

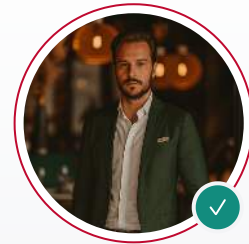
Metal-Asia

GE PACSystems RX3i, GE Fanuc, and Legacy PLC Modules for Installed-Base Support

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EXPERT PROFILE

Technical Procurement Guide for Legacy GE PLC/PAC Continuity and Exact Replacement

Prepared by: [METAL-ASIA.PW](https://www.metal-asia.com) Technical Division

Document Type: Legacy PLC/PAC Installed-Base Support Guide

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Applicable Systems: GE PACSystems RX3i · PACSystems RX7i · GE Fanuc Series 90-30/90-70 · VMIVME · VMIC · Legacy PLC/PAC Modules

Primary Sectors: Industrial Automation · Process Manufacturing · Packaging Lines · Water/Wastewater · Factory Automation · Machinery Control · Distributed I/O Systems

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1. Executive Summary

[GE Fanuc and PACSystems platforms](#) remain highly relevant in industrial facilities where legacy PLC architectures continue to operate as part of validated, capital-intensive, and technically stable control environments. In many [production plants](#), water treatment systems, process lines, factory automation cells, and installed-base control cabinets, [GE PACSystems RX3i](#), RX7i, CPU modules, communication modules, VMIVME boards, and VMIC hardware still perform critical operational roles.

[Metal-Asia.pw supplies GE PACSystems](#), GE Fanuc, legacy PLC modules, communication hardware, processor units, rack-based modules, and hard-to-find installed-base components for industrial enterprises across Russia and the CIS. Our role is not limited to simple catalog supply. We provide engineering-led sourcing for exact replacement, CPU module verification, legacy platform continuity, and revision-controlled selection before dispatch.

The main entities in this family include:

- **PACSystems RX3i**
- **PACSystems RX7i**
- **GE Fanuc**
- **Programmable Automation Controller**
- **Processor Modules**
- **Communication Modules**
- **VMIVME**
- **VMIC**

Typical part numbers in this cluster include IC693CPU350, IC693CPU331, IC693CPU363, IC695CRU320, IC697CPX772, IC698CRE030, VMIVME-7750, VMIVME-7700, VMIVME-7658, VMIVME-4140, VMICPCI-7806, and VMIVME-7807RC.

These systems are widely associated with:

- Industrial automation
- Process manufacturing
- Packaging lines
- Machinery and plant control
- Water and wastewater
- Factory automation
- Legacy control cabinets
- Distributed I/O systems

In this area, procurement errors often happen because buyers rely on model family names instead of full technical identification. A GE CPU or communication module may look mechanically similar while remaining incompatible due to revision differences, firmware mismatch, host architecture limitations, or software-environment constraints.

This document is meant to support engineers and procurement teams who need a practical, procurement-oriented explanation of how legacy GE PLC/PAC platforms should be grouped, identified, and sourced. It reinforces [Metal-Asia.pw positioning](#) as a supplier for installed-base continuity, exact CPU replacement, and cabinet-preserving modernization logic rather than generic low-depth catalog selling.

2. The GE PLC/PAC Installed-Base Landscape

2.1 Platform Architecture Overview

The GE legacy PLC/PAC ecosystem spans multiple hardware generations, each with distinct characteristics, software requirements, and lifecycle status. Understanding these distinctions is fundamental to accurate procurement.

PLATFORM FAMILY	ERA	ARCHITECTURE	CURRENT STATUS	PRIMARY APPLICATIONS
Series 90-30 (IC693)	1990s-2000s	Modular rack-based PLC	Legacy/Obsolete	Small-to-medium control, discrete manufacturing, water/wastewater
Series 90-70 (IC697)	1990s-2000s	High-performance modular PLC	Legacy/Obsolete	Complex control, process industries, high I/O count applications
VersaMax (IC200)	2000s-2010s	Micro/modular PLC	Active Mature	Cost-sensitive applications, distributed I/O nodes
PACSystems RX3i (IC695)	2000s-Present	High-performance PAC	Active	Modern industrial control, process automation, hybrid applications
PACSystems RX7i (IC698)	2000s-Present	Backplane-free rugged PAC	Active	Harsh environments, high-availability applications, OEM machinery
VMIVME / VMIC	1990s-2010s	VMEbus industrial computers	Legacy/Obsolete	Military/aerospace heritage, specialized industrial computing

