Allen-Bradley Co.
1747 Series Software
APS Release 4.02
Documentation Utility
Program Listing

ALYN 2/10/97

Processor File: DMCVDC4B.ACP
February 10, 1997 - 13:23

2:0
START OF LADDER LOGIC FOR VACUUM DIE CAST CYCLE

N MODE CYCLE POWER ON
ALT START
INPUT
TIMER

S7 T4:2 I:1 B3
[ ] [ ] [ ]--(
1 TT 0 10
CYCLE ON
B3
]--[
10

2:1
LOAD HSCE WITH FILE IN ONE SCAN FROM N10:0 FILE
ER 0%

I:1 B3 S7
]--[OSR]---( )--
0 8

2:2

TEST
H.S.C.E.
-COP-
+COPY FILE +-
Source #N10:0
Desi #N0:7.0
Length 42
+-

2:3
HSCE FUNCTION CONTROL
T ON POWER ON

HSCE
FUNCTION
CONTROL
"DN"

S7 I:1 40:3.1
]--------[ ]---( )--
11 0 12

4
HSCE TIMER RESET
DN DIE CLOSED
INPUT

RESET
TIMER
FOR HSCE
COUNTER

I:1 -TON-
]--------[ ]---+TIMER ON DELAY --EN-
1 -- T4:2 12--TN

```
                                                                                                                    Time Base     0.01
                                                                                                                    Preset         100
                                                                                                                    Accum            0
                                                                                                                   ----------------+

2:5
   HSCE TIMER RESET FUNCTION
ES ON  |DIE CLOSED|RESET                                                                                                    HSCE RESET
       |INPUT     |TIMER                                                                                                    BIT ON
                  |DN
                  |
                  |

2:6       I:1         T4:1                                                                                                  N9:3.1
]-----------[---------]-----------------------------------------------------------------------------------------------------------]
  0         6         TT                                                                                                      6

2:6
S OFF METAL VALUE OUTPUTS AT END OF PLUNGER STROKE (METAL INJECTION)
 CLOSED        INTERGER                                                                                                  LATCH BIT
?              FILE SET
               POINT

2:6       +GRT----------------+                                                                                             33
]-----------+GREATER THAN     +-----------------------------------------------------------------------------------------------]
  6       |Source A    I:3.1| |                                                                                             0
          |            0    | |
          |Source B    N10:16| |
          |            100  | |
          +-------------------+ |
          |LATCH BIT          |
          |FROM METAL         |
          |INJECTION          |
          |OUTPUTS            |
          |OFF                |
          |      33           |
          +-----]  ]----------+
                 6

2:7
MORE  |CYCLE                                                                                                              TIMED
IT    |START                                                                                                              INPUT
      |INPUT                                                                                                              CHECK FROM
      |FROM DCM                                                                                                           DCM

 B3       I:1                                                                                                  +TON----------------+
]-----------[-----------------------------------------------------------------------------------------------------------TIMER ON DELAY    +-(EN)-
  ]          5                                                                                                  Timer          T4:2+-(DN)
                                                                                                                Time Base      0.01
                                                                                                               !Preset          20
                                                                                                                Accum            0
                                                                                                               ------------------

2:8
E ON  |DIE CLOSED
      |INPUT

 BC       I:1                                                                                                  +TON----------------+
]-----------[-----------------------------------------------------------------------------------------------------------TIMER ON DELAY    +-(EN)-
 ]                                                                                                              Timer          T4:55+-(DN)
```

Time Base	1.0
Preset	300
Accum	0

2:9

VACUUM PUMP MOTOR ON

RUN MODE ON PI: MOTOR DWELL TIMER 1 T4:36 — LOW OIL SWITCH I:1 — MOTOR ON 0:2/0

B3 — TT

MOTOR DWELL TIMER 2 T4:37 — TT

T4:55 — TT

MANUAL VACUUM TEST OK B3 — J7

PURGE TEST B3 — 3E

2:10

RESET TIMER FOR AUTOMATIC CYCLE OF PURGE&VAC

T4:1 — TT

TOF TIMER OFF DELAY +-(EN)-
Timer T4:34-(DN)
Time Base 1.0
Preset 12
Accum 12

2:11

TIME SYSTEM PRESSURE UPDATE FOR DTAM PLUS OPERATOR INTERFACE

PRESSURE TRANSDUCER INPUT TO INTERGER FILE

MOV MOVE
Source I:4.0 / 2443
Dest N7:16

2:12
TIMER FOR MOTOR TO SHUT DOWN WHEN NOT IN USE DURING
'RUN' MODE
TOMATIC
LE
ET
EF
PUT
T4:3 B3
] [---+---

2:14
ARGE PHYSICAL OUTPUTS ENABLED FOR MAIN PROCESSOR CONTROL
PLUG 1 OUTPUTS 0, 2. PLUG 2 OUTPUTS 1,3.



