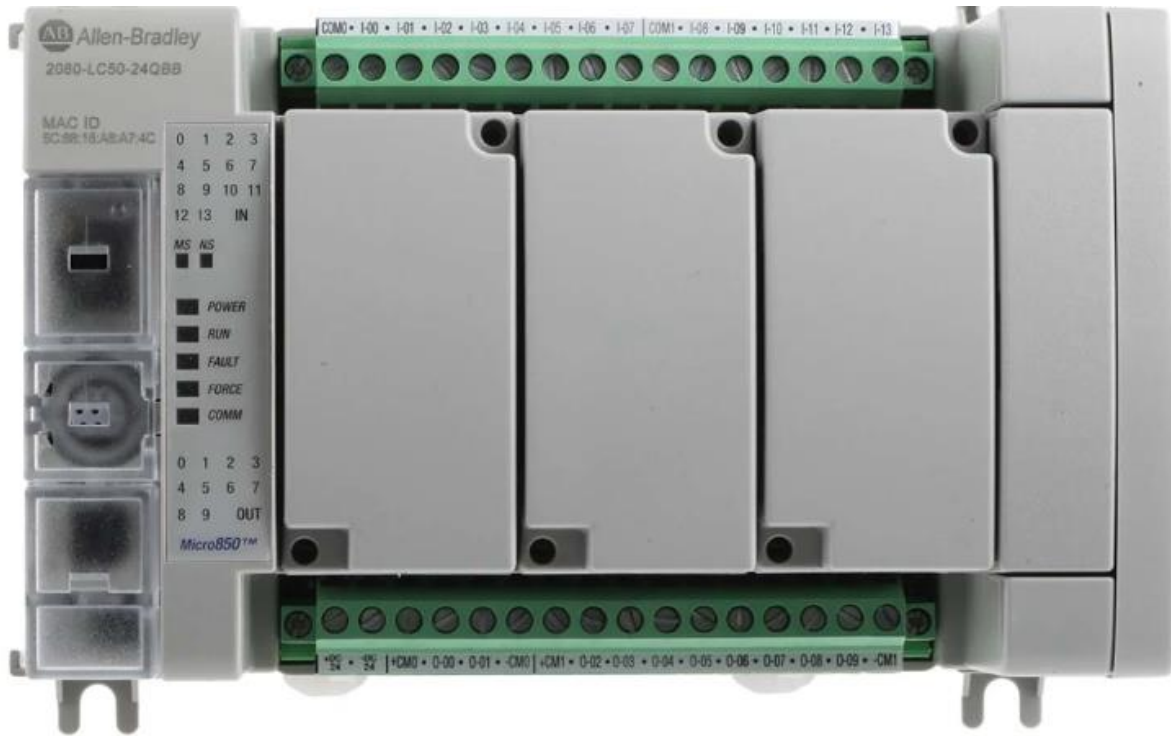


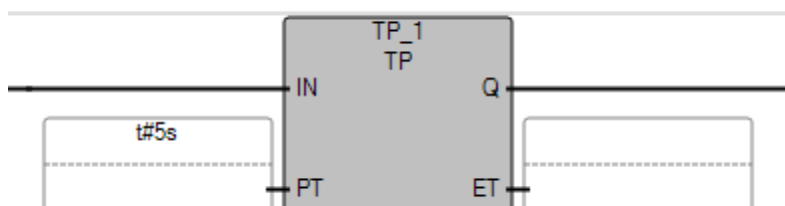
Test your skills for Micro850 PLC



1. You can FORCE the inputs in the PLC via Software which allows you to trigger the inputs without giving voltage to the input terminals

- **True**
- False

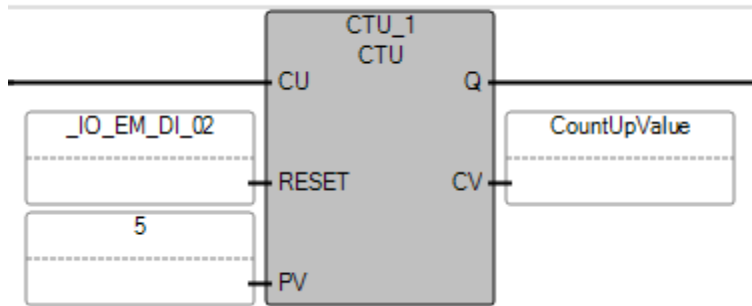
2. What type of timer is this?



