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<http://forums.mrplc.com/index.php?showtopic=2105>

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Beginner`s Manual fr GX Developer FX. For more information on PLC programming please refer to Programming Manual for the MELSEC FX family (FX1S, FX1N, FX2N, FX2NC

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Programming Languages A program loaded into PLC systems in machine code, a sequence of binary code numbers to represent the program instructions.

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CNC Router Information - Here is Technical documentation regarding the Mitsubishi PLC FX1S-FX1N-FX2N Series PLC used on the CNC equipment serviced by The Service Group.

<http://theservicegroup.us/2012/03/21/mitsubishi-plc-fx1s-fx1n-fx2n-series-programming-manual/>

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