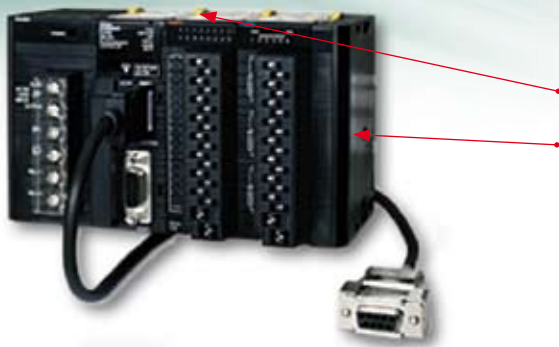
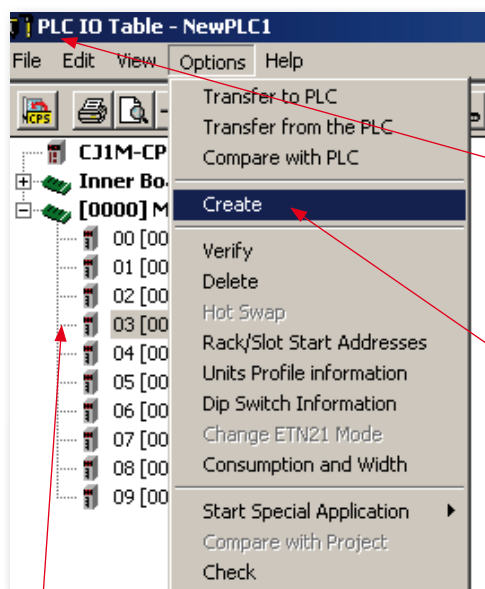


Creating an I/O Table on a CJ1 PLC



- 1A Assemble all the I/O modules and power supply module to the CPU.
- 1B Initially, make sure all modules are clipped together securely
- 1C Once assembled ensure the end plate is fitted to far right hand end
- 1D If expansion racks are used, connect these, otherwise I/O table will be incorrect, if expansion is added later
- 1E If special I/O modules are used, ensure they have different unit numbers
- 1F Switch on the power to the CPU, and any expansion racks

Always make sure power is off, and offline, before attempting to change units



- 2 **Connect online to the PLC**
- 2A Once online to the PLC, go into **PLC TAB**, followed by **OPERATING MODE**, and in there select **PROGRAM MODE**.
- 2B The run light of PLC should now be off. The PLC is now ready to have the I/O table created.
- 2C Double click on the **I/O TABLE** and unit set up in the workspace on the left hand side of screen. This will launch another window.
- 2D If the workspace is not present, it can be found by clicking **VIEW** at the top of CXP. Then select **WINDOWS**, followed by **WORKSPACE**. You can now go back to step 2C, and launch the I/O table window.
- 2E From the **PLC IO table** menu, select **OPTIONS**, and then **CREATE**. Initialise CPU Bus settings **Y**, tick both **I/O TABLE** and **S I/O UNIT TABLE**

3 What can be seen in the I/O table

- 3A Click on the + to the left of where it says (0000) Main Rack. The rack should expand out and show all modules connected to the CPU.
- 3B The first 2 digit number is the slot number in the rack (Slot 00 being next to the CPU and reading left to right.)
- 3C The next 4 digit number will be the start address of the I/O module in that slot in the case of ordinary I/O (in the case of special I/O has separate addressing for each module, and varies depending on what unit is being used)
- 3D The next part is the full description of the module fitted. In the case of special I/O, will contain the unit number.