

# GFK-0854

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## GE Fanuc Manual Series 90-70

Logicmaster Sequential Function Chart Programming  
Language

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# *GE Fanuc Automation*

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*Programmable Control Products*

*Series 90<sup>TM</sup>  
Sequential Function Chart  
Programming Language*

*User's Manual*

GFK0854A

October 1994

# Warnings, Cautions, and Notes as Used in this Publication

## Warning

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**In situations where inattention could cause either personal injury or damage to equipment, a Warning notice is used.**

## Caution

**Caution notices are used where equipment might be damaged if care is not taken.**

## Note

Notes merely call attention to information that is especially significant to understanding and operating the equipment.

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Logicmaster™ 90 programming software is used to configure and program the Series 90™ programmable controllers. This manual describes how to use sequential function chart (SFC) version of Logicmaster software to program your logic and create an application program for your programmable controller.

## Content of This Manual

For 90-70 users, this manual is supplementary in content to the *Logicmaster 90-70 Programming Software User's Manual*, GFK-0263, and to the *Series 90-70 Programmable Controller Reference Manual*, GFK-0265. You will need to refer to these Logicmaster 90-70 manuals in order to become familiar with the features of Logicmaster 90-70 programming software.

For 90-30 users, this manual is supplementary in content to the *Logicmaster 90-30 Programming Software User's Manual*, GFK-0466, and to the *Series 90-30 Programmable Controller Reference Manual*, GFK-0467. You will need to refer to these Logicmaster 90-30 manuals in order to become familiar with the features of Logicmaster 90-30 programming software.

The *Series 90 Sequential Function Chart Programming Language User's Manual*, GFK-0854A, contains only that information which is unique to the sequential function chart version of Logicmaster 90 software. It does not repeat material found in either the User's Manuals or the Reference Manuals that is common to both the SFC and RLD versions of Logicmaster 90 software.

This is the second edition of the *Series 90 Sequential Function Chart Programming Language User's Manual*, GFK-0854A. It contains the following chapters and appendixes.

**Chapter 1. Introduction:** provides an introduction to sequential function chart language and describes what you will need in order to create an application program.

**Chapter 2. Understanding SFC Language:** provides an overview of sequential function chart (SFC) language.

**Chapter 3. Sequential Function Chart Editor:** describes SFC program blocks, how to insert/edit an SFC network, and the functions available in the SFC Editor.

**Chapter 4. Printing SFC Blocks:** describes a typical printout of an SFC network and provides examples of each section of the printout.

**Appendix A. Common User Errors:** lists common user errors.

## *Revisions to This Manual*

Changes made to this manual reflect the features of this release of SFC (October 1994), primarily the inclusion of a 90-30 version of SFC. When there are differences between the 90-30 and the 90-70 versions (such as SFC subroutine capabilities), these differences are noted in the sections discussing the features wherein they differ. Additionally, clarifications and corrections have been made where necessary.

## *Related Publications*

*Series 90™ -70 Programmable Controller Installation Manual (GFK-0262).*

*Logicmaster™ 90-70 Programming Software User's Manual (GFK-0263).*

*Series 90™ -70 Programmable Controller Reference Manual (GFK-0265).*

*Series 90™ -30 Programmable Controller Installation Manual (GFK-0356).*

*Logicmaster™ 90-30 Programming Software User's Manual (GFK-0466).*

*Series 90™ -30 Programmable Controller Reference Manual (GFK-0467).*

## *We Welcome Your Comments and Suggestions*

At GE Fanuc Automation, we strive to produce quality technical documentation. After you have used this manual, please take a few moments to complete and return the Reader's Comment Card located on the next page.

*Linda Edenfield  
Customer Documentation Process Manager*

*David Bruton  
Sr. Technical Writer*

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# Chapter 1

## Introduction

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Logicmaster™ 90 programming software is used to configure and program the Series 90™ programmable controllers. In most cases, programming is done using Relay Ladder Diagram (RLD) logic to create an application program for the PLC. Now, you can optionally choose to program your logic in Sequential Function Chart (SFC) language. This manual explains how to use Sequential Function Chart (SFC) language with Logicmaster 90-70 or Logicmaster 90-30 software to program your logic and create an application program for your programmable controller.

This manual does not attempt to describe the other features and functions of Logicmaster 90-70 or 90-30 software. For information on the features and functions of the 90-70 software, please refer to the *Logicmaster™ 90-70 Programming Software User's Manual*, GFK-0263. For information on programming instructions and timing information pertaining to the 90-70 software, refer to the *Series 90™ -70 Programmable Controller Reference Manual*, GFK-0265. For information on the features and functions of the 90-30 software, please refer to the *Logicmaster™ 90-30 Programming Software User's Manual*, GFK-0466. For information on 90-30 programming instructions and timing information, refer to the *Series 90™ -30 Programmable Controller Reference Manual*, GFK-0467.

### SFC Defined

Sequential Function Chart (SFC) is a graphical, state language which is IEC-compliant. SFC was specifically developed for controlling sequential processes. SFC offers a graphical representation of the functions of a sequential automated system as a sequence of steps and transitions.

For a better understanding of what SFC does and the relationship between SFC and RLD, read the first five pages of chapter 2.

### SFC in 90-30 and SFC in 90-70 Logicmaster

Previously, SFC was available only for users of Logicmaster 90-70. It is now available for the 90-30 product as well. The places where the two differ are noted within this manual.

### What You Will Need

The *Logicmaster 90-70 Programming Software User's Manual*, GFK-0263, lists the hardware and software required to run the Logicmaster 90-70 software packages. The *Logicmaster 90-30 Programming Software User's Manual*, GFK-0466, lists the hardware and software



required to run the Logicmaster 90-30 software packages. You should review this list in chapter 1, "Introduction," to make sure your system is compatible before attempting to load the software or start up your computer.

## MS-DOS Version

In order to run Logicmaster software, MS-DOS Version 5.0 or later must be installed on your computer.

Logicmaster software provides foreign keyboard support, depending on the configuration of MS-DOS residing on the host computer. Consult your MS-DOS user's manual for configuration information for your country.

## Installing the Software

Chapter 2, "Operation," in both the *Logicmaster 90-70 Programming Software User's Manual*, GFK-0263 and the *Logicmaster 90-30 Programming Software User's Manual*, GFK-0466, describes how to install and start up the Logicmaster programming software. Before you can begin using the features and functions described in this manual, you must first install the software. If you have not yet installed the Logicmaster software, follow the installation procedure described in chapter 2 of GFK-0263 or GFK-0466, depending on which version of Logicmaster you are using.

If the SFC option has already been installed on your computer, then once you install Logicmaster, SFC is available with no additional installation. If the SFC option has not been installed previously, then you will need to install the SFC Option diskette after installing Logicmaster.

## Help Screens

Logicmaster software includes detailed Help screens. These Help screens are loaded onto the hard disk of your programmer during the software installation procedure and are readily accessible. Press **ALT-H** to access the help screens.

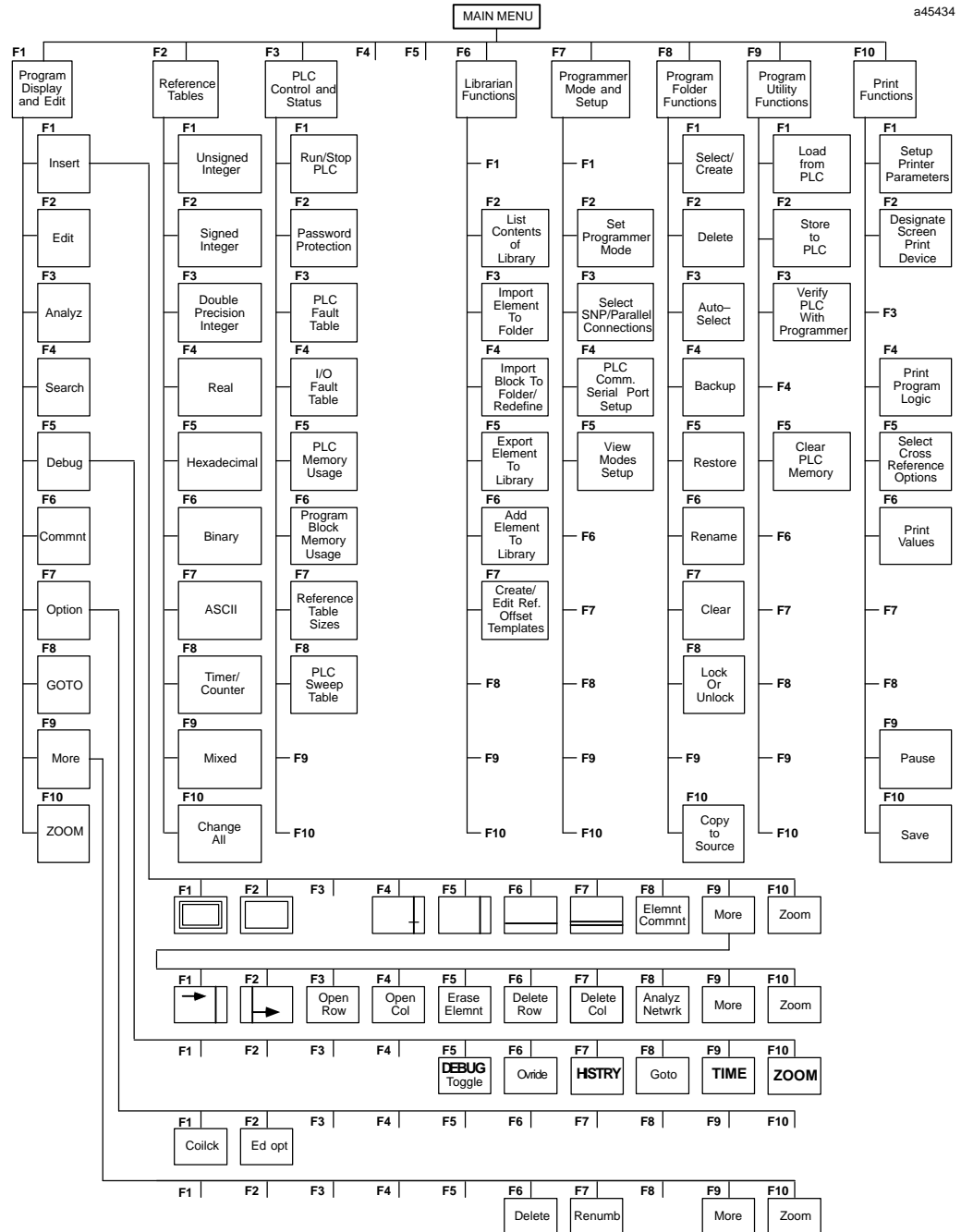
## Key Functions

Appendix E, "Key Functions," in both the *Logicmaster 90-70 Programming Software User's Manual*, GFK-0263, and the *Logicmaster 90-30 Programming Software User's Manual*, GFK-0466, lists the keyboard functions that are active in the Logicmaster software environment. Appendix E also contains a perforated card which can be removed from this manual.

## Softkey Directory

The display on the facing page shows the keys available to you in SFC programming. Notice that the Logicmaster softkeys (keystrokes-to-functions) are the same except for those accessed through the **Program Display and Edit** softkey. When going from the first **F1** (the **Program Display and Edit** softkey) to the SFC keys, you may be prompted to choose SFC or RLD programming if you are adding a new subroutine, or if you just created a new folder. (Of course, you will need to create a new folder if you are starting a new program.)

While attempting to display graphically the general structure of the SFC functions and their activating keystrokes, this display is not intended to encompass every possible keystroke option you may encounter, but rather it is intended to provide you with an overview of the general pattern of what is available and how to find it.



**NOTES:**

-F unctions shown in ALL CAPS are accessed by holding the Shift key down when pressing the function key. (Use of capitalization in this manner reflects the convention

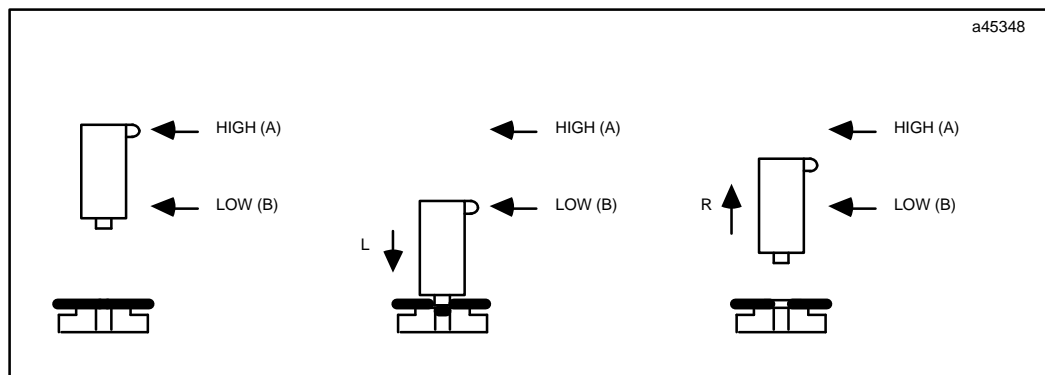
- used on the Logicmaster and SFC screens.)
- Librarian functions do not exist for the 90-30 version.
  - Refer to chapter 2 of the Logicmaster User's Manuals (90-30 or 90-70) for a similar display of Logicmaster keys and functions.

# Chapter 2

## Understanding SFC Language

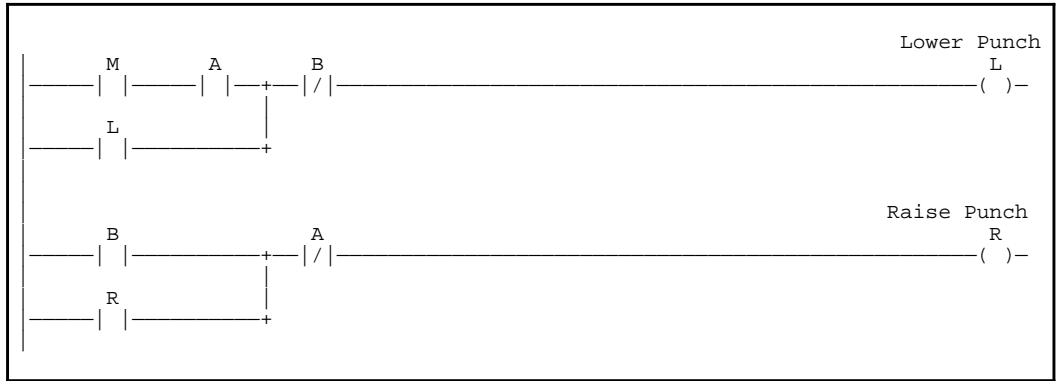
### RLD and SFC

The traditional Relay Ladder Diagram (RLD) logic (also called Ladder Logic) has been widely used for designing and representing logic control systems since the relay was invented. For combinational logic control systems, where outputs or actions are directly dependent on the states of inputs or conditions, RLD is excellent. However, for some control problems, where control actions are sequential or time dependent, Relay Ladder Diagram logic alone can become cumbersome. Consider the simplified example of a semi-automatic punch.



In this example, a semi-automatic punch is initially in the raised position (A). When the operator presses the Start pushbutton (M), the punch descends, pierces the metal plate at position (B), and completes the cycle by returning to the raised position.

In the ladder diagram approach, you not only have to take into account the fact that pressing the Start pushbutton (M) initiates the movement of the punch. You must also consider that the operator will release the pushbutton and that he could press the pushbutton before or after the punch is in the rest position. This additional information has no bearing on the movement of the punch and complicates the description of the function.



What is needed is a method of representing sequential control problems in a sequential manner, showing the various actions to be taken in a step and indicating the conditions that must be fulfilled before advancing to the next step. To observe some of the differences between SFC and RLD, compare the diagram represented above to the one shown on page 2-5.

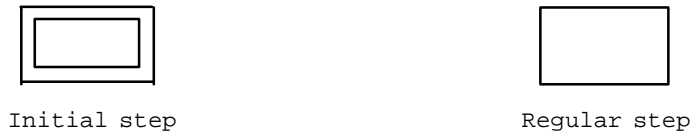
Sequential Function Chart (SFC) is a method specifically developed for describing industrial sequential control systems. SFC is a graphic method which represents the functions of a sequential automated system as a sequence of steps and transitions. Each step represents commands or actions that are either active or inactive. The flow of control passes from one step to the next through a conditional transition that is either true (1) or false (0). If the transition condition is true (1) (indicated by setting the transition variable), control passes from the current step (which becomes inactive) to the next step, which then becomes active.

Each control function can, therefore, be represented by a group of steps and transitions, called a Sequential Function Chart (SFC).

The next two pages demonstrate the steps and transitions required to program the same logic shown in the diagram above using SFC instead of RLD. The third page shows the final SFC diagram which, as mentioned above, should be compared and contrasted to the diagram shown above.

## Steps

Two types of steps may be used in a sequential function chart: initial steps and regular steps. They are represented graphically as shown below:



The **initial step** is executed the first time the SFC block is executed or as a result of SFC\_RESET (For more information on using the SFC\_RESET function to reset the SFC to its initial step, see page 3-58.) There can be one and only one initial step per SFC network. The initial step cannot appear within a simultaneous construct, but it may appear anywhere else.

A regular step is executed if the transitional logic in the SFC network makes the step active; therefore, there can be one or many regular steps in an SFC network.

Initial steps are constructed with double horizontal lines and double vertical side lines. Regular steps use single horizontal lines and single vertical side lines.

### Step Action Logic

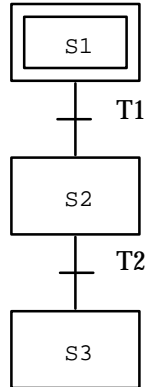
Each step may have action logic consisting of zero or more rungs programmed in Relay Ladder Diagram (RLD) logic language. (*Action Logic* is the logic associated with a step, i.e., the logic, programmed by RLD logic language, that is executed when the step is active.)

### Note

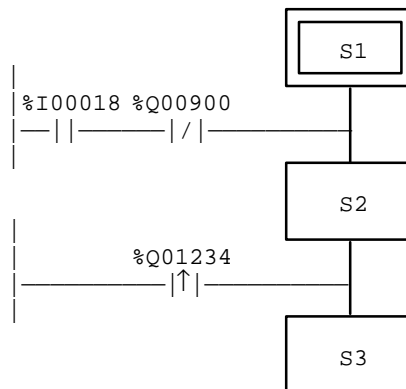
When a step becomes inactive, its action logic is executed one final time, without power flow. This sets the coils in the logic to their default state (i.e., a normally open coil defaults to OFF, while a normally closed coil defaults to ON).

## Transitions

Transition logic is programmed in Relay Ladder Diagram (RLD) logic. Each transition must contain a rung that ends with a coil to set its transition variable (i.e., the name of the transition, such as T1\*).



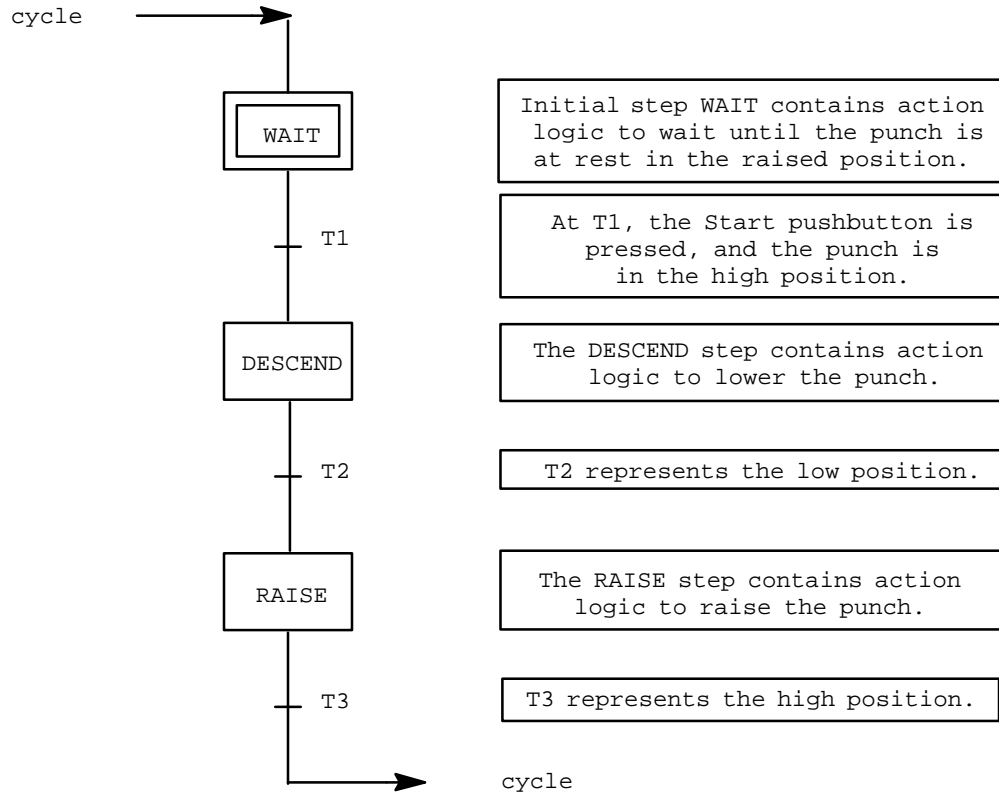
The following example shows how the transition conditions *conceptually* replace their associated transitions (T1 and T2) in the sequential function chart displayed above; i.e., the first one represents the transition conditions associated with T1, the second one (between S2 and S3) representing the transition conditions associated with T2.



\*Do not confuse *T1* (as used in these examples to represent *Transition 1*) with %T1 used in Logicmaster to represent a temporary coil.

### Example

Consider again the semi-automatic punch in the example on pages 2-1 through 2-2. It can be represented as an SFC as shown below.



In the example above, the initial step (WAIT) is represented by a square drawn with double lines. It contains action logic that is performed the first time the SFC network is executed. The initial step also becomes active if the SFC is reset via the SFC\_RESET function block. A regular step is represented by a square which may also contain a name (e.g., DESCEND or RAISE) representing the principle function at that step. Action logic associated with each step and also with each transition (T1, T2, and T3) is programmed in Relay Ladder Diagram logic by zooming into the appropriate step or transition.



## Series 90 PLC Scan Cycle

The Series 90-70 PLC scan continuously executes the **\_MAIN** block and any called **SFC block** when the PLC is in **RUN** mode. Each SFC block includes Preprocessing, Sequential Processing, and Postprocessing.

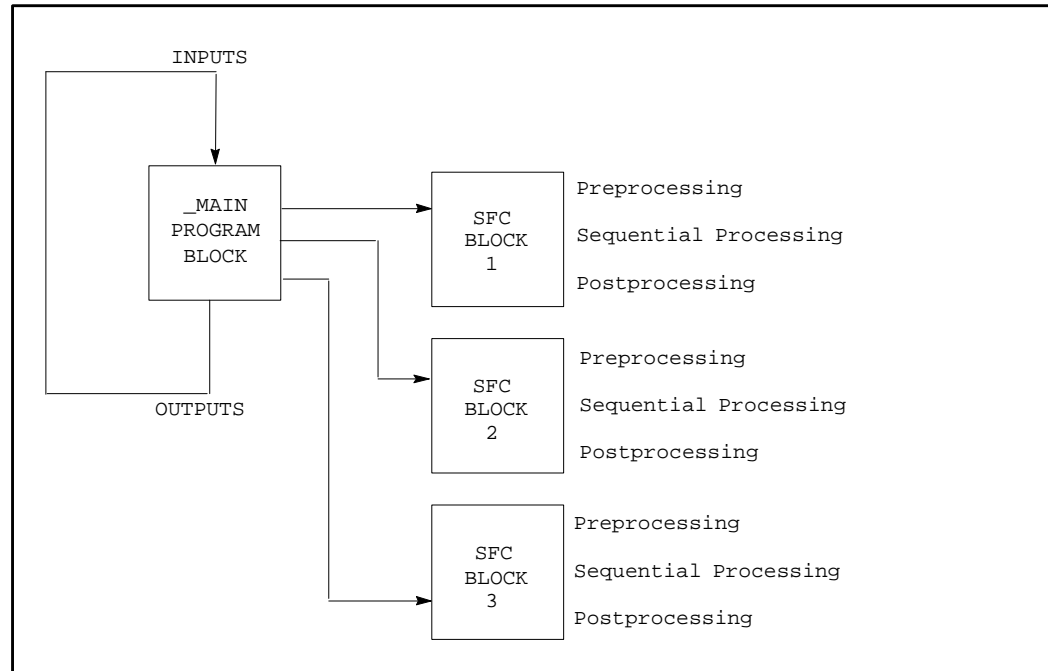


Figure 2-1. Series 90-70 PLC Scan Cycle

### Note

Logicmaster 90-30 does not allow SFC subroutine blocks; therefore, only the **\_MAIN** block is allowed to be SFC in the 90-30 version of SFC. For that reason, in a 90-30 SFC block (i.e., **\_MAIN** block that is SFC rather than RLD), the Preprocessing, Sequential Processing, and Postprocessing is all part of the **\_MAIN** block.

In addition, please note that this graphical representation of the PLC scan cycle is not intended to encompass all possible scenarios of PLC scan for 90-70 PLCs; e.g., the **\_MAIN** block could be an SFC block (thereby having the same three processing stages within it), and the subroutines could be a mixture of RLD and SFC.

### Preprocessing

This section is processed at the start of every scan. Normally, RLD preprocessing logic is used to process, at the start of the scan cycle, events which may affect the sequential processing section of the program. These events may include:

- Initialization;
- Operator commands;
- Resetting the SFC to the initial state.

### Sequential Processing

This portion of the PLC scan consists of evolving the SFC to its next state and processing the action logic of any steps that become active. Only the logic associated with active steps and transitions is scanned by the PLC, leading to a significant reduction of scan time. For more information, see “SFC Evolution” below.

### Postprocessing

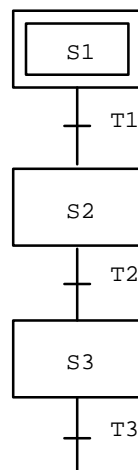
This section is processed every scan after the SFC is complete. It may contain Relay Ladder Diagram (RLD) logic to process safety interlocks, etc.

## SFC Evolution

A step can be either active or inactive. A transition is active (only evaluated) when the step immediately preceding it is active. If a transition evaluates true (ON), then the immediately preceding step(s) are made inactive and the immediately succeeding step(s) are made active. This process is referred to as “evolving the sequential function chart.” The sequence of operations for any given sequential processing portion of the PLC scan is to:

1. Evaluate the transitions following all active steps.
2. Evolve the sequential function chart.
3. Execute the action logic associated with the active steps.

The example Sequential Function Chart segment and example logic execution flow are used to illustrate how transitions and states become active in SFC evolution.



When an SFC block is initially executed, the SFC is considered to be in the reset state. The the initial step (S1) becomes active, and transition T1 becomes active. The action logic associated with step S1 is then executed.

On the second scan, the transition logic associated with active transition T1 is tested and found to be true. Step S1 becomes inactive, and transition T1 becomes inactive. Step S2 becomes active, and transition T2 becomes active. The action logic associated with step S2 is then executed.

On the third scan, the transition logic associated with active transition T2 is tested and found to be false. Since the transition condition is not satisfied, step S2 remains active, and transition T2 remains active. The action logic associated with step S2 is executed again.

On the fourth scan, the transition logic associated with active transition T2 is again tested and found to now be true. Therefore, transition T2 becomes inactive, step S2 becomes inactive. Step S3 becomes active, and transition T3 becomes active. The action logic associated with step S3 is then executed.

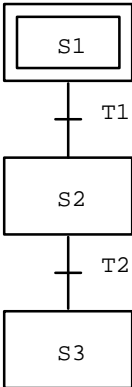
The following table summarizes this sequence of events for this example:

Table 2-1. Sequence of Events for the SFC Evolution

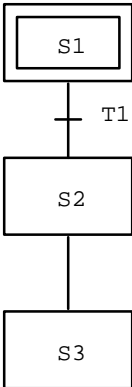
Scan	Step S1	Transition T1	Step S2	Transition T2	Step S3	Transition T3
1	Active	Active	Inactive	Inactive	Inactive	Inactive
2	Inactive	Inactive	Active	Active	Inactive	Inactive
3	Inactive	Inactive	Active	Active	Inactive	Inactive
4	Inactive	Inactive	Inactive	Inactive	Active	Active

### Examples of Sequential Function Charts

The following example shows part of a correctly structured sequential function chart. It has an initial step (S1), two regular steps (S2 and S3), and two transitions (T1 and T2).



The next example shows part of a sequential function chart that is incorrectly structured. It has two steps (S2 and S3) that do not have a transition between them.

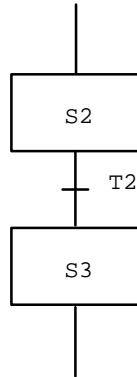


## Basic Control Structures

The following examples illustrate the six basic control structures that can be used in a sequential function chart.

### Simple Sequence

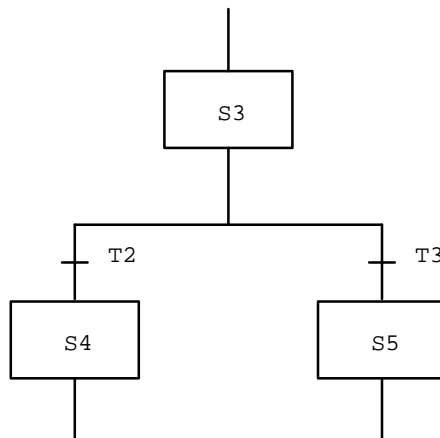
In a simple sequence, control passes from step S2 to step S3 **only if** step S2 is active and transition T2 evaluates true.



