

Downloaded on Saturday 19th May 2012

<b>Software</b>	RSLogix 5000
<b>Duration</b>	5 Days
<b>PLC-Type</b>	SLC500 PLC / ControlLogix
<b>Pre-Requisites</b>	No prerequisites this is a beginners course
<b>Maximum Delegates</b>	6

## Brief Description

- \* Be able to troubleshoot an SLC 500 and ControlLogix PLC system in a competent and confident manner
- \* Be able to recognise SLC500 and ControlLogix hardware and be able to replace modules when a fault occurs.
- \* Be able to operate the Allen Bradley software to make it perform certain tasks.
- \* Understand basic instruction set and be able to make minor modifications to software.
- \* Be able to backup and restore a PLC program when required.
- \* Be able to perform basic system diagnostics when a problem occurs.

## Course Documentation

- \* Training Log
- \* Pre Course Exercises
- \* Course Exercises
- \* Post Course Exercises
- \* Filofax Pocket Reference Guides x 2

## Course Content

To fault find a system you need to know EXACTLY how it works HOW EXACTLY DOES A PLC WORK?

- \* Am I getting the input to the PLC?
  - \* The Led on the output card means i am getting voltage out right? does it?
  - \* What exactly happens in between? ,theres more than just a program in the CPU
  - \* How exactly does it scan the program?
  - \* What is this Watchdog Timer? Is it that important?
  - \* Can I use the same output twice? That's bad programming isn't it?
  - \* A PLC is a logic controller, so use a logical approach to fault find it.
  - \* What are the 8 simple test points to check?
  - \* The PLC is in RUN, that means theres a program right? does it?
  - \* FORCING a bit and toggling a bit is pretty much the same yeah? depends on which PLC
- Then you need to Know the specifics HOW DO I DO THE FOLLOWING? (some straight forward some not so)
- \* Check power is ON and PLC is in right mode (RUN or Program)
  - \* Check LEDs for fault definition
  - \* Check and Change Modules if required (with spares and without spares)

- \* System connection
- \* Establish link to PLC (RSLinx, a major problem area these days)
- \* Create a blank project and take a backup (just in case I mess up)
- \* Open the correct project Off Line and link to PLC
- \* Interrogate errors in Status table
- \* Identify if it is a hardware or software fault?
- \* Identify if it is a PLC or Comms fault
- \* Change the battery
- \* Check all settings against a template, Node Address etc.
- \* Check Hardware Configuration
- \* Clear Memory and Download program
- \* Check software against latest copy (Compare function)
- \* Monitor program
- \* Searching for specific operands and instructions
- \* Changing timer, counter values On Line
- \* Making minor mods Off Line and On line
- \* Check or create a Custom Monitor table to establish parameter status
- \* Create a Histogram to monitor address transitions
- \* Create a Trend to trend address status or values
- \* Altering timer, counter and other data table values if required
- \* Force a parameter if required
- \* Toggling addresses to move program on in sequence
- \* Call up documentation to assist with software diagnostics
- \* Printing Cross Reference / Program Listings etc. Background information also covered

## Understanding of the following:

- \* Number formats, bits, words,
- \* Binary, floating point, integer
- \* Program blocks and Data Tables, B3, T4, N7 etc
- \* How to monitor various blocks
- \* Understand basic Ladder programs
- \* Basic Instructions, contacts, Set, reset etc.
- \* Timers, Counters
- \* Comparators, Maths
- \* Altering values in a data table
- \* Toggling v Forcing
- \* Back tracking through a program to establish where power flow stops
- \* Overall reset procedure
- \* Fault finding tips

## Equipment

- \* SLC500 and ControlLogix PLC
- \* PC or Laptop
- \* Simulator

*Solutions, Not Courses.*