



TRINE CENTER FOR TECHNICAL TRAINING



C-208 Programmable Controller Troubleshooting I

Skill Standards

Abstract

Defines the knowledge, skills, and abilities required to succeed in positions (e.g. controls engineer or maintenance technician) that install, troubleshoot, program, and maintain factory automation in a modern environment that uses Industry 4.0 technologies.

Version 1.3

Introduction to SACA

The Smart Automation Certification Alliance (SACA) is a non-profit foundation whose mission is to develop and deploy modular Industry 4.0 certifications for a wide range of industries. The vision is to provide highly affordable, accessible certifications that significantly increase the number of individuals who possess the skills represented by these credentials, thereby ensuring that companies have the highly skilled workers they need, and individuals are prepared to be successful in a “connected enterprise” world.

Industry-Driven Quality

SACA certifications are industry-driven, developed by industry for industry. They use a rigorous process that starts with the development of truly international skill standards, developed and endorsed by leading experts in Industry 4.0 technology throughout the world. Certifications examinations are created based on these standards, pilot-tested and statistically analyzed to ensure quality. Each certification includes a proctored hands-on evaluation (Gold) and an online, multiple choice test (Silver) to confirm that candidates have a knowledgeable foundation for certification success. SACA uses an annual standards and examination review process for all certifications to ensure that the certifications continue to remain highly up-to-date.

Certifying Individuals

Individuals can receive certifications through Trine University, an authorized SACA certification center. SACA ensures any certification center maintains high standards with proctored exams, certified evaluators, and approved equipment for consistent hands-on evaluation.

Certification Structure

SACA certifications use a modular structure to enable them to fit into wide range of individual needs and industries and educational environments. The three SACA certification categories include:

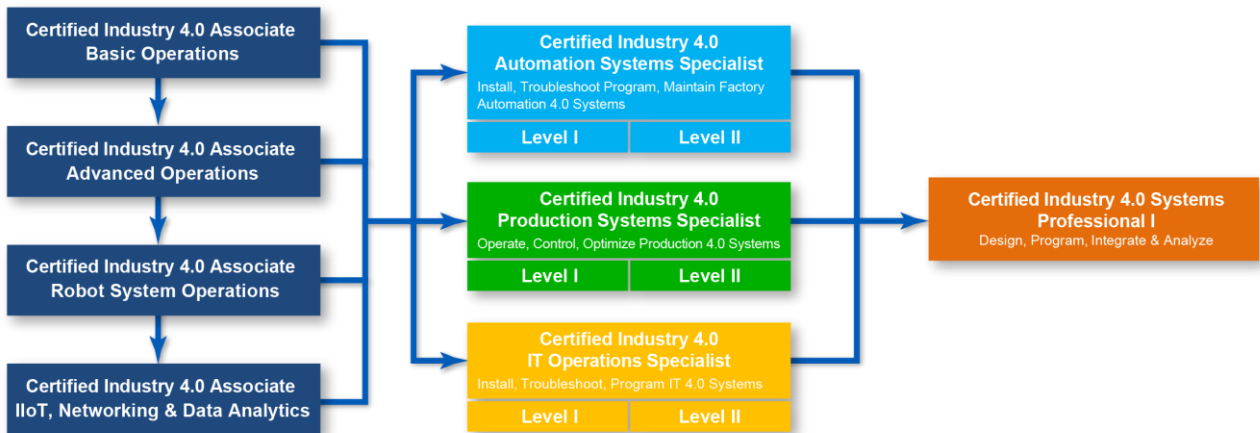
- Associate
- Specialist
- Professional



SACA Certification Structure

Each certification is stackable. Individuals can start with one certification and add other certifications to customize their documented skills. Certifications are occupationally focused so they prepare individuals for specific occupations.

Industry 4.0 Systems Occupational Certifications



Associate Certifications

The Associate certifications include the following four (4) credentials:

- C-101 Certified Industry 4.0 Associate-Basic Operations
- C-102 Certified Industry 4.0 Associate-Advanced Operations
- C-103 Certified Industry 4.0 Associate-Robot System Operations
- C-104 Certified Industry 4.0 Associate-IIoT, Networking and Data Analytics

The Associate certifications are introductory certifications for those individuals working in an Industry 4.0 environment. These certifications are ideal for production technicians, IT professionals, and industrial maintenance technicians seeking to acquire Industry 4.0 skills.

Specialist Certifications

Specialist certifications are modular certifications, consisting of a series of core and elective micro-credentials, each with its own hands-on practical assessment and a written (online) knowledge assessment. Core micro-credentials certify skills that are applicable to all companies, while elective micro-credentials can be added to match with regional or specific company needs.