- **Pulse Timer**

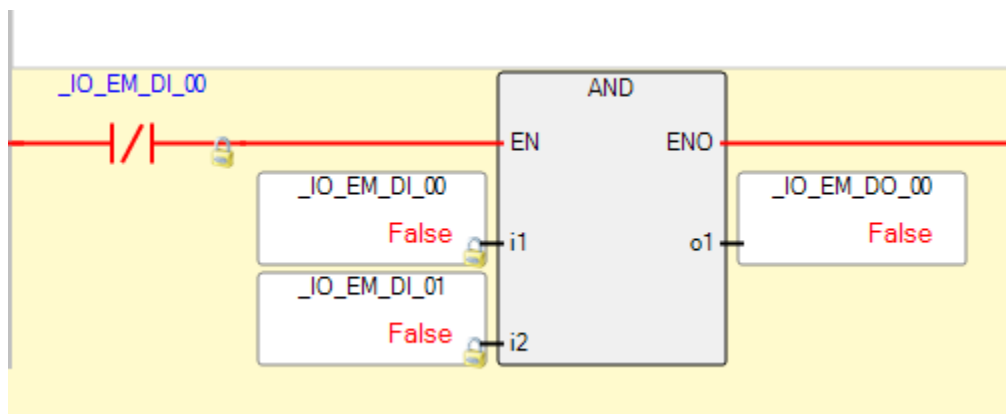
- Timer ON Delay
- Timer OFF Delay
- Retentive ON Timer

3. In the below instruction block, what type of counter is used?



- **Counter Up**
- Counter Up-Down
- Counter down

4. In the below ladder, what will happen if both the inputs connected at i1 and i2 are TRUE?



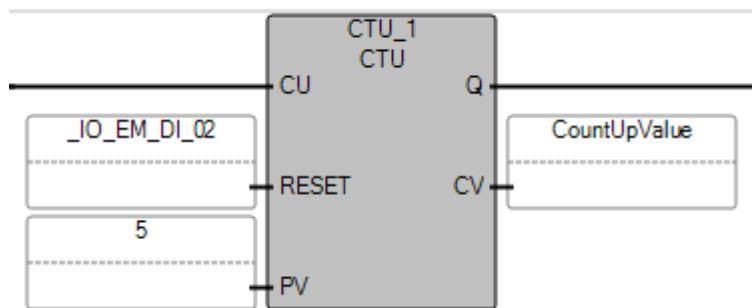
- The output o1 will be TRUE
- **The output o1 will be FALSE**

Explanation: The tag of i1 and EN is same. Hence, if _IO_EM_DI_00 is TRUE, it will also disable the AND block and AND block will not be scanned and executed by the PLC.

5. Which of the following coil gets TRUE only for 1 scan cycle when input is transitioned from False to True?

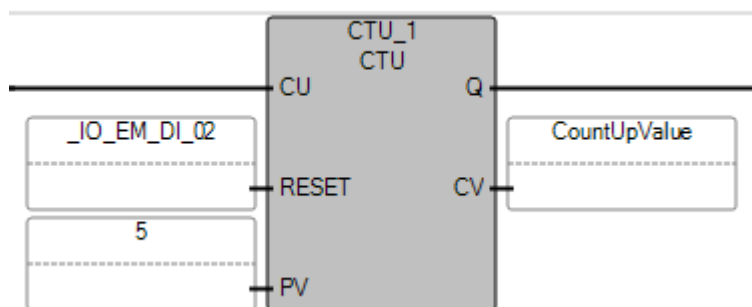
- **Pulse Falling Edge Coil**
- Set Coil
- Direct coil
- Pulse Rising Edge Coil

6. In the below instruction block, output Q is TRUE when:



- $CV < PV$
- $CV = 0$
- **$CV = PV$**
- CU is TRUE

7. In the below instruction block, what will happen if the RESET is TRUE and CU gets a TRUE signal?



- **The CV will get 0**

- The CV will jump to 5
- The CV will increment by 1
- The CV will decrement by 1

8. In the following ladder, what will be the status of coil `_IO_EM_DO_00` if both the inputs `_IO_EM_DI_00` and `_IO_EM_DI_01` are TRUE?



- `_IO_EM_DO_00` will be TRUE
- **`_IO_EM_DO_00` will be FALSE**

Explanation: RS (Reset Dominant) flip flop will reset the output Q1.

