


Hotswap Beckhoff PLC with Licence Slice Installed

Swapping a Beckhoff PC on an machine with EL6070 Licence Slice installed

 Difficulty **Medium**

 Duration **15 minute(s)**

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Comments

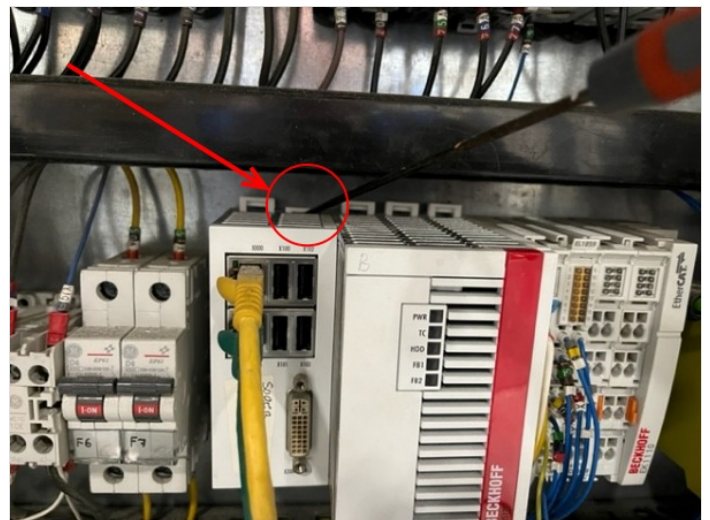
Introduction

If a machine is set up with an EL6070 Licence Slice, the PLC can be swapped freely and the TwinCAT licence remains on the slice in the machine

Step 1 - Power Off

Step 2 - Pop the retaining clips for the PC

There are a row of retaining clips on bot the top and bottom of the PC that hold it to the Din rail.
Pop them open with a flathead screwdriver



Step 3 - Remove the network cables



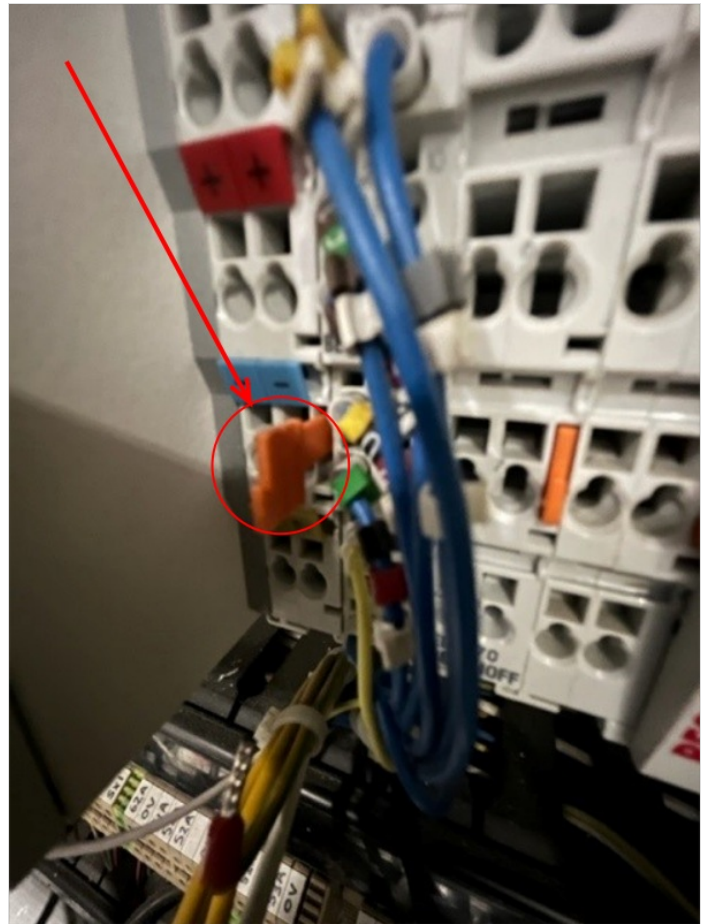
Step 4 - Remove the power cables

On the right hand side of the PC there are 2 columns of yellow, white and earth power cables. All must be removed using a small flathead screwdriver to release the friction clamps on the cables



