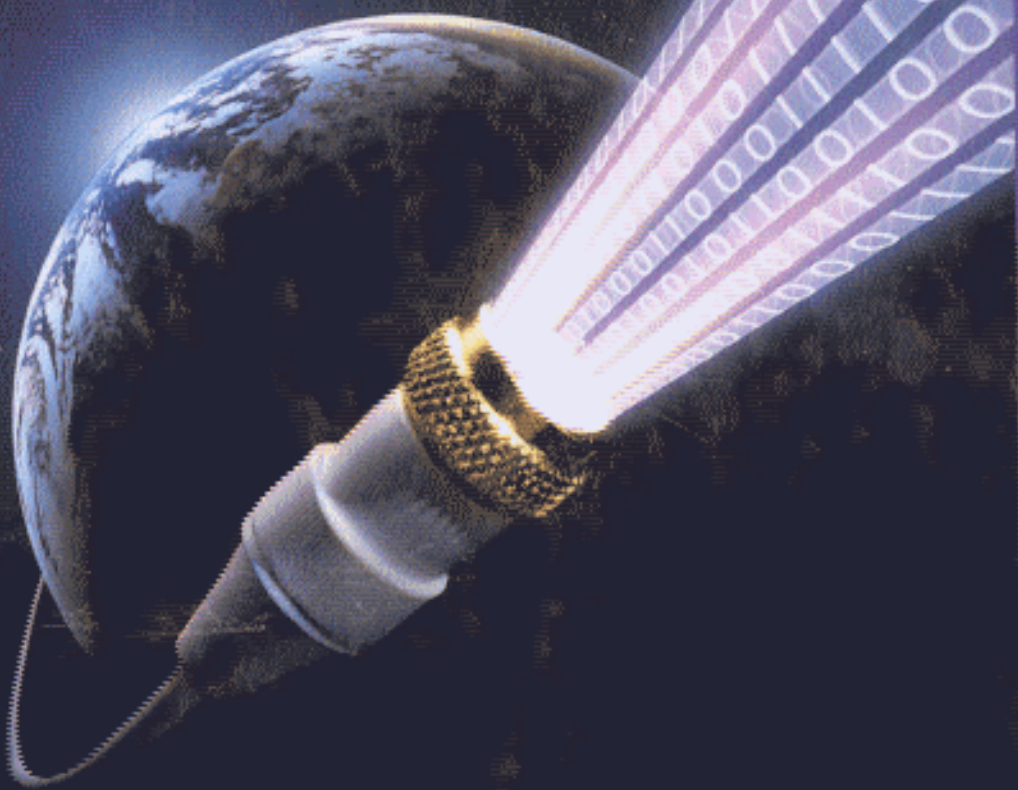


Programmable Logic Controllers



S. Brian Morriss

CONTENTS

Chapter 1 What Is a PLC? 1

- PLC Basics, 1
- Selecting the Right PLC, 9
- Evolution of the PLC, 11
- Troubleshooting, 15
- Questions, 17

Chapter 2 PLC Components 19

- The CPU Module, 20
- The Rack or Bus, 22
- The Power Supply, 22
- I/O Modules, 23
 - Digital Modules, 25
 - 29 31 32 33 34
 - Analog I/O Modules, 35
 - Intelligent I/O Modules, 37
 - 35 39 39 41
- Programming Units, 42
- Troubleshooting, 42
- Questions/Problems, 43

Chapter 3 Programming in Binary Logic (Boolean Logic) 45

- Ladder Logic for Bit Manipulation, 47
- Instruction List Programs for Bit Manipulation, 52
- Some Common Binary Logic Programming Tricks, 55
 - One-Shots, 55
 - Latching and Scaling, 56
 - Sequences, 58

Troubleshooting, 60
Questions/Problems, 61
Programming Exercises, 62
Suggested PLC Laboratory Exercises, 63

Chapter 4 Counters and Timers 65

Counter Instructions, 66

Timer Instructions, 67

68 72 77 78

Troubleshooting, 80

Questions/Problems, 82

Programming Exercises, 82

Suggested PLC Laboratory Exercise, 83

Chapter 5 Memory Organization and Data Manipulation 85

Memory Overview, 85

Data Types, 86

Addressing Modes, 87

Addressable Data Storage in PLCs, 88

89, 99 89, 102 104 116

139

Troubleshooting, 143

Questions/Problems, 145

Suggested PLC Laboratory Exercises, 147

Chapter 6 Manipulating Simple Data Elements 149

Microprocessor Basics, 150

Data Manipulation Instructions, 151

Simple Data Elements, 151

Moving Simple Data Elements, 151

152 153 157 159

Comparing Simple Data Elements, 160

160

Other Allen-Bradley Instructions, 161

162 163 164

Math, Logic, and Conversion Operations on Simple Data Elements, 165

166 168 171 174

Troubleshooting, 180

Questions/Problems, 182

Suggested PLC Laboratory Exercises, 184

Chapter 7 Manipulating Data in Files, Blocks, Arrays, and Structures 185

Files, Blocks, Arrays, and Structures Defined, 186

186 187 187 187

Bit Bit Arrays and Bit Shift Instructions, 188

189 191 191 192

Array Shift Instructions (Including FIFO and LIFO), 194

195 196 197 197

Moving Files, Arrays, and Structures, 200

201, 203 201, 203 205 209

212

Comparing Files, Arrays, and Structures, 214

215, 217 215 219

219

Math and Logic with Files, Arrays, and Structures, 220

220 222 222

Troubleshooting, 224

Questions/Problems, 225

Suggested PLC Laboratory Exercises, 226

Chapter 8 Program Structure and Structured Programming 227

Instructions That Affect Execution in a Single Program, 228

Master Control Reset/Relay, 228

229 231 232 234

Jump Instructions, 235

235 237 238 240

Loops, 240

241 241

Instructions That Affect Which Subprograms or Functions Are Executed during Program Scans, 242

