

G1x PLC Field Replacement Procedure

Part Number(s): 28C0011

Overview

This procedure describes the steps required to replace a IDEC MicroSmart PLC in the field. It is assumed the replacement PLC has been factory programmed to the required configuration for either a G1(544) or G1D(545) prior to installation.

After installation the G1x controller will need to be reprogrammed using the G1x Controller Installation documentation. Any custom "T" settings will also need to be reprogrammed using the PLC LCD programming module as with any new controller installation.

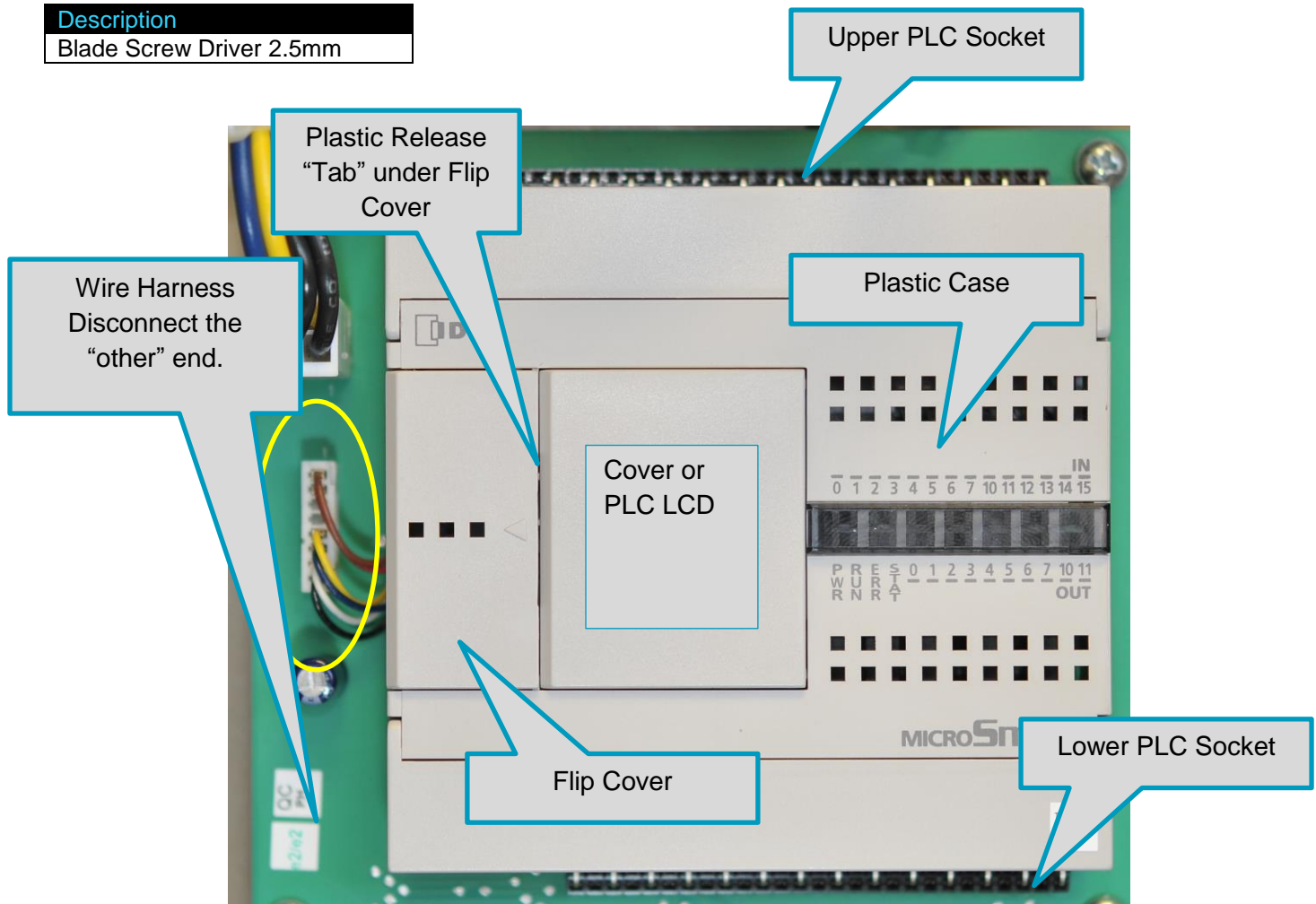
Reference:

G1x Install: <https://inmotionsupport.freshdesk.com/support/solutions/articles/17000057928-g1-g1d-installation-with-500-series-motor>

Tools Required

Description

Blade Screw Driver 2.5mm



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Instructions

Removing the old PLC

1. Power off the panel and disconnect the AC.
2. Flip open the side cover of the PLC and if installed remove the PLC LCD module or Module Cover. Once the side cover is flipped open, depress the plastic tab on the left side of the cover/PLC LCD to remove it.
3. Reach behind the right side of the PC board and release the plastic tabs holding the PLC cover to the board.
4. Gently rock the plastic PLC cover to release the plastic tabs on the left side. The cover should lift off.
5. Disconnect wire harness, on the PLC board, located at the top left side labeled CN1. The small screw driver can be used to separate the cable from its connector.
6. Using your fingers to gently pry up on each corner of the PLC board until the PLC releases from its board socket.
7. If "right angle" header pins are not installed on the new board you need to loosen all 29 screws holding the pins to the original board. Then insert the old pins into the new PLC screw terminals. The pins should butt up against the header and there should be 2 unused pins in the top left corner of the PLC.