2:15
TIMER T4:4 INPUT FOR FIRST VAC PURGE OF VALVE



2:16
DELAY FOR START OF PURGE CHECK



2:17
PURGE CHECK TIMER FOR FAULT

2:18
EXCESS PRESSURE CHECK FOR FAULT AT PURGE

2:19
OUTPUT TO DTAM ALARM SCREEN

2:20
RGE
GE
ENIODS
TIMER
T4:4
TT
DELAY
BIT FOR
VAC PURGE
B3
TT
GE TEST
B3

2:2]
START OF PURGE TMQ. AIR OFF METAL VALVE OPEN
GE 1 LARGE
E START SOLENOIDS
PURGE 2 ON TIMER

T4:6
EN
+TON----------+
+TIMER ON DELAY +-(EN)-
!Timer T8:7+-(DN)
!Time Base 0.01!
!Preset 75!
!Accum 0!
+-----------+

:+2]
ARGE 2 OUTPUT FOR LARGE SOLENOIDS

T
T

:+2]
E 2 DONE 1 SECOND TIME SPACER

+TON----------+
+TIMER ON DELAY +-(EN)-
!Timer T4:9+-(DN)
!Time Base 0.01!
!Preset 50!
!Accum 0!
+-----------+

:24
LE SPACER DONE START OF VACUUM LEAK DOWN TEST
E VACUUM
EP CONTROLS
$MOTOR
ON

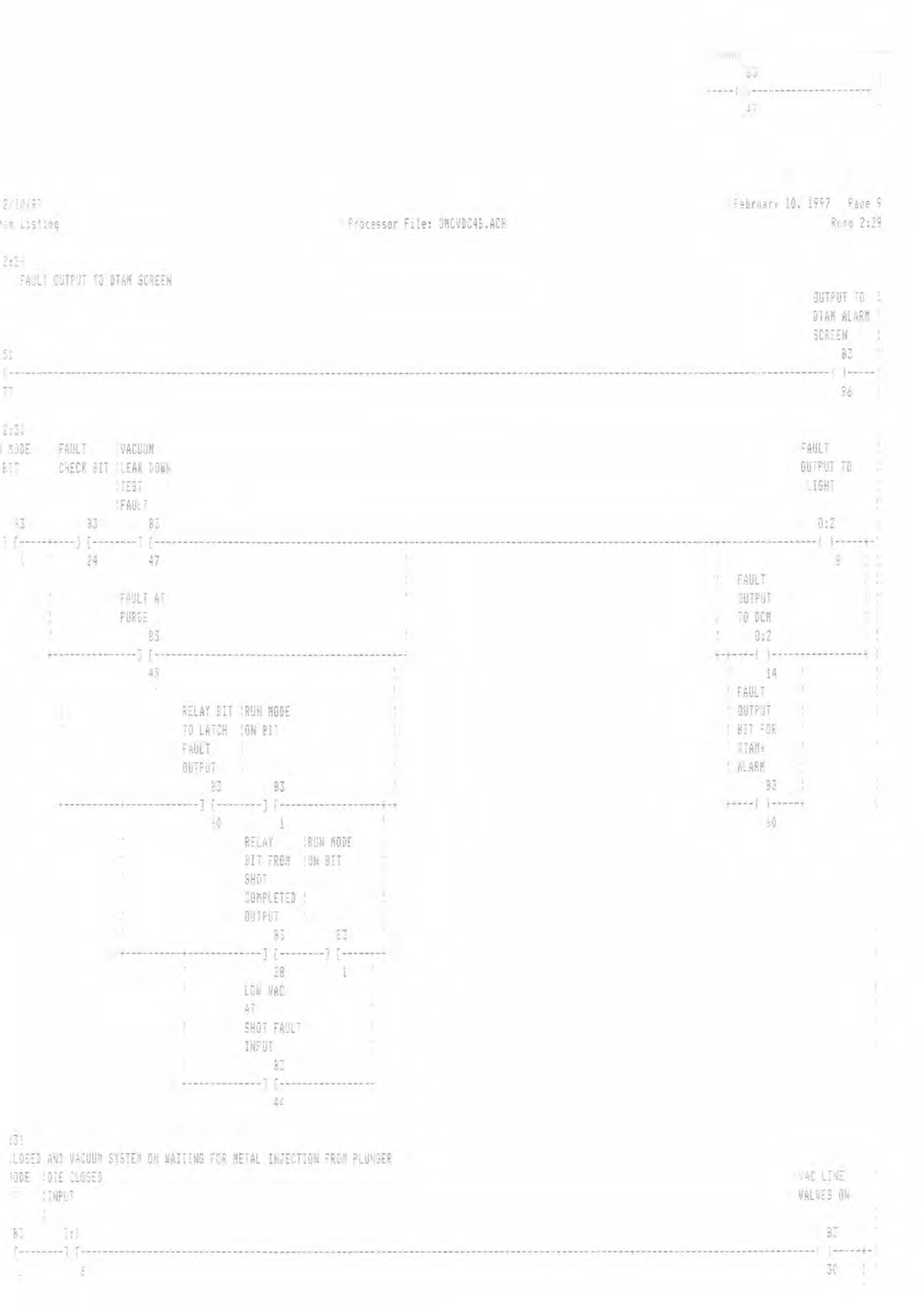
T4:9
DN
-TON----------+
+TIMER ON DELAY +-(EN)-
!Timer T4:10+-(DN)
!Time Base 0.01!
!Preset 200!
!Accum 0!
+-----------+