### Divergence of a Selective Sequence

*Divergence of a Selective Sequence* means that there is a choice of two or more paths down which control can be passed, but only one will be selected. In a divergent selective sequence, control passes from step S3 to step S4 **only if** step S3 is active and transition T2 evaluates true. Control passes from step S3 to step S5 **only if** step S3 is active, transition T2 is not true, and transition T3 is true (left-to-right priority of transition). Exactly one branch of the selective sequence is selected. A left-to-right priority is used to determine the action branch if more than one transition evaluates true at the same time.

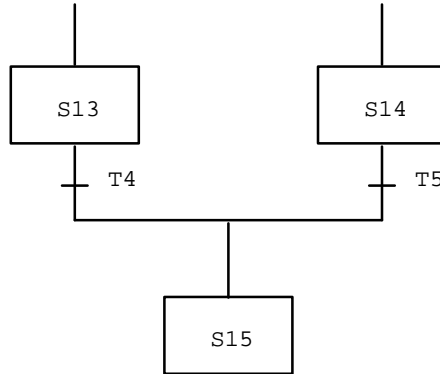
A selective divergence must be preceded by one step. The first element after a selective divergence must be a transition.



### Convergence of a Selective Sequence

A selective convergent branch can only be preceded by transitions. It must be followed by one step.

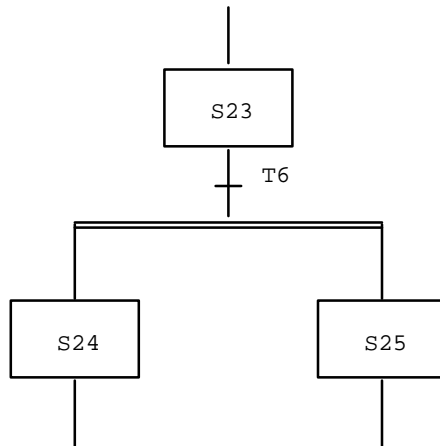
In a convergent selective sequence, control passes from step S13 to step S15 **only if** step S13 is active and transition T4 evaluates true. Control passes from step S14 to step S15 **only if** step S14 is active and transition T5 is true.



### Divergence of a Simultaneous Sequence

Like the divergence of a selective sequence, there is a choice of two or more paths down which control can be passed, but *unlike* the selective sequence, in a simultaneous divergent branch more than one step can become active. In a divergent simultaneous sequence, control passes from step S23 to step S24 and step S25 **only if** step S23 is active *and* transition T6 evaluates true. Both steps will become active, although the action logic contained in one step will be executed before the action logic in the other step. The order of which step is executed first is undefined.

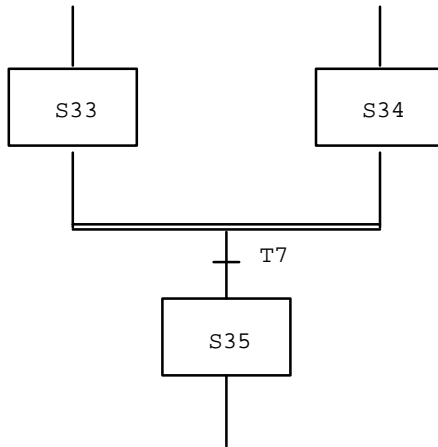
A simultaneous divergent branch must be preceded by one transition. A step must be the first element after a simultaneous branch.



### Convergence of a Simultaneous Sequence

A simultaneous convergent branch can only be preceded by step elements. It must be followed by one transition.

In a convergent simultaneous sequence, control passes from step S33 and step S34 to step S35 **only if** steps S33 and S34 are both active and transition T7 evaluates true.



The transition logic for T7 is only executed when all of the steps at the end of the simultaneous sequence are active.

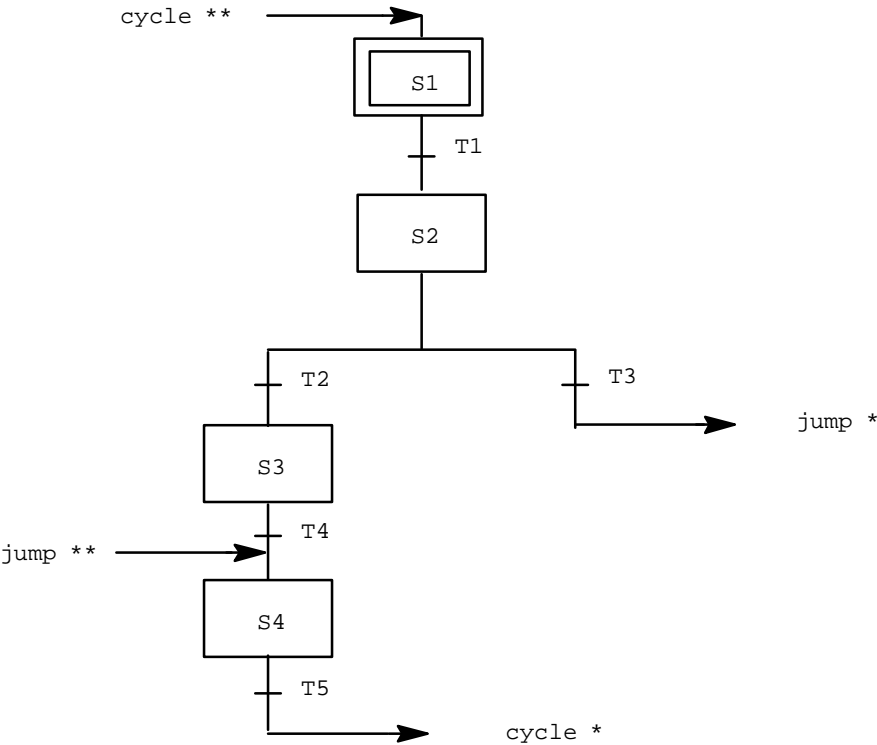
## Source and Destination Connectors

Source and destination connectors are used to create forward and backward jumps in a sequential function chart. The words **jump** and **cycle** denote connectors in the sequential function chart shown below. Backward jumps are called **cycles**

In the forward jump sequence shown below, control passes from step S2 to step S4 **only if** step S2 is active, transition T2 evaluates false, and transition T3 evaluates true.

In the backward jump (or cycle) sequence, control passes from step S4 to step S1 **only if** step S4 is active and transition T5 evaluates true.

Source and destination connectors cannot occur before a transition. Source connectors must occur immediately after the transition. Destination connectors must occur immediately before a step. Connectors cannot be used adjacent to a branch. Refer to appendix A, "Common User Errors," for other restrictions.

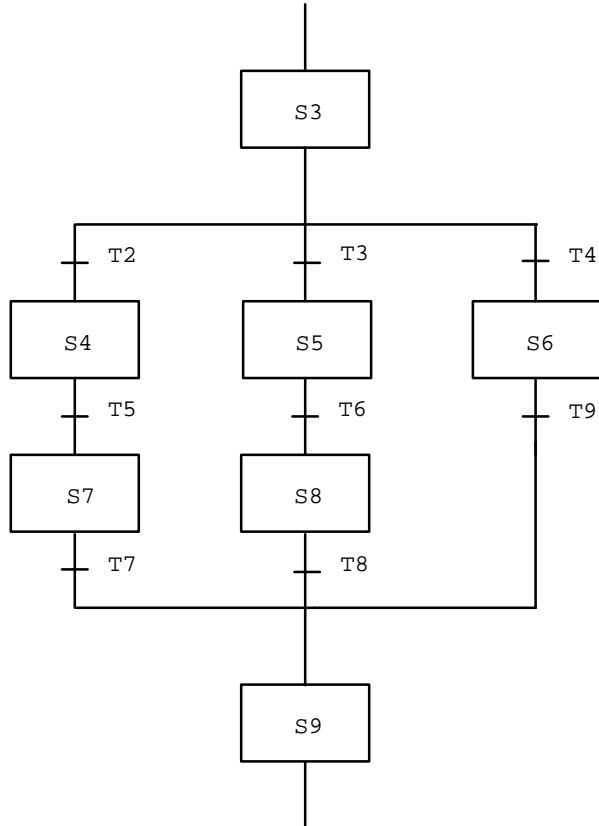


\* Denotes a source connector.  
\*\* Denotes a destination connector.



## Examples of Basic Control Structures

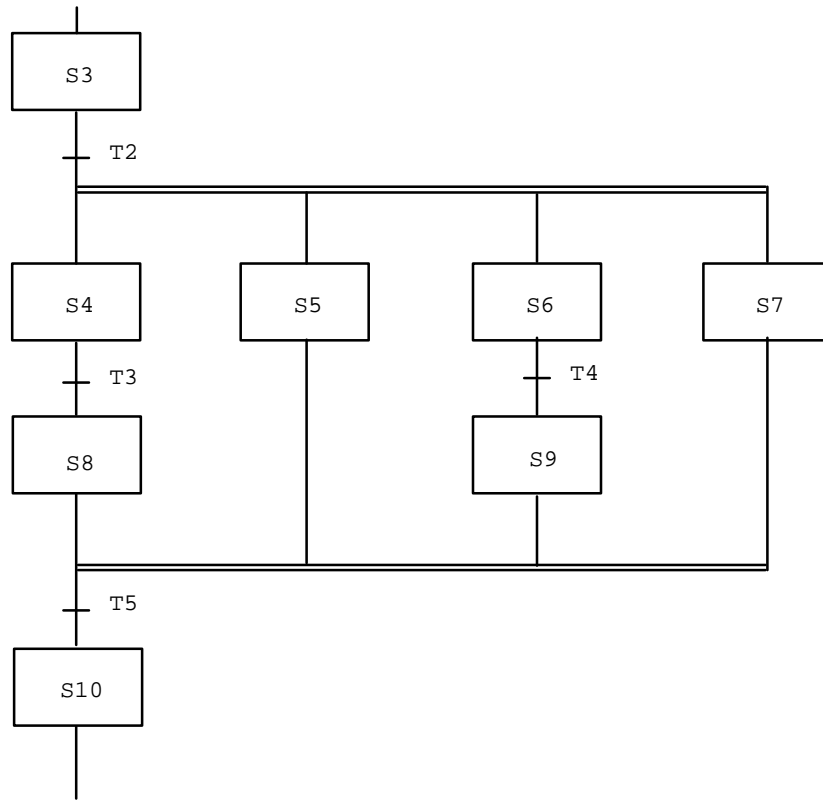
The following example shows a sequential function chart segment with a selective sequence.



After step S3 has been active for one evolution, the newly enabled transitions T2, T3, and T4 are evaluated. The enabled transition that evaluates true first determines which branch of the selective sequence is selected. If more than one transition evaluates true at the same time, the leftmost branch with a true transition condition is selected.

The following example shows a sequential function chart segment with a simultaneous sequence.

**Example of a Valid SFC Segment with Simultaneous Sequence:**



After step S3 has been active for one evolution, the newly enabled transition T2 is evaluated. When transition T2 evaluates true, step S3 becomes inactive, and steps S4, S5, S6, and S7 all become active. (All simultaneous branches are executed in parallel.) Transition T2 is disabled, and transitions T3 and T4 are enabled. When steps S8, S5, S9, and S7 are all active and transition T5 evaluates true, all simultaneous branches are terminated, and step S10 becomes active.

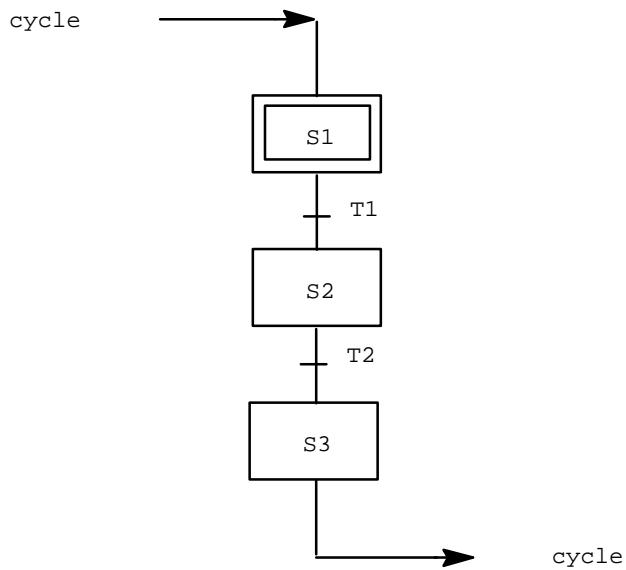
## Rules for Basic Control Structure

When constructing a sequential function chart, the following rules should be followed:

1. **Only one initial step may occur in the SFC graph. The initial step may not occur within a simultaneous structure.**
2. **Any two steps in sequence must be separated by a transition.**

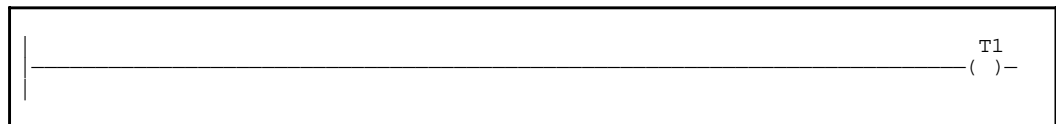
In the following *invalid* sequential function chart segment, a backwards jump (or cycle) directly connects two steps without an intervening transition.

### Example of an Invalid SFC Segment:

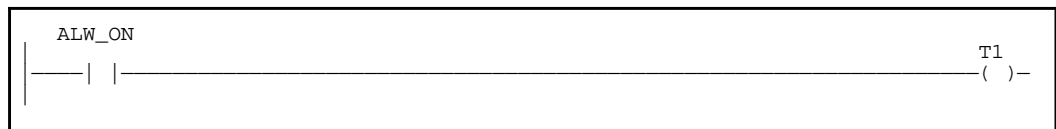


3. **Any two transitions in sequence must be separated by a step.**
4. **Each transition must contain *one and only one rung* of logic which, at a minimum, sets its transition variable.**  
For example, transition T1 must contain a rung similar to the rung shown below in order to set the transition variable T1.

For 90-70:



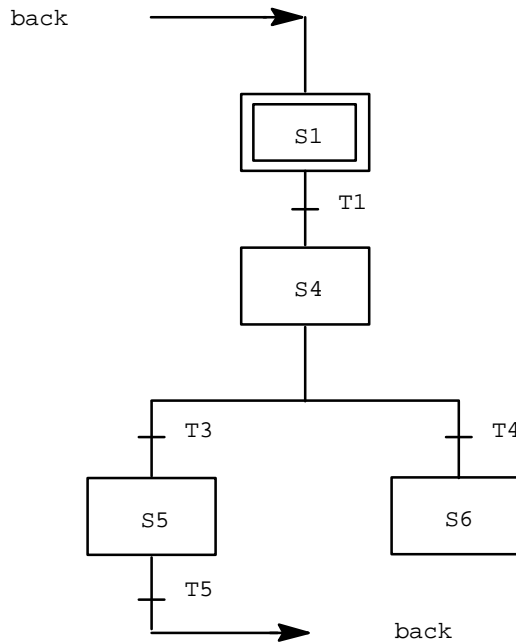
For 90-30:



- 5. **Terminal steps are allowed, except when they occur within a simultaneous sequence. A terminal step is one that is not followed by a transition. Once a terminal step is activated, it cannot be deactivated, except by an SFC\_RESET instruction.** (For more information on the SFC\_RESET function, see page 3-58.)

In the following **valid** sequential function chart segment, there is no transition after step S6. This would terminate the sequential function chart, and step S6 would continue to execute every evolution as long as the block is active and the chart is not reset.

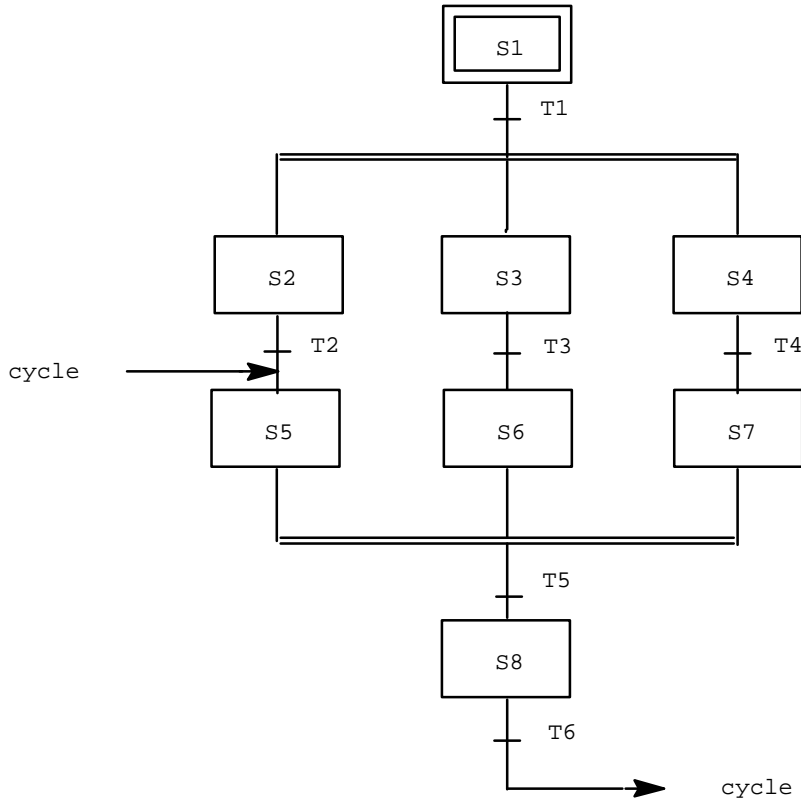
**Example of a Valid SFC Segment:**



- 6. A jump cannot jump into any branch of a simultaneous sequence.

In the following **invalid** sequential function chart segment, there is a jump into a simultaneous sequence. Logicmaster 90 software will indicate the program as non-executable and will prevent it from being stored in the Series 90-70 PLC.

**Example of an Invalid SFC Segment:**

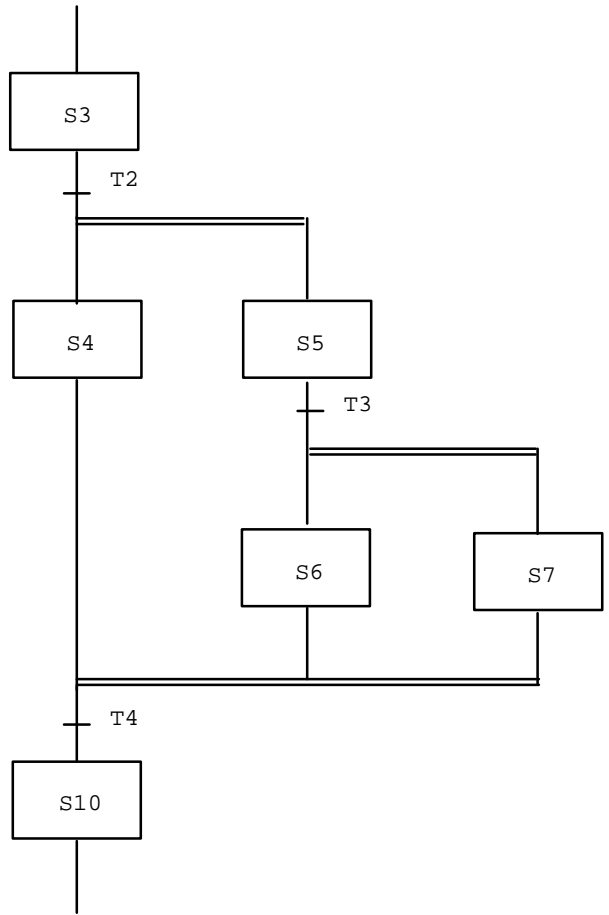


- 7. A jump cannot jump out of a branch within a simultaneous sequence.

- 8. Two divergent points of the same type of sequence (simultaneous or selective) may have a common convergent point. Similarly, one divergent point may have multiple convergent points.

The following portion of a **valid** sequential function chart segment illustrates a common point of convergence for two simultaneous sequences.

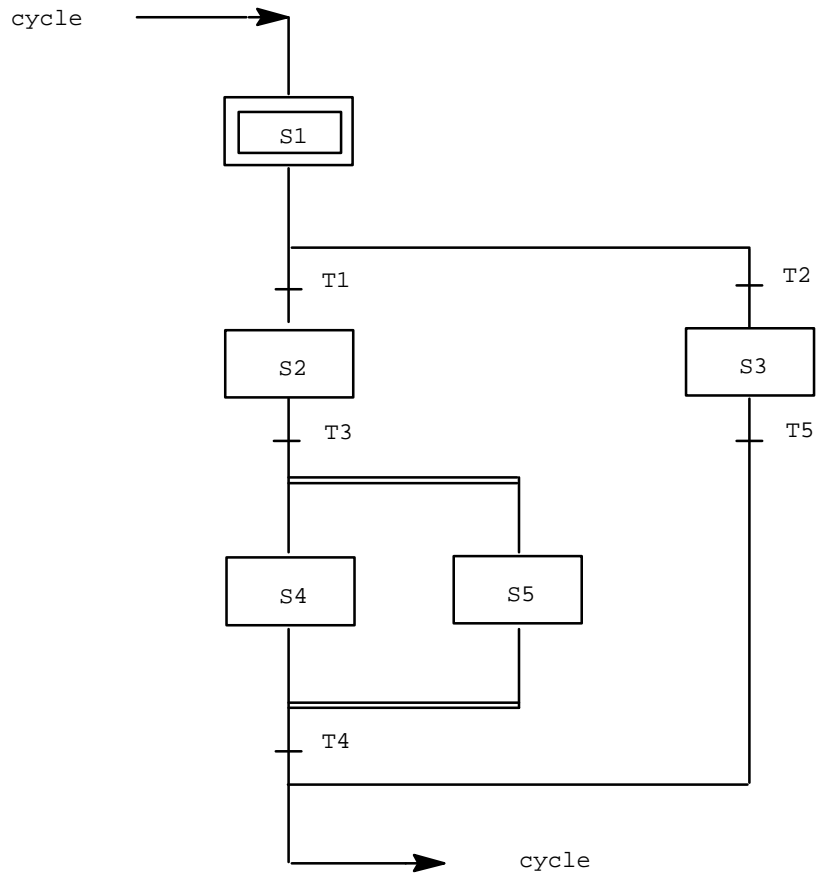
**Example of a Valid SFC Segment:  
(common point of convergence for two simultaneous sequences)**



- 9. The divergence and convergence of sequences must be properly nested. For example, if a simultaneous sequence diverges after a selective sequence diverges, it must converge before the selective sequence converges.

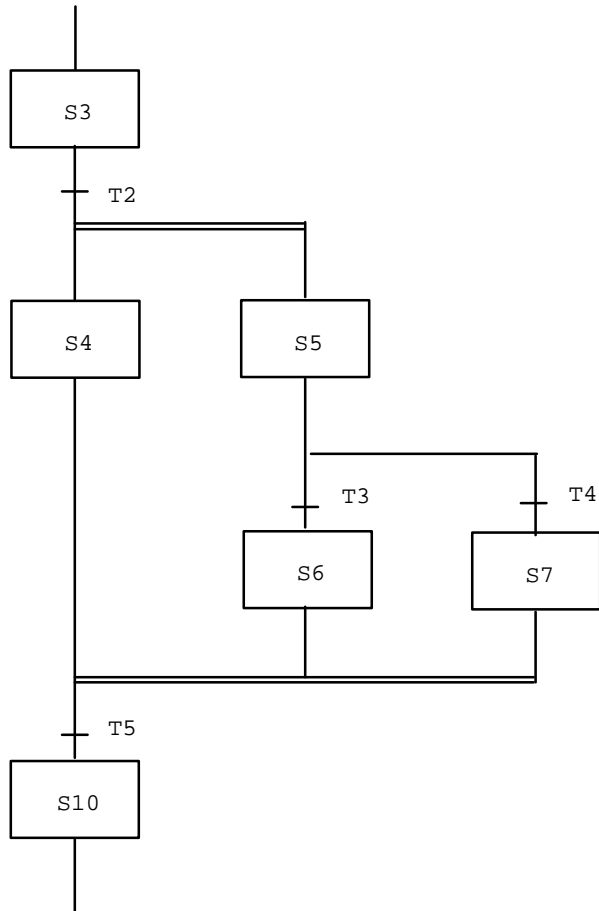
This **valid** sequential function chart segment illustrates proper nesting of dissimilar sequences.

**Example of a Valid SFC Segment:  
(proper nesting of dissimilar sequences)**



This **invalid** sequential function chart segment illustrates an improper nesting of two dissimilar sequences.

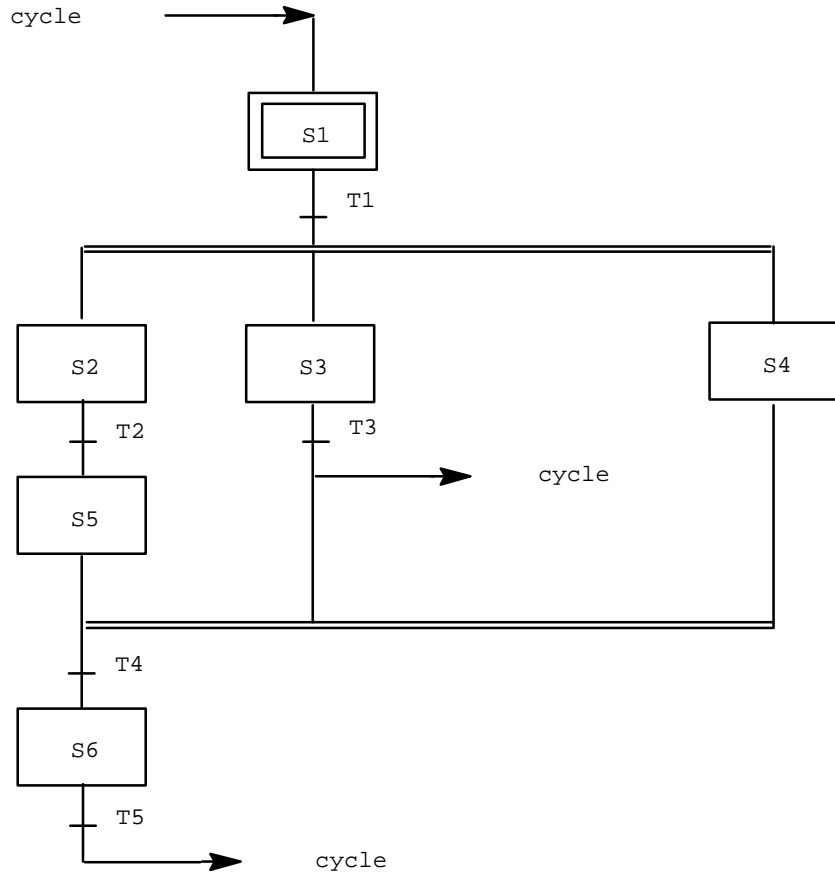
**Example of an Invalid SFC Segment:  
(improper nesting of dissimilar sequences)**





In the following **invalid** sequential function chart segment, there is a jump out of a simultaneous sequence, from step S3 to step S1.

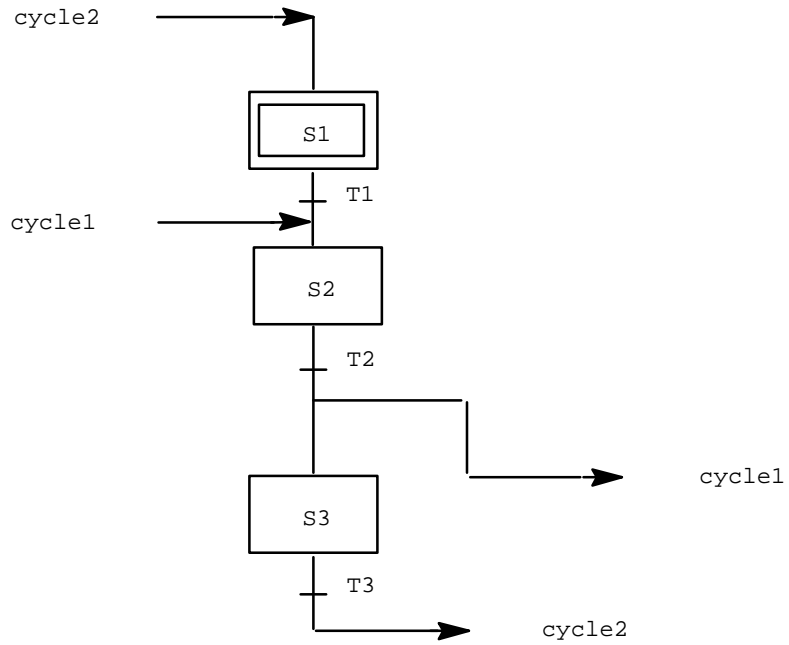
**Example of an Invalid SFC Segment:  
(jump out of sequence)**



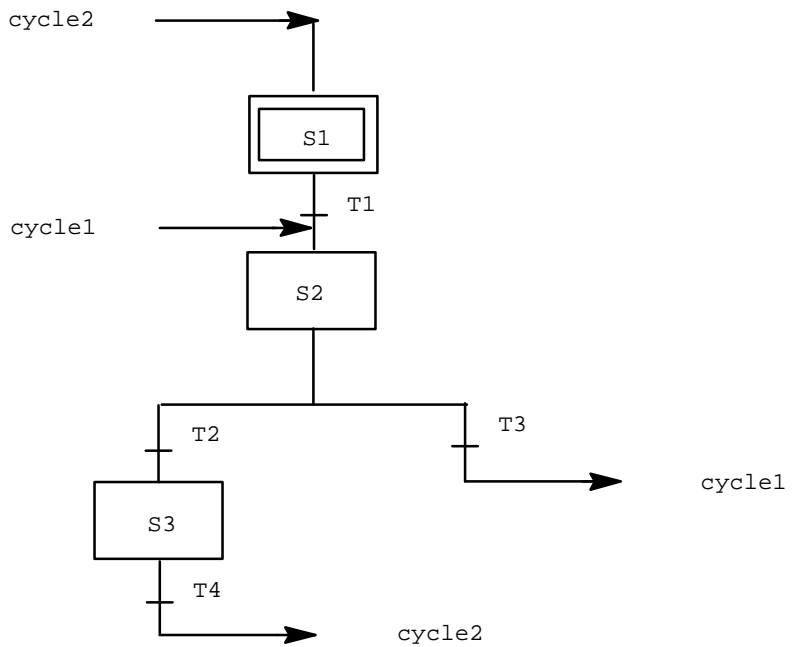
**Note**

When sequences do converge, they must do so in a properly nested manner. Selective structures can remain open, but simultaneous structures must be closed.

