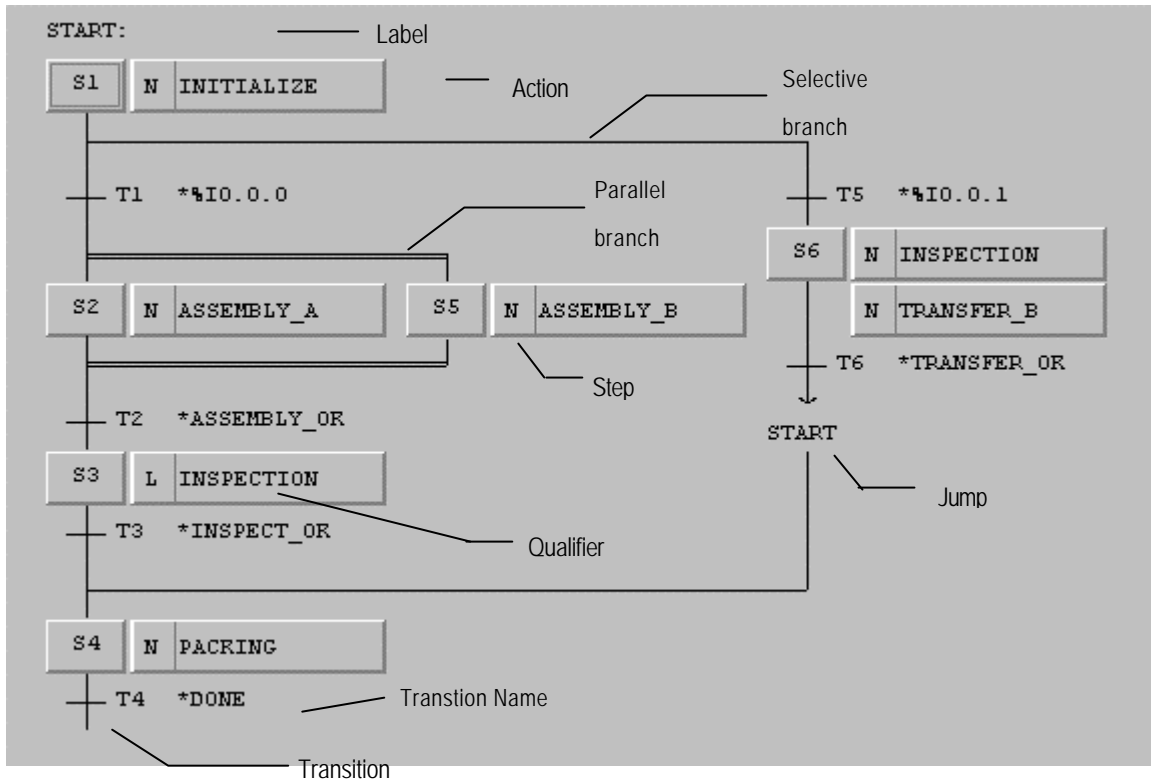


### 5.7. Edit SFC

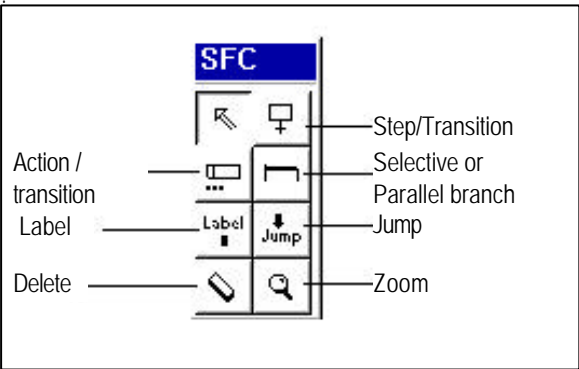
SFC supports the method that divides a PLC language (IL,LD) into step and transition according to the execution order. SFC consists of the following elements.



#### Note

In case of executing the automatic control of a machine with PLC, SFC (Sequential Function Chart) is the most optimal structural programming method.

SFC Toolbox.



	Step	Indicates the unit of a sequence control with connecting to action
	Transition	Indicates the condition for executing from an active step to next step
	Selective Branch	The executing flow is determined by executive condition
	Parallel Branch	Used to control several sequences simultaneously
	Label	The position where an executive flow start by jump
	Jump	Used to change an executive flow
	Action	Indicates an executing content in the specified step

Select the element to insert and click the left button of the mouse on a desired position.

5.7.1. Create a Step/Transition

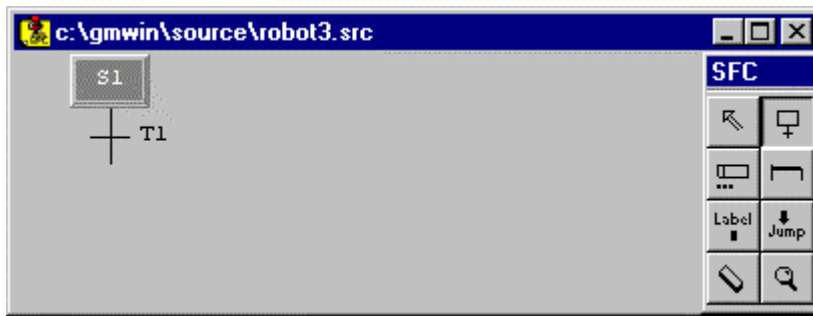
Step/Transition or Transition/Step is created in pairs by current position.



- ◆ Initial screen of SFC program is as below.



- ◆ Select ( ) in toolbox.
- ◆ Move the muse to the position marked , then ( ) symbol appears in the screen.
- ◆ Click the left button of mouse on the position marked .



New Step/Transition is created on the position marked .





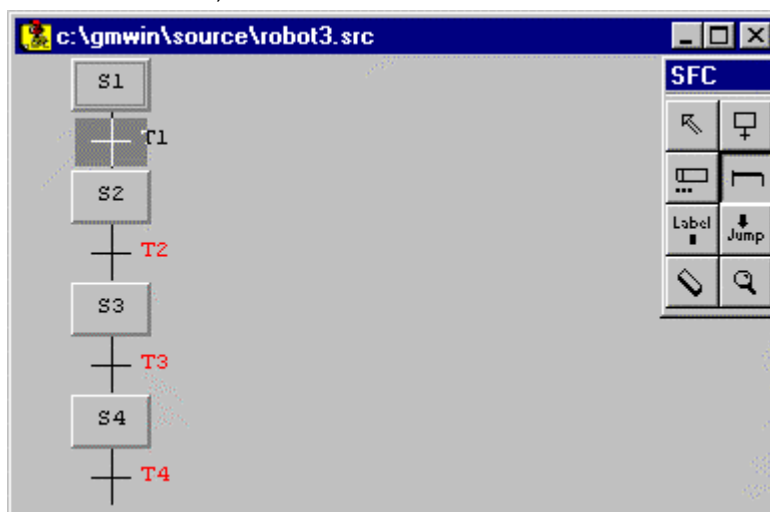
- ◆ Move the cursor with key to the position that you want to creates step/transition.
- ◆ Select **Toolbox-Step(F2)**.

### 5.7.2. Create a Parallel Branch

- 1) To create a parallel branch for the first time

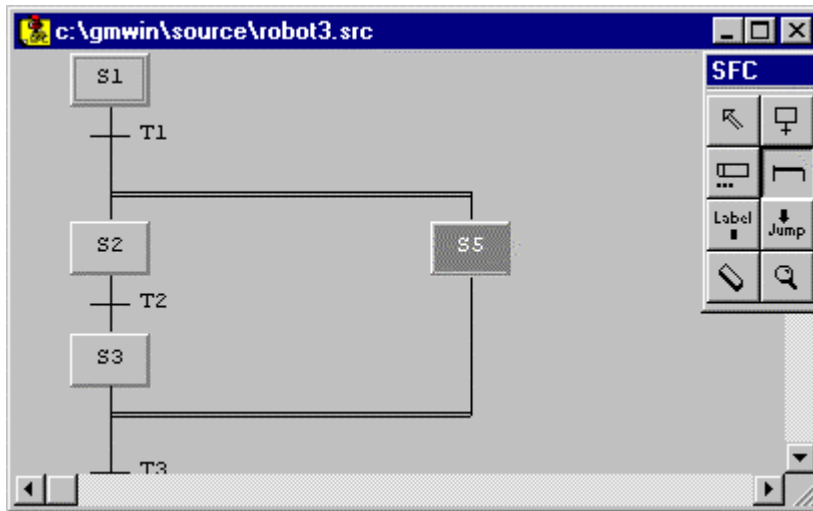


- ◆ Select (  ) in toolbox and move the mouse to the transition(T1) where branch starts and click a left button (You can see a mark ).



- ◆ Transition (T2,T3,T4) are active in red.

- ◆ Move the mouse to the transition (T3) where branch ends and click a left button.




- ◆ Parallel branch and new step (S5) are created.

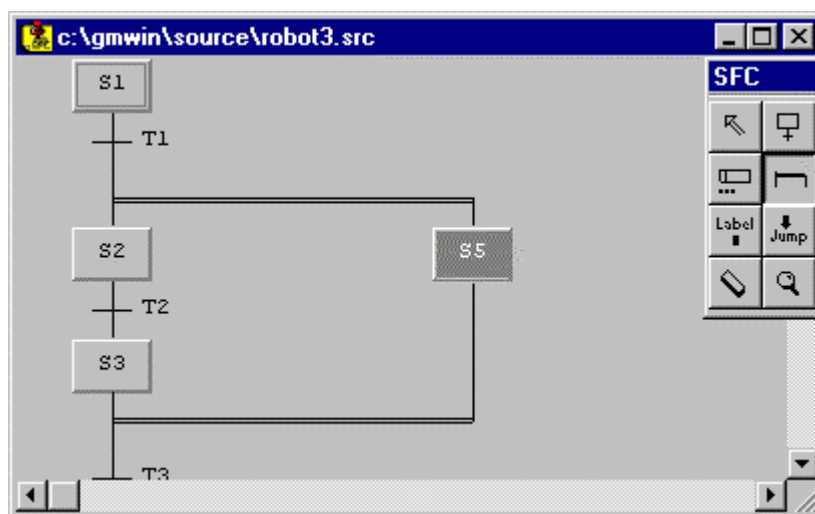


- ◆ Move the cursor to the transition where branch starts with key.
- ◆ Select **Toolbox-Branch(F3)**.
- ◆ Move the cursor to the transition where branch ends with key.
- ◆ Select **Toolbox-Branch(F3)**.