- Automation Systems Specialist
- IT Systems Specialist
- Operations Specialist
- Electrical Systems Specialist
- Control Systems Specialist
- Robotics Specialist
- Network Systems Specialist
- Instrumentation Specialist
- Mechanical Systems Specialist
- Electro-Fluid Power Systems Specialist

Certified Industry 4.0 Electrical Systems Specialist

SACA's Certified Industry 4.0 Electrical Systems Specialist certification prepares individuals to succeed as an industrial electrician in modern production environments that use Industry 4.0 technologies. In this role, individuals will install, troubleshoot, repair, and maintain industrial electrical circuits and electric motor systems.

Core Micro-Credentials:

C-101 Associate-Basic Operations

C-201 Electrical Systems 1

C-202 Electric Motor Control Systems 1

C-204 Motor Control Troubleshooting 1

C-206 Electrical System Installation 1



Certified Industry 4.0 Automation Systems Specialist

SACA's Certified Industry 4.0 Automation Systems Specialist certification prepares individuals to succeed in multi-skill maintenance technician positions in modern production environments that use Industry 4.0 technologies. This certification also features a variety of elective micro-credentials that are ideal for individuals seeking to become versed in Industry 4.0 automation or those pursuing SACA Professional Certification.

Core Micro-Credentials:

C-101 Associate-Basic Operations
C-201 Electrical Systems 1
C-202 Electric Motor Control Systems 1
C-203 Variable Frequency Drive Systems 1
C-204 Motor Control Troubleshooting 1
C-205 Sensor Logic Systems 1 (*)
C-206 Electrical System Installation 1
C-207 Programmable Controller Systems 1 (**)
C-208 Programmable Controller Troubleshooting 1
C-209 Pneumatic Systems 1
C-210 Mechanical Power Systems I
C-211 Industry 4.0 Total Productive Maintenance Management
C-212 Ethernet Communications 1
C-213 Smart Sensor and Identification Sys. 1
C-214 Smart Factory Systems 1
C-215 Robot System Operations 1 (***)
C-216 Robot Systems Integration 1

Elective Micro-Credentials:

C-255 Hydraulic Systems 1
C-256 Hydraulic Maintenance
C-257 Process Control Systems 1
C-258 Process Control Troubleshooting 1
C-259 Rigging Systems 1
C-260 Rigging Systems 2

(*) - or SACA C101 Associate-Basic Operations and C-102 Associate-Advanced Operations Certifications

(**) - or SACA C-102 Associate-Advanced Operations and C-104 Associate-IIoT and Data Analytics Certifications

(***) - or SACA C-103 Associate-Robot Systems Certification

Professional Certifications

SACA's Certified Industry 4.0 Professional certification is an engineering certification that focuses on analysis, design, and optimization of Industry 4.0 systems. It prepares engineers to succeed in positions in modern production environments that use Industry 4.0 technologies. The Certified Industry 4.0 Professional certification is designed in a modular format.

- Robot Systems Applications Design 1
- Smart Factory Systems Optimization 1
- Smart Factory Systems Optimization 2
- Smart Factory Systems Architecture Design 1
- Manufacturing Execution Systems 2
- Flexible Manufacturing Systems Optimization
- Process Simulation and Design 1





SILVER & GOLD CERTIFICATIONS



All SACA Certifications can be attained on two levels: Silver and Gold.



SACA Silver Certifications are awarded to candidates who successfully pass the written knowledge exam delivered online through the SACA testing portal. Silver Certifications are ideal for individuals seeking to validate online core achievement or when hands-on testing is not available.



SACA Gold Certifications are awarded to candidates that successfully pass the written knowledge exam and successfully complete a hands-on performance assessment on SACA-approved equipment. Gold Certifications are ideal for individuals seeking to show they possess job-ready, hands-on Industry 4.0 skills.



C-208 Programmable Controller Troubleshooting I

E-Learning Content

1. Introduction to PLC Troubleshooting
2. PLC Power Supply Troubleshooting
3. PLC I/O Device Testing
4. PLC Processor Troubleshooting
5. PLC Systems Troubleshooting
6. Analog Input/Output Troubleshooting
7. Analog Application Troubleshooting
8. SACA Test / Study Guide

Prepares individuals to troubleshoot and remedy faults in programmable logic controller systems. Skills include: systems troubleshooting and component testing using digital multimeters, PLC software, and PLC status indicators. Components include: PLC power supply, power distribution system, processor module, discrete input and output modules, chassis, and discrete field I/O devices. Troubleshooting applications include: multi-step machine sequence logic programs using electro-pneumatic actuators and on/off motor control systems.