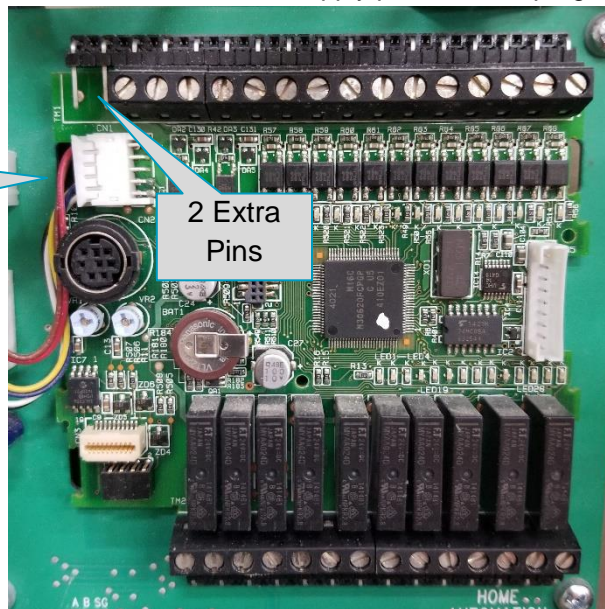
Double check all the screw terminals for snugness and a good electrical connection.

Installing the new PLC

1. Remove the plastic case on the new PLC to expose the bare PLC board.
 2. If "right angle" header pins are not included use the pins from the original PLC. See step 7 above.
 3. Align the PLC header pins with the socket on the circuit board. The side of the PLC with the most pins should be at the top.
 4. Gently press the board until all the pins are fully seated into board socket making sure that the pins mate with the sockets and no pins over hang without a connection.
- NOTE:** The 2 pins on the top right do not connect to screw terminals but DO mate with the board socket.
5. Re-attach the wire harness, CN1, at the upper left corner of the PLC.
 6. Re-attach the PLC plastic cover starting on left side making sure the wire harness is not pinched by the plastic tab in the upper left. Once clear, snap down the 2 tabs on the right making sure the cover is secure to the board.
 7. Re-install the plastic module cover or PLC LCD. Apply power and reprogram the controller.

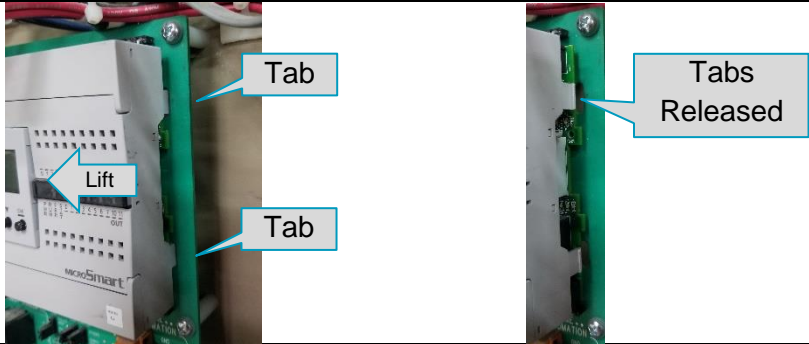
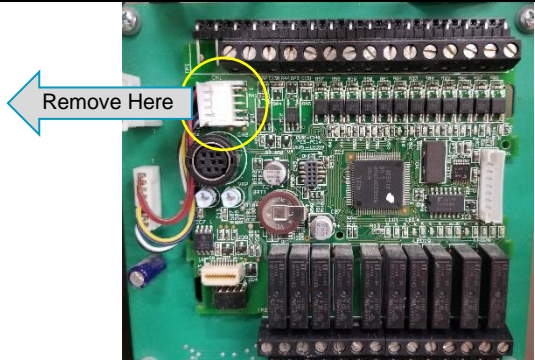
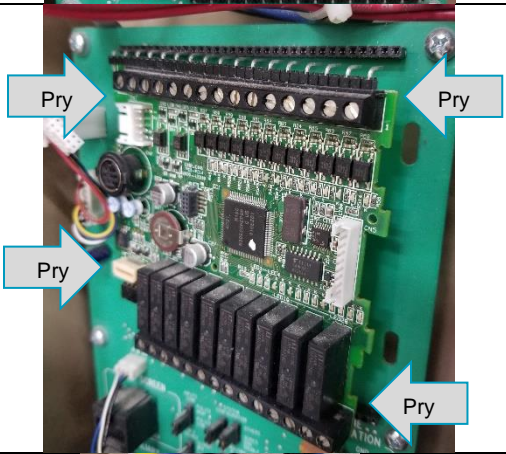
Don't pinch
wires with
cover tabs!

2 Extra
Pins



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Removal Steps	Diagrams
1. Power Off the Panel and disconnect the AC line.	
2. Open the flip cover and remove the PLC LCD / Cover.	
3. Release the plastic tabs holding the PLC cover to the board.	
4. Gently rock the plastic cover to release the right side tabs.	
5. Disconnect wire harness, on the PLC board.	
6. Using your fingers gently pry up on each corner of the PLC board until the PLC releases from the board sockets.	
7. Use the old "right angle" header pins if not included with the new PLC. Loosen all 29 screws to remove.	