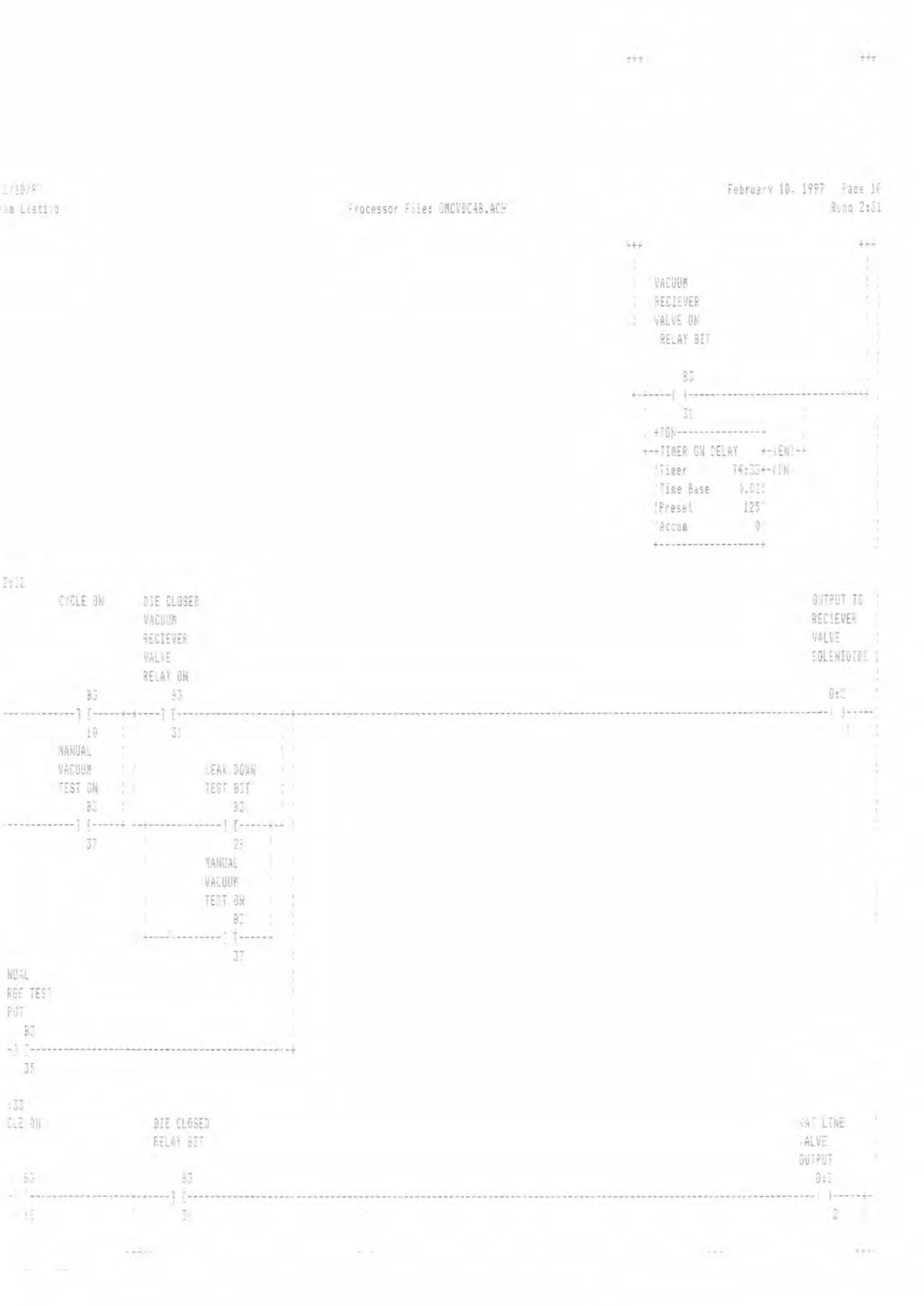
:2]
COUM TO VACUUM
LE LINE
CONTROL
VALVES

