

Fig. 8-3: <Example>

Line	Instruction
10	MOVL V=100
11	TIMER T=1.00
12	DOU OT# (1) ON
13	MOVL V=50

Cursor position

Fig. 8-4: S2C206-0 (Before the Next Step)

Line	Instruction
10	MOVL V=100
11	TIMER T=1.00
12	DOU OT#(1) ON
13	MOVL V=100
14	MOVL V=50

Added step

Fig. 8-5: S2C206-1 (Between Instructions)

Line	Instruction
10	MOVL V=100
11	TIMER T=1.00
12	MOVL V=100
13	DOU OT# (1) ON
14	MOVL V=50

Added step

#### 8.3.0.9 S2C207: MASTER JOB CHANGING OPERATION

This parameter specifies whether to permit or prohibit master job changing operation. If "PROHIBIT" is specified, the master job cannot be changed (or registered) easily. The specification can be done on the OPERATING CONDITION window.

- 0 : Permitted
- 1 : Prohibited

#### 8.3.0.10 S2C208: CHECK AND MACHINE-LOCK KEY OPERATION IN PLAY MODE

This parameter specifies whether to permit or prohibit in play mode to change the operation that changes the operation condition. Even if an error occurs because of the operation with the keys, the manipulator does not stop. The specification can be done on the OPERATING CONDITION window.

- 0 : Permitted
- 1 : Prohibited