

1794-IE4XOE2

FLEX 4-Input / 2-Output Analogue Combination Module

INSTALLATION, INTERFACE AND VALIDATION WORKBOOK

Allen-Bradley 1794-IE4XOE2 is a FLEX I/O analogue combination module with four inputs and two single-ended outputs. It exchanges configured analogue process signals through the installed FLEX I/O terminal base and adapter.

STEP	GATE	ENGINEERING PURPOSE
01	IDENTIFY	Confirm article, host and hardware
02	ISOLATE	Secure power and stored energy
03	CONNECT	Restore documented interfaces
04	VALIDATE	Prove diagnostics and function

WORKBOOK PURPOSE

Field-ready identity, isolation, connection, commissioning and closeout records for this exact Allen-Bradley article.

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1794-IE4XOE2

Installation Readiness Gate

Complete the identity, host-system and isolation checks before disturbing the installed hardware.

- 1

Confirm 1794-IE4XOE2, Series B and the assigned FLEX I/O station position.
- 2

Place affected process loops and final elements in the approved maintenance state.
- 3

Isolate field and module power and use ESD controls during handling.
- 4

Record all four input and two output terminals, commons, shields and field supplies.

Pre-Work Evidence

EVIDENCE ITEM	RECORDED VALUE
Complete article marking	1794-IE4XOE2
Host / carrier	Allen-Bradley FLEX I/O 1794 system
Primary system role	Acquires four configured analogue input channels
Acceptance boundary	Prove every input and output loop before automatic operation.
Source record	FLEX I/O Analogue Modules User Manual

WORK AUTHORIZATION RECORD

Work order: _____

Drawing / revision: _____

Checked by: _____

Date: _____

Isolation and Access Register

CONTROL POINT	ENGINEER RECORD
Incoming supply	Isolated / proved
Stored energy	Discharged / proved
Field connections	Identified / protected
ESD control	Established / recorded

Pre-Work Documentation

DOCUMENT	ENGINEER RECORD
Connection photograph	Reference / file
Configuration backup	Reference / revision
Diagnostic baseline	Reference / result

Connection and Installation Sequence

INSTALLATION PRINCIPLE

Install 1794-IE4XOE2 on the exact FLEX I/O terminal base specified by the official user manual and record all four input and two output channels before removal. Restore channel range, scaling and adapter configuration, then validate each loop and module diagnostic under controlled conditions.

- 1 Verify the terminal-base catalogue and adapter arrangement against the official manual.
- 2 Restore channel type, range, scaling and controller I/O configuration.
- 3 Review module, adapter and controller diagnostics after controlled power-up.
- 4 Prove every input and output loop before automatic operation.

Connection Record

CONNECTION GROUP	AS-FOUND / AS-LEFT RECORD	STATUS
Power / field connection	Reference / terminal	Checked
Signal / interface	Reference / connector	Checked
Ground / shield	Reference / point	Checked
Accessory / carrier	Reference / part	Checked

MODEL-SPECIFIC RELEASE LIMIT

Confirm 1794-IE4XOE2, Series B, FLEX I/O adapter and terminal base, 24 V DC supply, four input and two single-ended output assignments, signal ranges, scaling, commons, shielding, grounding, controller project and controlled loop-test results before commissioning.

Interface Acceptance Criteria

ACCEPTANCE ITEM	REQUIRED EVIDENCE
Identity	1794-IE4XOE2
Host match	Allen-Bradley FLEX I/O 1794 system
Connection proof	Restore channel type, range, scaling and controller I/O configuration.
Configuration proof	Review module, adapter and controller diagnostics after controlled power-up.

Commissioning and Acceptance Record

Record each controlled verification step before the equipment returns to automatic operation.

NO.	ACCEPTANCE CHECK	RESULT	RECORD
1	Article and host identity	PASS / FAIL	Initial / date
2	Mechanical installation	PASS / FAIL	Initial / date
3	Power and field wiring	PASS / FAIL	Initial / date
4	Grounding and shielding	PASS / FAIL	Initial / date
5	Configuration restoration	PASS / FAIL	Initial / date
6	Signal or power-path response	PASS / FAIL	Initial / date
7	Diagnostics and alarms	PASS / FAIL	Initial / date
8	Final functional release	PASS / FAIL	Initial / date

Engineering Notes

RECORD AREA	ENGINEER ENTRY
As-found condition	
Corrective action	
As-left configuration	
Outstanding restriction	
Release authorization	

CONTROLLED COMMISSIONING

Prove every input and output loop before automatic operation.

Diagnostics and Release Log

EVENT	ENGINEERING RECORD
Initial energization	Result / observation
Interface or signal response	Result / observation
Alarm and diagnostic review	Result / observation
Functional release	Name / date

Maintenance Verification and Closeout

Compact analogue process stations

Combines sensing and command loops in one FLEX I/O module position.

Skid control I/O

Connects a small set of transmitters and control outputs through a remote FLEX station.

Machine utility monitoring

Acquires analogue condition signals and returns configured analogue commands.

FLEX I/O migration verification

Provides the exact channel record required for controlled module replacement.

Related Engineering Pages

MODEL	ENGINEERING ROLE	APTER POWER PAGE
1756-ENBT/A	EtherNet/IP module	View 1756-ENBT/A page
1756-L71	ControlLogix controller	View 1756-L71 page
1794-IE8	FLEX analogue input module	View 1794-IE8 page
1794-OE4	FLEX analogue output module	View 1794-OE4 page
1756-IF8	ControlLogix analogue input module	View 1756-IF8 page
1756-OF8	ControlLogix analogue output module	View 1756-OF8 page
1756-A10	ControlLogix chassis	View 1756-A10 page
1756-PA75	ControlLogix power supply	View 1756-PA75 page

MANUFACTURER SOURCE RECORD

FLEX I/O Analogue Modules User Manual
Rockwell Automation publication 1794-UM062

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