

## Appendix 2 FATEK Communication Protocol

This Protocol is each communication port of FATEK PLC to communicate with the peripherals under standard mode. Any peripherals that want to communicate with FATEK PLC model have to meet the rules, not only the hardware connection but also the software parameter setting. Besides, the message format also has to be the same with this protocol so that the PLC can respond normally.

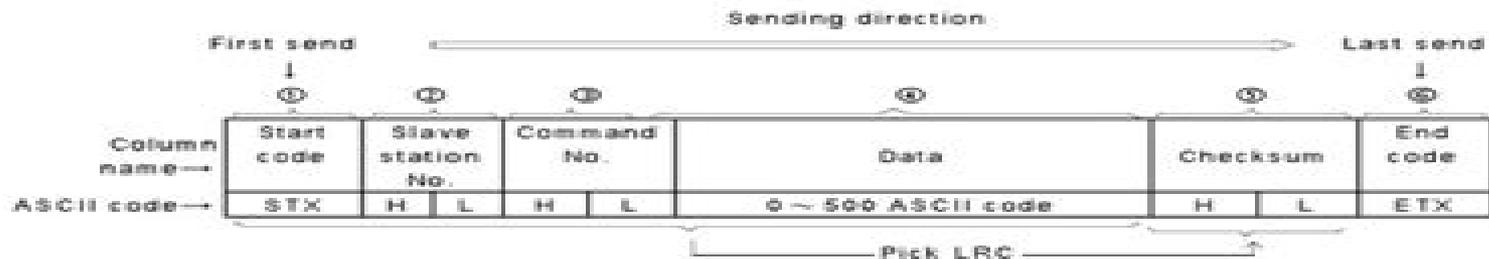
### 1. Master and Slave definition and communication

FATEK PLC is defined as slaves in the communication with peripheral devices that are always defined as masters when communicate with FATEK PLC. All the peripheral devices send the message when communicate with FATEK PLC and its respond when receive the message from masters.



### 2. The communication message format of FATEK PLC

There are 6 data columns in the FATEK PLC communication format including command (master) and response (slave) message.



① Start code (STX) : The hexadecimal code of the STX in ASCII code is 02H. The start characters are all STX in command and response message. The receiving site can determine the data start code with STX.

② The station No. of slave : The station numbers are hexadecimal two-number value. There is only master station and are 255 slave stations in the PLC communication frame. Every slave station has the only number from 1 ~ FEH. (if the station No. is 0, it means the master can send command to all slaves. When the master want to send command to one or all station No.=0) It accords the station No. assignment. The slave will send its own station No. when it send response message to master.

# Fatek Plc Communication Protocol Manual

**LM Reder**



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