2.2 Why Legacy Platforms Persist

[GE Fanuc and legacy PACSystems hardware](#) remains operational across industrial infrastructure for compelling technical and economic reasons:

Validated Systems: Pharmaceutical, food & beverage, and regulated industries operate under FDA, GMP, or similar validation regimes. Changing control platforms triggers extensive revalidation costs exceeding hardware replacement by orders of magnitude.

Proven Reliability: Decades of operational history demonstrate mean-time-between-failures (MTBF) performance that new platforms must match before risk-averse operators will migrate.

Software Investment: Hundreds to thousands of hours of ladder logic, function block, and structured text programming represent irreplaceable intellectual property. Migration requires conversion, testing, and recommissioning.

Capital Constraints: Full platform replacement requires new hardware, engineering, installation, commissioning, and downtime—often economically unjustifiable when [legacy components remain available](#).

Technical Stability: If the control system performs its required functions without limitation, "newer" does not equate to "better" for the operational requirement.

3. Critical Platform Families and Components

3.1 Series 90-30 (IC693) — The Workhorse PLC

The Series 90-30 remains one of the most widely deployed GE PLC families globally, with millions of units installed across [industrial automation applications](#).

COMPONENT CATEGORY	TYPICAL PART NUMBERS	FUNCTION
CPU Modules	IC693CPU350, IC693CPU331, IC693CPU363, IC693CPU364, IC693CPU374	Program execution, I/O control, communication management
Power Supplies	IC693PWR321, IC693PWR322, IC693PWR330	24VDC or 120/240VAC input; 5VDC backplane power
Discrete I/O	IC693MDL645, IC693MDL646, IC693MDL740, IC693MDL741	24VDC, 120VAC, relay output modules
Analog I/O	IC693ALG220, IC693ALG221, IC693ALG390, IC693ALG391	Voltage, current, thermocouple, RTD inputs/outputs

Communication	IC693CMM321, IC693BEM331, IC693PBS201	Genius, Ethernet, Profibus communication modules
Specialty Modules	IC693APU300, IC693DSM302, IC693TCM303	Motion control, temperature control, high-speed counter

Critical Procurement Considerations for Series 90-30:

- **CPU Firmware Version:** CPU350 firmware versions determine compatibility with programming software (Logicmaster, Control, or Proficy Machine Edition). Incorrect firmware may prevent program upload/download.
- **Power Supply Wattage:** High-density I/O configurations require high-capacity power supplies (IC693PWR330 30W vs. IC693PWR321 15W).
- **I/O Module Density:** 16-point, 32-point, and 8-point isolated variants exist for similar functions—mechanically identical but electrically distinct.
- **Communication Protocol:** IC693CMM321 modules require specific firmware for Genius vs. Ethernet capability.

[Metal-Asia.pw supports Series 90-30 exact replacement](#) with:

- CPU module revision verification
- Firmware version confirmation
- I/O module density and isolation specification matching
- Communication module protocol capability validation

3.2 Series 90-70 (IC697) — High-Performance Control

The Series 90-70 addressed applications beyond Series 90-30 I/O and processing limits, serving [complex process manufacturing](#) and high-availability requirements.

COMPONENT CATEGORY	TYPICAL PART NUMBERS	FUNCTION
CPU Modules	IC697CPX772, IC697CPX782, IC697CPX935, IC697CPM790	High-performance 32-bit processors with expanded memory
Power Supplies	IC697PWR710, IC697PWR711, IC697PWR720	100W capacity; redundant configurations supported
VME Modules	IC697VMM711, IC697VRD008, IC697VAL132	VMEbus-compatible specialty modules
I/O Interface	IC697GDS700, IC697ALG230, IC697ALG440	Genius distributed I/O, analog input/output
Communication	IC697CMM711, IC697BEM731, IC697CGR772	Ethernet, Genius bus controller, CPU redundancy

Series 90-70 Specific Risks:

- **CPU Memory Configuration:** CPX772 with 512KB vs. 1MB vs. 6MB memory—program size determines minimum requirement.
- **Redundancy Architecture:** CGR772 redundancy CPUs require specific firmware and configuration for hot-standby operation.
- **VMEbus Compatibility:** Third-party VME modules require voltage, timing, and interrupt compatibility verification.