The following sequential function chart segment is **invalid** because, when step S2 is active and transition T2 evaluates true, both steps S2 and S3 become active simultaneously within a sequential sequence.



The example shown below incorporates a divergent selective sequence to make the SFC chart sequence **valid**.



# Chapter 3

## Sequential Function Chart Editor

The Sequential Function Chart Editor is used to create, modify, or monitor a program block written in sequential function chart (SFC) language.

This chapter contains the following sections:

Section	Title	Description	Page
1	SFC Program Blocks (See Note below for 90-30 considerations.)	Describes the structure of an SFC block, how to select the block's language, cursor movement within the block, and the functions available in the SFC Editor	3-2
2	Inserting/Editing an SFC Network	Describes how to create a new SFC network or modify an existing network. Also included is information on displaying errors in the network and storing changes to an SFC block.	3-11
3	Search Function	Describes how to search for an item within a block programmed in sequential function chart language.	3-46
4	Comments	Describes how to document actions associated with a particular step.	3-52
5	Options Related to SFC Blocks	Describes fault logging for out-of-limit step times and configuration of multiple languages.	3-53
6	Debug Functions	Describes how to force an SFC block to start from the initial step, force transitions, track the evolution of a block, and set minimum/maximum step execution times.	3-57
7	Program Utility Functions	Describes how to load a program from the PLC to the programmer, store a program to the PLC from the programmer, and verify a program with the PLC.	3-65

### Note

In the 90-30 version, there are no subroutine SFC blocks. That is to say, only the **\_MAIN** block is allowed to be SFC.

## Section 1: SFC Program Blocks

In order to program a block in sequential function chart language, SFC language must be selected at the time the block is created. Information on selecting a programming language begins on page 3-8.

In the 90-30 software, only the `_MAIN` block can be SFC. In Logicmaster 90-70, however, the logic of any program block, either a `_MAIN` block or a subordinate program block, may be programmed in sequential function chart (SFC) language. Parameterized subroutine blocks (PSBs) are an RLD subroutine block and, therefore, cannot be programmed using SFC language. PSB blocks may, however, be collected from the RLD logic of an SFC block.

A block programmed in sequential function chart language includes the sequential function chart itself and all the logic contained in each step's logic, each transition's logic, and the preprocessing and postprocessing logic. For the 90-70, an SFC block may contain a maximum of 255 steps, 383 transitions, and 255 unique connectors. For the 90-30, an SFC block may contain a maximum of 95 steps, 95 transitions, and 255 unique connectors. The size of a logic block is restricted to 16 kilobytes. For an SFC block, this includes the SFC topology and all associated actions and relay ladder diagram logic.

### Note

#### (Applicable to 90-70 only)

Because of the 16 kilobyte size restriction and network complexity limitations, it may not be possible to fit the logic for all the steps into a single block. You can avoid this problem by placing the logic for each step in a separate block and have the only logic associated with the step be a call to the block.

The following list summarizes the limits placed on a block programmed in sequential function chart language.

- 16 kilobytes of logic space
- An SFC network (There can be one and only one SFC network per block.)
- 255 steps for the 90-70; 95 steps for the 90-30
- 383 transitions for the 90-70; 95 transitions for the 90-30
- 255 unique connectors
- 32 simultaneous parallel branches
- 32 simultaneously active steps
- 64 calls
- SFC grid size of 128 rows by 8 columns

Every step, transition, and connector used within an SFC network must have a name. These names are placed in the block's variable declaration table and are known everywhere throughout the block, including the relay ladder diagram logic. The names cannot, however, be used outside the current block, even if it is the `_MAIN` block.

Even though they can be referenced throughout the SFC block, step and transition names may only be defined once per block. That is, a given step or transition may only occur once within an SFC network (and, as stated previously, there can be one and only one SFC network within a block).

Connectors may only occur within one SFC network within a block. Within an SFC network, there may be one occurrence of a given destination connector, but there can be multiple occurrences of the corresponding source connector.

## Step Timers

A time value, denoted as `step.t` (e.g., `S1.t`), is associated with every step. `Step.t` is an integer value which gives the number of units (ticks) of time, relative to the user-selected time base, that the step has been active. It can be used as a read-only parameter anywhere in the block on any RLD function operand requiring a single word of input.

When a step is activated, its step timer is reset to zero before starting to accumulate time. For information on setting minimum and maximum step times, refer to “Debug Functions” on page 3-57.

## Step Fault Bits

Although you are not required to have a minimum or maximum activation time, if you do, the following should be noted:

When a step does not attain its minimum activation time, or when it exceeds its maximum activation time, a fault bit, denoted as `step.f` (e.g., `S1.f`), is set. For example, the fault bit for step `S1` is `S1.f`. This fault bit may be referenced in RLD logic anywhere in the block, but cannot be changed because it is read only. It can be used on any contact instruction, but not with transitional contacts. The fault bit retains its fault status until the step becomes active again, at which time it is set false.

## Step Flags

A boolean step flag, denoted as `step.x` (e.g., `s1.x`), is also associated with every step. The step flag indicates the execution status of all action logic within the step. It may be referenced in the relay ladder diagram (RLD) logic anywhere in the block to determine if a given step is active or inactive. The step flag can be used on any non-transitional contact. However, the step flag may not be written to in user logic because it is read only.

### Note

`Step.t`, `step.f`, and `step.x` values are cleared when the current folder is stored and when an `SFC_RESET` function is executed.

## Format of an SFC Block

The general format of a **\_MAIN** block programmed in sequential function chart language is:

```
[  START OF SFC PROGRAM PRGNAME  ]
[      VARIABLE DECLARATIONS      ]
[      BLOCK DECLARATIONS         ]
[      INTERRUPTS                 ]
[      PREPROCESSING LOGIC        ]
[      POSTPROCESSING LOGIC       ] ← SFC Network goes here.
[      END OF PROGRAM             ]
```

## Subordinate SFC Block Format-90-70 Only

The general format of a subordinate program block programmed in SFC language is:

```
[  START OF SFC BLOCK BLKNAME  ]
[      VARIABLE DECLARATIONS      ]
[      PREPROCESSING LOGIC        ]
[      POSTPROCESSING LOGIC       ] ← SFC Network goes here.
[      END OF BLOCK              ]
```

### Note

Remember subordinate SFC program blocks are not available with the 90-30 software.

The [ **START OF PROGRAM** ], [ **VARIABLE DECLARATIONS** ], [ **BLOCK DECLARATIONS** ], [ **INTERRUPTS** ], and [ **END OF PROGRAM** ] markers are identical in function to those used in ladder diagram language. For more information on these markers, refer to the *Logicmaster 90 Programming Software User's Manual*.

Only the [ **PREPROCESSING LOGIC** ], and [ **POSTPROCESSING LOGIC** ] markers are unique to sequential function chart language. These markers are described in the following table.

---

Marker	Description
PreprocessingLogic	<p>Preprocessing logic is executed each time the program block is called, prior to the evolution of the sequential function charts. This logic is optional, but, if desired, it must be programmed in a terminal language, such as relay ladder diagram.</p> <p>Read-only access to the sequential function chart step flags is provided, as well as access to any reference nicknames declared in the variable declarations table. The amount of logic that can be programmed is limited only by the size of the program block.</p>
PostprocessingLogic	<p>Postprocessing logic functions the same as preprocessing logic, except that postprocessing logic is executed after the evolution of the sequential function charts, that is, after all action logic is executed but before the program block is exited.</p>

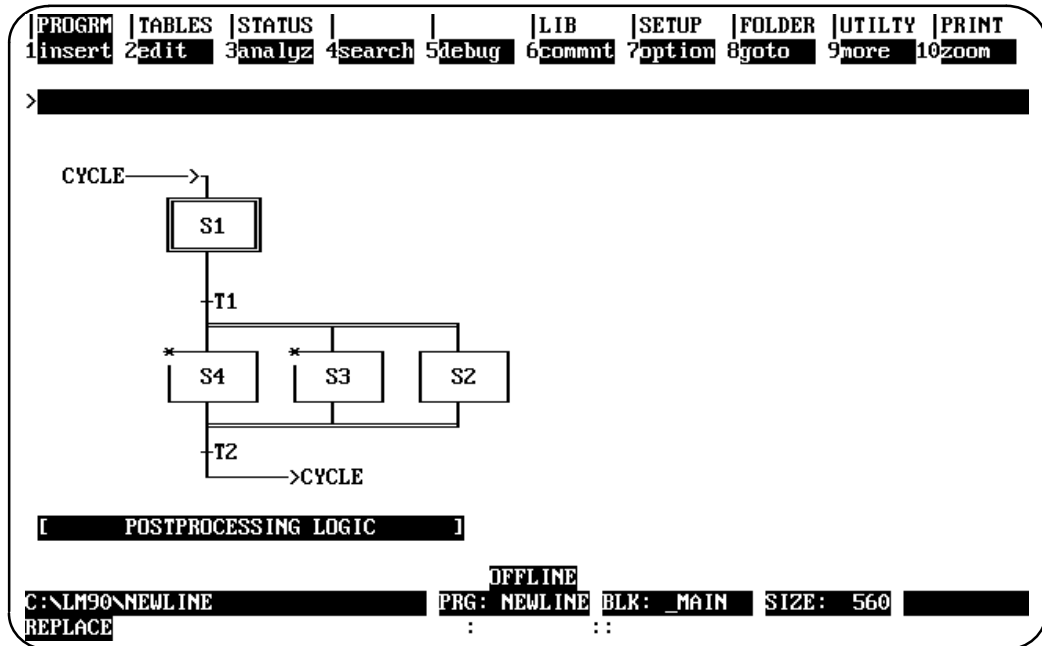
**Note**

The actual SFC logic in an SFC program block will occur after the preprocessing actions and before the postprocessing actions.

## Preprocessing and Postprocessing Logic

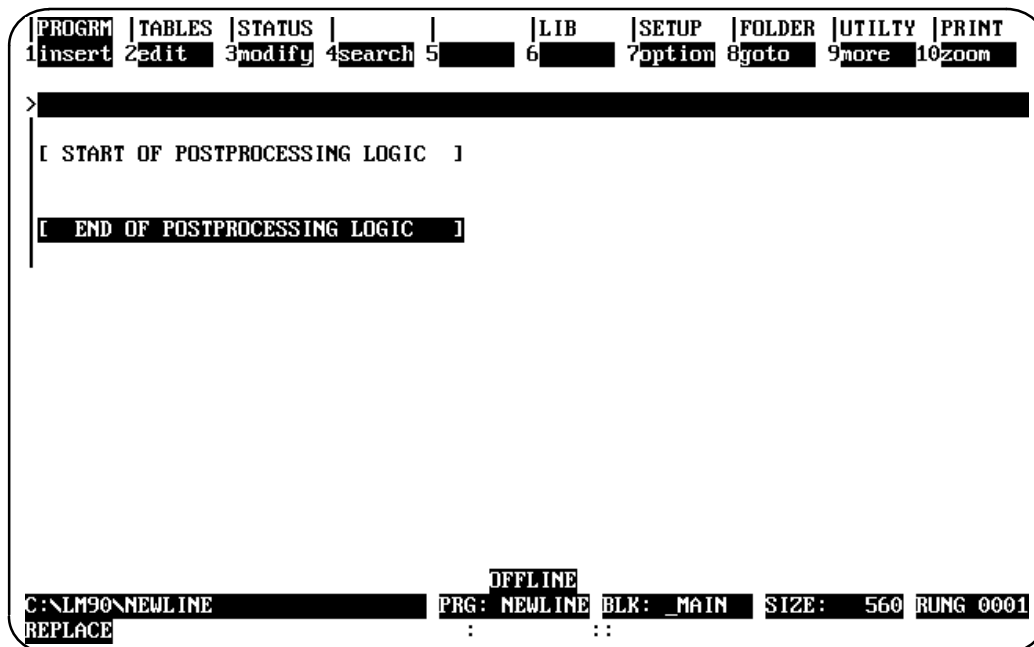
The sequential function chart block contains two marker rungs named [ PREPROCESSING LOGIC ] and [ POSTPROCESSING LOGIC ]. These marker rungs enable you to access the logic that precedes and follows each SFC evolution. To insert or edit this logic, you can move the cursor to the selected marker rung and press the **Zoom (F10)** softkey.

In the following example screen, the cursor is positioned on the [ POSTPROCESSING LOGIC ].





When you press the **Zoom (F10)** softkey, the following screen is displayed.



From this location, you can enter the ladder diagram logic that is executed after each evolution of the SFC block. The only limit to the amount of logic that can be entered is the logic space available in the block. As with preprocessing logic and the logic for steps, jumps and MCRs must be resolved within this segment of logic.

To return to the SFC block, press the **Escape** key.

### Programming SFC Step Action Logic

As first defined on page 2-3, *action logic* is the logic associated with a step, i.e., the logic, programmed by RLD logic language, that is executed when the step is active. Each step may have action logic, consisting of relay ladder diagram rungs, associated with it. The maximum size of the logic associated with an action is limited by the amount of program memory available. To display this ladder logic, position the cursor on the step and press the **Zoom (F10)** softkey.

Step action logic may be edited using the editing features of the Logicmaster software. For more information, 90-70 users should refer to chapter 3, “Program Editing,” in the *Logicmaster 90-70 Programming Software User’s Manual*, GFK-0263; or, for 90-30 users, refer to chapter 3, “Program Editing,” in the *Logicmaster 90-30 Programming Software User’s Manual*, GFK-0466.

Step action logic can also access other ladder diagram blocks or sequential function chart blocks using the relay ladder diagram CALL instruction. For more information on using the CALL instruction, 90-70 users should refer to the *Series 90-70 Programmable Controller Reference Manual*, GFK-0265; or, for 90-30 users, refer to *Series 90-30 Programmable Controller Reference Manual*, GFK-0467.

To exit from the action logic and return to step S1, press the **Escape** key.

### Selecting the Block's Language

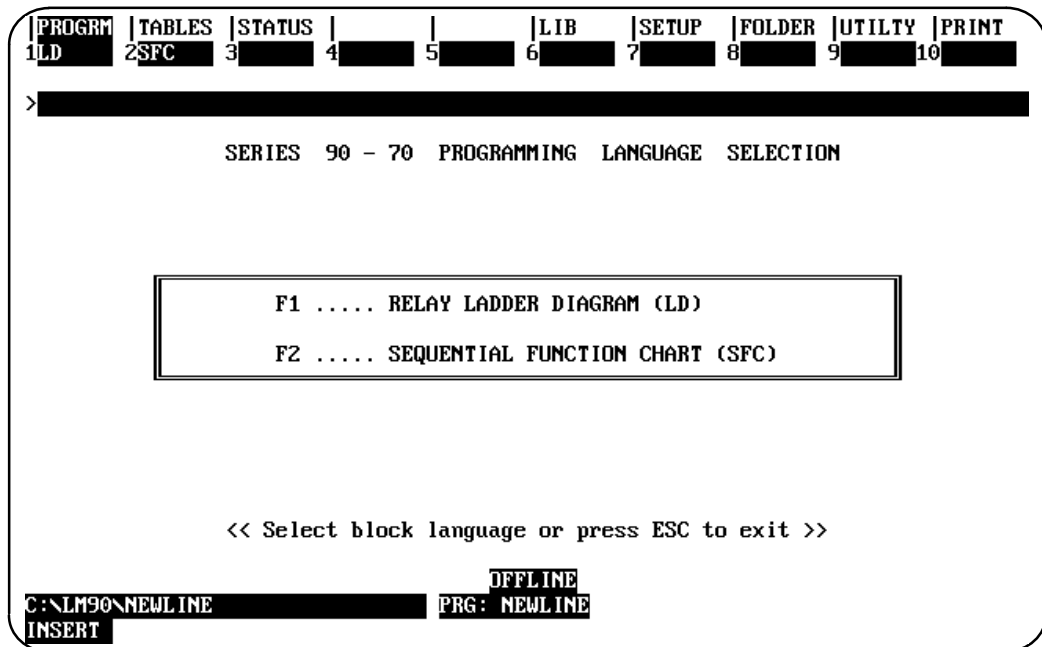
In the 90-70 software, any program block, including the **\_MAIN** block, may be programmed in SFC language. (In Logicmaster 90-30, only the **\_MAIN** block may be programmed in SFC language.) However, the logic for actions and transition conditions in an SFC block must be programmed in relay ladder diagram (RLD) language.

When you first enter a new folder ( **\_MAIN** ), the Logicmaster software will ask you to select a programming language. You may also select a language while creating program blocks in the program block declaration editor.

#### Note

Once a block's language has been selected, it cannot be changed. To change the language, you must delete the block declaration, and create a new block declaration with the desired language. To change the **\_MAIN** block's language, you must create a new folder with the desired language for **\_MAIN**.

When the **Program (F1)** softkey is pressed after creating a new folder, the Programming Language Selection screen, shown below, is displayed.



To select relay ladder diagram programming language, press **LD (F1)**. To select sequential function chart language, press **SFC (F2)**.

After pressing **SFC (F2)** to select sequential function chart language, the SFC block is displayed. The function keys displayed at the top of the screen are similar to the key selections displayed in the top level of the ladder diagram editor.

```
PROGRAM | TABLES | STATUS | | | LIB | SETUP | FOLDER | UTILITY | PRINT
1 insert 2 edit 3 analyz 4 search 5 debug 6 commnt 7 option 8 goto 9 more 10 zoom
>
[ START OF SFC PROGRAM NEWLINE ] (* *)
[ VARIABLE DECLARATIONS ]
[ BLOCK DECLARATIONS ]
[ INTERRUPTS ]
[ PREPROCESSING LOGIC ]
[ POSTPROCESSING LOGIC ]
OFFLINE
C:\LM90\NEWLINE PRG: NEWLINE BLK: _MAIN SIZE: 373
INSERT :
```

If you select an existing block, the language selection screen is not displayed. The Logicmaster software would directly display the top level SFC or RLD Editor. If the block were an SFC block, then the display would be as shown below. The cursor will appear in the first row and first column of the first SFC network. Note that the last entry in the right corner of the second line of the status information at the bottom of the screen identifies the current cursor location by row number, column number, and SFC network number. (For Release 5, the SFC network number will always be 1.)

```

PROGRAM | TABLES | STATUS |  |  | LIB | SETUP | FOLDER | UTILITY | PRINT
1insert 2edit 3analyz 4search 5debug 6commnt 7option 8goto 9more 10zoom
>
[ START OF SFC PROGRAM NEWLINE ] (* *)
[ VARIABLE DECLARATIONS ]
[ BLOCK DECLARATIONS ]
[ INTERRUPTS ]
[ PREPROCESSING LOGIC ]

OFFLINE
D:\LM90\NEWLINE PRG: NEWLINE BLK: _MAIN SIZE: 897 R001C1I1
REPLACE : ::
  
```

### Changing the Display Mode

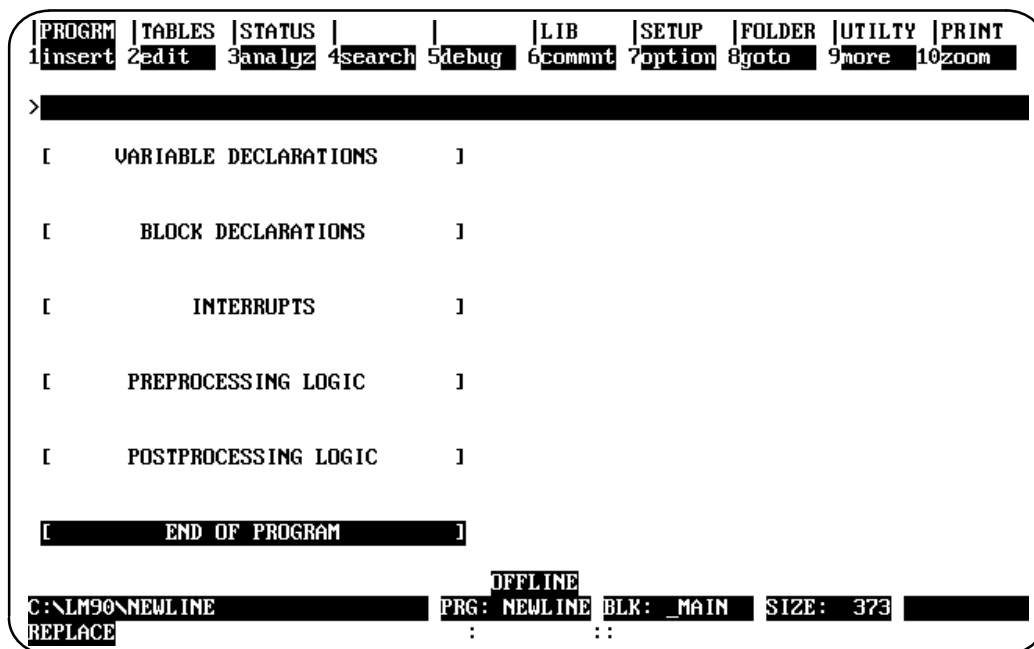
Two display modes allow you to view a sequential function chart. These display modes are **NORMAL** mode (the default mode) and **NUMBER** mode. Use the ALT-N key sequence to toggle these display modes.

Table 3-1. Display Modes

Mode	Description
Normal	In <b>NORMAL</b> mode, steps and transitions take three screen lines. User-defined step and transition names are used, rather than numbers. You can view, edit, and monitor SFC programs in <b>NORMAL</b> mode.
Number	<b>NUMBER</b> mode is very similar to <b>NORMAL</b> mode. The only difference is that system-supplied step and transition names, such as S1, S2, T1, and T2, are displayed rather than user-defined names.

## Section 2: Inserting/Editing an SFC Network Topology

The SFC Editor provides both an insert and an edit function. The insert function is used to create a new SFC network, while the edit function is used to modify an existing SFC network.



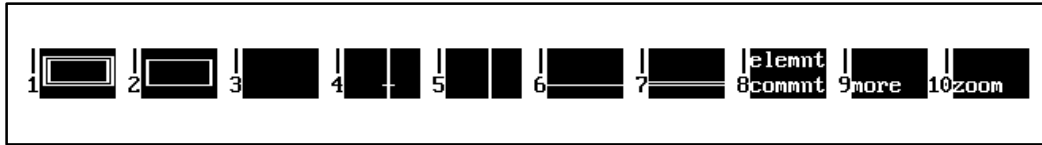
Function Key	Function	Description	See Page
F1	Insert	Create a new SFC network. The new network will be placed immediately before the cursor. In an empty SFC block, place the cursor on the [ POSTPROCESSING LOGIC ] marker, and press the <b>Insert (F1)</b> softkey. The new network will be placed before the [ POSTPROCESSING LOGIC ] marker.	3-13
F2	Edit	Modify an existing SFC network. Place the cursor on the network you want to change, and press the <b>Edit (F2)</b> softkey.	3-15
F3	Analyze	Determine what errors exist in the network, and check to verify that the block is executable. More information on the analyze function is provided at the end of this section.	3-44
F4	Search	Search for an element(s) in an SFC block.	3-46
F5	Debug	Access debug functions that will help you debug an SFC block.	3-57
F6	Comment	Associate detailed comments with steps in an SFC network.	3-52
F7	Option	Access the set-up of options that relate to programs containing SFC blocks.	3-53
F8	Goto	Move the cursor to the location of a specified SFC step, transition, or connector name in the SFC block.	3-61

Function Key	Function	Description	See Page
F9	More	Additional editor functions you can select.	
F10	Zoom	<p>Zoom into a variable declaration, a block declaration, or an interrupt declaration. For information on using the zoom function on these marker rungs, refer to the <i>Logicmaster 90 Programming Software User's Manual</i>.</p> <p>On the [ PREPROCESSING LOGIC ] or [ POST PROCESSING LOGIC ] marker, zoom enables you to zoom into the top-level relay ladder diagram editor, with preprocessing or postprocessing relay ladder diagram logic displayed.</p> <p>The zoom function can also be used on steps or transitions in an SFC network. When you zoom into a step, you can view and edit the action logic associated with that step. When you zoom into a transition, you can view and edit the logic associated with the transition.</p>	
<i>Pressing <b>More (F9)</b> displays these additional editor function key assignments:</i>			
F6	Delete	Cursor to the SFC network to be deleted and press the <b>Delete (F6)</b> softkey or <b>ALT-D</b> . Then, confirm the deletion. <b><u>Once deleted, the network cannot be restored.</u></b>	
F7	Renumber	Renumber every step and transition in an SFC block. Normally, step and transition numbers are assigned in the order in which the steps or transitions are created. Automatic names generated for steps and transitions are based on the step and transition numbers. Renumbering the steps and transitions will cause numbers to be assigned in an order dependent solely on the SFC topology.	3-18
F9	More	Additional editor functions you can select.	
F10	Zoom	See description of <b>Zoom (F10)</b> above.	

**ALT-A** can be used to abort a function in the SFC Editor. Once the abort request is confirmed, it will restore the disk version of the current block, and all editing done since the last store of the program block will be lost.

**ALT-D** can be used to delete an SFC network. It functions similar to the **F6** softkey described above.

When **Insert (F1)** or **Edit (F2)** is pressed, the following softkey assignments are displayed:



Function Key	Function	Mnemonic	Description	See Page
F1	Initial Step	&istep	Press <b>F1</b> to enter an initial step in an SFC network. There can be one and only one initial step in the SFC network.	2-3
F2	Regular Step	&step	Press <b>F2</b> to enter a regular step in an SFC network. A regular step is a step which must be programmed using action logic in written relay ladder diagram logic.	2-3
F4	Transition	&trans	Press <b>F4</b> to enter a transition in an SFC network.	2-4
F5	Vertical Link	&verlnk	Press <b>F5</b> to enter a vertical link	
F6	Selective Sequence	&selbrch	Press <b>F6</b> to enter a selective sequence.	2-10
F7	Simultaneous Sequence	&simbrch	Press <b>F7</b> to enter a simultaneous (parallel) sequence.	2-11
F8	Comment	&commnt	Press <b>F8</b> to enter a comment. Comments can only be placed on step instructions.	3-52
F9	More		Press <b>F9</b> to display additional SFC elements or options you can select.	
F10	Zoom		Press <b>F10</b> to zoom into a step or transition. When you zoom into a step, you can view the action logic associated with that step. When you zoom into a transition, you can view the logic associated with that transition.	

When **More (F9)** is pressed, these additional softkey assignments are displayed:



Function Key	Function	Mnemonic	Description	See Page
<i>Pressing <b>More (F9)</b> displays these additional elements:</i>				
F1	Destination Connector	&dstcnct	Press <b>F1</b> to enter a destination connector. You must enter a name for the destination connector before the cursor can be moved.	2-13
F2	Source Connector	&srcnct	Press <b>F2</b> to enter a source connector. You must enter a name for the source connector before the cursor can be moved.	2-13
F3	Open Row		Press <b>F3</b> to add two rows immediately above the cursor location.	3-36
F4	Open Column		Press <b>F4</b> to add a column at the cursor position.	3-38
F5	EraseElement		Press <b>F5</b> (or <b>ALT-D</b> ) to remove branch elements or erase a step, transition, or connector element.	3-35
F6	Delete Row		Press <b>F6</b> to delete the current row at the cursor location and the next row.	3-40
F7	Delete Column		Delete <b>F7</b> to delete the column at the cursorposition.	3-42
F8	Analyze Network		Press <b>F8</b> to check the topology, display a message about the first error encountered, and position the cursor on that error.	3-44
F9	More		Press <b>F9</b> to return to the first level of SFC elements.	
F10	Zoom		Press <b>F10</b> to zoom into a step or transition. When you zoom into a step, you can view the action logic associated with that step. When you zoom into a transition, you can view the logic associated with that transition.	



## Grid Organization

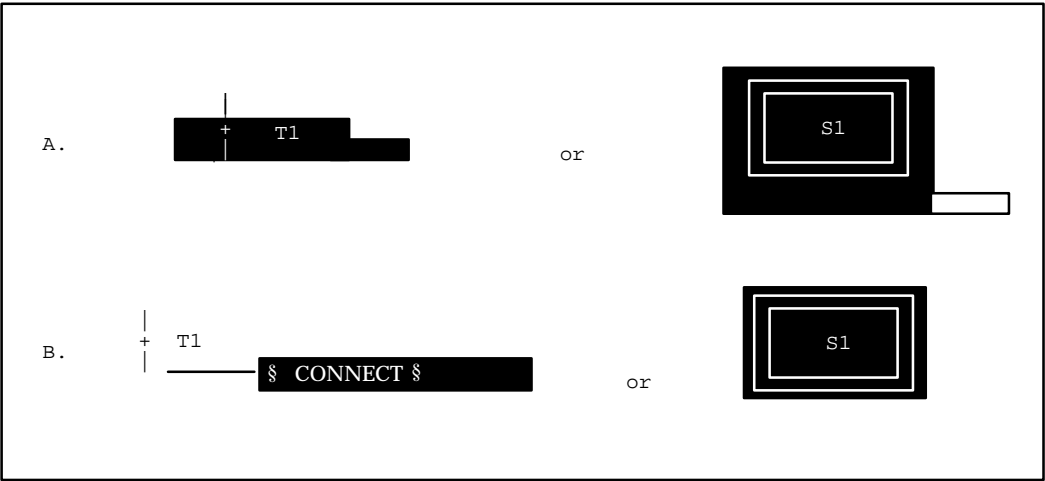
Each SFC network may contain up to 128 element rows and 8 element columns. When the status area is displayed on the screen, only 6 rows by 8 columns of the network can be displayed; without the status area, an additional row can be displayed. The status line may be toggled off by pressing **ALT-E**.

