

## Machine Startup and Program Troubleshooting

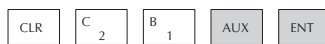
The DL06 Micro PLCs provide several features that can help you debug your program before and during machine startup. This section discusses the following topics which can be very helpful.

- Program Syntax Check
- Duplicate Reference Check
- Special Instructions
- Run Time Edits
- Forcing I/O Points

### Syntax Check

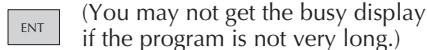
Even though the Handheld Programmer and *DirectSOFT32* provide error checking during program entry, you may want to check a program that has been modified. Both programming devices offer a way to check the program syntax. For example, you can use AUX 21, CHECK PROGRAM to check the program syntax from a Handheld Programmer, or you can use the PLC Diagnostics menu option within *DirectSOFT32*. This check will find a wide variety of programming errors. The following example shows how to use the syntax check with a Handheld Programmer.

Use AUX 21 to perform syntax check



AUX 21 CHECK PRO  
1:SYN 2:DUP REF

Select syntax check (default selection)



BUSY

One of two displays will appear

Error Display (example)

\$00050 E401  
MISSING END

(shows location in question)

Syntax OK display

NO SYNTAX ERROR  
?

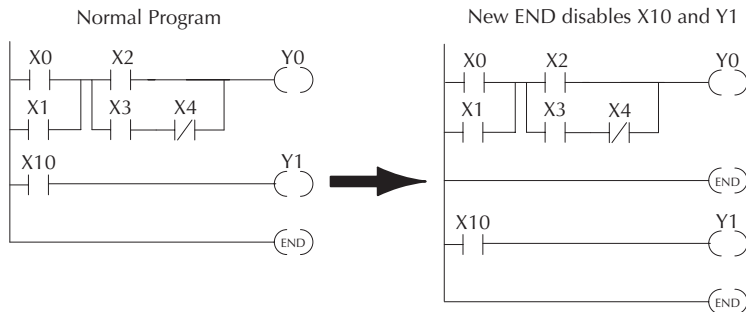
See the Error Codes Section for a complete listing of programming error codes. If you get an error, just press CLR and the Handheld will display the instruction where the error occurred. Correct the problem and continue running the Syntax check until the NO SYNTAX ERROR message appears.

## Special Instructions

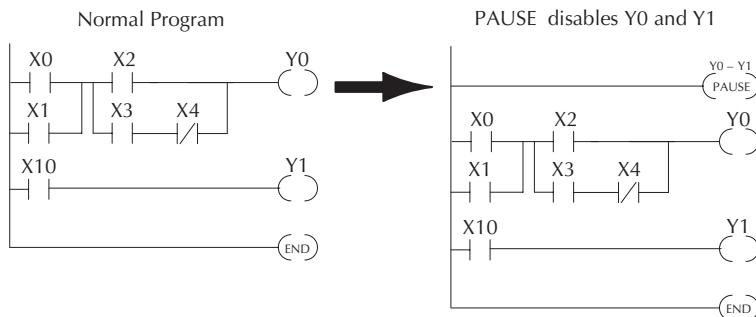
There are several instructions that can be used to help you debug your program during machine startup operations.

- END
- PAUSE
- STOP

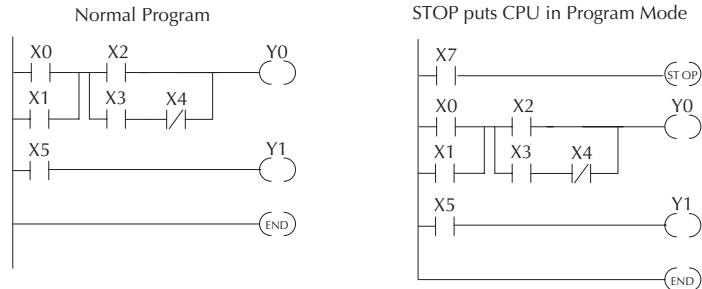
**END Instruction:** If you need a way to quickly disable part of the program, just insert an END statement prior to the portion that should be disabled. When the CPU encounters the END statement, it assumes that is the end of the program. The following diagram shows an example.



**PAUSE Instruction:** This instruction provides a quick way to allow the inputs (or other logic) to operate while disabling selected outputs. The output image register is still updated, but the output circuits are not. For example, you could make this conditional by adding an input contact or CR to control the instruction with a switch or a programming device. Or, you could just add the instruction without any conditions so the selected outputs would be disabled at all times.



**STOP Instruction:** Sometimes during machine startup you need a way to quickly turn off all the outputs and return to Program Mode. You can use the STOP instruction. When this instruction is executed the CPU automatically exits Run Mode and enters Program Mode. Remember, all outputs are turned off during Program Mode. The following diagram shows an example of a condition that returns the CPU to Program Mode.