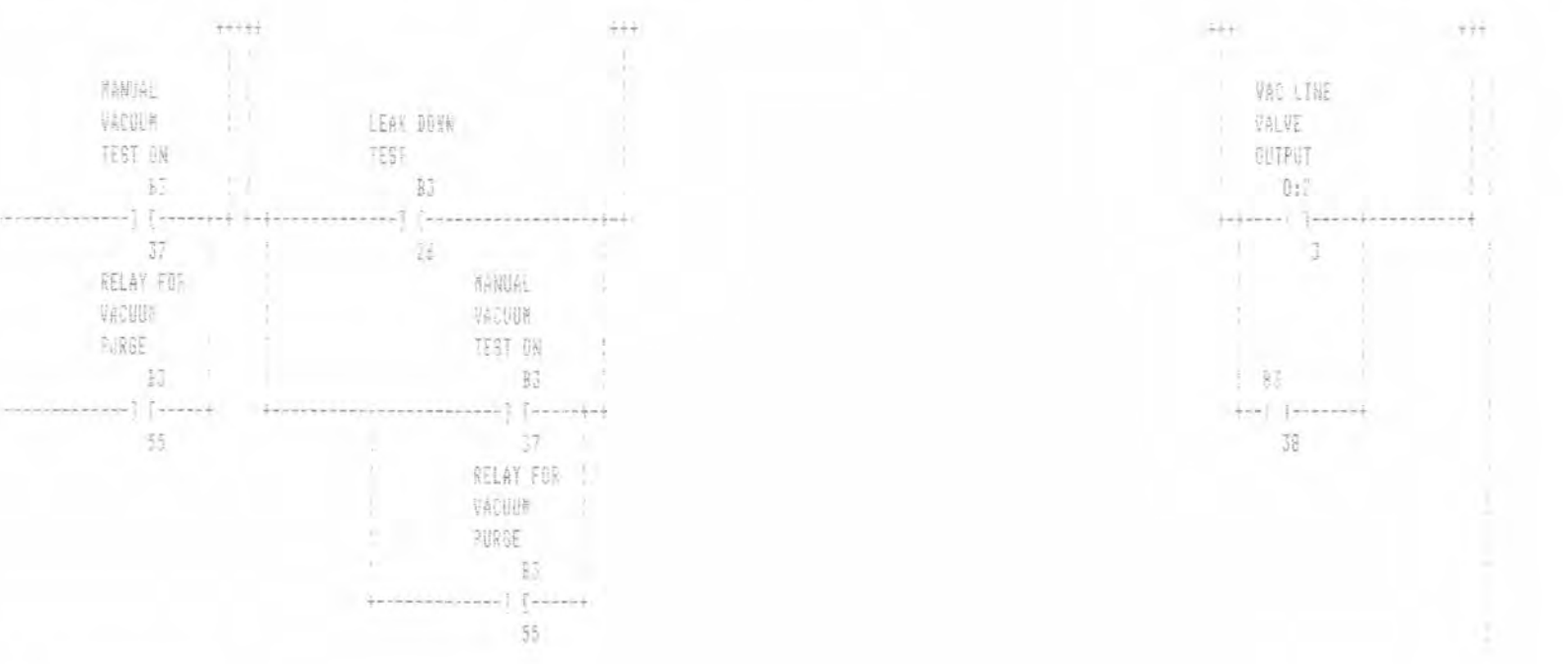
T4:10
TT


TO VACUUM RECIEVER CONTROL VALVE
B3
39
2:24
LEAK DOWN TIME CHECK FOR METAL VALVES DURING AUTOMATIC CYCLE
TIMER FOR LEAK DOWN
TON
TIMER ON DELAY
EN
Timer T4:12
DN
Time Base 0.01
Preset 500
Accum 0
2:27
K DOWN TIMED OUT CHECK FOR FAULT
K DOWN
D OUT
FAULT CHECK BIT
B3
24
UPDATE FOR PRESS. TRANSDUCER INPUT
MOV
MOVE
Source I:4.0
2444
Dest N7:10
2444
2:25
VACUUM CHECK AT DIE CLOSE
E ON
FAULT CHECK BIT
B3
GRT
GREATER THAN
Source A N7:10
2444
Source B N7:11
1148
TOF
TIMER OFF DELAY
EN
Timer T4:51
DN
Time Base 0.01
Preset 550
Accum 531
OUTPUT TO FAULT

2:29
FAULT OUTPUT TO DTAM SCREEN




VACUUM
RECIEVER
VALVE ON
RELAY BIT
B3
31
+TON
TIMER ON DELAY
Timer T4:33
Time Base 0.01
Preset 125
Accum 0
2:52
CYCLE ON
DIE CLOSED
VACUUM
RECIEVER
VALVE
RELAY ON
B3
93
10
31
OUTPUT TO
RECIEVER
VALVE
SOLENIGIDE
MANUAL
VACUUM
TEST ON
B3
37
LEAK DOWN
TEST BIT
B3
25
MANUAL
VACUUM
TEST ON
B3
37
B3
35
2:53
CLE ON
DIE CLOSED
RELAY BIT
VAC LINE
VALVE
OUTPUT
B3
56



2:34
VUUM DURING SHOT TIMER
CLOSED)CYCLE ON
IT

TIMER TO SET VAC UPDATE POINT

B3
37
10

+TON
+TIMER ON DELAY +-(EN)-
!Timer T4:16 -(DN)
!Time Base 0.01
!Preset 800
!Accum 0