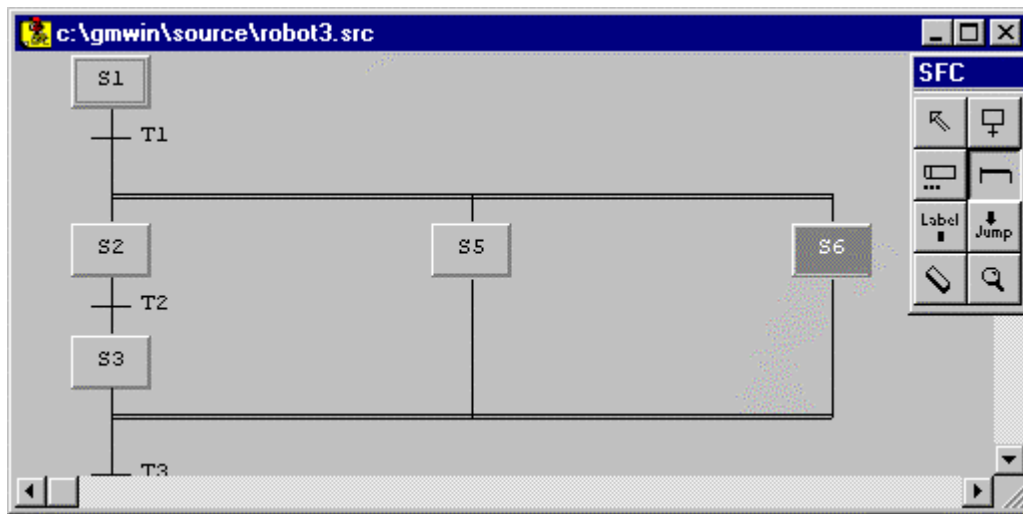
## 2) To expand a parallel branch



- ◆ Select (  ) in toolbox .
- ◆ Move the mouse to the start position of the parallel branch and click a left button.



- ◆ Parallel branch and new step (S6) are created.





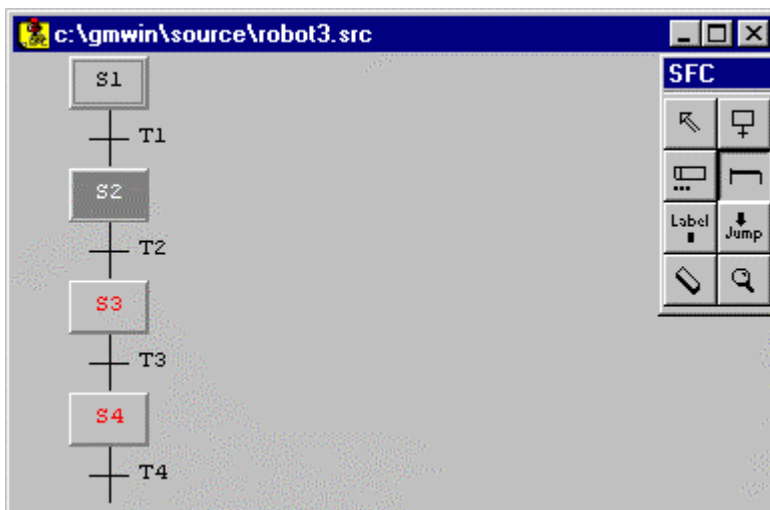
- ◆ Move the cursor to the start position of a parallel branch where you want to insert a branch with key.
- ◆ Select **Toolbox-Branch(F3)**.

### 5.7.3. Create a Selective Branch

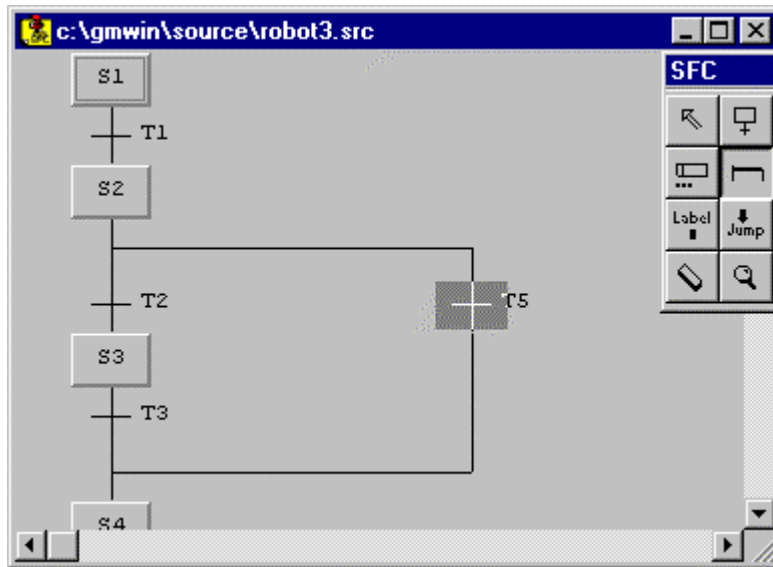
- 1) To create a selective branch initially.



- ◆ Select (  ) in toolbox and move the mouse to the step(S2) where branch starts and click a left button (You can see a mark ).



- ◆ Steps(S3,S4) are active in red.
- ◆ Move the mouse to the step(S4) where branch ends and click a left button.




- ◆ Selective branch and new transition (T5) are created.

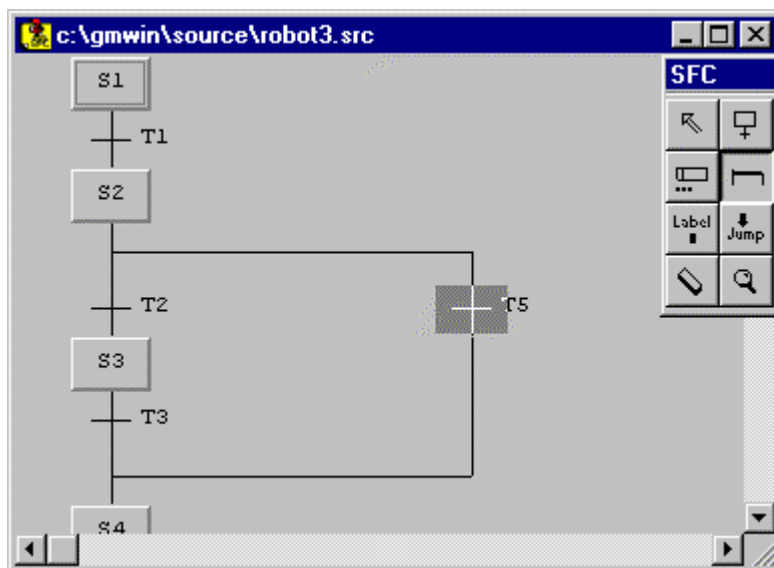


- ◆ Move the cursor to the step where branch starts with key.
- ◆ Select **Toolbox-Branch(F3)**.
- ◆ Move the cursor to the step where branch ends with key.
- ◆ Select **Toolbox-Branch(F3)**.

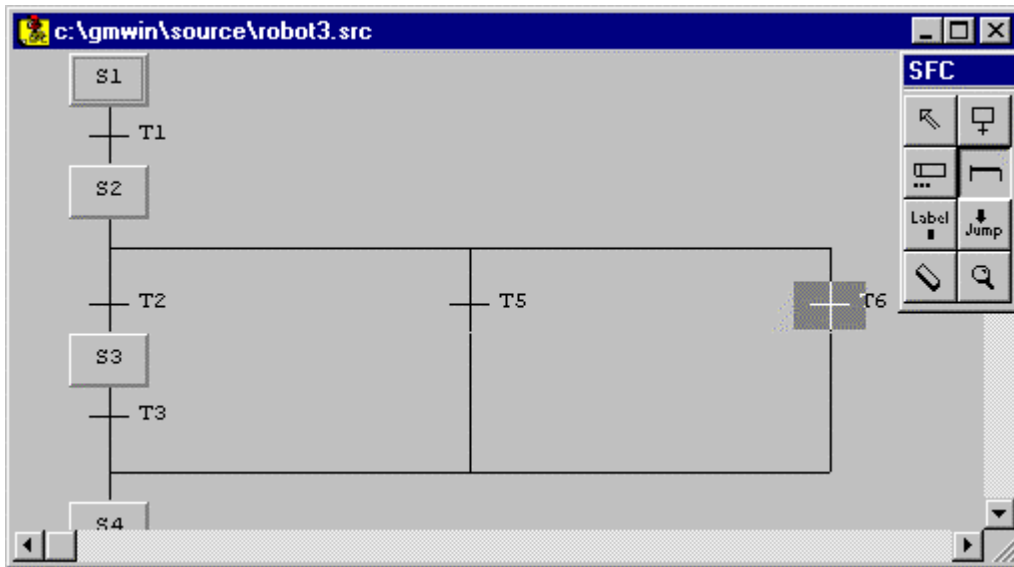
## 2) To expand a selective branch



- ◆ Select (  ) in toolbox.
- ◆ Move the mouse to the start position of a selective branch and click a left button.





- ◆ Selective branch and new transition (T6) are created.

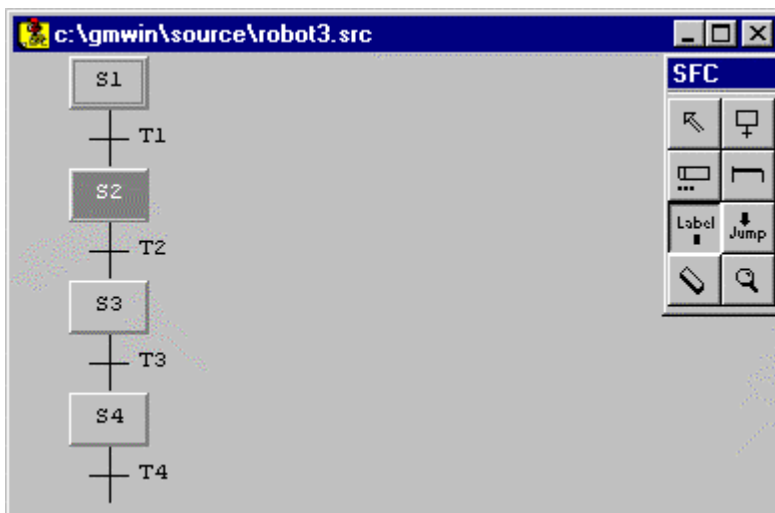


- ◆ Move the cursor to the start position of a selective branch where you want to insert a branch with key.
- ◆ Select **Toolbox-Branch(F3)**.

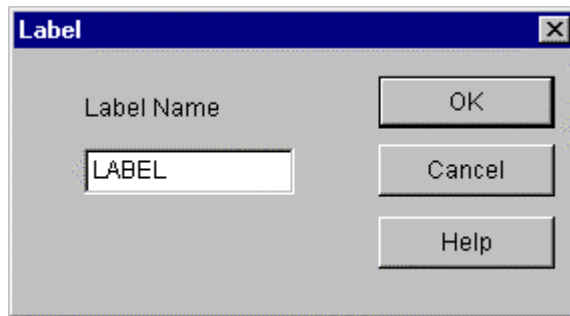
### 5.7.4. Create a Label



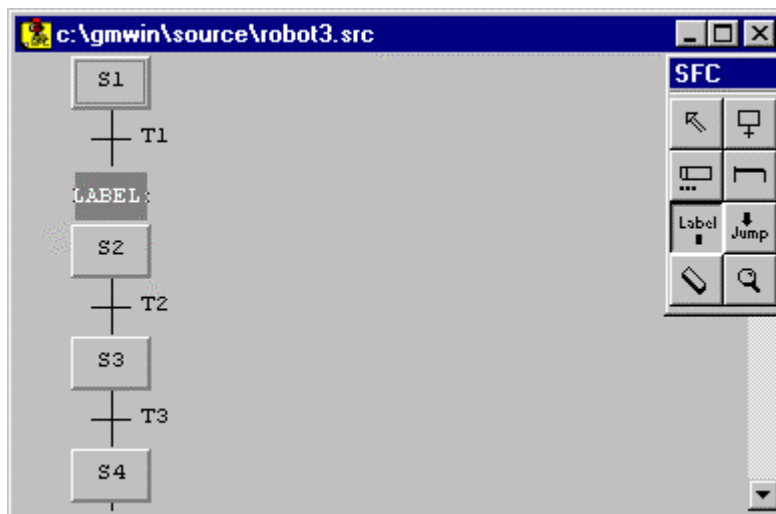
- ◆ Select (  ) in toolbox.
- ◆ Move the mouse to the step (is marked with  ABC;) and click a left button.