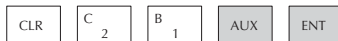


In the example shown above, you could trigger X7 which would execute the STOP instruction. The CPU would enter Program Mode and all outputs would be turned off.

### Duplicate Reference Check

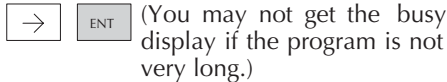
You can also check for multiple uses of the same output coil. Both programming devices offer a way to check for this condition.. For example, you can AUX 21, CHECK PROGRAM to check for duplicate references from a Handheld Programmer, or you can use the PLC Diagnostics menu option within *DirectSOFT32*. The following example shows how to perform the duplicate reference check with a Handheld Programmer.

Use AUX 21 to perform syntax check



AUX 21 CHECK PRO  
1:SYN 2:DUP REF

Select duplicate reference check



BUSY

One of two displays will appear

Error Display (example)  
(shows location in question)

\$00024 E471  
DUP COIL REF

Syntax OK display

NO DUP REFS  
?

If you get an error, just press CLR and the Handheld will display the instruction where the error occurred. Correct the problem and continue running the Duplicate Reference check until no duplicate references are found.



**NOTE:** You can use the same coil in more than one location, especially in programs containing Stage instructions and / or ORQUT instructions. The Duplicate Reference check will find occurrences, even though they are acceptable.

### Run Time Edits

The DL06 Micro PLC allows you to make changes to the application program during Run Mode. These edits are not “bumpless.” Instead, CPU scan is momentarily interrupted (and the outputs are maintained in their current state) until the program change is complete. This means if the output is off, it will remain off until the program change is complete. If the output is on, it will remain on.



**WARNING:** Only authorized personnel fully familiar with all aspects of the application should make changes to the program. Changes during Run Mode become effective immediately. Make sure you thoroughly consider the impact of any changes to minimize the risk of personal injury or damage to equipment. There are some important operational changes during Run Time Edits.

1. If there is a syntax error in the new instruction, the CPU will not enter the Run Mode.
2. If you delete an output coil reference and the output was on at the time, the output will remain on until it is forced off with a programming device.
3. Input point changes are not acknowledged during Run Time Edits, so, if you're using a high-speed operation and a critical input comes on, the CPU may not see the change.

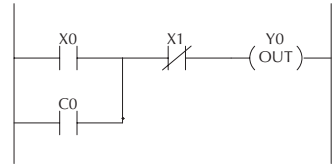
Not all instructions can be edited during a Run Time Edit session. The following list shows the instructions that can be edited.

Mnemonic	Description
TMR	Timer
TMRF	Fast timer
TMRA	Accumulating timer
TMRAF	Accumulating fast timer
CNT	Counter
UDC	Up / Down counter
SGCNT	Stage counter
STR, STRN	Store, Store not (Boolean)
AND, ANDN	And, And not (Boolean)
OR, ORN	Or, Or not (Boolean)
STRE, STRNE	Store equal, Store not equal
ANDE, ANDNE	And equal, And not equal
ORE, ORNE	Or equal, Or not equal
STR, STRN	Store greater than or equal Store less than (Comparative Boolean)
AND, ANDN	And greater than or equal And less than (Comparative Boolean)

Mnemonic	Description
OR, ORN	Or greater than or equal or less than (Comparative Boolean)
LD	Load data (constant)
LDD	Load data double (constant)
ADDD	Add data double (constant)
SUBD	Subtract data double (constant)
MUL	Multiply (constant)
DIV	Divide (constant)
CMPD	Compare accumulator (constant)
ANDD	And accumulator (constant)
ORD	Or accumulator (constant)
XORD	Exclusive or accumulator (constant)
LDF	Load discrete points to accumulator
OUTF	Output accumulator to discrete points
SHFR	Shift accumulator right
SHFL	Shift accumulator left
NCON	Numeric constant

### Run Time Edit Example

We'll use the program logic shown to describe how this process works. In the example, we'll change X0 to C10. Note, the example assumes you have already placed the CPU in Run Mode.



Use the **MODE** key to select Run Time Edits



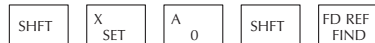
\*MODE CHANGE\*  
RUN TIME EDIT?

Press **ENT** to confirm the Run Time Edits

**ENT** (Note, the RUN LED on the D2-HPP Handheld starts flashing to indicate Run Time Edits are enabled.)

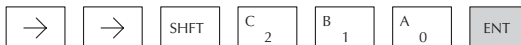
\*MODE CHANGE\*  
RUNTIME EDITS

Find the instruction you want to change (**X0**)



\$00000 STR X0

Press the arrow key to move to the **X**. Then enter the new contact (**C10**).