2:35
G BUTTON NOT RUN BUTTON

I:1
2:1

JOG LATCH RELAY
B3
39

G CYCLE TCH
B3
32

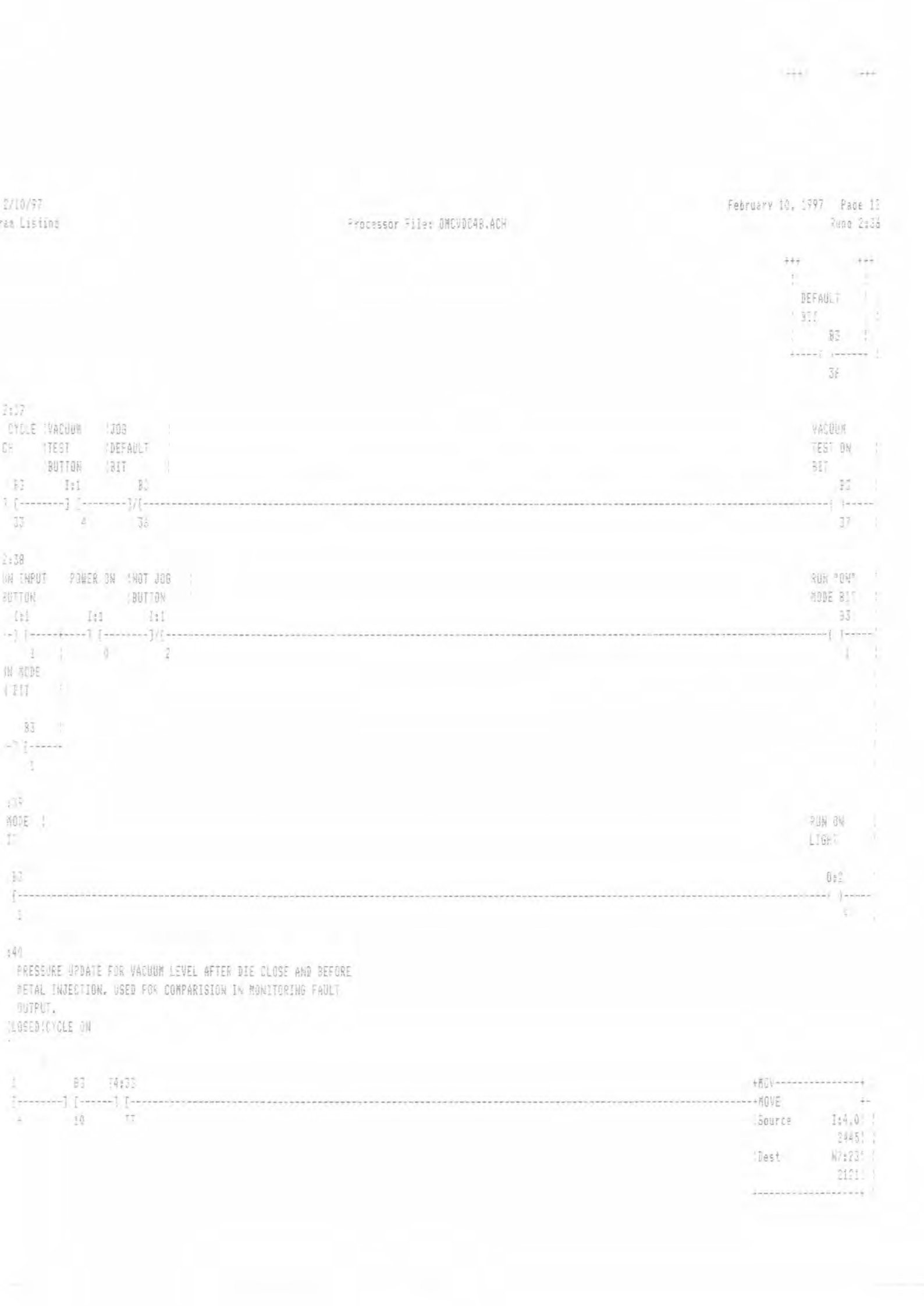
JOG LIGHT OUTPUT
O:2
10

2:36
YCLE (PURGE INPUT BUTTON

OUTPUT TO AIR VALVES LARGE SOLENOIDE

B3
I:1
32

B3
35


DEFAULT BIT
B3
36
2:37
CYCLE CH
VACUUM TEST BUTTON
JOG DEFAULT BIT
B3
I:1
B3
33
4
36
VACUUM TEST ON BIT
33
37
2:38
ON INPUT BUTTON
POWER ON
NOT JOG BUTTON
I:1
I:1
I:1
33
1
0
2
1
RUN "ON" MODE BIT
IN MODE BIT
B3
2:39
MODE
37
RUN ON LIGHT
32
0:2
1
0
2:40
PRESSURE UPDATE FOR VACUUM LEVEL AFTER DIE CLOSE AND BEFORE
METAL INJECTION. USED FOR COMPARISION IN MONITORING FAULT
OUTPUT.
CLOSED
CYCLE ON
B3
T4:33
10
TT
MOV
MOVE
Source
I:4,0
2445
Dest
N7:23
2121

2:41
PLUNGER POSITION SET POINTS FOR MEASURING VACUUM DURING THE
METAL INJECTION CYCLE

2:42
TIMED CHECK OF VACUUM DURING SHOT

2:43
CLOSED CYCLE ON
UPPER LIMIT FOR VACUUM FAULT

2:44

2:45
PLUNGER POSITION SET POINTS FOR MEASURING VACUUM DURING THE
METAL INJECTION CYCLE



2:46
OUTPUT TO FAULT LIGHT



2:47

END

T OPTIONS SUMMARY

Insure Valid X-Ref Info:	YES
Graphics Mode:	NO
Page Width:	150
Page Length:	66
Starting File:	2
Ending File:	2
Power Rail:	YES
Address Comments:	YES
Address Display:	YES
Rung Comments:	YES
Ladder Cross Reference:	NONE

Allen-Bradley Co.
1747 Series Software
APS Release 4.02
Documentation Utility
Cross Reference

