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 ▶ Shimaden

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.)

■ Controllers

<SR253/SR90/SR80/MR13/FP93/SD16/EM70 Series>

Device	Max No. of Consecutive Address
Data Address	10 Words

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)

■ Controllers

<SR253/SR90/SR80/MR13/FP93/SD16/EM70 Series>

Device	Word Address (HEX)	Device Code (HEX)	Address Code (HEX)
Data Address	0020~03FF	0200	Word Address - 0020
	0400~07FF	0400	Word Address - 0400
	0800~0BFF	0600	Word Address - 0800
	0C00~0D7F	0800	Word Address - 0C00