RUNTIME EDIT?  
STR C10

Press **ENT** to confirm the change.

**ENT** (Note, once you press ENT , the next address is displayed.)

OR C0

### Forcing I/O Points

There are many times, especially during machine startup and troubleshooting, that you need the capability to force an I/O point to be either on or off. Before you use a programming device to force any data type, it is important to understand how the DL06 CPUs process the forcing requests.



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**WARNING: Only authorized personnel fully familiar with all aspects of the application should make changes to the program. Make sure you thoroughly consider the impact of any changes to minimize the risk of personal injury or damage to equipment.**

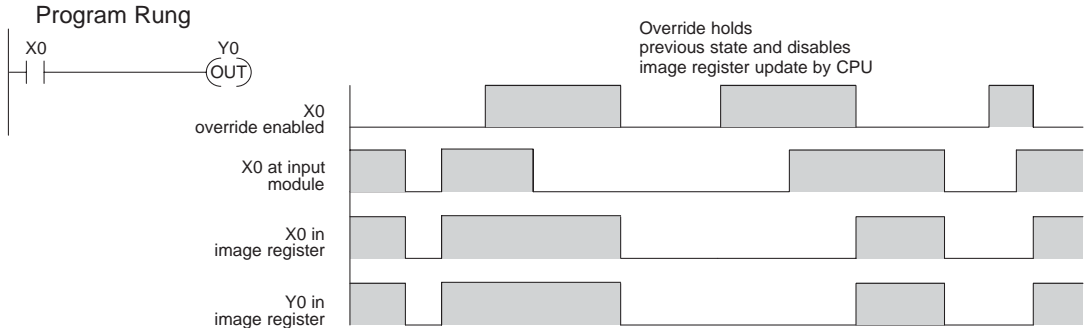
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There are two types of forcing available with the DL06 CPUs. (Chapter 3 provides a detailed description of how the CPU processes each type of forcing request).

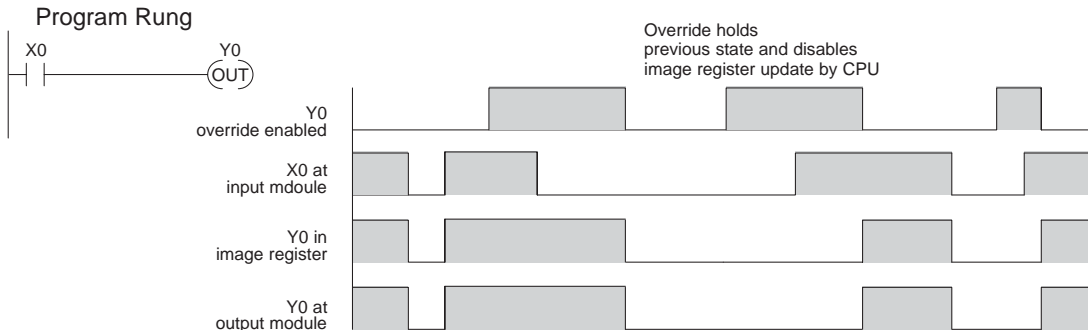
- **Regular Forcing:** This type of forcing can temporarily change the status of a discrete bit. For example, you may want to force an input on, even though it is really off. This allows you to change the point status that was stored in the image register. This value will be valid until the image register location is written to during the next scan. This is primarily useful during testing situations when you need to force a bit on to trigger another event.
- **Bit Override :** Bit override can be enabled on a point-by-point basis by using AUX 59 from the Handheld Programmer or by a menu option in DirectSOFT. You can use Bit Override with X, Y, C, T, CT, and S data types. Bit override basically disables any changes to the discrete point by the CPU. For example, if you enable bit override for X1, and X1 is off at the time, the CPU will not change the state of X1. This means that even if X1 comes on, the CPU will not acknowledge the change. Therefore, if you used X1 in the program, it would always be evaluated as “off” in this case. If X1 was on when the bit override was enabled, then X1 would always be evaluated as “on”.

There is an advantage available when you use the Bit Override feature. The Regular Forcing is not disabled because the Bit Override is enabled. For example, if you enabled the Bit Override for Y0 and it was off at the time, the CPU would not change the state of Y0. However, you can still use a programming device to change the status. If you use the programming device to force Y0 on, it will remain on and the CPU will not change the state of Y0. If you then force Y0 off, the CPU will maintain Y0 as off. The CPU will never update the point with the results from the application program or from the I/O update until the Bit Override is removed from the point.