3.3 PACSystems RX3i (IC695) — Modern High-Performance PAC

The [PACSystems RX3i](#) represents GE's transition from PLC to PAC (Programmable Automation Controller), combining PLC reliability with PC-based performance.

COMPONENT CATEGORY	TYPICAL PART NUMBERS	FUNCTION
CPU Modules	IC695CPU310, IC695CPU320, IC695CRU320, IC695CPE330	High-speed processors with Ethernet embedded; redundancy support
Racks/Backplanes	IC695CHS012, IC695CHS016, IC695LRE001	12-slot and 16-slot universal backplanes; expansion receiver
Power Supplies	IC695PSA040, IC695PSD040	40W AC or DC input power supplies
I/O Modules	IC695ALG508, IC695ALG616, IC695DI304, IC695DO310	High-density analog and discrete I/O
Communication	IC695ETM001, IC695PNS001, IC695CMM002	Ethernet, Profinet, serial communication modules
Specialty	IC695HSC304, IC695PMM335	High-speed counter, pulse width modulation

RX3i Critical Procurement Factors:

- **CPU Ethernet Capability:** CPE330 includes embedded Ethernet; CPU310 requires ETM001 module for Ethernet.
- **Redundancy Configuration:** CRU320 redundancy CPUs require specific synchronization modules and cable kits.
- **Universal Backplane Compatibility:** RX3i I/O works in Series 90-30 racks with adapters, but not all combinations are valid.
- **Proficy Machine Edition Version:** RX3i CPU firmware requires specific software versions for programming access.

[Metal-Asia.pw RX3i support](#) includes:

- CPU feature set verification (Ethernet, redundancy, motion)
- Backplane and expansion architecture validation
- I/O module density and feature matching
- Software environment compatibility confirmation

3.4 PACSystems RX7i (IC698) — Rugged High-Availability PAC

The RX7i addresses applications requiring [harsh environment operation](#) and maximum availability without traditional rack-based backplanes.

COMPONENT CATEGORY	TYPICAL PART NUMBERS	FUNCTION
CPU Modules	IC698CRE030, IC698CPE010, IC698CPE020	Rugged CPUs with embedded I/O and communication
I/O Modules	IC698PSA100, IC698PSA350	I/O and power integrated modules
Communication	IC698ETM001, IC698CMM016	Ethernet and serial communication options
Expansion	IC698RMX016, IC698CNI016	Remote I/O and control network interface

RX7i Specific Considerations:

- **Embedded vs. Modular I/O:** CRE030 includes embedded I/O; verify if customer application uses it or external I/O only.
- **Control Memory Expansion:** Some applications require memory expansion modules for large programs.
- **Environmental Hardening:** RX7i rated for -40°C to +70°C operation—replacement must match environmental rating.

3.5 VMIVME and VMIC — VMEbus Industrial Computing

VMIVME (VME Industrial Modules for Input/Output) and VMIC (VMEbus Modules for Industrial Control) represent GE's VMEbus-based industrial computing platforms, originally developed for military/aerospace applications and adapted for [harsh industrial environments](#).

