

Ethernet/IP for iNspect

Using AB Controllers SLC/505 or Micrologix 1100

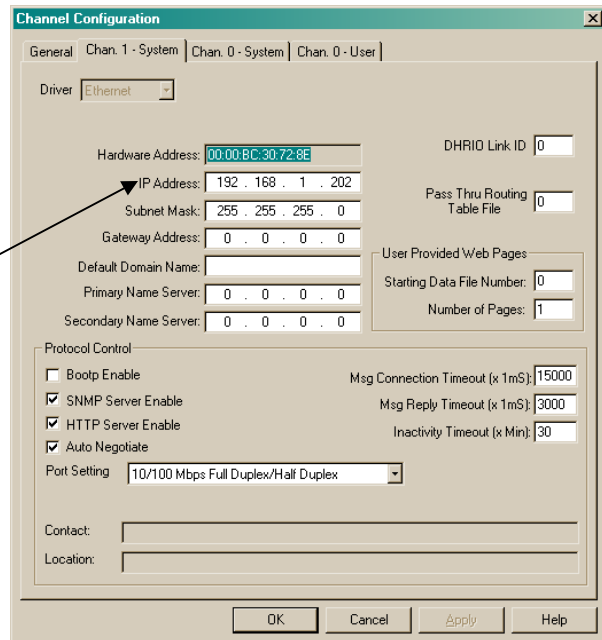
Note: This is not for Control /Compact Logix tags

1. Set-up RSLogix 500

Set up your channel 1 system under the channel configuration column.

The IP address will have to be in the same network as the Vision Appliance.

Set the subnet mask as well



2. Data File may need to be made:

In order to get a message address, you may have to create a new file.

Right-click Data Files => New... => File: 11, Select Type: Message, Elements: 10 click OK

For Micrologix 1100:

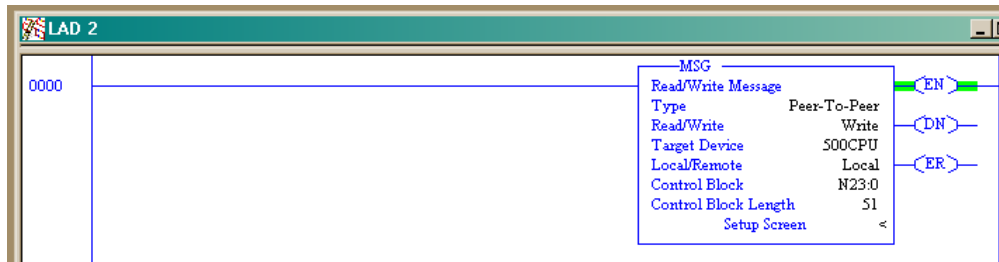
Right-click Data Files => New... => File: 12, Select Type: Routing Information, click OK

Right-click Data Files => New... => File: 13, Select Type: Routing Information, click OK

3. Setup your PLC ladder logic (simple example shown)

This is your read or write message instruction:

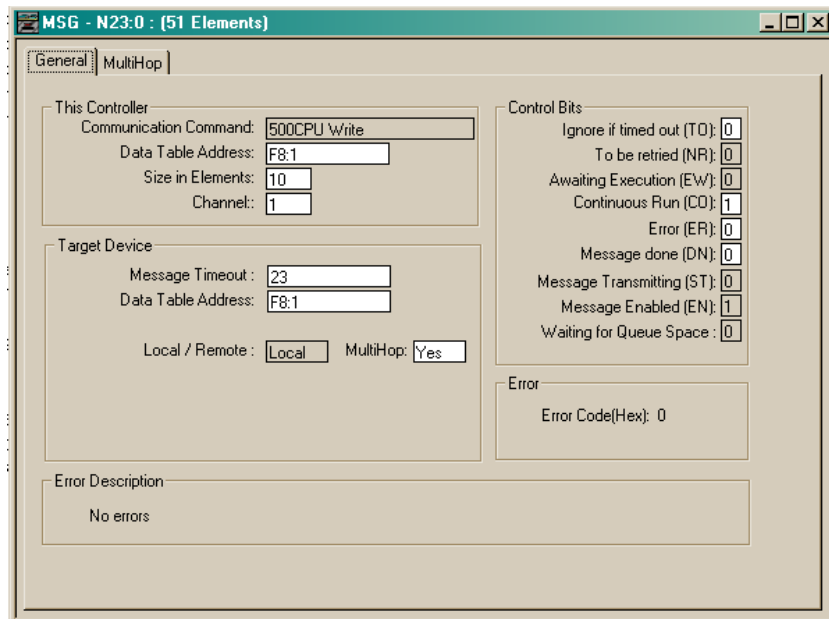
Create a new rung with a MSG specify read/write and control block address.