Odd-numbered rows are designated as transition rows, and even-numbered rows are designated as step rows. The Logicmaster software automatically applies the element you select to the correct row.

Transition rows may contain transitions, branch, connector, and vertical link elements. Step rows may contain the two types of step elements and vertical link elements. A single position in a transition row may contain a transition, with a branch element on the top line of the row, and another branch element on the bottom line of the row.

### Shape of the Cursor

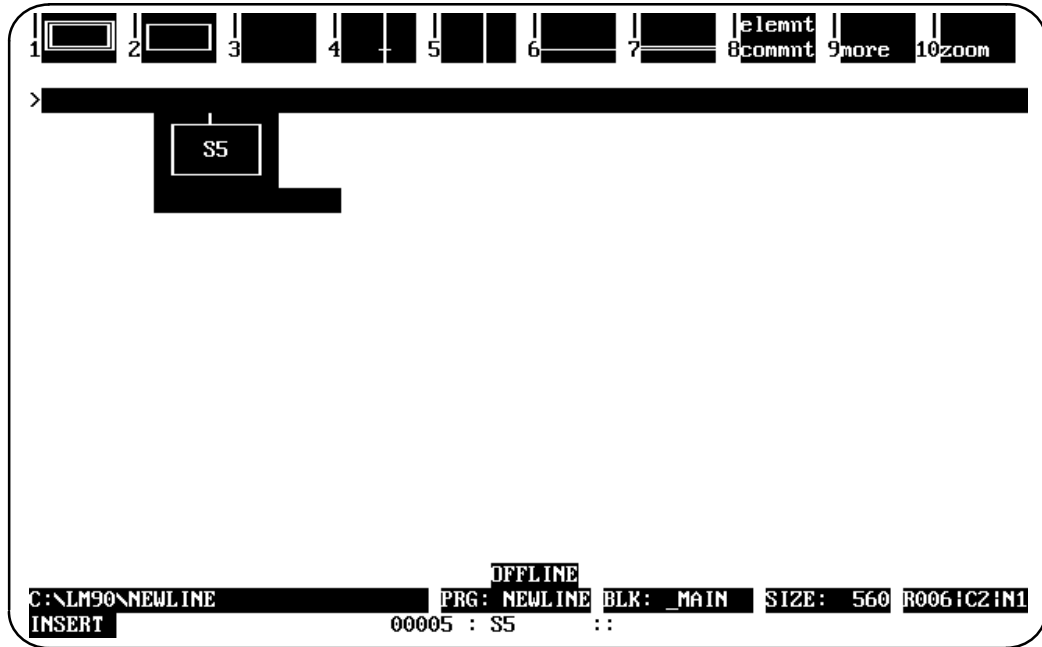
The shape of the cursor in **INSERT** or **EDIT** mode changes, depending on whether the cursor is on a step or transition row. Two cursor shapes are provided on step and transition rows, as shown below.



Cursor A is used to indicate where a branch element would be inserted. Cursor B is used on connector elements, branch elements, and also on transitions when a branch element already exists below the transition or step.

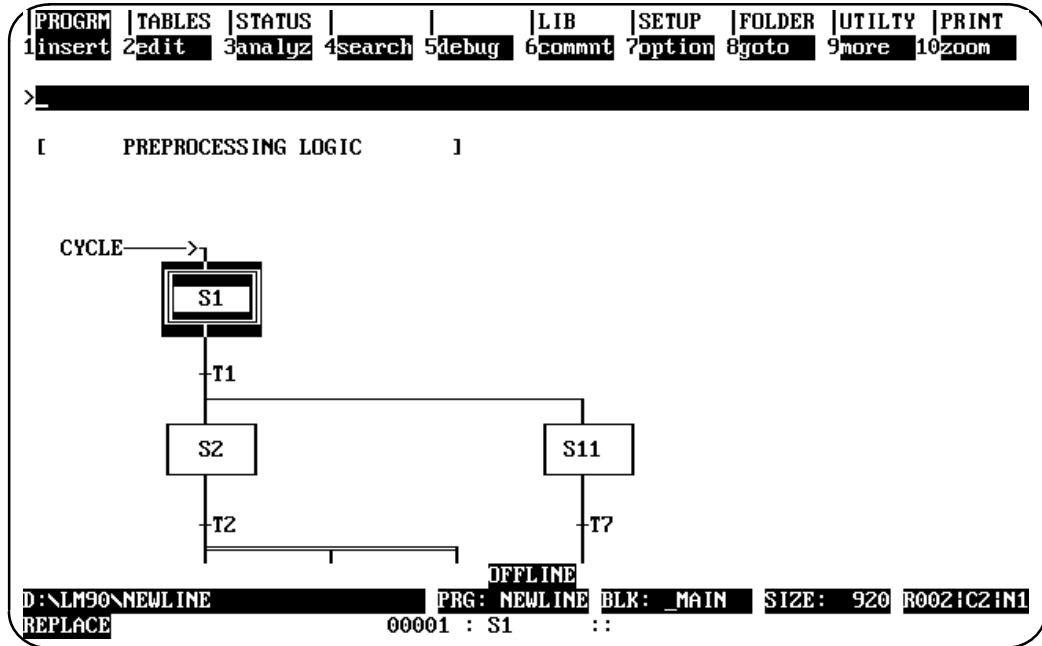
At a transition row location, you can add a transition or a branch element. From cursor A, the branch is added at the position indicated by the longer lower segment of the cursor.

The step row cursor is shown below:



The longer lower cursor line of cursor A indicates where a branch would be inserted. Start-of-selective branches and end-of-simultaneous branches are entered from the step row. End-of-selective branches and start-of-simultaneous branches are entered from the transition row.

When a branch element exists below a step, step cursor B is displayed, as shown in the following screen. The branch element would have its own cursor, as previously described.



### Moving the Cursor

The following cursor keys are available in the top-level SFC Editor:

Keys	Name	Description
[↑] and [↓]	Up and Down cursor keys	Move one row up or down, respectively, within the sequential function chart. Scrolling will occur at the display boundaries.  If on the top row of the SFC network, the cursor will move onto the preprocessing logic marker rung.  If on the bottom row of the SFC network, the cursor will move onto the postprocessing logic marker rung.
[←] and [→]	Left and Right cursor keys	Move one column left or right, respectively, within the sequential function chart. Movement beyond the left or right side of the 8-column area will result in a wrap to the next highest or lowest row, respectively, with the cursor positioned at the opposite side.
[CTRL][↑] [CTRL][↓] [CTRL][←] [CTRL][→]	CTRL-Cursor key	Move to the first or last row of the SFC network, maintaining column position. Or, move to the first or last column of the SFC network, maintaining row position. (These keys are for <b>INSERT</b> and <b>EDIT</b> mode only.)
[PgUp] and [PgDn]	Page Up and Page Down keys	Move six rows at a time up or down, respectively. The cursor is always positioned in column 1 of the row being moved to.
[Home]	Home key	Place the cursor on the start of the program/block marker.
[End]	End key	Place the cursor on the end of the program/block marker.

## Naming Steps, Transitions, and Connectors

System names S1 through S9999 are reserved in an SFC block to be used as step names. Similarly, transition names T1 through T9999 are reserved for transitions, and connector names C1 through C9999 are reserved for connectors. You cannot use these names as reference nicknames, label names, or program block names. These names (S1–S9999, T1–T9999, and C1–C9999) are system-assigned, and should not be confused with the user-assigned names discussed in the last paragraph on this page.

Step and transition numbers are assigned in the order in which the steps or transitions are created. Automatic names generated for these steps and transitions are based on the step and transition numbers. However, you can renumber every step and transition in an SFC block by pressing **More** (F9) and then **Renumber** (F7) in the SFC Editor. Renumbering the steps and transitions will cause numbers to be assigned in an order dependent solely on the SFC topology.

To create an alternative to the system-assigned name, enter the desired name on the command line with the cursor positioned on the step or transition, and press the **Enter** key. The name must follow the rules for Logicmaster 90 identifiers. (For more information on identifiers pertaining to the 90-70 version, refer to chapter 3, section 5, “Variable Declaration Table,” in the *Logicmaster 90-70 Programming Software User’s Manual*, GFK-0263. For more information on identifiers pertaining to the 90-30 version, refer to chapter 3, section 5, “Variable Declaration Table,” in the *Logicmaster 90-30 Programming Software User’s Manual*, GFK-0466.)

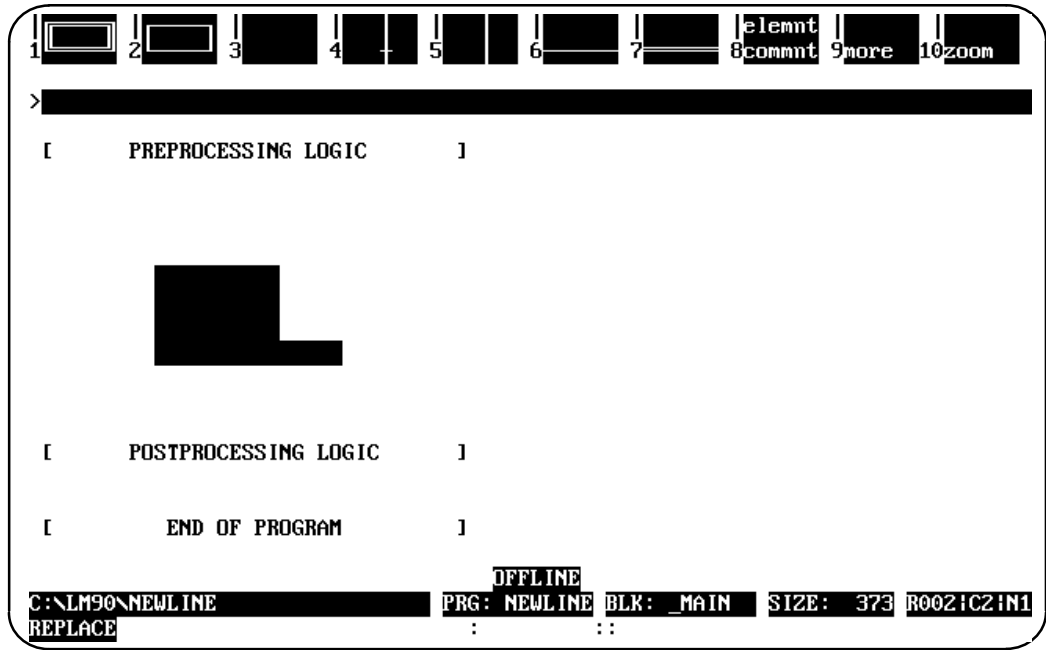
## Inserting/Editing an Example SFC Network

This example takes you step-by-step through the process of editing an SFC network.

1. Enter a new folder, and select SFC language. The following screen will be displayed:

```
|PROGRAM |TABLES |STATUS | | |LIB |SETUP |FOLDER |UTILITY |PRINT
1insert 2edit 3analyz 4search 5debug 6commnt 7option 8goto 9more 10zoom
>_
[ START OF SFC PROGRAM NEWLINE ] (* *)
[ VARIABLE DECLARATIONS ]
[ BLOCK DECLARATIONS ]
[ INTERRUPTS ]
[ PREPROCESSING LOGIC ]
[ POSTPROCESSING LOGIC ]
OFFLINE
D:\LM90\NEWLINE PRG: NEWLINE BLK: _MAIN SIZE: 479
REPLACE :
```

- 2. Press **Insert (F1)** to create a new SFC network, or press **Edit (F2)** to edit an existing SFC network. When **Insert (F1)** is pressed, the following screen is displayed.



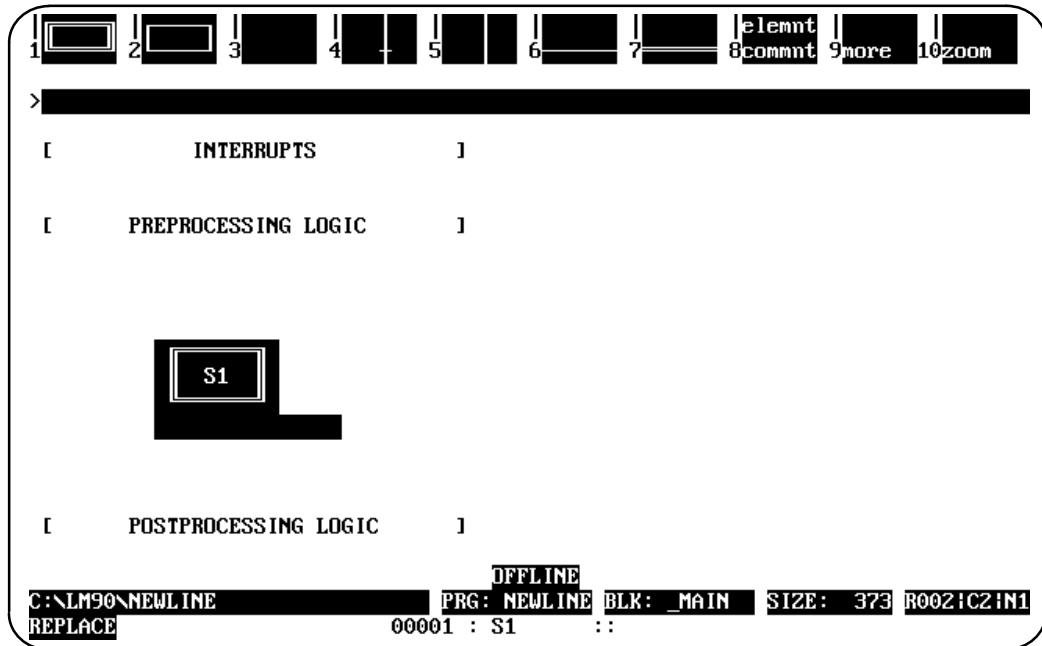
The function keys display the basic SFC elements. You can also enter one of these SFC elements by entering its mnemonic on the command line.

Table 3-2. SFC Mnemonics

Mnemonic	Name
&istep	Initialstep.
&step	Regularstep.
&trans	Transition.
&verlnk	Verticallink
&selbrch	Selectivelink.
&simbrch	Simultaneouslink.
&srcnet	Source connector.
&dstcnet	Destinationconnector.

Odd-numbered rows (e.g., first, third, fifth, etc.) on an SFC network are transition rows. Even-numbered rows (e.g., second, fourth, sixth, etc.) are step rows. The current position of the cursor is listed in the status line on the previous screen as row 2, column 2. This indicates that a step element can be entered at this location. If a transition is entered, the Logicmaster 90 software would attempt to enter the element on row 3 below the current cursor position because transitions are only entered on odd-numbered rows. The cursor would advance to the next row even if your attempt to enter the transition failed.

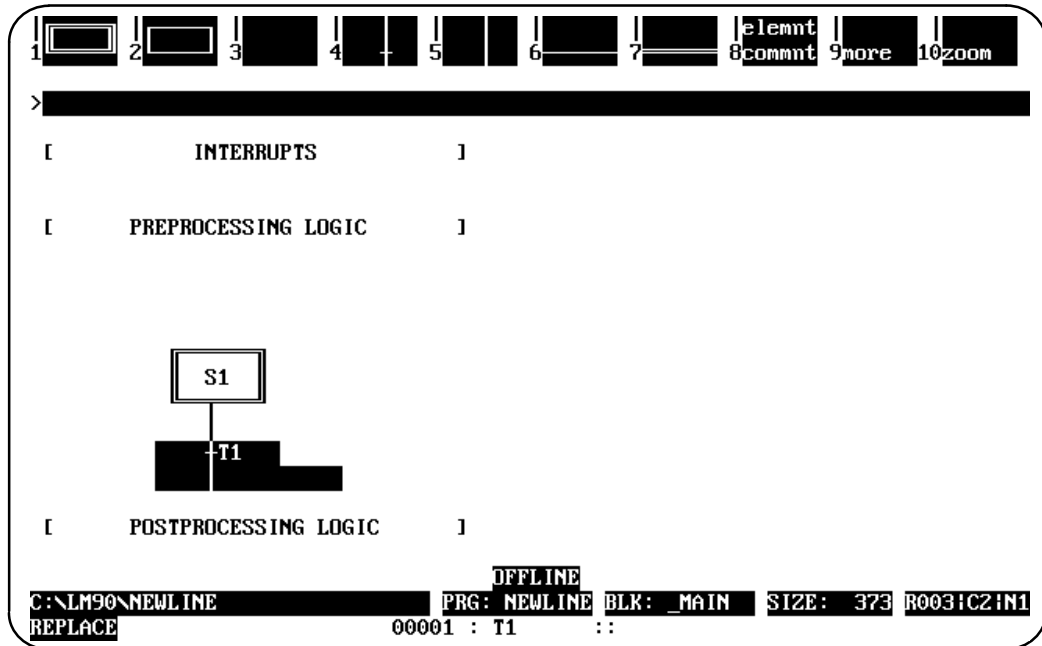
- 3. Press the F1 softkey to enter an initial step.



The default step name S1 is automatically entered by the Logicmaster software.

If you enter another name on the command line, the software will check to see if the name is available and apply it instead of the default name S1. (For more information on naming steps, see page 3-18.)

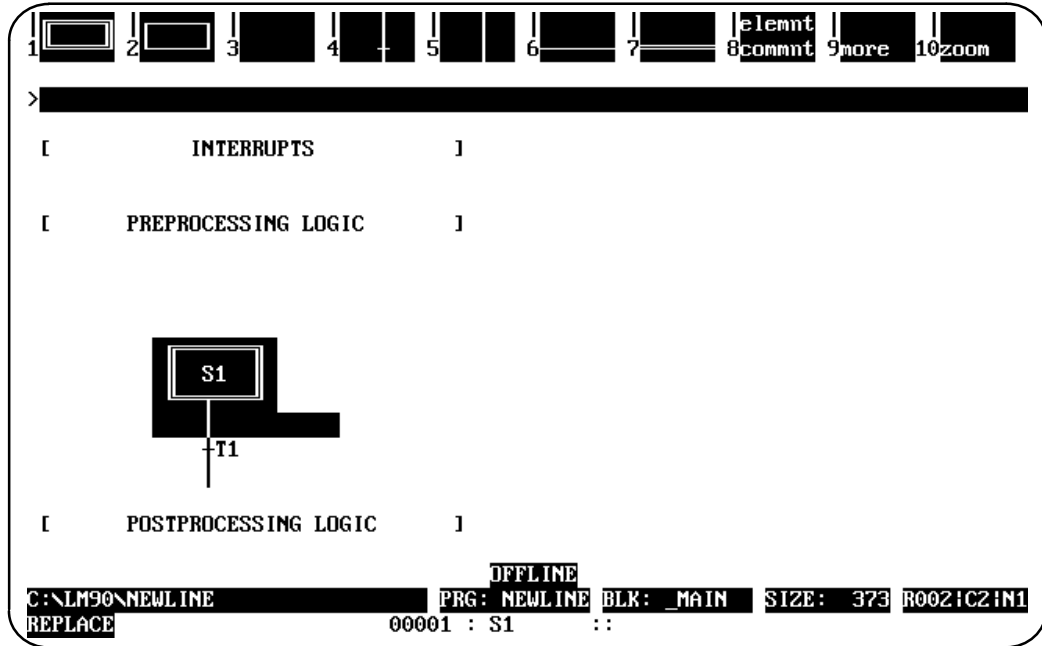
- 4. After entering the initial step, continue creating the SFC network, or press the **Zoom (F10)** softkey to program the step. (A valid SFC network must have one initial step.)
- 5. After the step is entered in the SFC network, the cursor remains on the element. You can enter a different type of step, zoom into the step, delete the step, enter a transition, or enter a branch element. If you enter a transition by pressing the **F4** softkey, the transition is entered, and the cursor is automatically advanced, as shown below.



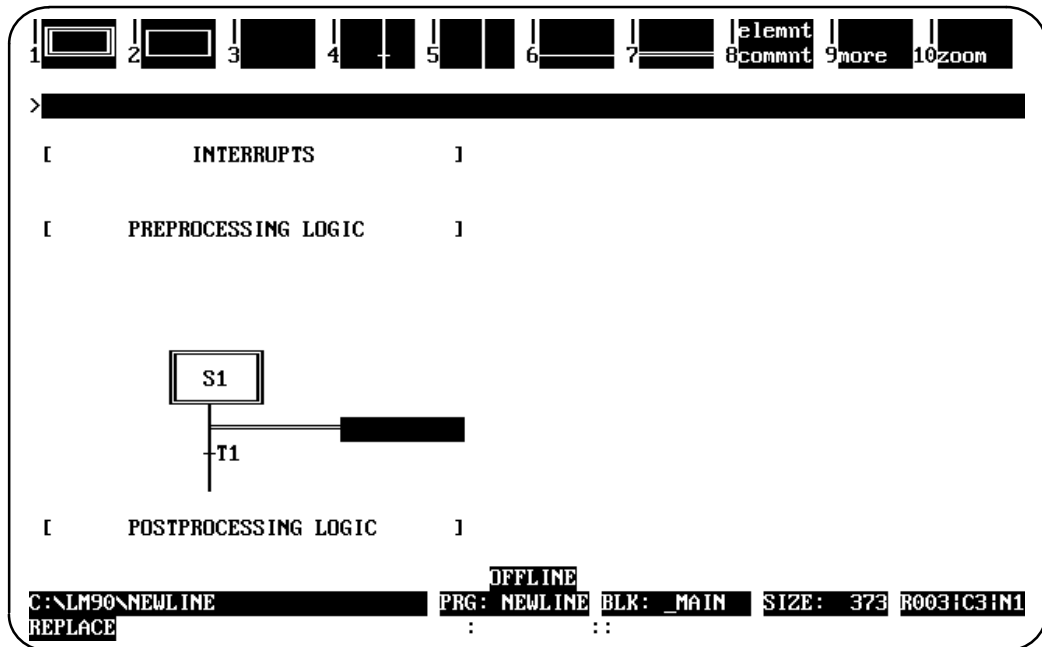
The transition is also assigned a name by the Logicmaster software. (For more information on naming transitions, see page 3-18.)



- 6. The location of the bottom leg on the “L” of the L-shaped cursor indicates where a branch instruction would be placed if entered at this location. If you move the cursor up at this location, the following screen is displayed.

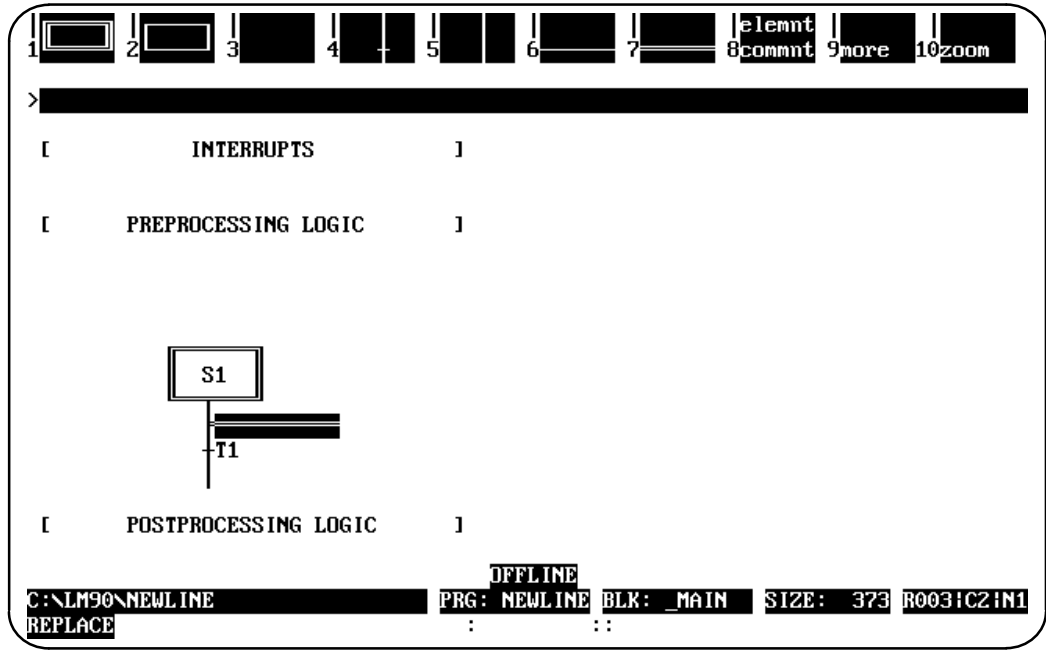


If you enter a simultaneous branch at this location by pressing the F7 softkey, the following screen will be displayed.



Note that the cursor has automatically advanced to allow you to extend the branch with the next branch keystroke.

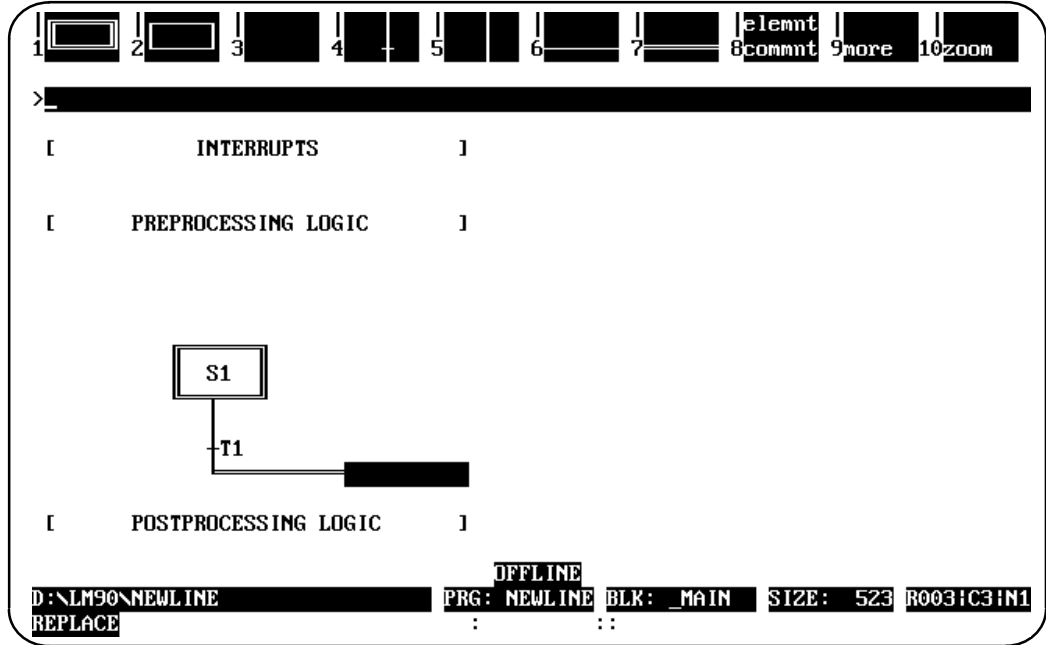
- 7. To move the branch below the transition T1 and remove the branch just entered, position the cursor on the leftmost portion of the branch. Then, press the selective link or simultaneous link softkey that corresponds to the branch to be deleted. (Or, you may press ALT-D.) The branch softkeys act as toggle keys, either inserting or deleting a branch.



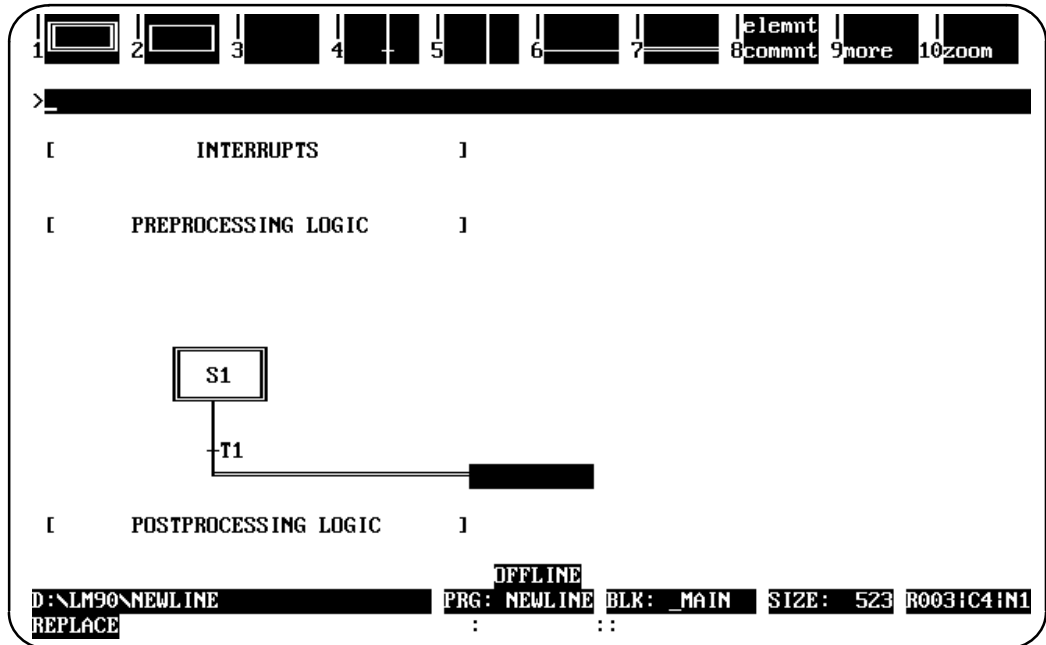
### Note

The Erase Element function (press **More**, **F9**, to display this key) or **ALT-D** can also be used to remove any SFC element. For more information about deleting an element, see page 3-35.

