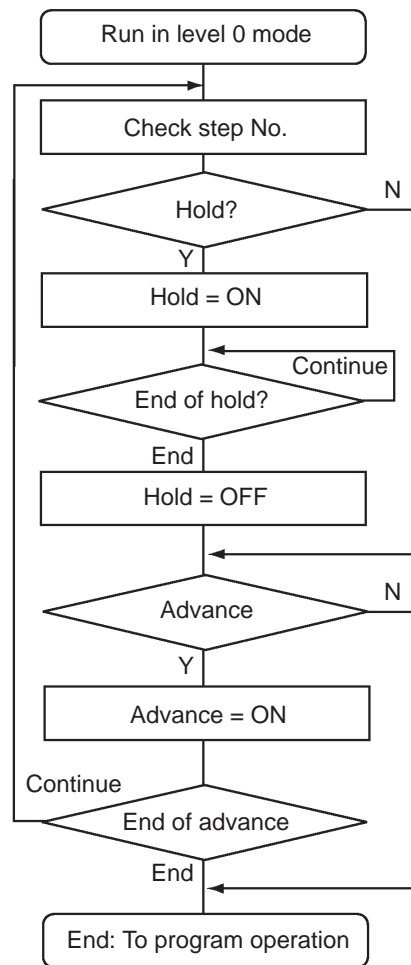


Program Operation

Hold/advance

- Steps in currently executing programs can be forcibly stopped (Hold) and advanced (Advance).
- Hold and Advance operation is according to the following procedure:



- Execute hold/advance operation while making sure the step No. in the “step No. monitor” parameter (level 0 mode).
- When the “hold” parameter (level 0 mode) is set to “**ON**”, step time counting is paused (held), and the HOLD LED lights. [Hold] and the SP appear alternately on the No.2 display when in the “PV/ Present SP” parameter.
- Hold is canceled time counting is restarted by one of the following conditions: “hold” parameter = “**OFF**”, Run, Reset, End operation using advance instruction
- Each time that “advance” parameter (level 0 mode) is set to “**ON**”, the program advances one step. With each step advance, the “Advance” parameter setting returns to “**OFF**”.
- If the advance function is executed with the program in a hold state, the hold state is continued in the next step.

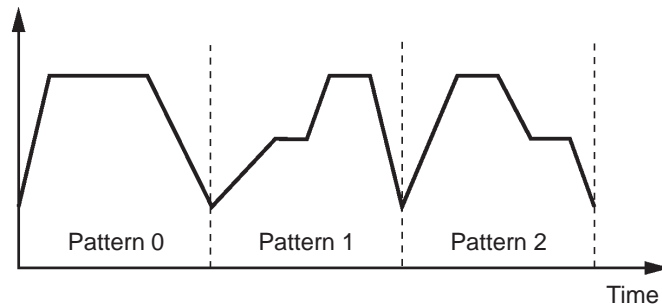
Pattern operation

Repeating execution of the same pattern

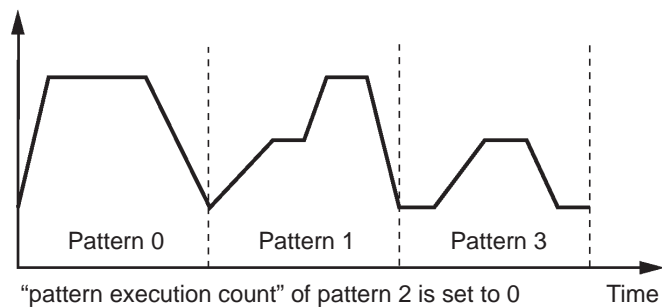
- To repeatedly execute the same pattern, set the number of times that the pattern is to be executed in the “pattern execution count” parameter (program mode).
- The pattern execution count can be set up to 9999 (times). (Default is “0”.)
- Patterns for which the “pattern execution count” parameter is set to “0” cannot be executed.
- The count of the currently executing pattern in the program can be verified in the “pattern execution count monitor” parameter (level 0 mode). “0” is indicated in this parameter when the controller of reset or in a standby state.

Executing all patterns

- To execute all preset patterns in order from pattern 0, set the “run all enable” parameter (expansion mode) to “ $\bar{0}n$: ON”. (Default “ $\bar{0}FF$: OFF”.)



- When a power interruption occurs during run all execution, if the “operation at power ON” parameter (expansion mode) is set to “ $\bar{0}n$: Continue”, the currently executing pattern No. is held in memory. When power is restored, program operation resumes from the pattern that was being executed when the power was interrupted. (For details on operation at power ON, see Section 4–7 Setting Running Conditions.
- Patterns whose “pattern execution count” is set to “0” are skipped.



Parameters

Symbol	Parameter Name: Mode	Description
<i>HöLd</i>	Hold : Level 0	Pauses program execution.
<i>Adu</i>	Advance : Level 0	Advances the program one step.
<i>rPt</i>	Pattern execution count : Pro- gram	Repeatedly executes current pattern.
<i>rUnR</i>	Run all :Expan- sion	Executes all patterns.



About Reset

- A reset cancels a hold state.
- When the controller is reset during run all execution, the program returns to step 0 of the currently executing pattern.