Chapter 5 LD Edit

LD program displays the PLC program through graphic signals of coils or contact points used in the relay logic diagram.

### 5.1 Limits

There are functional limits in LD Program Edit as described below.

<table>
<thead>
<tr>
<th>Item</th>
<th>Description</th>
<th>Limit</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maximum contact points</td>
<td>Maximum contact points available to input in a line</td>
<td>Up to 31</td>
</tr>
<tr>
<td>Maximum lines</td>
<td>Maximum lines available to edit</td>
<td>Up to 65535</td>
</tr>
<tr>
<td>Maximum Copy lines</td>
<td>Maximum Copy lines available to copy at a time</td>
<td>Up to 300</td>
</tr>
<tr>
<td>Maximum Paste lines</td>
<td>Maximum Paste lines to paste at a time</td>
<td>Up to 300</td>
</tr>
</tbody>
</table>

### 5.2 Program Edit

#### 5.2.1 Edit Tools

The input of LD Edit items shall be started after the input symbols are selected from the LD tool box and the mouse clicked on the specified position or with applicable Shortcut Key pressed.

<table>
<thead>
<tr>
<th>Symbol</th>
<th>Shortcut Key</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Esc</td>
<td>Esc</td>
<td>Changes to selection mode</td>
</tr>
<tr>
<td>F3</td>
<td>F3</td>
<td>Normally open contact point</td>
</tr>
<tr>
<td>F4</td>
<td>F4</td>
<td>Normally closed contact point</td>
</tr>
<tr>
<td>Shift + F1</td>
<td>Shift + F1</td>
<td>Positive-conversion detection contact point</td>
</tr>
<tr>
<td>Shift + F2</td>
<td>Shift + F2</td>
<td>Negative-conversion detection contact point</td>
</tr>
<tr>
<td>F5</td>
<td>F5</td>
<td>Horizontal line</td>
</tr>
<tr>
<td>F6</td>
<td>F6</td>
<td>Vertical line</td>
</tr>
<tr>
<td>Shift + F8</td>
<td>Shift + F8</td>
<td>Connection line</td>
</tr>
<tr>
<td>Symbol</td>
<td>Shortcut Key</td>
<td>Description</td>
</tr>
<tr>
<td>--------</td>
<td>-------------</td>
<td>----------------------------------</td>
</tr>
<tr>
<td></td>
<td>Shift + F9</td>
<td>Reverse input</td>
</tr>
<tr>
<td></td>
<td>F9</td>
<td>Coil</td>
</tr>
<tr>
<td></td>
<td>F11</td>
<td>Reverse coil</td>
</tr>
<tr>
<td></td>
<td>Shift + F3</td>
<td>Set(latch) coil</td>
</tr>
<tr>
<td></td>
<td>Shift + F4</td>
<td>Reset(un latch) coil</td>
</tr>
<tr>
<td></td>
<td>Shift + F5</td>
<td>Positive-conversion detection coil</td>
</tr>
<tr>
<td></td>
<td>Shift + F6</td>
<td>Negative-conversion detection coil</td>
</tr>
<tr>
<td></td>
<td>F10</td>
<td>Application instruction</td>
</tr>
<tr>
<td></td>
<td>Ctrl+3</td>
<td>Normally opened OR contact point</td>
</tr>
<tr>
<td></td>
<td>Ctrl+4</td>
<td>Normally closed OR contact point</td>
</tr>
<tr>
<td></td>
<td>Ctrl+5</td>
<td>Positive-conversion detection OR contact point</td>
</tr>
<tr>
<td></td>
<td>Ctrl+6</td>
<td>Negative-conversion detection OR contact point</td>
</tr>
</tbody>
</table>

The following Shortcut Keys are related with the movement of the cursor. Applicable Shortcut Keys can not be specified by users XG5000.

<table>
<thead>
<tr>
<th>Shortcut Key</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Home</td>
<td>Moves to the start of the column.</td>
</tr>
<tr>
<td>Ctrl + Home</td>
<td>Moves to the start of the program.</td>
</tr>
<tr>
<td>Back space</td>
<td>Deletes the present data and moves to the left.</td>
</tr>
<tr>
<td>→</td>
<td>Moves the present cursor to the right by a blank.</td>
</tr>
<tr>
<td>←</td>
<td>Moves the present cursor to the left by a blank.</td>
</tr>
<tr>
<td>↑</td>
<td>Moves the present cursor upward by a blank.</td>
</tr>
<tr>
<td>↓</td>
<td>Moves the present cursor downward by a blank.</td>
</tr>
<tr>
<td>End</td>
<td>Moves to the end of the column.</td>
</tr>
<tr>
<td>Ctrl + End</td>
<td>Moves to the last line edited.</td>
</tr>
</tbody>
</table>

