

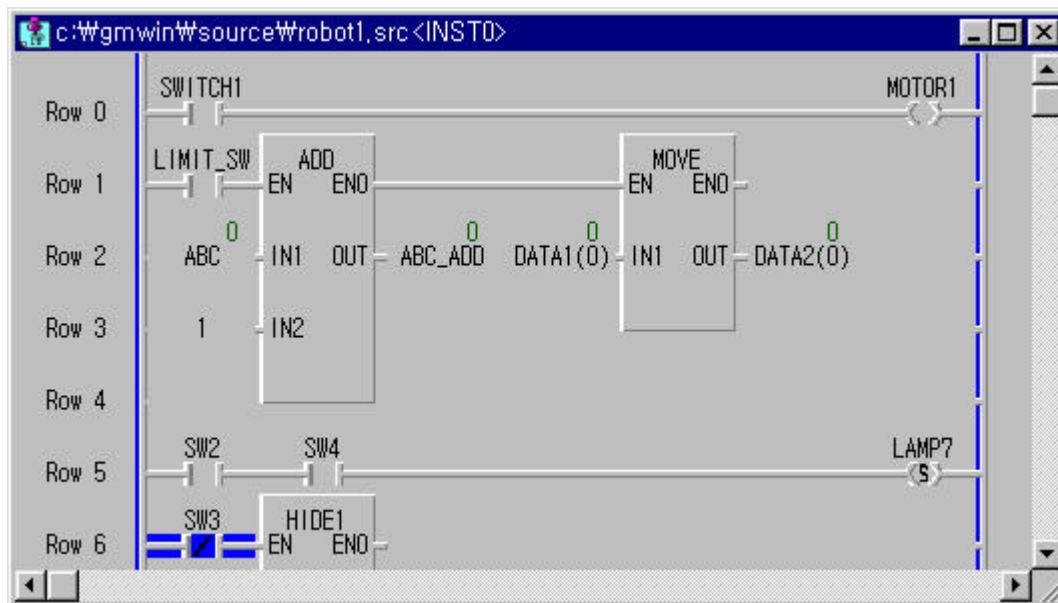
## Chapter 13. Online Edit

In Run Mode, You can edit a program without changing the PLC Mode to Stop Mode.

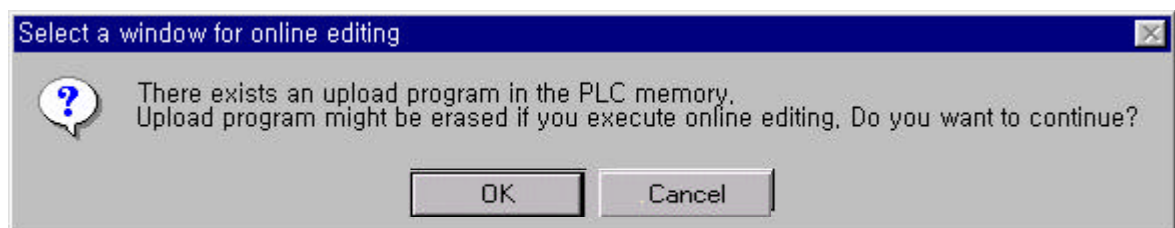
### 13.1. Start Online Edit

. To edit a program in Run mode, the program to edit must be identified with the program in the PLC.

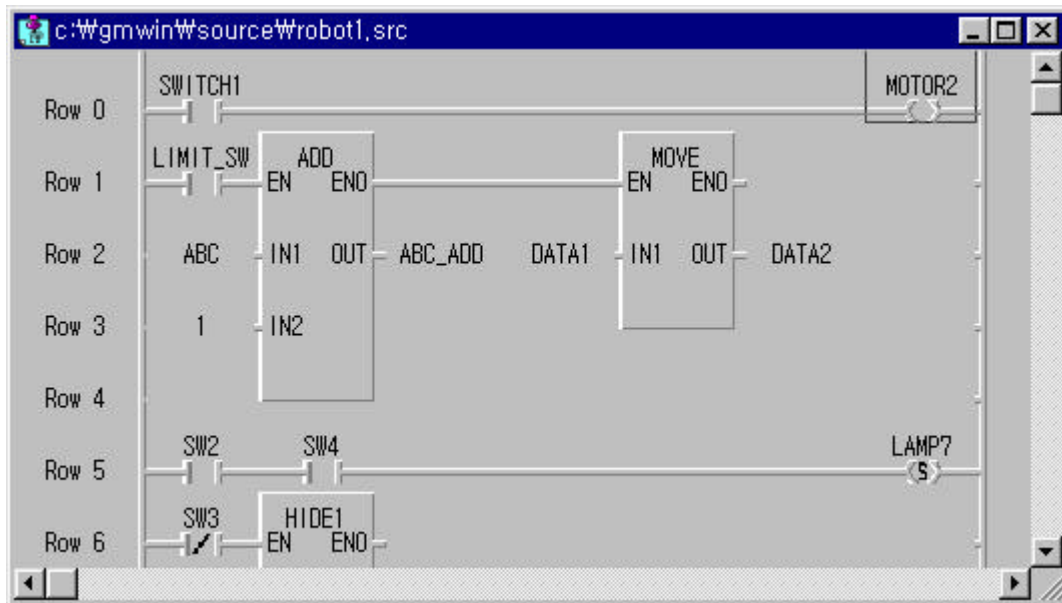
- ◆ Select the program.