ALYN 2/10/97

Processor Files ORCVDC4B.PCH
February 10, 1997 - 13:23

ess	Symbol / Instruction	Comment / File Numbers/Rung Number
	-[ ]-	RUN MODE ON BIT
	2:0 2:7 2:9 2:30 2:30 2:30 2:31 2:38 2:39	
	-( )-	RUN "ON" MODE BIT
	2:36	
		LATCH BIT
	-[ ]-	LATCH BIT FROM METALINJECTION OUTPUTS OFF
	2:8 2:14	
	-[/]-	LATCH BIT FROM METALINJECTION OUTPUTS OFF
	2:15	
	-[ ]- 2:6	
	-OSR- 2:1	
	-[ ]- 2:2	
	-[ ]- 2:4	
	-[ ]-	CYCLE ON
	2:0 2:3 2:8 2:13 2:28 2:32 2:33 2:34 2:40 2:41 2:43 2:45	
	-[ ]- 2:0	
	-[ ]- 2:10 2:16	
	-[ ]- 2:12	
	-[ ]-	PURGE 2 INPUT
	2:15	
	-[ ]- 2:22	
	-[ ]-	FAULT CHECK BIT
	2:28 2:30	
	-[ ]-	FAULT CHECK BIT
	2:27	
	-[ ]-	LEAK DOWN TEST
	2:33	
	-[ ]-	TO VACUUM LINE CONTROL VALVES
	2:25	
	-[ ]-	RELAY BIT FROM SHOT COMPLETED OUTPUT
	2:30	
	-[/]-	RELAY INPUT FROMFAULT RUNG
	2:4	

ess	Symbol / Instruction	Comment / File Number:Rung Number
	-] [-	LEAK DOWN TEST BIT
		2:38
	-( )-	TO VACUUM RECIEVER CONTROL VALVE
		2:25
	-] [-	DIE CLOSEDRELAY BIT
		2:33
	-( )-	VAC LINE VALVES ON
		2:31
	-] [-	DIE CLOSEDVACUUM RECIEVER VALVE RELAY ON
		2:32
	-( )-	VACUUM RECIEVER VALVE ON RELAY BIT
		2:31
	-] [-	JOG CYCLE LATCH
		2:35 2:36 2:37
	-( )-	JOG LATCH RELAY
		2:31
	-] [-	MANUAL PURGE TESTINPUT
		2:15 2:20 2:31
	-( )-	OUTPUT TO AIR VALVE&LARGE SOLINOIDE
		2:34
	-] [-	PURGE TEST
		2:9
	-]/[-	JOG DEFAULT BIT
		2:37
	-( )-	DEFAULT BIT
		2:36
		VACUUM TEST ON
	-] [-	MANUAL VACUUM TEST ON
		2:9 2:25 2:32 2:32 2:33 2:33
	-( )-	VACUUM TEST ON BIT
		2:37
	-)-	2:33
	-] [-	LOW VAC AT SHOT FAULTINPUT
		2:30
	-)-	OUTPUT TO FAULT RUNS
		2:41

ces	Symbol / Instruction	Comment / File Number:Rung Number
	-] [-	FAULT AT PURGE
	2:30	
	-( )-	TO FAULT OUTPUT
	2:18	
	-] [-	VACUUM LEAK DOWN TEST FAULT
	2:30	
	-( )-	OUTPUT TO FAULT RUNG
	2:28	
	-] [- 2:42	
	-( )- 2:41	
	-] [-	RELAY FOR VACUUM PURGE
	2:33 2:33	
	-( )-	RELAY BIT FOR VAC PURGE
	2:20	
	-] [-	RELAY BIT TO LATCH FAULT OUTPUT
	2:30	
	-( )-	FAULT OUTPUT BIT FOR DTAM+ ALARM
	2:30	
	-( )-	FAULT OUTPUT TO ALARM SCREEN
	2:19	
	-( )-	OUTPUT TO DTAM ALARMSCREEN
	2:29	
	-( )-	OUTPUT TO DTAM ALARMSCREEN
	2:44	
	-] [-	POWER ON
	2:0 2:1 2:3 2:4 2:5 2:38	
	-] [-	RUN INPUT BUTTON
	2:33	
	-]/[-	NOT RUN BUTTON
	2:35	
	-( )-	JOG BUTTON
	2:31	

ess	Symbol / Instruction	Comment / File Number:Rung Number
	-] [-	PURGE INPUT BUTTON
		2:36
	-] [-	VACUUM TEST BUTTON
		2:37
		CYCLE START INPUT FROM DCM
	-] [-	2:7
		DIE CLOSEDINPUT
	-] [-	2:4 2:5 2:6 2:8 2:31 2:34 2:40 2:41 2:43 2:45
	-]/[-	NOT DIE CLOSEDINPUT
		2:14 2:15
	-] [-	LOW OIL SWITCH
		2:9
		INTERGER FILE SET POINT
	-GRT-	2:6 2:41 2:45
	-LES-	2:41 2:45
	-MOV-	2:11 2:27 2:40 2:41 2:45
		DEST P.S.C.E.
	-COP-	2:2
10	-( )-	2:14
11	-( )-	2:14
12		HSCE RESET BIT ON
	-( )-	2:5
13	-( )-	HSCE FUNCTION CONTROL "ON"
		2:3
	-GRT-	2:28
	-MOV-	UPDATE FOR PRESS.TRANSDUCERINPUT
		2:27
	-GRT	2:28