- ◆ Input a label name in **Label** dialog box and click **OK** button.
- ◆ Maximum size of a label name is 10 characters.



- ◆ Create a label



#### Note


Label is only inserted in the front of Step.



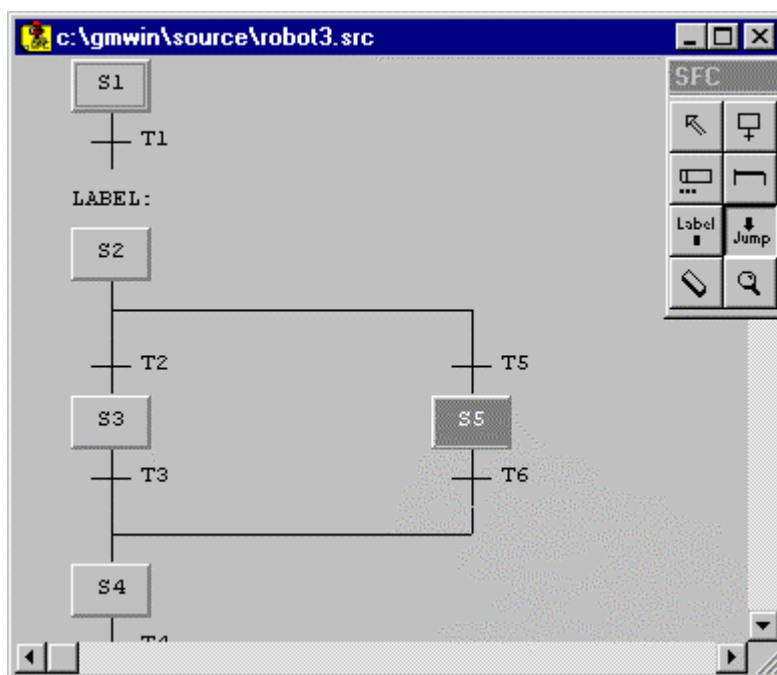
- ◆ Move a cursor to the step with key.
- ◆ Select **Toolbox-Label(F5)**.
- ◆ Input a label name in **Label** dialog box and click **OK** button.

#### 5.7.5. Create a Jump



- ◆ Select (  ) in toolbox.
- ◆ Move the mouse to a desired position (is marked with (  ) for jump and click a left button.





- ◆ Enter the jump name in **Jump** dialog box and click **OK** button.

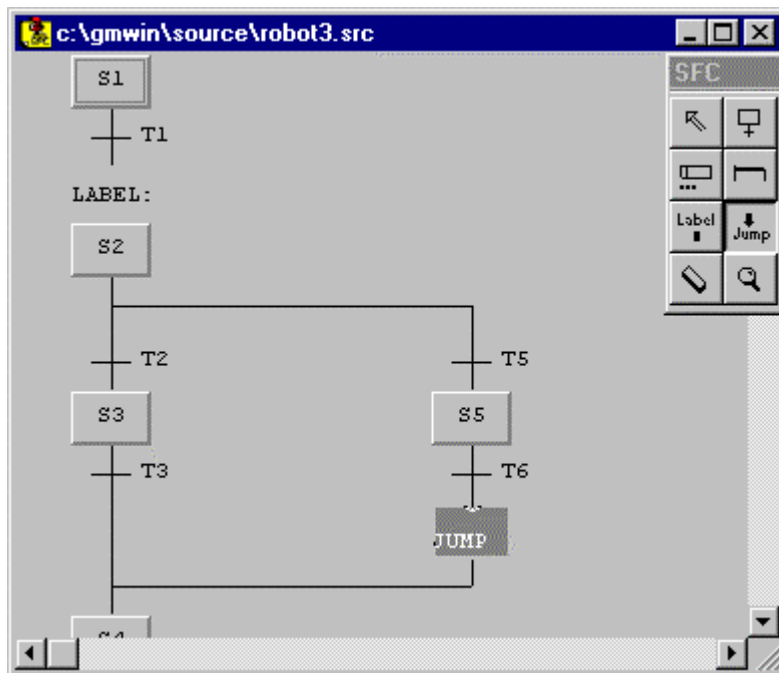
The 'Jump' dialog box is shown. It has a title bar with 'Jump' and a close button. Inside, there are two text input fields. The first is labeled 'Jump Name' and contains the text 'JUMP'. The second is labeled 'Label Used' and contains the text 'LABEL'. To the right of these fields are three buttons: 'OK', 'Cancel', and 'Help'.


- ◆ Maximum size of the jump name is 10 characters.

### Note

Available position for Jump

- Transition at the end of the selective branch
- Transition at the last end of SFC program




- ◆ Move a cursor to a desired position (is marked with  ABC) for jump with key.
- ◆ Select **Toolbox-Jump(F6)**.
- ◆ Enter the jump name in **Jump** dialog box and click **OK** button.

### 5.7.6. Create an Action

To connect an action to a step.



- ◆ Select (  ) in toolbox.
- ◆ Move the mouse to a step and click a left button.



- ◆ Move the cursor to the step with key.

The 'Action' dialog box is shown with the following fields and controls:

- Kind:** Radio buttons for 'Program' (selected) and 'Variable'.
- Name:** A text input field.
- Comment:** A text input field.
- List:** A list box with columns 'Name' and 'Kind'. A 'Flag' button is located to the right of the list box.
- Qualifier:** A dropdown menu currently showing 'N(Non-stored)'.
- Time:** A text input field.
- Buttons:** 'OK', 'Cancel', and 'Help' at the bottom.

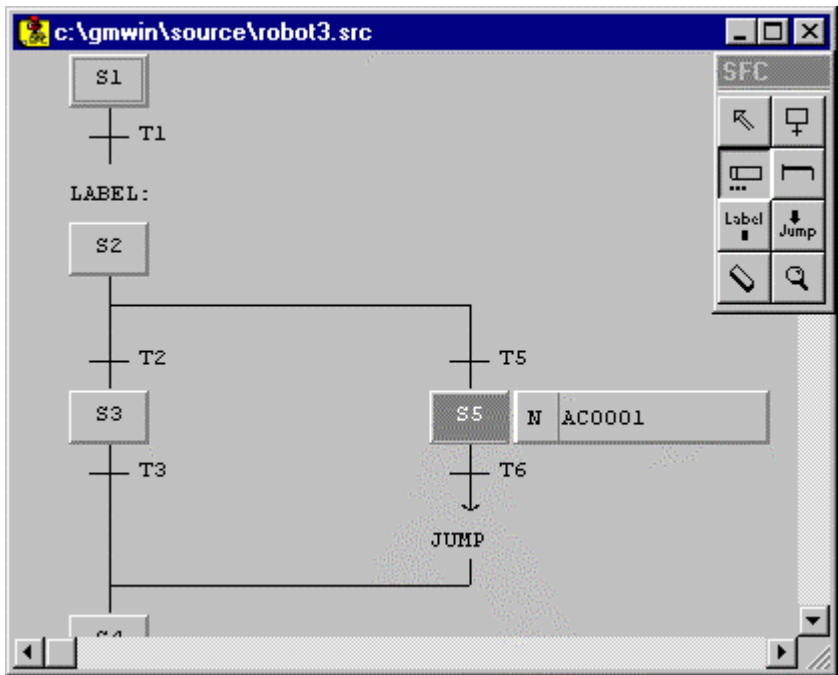
- ◆ Select **Toolbox-Action/Transition(F4)**.
- ◆ Select whether you setup an action as a program or as a Boolean variable output in **Kind** radio button of **Action** dialog box.  
If you setup an action as a variable output, the designated variable is outputted as ' 1 ' when the action is in active.

### 1) In case of setting up an action as a program

- ◆ Enter the variable name in the **Name** edit box (maximum size is 16 characters).  
When you want to connect an already used action, select the action in list box.
- ◆ Enter the comment for the action in the **Comment** edit box (maximum size is 40 characters).

### 2) In case of setting up an action as a variable

- ◆ Enter the variable name in the **Name** edit box (maximum size is 16 characters).  
When you want to connect an already declared variable, select the variable in list box. Select a desired qualifier in **Qualifier** list box.
- ◆ If the selected qualifier has a time value (D,L,SD,SL,DS), enter the time value in the **Time** edit box.  
Example) T#10s.
- ◆ click **OK** button.




### 3) Kind and Function of Qualifier

Symbol	Function	<div>Step: Active Condition</div>
N(Non-stored)	Action is executed while Step is in active.	
R(overriding Reset)	R(overriding Reset) makes stopping the execution of action executed by qualifier(S,SD,DS,SL) before.	
S(Set)	After Step is in active, an action is executed until R qualifier acts.	
L(time Limited)	After Step is in active, an action is executed as long as setting time.	
D(time Delayed)	After Step is in active, the execution of action is delayed as long as setting time.	
P(Pulse)	Action is executed at the only moment when Step is in active.	
SD(stored & time Delay)	After Step is in active, an action is executed after the lapse of setting time until R qualifier acts. If the R qualifier, However, acts before the lapse of setting time, the action is not executed.	
DS(Delayed & stored)	After Step is in active, an action is executed after the lapse of setting time until R qualifier acts. But, if the step is in passive or the R qualifier acts before the lapse of setting time, the action is not executed.	
SL(stored & time Limited)	After Step is in active, an action is executed as long as setting time, and when the setting time elapses or R qualifier acts, the action is stopped.	

### 5.7.7. Create a Transition

To connect Name to Transition.



- ◆ Select (  ) in toolbox.
- ◆ Move the mouse to a transition and call a transition dialog box by clicking a left button.



- ◆ Move the cursor to a transition with key .
- ◆ Select **Toolbox-Action/Transition(F4)**.

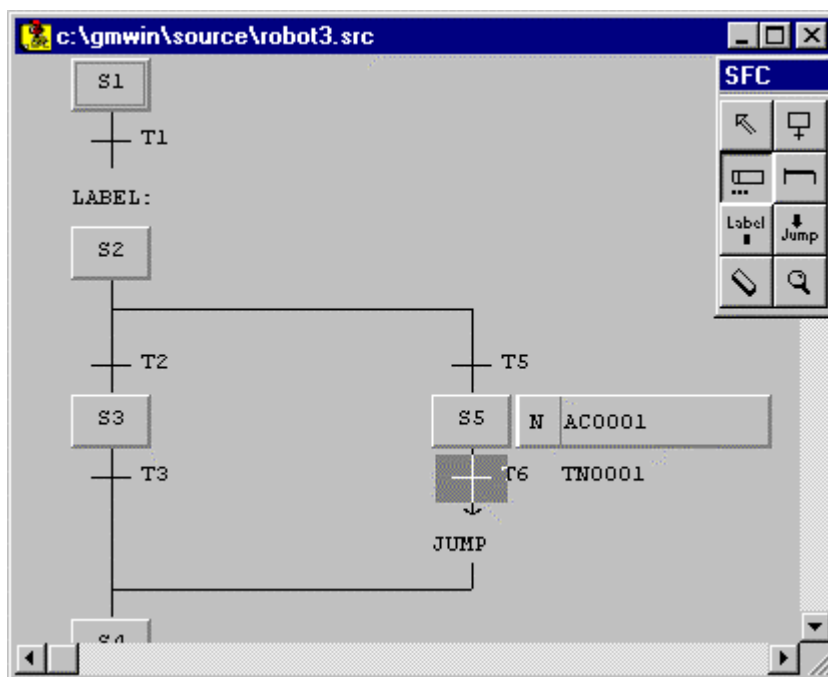
- ◆ Select whether you setup an executive condition as a program or as a Boolean variable in **kind** button of **Transition** dialog box.