Step 5 - Pull the Orange Retaining clip

This clip is the final fastening to the din rail



Step 6 - Swap the PCs

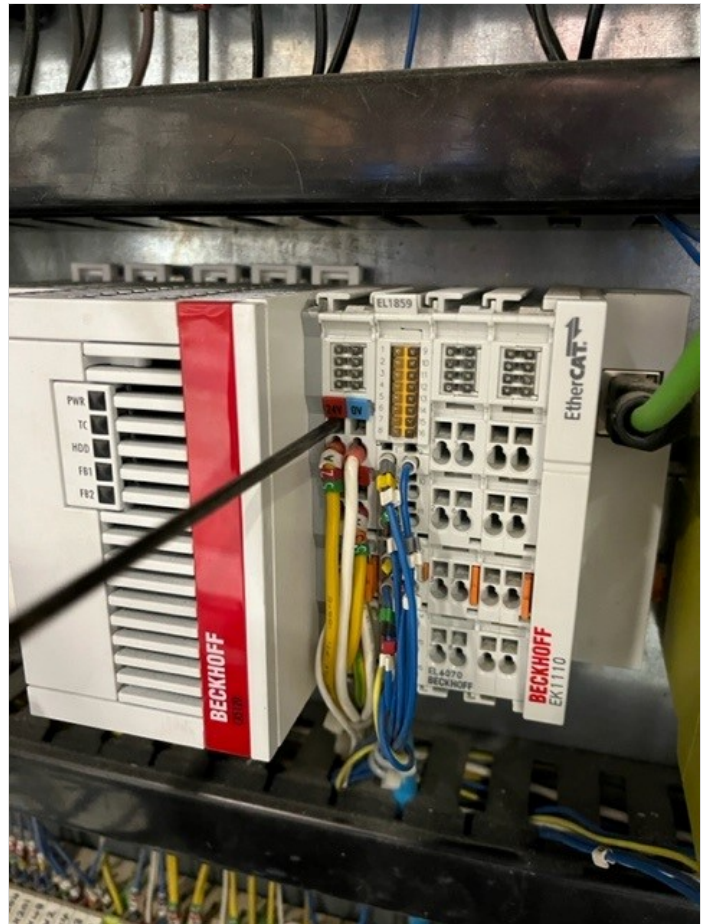


Step 7 - Reattach Power Cables

Yellow into + / 24v

White into - / 0v

G/Y into PE



Step 8 - Replace Network Cables

Yellow in top

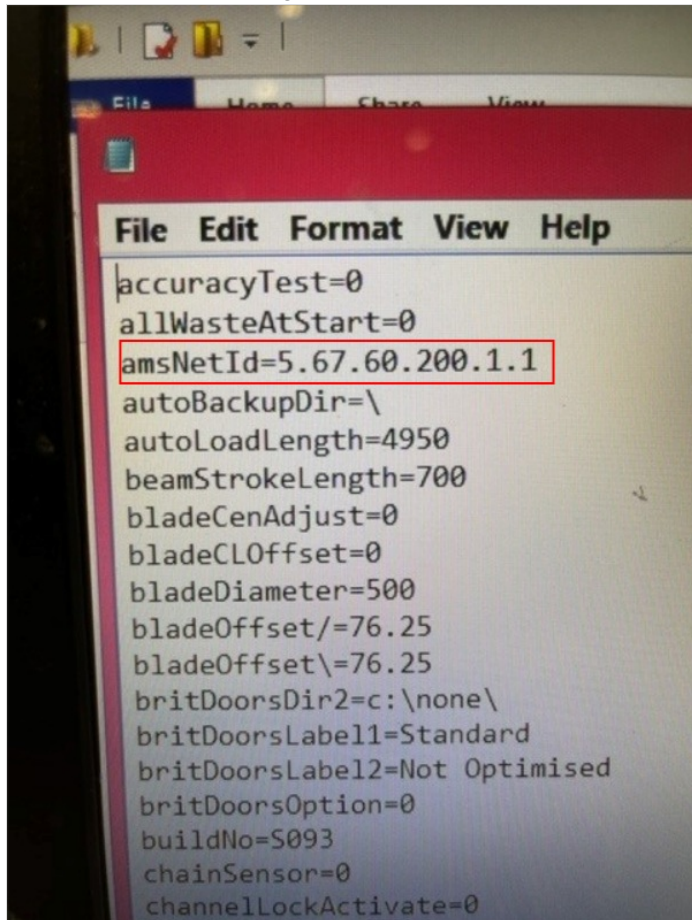
Green in Bottom



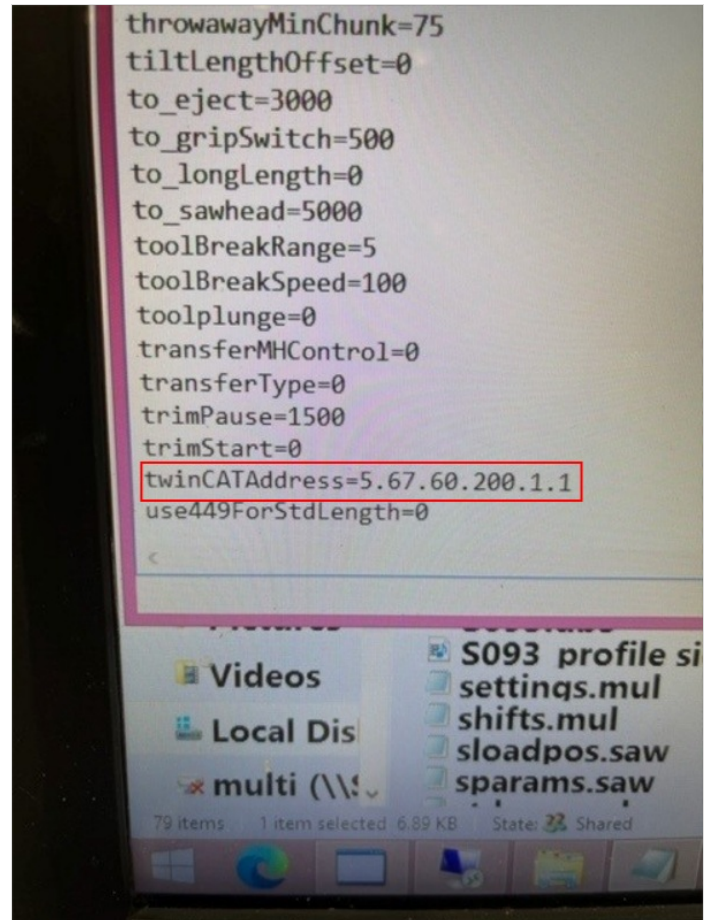
Step 9 - Change the AMS Net Id settings

In the c:\ddrive\params.saw file, two AMS Net Id's need to be changed
The specific values are unique for each PC used

- refer to the c:\DDRIVE\log.mul file



```
accuracyTest=0
allWasteAtStart=0
amsNetId=5.67.60.200.1.1
autoBackupDir=\
autoLoadLength=4950
beamStrokeLength=700
bladeCenAdjust=0
bladeCLOffset=0
bladeDiameter=500
bladeOffset/=76.25
bladeOffset\=76.25
britDoorsDir2=c:\none\
britDoorsLabel1=Standard
britDoorsLabel2=Not Optimised
britDoorsOption=0
buildNo=S093
chainSensor=0
channelLockActivate=0
```



```
throwawayMinChunk=75
tiltLengthOffset=0
to_eject=3000
to_gripSwitch=500
to_longLength=0
to_sawhead=5000
toolBreakRange=5
toolBreakSpeed=100
toolplunge=0
transferMHControl=0
transferType=0
trimPause=1500
trimStart=0
twinCATAddress=5.67.60.200.1.1
use449ForStdLength=0
```