- 8. To complete moving the branch below the transition T1, cursor down to the transition row and press **Simultaneous Branch (F7)**. The cursor automatically advances to the right.



- 9. To continue the branch, press the **Simultaneous Branch (F7)** softkey.

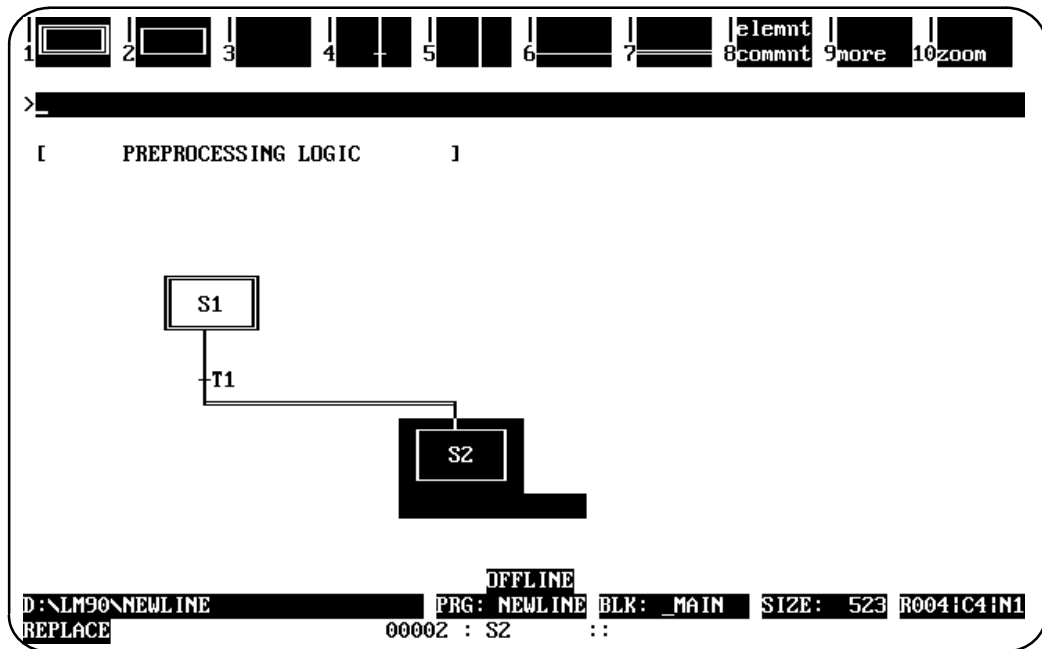


You are now ready to begin programming the three simultaneous paths that have been created.

### Note

You do not have to enter all the logic in a top-down entry order. You can cursor down and develop some logic that would follow the convergence of this branch, for example, and then connect the logic after completing the simultaneous logic.

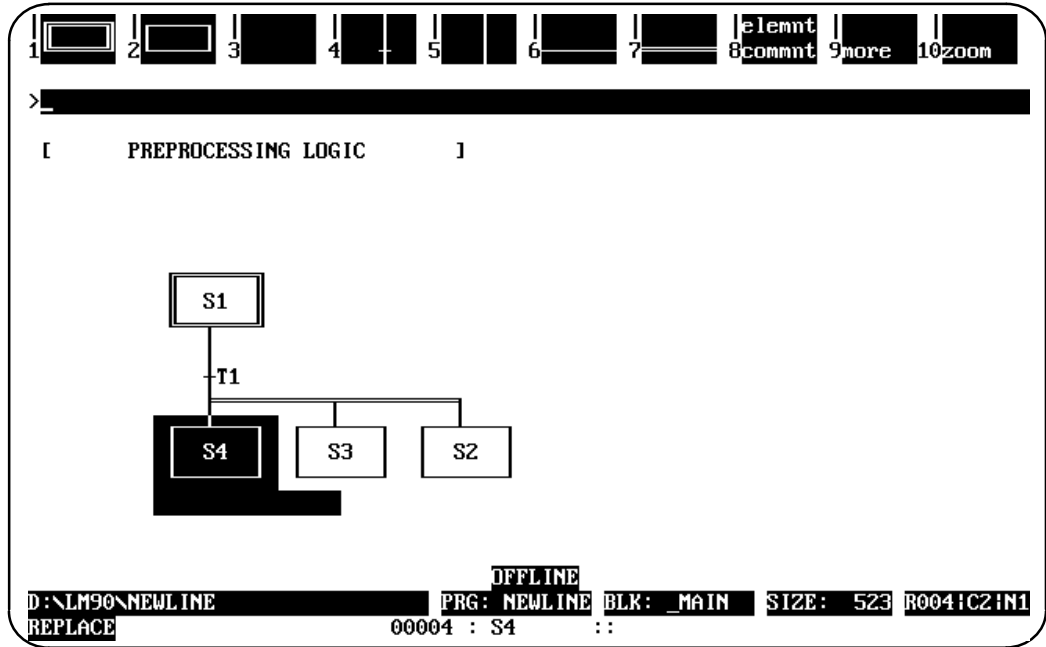
10. Press the **Step (F2)** softkey to add a step below the branch connector. This new step is positioned in the rightmost branch path contained within the cursor on the next screen.



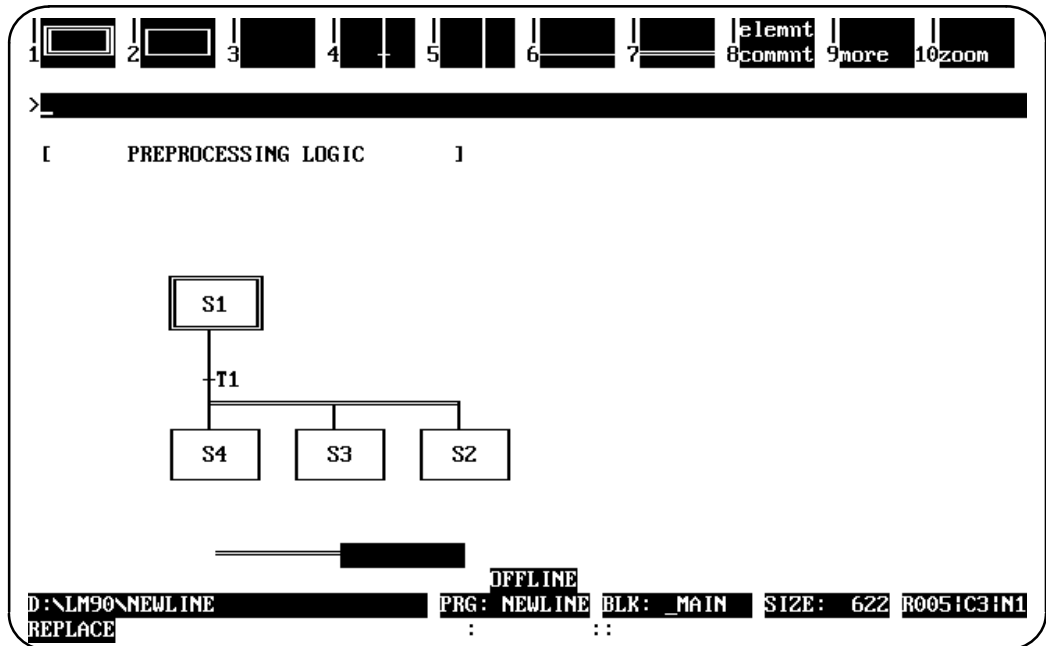
### Note

If you press the **Down cursor** key before pressing the **Step (F2)** softkey, the step will be entered in the same location as when the step element is added from the previous row.

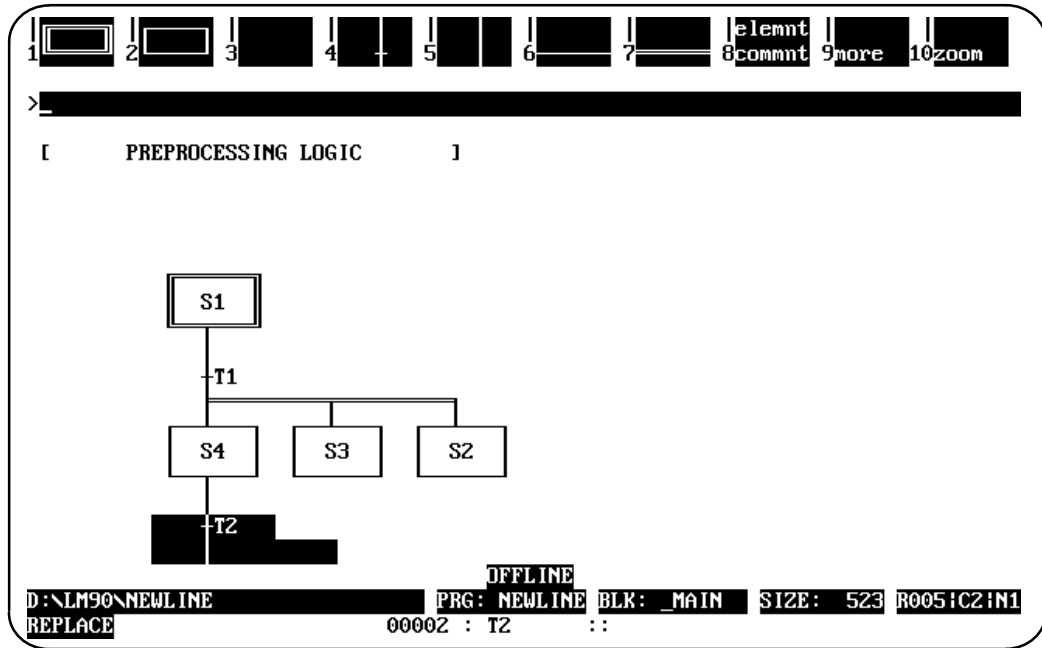
- 11. The Logicmaster software assigns the default name S2 to the second step added to this folder. If you cursor left and press the **Step (F2)** softkey two more times, the three paths will be assigned steps.



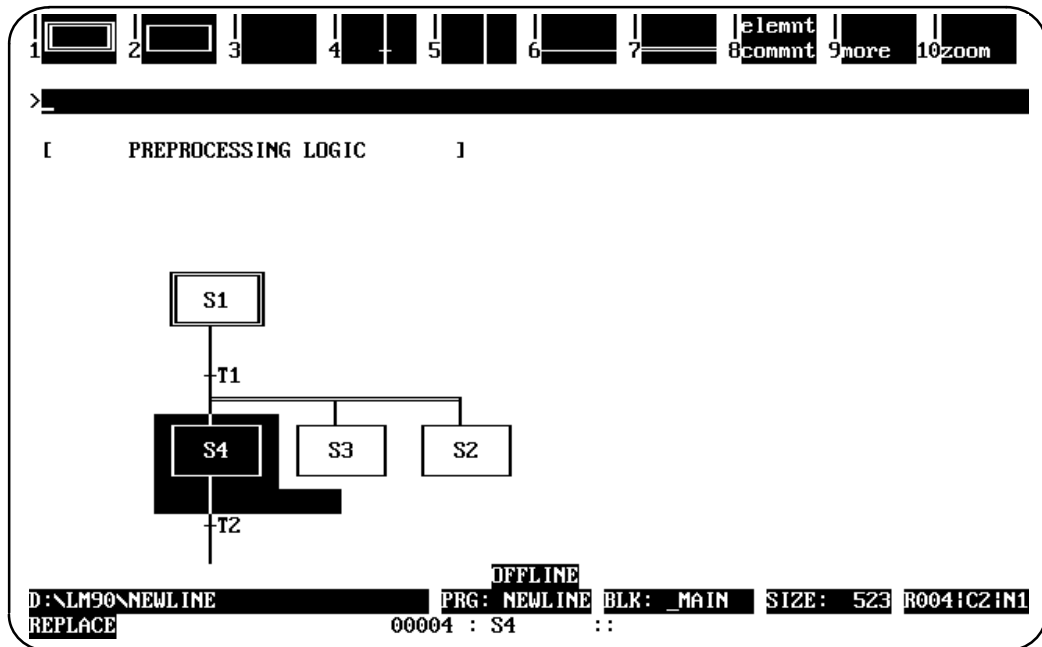
- 12. If you try to cursor down and enter a bottom simultaneous branch to close the sequence, you will see that the branch is positioned below the transition location.



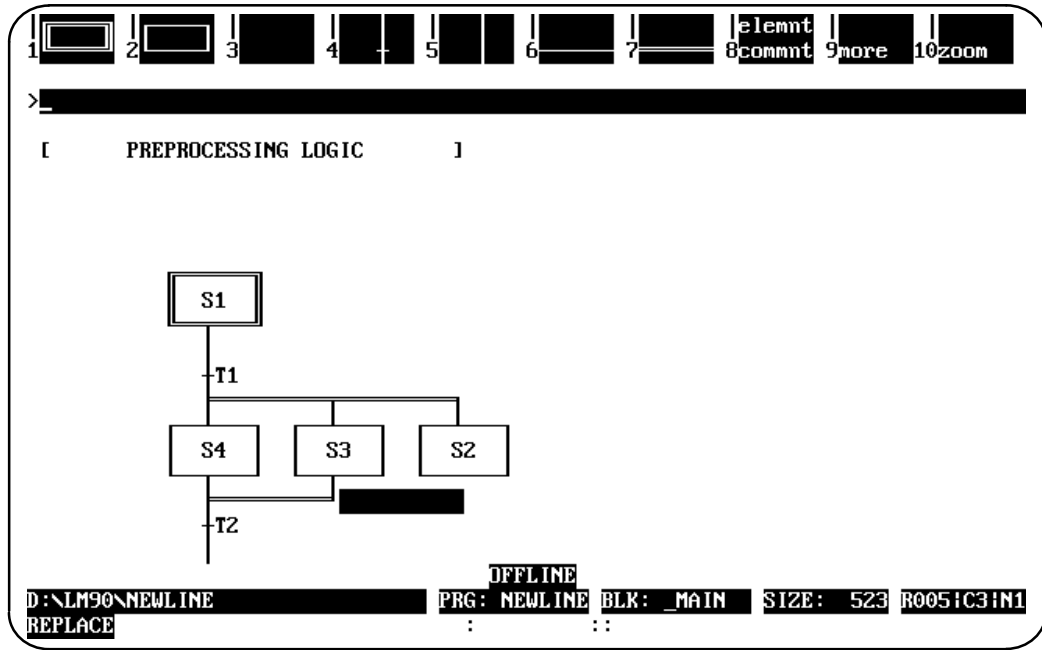
- 13. Do **not** press the **Simultaneous Branch (F7)** softkey here. You may enter a transition at this position. To enter a transition, press the **F4** softkey.



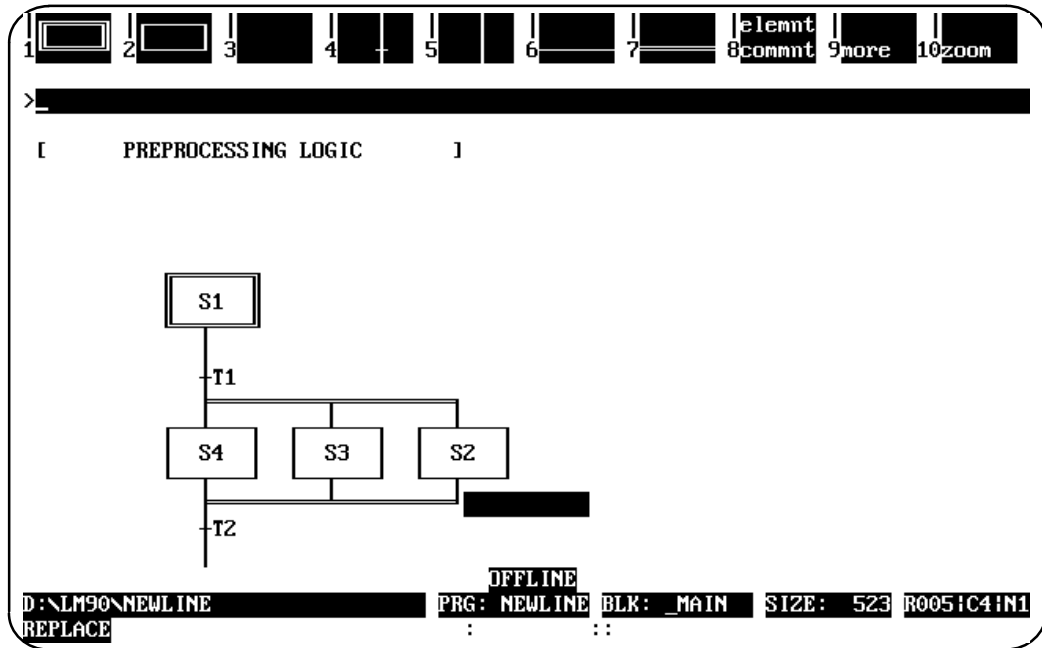
- 14. Press the **Up arrow** key to move the cursor to the correct location for the simultaneous branch element.



15. Press the **Simultaneous Branch (F7)** softkey to enter the first leg of the branch.



16. Press **Simultaneous Branch (F7)** again to add a second parallel branch in order to complete the sequence.

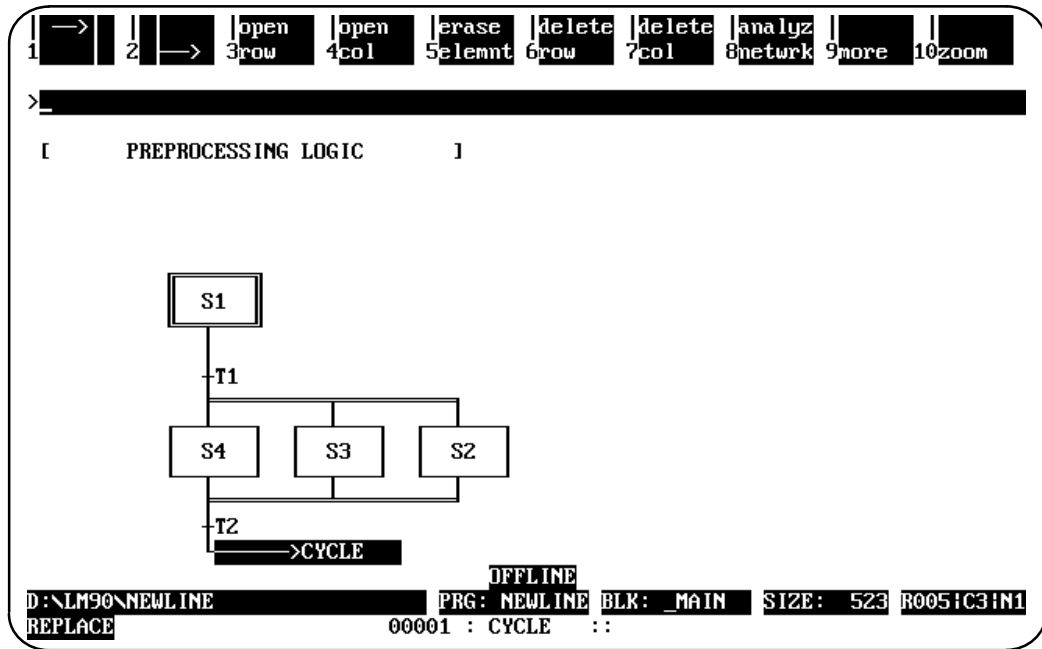


- 17. To complete this SFC network, you may add a source and destination connector. The function softkeys for these SFC elements can be displayed by pressing the **More (F9)** softkey.

### Note

Connector instructions are **only** allowed in odd-numbered transition rows. Source connectors must be added **after transitions**; destination connectors must be added **before steps**. They are entered the same way that branches are entered. The location of the connector that will be entered is indicated by the cursor location.

- 18. To enter a source connector, first position the cursor on transition T2 by pressing the **Left cursor** key twice and the **Down cursor** key once. Then, enter a name (i.e., **CYCLE**) on the command line, and press **Source Connector (F2)**.



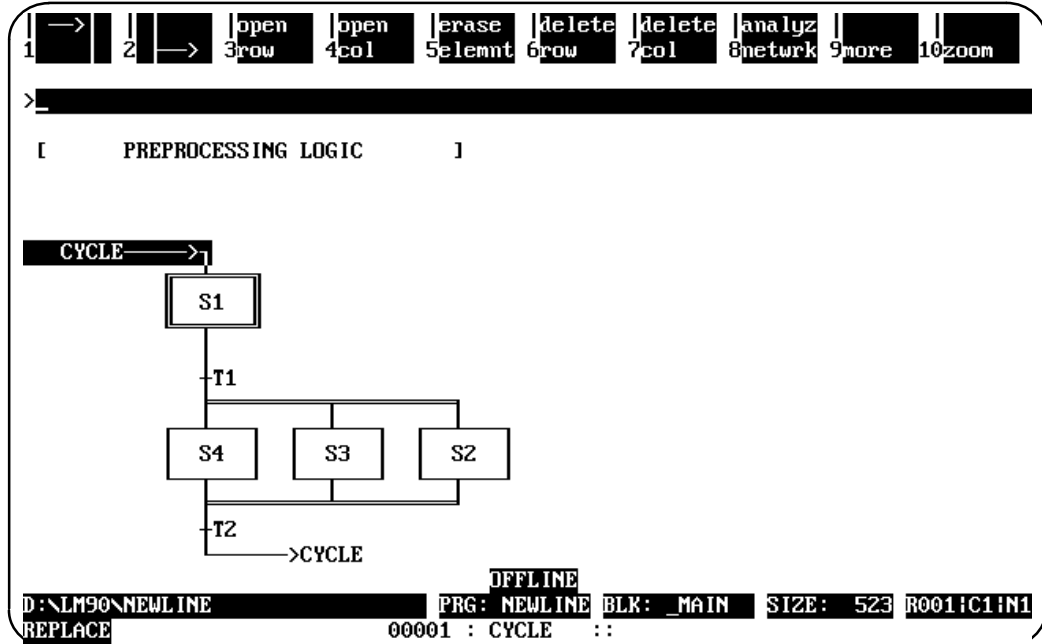
If you press **F2** before entering a name on the command line, the Logicmaster software will insert the connector and fill the name location with question marks. The question marks indicate that a connector name is required. You must enter a name before you can cursor off that connector.

### Note

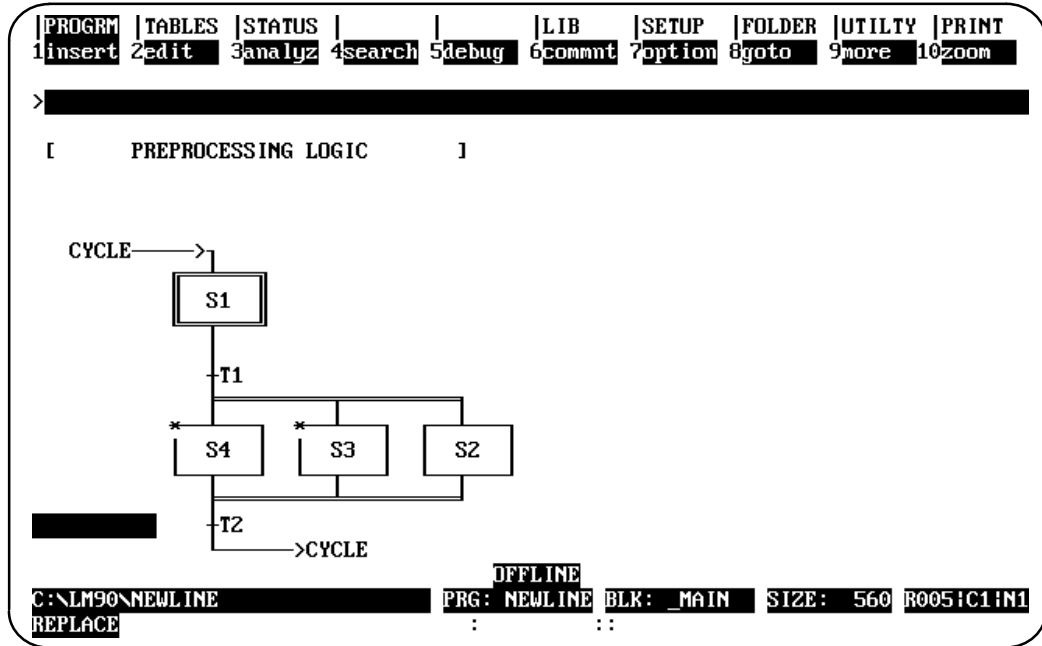
You can use **ALT-D** to delete the connector entry at any time. For more information about deleting an element, see page 3-35.



- 19. To add a destination connector, for this example, above the initial step S1, position the cursor in the top left corner of the network by pressing the **Home** key. Enter the name **CYCLE** on the command line and press **Destination (F1)**.



- 20. The **Element Comment (F8)** softkey provides access to the comment block that is available with each step element. To add a comment, press **More (F9)** with the SFC Editor function softkeys displayed at the top of the screen. Then, press **F8**. For more information on comments, refer to section 5, "Comments," on page 3-52. For additional information on the Logicmaster COMMENT instruction, refer to chapter 3, "Program Editing," in the *Logicmaster 90-70 Programming Software User's Manual*, GFK-0263, or in chapter 3 of the *Logicmaster 90-30 Programming Software User's Manual*, GFK-0466.



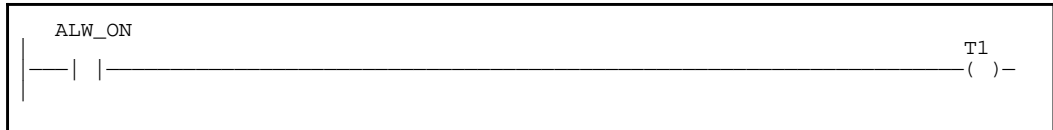
When a step element has a comment associated with it, an asterisk is displayed in the upper left corner of the step graphic, as shown for steps S3 and S4 in the screen shown above.

- 21. To enter action logic for a transition, cursor to that transition and press the **Zoom (F10)** softkey. The action logic for a transition must contain logic that, at a minimum, sets its transition variable. For example, the action logic for transition T1 must contain a rung similar to the ones shown below to set transition T1.

**For 90-70:**



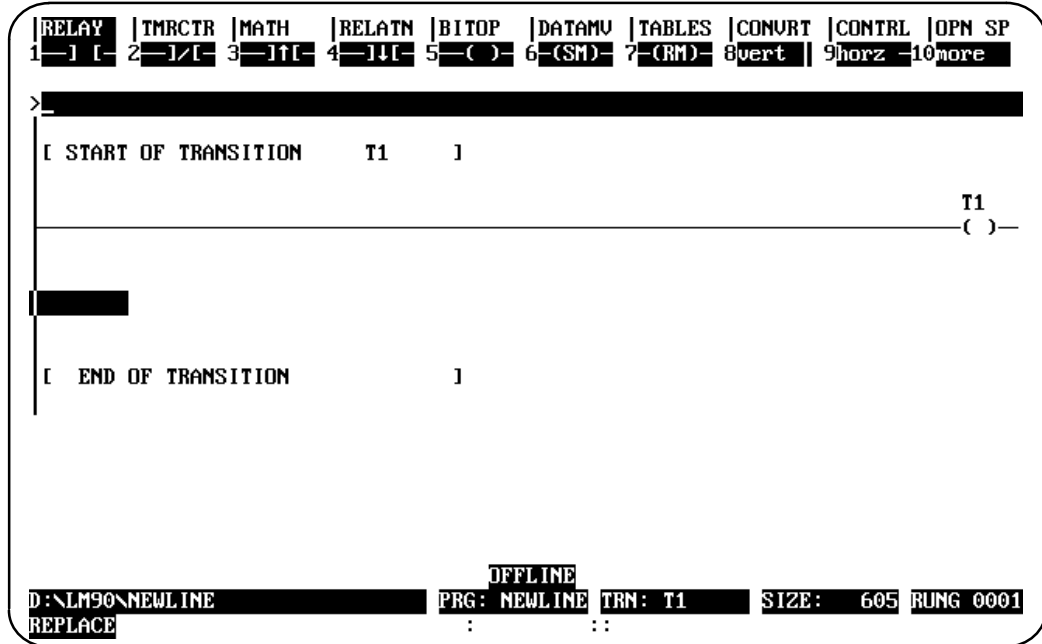
**Or for 90-30:**



To add this rung of transition logic, position the cursor on transition T1, and press the **Zoom (F10)** softkey. The following screen will be displayed.

A screenshot of a software interface with a menu bar at the top and a status bar at the bottom. The menu bar includes: PROGRAM, TABLES, STATUS, LIB, SETUP, FOLDER, UTILITY, PRINT. Below the menu bar are numbered options: 1insert, 2edit, 3modify, 4search, 5, 6, 7option, 8goto, 9more, 10zoom. The main area shows a transition logic screen with a cursor at the top left. The text in the main area is: [ START OF TRANSITION T1 ] and [ END OF TRANSITION ]. The status bar at the bottom contains: D:\LM90\NEWLINE, PRG: NEWLINE, TRN: T1, SIZE: 605, RUNG 0001, and REPLACE. The word "OFFLINE" is centered above the status bar.

Then, press **Insert (F1)** to enter new logic (or **Edit (F2)** to edit existing logic for that transition). Note that the RLD softkeys will be displayed after you press **Insert (F1)** or **Edit (F2)**. Press **F5** to display the following rung.



Entering action logic for a step is similar to entering action logic for a transition. Position the cursor on the step, and press the **Zoom (F10)** softkey. Then, press **Insert (F1)** or **Edit (F2)** to enter new relay ladder diagram (RLD) logic or edit existing RLD logic.

---

## Deleting an Element

The Erase Element function (press **More, F9**, to display this key) or **ALT-D** can be used to remove any SFC element, such as a step or transition.

When a step or transition is erased, its logic is also deleted. When the **Erase Element (F5)** function is used on a step with action logic or a transition with ladder diagram logic, you must confirm the action. The Erase Element function also deletes any related entries in the symbol table. The step, transition, or connector name can then be used on another element.