- ◆ Select **Online-Start Online Edit** in menu.  
At this moment, If PLC Mode is Monitoring Mode, only the program for online editing is changed to Edit Mode.
- ◆ If there is the Upload program in PLC, the following message appears. If you click **Yes** button, the Upload program is downloaded to PLC after the online editing. But, the PLC must have an enough memory space.



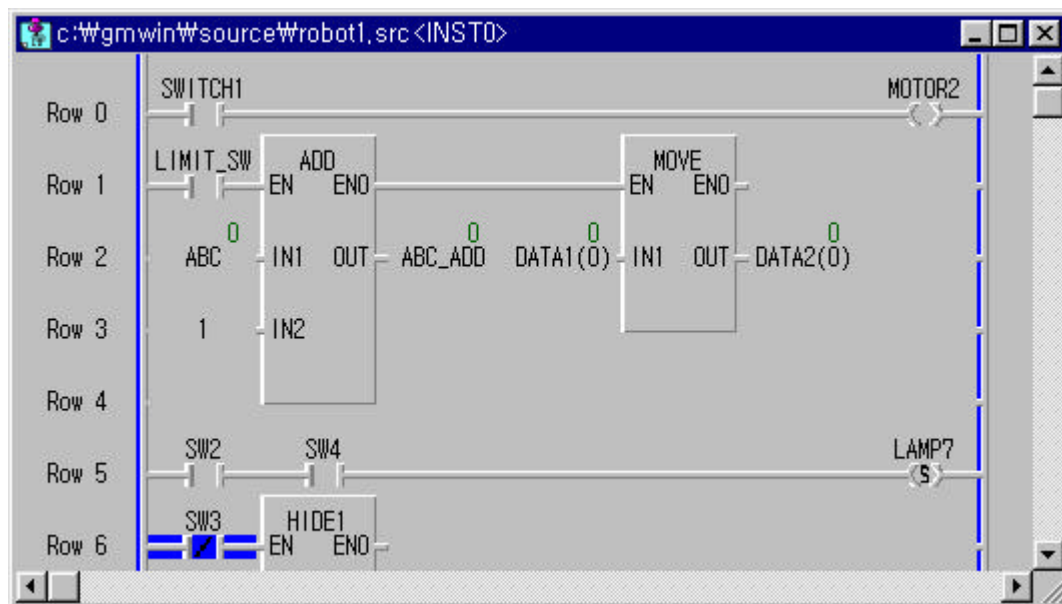
- ◆ Edit the program.



### 13.2. Write for Online Edit

To write the edited program to PLC,

- ◆ Select **Online-Write for Online Edit** in the pull-down menu.



- ◆ If an error is occurred in this step, the program can't be downloaded to PLC. So, edit the program again after selecting **Online-Write for Online Edit** in the pull-down menu.

### 13.3. Cancel Online Edit

To cancel the online editing and return to the previous program,

- ◆ Select **Online-Cancel Online Edit** in the pull-down menu.

### 13.4. Available Items for Online Edit

You can edit the following items.

- ◆ Edit, Add or Delete for Contacts and Variables
- ◆ Edit for the directly used data in Program
- ◆ Add initial Variable, Retain Variable  
Initial Value and Retain Variable are applicable in Mode change(from Stop to Run mode).
- ◆ Add or Delete Rung
- ◆ Edit Parameter  
Only Basic Parameter and High Speed Link Parameter(including Link Enable).  
Not available for I/O Parameter
- ◆ Add Jump or Label
- ◆ Delete Variable in Variable List
- ◆ Change Memory Allocation for Variable  
Example) AT %I0.2.0 ==> %I0.2.1

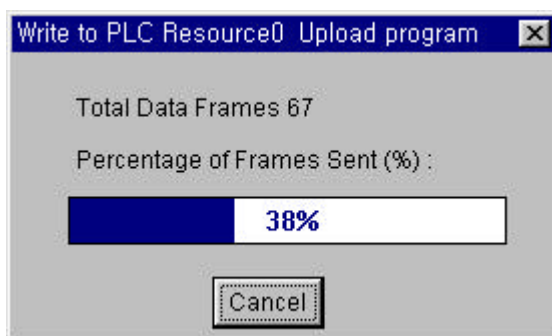
### 13.5. Non-available Items for Online Edit

You cannot edit the following items.

- ◆ Change of Variable Property  
Example) Standard Variable ==> Variable with Initial Value,  
Local Variable ( VAR ) ==> Global Variable ( VAR\_EXTERNAL )  
BYTE ==> WORD  
Initial Value declared as Initial Value can be changed.
- ◆ Edit, Add or Delete Global Variable
- ◆ Add or Delete Program Block
- ◆ Add or Edit User Defined Function/Function Block (Available for Function or Function Block for already used in the Project)
- ◆ Edit many rungs at the same time  
<No. of edited Rung + No. of Label included in edited Rung> must be within 256 numbers

#### Note

1. When complete the online-edit, to close a program, you must execute a disconnection.  
If you execute a disconnection, Upload program is transmitted to PLC as below.



2. To online-edit an uploaded program, you must complete Make.  
(Refer to the section ' 12.3.Read from PLC (Upload).)