243 245 249 263

Configurations That Affect Program Execution, 265

265 266 267 267

269

Troubleshooting, 270

Questions/Problems, 272

Suggested PLC Laboratory Exercises, 275

Chapter 9 IEC 1131-3: The Common Programming Language 277

Introduction to IEC 1131, 277

IEC 1131-3 Programming Languages, 279

Common Elements of an IEC 1131-3 Structured Program, 279

Algorithm and Data Types, 279

Configuration, 280

Resources, 281

Tasks, 282

Programs, 282

Function Blocks, 284

Program Organizational Units, 285

Programs, 285

Functions, 285

Function Blocks, 289

Variables and Variable Declarations, 291

Variable Declarations at the Configuration Level, 291

Variable Declarations at the Resource Level, 294

Variable Declarations at the Program Level, 295

Variable Declarations at the Function Block Level, 298

Variable Declarations at the Function Level, 299

Programming Languages in IEC 1131-3, 299

Ladder Logic, 300

Structured Text, 304

Sequential Function Chart, 305

Function Block Diagram, 310

Continuous Function Chart, 311

Summary, 313

Troubleshooting, 315

Bibliography, 316

Questions/Problems, 316

Chapter 10 PLC Setup and Configuration, 317

Installing and Configuring a New PLC, 317

Installing the Hardware, 318

318 322 322 326

329

First-Time Configuration of a PLC System to Prepare It for an Application, 331

332 344 349 356

369

Reconfiguration during Restart of a PLC Program,	374
374	375
375	377
Troubleshooting,	378
Questions/Problems,	381

Chapter 11 Interrupts 383

The Problem,	384
The Interrupt Solution,	385
More Detailed Descriptions of Interrupt Response,	388
Immediate Input and Immediate Output Instructions,	388
389	390
391	393
394	
The I/O Interrupt,	395
396	398
402	404
409	
Timed Interrupts,	419
420, 422	421, 422
424	426
431	
Fault Routine Interrupts,	437
437	440
441	446
Initialization Interrupts,	447
448	449
450	451
Communication Interrupts,	451
452	453
453	454
454	
Summary,	454
Troubleshooting,	456
Questions/Problems,	458
Suggested PLC Laboratory Exercise,	459

Chapter 12 Process Control 461

Introduction to Process Control,	461
The PLC in Process Control,	464
Improving the Performance of PLC Programs for Process Control,	467
Scaling of the Process Variable and the Control Variable,	467

Limiting the Control Variable,	470
Reducing Scan-Time Delay in Process Control,	470
	475
	476
	476
	476
Timed Interrupts,	476
	476, 479
	478, 481
	478, 481
	479, 481
	479
Inclusion of Other Values in the Calculation of Output,	482
Sophisticated Process Control Routines: PID Control,	487
	499
	499, 517
	525
	537
	542
Sophisticated Process Control Routines: Fuzzy Logic,	546
Taking Manual Control of the System,	550
Forcing Different Methods of Calculating the Control Output Depending on Sensed Conditions,	550
Troubleshooting,	553
Questions/Problems,	556
Suggested PLC Laboratory Exercises,	556

Chapter 13 Communications 559

PLC Communication Capabilities,	559
	562, 564
	562, 570
	with Profibus, 578
	578
	584
	592
Troubleshooting,	597
Questions/Problems,	599
Suggested Laboratory Exercise,	600

Chapter 14 Robotics, Automation, and PLCs 601

Robots and PLCs in Workcells,	601
Differences between Robot Controllers and PLCs,	601
Similarities between Robot Controllers and PLCs,	603
Programming a Robot and a PLC to Work Together,	604

Chapter 15 Troubleshooting 613

Systematic Approach,	613
Troubleshooting Hardware Outside the PLC,	614
Troubleshooting PLC Hardware, Configuration, and Programming,	615
	616, 620, 622
	620, 626
	628
	635
	644

Summary, 651

Questions, 651

Chapter 16 The Future: Wither the PLC? 653

Tomorrow's PLC, 654

Fieldbus and Sensor-Actuator Nets, 654

SCADA Systems, 657

Soft Logic, 658

Process Simulation, 660

Reflective Memory, 660

OMAC Motion and Process Control, 660

Questions, 661

Appendixes 663

Appendix A Allen-Bradley PLC-5 Status File Structure, 665

Appendix B Allen-Bradley SLC 500 Status File Structure, 669

Appendix C OMRON CQM1 SR and AR Memory Areas, 673

Appendix D Allen-Bradley Compare Instruction Operators, 681

Appendix E Allen-Bradley Compute (CPT) Instruction Operators and Precedence, 683

Appendix F Siemens S7 Status Bit Affected by Math and Logic Operations, 687

Appendix G Siemens S7 System Functions (FC), System Function Blocks (SFB), and IEC Functions (FC), 691

Appendix H Allen-Bradley PLC-5 Major and Minor Fault Bits and Codes, 697

Appendix I Allen-Bradley SLC 500 Major Fault Codes, 703

Appendix J Allen-Bradley PLC-5 PID Control Block, 713

Index 719