



Integrated Manufacturing Systems Troubleshooting (IMST) Level 1

Attachment 1-18

PLC 5 TROUBLESHOOTING ANSWERS

PLC 5 Troubleshooting Answers

Exercise	Answer
2	Full Depth Limit Switch - or Broken Wire or Mechanical Actuator - or
3	Adapter Fault or Blown Output card
4	Output Card Fuse
5	E-stop PB - or open Wire - or
6	Bad Input Module
7	Bad Output solenoid - Stuck Dir. Valve. Or Mechanical Jam or -
8	Return Limit Switch Stuck or Shorted or -

Remember: Watch out for missing Power or Air or Hydraulics

Remember: It makes a difference if the machine just quit... or it could never be started. (Permissives)

Remember: If a problem is not fixed on one shift... the next shift may face 2 problems.



**Multi-State
Advanced Manufacturing
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US DOL SPONSORED TAACCCT GRANT: TC23767
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RELEASE DATE 09/30/16
VERSION v 001
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