1) In case of setting up Transition as a program,

- ◆ Enter the transition name in the **Name** edit box(maximum size is 16 characters).  
When you want to connect the already declared transition, select the transition in list box.
- ◆ Enter the comment for the transition in the **Comment** edit box(maximum size is 40 characters).

2) In case of setting up Transition as a variable,


- ◆ Enter the transition name in the **Name** edit box(maximum size is 16 characters).  
When you want to connect the already declared variable, select the variable in list box.
- ◆ Enter the comment for the transition in the **Comment** edit box(maximum size is 40 characters).
- ◆ Click **OK** button

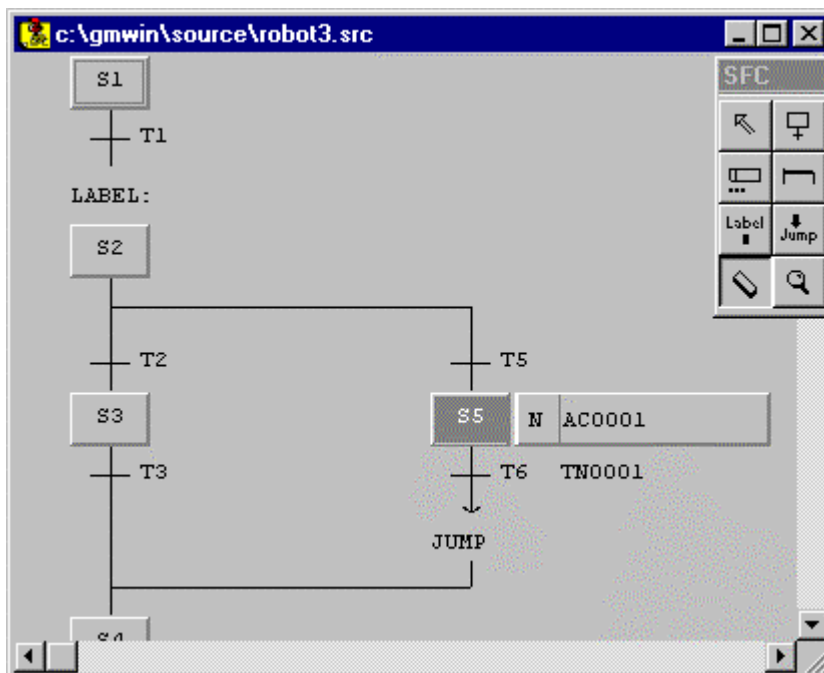


### 5.7.8. Delete

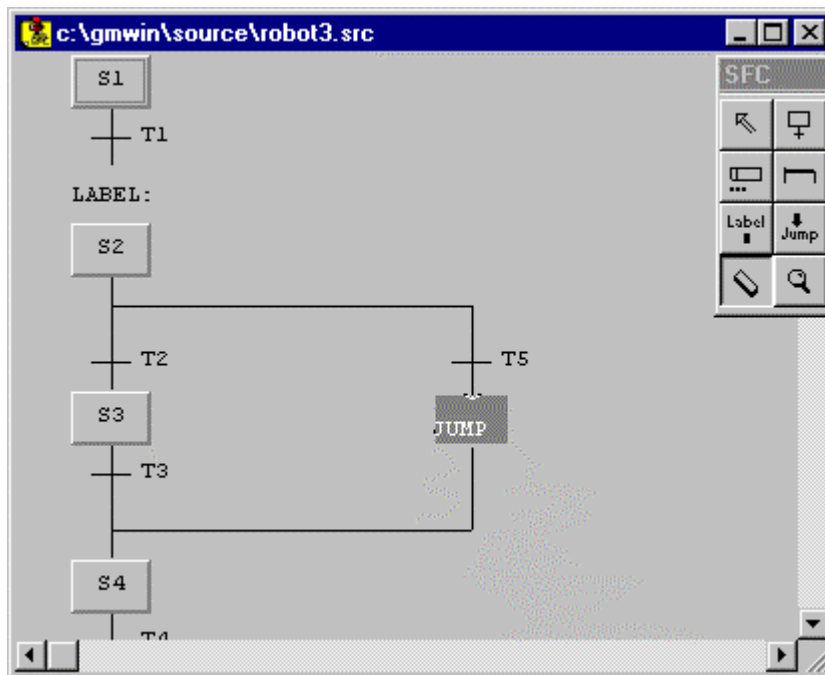
#### 1) Delete a Step/ Transition



- ◆ Select (  ) in toolbox.
- ◆ Move the mouse to the step or transition that you want to delete.



- ◆ Click the left button of the mouse.



- ◆ Move the cursor to a step or transition that you want to delete with key.
- ◆ Select **Edit-Delete**.



### Note

Although you delete a transition in SFC program, a transition program is not deleted.  
If you want to delete the program, you must delete it in transition list.  
(select **Program-Transition List**)

## 2) Delete a Branch

To delete the branch, All elements must be deleted before deleting a branch.  
Namely, there must be only Step(in case of parallel branch) or Transition (in case of selective branch) in branch

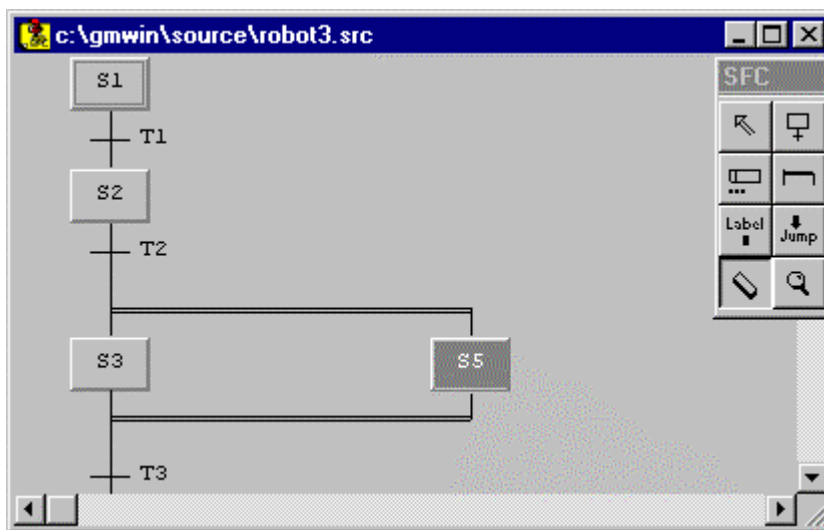


- ◆ Select (  ) in toolbox.
- ◆ Move the mouse to Step(in case of parallel branch, is marked with  ) or transition (in case of selective branch) in branch and click a left button.




- ◆ Move the cursor to a step (or transition) in the branch that you want to delete.
- ◆ Select **Edit-Delete**.





### 3) Delete a Label




- ◆ Select (  ) in toolbox.
- ◆ Move the mouse to the label that you want to delete and click a left button.



- ◆ Move the cursor to the label that you want to delete.
- ◆ Select **Edit-Delete**.

### 4) Delete a Jump




- ◆ Select (  ) in toolbox.
- ◆ Move the mouse to the Jump that you want to delete and click a left button.



- ◆ Move the cursor to the Jump that you want to delete with key.
- ◆ Select **Edit-Delete**.

### 5) Delete a Action



- ◆ Select (  ) in toolbox.
- ◆ Move the mouse to the Action that you want to delete and click a left button.



- ◆ Move the cursor to the Action that you want to delete with key.
- ◆ Select **Edit-Delete**.

#### Note

Although you delete an action in SFC program, an action program is not deleted. If you want


to delete the program, you must delete it in action list (select **Program-Action List**)

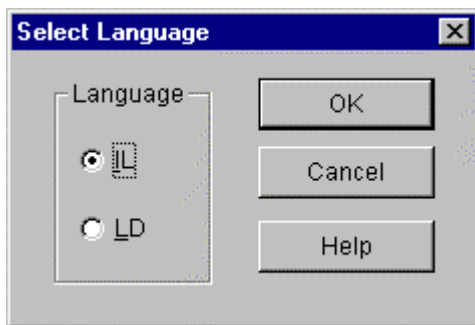
### 5.7.9. Zoom In Action/Transition

This Function is used for editing an action or transition program.

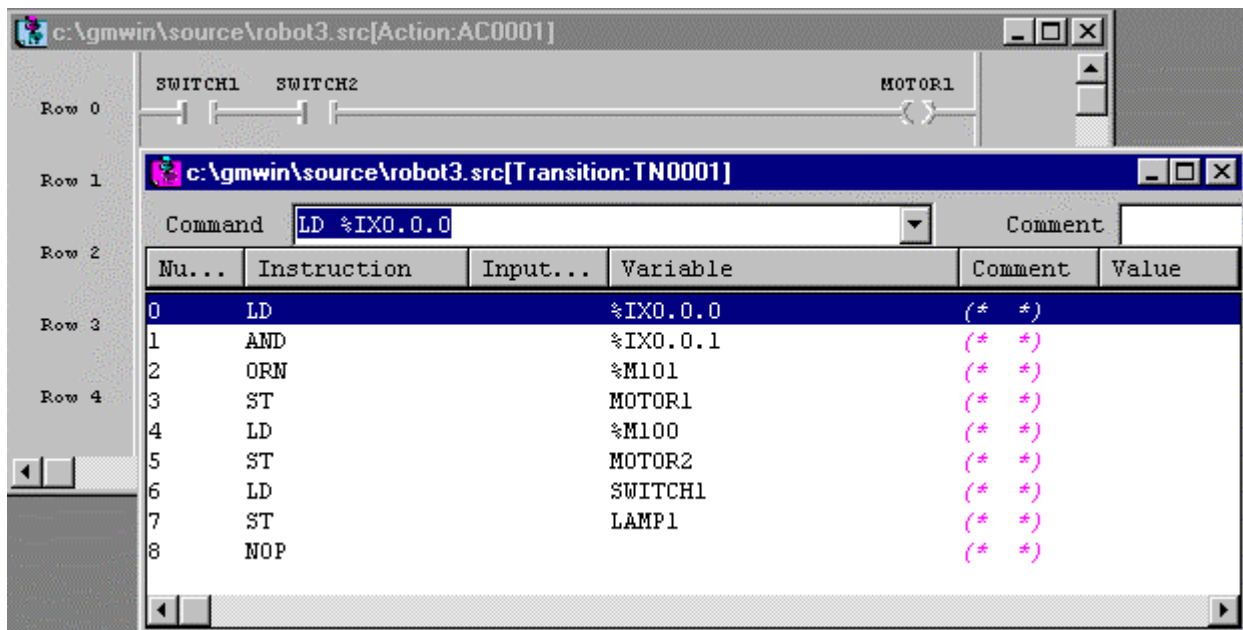
#### Note

A variable used in action or transition is commonly shared in other actions or transitions.