Replacing an element with another element having a different name has the same effect as executing an erase element operation. For example, pressing the **Step (F2)** softkey with a name on the command line will replace (delete) the current step with the newly defined step.

---

## Open/Delete Space Functions

The **Open Row (F3)** and **Open Column (F4)** softkeys can be used to expand individual branch sequences or move an entire network.

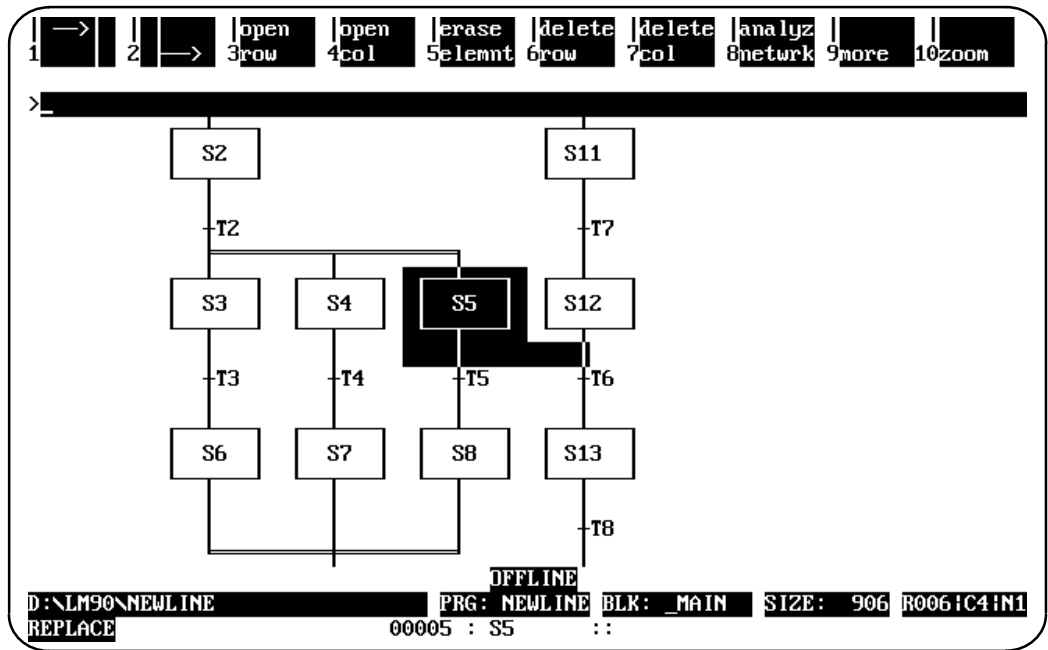
The **Delete Row (F6)** and **Delete Column (F7)** softkeys can be used to remove space from individual branch sequences or move an entire network.

### Open Row

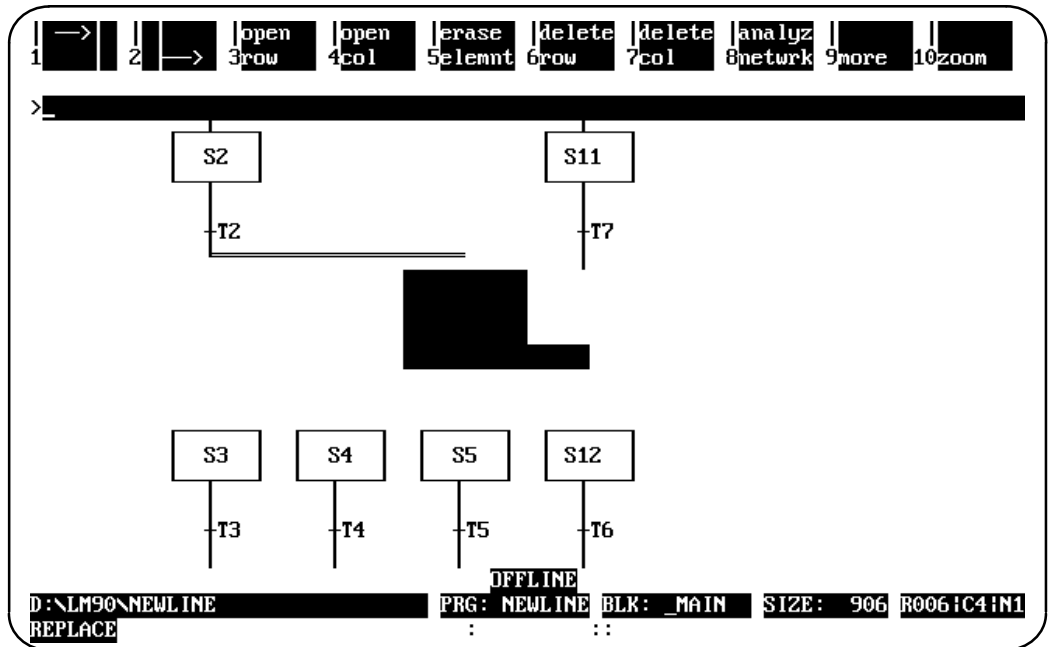
The **Open Row (F3)** function adds two rows immediately above the cursor location by moving the row that the cursor is on down two rows. Two rows are added to maintain steps on even rows and transitions on odd rows. The cursor remains at its original row location. The last two rows (rows 127 and 128) must be empty in order to use the open row function.

In the example on the following page, the row containing step S5 is moved down two rows by positioning the cursor on step S5 and pressing the **Open Row (F3)** softkey.

Before:



After:



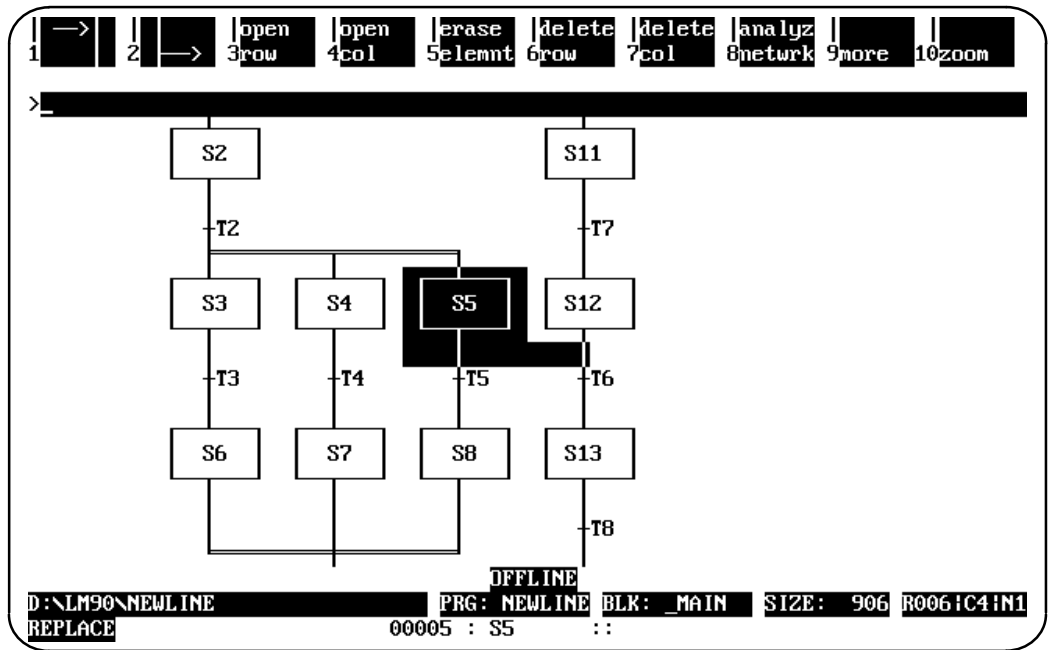
### Open Column

The **Open Column (F4)** function adds a column at the cursor position by moving the column that the cursor is on to the right one position. The cursor remains at its original column location, and all branches are extended in order to maintain control structures. All elements to the right of the cursor will be moved. The last column must be empty in order to use the open column function.

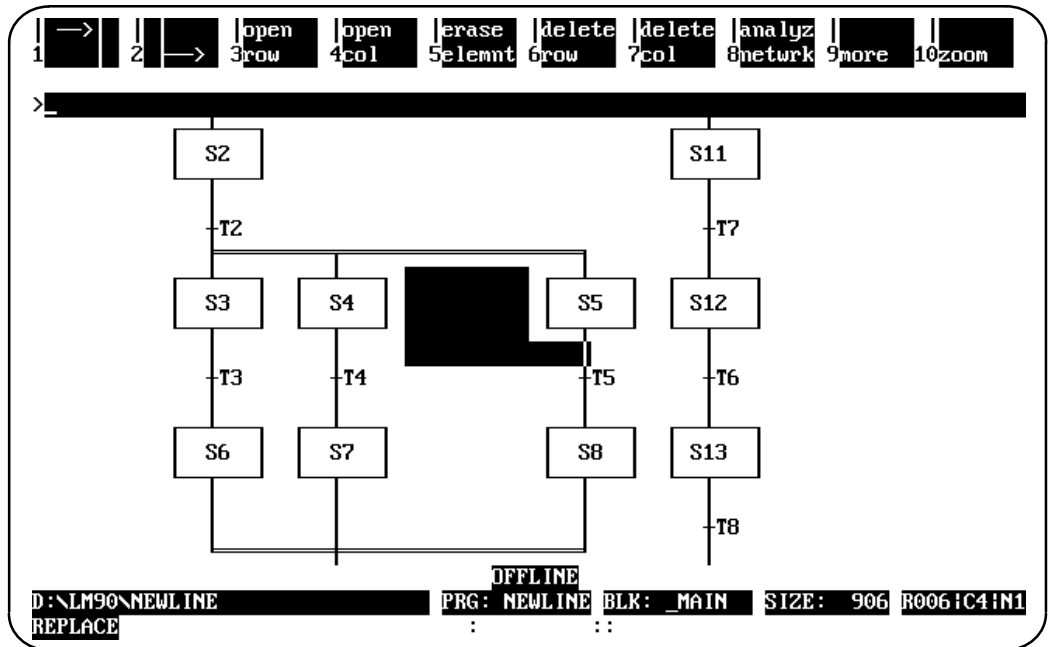
In the example on the following page, the column containing step S5 is moved right one column by positioning the cursor on step S5 and pressing the **Open Column (F4)** softkey.



Before:



After:

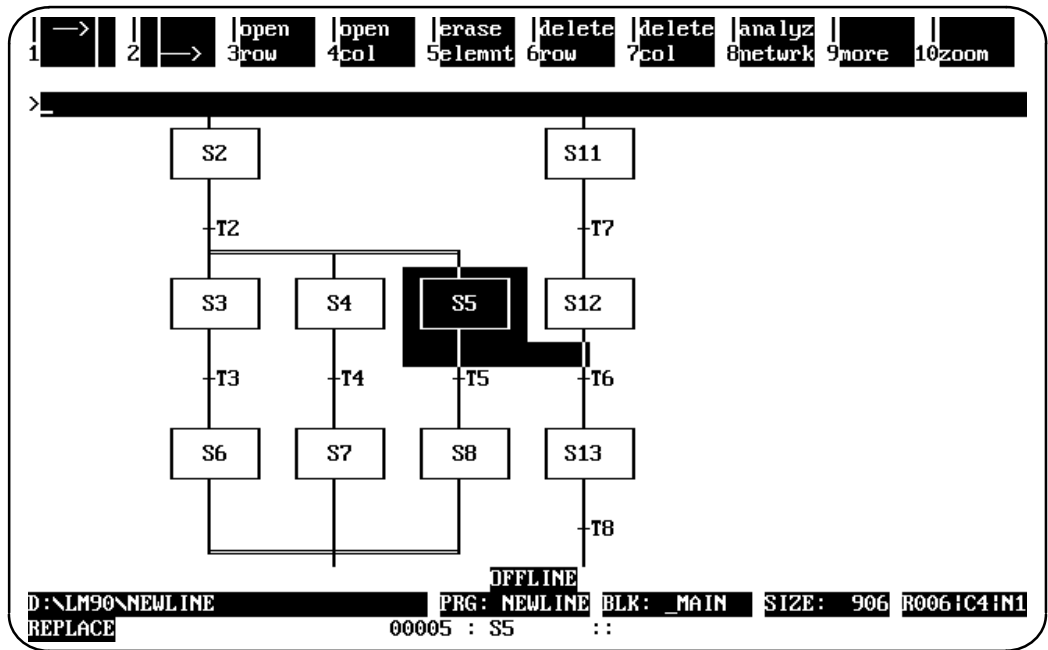


### Delete Row

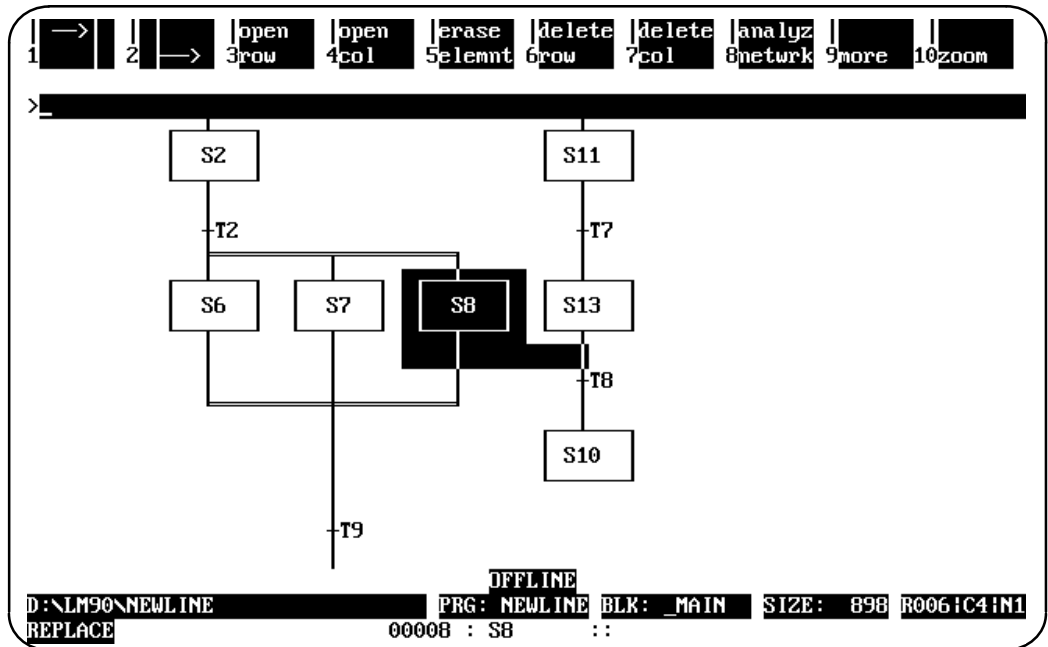
The **Delete Row (F6)** function removes the row at the cursor location and the next row. The cursor remains at its original row location, and all branches are shortened in order to maintain control structures.

In the example on the following page, the row containing step S5 and the one below are deleted by positioning the cursor on step S5 and pressing the **Delete Row (F6)** softkey.

Before:



After:



### Delete Column

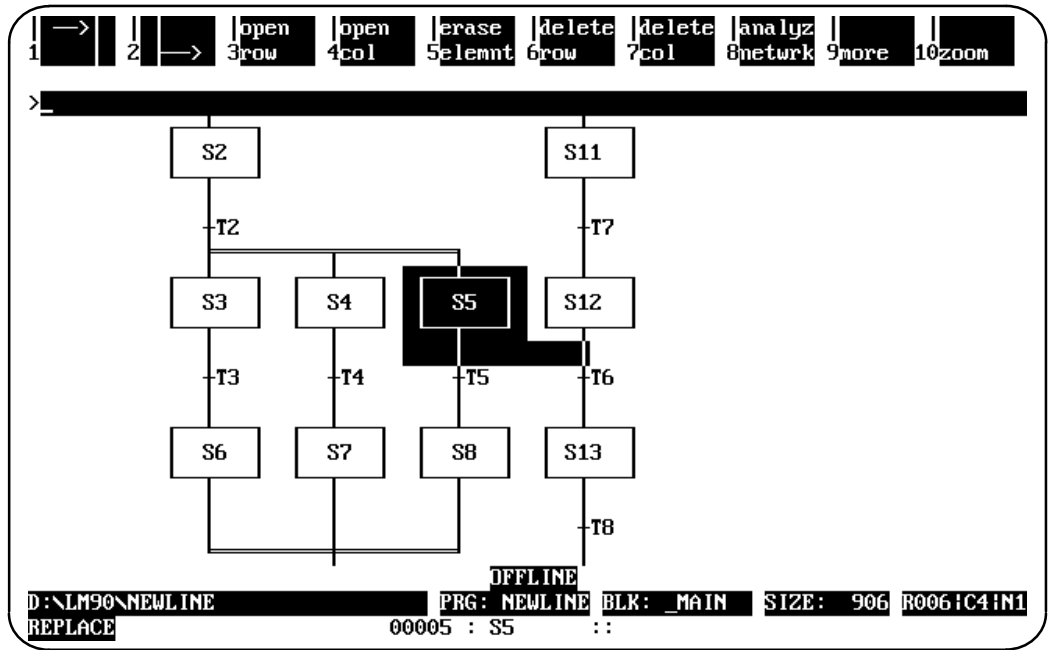
The Delete Column (F7) function deletes the column at the cursor position by moving the column that the cursor is on to the left one position. The cursor remains at its original column location, and all branches are shortened in order to maintain control structures.

### Note

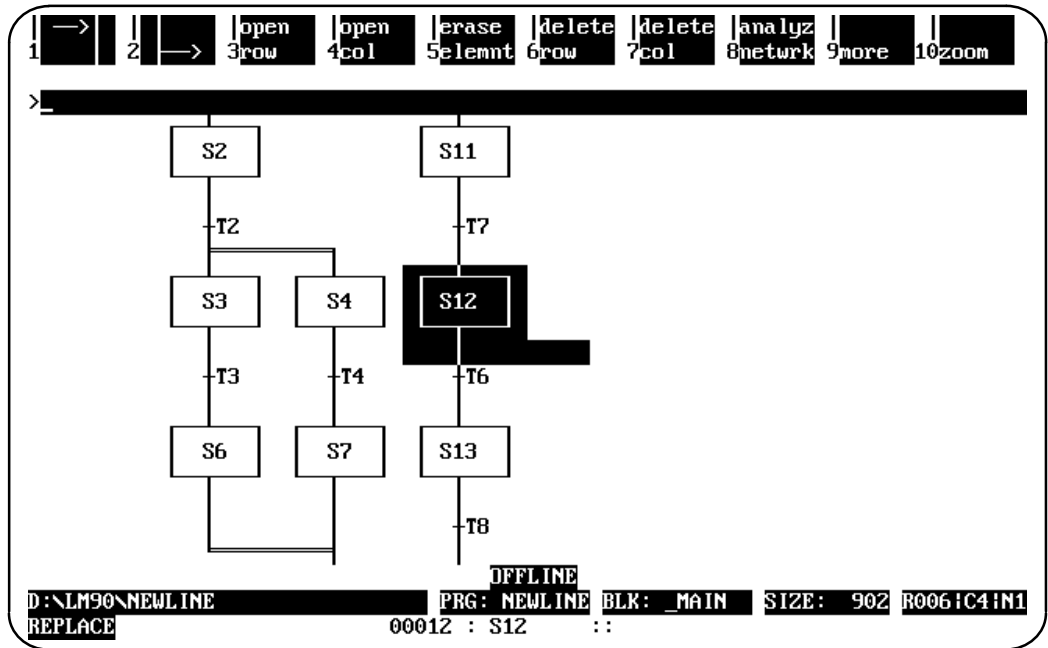
All elements in the entire column occupied by the cursor will be deleted.

In the example on the following page, the column containing step S5 is deleted by positioning the cursor on step S5 and pressing the **Delete Column (F7)** softkey.

Before:



After:



## Exiting Insert or Edit Mode

To exit **INSERT** or **EDIT** mode and save the SFC network, press the **Escape** key or the **Enter (Accept)** key. Error messages or warnings pertaining to the network will be displayed, and the cursor will be positioned at the location of the first error found in the SFC network.

## Displaying Errors in the Network

Errors in the SFC network can be identified and displayed using one of the following methods:

- At the command level, you can press the **Analyze (F3)** function softkey to check the validity of the SFC network and the executability of the block. The first three errors that are detected will be displayed, and the cursor will be positioned at the first error.
- In **INSERT** or **EDIT** mode, press **More (F9)** and then **Analyze Network (F8)** to check the validity of the SFC network. The first error detected will be displayed, and the cursor will be positioned at that error. In **INSERT** or **EDIT** mode, the network will also be checked for errors when you press the **Escape** key to accept the network.
- The analyze function can also be used to check the validity of a step or transition when accepting Relay Ladder Diagram (RLD) logic in a step or transition. This check will automatically be performed when you press the **Escape** key to accept the action logic. The first error found will be displayed. For example, this type error will occur if you attempt to accept a transition with no logic.

When you zoom out of an SFC block, a complete analysis of the SFC network in the block is performed automatically. If any errors are found, a message identifying the SFC network that contains the error will be displayed. You do not have to correct any errors before you exit an edit or insert session; however, an SFC block that contains errors is not executable and cannot be stored to the PLC.

## Storing Changes to an SFC Block

Changes to an SFC block are automatically stored to disk when you:

1. **Zoom** into lower levels of the block.
2. **Escape** back to higher levels of the block.
3. Press the **Escape** key again to exit from **INSERT** or **EDIT** mode.
4. Press **ALT-U** to force a store to disk. (**ALT-U** may be pressed at any time.)
5. Press **ALT-S** to store to a PLC (available in **BLOCK EDIT** mode only).

For 90-70 users, depending on the type of changes made to the block and whether the block is still executable, you may be able to store an SFC block to a PLC while the PLC is in **STOP** or **RUN** mode. (This option is not available for 90-30 users.) The type of changes allowed are changes to the relay ladder diagram logic associated with steps, transitions, or the preprocessing or postprocessing logic. In addition, the block cannot contain any errors.

While online changes are being made, the status line will change from **LOGIC EQUAL** to **BLOCK EDIT**. After the store is completed, the status line will change back to **LOGIC EQUAL**.

However, if you make any changes to the SFC network topology or if any errors exist, the block cannot be stored to a running PLC from the editor. Changes to the network will result in the status line changing to **LOGIC NOT EQ**. For 90-70 users, attempts to **RUN-MODE-STORE** a block that has had a change to its topology will result in an error from the PLC. (This is nonapplicable to 90-30 users because the **RUN-MODE-STORE** option is not available.)

## Section 3: Search Function

The Search function is used to search for an item within a block programmed in sequential function chart language. The Search softkey functions the same as it does for a ladder diagram block. For more information on the Search function, refer to section 11, “Search Function,” in chapter 3, “Program Editing,” of the *Logicmaster 90-70 Programming Software User’s Manual*, GFK-0263, or in the *Logicmaster 90-30 Programming Software User’s Manual*, GFK-0466.

In addition, you can search for the following SFC elements, even though no replacement is allowed:

- A step or step name, <stepname>.x, <stepname>.t, <stepname>.f.
- A transition or transition name.
- A connector name.
- An SFC language element:
  - &istep (initial step—see pages 3-13 and 3-14 for a discussion of this and the other steps)
  - &step (regular step)
  - &trans (transition)
  - &selbrch (selective sequence)
  - &simbrch (simultaneous sequence)
  - &verlnk (vertical link)
  - &srcnct (source connector)
  - &dstnct (destination connector)

A local search operates over all the SFC logic in the block, even if it is invoked within a particular step or transition. A global search initiated from an SFC topology will wrap to search the beginning of the block down to the original starting point. The cursor position identifies the starting point of the search. When the search is invoked, it will start with the next SFC element in traversal order. The search will continue and wrap around to include the starting point and its underlying logic. A local search, however, begins at the specified position and does not wrap.

### Note

A backward search can only be executed on relay ladder diagram (RLD) blocks. SFC logic will always search in traversal order, even if a backward search is selected.

In executable topologies, traversal order begins with the leftmost, topmost step in the topology and continues along the branch of the topology, following this step. When a selective or simultaneous structure is encountered, its branches are searched in left-to-right order. Destination connectors are searched immediately before the steps they precede. Source connectors are searched immediately after the transitions they follow. In non-executable topologies, traversal order follows the left-to-right, top-to-bottom ordering of SFC elements, as they appear on the screen.

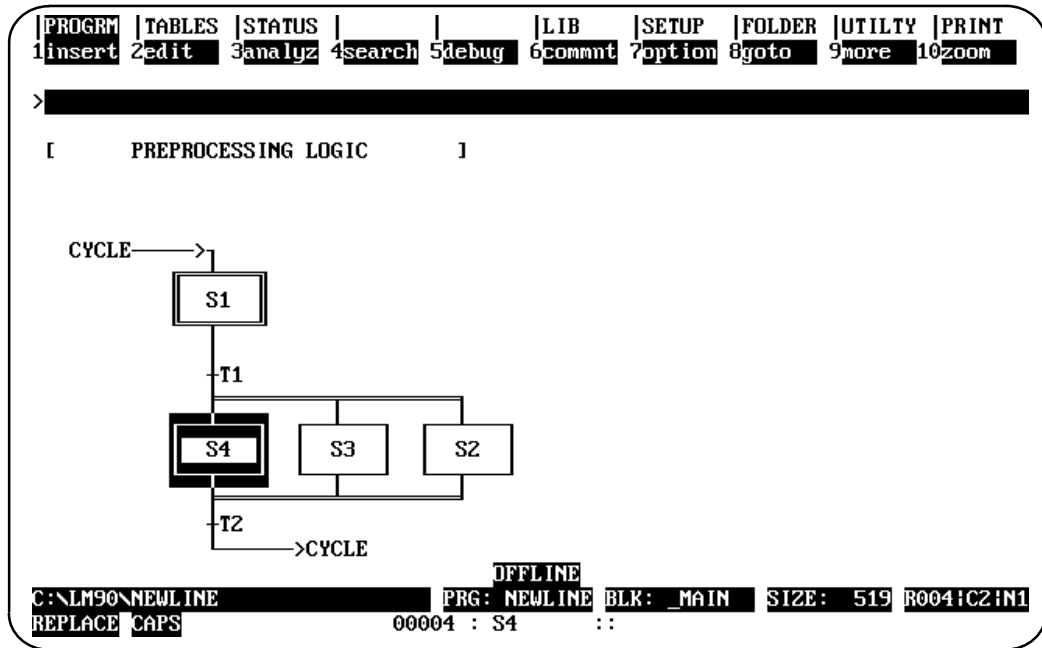


## Enabling the Search Function

The Search function is accessed by pressing the **Search (F4)** softkey from the SFC Editor function keys.

The following example illustrates how to use the Search function.