The following diagrams show how the bit override works for both input and output points. The example uses a simple rung, but the concepts are similar for any type of bit memory.

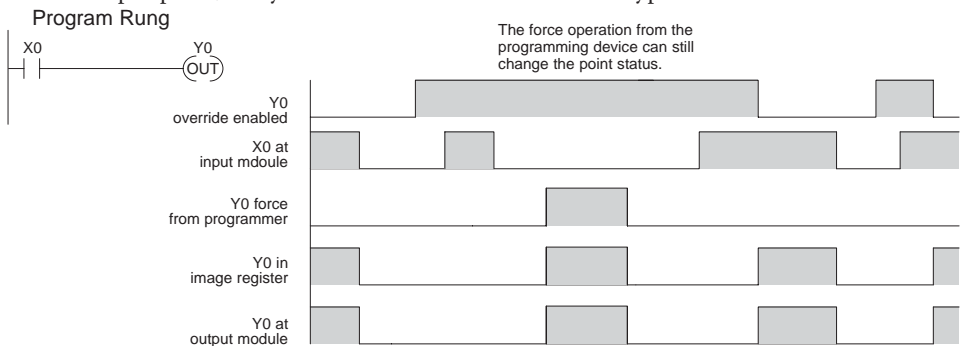


The following diagram shows how the bit override works for an output point. Notice the bit override maintains the output in the current state. If the output is on when the bit override is enabled, then the output stays on. If it is off, then the output stays off.

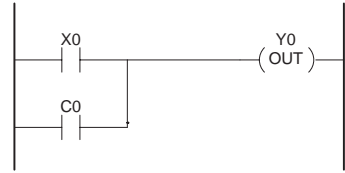


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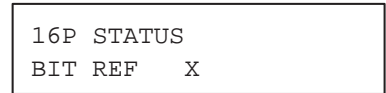
The following diagram shows how you can use a programming device in combination with the bit override to change the status of the point. Remember, bit override only disables CPU changes. You can still use a programming device to force the status of the point. Plus, since bit override maintains the current status, this enables true forcing. The example shown is for an output point, but you can also use the other bit data types.



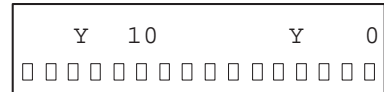
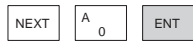
The following diagrams show a brief example of how you could use the DL06 Handheld Programmer to force an I/O point. Remember, if you are using the Bit Override feature, the CPU will retain the forced value until you disable the Bit Override or until you remove the force. The image register will not be updated with the status from the input module. Also, the solution from the application program will not be used to update the output image register. The example assumes you have already placed the CPU into Run Mode.



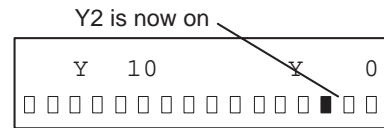
From a clear display, use the following keystrokes



Use the PREV or NEXT keys to select the Y data type. (Once the Y appears, press 0 to start at Y0.)

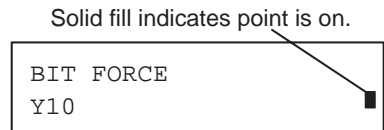


Use arrow keys to select point, then use ON and OFF to change the status

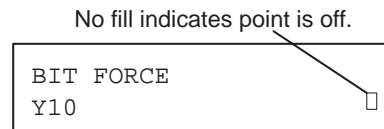


## Regular Forcing with Direct Access

From a clear display, use the following keystrokes to force Y10 ON. Solid fill indicates point is on.



From a clear display, use the following keystrokes to force Y10 OFF. No fill indicates point is off.



### Bit Override Forcing

From a clear display, use the following keystrokes to turn on the override bit for Y10.



Solid fill indicates point is on.



Small box indicates override bit is on.

Note, at this point you can use the PREV and NEXT keys to move to adjacent memory locations and use the SHFT ON keys to set the override bit on.

From a clear display, use the following keystrokes to turn off the override bit for Y10. Solid fill indicates point is on.

for Y10.



Solid fill indicates point is on.



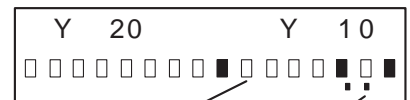
Small box is not present when override bit is off.

Like the example above, you can use the PREV and NEXT keys to move to adjacent memory locations and use the SHFT OFF keys to set the override bit off.

### Bit Override Indicators

Override bit indicators are also shown on the handheld programmer status display. Below are the keystrokes to call the status display for Y10 – Y20.

From a clear display, use the following keystrokes to display the status of Y10 – Y20.



Point is on

Override bit is on