- ◆ Select (  ) in toolbox.
- ◆ Move the mouse to an action or transition and call a **Select language** dialog box by clicking a left button. At this time, if it is declared as a variable, you cannot zoom in.
- ◆ Selecting a language type is omitted for the action or transition that selected a program type before.



- ◆ Select a desired language type in **Language** option button of **Select Language** dialog box.
- ◆ Call the screen of making a program by clicking **OK** button, and create a program.
- ◆ When you edit a transition, the execution condition must be outputted as **TRANS** variable.



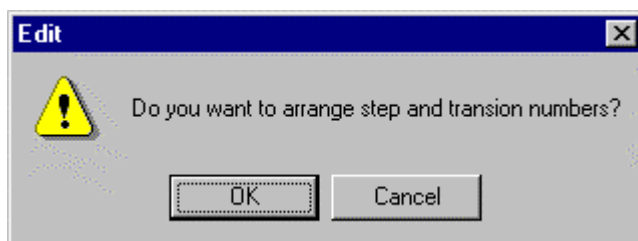
### Note

Action and transition programs are not saved by individually. They are also saved when SFC Program as saved. So if you saved SFC program in window, then action and transition are also saved

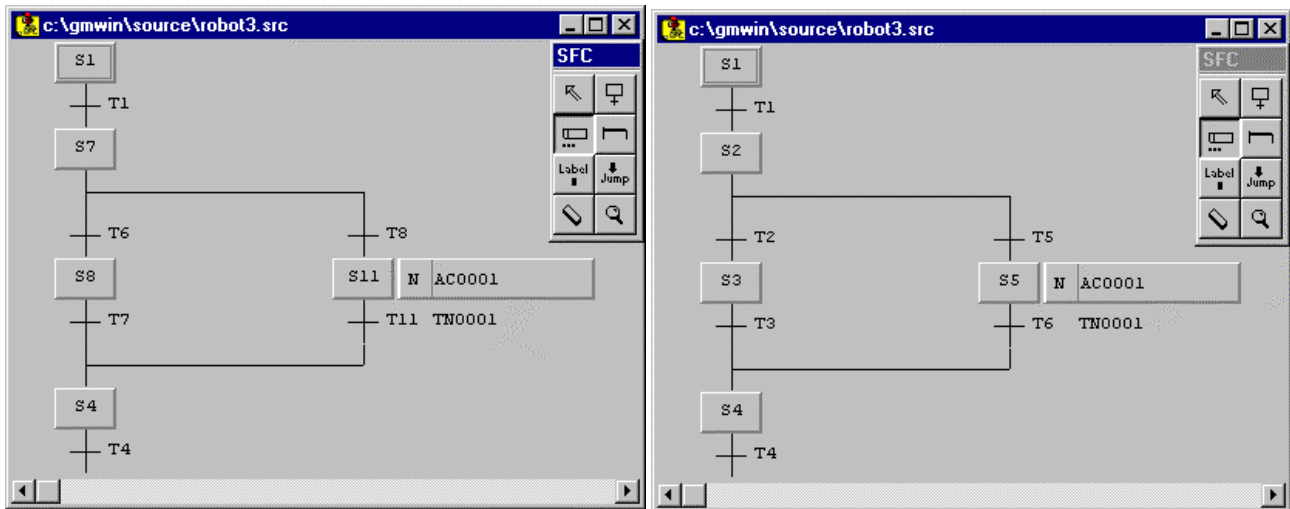
### 5.7.10. Arrange Number

This is function for putting the number added to Step and Transition in order. Step or Transition number is added in inserted order, and they have no other meaning. It is arranged automatically when you compile or save the program.

- ◆ Select **Edit-Arrange Number**.



- ◆ Click OK button and the numbers are given in order.

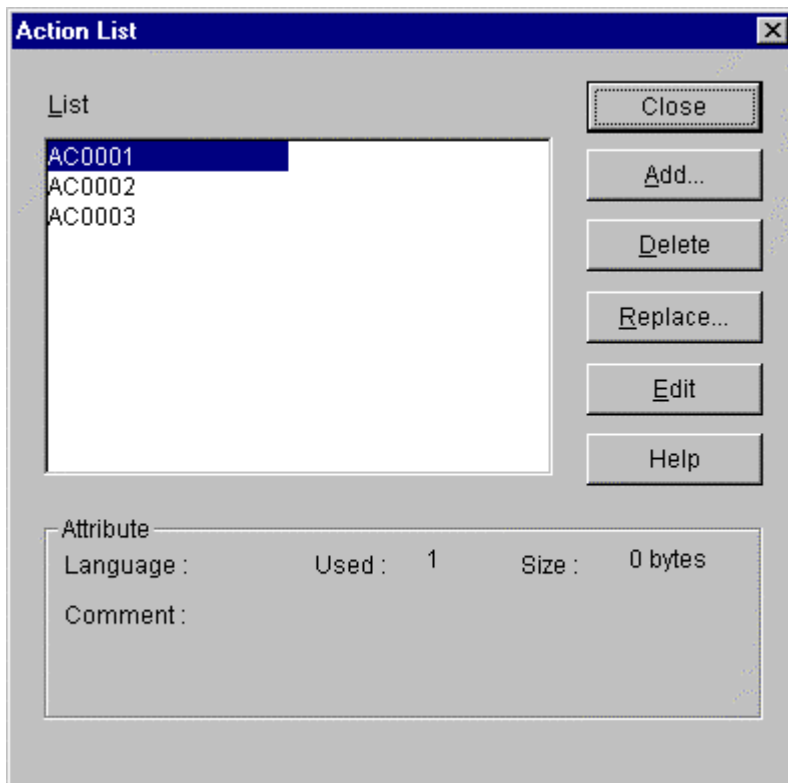


Before arrangement

After arrangement

### 5.7.11. Action/ Transition List

- ◆ Select Program-Action List(or Transition List).



- ◆ Action list and the attribute of the selected action appears in **Action List** dialog box.

Language : Language type of the action  
 Used : The number of being used in SFC program  
 Size : Program size of the action (byte)  
 Comment : Comment for the action

### 1) Add the action

- ◆ Click **Add** button in **Action List** dialog box.
- ◆ Enter the action name and comment, and click **OK** button.

### 2) Replace the action name

- ◆ Click **Replace** button in **Action List** dialog box.
- ◆ Enter the action name and comment that you want to replace and click, **Ok** button.  
At this time, the action on using in SFC program is also replaced in SFC program.

### 3) Delete the action

- ◆ Click **Delete** button in **Action List** dialog box.  
At this time, you cannot delete the action on using in SFC program.

### 4) Edit the action

To edit an action program.

- ◆ Click **Edit** button in **Action List** dialog box.

## 5.7.12. Edit a Block

Before editing a block, you must setup the range to be applied as a block.


Namely, if you want to copy or delete a continuous program, you must designate the desired content as a block before selecting edit a block function.

When you fix a block in SFC, a correct program is only available.

For example, you must setup the block, which starts from a step, as a transition for the end of the program.

To setup a block,



- ◆ Select (  ) in toolbox.
- ◆ In SFC program window, move the mouse to the start point of the block and drag it to the last row of the range to select with clicking the left button.



- ◆ In SFC program window, move the cursor to the start point of the block.
- ◆ With pressing **Shift** key, move the cursor with arrow key to the last row of the range to select.


### 1) Cut

After selecting a block

- ◆ Select **Edit-Cut**(Ctrl+X, ).


### 2) Copy

After selecting a block

- ◆ Select **Edit-Copy**(Ctrl+C, ).


### 3) Paste

After copying or cutting,


- ◆ In SFC program window, move the cursor to the position that you want to paste.
- ◆ Select **Edit-Paste**(Ctrl+V, ).

### 4) Delete

After selecting a block

- ◆ Select **Edit-Delete**(Delete, ).

### 5.7.13. Find

- ◆ Select **Edit-Find** (.
- ◆ In **Name** edit box of **Find** dialog box, enter the string that you want to find.
- ◆ Select the following option and click **OK** button.

#### 1) Kind

Select the type of string that you want to find.

#### 2) Origin

Select the range where Find function is executed.

From cursor : Find from current cursor position.

Entire scope : Find through the whole range.


#### 3) Direction

Select the direction that Find function is executed.

Forward : Find function is executed forward.


Backward : Find function is executed backward.

### 5.7.14. Replace

- ◆ Select **Edit-Replace** (.
- ◆ In **Name** edit box of **Replace** dialog box, enter the character that you want to find.
- ◆ Enter the new character in **New Name** edit box of **Replace** dialog box,
- ◆ Select options in the same way as Find function and click **OK** button.

### 5.7.15. Again

If you executed Find.Replace function before, executes the function again with the condition that designated before..

- ◆ Select **Edit-Again**(Ctrl+F3, .

### 5.7.16. Goto

- ◆ Select **Edit-Goto**.
- ◆ In Go to Position dialog box, enter the Y(vertical), X(horizontal) coordinates that you want to go.

### 5.7.17. Condense Screen

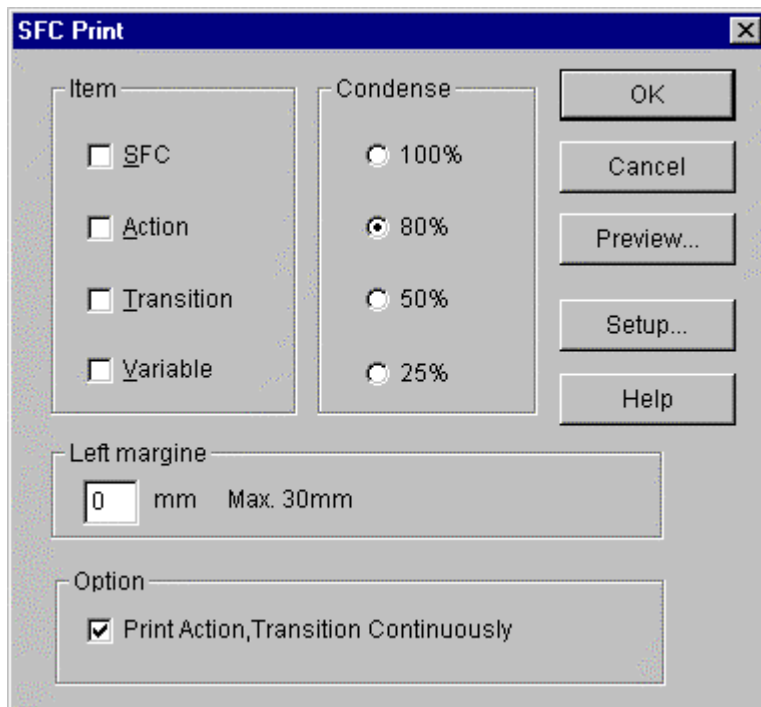
To adjust the screen size,

- ◆ Select **Edit-Condense screen**.
- ◆ Select a desired screen size in **Condense screen** dialog box and click **Ok** button.

### 5.7.18. Print

If you click **View Comment** button to see the comments that you edited in the program.

