

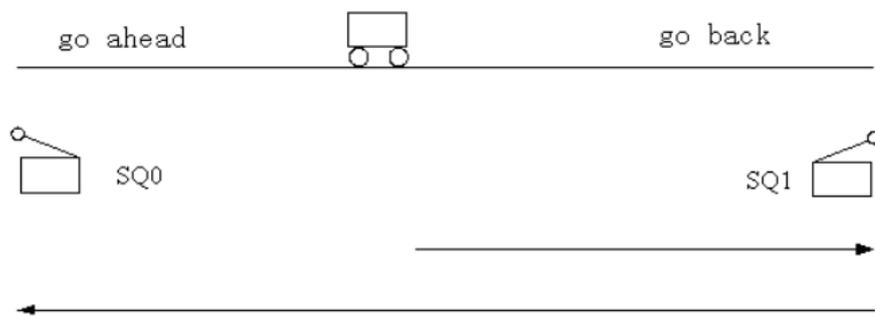
## Via flow instructions, realize the cargo controlled

### Summary

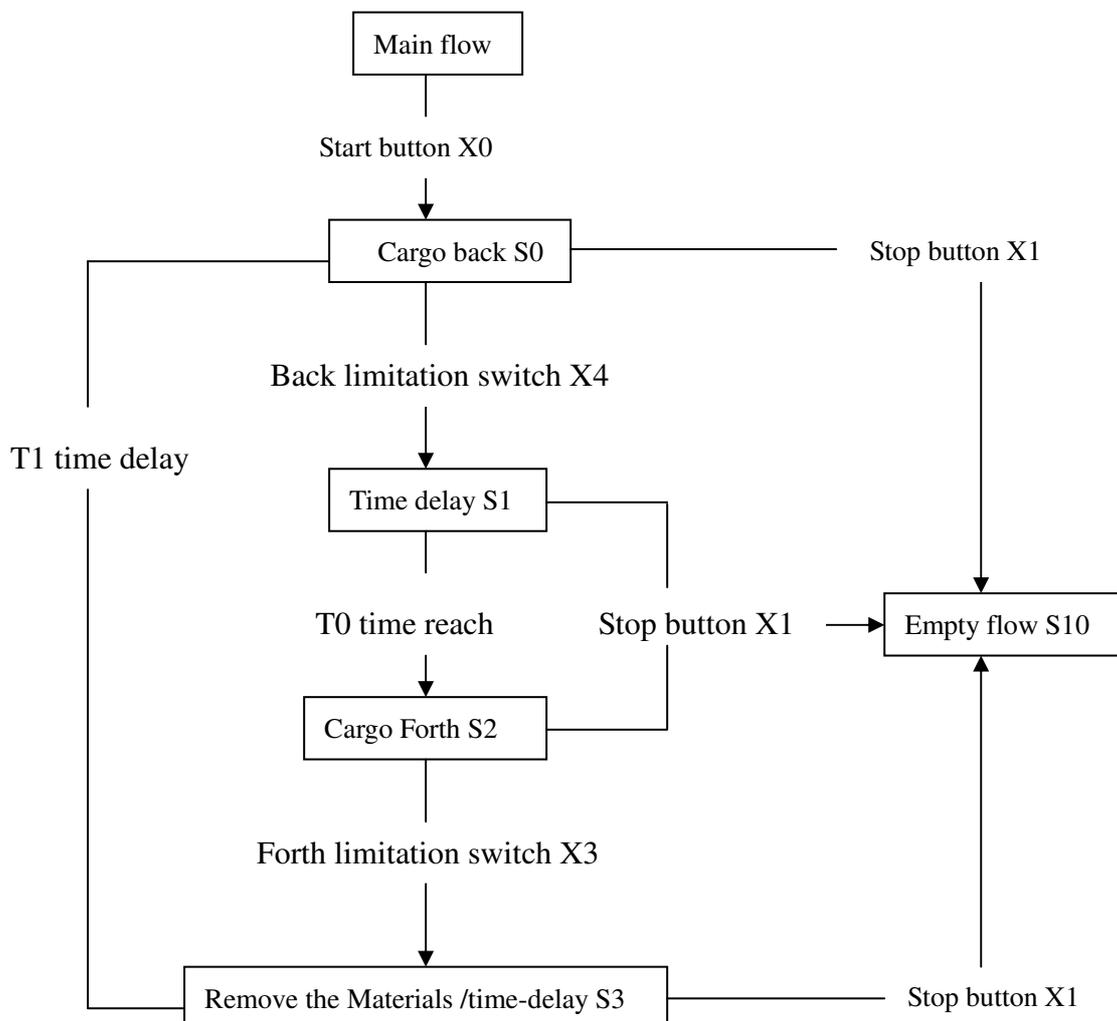
XC Series PLC's offer 4 (four) instructions: **STL**, **STLE**, **SET**, **ST**. **STL**, **STLE** should be used in pairs. **STL** indicates the start of a flow, while **STLE** indicates the end of a flow. Executing **SET Sxxx**, Sxxx flow will be open, while the current flow will be closed. But, when executing **ST Sxxx**, flow **Sxxx** will be open but the current flow is not closed.

This example shows an automatic control flow of a cargo. The program executes the events step by step sequentially. Each step includes a series of actions. Also, only the conditions fulfill the requirements, the program can be executed.

### Graph:



### Flow Chart:



**Program Description:**

After pressing the start button X0, the cargo will go back. When reaches back limitation switch X4, the cargo will stop and delay 5 seconds. When delay time reaches, the cargo will go forth. When reaches the forth limitation switch X3, the cargo will stop to remove the materials. After 8 seconds delay, the cargo will go back again. Unless you press down the stop button, the cargo will keep working in this loop

**Program:**

