM MACHINE.
2. 0100 THRU 0107: INPUTS FROM OPERATING PANEL.
3. 0170 THRU 0177: FMS INPUTS. (Direct inputs to MC)
4. 0200 THRU 0207: INPUTS FROM THE MC.

2. "Q" ADDRESS FROM THE PLC (Output-Declarable).

1. 00 THRU 007: OUTPUTS TO MACHINE.
2. 0100 THRU 0107: OUTPUTS TO OPERATING PANEL.
3. 0200 THRU 0207: OUTPUTS TO MC.

3. "M" PLC MEMORY MEMORY (Declarable).

The status of these addresses is established during the power up sequence.

4. "T" PLC TIMERS (Declarable).

1. 00 THRU 0107: TIMER INPUTS (1 BIT).
2. 0100 THRU 0107: TIMER OUTPUTS (1 BIT).
3. 0200 THRU 0207: SET TIME (16 BITS).
4. 0300 THRU 0307: ACCUMULATED TIME (16 BITS).

5. "D" DATA REGISTERS (Declarable).

The machine and control status are kept current by storing the vital data at these addresses. As things change, so do the data register values. All data registers are of the 16 bit type.

6. "A" ALARMS & MIS-OPERATIONS (Declarable). (R - RST).

Machine wide malfunctions and mis-operations are detected by the PLC. Alarms 000 thru 007 are generated by PLC addresses 00 thru 007. For alarms 000 thru 009 an alternate method is used and that will be covered in the section for ALARMS.

7. "R" PLC RELATIONS (Declarable).

These addresses are used much like the "Q" addresses listed above. The main difference between the two is that the "Q" registers show current status that has to be updated as the status changes. For the same part, the "R" addresses show permanent sequence data that will only change when you change it.

8. "L" LATCHING ADDRESSES (Declarable).

These addresses will not change status when the MC power is turned OFF/ON.

9. "F" PLC or "C" LANGUAGE MIS-OPERATIONS (Declarable).

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