- ◆ Select **Project-Print** in the pull-down menu.



- ◆ Setup the conditions to print in SFC program.
- ◆ To preview the program, select Preview button.
- ◆ Close **Preview** screen and click **OK** button to print.

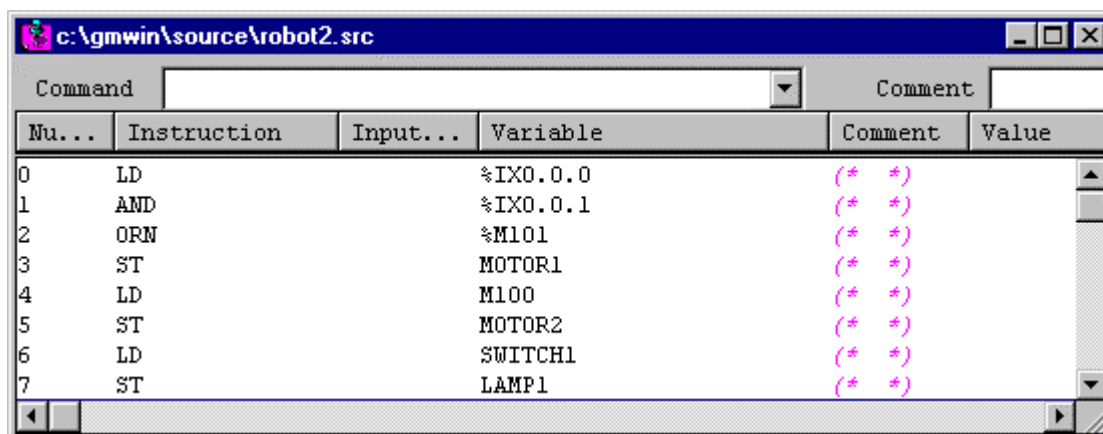
### 5.8. Edit IL

IL is a language that consists of instructions, whose elements are operators, functions, function block and label.

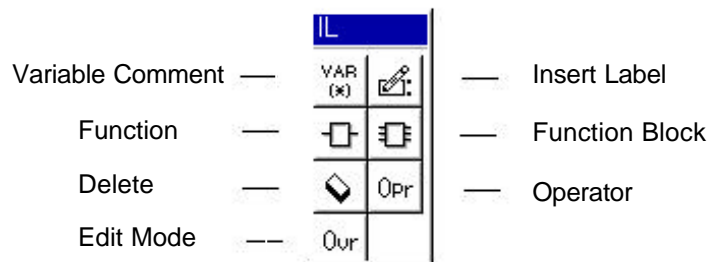
The input of an instruction and a variable is accomplished in edit control box for command and the input of a comment is accomplished in a comment input box.

A blank separates instruction from variable and in case of several variables, they are separated by ' , '.

Example) ADD A,B,2



## Toolbox for IL



	Function Input	Select a function to input
	Function Block Input	Select a function block to input
	Label Input	Input a label
	Operator Input	Select an operator to input
	Delete a Row	Delete a present row
	Row Comment Input	Input a row comment
	Variable Comment Input	Input a variable comment
	Insert Mode	Change into insert mode
	Overwrite Mode	Change into overwrite mode

The below picture is the menu that is displayed with clicking the right button of the mouse in IL. You can execute each command simply using this menu.





### 5.8.1. Operator Input


**END** indicates the end of the main program and the program after **END** is a subroutine program.

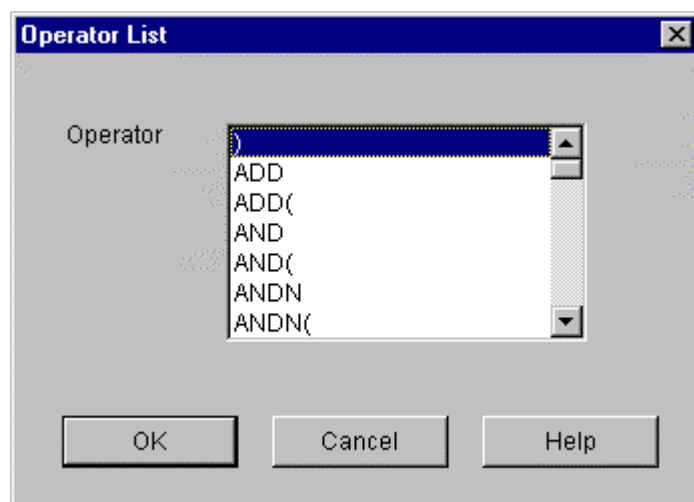
If there is not **END**, the whole program is the main program.

You can use **SCAL**, **SCALC**, **SCALN** for calling a subroutine and **RET**, **RETC**, **RETN** for return from a subroutine. The name created in **SCAL(C,N)** must not be in front of **END**.

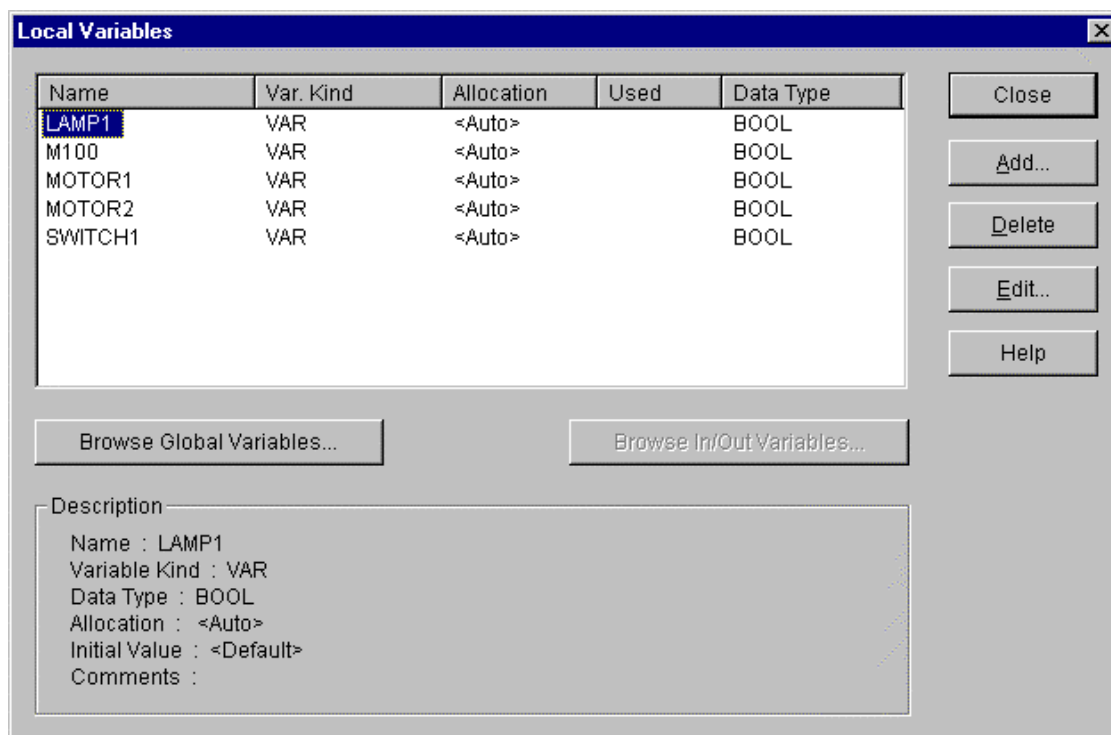
If **JMP(C,N)** is in front/rear of **END**, the appropriate label is in front/rear of **END**. Although **RET(C,N)** is not in the rear of **END**, the last is regarded as the return from a subroutine..



- ◆ To insert the operator.
- ◆ Click (  ) in toolbox.



- ◆ Select the operator in **Operator List** dialog box.



- ◆ Enter the variable name in **Name** edit box of **Variables** dialog box.
- ◆ Click **OK** button.

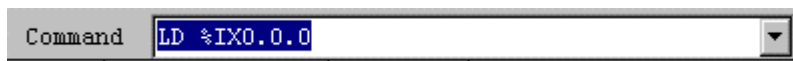
### Note

If you want to enter the already declared variable, select the variable in list box of **Variable** dialog box..



#### method 1

- ◆ Move the cursor in program region to the position in where you want to insert an operator.
- ◆ Input an operator and object in **Command** edit box.




- ◆ Press **Enter** key.

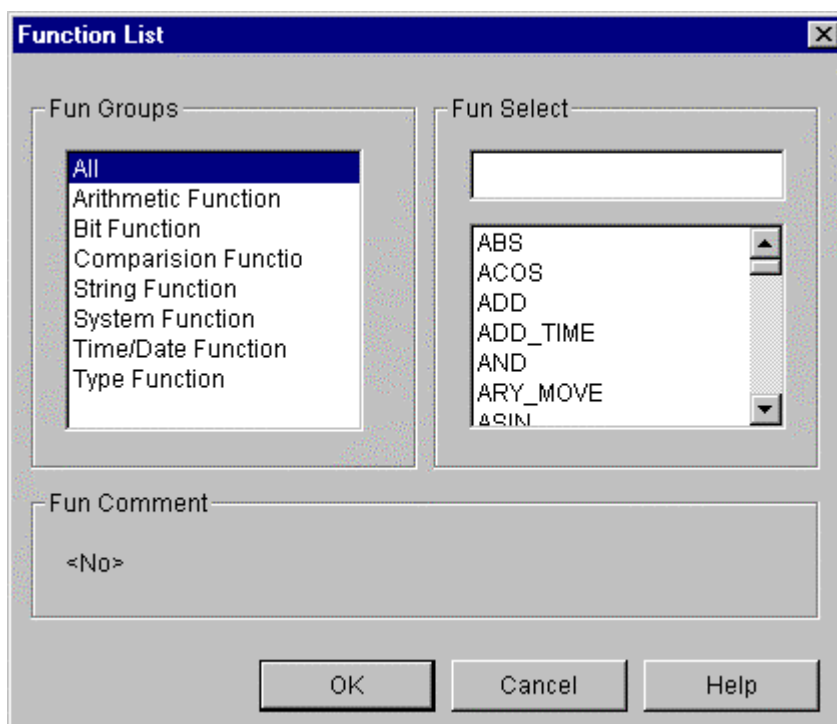
#### method 2

- ◆ Move the cursor in the display region which you want to insert an operator.
- ◆ Select **Toolbox-Operator**.
- ◆ Select an operator in **Operator List** dialog box.
- ◆ Enter the variable name in **Name** edit box of **variables** dialog box.
- ◆ Press **Enter** key.

## 5.8.2. Function Input



- ◆ To insert the Function in IL.
- ◆ Click (  ) in toolbox.