Notes
- Among Shortcut Keys in Edit Toolbox, ‘s’ stands for Shift key, ‘c’ for Ctrl key.
  Example) Positive-conversion detection contact point: Shift + F1 → s + F1 → sF1
- The Shortcut Keys described in Edit Tool are based on the Shortcut Keys basically provided in XG5000.
- For setting details on the user defined Shortcut Keys, Refer to 2.4 Shortcut Setting in Chapter 2 Basic Application.
5.2.2 Input Contact Point

This is used to input the contact points (normally open contact, normally closed contact, positive-conversion detection contact and negative-conversion detection contact).

[Steps]
1. Move the cursor to the location to input the contact point on.

2. On the tool box, select the type of the contact to input and then click the edit area. Or click the Shortcut Key applicable to the contact to input.

3. After the device name is input on the Variable Input Dialog Box, click [OK]. Refer to 5.2.3 Variable/Device Input for details on the Variable Input Dialog Box.
Notes

- Select [Tool]-[Option]-[Option Dialog Box] on the menu. If the Input mode is promptly released from the LD/IL Edit page, the Variable Input Dialog Box will not be displayed.

- The basic operation of Enter key is to input identical kind of instruction used previous edit. 
  *Example* If a normally open contact is input and entered in the previous edit, the normally open contact input dialog box will be displayed when enter key is pressed.

5.2.3 Input OR Contact Point

Inputs OR contact point (Normally opened OR contact point, Normally closed OR contact point, Positive-conversion detection OR contact point, Negative-conversion detection OR contact point)

[Steps]
1. Move the cursor where you want connect OR
2. Select contact point kind at Toolbar and click editing area. Or press shortcut key corresponding to OR contact point

3. Input device name at dialog box for variable input. For detail on dialog box for variable input, refer to 5.2.4

**Note**
- In duplicated mode, in case contact point is in cursor, OR connection does not operate
- In there is application instruction etc, vertical line is not inserted
5.2.4 Input Variable/Device

It is used to input the Device or Variable/Comment.

[Dialog Box]
Chapter 5 LD Edit

[Description of Dialog Box]
a. Variable/Device: used to input the Device or Declared Variable name. If the input String is of variable format and the applicable String is not registered as a variable in the Variable/Comment, the Variable/Comment Add Dialog Box will be displayed.
b. Add to Symbol: used to decide to add the input device to the Variable/Comment automatically or not. With Variable/Comment Automatic Add selected if any other device than registered on the Variable/Comment list is input, the Variable/Comment Add Dialog Box will be displayed.
c. Variable/Comment: used to display the Declared Variable/Comment on the list.
d. Flag: displays flags on the list. Detailed flag type can be selected on the flag item.
e. Item: as the selection box, it displays the types of the flags. System/High-speed Link/P2P/PID Flags are available to select.
f. All: used to decide to display all the flags selected on the item or the flags only applicable to the input parameter number/block index.
g. Parameter number: used to input the setting number for each selected flag item. 0~12 is available for HS link, 0~8 for P2P and 0~63 for PID.
h. Block Index: used to input the block number for each selected flag item. 0~127 is available for High-speed link and 0~63 for P2P.
i. Variable/Comment List: displays the details of Variable/Comment and flags.
j. Modify: used to modify the selected Variable/Comment.
k. Delete: used to delete the selected Variable/Comment.
l. OK: applies the input or selected items and closes the Dialog Box.
m. Cancel: closes the Dialog Box.

[Dialog Box]

[Description of Dialog Box]
a. Device: used to input the device to add.
b. Variable: used to input the variable name to add.
c. Comment: used to input the description to add.
**Notes**

- If the variable name is input on the Variable/Device Input Dialog Box, it will be automatically completed based on the presently displayed Variable/Comment list. For example, if flag is monitored and ‘FA’ is input, the address will be changed to F000A automatically. And if Variable/comment is displayed, and ‘FA’ is input, the software finds the variables whose the first two characters are F and A and converts the variable automatically.
- It is unable to cancel or redo for edited Variable/Comment.

### 5.2.5 Input Line

The horizontal line shall be input for horizontal connection between LD Edit factors, and the vertical line shall be for vertical connection.