4. MSG Setup

In MSG, select channel 1 and enable MultiHop in the general tab

For Micrologix 1100, you will have to give some routing addresses from the routing files created

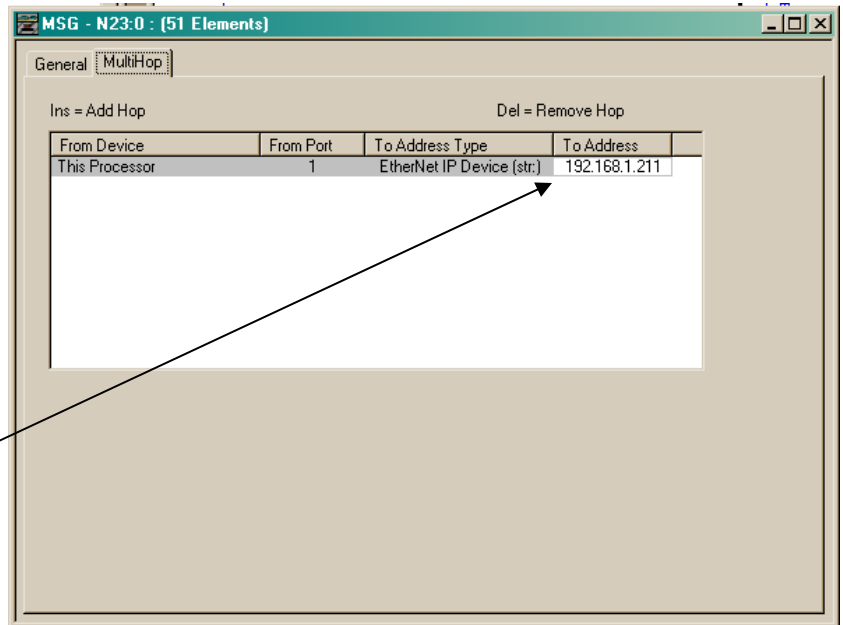


MultiHop tab:

The file number data type relationship only is:

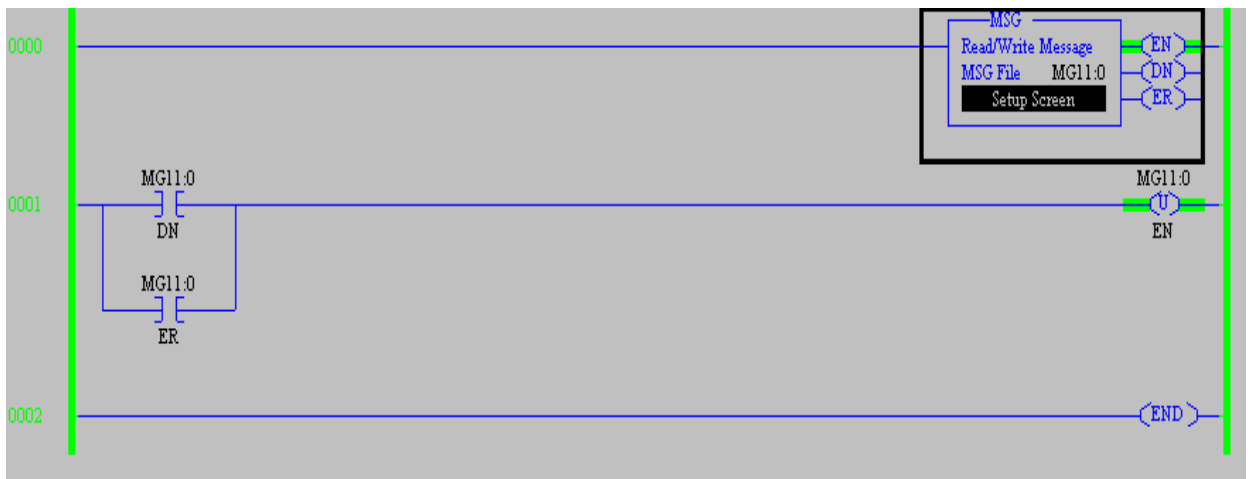
Data Type File Number
 int - signed 16 : N7
 real - float 32 : F8
 char array – string: ST9

*integers appear in the N7 file



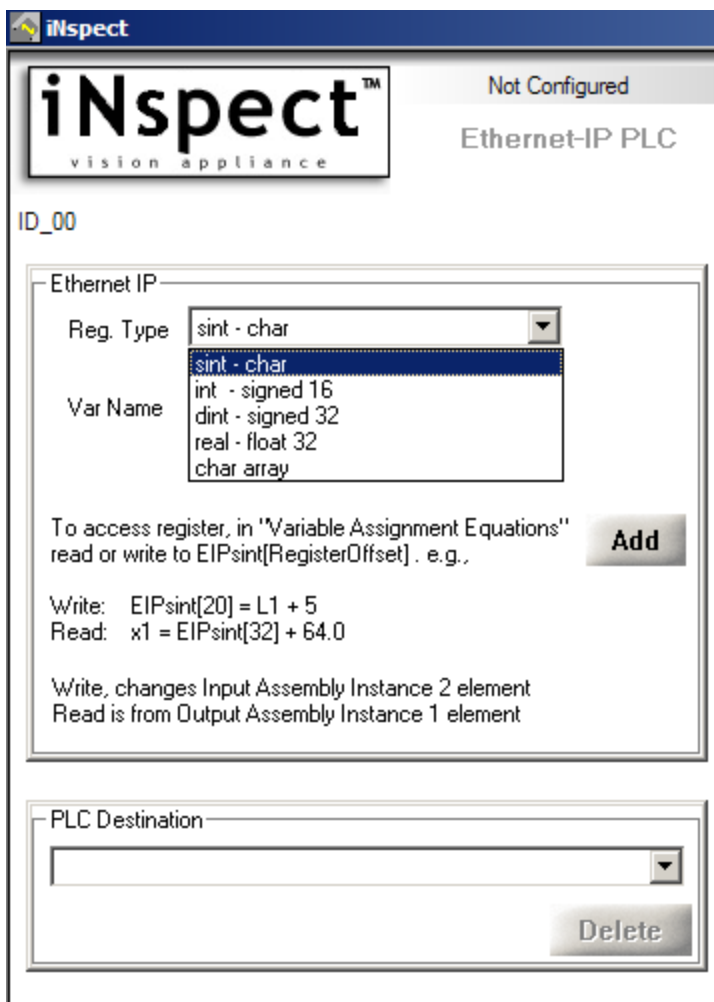
Under MultiHop,
 define the IP
 address of the
 Vision appliance

Enter the rung shown below which will Unlatch EN if DN or ER is set.



5. Setup iNspect

In iNspect, under setup / outputs, use the drop down to select Ethernet IP. Click Add button



Select your Reg type.

To get exact tool measurements use the real float option

Use the default name or create your own.