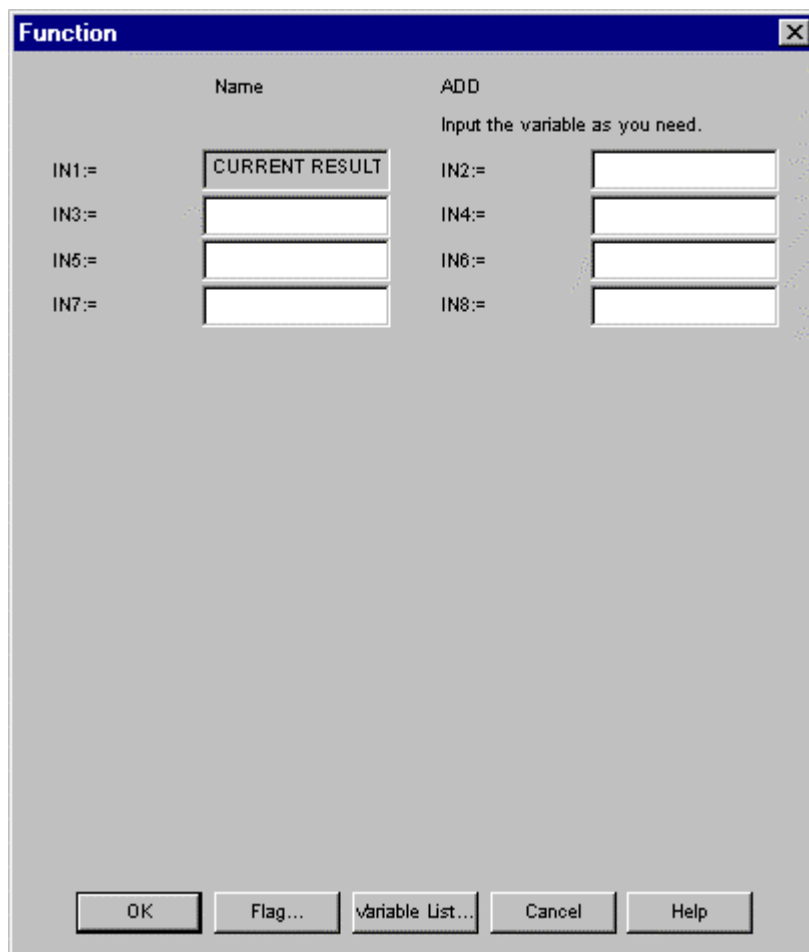


## Chapter 5. Edit a Program

- ◆ Select the function in **Function List** dialog box.
- ◆ Enter the variable as many as you want in edit box of **Function List** dialog box.
- ◆ Click **OK** button.

### Note

If you want to use the already declared variables as the variable, click Variable list button of **Function** dialog box and select the variable in the list box of **Variables** dialog box.



The **Function** dialog box is shown. It has a title bar with a close button. The main area is divided into two columns: **Name** and **ADD**. Under **Name**, there are four input boxes labeled IN1:=, IN3:=, IN5:=, and IN7:=. The first box (IN1:=) contains the text "CURRENT RESULT". Under **ADD**, there is a label "Input the variable as you need." followed by four input boxes labeled IN2:=, IN4:=, IN6:=, and IN8:=. At the bottom, there are five buttons: **OK**, **Flag...**, **variable List...**, **Cancel**, and **Help**.



### method 1

- ◆ Move the cursor in the display region which you want to insert a function.
- ◆ Enter the function and variable in **Command** edit box.



The **Command** edit box is shown. It contains the text "ADD E,F,G".

- ◆ Press an **Enter** key.

method 2


- ◆ Move the cursor in the display region which you want to insert a function.
- ◆ Select **Toolbox-Function**.
- ◆ Select the function that you want to insert in **Fncion List** dialog box.
- ◆ Enter the variables for the function in **Function** dialog box.
- ◆ Press **OK** button.

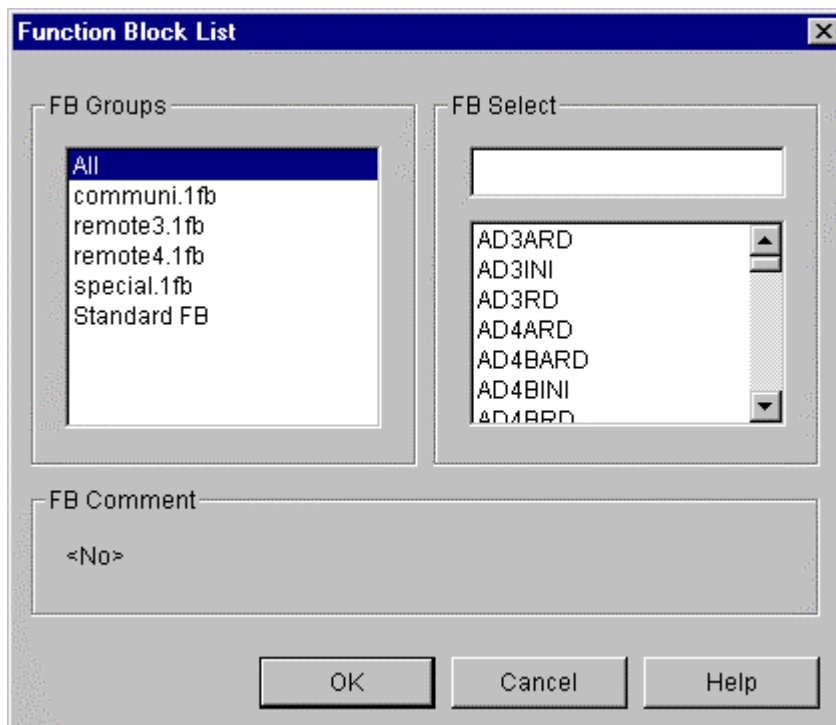
**Note**

I case of extensible function (refer to GMWIN commands for the detail information), the number of input for the variable is not designated.

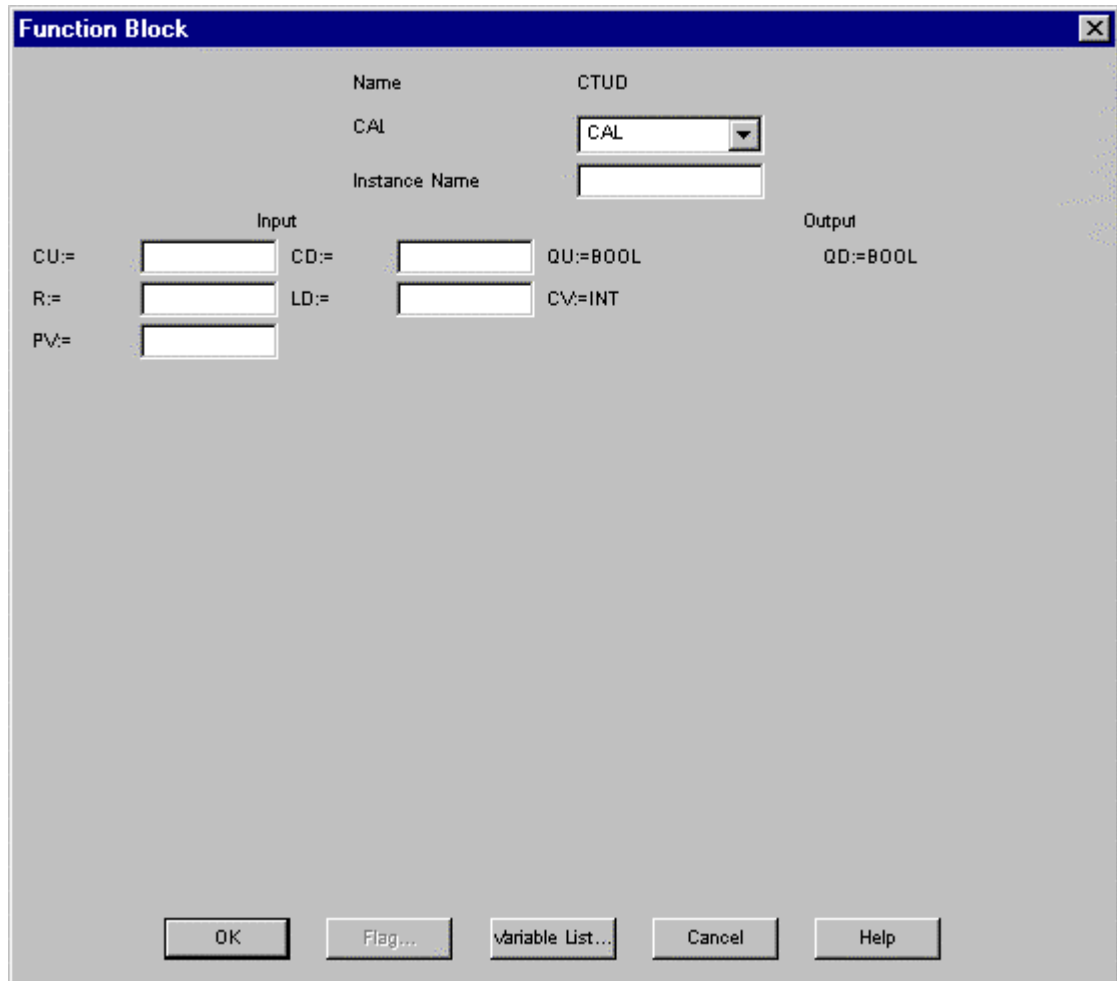
### 5.8.3. Function Block Input



- ◆ To insert the Function Block,
- ◆ Click (  ) in toolbox.



- ◆ After selecting a function block to use in **Function Block List** dialog box, click **OK** button.



The **Function Block** dialog box is shown. It has a title bar with a close button. The main area contains the following fields and controls:

- Name:** A label followed by the text "CTUD".
- CAL:** A label followed by a dropdown menu showing "CAL".
- Instance Name:** A label followed by an empty text box.
- Input:** A label above three input fields.
  - CU:= [ ]
  - R:= [ ]
  - PV:= [ ]
- CD:=** [ ]
- LD:=** [ ]
- QU:=BOOL**
- CV:=INT**
- Output:** A label above the text "QD:=BOOL".

At the bottom, there are five buttons: **OK**, **Flag...**, **Variable List...**, **Cancel**, and **Help**.

- ◆ Input an instance name in **Instance Name** edit box.
- ◆ Click **OK** button.

### Note

If you want to insert the already declared variable, click **Variable list** button of **Function Block** dialog box and select the variable in list box of **Variables** dialog box.



### method 1

- ◆ Move the cursor in the display region which you want to insert a function block.
- ◆ Enter CAL/CALC/CALN in **Command** edit box.



The **Command** edit box is shown with the text "CAL" entered.


- ◆ Select the function block in **Function Block List** dialog box.
- ◆ Enter the instance name and variables in **Function Block** dialog box.
- ◆ Press **Enter** key.

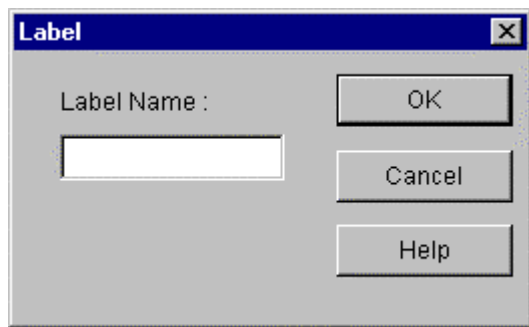
method 2

- ◆ Move the cursor in the display region which you want to insert a function block.
- ◆ Select **Toolbox-Function Block**.
- ◆ Select the function block in **Function Block List** dialog box.
- ◆ Enter the instance name and variables in **Function Block** dialog box.
- ◆ Press **Enter** key

#### 5.8.4. Label Input



- ◆ To input the label.
- ◆ Click (  ) in toolbox.