990-PAB53AF Technical Trainer for Gold Certification



Amatrol's Portable PLC Troubleshooting Learning System (990-PAB53AF) teaches Programmable Logic Controller (PLC) programming, operation, and applications used throughout industry. The system also utilizes FaultPro, the industry's premier computer-based fault insertion system. The 990-PAB53AF with FaultPro includes a variety of electronic faults that present realistic situations that technicians encounter on the job. This allows learners to develop important PLC troubleshooting skills, like PLC input and output testing, software testing, and application troubleshooting. Learners will practice skills, such as using a six-step sequence to troubleshoot a PLC system, troubleshooting a PLC routine that performs on/off control using an analog input, and testing a PLC-controlled PWM output device.

SACA FAQ's

Who and What is SACA?

[Smart Automation and Certification Alliance](#) is a third-party certification body whose purpose is to validate technical knowledge and ability and prepare the next generation of skilled workers.

Each SACA certification is stackable, allowing individuals to start with one certification and add other certifications to customize their documented skills. Certifications are occupationally focused so they prepare individuals for specific occupations in the world of Industry 4.0.

How will SACA contribute to Student Success in the Workforce?

SACA credentials provide students industry driven competencies in an applied learning (hands on lab) format. These skills translate directly to jobs that are in high demand, great paying, and leading to exciting lifelong career paths.

What's the difference between Silver and Gold SACA certifications?

Silver is a theory only, multiple choice, proctored exam. Exams are 1 - 2 hour in length and varies from 40 to 100 questions depending on the subject.

Gold is a combination of theory in addition to hands on skills. This is the lab portion of the certification and vastly ranges from 15 minutes to 4 hours till completion depending on the subject.

Are Instructors required to be SACA certified?

Yes! Instructors must earn the SACA certification for the courses they teach to be credentialed.

How do Instructors earn SACA Silver certifications?

Instructors can take the theory exam before or at the same time as the exam is being taken with the students. Trine University will help you with this process.

How do Instructors earn SACA Gold certifications?

Instructors will work with Trine University to complete and validate the hands-on skills required.

What resources are students allowed to use while taking the certification exams?

Formulas are available within the testing environment as well as a calculator, and blank piece of paper.

Note: All resources are pending SACA approval and may be modified.

How long do students or instructors wait before re-attempting a failed attempt?

Re-attempts can be proctored again after 24 hours.

Is Trine University an Authorized Certification Assessment Center for SACA?

Yes! Trine University partnered with SACA in 2021 and Trine University has several Amatrol Industrial trainers that are SACA Gold certification approved.

What do Employers have to say about SACA?

“Technology disruption is widening the gap between student learning and industry relevance of learning. At the same time, it is also shortening the shelf life of degrees and opening up variable pathways of learning. To narrow this gap, we are actively participating with the Smart Automation Certification Alliance and other industry stakeholders working alongside education to create relevant standards around Industry 4.0 and more importantly access to relevant stackable learning.”

- Michael Cook, Director Global Academic Partnerships, Rockwell Automation

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C-208 Programmable Controller Troubleshooting I Skill Standards

- **Passing the C207 exam will help you pass the C-208 exam.**
 - Did you pass the C-207 exam?
 - Given an IO diagram, the PLC program, the Sequence Diagram, and the Power Diagram, can you determine what inputs and outputs should be on in a given sequence step?
- **Introduction to PLC Troubleshooting**
 - Can you describe the two levels of troubleshooting and give an application of each?
 - Do you know six types of PLC faults?
 - Do you know how to check the status of a PLC using the PLC's status and diagnostic indicators?
- **PLC Power Supply Troubleshooting**
 - Can you explain the operation of a PLC power distribution system?
 - Can you describe how to troubleshoot a PLC power distribution system?
 - Do you know how to troubleshoot a PLC power supply?
- **PLC I/O Device Testing**
 - Can you describe how to test discrete I/O devices?
 - Can you describe how to test discrete PLC input and output terminals?
 - Can you explain the PLC force function?
 - Do you know the effect and function of the Force Mask on the controller's local tags?
- **PLC Processor Troubleshooting**
 - Do you know the operation of the GSV instruction?
 - Can you describe how to troubleshoot a CompactLogix processor?
 - Can you manually clear a fault with the controller properties window?
- **PLC Systems Troubleshooting**
 - Can you explain an application for five different methods of PLC troubleshooting?
 - Do you know four types of PLC component tests?
 - Can you describe a six-step PLC troubleshooting sequence?
 - Do you know how to use the cross-reference function?
- **Analog Input / Output Troubleshooting**
 - Can you describe how to test an analog input device and channel?
 - Can you describe how to test an analog output device and channel?



- **Analog Application Troubleshooting**

- Can you explain how to test and troubleshoot a PLC-controlled variable speed drive?
- Can you explain the basic operation and of a stepper motor?
- Do you know how to troubleshoot a Stepper Motor?

