



- Modify the  $\pm 30$  second adjustment control signal M1953, let it work at the positive edge (Perform the  $\pm 30$  second adjustment while the status changing from 0 $\rightarrow$ 1)
- While writing the ROM PACK with system backup, the motion parameter table (Assigned by FUN141) will also be included; it means the motion parameters will remain the settings even the system initialization being executed
- It can support “Only read one time” function for ROM PACK accessing while writing the ROM PACK and selecting the item “After initial system, read back the data one time” for both data backup or system backup.
- There are two kinds of system back for ROM PACK writing as below:
  - System backup with PLC ID
  - System backup without PLC ID

.While selecting the “System backup with PLC ID” for ROM PACK writing, the PLC main unit will read the PLC ID and ladder program from ROM PACK every power up if the ROM PACK has been installed for working; but all data registers and discrete status will read only once (Selecting “After initial system, read back the data one time”) or every time (Selecting “When power on, read back the data every time”) depending on the selective item.

It can make the ID (PLC ID and PROGRAM ID) copy for the main unit needing ID protection through this kind of ROM PACK without the intervention of programming tool.

This kind of ROM PACK can't be installed for working to have intellectual ID protection.

.While selecting the “System backup without PLC ID” for ROM PACK writing, the PLC main unit will read the ladder program from ROM PACK every power up if the ROM PACK has been installed for working; but all data registers and discrete status will read only once (Selecting “After initial system, read back the data one time”) or every time (Selecting “When power on, read back the data every time”) depending on the selective item.

It needs to have correct PLC ID setting for the PLC main unit to enter RUN mode if being installed ROM PACK with program ID protection; it means the PLC ID of the main unit must be same with the program ID of the ROM PACK, then the PLC main unit can work without problem.

This kind of ROM PACK can be installed for working to have intellectual ID protection; it is very suitable for mass production and long term maintenance with intellectual property protection.

- ※ "After initial system, read back the data one time" means the PLC main unit will read the data register and discrete status from the ROM PACK only one time at the first power up, and then the main unit doesn't read the data register and discrete status again from the ROM PACK at the following power up. It is very useful to have the default settings for the data registers from the ROM PACK, and after the default initialization, the data register can remain the new setting without loss at the next power up.
- ※ "When power on, read back the data every time" means the PLC main unit will read the data register and discrete status from the ROM PACK every power up. It is very useful to have the default settings for the data registers from the ROM PACK at every power up, the PLC main unit being equipped with this kind of ROM PACK can work properly even the battery low.
- ※ While changing the PLC ID, the PLC ID will be written into the internal system FLASH ROM once at the next power up; it will keep the ID information even battery low.
- ※ While executing system initialization, the PLC ID will be erased from the internal system FLASH ROM once at the next power up if it exists.