

STL Instruction



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STL instruction

I Instruction description:

Mnemonic, Name	Function	Usable soft component	Program Step
STL	Initiation of Step Procedure	S	1
RET	End of Step Procedure	None	1

II Operation

Step Control (STL) is controlled by several operating procedures (S0,S1.....Sn).

Step Control method's feature is that after taken into considerations for each control step and divided the complex procedure into successive steps, it greatly reduces the interdependence between each step and the complexity involved in programming.

Every movement executed in each status are programmed by other instructions in the ladder diagram.

STL is the initiation instruction for step procedures, and RET is the ending instruction for a step procedure. After the instruction is executed, it returns to the bus bar.

SET S[k]([k] is in decimal) is the only instruction for initiating STL transitions.

Note: STL---RET instructions cannot be used in sub-programs.

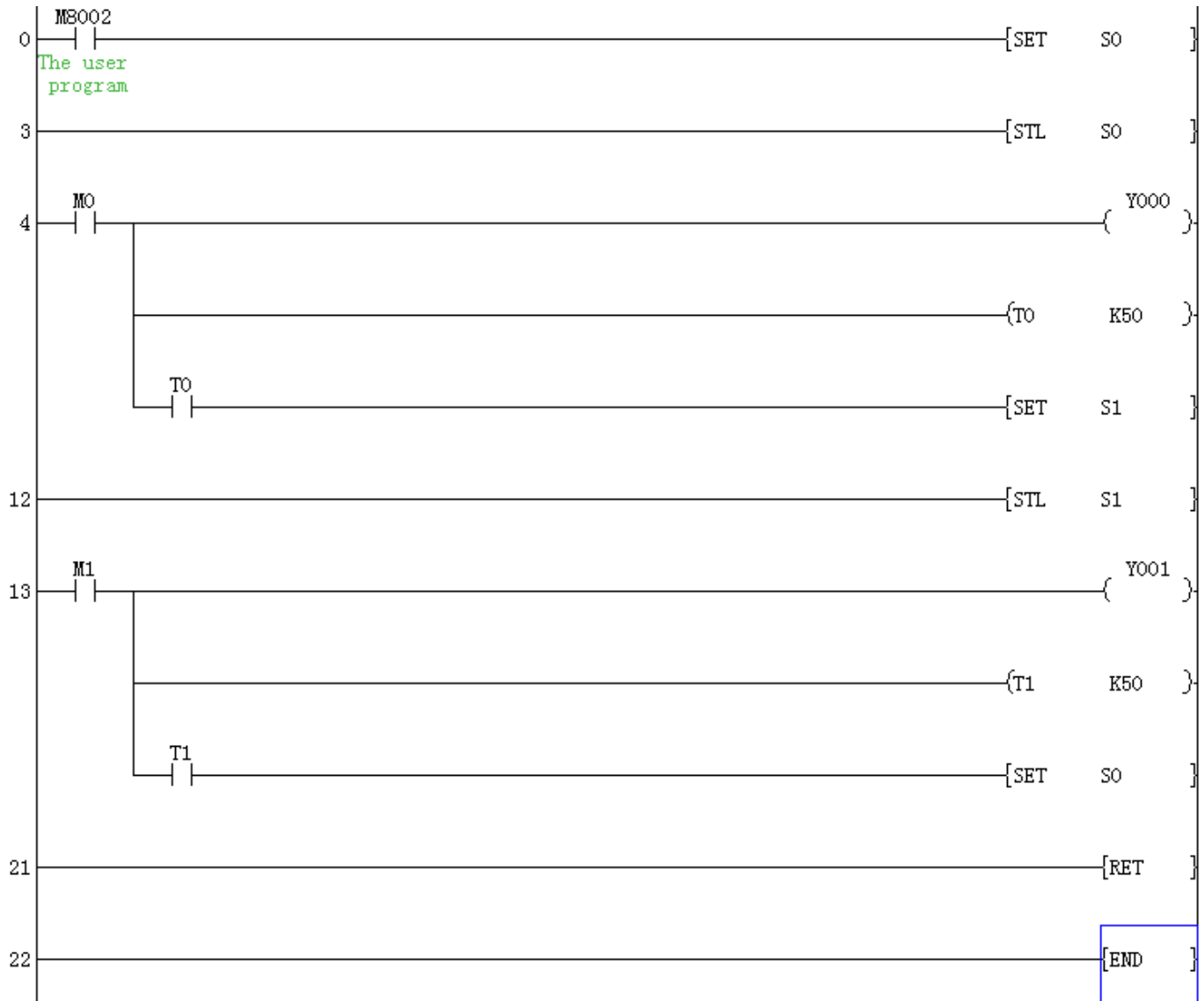
When transition is happening from current status (S0) to next status (S1), the actions under the two scanning cycle conditions will both be executed; when the next scanning cycle is being executed, current status (S0) will be reset by the next status (S1), and the actions under the current status (S0) will not be executed. All OUT components' inputs will be interrupted.

Generally speaking, RET will be omitted between each step procedures. Therefore, it will seem a RET is shared by several STL. When STL is programmed and RET procedure is not, error message will appear.

III Program

Demo1:M0 and M1 control the step demo.

Note: Time Relay T can be used repeatedly. However, the two neighboring statuses cannot use the same time relay repeatedly. Please add a **RET** in the last line to stop the first circulation.



Demo2: Automatic operation.

Step 1: Y0=ON about 10 seconds. Then Y0=OFF and continue step2

Step 2: Y1=ON about 10 seconds. Then Y1=OFF and continue step3

Step 3: Y2=ON about 10 seconds. Then Y2=OFF and continue step1