-MOV- PRESSURE TRANSDUCERINPUT TO INTERGER FILE
2:11

Symbol / Comment /
Instruction File Number:Rung Number

-LES- 2:18

-GRT- UPPPER LIMIT FOR VACUUM FAULT
2:43
-MOV- VACUUM AT SHOT PRESSTRANEDUCER UPDATE
2:41 2:45

-MOV- 2:40

-GRT- 2:43

-COP- 2:2

-GRT- 2:41 2:45

-GRT- 2:6
-LES- 2:41 2:45

MOTOR ON
-( )- 2:9

-( )- OUTPUT TO RECIEVER VALVE SOLENOIDE
2:32

-( )- VAC LINE VALVE OUTPUT
2:33

-( )- VAC LINE VALVE OUTPUT
2:31

-( )- FAULT OUTPUT TO LIGHT
2:30

-( )- RUN ON LIGHT
2:39

-( )- DOG LIGHT OUTPUT
2:35

-| |- OUTPUT TO SHOT COMPLETED
2:46

Symbol / Instruction	Comment / File Number:Rung Number
-| |-	FAULT OUTPUT TO DCM
2:30	
-| |-	LARGE SOLENOIDS PHYSICAL OUTPUTS ON
2:15	
-( )- 2:15	
	RESET TIMER
-TON-	RESET TIMER FOR HSCE COUNTER
2:4	
	RESET TIMER ON
-] [- 2:5	
	TIMED INPUT CHECK FROMDCM
-TON- 2:7	
-] [-	CYCLE START INPUT TIMER
2:0 2:10	
	RESET TIMER FOR AUTOMATIC CYCLE OF PURGE&VAC
-TOF- 2:10	
	AUTO CLCLERESET TIMER
-] [-	AUTOMATIC CYCLE RESET TIMER OUTPUT
2:12	
-TON-	LARGE SOLENOIDE ON TIMER
2:13	
-] [-	PURGE 1 LARGE SOLENOIDS ON TIMER
2:15 2:20	
-TON-	PURGE ONE PLUS DELAY BETWEEN PURGE TWO
2:13	
-] [-	PURGE 1 DONE STARTOF PURGE 2
2:21	
-TON-	LARGE SOLENOIDE ON TIMER
2:21	

Symbol / Instruction	Comment / File Number:Rung Number
-] [- 2:23	
-] [- 2:22	
-TON- 2:23	
-] [- 2:24	CYCLE SPACER DONE
-TON- 2:24	VACUUM CONTROLS MOTOR ON
-] [- 2:25	
-] [- 2:25	VACUUM CYCLE ON
-TON- 2:26	TIMER FOR LEAK DOWN
-] [- 2:27	LEAK DOWN TIMED OUT
-TON- 2:34	TIMER TO SET VAC UPDATE POINT
-TON- 2:17	
-] [- 2:15	
-TON- 2:16	
-] [- 2:17	
-TOF- 2:45	
-] [- 2:46	INPUT TO SHOT COMPLETED LIGHT

-TON- 2:31

ess	Symbol / Instruction	Comment / File Number:Rung Number
S/TT		
	-] [- 2:40	
	-TON- 2:12	
/TT		
	-] [- 2:9	MOTOR DWELL TIMER 1
	-TOF- 2:12	
TT		
	-] [- 2:9	MOTOR DWELL TIMER 2
	-TOF- 2:42	
TT		
	-] [- 2:43	
	-TOF- 2:18	
TT		
	-] [- 2:19	
	-TOF- 2:28	
T		
	-] [- 2:29	
	-TOF- 2:43	
T		
	-] [- 2:44	
	-TON- 2:8	
T		
	-] [- 2:9	

T OPTIONS SUMMARY

Insure Valid X-Ref Info:	YES
Graphics Mode:	NO
Page Width:	160
Page Length:	66
Starting Value:	9
Ending Value:	T
Sort Order:	ADSREDB
Address Comments:	YES
Instruction Mnemonics:	YES

Allen-Bradley Co.
1747 Series Software
APS Release 4.02
Documentation Utility
Data Table

ALYN 2/10/97

Processor File: QMKVDC4B.ACH
February 10, 1997 - 13:23

se	Data (Radix=HEX)
	4300
	E33E

ess	Data (Radix=HEX)
	028
	E5DA
	0000
	0000
	1000
	0000
	0C00
	0000
	0000
	0000
	0000
	0000
	0009

METIC FLAGS S: 0 Z: 0 V: 0 C: 0

SSDF STATUS 00000000 00000000 SUSPEND CODE 0
SSOR STATUS 00000000 10000001 SUSPEND FILE 0
SSTR STATUS 10000000 00101010
WATCHDOG [x10 ms] 10
FAULT 00000000 00000000 LAST SCAN [x10 ms] 0
CODE 0000 FREE RUNNING CLOCK 10000001 01110011
DESCRIPTION:

REGISTER 0000 0000

E NODE LIST I/O SLOT ENABLES
10 20 30 0 10 20 30
000 00000000 00000000 00000000 11111111 11111111 11111111 11111111

SSOR BAUD RATE 19200 PROCESSOR ADDRESS 1

I/O SLOT INTERRUPT ENABLES
SCAN [x10 ms]: 0 0 10 20 30
11111111 11111111 11111111 11111111
VE SCAN [x10 ms]: 0
IM SCAN [x10 ms]: 3
I/O SLOT INTERRUPT PENDING
REGISTER VALUE: 0 0 10 20 30
ACROSS FILES: YES 00000000 00000000 00000000 00000000

ROUTINE SUBROUTINE FILE: 0 I/O INTERRUPT FILE EXEC: 0

ABLE TIMED INTERRUPT SINGLE STEP TEST FILE RUNG
OUTINE FILE: 0 START STEP ON: 0 0
OINT [x10 ms]: 0 END STEP BEFORE: 0 0
LED: 1 FAULT/POWER DOWN: 0 0
UTING: 0 COMPILED FOR SINGLE STEP: NO
ING: 0

ess	Data (Radix=BINARY)	Address	Data (Radix=BINARY)	Address	Data (Radix=BINARY)	Address	Data (Radix=BINAR()
	1110 0101 0011 1010	B3:4	0000 0000 0000 0000	B3:8	0000 0000 0000 0000	B3:12	0000 0000 0000 0000
	0000 0000 0000 0000	B3:5	0000 0000 0000 0000	B3:9	0000 0000 0000 0000	B3:13	0000 0000 0000 0000
	0000 0000 0000 0000	B3:6	0000 0000 0000 0000	B3:10	0000 0000 0000 0000	B3:14	0000 0000 0000 0000
	0001 0000 0000 0000	B3:7	0000 0000 0000 0000	B3:11	0000 0000 0000 0000		

ss	EN	TT	DN	TIME BASE	PRE	ACC
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	100	0
	0	0	0	.01 sec.	30	0
	0	0	0	1.0 sec.	12	12
	0	0	0	.01 sec.	150	0
	0	0	0	1.0 sec.	300	0
	0	0	0	.01 sec.	200	0
	0	0	0	.01 sec.	75	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	50	0
	0	0	0	.01 sec.	200	0
	0	0	0	.01 sec.	200	0
	0	0	0	.01 sec.	500	0
	0	0	0	.01 sec.	300	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	9	9
	0	0	0	.01 sec.	800	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	150	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	75	0
	0	0	0	.01 sec.	75	0
	0	0	0	.01 sec.	300	300
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	125	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	5000	0
	1	0	0	1.0 sec.	300	75
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	100	100
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	1.0 sec.	15	0
	0	0	0	1.0 sec.	12	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	0	0
	0	0	0	.01 sec.	550	550
	0	0	0	.01 sec.	550	551
	0	0	1	.01 sec.	550	550
	0	0	0	.01 sec.	0	0

4	0	9	1	.01 sec.	0	2
5	1	6	0	1.0 sec.	300	9

Table File 5 IS EMPTY
Table File 6 IS EMPTY

ss Date (Radix=DECIMAL)

1	3	0	0	0	0	0	0	0	0	2444	1148	0	0	0	0	2445	0	0	0	476
0	1373	2121	2482	492	0	0	0	0	100	300	0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0	0	16375	19562	18575	16562						

Table File 8	RESERVED
Table File 9	NOT IN USE

ss Data (Radix=DECIMAL)

	0	18562	1	3	0	0	0	0	0	255	20	80	0	0	0	0	100	32767	0	0	70
1	90	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0

File Length:0
File Length:0
File Length:42
File Length:0
File Length:0
File Length:0
File Length:0

File Length=0
File Length=0
File Length=0
File Length=0
File Length=0
File Length=0
File Length=0

T OPTIONS SUMMARY

Insure Valid X-Ref Info:	YES
Graphics Mode:	NO
Page Width:	160
Page Length:	66
Starting File:	0
Ending File:	10
Input File Radix:	HEX
Output File Radix:	HEX
Integer File Radix:	DECIMAL
Binary File Radix:	BINARY
X0 File Radix:	HEX
X1 File Radix:	HEX

Allen-Bradley Co.
1747 Series Software
APS Release 4.02
Documentation Utility
Processor Config

ALYN 2/10/97

Processor File: CHCVDC4P.ACH
February 10, 1997 - 13:23

CONFIGURATION FOR: OMCVDC4B

1 = 1746-A7 7-slot Backplane

CATALOG #	CARD DESCRIPTION	CONFIG. - SIZE
1747-L524	5/02 CPU - 4K USER MEMORY	
1746-IA8	8-Input 100/120 VAC	
1746-OA16	16-Output(TRIAC) 100/240 VAC	
1746-HSCE	High Speed Counter/Encoder	
1746-NI4	4 Ch. Analog Input	
#####	NOT CONFIGURED #####	
#####	NOT CONFIGURED #####	

RT OPTIONS SUMMARY

Insure Valid X-Ref Info:	YES
Graphics Mode:	NO
Page Width:	160
Page Length:	66

OMC

VACUUM