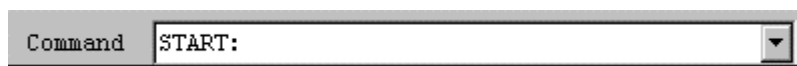


- ◆ Enter the label name (maximum size is 8 characters) in **Label** dialog box.
- ◆ Click **OK** button.



method 1

- ◆ Move the cursor in the display region which you want to insert a label.
- ◆ Enter the label name and ':' in **Command** edit box.



- ◆ Press **Enter** key.

method 2

- ◆ Move the cursor in the display region which you want to insert a label.
- ◆ Select **Toolbox-Label**.
- ◆ Enter the label name in **Label** dialog box.
- ◆ Click **OK** button.

#### 5.8.5. Comment Input

Comment is created in **Comment** edit box in IL program screen. You can insert a line comment and variable comment separately by the comment display of toolbox. You can edit directly the comment in **Comment** edit box.



- ◆ Move the cursor in the display region which you want to insert a comment.
- ◆ Make a comment (maximum size 24 characters) in **Comment** edit box.




- ◆ Move the cursor in the display region which you want to insert a comment.
- ◆ Select **Toolbox-Variable Comment (Line Comment)**.
- ◆ Enter the comment in **Comment** edit box.

### 5.8.6. Change an Inset/ Overwrite Mode of Program

To change into Insert Mode,




Click (  ) in toolbox.



- ◆ Select **Toolbox-Insert**.

To change into Overwrite Mode,




Click (  ) in toolbox.



- ◆ Select **Toolbox-Overwrite**.

### 5.8.7. Delete a Program



- ◆ Move the cursor in the display region which you want to delete.
- ◆ Click (  ) in toolbox.



- ◆ Move the cursor in the display region which you want to delete.
- ◆ Select **Toolbox-Delete**.

### 5.8.8. Edit a Block

Before editing a block, you must setup the range to be applied as a block.

Namely, if you want to copy or delete a continuous program, you must designate a desired range as a block before selecting Edit Block Function.




- ◆ Move the mouse to the row of the display range to select.
- ◆ Drag the mouse to the last row of the range to select with clicking the left button.



- ◆ Move the cursor to the row of the display range to select.
- ◆ With pressing **Shift** key, move the cursor with arrow key to the last row of the range to select


#### 1) Cut

After selecting a block,

- ◆ Select **Edit-Cut**(Ctrl+X, ).


## 2) Copy

After selecting a block,

- ◆ Select **Edit-Copy**(Ctrl+C, ).


## 3) Paste

After copying or cutting,

- ◆ Move the cursor in the display region which you want to paste.
- ◆ Select **Edit-Paste**(Ctrl+V, .


## 4) Delete

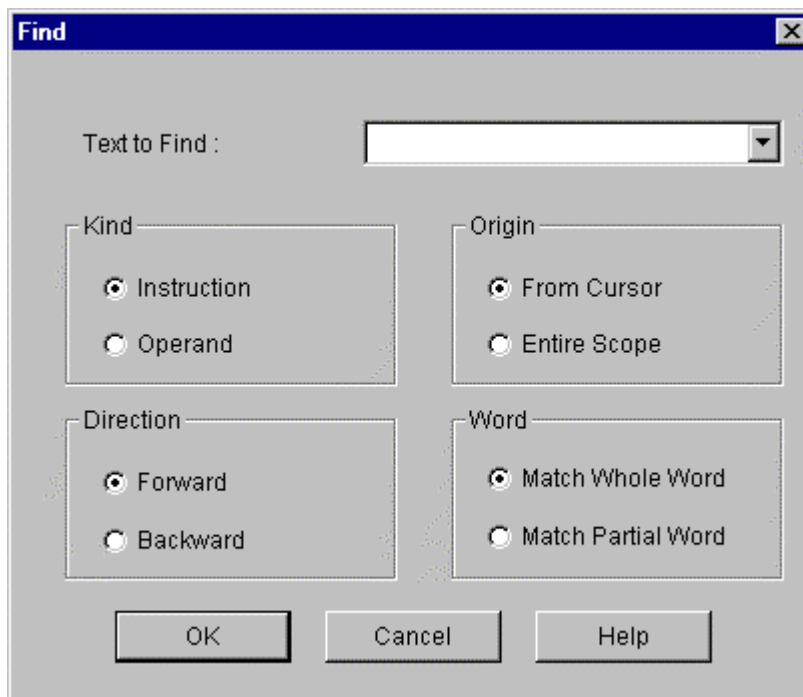
After selecting a block,

- ◆ Select **Edit- Delete** (Delete, .

## 5.8.9. Find

To find an instruction or variable in the program on editing,

- ◆ Select **Edit- Find** (.



- ◆ In **Text to Find** edit box of **Find** dialog box, enter the string that you want to find.
- ◆ Select the following option and click **OK** button

### 1) Kind

- ◆ Select the string type to find.

### 2) Origin

- ◆ Select the range where Find functions executed.
  - (1) From cursor : Find from the current cursor position
  - (2) Entire scope : Find through the whole program



### 3) Direction

- ◆ Select the direction that Find function is executed.
  - (1) Forward : Find function is executed forward
  - (2) Backward : Find function is executed backward

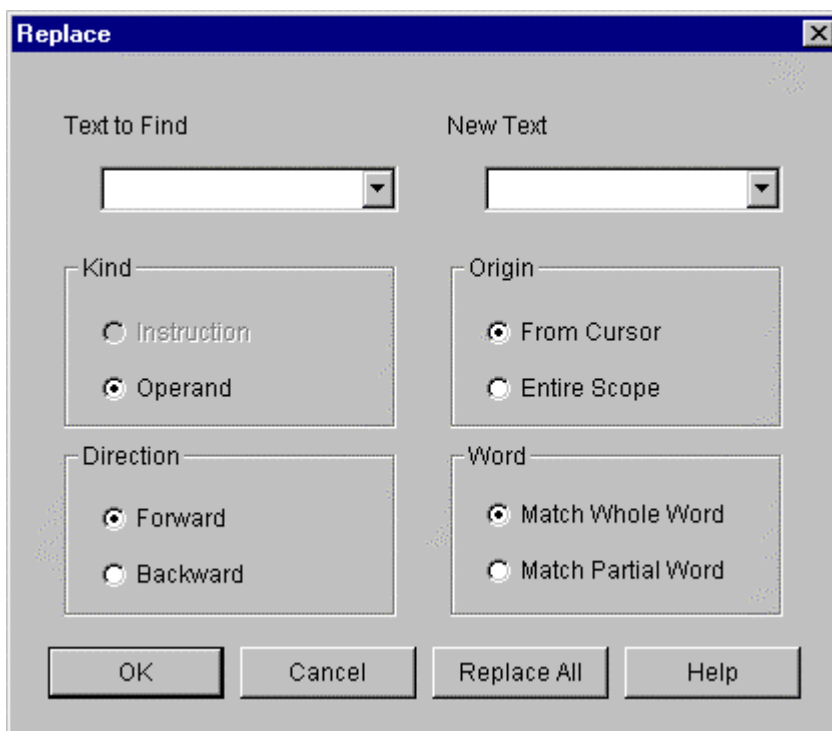
### 4) Word

- ◆ Select an accordance degree in finding a word.
  - (1) Match Whole Word : Find only an exact same word
  - (2) Match Partial Word : Find also a partial same word

## 5.8.10. Replace

To replace a variable with a desired variable in the program on editing,

- ◆ Select **Edit-Replace** (.




- ◆ In **Text to find** edit box of **Replace** dialog box, enter the string that you want to find.
- ◆ In **New Text** edit box, enter the new string.
- ◆ Select options in the same way as Find function and click **OK** button.
- ◆ Click **Replace All** button to replace all string at once.

### Note

You can replace the string only for a variable.

## 5.8.11. Again

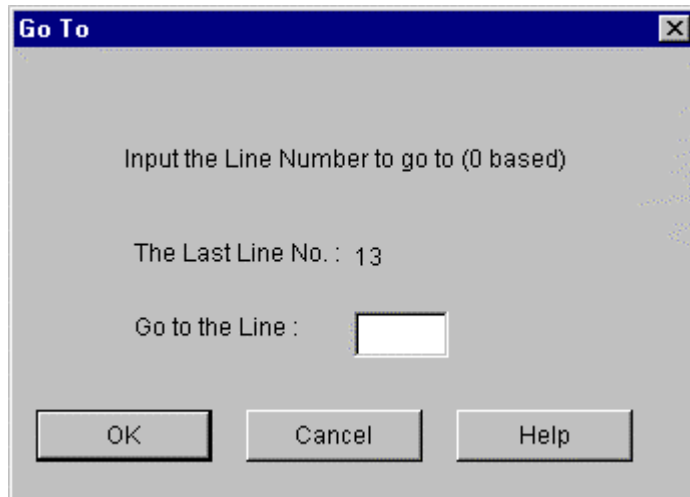
If you executed Find/ Replace command before, executed the command again with condition that designated before.

- ◆ Select **Edit-Again** (Ctrl+F3, .

### 5.8.12. Go to

This function allows you to find the desired line in the program.

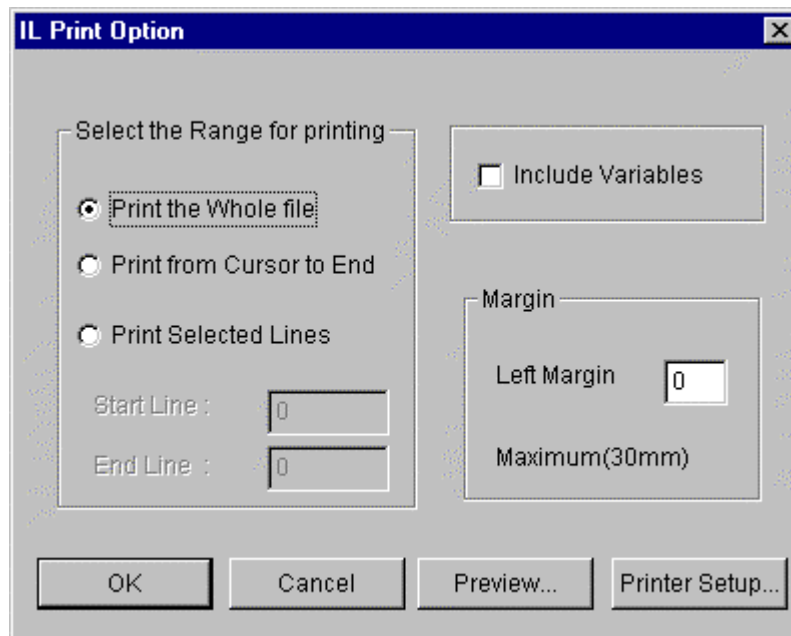
- ◆ Select **Edit-Goto**.
- ◆ In **Goto** dialog box, enter the line number that you want to find.
- ◆ Click **OK** button.



### 5.8.13. Print

If you click a **Preview** button before printing a program, the outline of content is printed on the screen.

- ◆ Select **Project-Print**.



- ◆ Select the Range for printing in **IL Print Option** dialog box.  
 Print Whole file : Print the whole program  
 Print from Cursor to End : Print from a cursor to the end  
 Print selected lines : Print from start line to end line
- ◆ To print variables, select **Include Variables** check box.
- ◆ Setup the margin to print in **Margin** edit box.