Pro-face

Device/PLC Connection Manuals

About the Device/PLC Connection Manuals

Prior to reading these manuals and setting up your device, be sure to read the "Important: Prior to reading the Device/PLC Connection manual" information. Also, be sure to download the "Preface for Trademark Rights, List of Units Supported, How to Read Manuals and Documentation Conventions" PDF file. Furthermore, be sure to keep all manual-related data in a safe, easy-to-find location.

A ▶ **Toyoda Machine Works**

A.1 ▶ **Maximum Number of Consecutive Device Address**

The following lists the maximum number of consecutive addresses that can be read by each PLC. Refer to these tables to utilize *Block Transfer*.

Note: **When the device is setup using the methods below, the Data Communication Speed declines by the number of times the device is read.**

- **When consecutive addresses exceed the maximum data number range**
- **When an address is designated for *division***
- **When device types are different**

To speed up data communication, plan the tag layout in screen units, as consecutive devices. (Includes the Alarm and Trend screens.)

■ **PLCs**

<TOYOPUC-PC2 Series>

Device	Max. No. of Consecutive Address	Device	Max. No. of Consecutive Address
Input Relay X		Timer (contact) T	
Output Relay Y		Counter (contact) C	
Internal Relay I		Data Register D	
Keep Relay K	128 Words	Link Register R	128 Words
Link Relay L		File Register B	
Edge Detect P		Current Value Register N	

A.2   Device Codes and Address Codes

Device codes and address codes are used to specify indirect addresses for the E-tags or K-tags.

The word addresses of data to be displayed are coded and stored in the word address specified by the E-tags and K-tags. (Code storage is done either by the PLC, or with T-tag and K-tags)

■ PLCs

<TOYOPUC-PC2 Series>

	Device	Word Address	Device code (HEX)	Address code
Bit Device	Input Relay	X0000~	8000	Word Address
	Output Relay	Y0000~	8800	Word Address
	Internal Relay	M0000~	9000	Word Address
	Keep Relay	K0000~	C000	Word Address
	Link Relay	L0000~	C800	Word Address
Word Device	Register (current value)	N0000~	6000	Word Address
	Data Register	D0000~	0000	Word Address
	Link Register	R0000~	4800	Word Address
	File Register	B0000~	7800	Word Address
	Special Register	S0000~	5000	Word Address
	LS area	LS0000~	4000	Word Address