#### 1) Horizontal Line Input

**[Steps]**

1. Move the cursor onto the location to connect to.

![Horizontal Line Input Diagram](image)

2. Select the Shortcut Key of Horizontal Line Input. Or select Horizontal Line on the tool box to select the Edit area to input the Horizontal Line in.

![Horizontal Line Input Diagram](image)

#### 2) Vertical Line Input

**[Steps]**

1. Move the cursor onto the location to connect to.

![Vertical Line Input Diagram](image)
2. Select the Shortcut Key of Vertical Line Input. Or select Vertical Line on the tool box to select the Edit area to input the Vertical Line in.

Notes
- The vertical line will be input downward to the left from the location of the present cursor.

5.2.6 Input Coil

It is used to input the coils (coil, reverse coil, positive-conversion detection coil and negative-conversion detection coil).

[Steps]
1. Move the cursor to the location to input the coil on.

2. On the tool box, select the type of the coil to input and then click the edit area. Or click the Shortcut Key applicable to the coil to input.
3. After the device name is input on the Variable Input Dialog Box, click [OK].

![Diagram](image1)

<table>
<thead>
<tr>
<th>L1</th>
<th>M00000</th>
<th>F00092</th>
<th>M00002</th>
</tr>
</thead>
<tbody>
<tr>
<td>L2</td>
<td>T200M6</td>
<td></td>
<td>S.ON</td>
</tr>
</tbody>
</table>

**Notes**

- If a coil and output related application instruction is input, a horizontal line will be automatically input to connect with the left factor.
- In case there is duplicate coil, output to output module according to status of last coil.

### 5.2.7 Input Application Instruction

It is used to input the application instruction for calculation.

**[Steps]**

1. Move the cursor to the location to input the application instruction on.

![Diagram](image2)

**Notes**

- If a coil and output related application instruction is input, a horizontal line will be automatically input to connect with the left factor.
- In case there is duplicate coil, output to output module according to status of last coil.

2. On the tool box, select the application instruction to input and then click the edit area. Or click the Shortcut Key applicable to the application instruction input.

Input the application instruction, or edit the input application instruction.
[Description of Dialog Box]

a. Instruction: used to input the application instruction. If the input application instruction is edited, the previous application instruction will be displayed in default.

b. Category: used to display the application instructions classified. If specific classification is selected, the instructions applicable to the classification will be displayed on the instructions list.

c. Variable (Ins.): used to display the classification of the input application instructions, the application method and the available area for each operand.

d. Instruction: the list of the instructions which belong to the specified classification will be displayed. If ‘All’ is selected, all the instructions will be displayed.

e. Usage: used to display the Variable/Device Input Dialog Box.

f. Command Help: used to display the help for the selected input command.

g. OK: Applies the input details and closes the Dialog Box.

h. Cancel: closes the Dialog Box.
3. On the Application Instruction Input Dialog Box, input the application instruction, and then click [OK].

```
L1  M00000  F00052  M00002
  3D     2000MS    S.ON
L2  _     _     _     _
L3  _     _     _     _
L4  _
      MCV  hFOFO  L00023
```

**Notes**
- Refer to XGK CPU manual for details on the application instructions.
- The following steps lead you to edit application instructions easily.
  1. Input application instruction.
  2. Variable/Device input dialog box will be displayed when Enter key is pressed.
  3. Input the device on the Variable/Device input dialog box.
  4. The Variable/Device name will be displayed when input is finished.
  5. If the input operand is not the last operand for the instruction, the cursor will move to
     the position to input next operand.

### 5.2.8 Inputting the Applied Command of Functions/Function Blocks

The command is available only if it is created through ‘Device Auto-allocation project’.

**Steps**
1. Move your cursor to the position to input the command applying extended functions.

2. Select the command applying extended functions and click the edition area. Otherwise, press the short
   key to input the command applying extended functions.
a. Name: Searches the names for the functions.
b. List: Displays the list for the functions.
c. Category: Displays the classification of the extended functions.
d. Function information: Displays the designated function's information.
e. Function list: Displays the list of the extended functions.
f. Max. No. of input: Fixes the maximum input of the functions.
g. No. of input: Determines the number of inputs for the functions.
h. OK: Applies the input details and close the dialog box.
i. Cancel: Closes the dialog box.

After inputting the applied command in the dialog box to input the applied command, press OK button.
5.2.9 Input Comment

It is used to input the Rung and Output Comment. The comment displayed on the start position of Rung is called [Rung Comment], and the comment for the output factor is called [Output Comment].