PRODUCT FAMILY	TYPICAL PART NUMBERS	APPLICATION
VMIVME Single-Board Computers	VMIVME-7750, VMIVME-7700, VMIVME-7658	Pentium/PowerPC-based VMEbus controllers
VMIVME I/O Modules	VMIVME-4140, VMIVME-2120, VMIVME-1182	Analog output, digital I/O, analog input
VMIC PCI/VME Bridges	VMICPCI-7806, VMICPCI-7807	PCI-to-VMEbus interface for hybrid systems

VMIVME/VMIC Procurement Complexity:

- **Processor Architecture:** VMIVME-7750 (Pentium M) vs. VMIVME-7700 (PowerPC) are completely incompatible software environments.
- **VMEbus Specification:** VME64, VME64x, and legacy VMEbus timing differences affect module compatibility.
- **Operating System Dependency:** VxWorks, Linux, or Windows CE environments require specific BSP (Board Support Package) versions.
- **Conduction vs. Convection Cooling:** "RC" suffix indicates conduction-cooled variants—mechanically incompatible with standard enclosures.

[Metal-Asia.pw VMIVME sourcing](#) addresses:

- Processor architecture and speed grade verification
- VMEbus specification and timing compatibility
- Operating system and BSP version confirmation
- Thermal management specification matching

4. The Criticality of Exact Technical Identification

4.1 Why Model Family Names Are Insufficient

In [GE PLC/PAC procurement](#), ordering by family name ("Series 90-30 CPU," "RX3i processor") virtually guarantees delivery of incompatible hardware. The following factors mandate exact part number discipline:

Firmware Interoperability: IC693CPU350 with firmware version 9.0 operates with Logicmaster 90 software; version 10.0+ requires Proficy Machine Edition. A "CPU350" without revision specification may be unusable.

Memory Capacity: IC697CPX772 available in 512KB, 1MB, and 6MB variants—program size determines minimum requirement, and excess memory may indicate different firmware features.

Communication Capability: IC695CPU320 vs. IC695CPE330 vs. IC695CRU320 have fundamentally different Ethernet, redundancy, and I/O capabilities despite similar "CPU" nomenclature.

I/O Density and Isolation: IC693MDL645 (16-point 24VDC input) vs. IC693MDL646 (16-point 24VDC input with enhanced diagnostics)—identical form factor, different functionality.

Host Architecture Constraints: VMIVME-7750 Pentium M modules require specific VMEbus chassis and power configurations incompatible with other VME variants.

4.2 Common GE PLC/PAC Procurement Errors

ERROR PATTERN	CONSEQUENCE	METAL-ASIA.PW PREVENTION
Ordering "Series 90-30 CPU"	Delivery of incompatible CPU (e.g., CPU331 instead of CPU350)	Exact IC693 part number with firmware version verification
Ignoring IC69x Prefix	IC693 (90-30) vs. IC697 (90-70) vs. IC695 (RX3i) vs. IC698 (RX7i) are completely incompatible families	Prefix verification as primary compatibility gate
Missing Revision Suffix	IC693CPU350-JK vs. IC693CPU350-KL indicate different firmware baselines	Full part number including revision suffix
VMIVME Architecture Assumption	VMIVME-7750 (Pentium) vs. VMIVME-7700 (PowerPC) are software-incompatible	Processor architecture explicit confirmation
Software Environment Mismatch	Module requires Proficy ME 8.0; customer operates 5.0	Software version compatibility matrix check
Rack/Backplane Incompatibility	RX3i module ordered for Series 90-30 rack without adapter	Chassis architecture verification

4.3 Exact Replacement Scenarios

[Metal-Asia.pw supports](#) the following replacement strategies for GE PLC/PAC:

Like-for-Like Replacement: Identical part number, revision, and firmware—plug-and-play installation without engineering changes.

Revision-Compatible Replacement: Same base part number with verified firmware-compatible revision—requires validation but minimizes risk.

Family-Compatible Migration: Newer generation within same family (e.g., Series 90-30 to RX3i with appropriate adapters)—requires engineering analysis and testing.

Cross-Platform Migration: Different family with verified functional equivalence (e.g., VMIVME to modern industrial PC)—requires complete re-engineering.

5. Metal-Asia.pw Technical Support for GE PLC/PAC

5.1 Engineering-Led Sourcing

[Metal-Asia.pw provides](#) more than catalog supply—we deliver engineering-verified sourcing:

Exact Part Number Verification: Complete IC69x part number decomposition including prefix, base number, option suffixes, and revision codes.