9. In which of the flip-flop reset is dominant?

- SR
- **RS**

Select the correct answer. Consider we have two inputs A and B:

10. Output is only TRUE if either of the inputs is TRUE

- OR
- NOR
- **XOR**
- AND

11. Output is only TRUE if both the inputs are TRUE

- OR
- NOR
- XOR
- **AND**

12. Output is only TRUE if both the inputs are FALSE

- OR
- **NOR**
- XOR
- AND

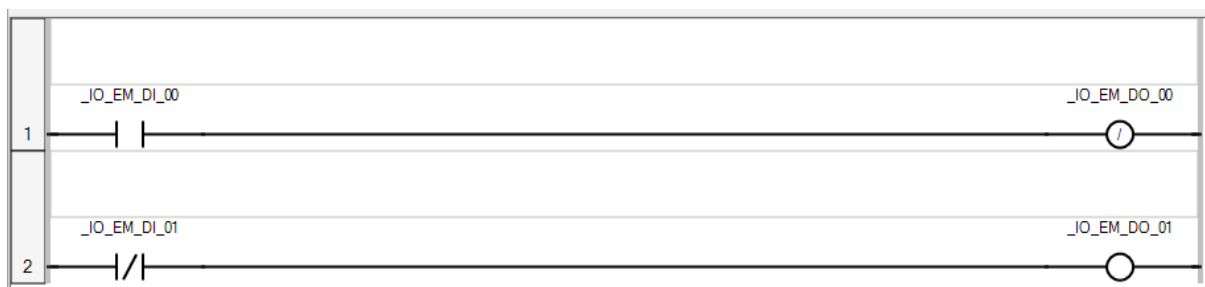
13. Output is only TRUE if any or both of the input are TRUE

- **OR**
- NOR
- XOR
- AND

14. Which of the following Timer retains the time if the PLC goes to STOP mode?

- TON
- TOF
- TONOFF
- **RTO**

15. Both the ladder below behaves in the similar way such that if the input is TRUE, output is FALSE and vice versa



- False
- **True**

16. Choose the best answer, the output `_IO_EM_DO_00` will be TRUE?



- When the input `_IO_EM_DI_00` is only TRUE
- When the input `_IO_EM_DI_00` is only FALSE
- **When the input `_IO_EM_DI_00` is either TRUE or FALSE**

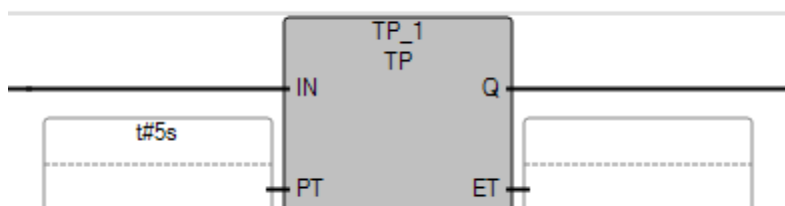
17. In Micro850 PLC, if the common (COM0) of the inputs is connected to 0V what signal should be connected to the input terminal to actuate the inputs?

- **24V**
- 5V
- 0V
- 12V

18. E-Stop is an _____ switch.

- NO
- **NC**

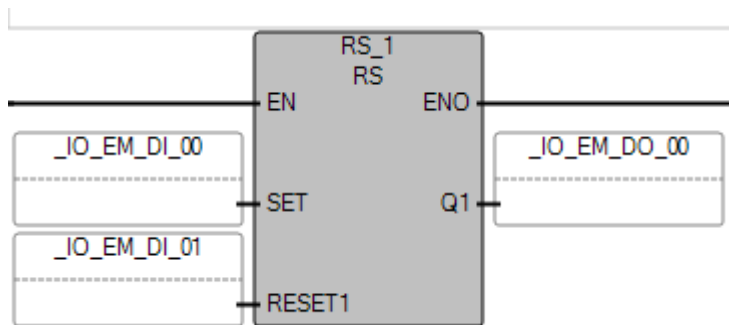
19. What will happen if the input is TRUE for 1 second



- The timer output (Q) will start after the delay of 5 seconds

- Nothing, the timer output (Q) will not be TRUE as the input is TRUE for less than 5 seconds
- **The timer output (Q) will be TRUE for 5 seconds and then stop**

20. In RS flip-flop what will be the status of the output if SET and RESET both are TRUE?



- **Q1 will be FALSE**
- Q1 will be TRUE

21. What is the operating voltage of Micro 850 PLC?

- 110 VAC
- **24 VDC**
- 220 VAC
- 5 VDC