1) Rung Comment

[Steps]
1. Move the cursor to the location to input the rung comment on.
2. Select [Edit]-[Comment/Label Input].

[Dialog Box]
Input the Comment and Label.
[Comment of Dialog Box]
a. Comment: used to select the Rung Comment to input.
b. Label: used to select the Label to input.
c. OK: applies the selected details and closes the Dialog Box.
d. Cancel: closes the Dialog Box.

3. If the Rung Comment Dialog Box is displayed, input the comment and click [OK].

[Dialog Box]
Input or edit the Rung Comment or the Output Comment.

[Description of Dialog Box]
a. Comment: used to input the details of the rung comment or the output comment.
b. OK: applies the input details and closes the Dialog Box.
c. Cancel: closes the Dialog Box.
2) Output Comment

[Steps]
1. Move the cursor to the location to input the output comment on.

2. Double-click the left mouse button or press Enter key.

3. Input the output comment on the Output Comment Dialog Box and then click [OK].

Notes
- The output comment will be available to input only when the output factor exists.

5.2.10 Input Label

This is used to input the label to refer to from the application instruction of JMP.

[Steps]
1. Move the cursor to the location to input the label on.
2. Select [Edit] – [Comment/Label Input].
3. On the Dialog Box, select Label and then press Enter or click [OK].

4. On the Label Dialog Box, input the label to add, and then click [OK].

[Comment of Dialog Box]

a. Label: used to input the label to use.

b. Label being used: used to display the label presently used in the same scan program.
5.2.11 Insert Cell

It is used to insert a new cell in the present cursor position.

[Steps]
1. Move the cursor to the location to insert the cell in.

2. Select [Edit] - [Cell Insert].

Notes
- Up to 16 characters in English is available for the label.
- Capital/Small letters are sorted out for the label. The first letter of the label can not be a figure or a special character.
- Label Input rules shall conform to the Variable/Comment Input rules. Refer to 4.2.1 in Chapter 4 Variable/Comment for details on the Variable/Comment Input rules.
5.2.12 Insert Line

It is used to insert a new line in the present cursor position.

[Steps]
1. Move the cursor to the location to insert the line in.

2. Select [Edit] - [Line Insert].

Notes
- If Line Insert is executed, a new line will be inserted in the present cursor position.
- If an area is selected for Line Insert, new lines as many as the lines in the selected area will be inserted.
5.2.13 Delete Factor

It is used to delete the input contact point, coil, application instruction, line, rung/output comment and label.

[Steps]
1. Move the cursor to the location to delete the factor from.
2. Select [Edit] - [Delete].

5.2.14 Delete Cell

It is used to delete the factors such as the input contact point and horizontal line to draw in the next cell.

[Steps]
1. Move the cursor to the location to delete the cell from.
Notes

- Delete Cell operates in rung unit.
- If among the factors connected with OR, any other factor than the horizontal line is included in the present cursor position, Delete Cell is unavailable.

5.2.15 Delete Line

It is used to delete all the lines in the selected area.

[Steps]
1. Move the cursor onto the line to delete.
2. Select [Edit] - [Line Delete].

5.2.16 Copy/Cut/Paste

It is used to copy the data in the selected area, or cut the data to copy on the specified position. Differently from [Copy], [Cut] is used to delete the data in the presently selected area.

1) Copy

[Steps]
1. Select the area to copy.

3. Move the cursor to the area to paste on.

2) Cut

[Steps]
1. Select the area to cut.


3. Move the cursor to the area to paste on.
5.2.17 Drag & Drop

Drag & Drop function allows for faster moving and copying of program items. Moving and copying the LD data with Drag & Drop function is available in the LD program. And the dragging the information of Variable/Comment in the Variable/Comment window and dropping to the operands of contacts, coils, and application instruction is possible.

1) Drag & Drop.
Select items or area to drag and move the cursor to the selected area. The shape of cursor will be changed when the mouse cursor is moved to selected item or area. The change of mouse cursor shape means that Drag & Drop is ready.

When Move Data.

When Copy Data

When Move or Copy Data is not allowed

2) Move Data.
It is used to move data in the selected area. The original data will be deleted after moving. The steps to move data with Drag & Drop function are as follows.

[Steps]
1. Select the items or area where the data to be moved is located.
2. Move the mouse cursor to the selected area and press the left mouse button. The outline of the object(s) will change and a rectangle symbol will appear under the cursor.