Firmware Compatibility Confirmation: Where accessible, firmware version verification against customer's software environment.

Rack Architecture Validation: Verification that modules are compatible with customer's existing chassis, backplane, and power supply configuration.

Software Environment Review: Confirmation that delivered hardware is compatible with customer's programming software version.

5.2 CPU Module Verification

CPU modules receive enhanced scrutiny due to their system-critical nature:

1. **Processor Type Verification:** 80188, 80386, Pentium, or PowerPC as required by application
2. **Memory Size Confirmation:** RAM and Flash capacity verification against program requirements
3. **Communication Port Verification:** Ethernet, serial, or proprietary protocol support as specified
4. **Firmware Version Documentation:** Exact firmware revision and feature set confirmation
5. **Clock Speed and Timing:** For time-critical applications, processor speed grade verification
6. **Battery and Real-Time Clock:** RTC battery status and backup memory retention verification

5.3 Legacy Platform Continuity

For [obsolete GE PLC/PAC components](#), [Metal-Asia.pw maintains](#):

- **Global Surplus Networks:** Access to decommissioned plant inventory, distributor liquidation stock, and authorized surplus channels
- **Refurbishment Partnerships:** Board-level repair and recertification for critical legacy modules
- **Last-Time-Buy Inventory:** Strategic stock of discontinued components with known provenance
- **Compatible Alternative Identification:** Newer-generation modules with documented interchangeability

5.4 Revision-Controlled Selection

Every [GE module supplied by Metal-Asia.pw](#) undergoes:

- **Visual Inspection:** Nameplate photography; date code verification; physical condition assessment

- **Part Number Validation:** Complete ordering code verification against GE material master
- **Revision Level Confirmation:** Hardware revision (e.g., -JK, -KL, -FM suffixes) verification
- **Firmware Identification:** Where accessible, firmware version and feature set documentation
- **Functional Testing:** Power-up, self-test, and communication interface verification where facilities permit
- **Packaging Integrity:** Anti-static packaging; moisture barrier; shock protection for [industrial electronics](#)

5.5 Direct B2B Supply Geography

[Metal-Asia.pw provides direct supply](#) of GE PLC/PAC modules to:

- **Russia:** Full customs documentation, EAC certification support, ruble/euro/dollar settlement
- **CIS Region:** Kazakhstan, Uzbekistan, Azerbaijan, Armenia, Georgia
- **Kazakhstan:** Specialized support for oil & gas and mining automation infrastructure
- **Belarus:** Direct supply for industrial manufacturing and power sector projects

All shipments include:

- Commercial invoice with HS code classification (8537.10 for PLCs)
- Certificate of conformity (EAC where required)
- Packing list with serial number detail
- Manufacturer datasheets and manuals
- Export control compliance documentation

6. Procurement Data Requirements

6.1 Mandatory Information for Accurate Sourcing

DATA ELEMENT	EXAMPLE	CRITICALITY
Complete GE Part Number	IC693CPU350-KL	Mandatory
IC69x Family Prefix	IC693 (90-30), IC697 (90-70), IC695 (RX3i), IC698 (RX7i)	Mandatory
Hardware Revision	-KL, -FM, -JK suffix	Mandatory
Firmware Version	If accessible via programming software	Highly Recommended
Rack/Chassis Type	Series 90-30 5-slot, 10-slot; RX3i 12-slot, 16-slot	Mandatory for physical compatibility
Power Supply	Existing power supply model and wattage	Mandatory for loading verification

Software Environment	Logicmaster, Control, Proficy ME version	Mandatory for CPU compatibility
Application Context	Water treatment, packaging line, process control	Recommended for alternative identification

6.2 What Accelerates GE PLC/PAC Procurement

- **Nameplate Photography:** Clear image of GE label showing complete part number and date codes
- **Programming Software Screenshot:** CPU information screen showing firmware and memory details
- **Rack Configuration:** List of all modules in chassis with slot positions
- **Existing Program Size:** For CPU replacement, confirmation that replacement has adequate memory
- **Communication Requirements:** Protocols and network topology in use
- **Acceptable Alternative Policy:** Explicit statement if newer-generation or compatible revision acceptable