Click Add

The E/IP connection will now show in the Variable Assignment Equation

6. Write Operations

Create the equation as written in this example

(if) 1

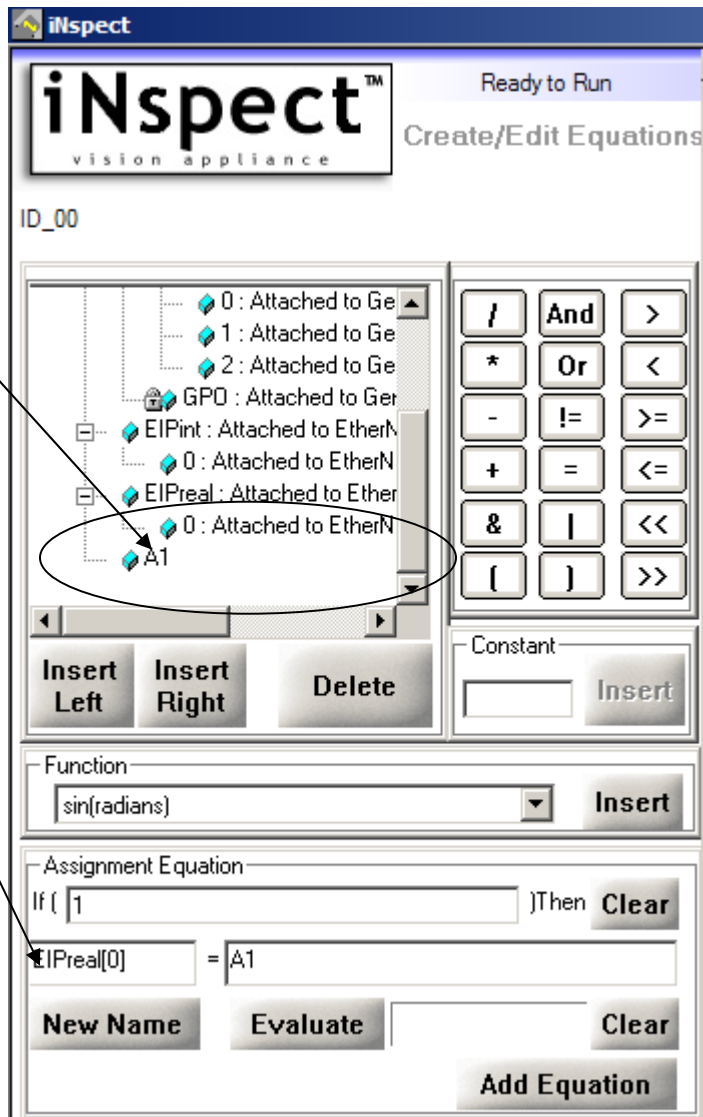
(then) $EIPreal(0) = A1$

(A1 is the angle tool used in this example)

Click Add Equation

Name would show $EIPreal(0)$ this is equal to F8:0 to RSLOGIX

Relationship again is:
 Data Type File Number
 int - signed 16 : N7
 real - float 32 : F8
 char array – string: ST9



Data will show in the Data file (the angle was 91.29 degrees)

Offset	0	1	2	3	4
F8:0	91.29	91.29	0	0	0
F8:5	0	0	0	0	0
F8:10	1978	1978.25	1978.5	1978.75	1979
F8:15	1979.25	1979.5	1979.75	1980	1980.25

7. Read Operations:

If you want to store your input data from the PLC to a variable in the inspection.

In this example:

(if) 1 (then)

UserVariable = EIPreal(1)

EIPreal(1) is equal to F8:1 in the PLC

The results will show up in the monitor screen and also can be used in other equations.

Relationship again is:

Data Type	File Number
int - signed 16	: N7
real - float 32	: F8
char array – string:	ST9

UserVariable results will appear in the Monitor screen
 *It can also be used in other equations