1. Position the cursor on step S4.





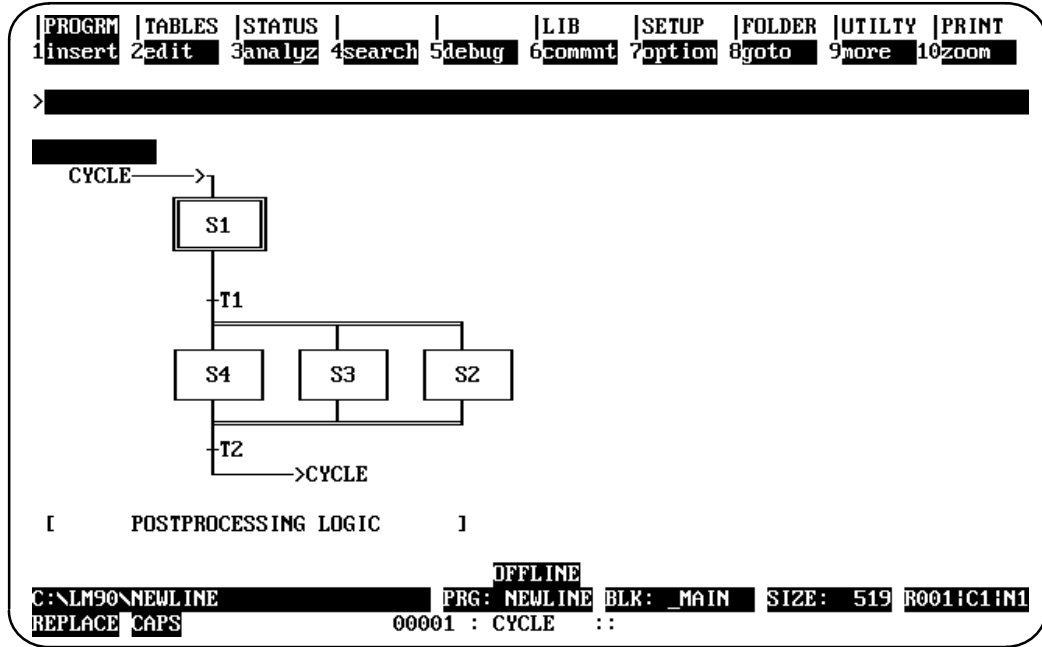
- 3. For this example, the connector **CYCLE** is the desired search target. Enter the word **CYCLE** in the **Search for** field.

```
PROGRAM | TABLES | STATUS | | | LIB | SETUP | FOLDER | UTILITY | PRINT
1insert 2edit 3analyz 4search 5debug 6commnt 7option 8goto 9more 10zoom
>
SEARCH
Search for :CYCLE
Replace With:
Scope: LOCAL (LOCAL, GLOBAL)
Usage: EXPLICIT (EXPLICIT, IMPLICIT)
Prompt: NO (YES, NO)
Direction: FORWARD (FORWARD, BACKWARD)
Start From: CURRENT (CURRENT, TOP, BOTTOM)
<< Press Enter key to begin search function >>
<< Press Esc key to exit search screen >>
OFFLINE
D:\LM90\NEWLINE PRG: NEWLINE BLK: _MAIN SIZE: 519 R001C1I1N1
REPLACE 00001 : CYCLE ::
```

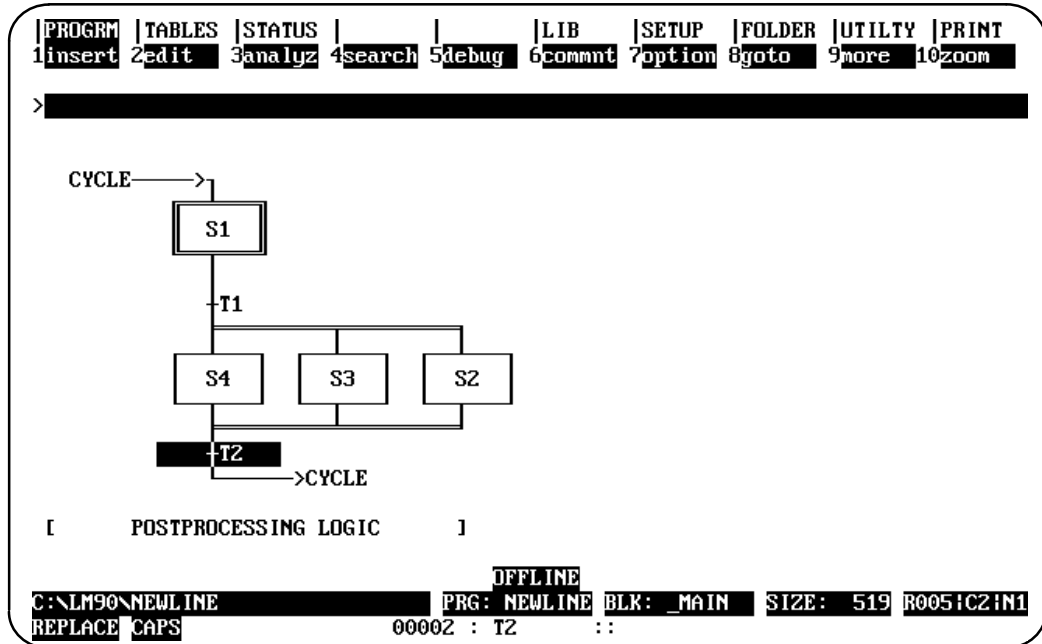
- 4. Press the **Enter** key to initiate the search for the target **CYCLE**. The target is located within the sequential function chart.

```
PROGRAM | TABLES | STATUS | | | LIB | SETUP | FOLDER | UTILITY | PRINT
1insert 2edit 3analyz 4search 5debug 6commnt 7option 8goto 9more 10zoom
>
CYCLE ->
S1
|
-T1
S4 S3 S2
|
-T2
->CYCLE
[ POSTPROCESSING LOGIC ]
OFFLINE
C:\LM90\NEWLINE PRG: NEWLINE BLK: _MAIN SIZE: 519 R0051C3I1N1
REPLACE CAPS 00001 : CYCLE ::
```

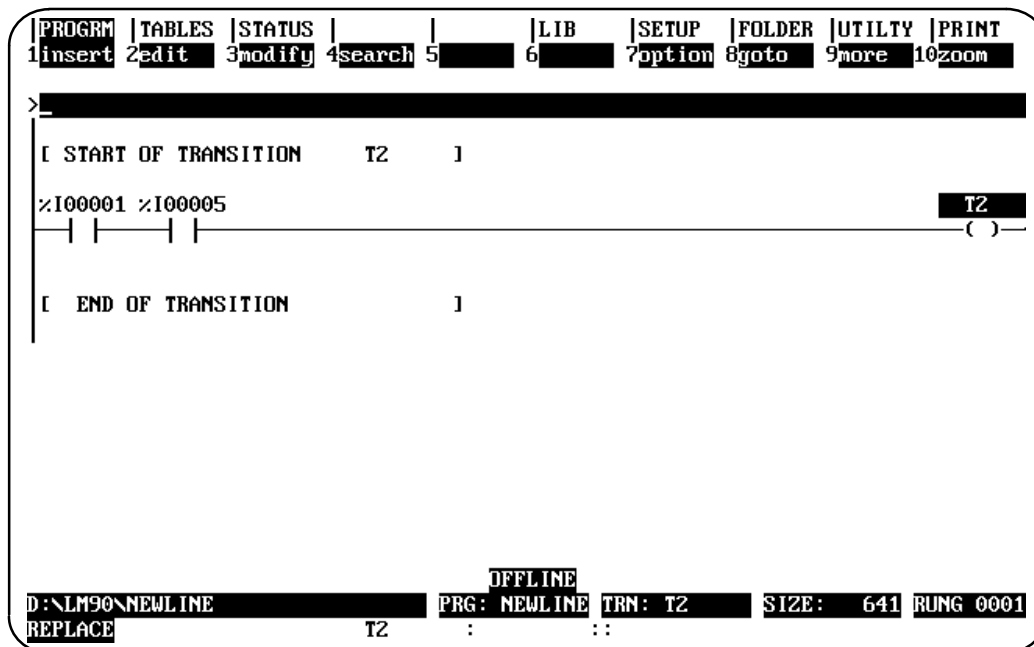
- Press the **Search (F4)** softkey and then the **Enter** key again (or press **ALT-Search (F4)**) to search for the next instance of the target **CYCLE**.



- This time press only the **Search (F4)** softkey. Then, set up a search for transition **T2** by entering **T2** in the **Search for** field. When you press the **Enter** key, the following screen is displayed.



7. Press **ALT-Search (F4)** to find the second occurrence of transition **T2**.



### Note

As noted on page 3-46, a search is performed in traversal order. In executable topologies, traversal order begins with the leftmost, topmost step in the topology and continues along the branch of the topology, following this step. When a selective or simultaneous structure is encountered, its branches are searched in left-to-right order. Destination connectors are searched immediately before the steps they precede. Source connectors are searched immediately after the transitions they follow. In non-executable topologies, traversal order follows the left-to-right, top-to-bottom ordering of SFC elements, as they appear on the screen.

### Goto

The goto function enables you to quickly go to a specific step, transition, or connector in an SFC network. To use this function, you must first be positioned within the SFC network. Enter the name of the specific step, transition, or connector on the command line, and press the **Goto (F8)** softkey from the Debug function keys.

If **Goto (F8)** is pressed without entering a name on the command line and the programmer is **ONLINE** and **EQUAL** to the PLC, the cursor will advance to the next active step in the SFC network.

### Ending the Search

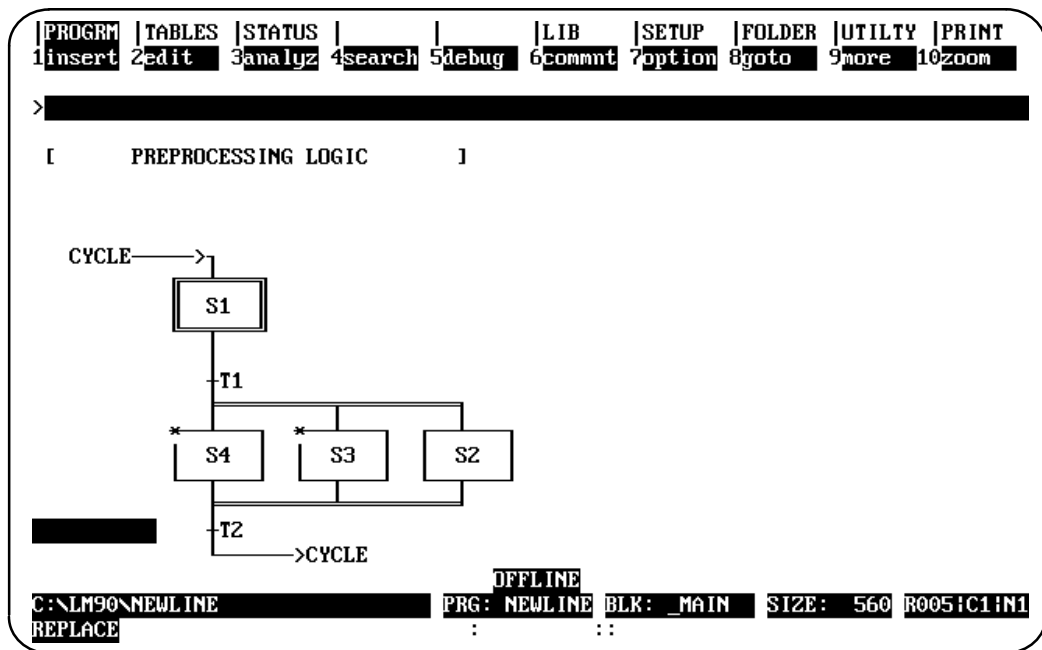
To end the search and return to the top level of the SFC editor, press the **Escape** key.

## Section 4: Comments

Step comments allow you to document actions associated with a particular step. These step comments can be viewed while editing the program or printed on the program listing.

To invoke the comment text editor, position the cursor on the step and press the **Comment (F6)** softkey. The comment text editor functions the same as it does for the ladder diagram COMMENT instruction in Logicmaster 90 programming software. For more information on the Logicmaster COMMENT instruction, refer to chapter 3, "Program Editing," in the *Logicmaster 90-70 Programming Software User's Manual*, GFK-0263, or in the *Logicmaster 90-30 Programming Software User's Manual*, GFK-0466.

When a step element has a comment associated with it, an asterisk is displayed in the upper left corner of the step graphic, as shown for steps S3 and S4 in the following example screen.



## Section 5: Options Related to SFC Blocks

The following options are available for all SFC language blocks in a program:

- Fault logging for out-of-limit step times.
- Program block language selection options.

### Fault Logging for Out-of-Limit Step Times

If a minimum and/or maximum time limit is set for a step, a step.f flag is set whenever the step time is outside the limits. In addition, if you enable the fault logging option, the PLC will log a fault in the PLC fault table when this occurs.

To enable the fault logging option, press **I/O (F1)** to enter the I/O configuration from the Logicmaster 90 configuration software.

1. In the configuration software, use the cursor keys to position the cursor on slot 1 of rack 0. Slot 1 contains the CPU module.

PS	1	2	3	4	5	6	7	8	9
===== P R O G R A M M E D C O N F I G U R A T I O N =====									
PWR711	CPU 771	MDL 240	PCM 711	BEM 731	ADC 701				
100W		I AC 16	PCM	GBC1	ADC				
	256 KB	Ref Adr %I00001	64 KB	Devices BUS1: 0					

OFFLINE

D:\NLM90\NEWLINE REPLACE
PRG: NEWLINE
CONFIG VALID

### Note

The sample screens are from the 90-70 software. The process is the same for the 90-30.

2. Press **Zoom (F10)** to zoom into the CPU detail screen.

```

RACK 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10
cpu    |   |   |   |   |   |   |   | expbd |
>
SERIES 90-70 MODULE IN RACK 3 SLOT 1
SOFTWARE CONFIGURATION
SLOT 1 Catalog #: IC697CPU771 771 CPU EXPANDABLE MEM
CPU 771
256 KB

IOScan-Stop: NO      Baud Rate : 19200
Passwords : ENABLED Parity : ODD
Tmr Faults : DISABLED Stop Bits : 1
Data Bits : 8
Modem TT : 0 1/100 Second / Count
Idle Time : 10 Seconds
Mode : SNP
Watchdog Tmr: 200 msec

The parameters on next page are supported by PLC Rev 4.0 or higher.
If PLC Firmware version is less than 4.0, do not modify them.

<< More Config Data Exists; PgDn for Next Page, PgUp for Previous Page >>
OFFLINE
C:\LM90\NEWLINE PRG: NEWLINE CONFIG VALID
REPLACE
  
```

3. Cursor to the **Tmr Faults** field, and use the Tab key to toggle the parameter selection to **ENABLED**. (The default selection for this parameter is **DISABLED**.)

```

RACK 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10
cpu    |   |   |   |   |   |   |   | expbd |
>
SERIES 90-70 MODULE IN RACK 3 SLOT 1
SOFTWARE CONFIGURATION
SLOT 1 Catalog #: IC697CPU771 771 CPU EXPANDABLE MEM
CPU 771
256 KB

IOScan-Stop: NO      Baud Rate : 19200
Passwords : ENABLED Parity : ODD
Tmr Faults : ENABLED Stop Bits : 1
Data Bits : 8
Modem TT : 0 1/100 Second / Count
Idle Time : 10 Seconds
Mode : SNP
Watchdog Tmr: 200 msec

The parameters on next page are supported by PLC Rev 4.0 or higher.
If PLC Firmware version is less than 4.0, do not modify them.

<< More Config Data Exists; PgDn for Next Page, PgUp for Previous Page >>
OFFLINE
C:\LM90\NEWLINE PRG: NEWLINE CONFIG VALID
REPLACE
  
```



The change is automatically stored to disk when you exit from the I/O configuration (by pressing the **Escape** key) and will be stored to the PLC the next time a store of the program configuration is executed.

For more information on configuring CPU modules, refer to section 2, “Configuring CPU Modules,” in chapter 11, “I/O Configuration,” of the *Logicmaster 90-70 Programming Software User’s Manual*, GFK-0263; or, for 90-30 CPUs, refer to chapter 11, “CPU Configuration,” of the *Logicmaster 90-30 Programming Software User’s Manual*, GFK-0466.

## Configuring Multiple Languages

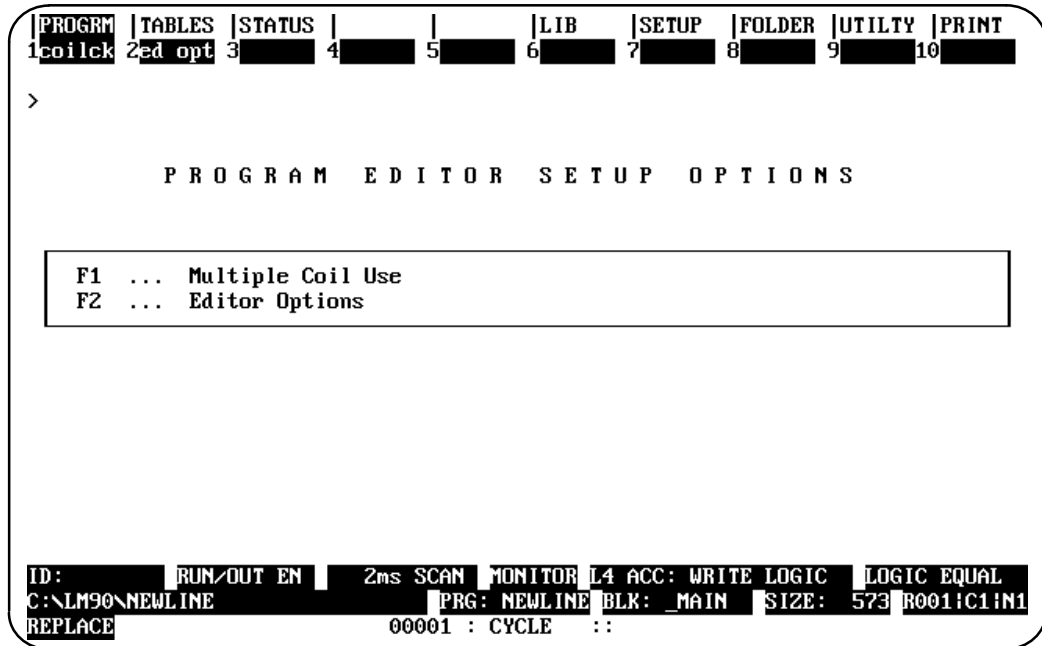
If you want all program blocks programmed in the same language, either relay ladder diagram or sequential function chart, you can set the multiple language option to a single language. Then, you will not have to select a language when you first enter a new block.

### Note

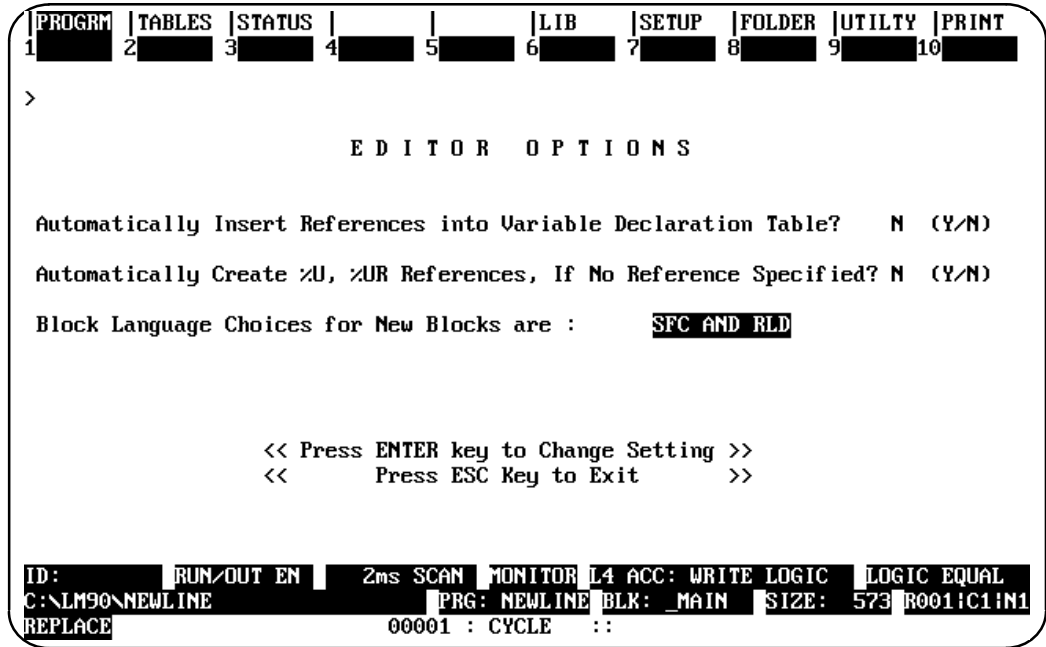
Even if you decide to program all your blocks in sequential function chart language, you must still use relay ladder diagram for those portions of the SFC block where there is no choice of language (e.g., preprocessing actions, postprocessing actions, transition logic, and step action logic).

To change the block language configuration:

1. Press the **Options (F7)** softkey from the main level of the SFC or RLD Editor.



2. Then, press the **Editor Options (F2)** softkey.



3. Cursor to the line:

Block Language Choices for New Blocks are:

and press the **Tab** key to select a language. Your choices are **SFC** and **RLD**, **RLD**, or **SFC**.

### Note

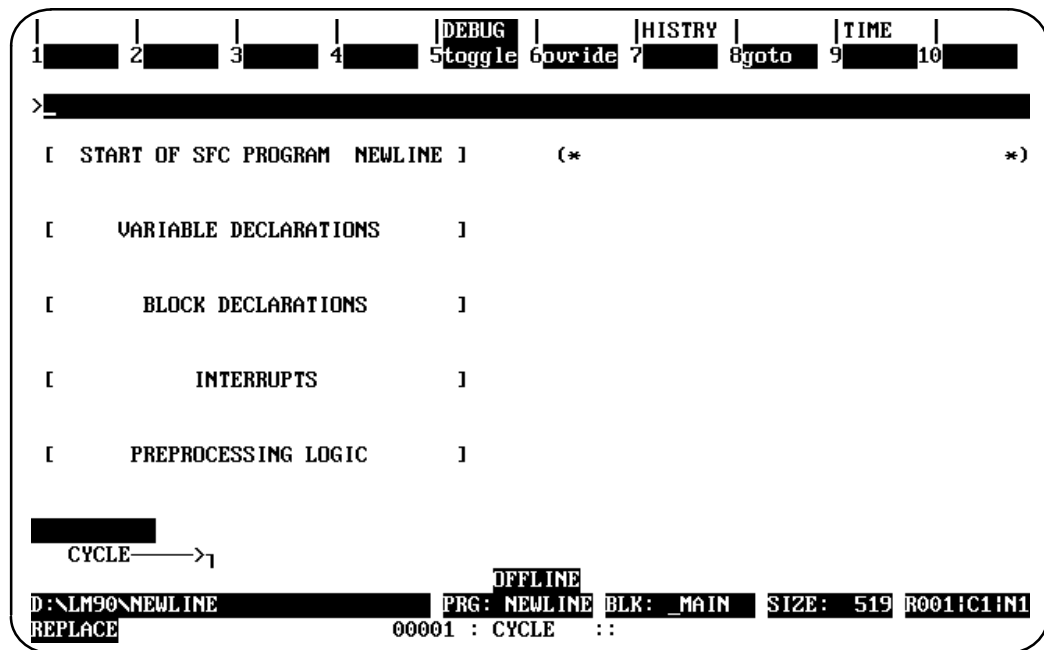
The multiple language option may be changed as often as desired. Your selection takes effect immediately; however, it only impacts the language selection for new blocks. For example, if the **RLD** option is selected, any old blocks programmed in sequential function chart language will remain **SFC** when you zoom into them.

## Section 6: Debug Functions

The following debug functions can help you debug a sequential function chart:

- Forcing (optionally overriding) transitions, disregarding the logic conditions.
- Tracking the evolution history of an SFC block.
- Setting the time base of the network.
- Setting minimum and maximum execution times for a step.
- Monitoring step time faults.
- The SFC\_RESET function block allows the network to be reset using RLD.
- Single sweep (scan) debug.
- You can zoom into steps or transitions from the debug screen.

The function keys for the debug functions are displayed by pressing the **Debug (F5)** softkey from the top level of the SFC Editor.



## SFC\_RESET

You can also control the execution mode through relay ladder diagram logic using the SFC request function **SFC\_RESET**; i.e., the SFC request function is one of the function blocks accessed through the Logicmaster Control softkey (spelled **CONTRL** on the Logicmaster screen).

To access the **SFC\_RESET** when editing or inserting a step, do the following: (1) Zoom into the step, (2) press the **CONTRL** softkey (**Shift-F9**), and then (3) press the **sfcrs** soft key (**F6**).

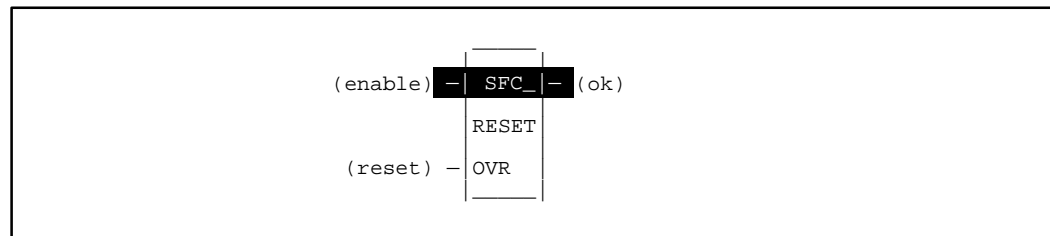
### Note

**SFC\_RESET** only has meaning in the action logic under a step. If it is used in a subroutine block (non-SFC), the function block will simply pass power without resetting the SFC.

## SFC\_RESET

The **SFC\_RESET** function can be used to reset the SFC network in the block to the initial step. Because SFC blocks are retentive, you must use the **SFC\_RESET** function to force an SFC block to start from the initial step on power-up or from a **STOP-TO-RUN** transition.

The **SFC\_RESET** function has the following form:



The enable (EN) and reset inputs are used to control execution of the SFC block. EN is the only required input; the OVR input is optional. When EN is active, the **SFC\_RESET** function causes the SFC block to begin at the initial step. Step timers are initialized, and step.f bits are set to OFF. When OVR is active, overrides are cleared.

### Note

Step.t, step.f, and step.x values are cleared when an **SFC\_RESET** function is executed.

When a reset request is received, it is sent to the SFC interpreter. The next time the SFC interpreter is invoked to evolve the SFC network, all currently active steps are deactivated. This causes all the action logic associated with the active steps to be executed without power flow. Then, the SFC network will evolve to a state of having its initial step activated, and the activated logic will be executed.

#### Parameters:

Parameter	Description
EN	When the function is enabled, the operation is performed.
OVR	OVR clears SFC override bits.

## Toggles and Overrides

If Logicmaster 90 software is **ONLINE** and **EQUAL** to the PLC, transitions can be toggled and overridden the same as contacts and coils in relay ladder diagram language. To change the state of a transition, position the cursor on the transition to be changed, and press either the **Toggle (F5)** softkey from the Debug function keys, the **F12** function key, or the keypad “-” key. If the step was previously active, it will become inactive. If the transition was previously ON, it will turn OFF.

### Note

The effect of toggling a transition may last only one sweep. On the next sweep, the transition will be evaluated again and the toggled value replaced.

To keep the transition in its toggled state, the transition should first be overridden using the **Override (F6)** softkey from the Debug function keys, the **F11** function key, or the keypad “\*” key and then toggled to the desired state.

### Caution

**Proceed with caution when using this functionality to keep a transition in its toggled state. The SFC can be put in an illegal state, one that Logicmaster 90 software would normally prevent by enforcing restrictions on the SFC.**

When a transition is overridden, its name will flash to indicate its overridden state.

The toggle and override functions can be used to control the execution path of an SFC network. For example, to disable one branch of a simultaneous structure while allowing the others to execute normally:

- Toggle the overridden step OFF.

When the simultaneous structure is entered, all paths except the disabled path will execute normally. In a similar series of steps, you can disable all simultaneous branches except one or disable all selective branches except one.

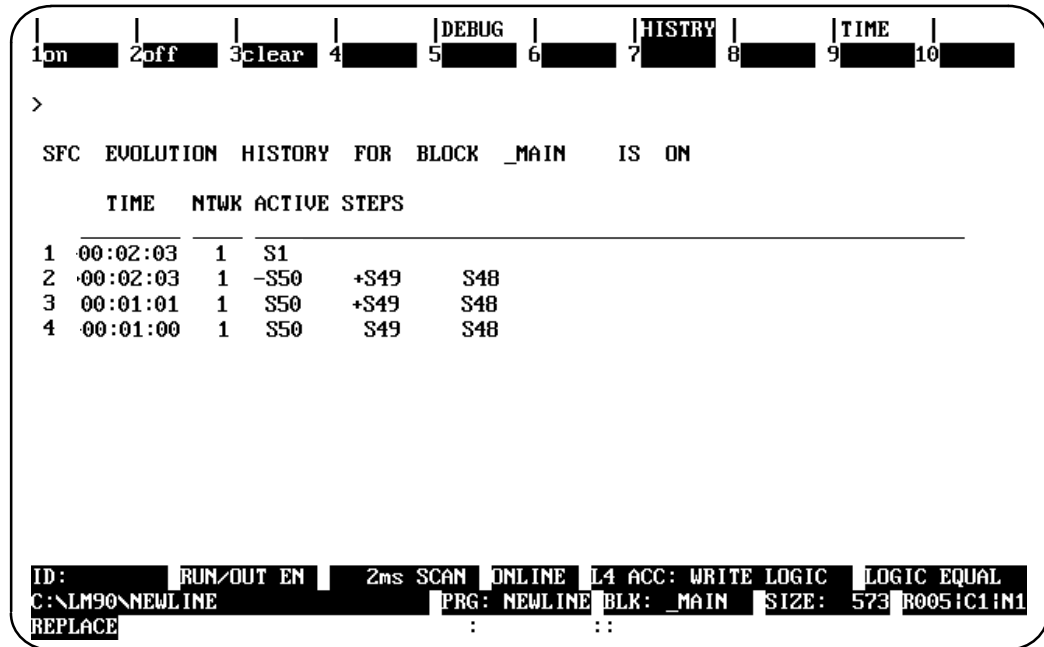
## Evolution History

The **History (Shift-F7)** softkey allows you to view and record an evolution history of the current SFC block. The PLC does not have to be currently running in order to turn the evolution history feature on, but it does need to be running for updates.

### Note

The information about whether the SFC block will have its evolution history recorded is stored in the PLC **only**. It is **not** stored within the current folder as part of the information about that block.

To display the following screen, press the **History (Shift-F7)** softkey from the Debug function keys for the desired block..



To enable the collection of evolution history of the current SFC block, press **On (F1)**. When enabled, a history of the last eight evolutions of the SFC block is recorded and displayed. The most recent evolution is displayed first (i.e., in the example screen above, entry 8 occurred earlier in time than entry 1). Each evolution is time-stamped (i.e., the time at which each step for that evolution became active is recorded). Note that this screen shows which steps *became* active at which time, not which steps *are* active.

To disable the collection of evolution history, press **Off (F2)**. To clear the evolution history, press **Clear (F3)**.

If a step exceeds its maximum time or does not attain its minimum time, it will be marked in the evolution history with a “+” or “-”, respectively. A step exceeding its maximum timer is a distinct evolution of the SFC block and is listed as a separate entry in the history log. A step that does not attain its minimum time will be logged with the next step(s) that become active. The reason for this is that a step which exceeds its

maximum timer is logged at the time the maximum timer has been exceeded. The minimum time requirement is not evaluated until the step has become inactive and the next step(s) have become active.

For example, in the previous screen, the third entry records the fact that step S49 exceeded its maximum time at 1:01 a.m. The second entry was generated at 2:03 a.m. when the SFC network evolved from steps S50, S49, and S48 to step S1. At this point, S50 had not attained its minimum time, and the second entry was generated to record this fact.

A fixed amount of user memory in the PLC is required for each SFC block to support this feature. The memory is used to store the evolution information.

### Caution

**Once turned on, history is continuously recorded in the PLC until the feature is turned off by pressing Off (F2), or a program is stored to the PLC in STOP mode. If you exit from an SFC block that has its evolution history recording, this will impact the scan time of the PLC unless you turn off the evolution history before exiting from the SFC block.**

## Goto

The goto function enables you to quickly go to a specific step, transition, or connector in an SFC network. To use this function, you must first be positioned within the SFC network. Enter the name of the specific step, transition, or connector on the command line, and press the **Goto (F8)** softkey from the Debug function keys.