6.3 What Reduces GE PLC/PAC Procurement Risk

- **Never order by "Series 90-30" or "RX3i" alone:** Specify exact IC69x part number
- **Never ignore the prefix:** IC693, IC697, IC695, IC698 indicate incompatible families
- **Never assume firmware compatibility:** Specify required firmware version or accept reflash responsibility
- **Never overlook rack compatibility:** Verify module works in customer's specific chassis
- **Never accept "functionally equivalent" without documentation:** Only GE-authorized interchangeability is valid

7. Cabinet-Preserving Modernization Logic

7.1 When Legacy Continuity Is Preferred

[Metal-Asia.pw supports cabinet-preserving strategies](#) for GE PLC/PAC when:

- **Validated Systems:** FDA, GMP, or regulatory validation makes platform change prohibitively expensive
- **Proven Reliability:** Existing system demonstrates acceptable performance with no technical limitation
- **Software Investment:** Existing program logic represents irreplaceable engineering value
- **Capital Constraints:** Full migration economically unjustifiable versus [exact replacement sourcing](#)

- **Downtime Limitations:** Production schedules prevent extended commissioning windows

7.2 Modernization Pathways

When legacy continuity is not feasible, [Metal-Asia.pw supports](#) structured migration:

Within-Family Upgrade: Series 90-30 to RX3i using existing I/O with appropriate adapters—preserves field wiring, requires program conversion.

Cross-Family Migration: Series 90-30/90-70 to RX3i/RX7i with new I/O—requires complete re-engineering but provides long-term support.

VMIVME Migration: VMEbus systems to modern industrial PCs or PACs—requires hardware and software re-engineering, typically triggered by VME component obsolescence.

8. Quality Assurance and Authenticity

8.1 Counterfeit Risk in Legacy PLC/PAC

The sustained demand for [obsolete GE PLC modules](#)—combined with OEM discontinuation—creates counterfeit incentive. Substandard modules may:

- Fail prematurely due to component quality
- Lack genuine GE firmware with correct feature set
- Contain modified circuits incompatible with host systems
- Carry falsified date codes indicating recent manufacture of long-discontinued items

8.2 Metal-Asia.pw Authentication Protocol

[Our quality control processes](#) for GE PLC/PAC include:

- **Provenance Documentation:** Chain of custody from GE manufacturing or authorized distribution
- **Visual Authentication:** Comparison against GE reference standards; label verification; date code sanity checking
- **Firmware Validation:** Confirmation that loaded firmware is GE-authentic and version-identified
- **Functional Testing:** Power-up, self-test, and communication verification where facilities permit
- **Component Inspection:** Population verification against GE bills of material for high-value modules

9. Conclusion

[GE Fanuc and PACSystems platforms](#) represent a significant installed base of industrial control systems where legacy continuity, exact replacement, and revision-sensitive sourcing directly impact operational stability. The distinction between "a Series 90-30 CPU" and "IC693CPU350-KL with firmware 10.02, compatible with Proficy Machine Edition 8.6" is the difference between protected production and control system failure.

[Metal-Asia.pw](#) delivers GE PLC/PAC procurement capabilities distinguished by:

- **Exact Part Number Discipline:** No substitution without documented GE authorization or verified equivalence
- **Revision Verification:** Hardware and firmware compatibility confirmation before dispatch
- **Legacy Continuity Expertise:** Global sourcing for discontinued modules with authentication
- **Geographic Reach:** Direct B2B supply to Russia, CIS, Kazakhstan, and Belarus with full documentation
- **Technical Support:** Engineering review of compatibility requirements and cabinet-preserving strategies

For [industrial automation environments](#), [process manufacturing facilities](#), and critical infrastructure where GE PLC/PAC systems remain operational, the procurement partner must match the technical precision of the control platform itself. [Metal-Asia.pw](#) provides that capability for GE Fanuc and PACSystems installed-base support.

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This document is intended for engineers, procurement teams, and maintenance professionals responsible for GE Fanuc and PACSystems installed-base support in industrial automation and process control environments.

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