3. Release the left mouse button after moving the cursor to the area where the data is moved to.

3) Copy Data.
It is used to copy data included in the selected area. Different from moving data, the original data will remain. To copy data, Ctrl key must be pressed while Drag & Drop function is executed. The steps to copy data are as follows.

[Steps]
1. Select the items or area where the data to be copied is located.
2. Move the mouse cursor to the selected area and press the left mouse button and Ctrl key of keyboard. Wait until the shape of mouse cursor is changed.

3. Release the left mouse button and Ctrl key after moving the cursor to the area where the data is moved to.

4) Paste Variable/Comment.
It is used to paste device (including Variable/Comment) from Variable/Comment window to instructions. This function is available for contacts, coils and application instructions, but it is not available if data types of operand and copied data are mismatch. The steps to paste variable/comment with Drag & Drop function are as follows.

[Steps]
1. Select an item to be copied in the Variable/Comment window and move the mouse cursor to the boundary of the cell and start Drag & Drop.

2. Drag the mouse to the position where the selected device is copied to. At this moment, the shape of cursor will be changed if drop is possible.
3. Release the mouse button.

Notes.
- It is possible to copy the device information from variable monitor window.
- It is possible to copy the device information from trend monitor window.

5.2.18 Undo and Redo

It is used to Undo the details edited by Program Edit back to its previous state, or execute again the details cancelled.

1) Undo (example of Delete)

[Sequence]
1. Move the cursor onto the position to delete.


2) Redo (example of Delete)
1. Select [Edit] - [Redo].

Notes
- All the edited details can be cancelled or executed again.
- The number of times to cancel the execution is unlimited.
- The shortcut key for Undo is “Ctrl + Z”, Redo is “Ctrl + Y”.

5.2.19 Change Columns

It allocates the number of contacts that can be inserted in a line.

1) Change Columns.

[Steps]
1. Select [View]-[Change Columns] on the menu.
2. Select the number of contacts can be inserted in a line. The choices are 9, 12, 16, 20, 24, 28, 32.

2) Increase columns.

[Steps]
1. Select Increase columns on the View tool bar.
3) Decrease columns

[Steps]
1. Select columns on the View tool bar.

Notes
- The range of columns is 9 ~ 32.
- If the columns inserted in a line is greater than assigned number, ‘▶’ mark will be displayed as below.
  The connection to the next line will be displayed with ‘connection number’ mark and connected line
  will be displayed with ‘connection number’ mark.

- Line number may be converted or duplicated when Change Columns function is used.

5.2.20 LD View Properties
Specifies LD View Properties. In properties, you can specify setting about device view, variable view,
comment view, Magnification and number of contacts. For entire LD screen, you can specify same properties

[Steps]
1. Select [View]-[LD View Properties]
2. Change LD View Properties and press OK

[Dialog box]
5.3 Program View

It is used to specify the Program View options.

5.3.1 IL Program View

It is used to convert the LD program to the IL program in IL format so to display or edit the IL program as converted.

[Sequence]

1. Select the program.

   1. Select the program.
   2. Select [View] - [IL].

   Notes
   - If any incomplete rung exists, the LD program can not be converted to IL program.
5.3.2 Program Magnification Change

This is used to change the magnification of the LD program displayed on the screen.

1) Zoom-In
[Sequence]
1. Select [View]-[Zoom-In] on the menu.

2) Zoom-Out
[Sequence]
1. Select [View]-[Zoom-Out] on the menu.

Notes
- Ctrl + Wheel Up, if available perform Zoom-Out step by step.
- Ctrl + Wheel Down, if available perform Zoom-In step by step.
- On the View Tool selection box, the user can select or directly input the magnification. Refer to 2.2 Tool Box in Chapter 2 Basic Application for more details.

5.3.3 View Device

It is used to display only the name of the applicable device for the device used as the operand of the contact point, coil and application instruction.

[Sequence]
1. Select [View]-[Devices].
5.3.4 View Variable

View Variable is used to display the name of the variable for the device used as the operand of the contact point, coil and application instruction. If no variable is declared for the applicable device, it will be displayed as the device name.

[Sequence]
1. Select [View]-[Variable].

5.3.5 View Device/Variable

View Device/Variable is used to display the name of the device/variable for the device used as the operand of the contact point, coil and application instruction. If no variable is declared for the applicable device, the device name only will be displayed.

[Sequence]
1. Select [View]-[Devices/Variables] Item.