If **Goto (F8)** is pressed without entering a name on the command line and the programmer is **ONLINE** and **EQUAL** to the PLC, the cursor will advance to the next active step in the SFC network.





## Setting the Time Base

You can use the screen shown on the previous page to set the time base for the SFC network in the sequential function chart block. The time base is used for all step timers in the SFC network. The value for the time base can be 1 second, .1 second (default), or .01 second. To select a value for the time base, position the cursor on the **Time Base** field, and press the **Tab** key repeatedly until the desired time base is displayed. Another way to set the time base is to enter the value, and press the **Enter** key.

Changing the network's time base must be done **OFFLINE**, regardless of whether Logicmaster 90 software is connected to a PLC. New time base information is stored to disk when you exit from this screen and stored to the PLC the next time a **STOP-MODE-STORE** of the entire program is executed.

## Setting Step Time Limits

You can also set minimum and maximum step times for each initial step or regular step by positioning the cursor on the time field for a specific step, entering a step time limit, and pressing the **Enter** key.

Time limits must be expressed as fixed point numbers in the range .1 – 32,767, or the special default value **NONE**, which indicates that there is no minimum or maximum time limit on the step.

All time values are automatically adjusted to be within the range allowed by the time base. For example, if the time base is .01 seconds and you enter a maximum step time of 400 seconds, the value will be automatically set to the maximum possible value of 327.67 seconds. If the time base is 1 second and you enter a minimum time of 1.5 seconds, the value will be changed to 2 seconds.

### Note

If you change the network time base after you have specified minimum and maximum step times, the minimum and maximum step times will be automatically adjusted within the range of the new time base.

If the PLC is **EQUAL** to the programmer, minimum and maximum step times can be changed **ONLINE**. The new step times are sent to the PLC immediately; however, changes to the step times are not applied to an active step until that step becomes inactive. The changes are stored to disk when you exit from this screen and are stored to the PLC the next time a **STOP-MODE-STORE** of the entire program is executed.

### Note

In order to have the time base faults appear in the fault table, you must enable the **Tmr Faults** parameter in the CPU configuration. For more information, refer back to section 5, "Options Related to SFC Blocks," beginning on page 3-53.

## Single Sweep Debug

In the 90-70 SFC, Single Sweep (scan) Debug allows you to stop the PLC to view or monitor the program after one sweep by pressing **ALT-G**. **ALT-G** may be used while viewing the program, reference tables, PLC fault table, or I/O fault table. To use this feature, the programmer must be in **ONLINE** mode, and the PLC must be in **STOP/IOSCAN** mode. If the PLC is in **RUN** mode, press **ALT-R** to toggle the PLC mode to **STOP**, or select **STOP** mode from the Run /Stop PLC screen using the status functions.

To perform a first scan, type **0** on the command line before pressing **ALT-G**. If the command line is blank or **1** is entered on the command line, a non-first scan single sweep debug is performed.

When the PLC is running sweeps in single-sweep mode, timers do not increment. You will have to force a value into the timer's CV register to make the timer time out.

### Note

Single Sweep Debug is available *only* in the 90-70 SFC, *not* the 90-30.

## Section 7: Program Utility Functions

### Loading from the PLC to the Programmer

Programs containing SFC blocks can be loaded from the PLC to Logicmaster 90 software the same as programs without SFC blocks. For information on the load function with the 90-70 software, refer to chapter 9, “Program Utilities,” in the *Logicmaster 90-70 Programming Software User’s Manual*, GFK-0263. For 90-30 users, refer to chapter 8, “Program Utilities,” in the *Logicmaster 90-30 Programming Software User’s Manual*, GFK-0466.

### Storing to the PLC from the Programmer

The store function is used to copy program logic, configuration data, and/or reference tables from the programmer to the PLC. (Only configuration data may be stored from the configuration software.)

#### Stop-Mode-Store

The **STOP-MODE-STORE** of a program containing SFC blocks is similar to storing a program without SFC blocks. For information on the store function with the 90-70 software, refer to chapter 9, “Program Utilities,” in the *Logicmaster 90-70 Programming Software User’s Manual*, GFK-0263. For 90-30 users, refer to chapter 8, “Program Utilities,” in the *Logicmaster 90-30 Programming Software User’s Manual*, GFK-0466.

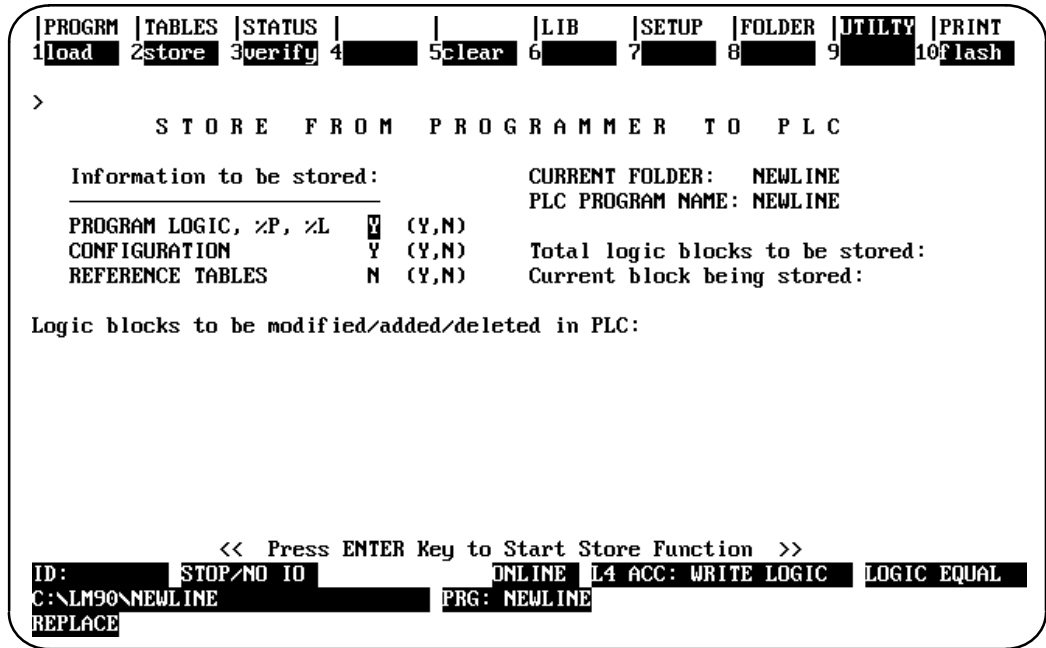
The Logicmaster software must first determine whether the current program contains any SFC blocks and, if it does, whether the SFC blocks are supported by the current version of the SFC interpreter on the PLC. If one of the SFC blocks is not supported by the current version of the SFC interpreter, the store will not be allowed. If all the blocks are supported, the **STOP-MODE-STORE** will proceed. For the 90-30 software, the process is the same except that only the **\_MAIN** block can be SFC.

A full **STOP-MODE-STORE** will store every block in the program to the PLC. In this type of store, all SFC blocks are reset to their initial states. This includes initializing step timers and resetting step.f flags to OFF.

#### Note

Storing the SFC block will cause all the SFC topology control bits to be cleared. This will result in starting with the initial step when going to **RUN** mode. The PLC memory (reference tables) will not be cleared unless you select this option on the Load/Store screen.

To initiate a **STOP-MODE-STORE**, press **Store (F2)** from the Program Utility Functions menu.



Three types of data can be stored from the programmer to the PLC: program logic, configuration data, and/or reference tables. When this screen is first displayed, only the program logic is set to **Y** (Yes); this is the default selection. All other fields default to **N** (No).

To store all of the data, you must change the selections for reference tables and configuration to **Y** (Yes). To store only part of the data, select **N** (No) for the data you do not want to store. The Tab key may also be used to toggle the selection of each option.

After the selections are made, press the **Enter** key to begin the store process.

### Run-Mode-Store

In a **RUN-MODE-STORE**, only changed blocks are stored to the PLC. A **RUN-MODE-STORE** can only be performed if the SFC blocks to be stored have the same network topology as what is currently stored in the PLC. Only the RLD logic for the existing steps and transitions can be changed.

### Note

SFC blocks cannot replace RLD blocks, and vice-versa, during a **RUN-MODE-STORE**.

---

## Verifying a Program with the PLC

If the program in the current folder is equal to the program in the PLC, a message displayed on the screen will state that the verify is complete and no miscompares were found; the program logic equality state will be set to EQUAL. If the program in the current folder is not equal to the program in the PLC, the verify function will list which blocks are different.

For more information on verifying a program with the PLC with the 90-70 software, refer to chapter 9, “Program Utilities,” in the *Logicmaster 90-70 Programming Software User’s Manual*, GFK-0263. For 90-30 users, refer to chapter 8, “Program Utilities,” in the *Logicmaster 90-30 Programming Software User’s Manual*, GFK-0466.

# Chapter 4

## Printing SFC Blocks

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An SFC network can be printed by selecting to print **SFC TOPOLOGY**. The logic associated with the steps and transitions is printed using the options selected for printing the Relay Ladder Diagram (RLD) logic.

A printout of an SFC block begins with the SFC network, by listing the steps in the network. After the network is printed, the preprocessing and postprocessing Relay Ladder Diagram logic is printed, followed by the Relay Ladder Diagram logic for each step and finally the Relay Ladder Diagram logic for each transition.

The variable table is printed after all the logic has been printed. For a **\_MAIN** SFC block, the program block and interrupt block declaration tables follow the variable table. Cross reference tables and reference use tables are the last listings printed for the block.

Each section of the printout has an entry in the table of contents, which is printed at the end of the listing.

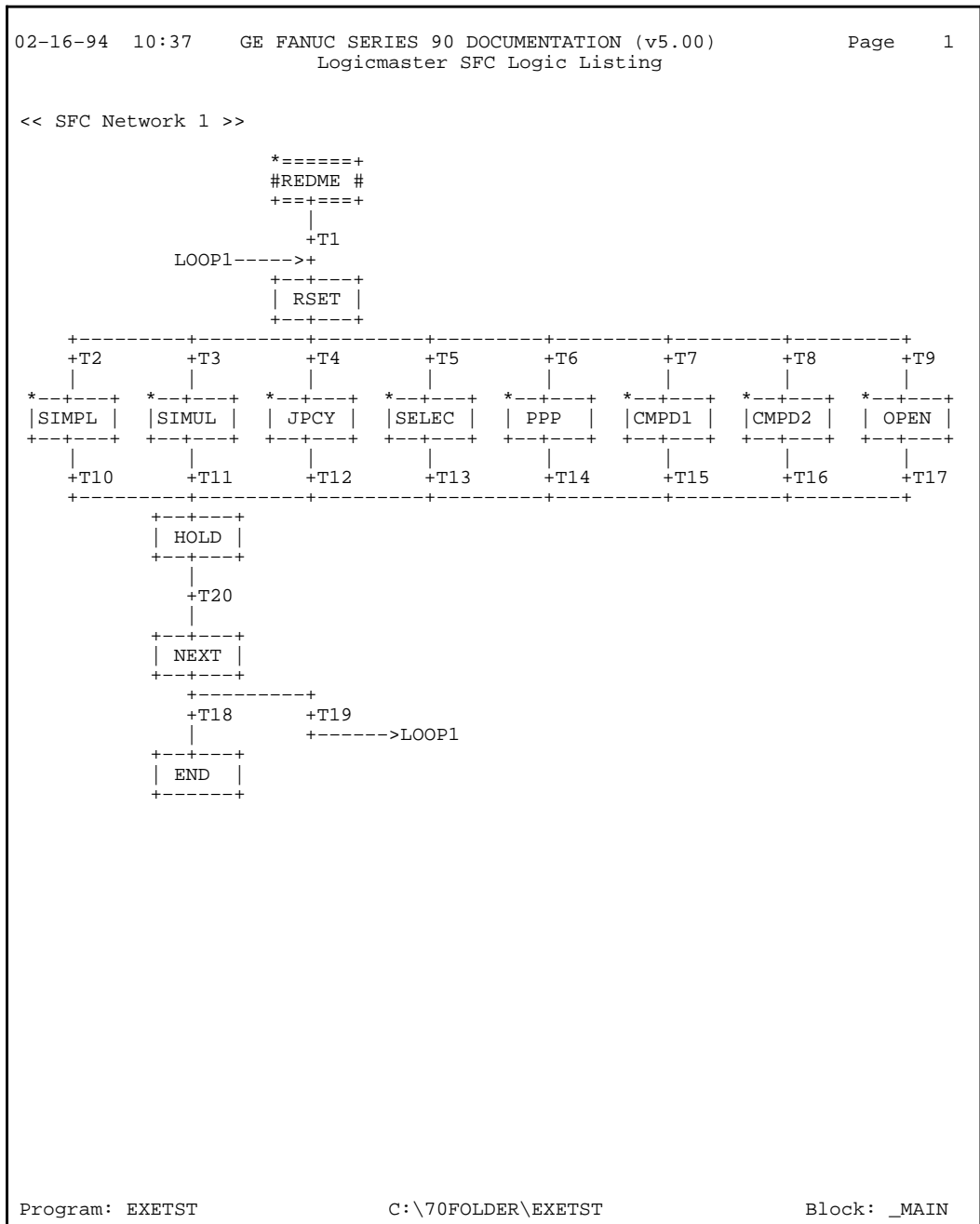
### Note

Chapter 10, "Print Functions," in the *Logicmaster 90-70 Programming Software User's Manual*, GFK-0263, or Chapter 9, "Print Functions," in the *Logicmaster 90-30 Programming Software User's Manual*, GFK-0466, contains descriptions of parameters to be set and options to be selected for your printout. Refer to the "Print Functions" chapter to help you complete the appropriate software Print Function screens.

The following table describes what is printed on each of the following sample pages, beginning on page 4-3.

Printed Page	Description
SFC Network	The SFC network is identified with a label in the form <<SFC network 1>>, similar to the <<RUNG 1>> label used on Relay Ladder Diagram rungs. This label is repeated at the top of every page of SFC topology logic printed for the network.
Preprocessing and Postprocessing Logic	Preprocessing and postprocessing Relay Ladder Diagram logic is printed after the network topologies and before the Relay Ladder Diagram logic of the first action.
Step Logic	The step logic listing, an expansion of each step into its relay ladder diagram logic, follows the preprocessing and postprocessing Relay Ladder Diagram logic. Any step comment text associated with the step will be printed before the step's logic.
Transition Logic	The transition logic section of the printout contains the relay ladder diagram logic for every transition associated with the sequential function chart. Transition logic is printed after the logic of all the steps.
Block Cross References	<p>Block cross references are printed immediately after the logic for the block. The cross references include the name of the step or transition, the rung number, and the instruction where each reference is used. The step or transition name is printed inside angle brackets, such as &lt;STEP1&gt;. The list of rung numbers following a step or transition name includes the rungs in which the reference is used on the indicated instruction within the step or transition. Since each step can appear in only one SFC network, a step can be quickly located by scanning the listing of each network.</p> <p>The block identifier cross reference table includes cross reference information for the step.x, step.f, and step.t variables and transition names. Since step names and transitions are local to the SFC block in which they are used, step variables and transition names are not included in the global identifier cross reference table.</p> <p><b>Note:</b> References that are found in the preprocessing or post processing logic associated with an SFC block are noted as being in a "step" &lt;_PRE&gt; or &lt;_POST&gt;, respectively (see example below).</p>
Global Cross References	Global cross references include the block name, step or transition name, rung number, and instruction for each reference address or identifier used in the program.
Table of Contents	Each section of the printout has an entry in the table of contents, which is printed at the end of the listing.

# Sample SFC Network Page







# Sample Step Logic Page

```

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                    Logicmaster SFC Logic Listing

***** EXPANSION OF STEP REDME *****

[ START OF ACTION FOR STEP REDME ]

<< RUNG 1 >>

+-----+             +-----+
+-----+MOVE_+-----+MOVE_+
|         |         |         |
|         |         |         |
|         |         |         |
+-----+IN Q+   PATH   +-----+IN Q+   BASE
+00000 |   LEN   |         +00700 |   LEN   |
|         |         |         |
|         |         |         |
+-----+         +-----+

<< RUNG 2 >>

----- CONT
----- (S)-----

<< RUNG 3 >>

----- DONE
----- (R)-----

[ END OF ACTION ]

***** EXPANSION OF STEP RSET *****

(*****
(* This step calls a program block which clears all of the registers used *)
(* in the program. *)
(*****

[ START OF ACTION FOR STEP RSET ]

<< RUNG 1 >>

+-----+             CONT
+-----+CALL CLEAR +-----+(R)-----
+-----+

[ END OF ACTION ]

Program: EXETST           C:\70FOLDER\EXETST           Block: _MAIN

```



# Sample Page of Block Cross References

```

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                Logicmaster SFC Logic Listing

===== INTERNAL (%M) CROSS REFERENCES =====
=====
REF.      NICKNAME  REF. DESCRIPTION / CROSS REFERENCES
-----
%M00001  NOHLT      If set to 1, no halting/test
          -] [- <HOLD> 2
%M00002  DONE      Indicate the end of testing
          -(S) <END> 1
          -(R) <REDME> 3

===== TEMPORARY (%T) CROSS REFERENCES =====
=====
REF.      NICKNAME  REF. DESCRIPTION / CROSS REFERENCES
-----
%M00001  CONT      Continuation flag
          -] [- <T10> 1 <T11> 1 <T12> 1 <T13> 1 <T14> 1 <T15> 1
          <T16> 1 <T17> 1 <T20> 1 <HOLD> 1
          -(S) <REDME> 2 <OPEN> 1 <HOLD> 2
          -(R) <RSET> 1 <HOLD> 1

===== REGISTER (%R) CROSS REFERENCES =====
=====
REF.      NICKNAME  REF. DESCRIPTION / CROSS REFERENCES
-----
%M00001  BASE      Base address of DEVLIB table
          FBIO <REDME> 1
%M00004  PATH      Execution path selection
          FBIO <T2> 1 <T3> 1 <T4> 1 <T5> 1 <T6> 1 <T7> 1 <T8> 1
          <T9> 1 <T18> 1 <T19> 1 <REDME> 1 <NEXT> 1

===== IDENTIFIER NAME CROSS REFERENCES =====
=====
IDENTIFIER REF. DESCRIPTION / CROSS REFERENCES
-----
T1         -( ) <T1> 1
T2         -( ) <T2> 1
T3         -( ) <T3> 1
T4         -( ) <T4> 1
T5         -( ) <T5> 1
T6         -( ) <T6> 1
T7         -( ) <T7> 1
T8         -( ) <T8> 1
T9         -( ) <T9> 1
T10        -( ) <T10> 1
T11        -( ) <T11> 1
T12        -( ) <T12> 1
T13        -( ) <T13> 1
T14        -( ) <T14> 1
T15        -( ) <T15> 1
T16        -( ) <T16> 1

Program: EXETST                C:\70FOLDER\EXETST                Block: _MAIN

```

### Sample Page of Global Cross References

```

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                Logicmaster SFC Logic Listing

=====
===== INTERNAL (%M) GLOBAL CROSS REFERENCES
=====
REF.      BLOCK  NICKNAME  REF. DESCRIPTION / CROSS REFERENCES
-----
%M00001  _MAIN  NOHLT    If set to 1, no halting/test
                -] [- <HOLD> 2
%M00002  _MAIN  DONE     Indicate the end of testing
                -(S) <END> 1
                -(R) <REDME> 3

=====
===== TEMPORARY (%T) GLOBAL CROSS REFERENCES
=====
REF.      BLOCK  NICKNAME  REF. DESCRIPTION / CROSS REFERENCES
-----
%M00001  _MAIN  CONT     Continuation flag
                -] [- <T10> 1 <T11> 1 <T12> 1 <T13> 1 <T14> 1
                <T15> 1 <T16> 1 <T17> 1 <T20> 1 <HOLD> 1
                -(S) <REDME> 2 <OPEN> 1 <HOLD> 2
                -(R) <RSET> 1 <HOLD> 1
                RST_MSG      -(S) <S13> 3
                RACKGEN      -(S) <S10> 3
                RESET        -(S) <S3> 4
                CBASE        -(S) <S7> 4
                CNVCTRL      -(S) <S5> 4
                GOTSG        -(S) <S5> 4
                ALLSTOP      -(S) <S3> 4
%M00002  RST_MSG  NO-ERR   Error status flag
                -]/[- <S1> 2 <S2> 3,6,9 <S3> 2 <S8> 2 <S4> 2
                <S6> 2 <S11> 2 <S7> 2 <S12> 2 <S5> 2<S9> 2
                <S13> 2
                -( ) <S1> 1 <S2> 2,5,8 <S3> 1 <S8> 1 <S4> 1
                <S6> 1 <S11> 1 <S7> 1 <S12> 1 <S5> 1<S9> 1
                <S13> 1
                RACKGEN      -]/[- <S1> 2 <S2> 3,6 <S3> 2 <S4> 2 <S5> 2<S6> 2
                <S7> 2 <S8> 2 <S9> 2 <S10> 2
                -( ) <S1> 1 <S2> 2,5 <S3> 1 <S4> 1 <S5> 1<S6> 1
                <S7> 1 <S8> 1 <S9> 1 <S10> 1
                RESET        -]/[- <S1> 2 <S2> 2 <S3> 3
                -( ) <S1> 1 <S2> 1 <S3> 2
                CBASE        -]/[- <S1> 3 <S2> 2,4,6 <S3> 2 <S4> 2 <S5> 2
                <S6> 2 <S7> 3
                -( ) <S1> 2 <S2> 1,3,5 <S3> 1 <S4> 1 <S5> 1
                <S6> 1 <S7> 2
                CNVCTRL      -]/[- <S1> 3 <S2> 2 <S3> 2 <S4> 2 <S5> 3
                -( ) <S1> 2 <S2> 1 <S3> 1 <S4> 1 <S5> 2
                GOTSG        -]/[- <S1> 3 <S2> 2 <S3> 2 <S4> 2 <S5> 3
                -( ) <S1> 2 <S2> 1 <S3> 1 <S4> 1 <S5> 2
                ALLSTOP      -]/[- <S1> 3 <S2> 2 <S3> 3
                -( ) <S1> 2 <S2> 1 <S3> 2

Program: EXETST      C:\70FOLDER\EXETST      Global Cross Reference Tables

```

REF.	BLOCK	NICKNAME	REF.	DESCRIPTION / CROSS REFERENCES
%G00177	RST_MSG		FBIO	<S1> 1 <S13> 1
	RACKGEN		FBIO	<S1> 1 <S10> 1
	CNVCTRL		FBIO	<S1> 1
%G00185	RESET		FBIO	<S1> 1 <S3> 2
	CNVCTRL		FBIO	<S5> 1

=====

=

===== IDENTIFIER NAME GLOBAL CROSS REFERENCES

=====

IDENTIFIER	BLOCK	REF.	DESCRIPTION / CROSS REFERENCES
FAULT	RST_MSG	CALL	<S1> 1 <S13> 1
	RACKGEN	CALL	<S1> 1 <S10> 1
	RESET	CALL	<S1> 1 <S3> 2
	CBASE	CALL	<S1> 1 <S7> 2
	CNVCTRL	CALL	<S1> 1 <S5> 2
	GOTSG	CALL	<S1> 1 <S5> 2
	ALLSTOP	CALL	<S1> 1 <S3> 2
ESET	RST_MSG	CALL	<S3> 1 <S8> 1 <S4> 1 <S6> 1 <S11> 1 <S7> 1 <S12> 1 <S5> 1 <S9> 1
	RACKGEN	CALL	<S3> 1 <S4> 1 <S5> 1 <S6> 1 <S7> 1 <S8> 1
	CBASE	CALL	<S3> 1 <S4> 1 <S5> 1
	CNVCTRL	CALL	<S2> 1 <S3> 1 <S4> 1
	GOTSG	CALL	<S2> 1 <S3> 1 <S4> 1
	ALLSTOP	CALL	<S2> 1
	ECHCK	RACKGEN	CALL
ASSERT	CBASE	CALL	<S6> 1
	CNVCTRL	CALL	<S5> 1
	GOTSG	CALL	<S5> 1
	ALLSTOP	CALL	<S3> 1
	RST_MSG	CALL	<S2> 1,4,7
ADDSSERT	RACKGEN	CALL	<S2> 1,4
	CBASE	CALL	<S2> 1,3,5
	CNVCTRL	CALL	<S1> 2
	GOTSG	CALL	<S1> 2
	ALLSTOP	CALL	<S1> 2
RESET	RST_MSG	CALL	<S2> 2,5,8
	RACKGEN	CALL	<S2> 2,5
CLEAR	_MAIN	CALL	Pre & Post Processing
	_MAIN	CALL	Clear fault tables
STOP	_MAIN	CALL	<RSET> 1
	RST_MSG	CALL	Stop the PLC
		CALL	<S1> 2 <S2> 3,6,9 <S3> 2 <S8> 2 <S4> 2 <S6> 2 <S11> 2 <S7> 2 <S12> 2 <S5> 2 <S9> 2 <S13> 2
	RACKGEN	CALL	<S1> 2 <S2> 3,6 <S3> 2 <S4> 2 <S5> 2 <S6> 2 <S7> 2 <S8> 2 <S9> 2 <S10> 2
	RESET	CALL	<S1> 2 <S2> 2 <S3> 3
	CBASE	CALL	<S1> 3 <S2> 2,4,6 <S3> 2 <S4> 2 <S5> 2 <S6> 2 <S7> 3
	CNVCTRL	CALL	<S1> 3 <S2> 2 <S3> 2 <S4> 2 <S5> 3

# Sample Table of Contents Page

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In general, anything that would be an error in a relay ladder diagram logic block will also be an error in the relay ladder diagram portion of a sequential function chart logic block. In addition, there are several global checks made over an entire relay ladder diagram logic block, including missing labels, backward MCR jumps, missing END\_FORs, and too many program block calls. These types of global checks are also applied individually to each relay ladder diagram section of an SFC block. For example, every action logic section must have a matching label for each unique jump within that section of relay ladder diagram logic. The only exception is the check on the number of program block calls. For a sequential function chart block, the check is made over the entire SFC block, not the individual relay ladder diagram logic sections.

This appendix describes error conditions that are unique to sequential function chart logic blocks and to the ladder diagram logic found within them. It does not include ladder diagram errors that are common to ladder diagram logic in both ladder diagram blocks and SFC blocks.

## General Errors

The following errors will be detected while entering a relay ladder diagram rung:

- Reference to a transition variable name outside the relay ladder diagram transition logic for the variable.
- Attempting to write to a step.x or step.f flag.
- Attempting to write to a step.t value.



## Transition Logic Errors

The following error conditions will be detected when you press the **Escape** key to exit from a transition logic section. The block will remain unexecutable until these errors are corrected.

- Transition variable was not set.
- More than one regular rung.
- Less than one regular rung.

## Transition Logic, Step Action Logic, and Preprocessing/Postprocessing Logic Errors

The following error conditions will be detected when you press the **Escape** key to exit from a transition logic section, an action logic section, or a preprocessing or postprocessing logic section. The SFC block will remain unexecutable until these errors are corrected.

- A Jump/label name is used in another relay ladder diagram logic section in this block.
- An MCR/END\_MCR name is used in another relay ladder diagram logic section in this block.

The following error conditions **must** be corrected immediately:

- A backwards MCR jump.
- Too many nested FORs.
- Too many EXIT\_FORs.
- Attempting to flow more than 16 bytes of data between function blocks (instructions). You can use registers on the output of one function block and the input of the next function block (instruction) instead.

## General SFC Element Errors

The following errors will be detected at entry and must be corrected immediately:

- Attempting to enter a step, transition, or connector in the wrong row.
- Attempting to cursor off a connector before naming it.
- For the 90-70, attempting to add more than 255 steps, 383 transitions, or 255 unique connectors. For the 90-30, attempting to add more than 95 steps, 95 transitions, or 255 unique connectors.
- Attempting to extend the SFC network beyond 128 rows or 8 columns.

## SFC Top-Level Errors

The following errors can occur at the main level of the SFC network. They will be detected as you press the **Escape** key from that level. The block will remain unexecutable until they are corrected.

- Two transitions directly connected.
- Two steps directly connected.
- Transition not preceded by a step.
- Transition not followed by a step or source connector.
- Step and source connector directly connected.
- Disconnected SFC segments. Two or more sections of SFC networks are not connected by vertical links, horizontal branches, or connectors.
- Mismatched adjoining branch segments. A selective branch segment adjoins as a parallel branch segment.
- Incomplete start of a simultaneous branch. You must have a transition as well as a simultaneous branch.
- Incomplete end of a simultaneous branch. You must have a transition as well as a simultaneous branch.
- Incomplete start of a selective branch. You must have a transition as well as a selective branch.
- Incomplete end of a selective branch. You must have a transition as well as a selective branch.
- More than one initial step.
- Initial step occurs inside a simultaneous control structure.
- Step or transition appears more than once in the SFC network.
- Missing destination connector.
- Multiple occurrences of the same destination connector.
- Missing source connector. (This is just a warning; it does not have to be corrected.)
- Source and destination connectors are not allowed within a simultaneous control structure.
- More than 32 parallel branches within one control structure.
- Improper nesting of control structures. A simultaneous structure is required to be closed, that is, it must converge; and it must be closed in reverse order of its opening.
- Directed link in SFC diverges into two paths without the use of a divergent control structure.

In addition to catching the errors that occur at the main level of the sequential function chart when you press the **Escape** key from the editor, all errors at all other levels of the SFC block will also be detected. A message about the first error encountered will be displayed in the message box. You can choose to correct the error at this time, or you may continue to exit the editor. Most of the errors listed here will cause the block to be designated “non-executable.” This means that the block can be stored, but the errors must be corrected before the logic can be stored to the PLC.

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