

Custom In-House PLC Training.

– Based on Allen-Bradley SLC500.

Training Materials Includes:

- 1.) PC equipped with RSLogix 500 and RSLogix Emulate 500**
- 2.) Training Handout / Course Book**

Day 1:

1.) General PLC Information

- a.) Program Flow
- b.) Inputs / Outputs
- c.) Memory & Addressing
 - i.) Program files
 - ii.) Data files
 - iii.) Logical addressing
- d.) Communication Options – available for all SLC 500 series models and their specification.

2.) Programming

- a.) RS Logix 500 features
- b.) Connecting to PLC (RS Logix / RS Linx)
- c.) Off-Line Programming
- d.) On-Line Programming
- e.) Add Rung
- f.) Editing Rung

3.) Programming Instructions

- a.) Basic Instructions
 - Examine if Closed (XIC)
 - Examine if Open (XIO)
 - One-Shot Rising (OSR)
 - Output Energize (OTE)Output Latch / Unlatch (OTL/ OTU)
- b.) Timer / Counter Instructions
 - Timer On-Delay (TON)
 - Timer Off-Delay (TOF)
 - Retentative Timers (RTO)
 - Counter Up (CTU)
 - Counter Down (CTD)*Hands on training for the above instructions*
- c.) Comparison Instructions
 - Equal (EQU)
 - Limit Test (LIM)
 - Less Than (LES)
 - Less Than or Equal (LEQ)
 - Greater Than (GRT)
 - Greater Than or Equal (GEQ)*Hands on training for the above instructions*

Day 2:

3.) Programming Instructions (continue)

- d.) Math Instructions
 - Add (ADD)
 - Subtract (SUB)
 - Multiply (MUL)
 - Divide (DIV)
 - Compute (CPT)*Hands on training for the above instructions*
- e.) Move & Logic Instructions
 - Move (MOV)
 - Masked Move (MVM)
 - And (AND)
 - Or (OR)
 - Exclusive Or (XOR)
 - Clear (CLR)*Hands on training for the above instructions*
- f.) File / Misc Instruction
 - Copy File (COP)
 - Fill File (FLL)
 - PID Function (PID)
 - Scale With Parameters (SCP)
 - File Bit Comparison (FBC)*Hands on training for the above instructions*
- g.) Program Control
 - Label (LBL)
 - Jump to Label (JMP)
 - Master Control Reset (MCR)*Hands on training for the above instructions*

4.) Additional Q&A from the participants.

Notes :

Program list above is only sample. The real Custom In House PLC Training program will base on Customer Requirement.