



## Integrated Manufacturing Systems Troubleshooting (IMST) Level 1

### Attachment 1-12

### PLC MEMORY

#### Binary

	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0
B3:0/	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
B3:1/	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
B3:2/	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
B3:3/	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
B3:4/	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0

Radi:  Table:  Forces

Address:  Symbc:

#### Input

	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0
I:0/																
I:1/	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
I:2/																
I:3/	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
I:4/																

Radi:  Table:  Forces

Address:  Symbc:





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Output

	15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0
O:0/																
O:1/																
O:2/	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
O:3/																
O:4/	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0

Radi: Binary Table: O0: Output Forces

Address: Symbol:





**Multi-State  
Advanced Manufacturing  
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