5.3.6 View Device/Comment

View Device/Comment is used to display the device/comment for the device used as the operand of the contact point, coil and application instruction. If no comment is available for the applicable device, the device name only will be displayed.
[Steps]
1. Select [View]-[Devices/Comments] Item.

5.3.7 View Variable/Comment

View Variable/Comment is used to display the variable/comment for the device used as the operand of the contact point, coil and application instruction.

[Steps]
1. Select [View]-[Variable/Comment]

Notes
- If View Options are changed, it may take some time based on the number of the edited program steps.
- Print function of the Device/Variable/Comment is available.
5.4 Edit Function Additional

Additional editing functions are described below.

5.4.1 Optimize Program

Optimize Program is used to delete the horizontal and empty lines between the contact points to optimize the drawn LD.

[Sequence]

Notes
- Optimize Program cannot be undone.
- It may take some time based on the size of the program.
- If the LD logic is not complete, optimization function doesn't operate.
5.4.2 Block Mask Instruction

The Block Mask Instruction is used to specify or cancel the area Block Mask in PLC among the LD programs.

1) Block Mask Instruction Setting

[Sequence]
1. Move the cursor to the rung to specify the Block Mask instruction.

2. Select [Edit] - [Set Block Mask Instruction].
2) Block Mask Instruction Cancel

[Sequence]

1. Move the cursor to the rung to cancel the Block Mask instruction.

2. Select [Edit] - [Remove Block Mask] on the menu.

**Notes.**
- The program capacity of block masked area is included not in the program capacity but comment capacity.
- The program in the block masked area can be written to PLC and read from PLC just like comment.
- Online edit is not available for the block masked program. To modify the block masked program when PLC is running, write comment function is available.
5.4.3 Bookmark

Bookmarks allow the user to mark rungs of the LD for referencing later by just navigating to the next bookmark.

1) Set Bookmark

[Sequence]

1. Move the cursor to the line to specify the bookmark on.

2) Bookmark Reset

[Sequence]

1. Move the cursor to the line to cancel the bookmark from.

3) Reset All Bookmark

[Sequence]

4) Previous Bookmark

[Sequence]
5) Next Bookmark

[Sequence]


Notes

- Bookmark will be specified in line unit.
- [Move to Previous Bookmark] and [Move to Next Bookmark] function is effective in the same program.
- Bookmark is not an item to edit, thus the Set/Reset options will not be included in Undo and Redo.
5.4.4 Go To

Go To is used to move to the step position the program has specified, or go to the position of the edited label and rung comment.

1) Go To Step
[Sequence]
1. Select [Find/Replace]-[Go To]-[Step/Line].

[Dialog Box]

[Description of Dialog Box]
a. Go to what: used to input the step to go to.
b. Program list: used to display the list of the present PLC programs.
c. Go to: closes the Dialog Box to go to the selected program’s step to find.
d. Cancel: closes the Dialog Box.

2. Input the step to move to on the Dialog Box.
2) Go To Label

[Sequence]
1. Select [Find/Replace]-[Go To]-[Label].

[Dialog Box]

[Description of Dialog Box]

a. Program: used to display the list of the present PLC programs. If ‘All Programs’ is selected, the list of all the labels will be displayed.
b. Labels list inside the program: used to display the list of the labels used in the selected program.
c. Go To: closes the Dialog Box to go to the selected label.
d. Close: closes the Dialog Box.

2. Select the label to go to on the Dialog Box.
3) Go To Rung Comment

[Sequence]

1. Select [Find/Replace]-[Go To]-[Rung Comment].

[Dialog Box]

a. Program: used to display the list of the present PLC programs. If 'All Programs' is selected, the list of all the rung comments will be displayed.

b. Rung comment list: used to display the list of the rung comments used in the selected program.

c. Go to: closes the Dialog Box to go to the selected rung comment.

d. Close: closes the Dialog Box.

2. Select the rung comment to go to on the Dialog Box.
4) Go To END Instruction

[Sequence]
1. Select [Find/Replace]-[Go To]-[END Instruction] on the menu.

[Dialog Box]

[Description of Dialog Box]

a. Program: used to display the list of the present PLC programs. If ‘All Programs’ is selected, the list of all 
   the END instructions will be displayed.

b. END instruction list inside the program: used to display the list of the END instructions used in the 
   selected program.

c. Go to: closes the Dialog Box to go to the selected END instruction.

d. Close: closes the Dialog Box.

2. Select the END instruction to go to on the Dialog Box.