
PLuS PS-6244 Series Programmable Limit Switch

Initial programming and set up*

*All programming is done through the Electro Cam Keypad Display

Set the Position

- 1) **Set Direction of increasing rotation.**
Set to (CL) "clockwise" or (CCL) "counter clockwise" so the encoder position counts upwards when machine is running.
 - 2) **Set the displayed position to match the actual machine position.**
With the machine at zero or a known position, set the "offset" position to match actual machine position.
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Setting ON/OFF Setpoints for each output

- 3) In the Setpoint Menu, program the desired ON/OFF setpoint positions when the output is required to turn on and off.
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Shift Register Setup

- 4) **Set the Shift Input Window.** Set in channel 91. This is the window in which the shift input on terminal 16 (usually a photo eye or prox) must occur. The rising edge of this product present input must occur within the ON/OFF setpoints of Channel 91 in order to set a bit in the internal shift register.
- 5) **Set The Shift Position.** This is the machine position where the internal shift register will shift all bits that were set by the input to the next shift position in the shift register.
- 6) **Set Shift Register Anding for individual Channels.** Outputs with programmed ON/OFF setpoints will operate normally by turning On and OFF with each revolution of the encoder. To tie output channels in with the shift register operation, they must be "Anded" in the "**Shift Register Anding Menu**". In this Menu, each output can be set to turn on only when a shift bit is active at a specific shift count up to a maximum of 256. At a setting of zero, outputs will turn on every cycle and not be affected by the shift register.

Normal sequence of shift register:

1. Product present on input terminal 16 occurs within channel 91 **shift input** window and sets a bit in the zero position shift register.
2. The machine position passes the **Shift Position** and the bit is shifted to the next count or position.
3. Outputs that are Shift Register anded will turn on if a bit is present in the specified count during this cycle.