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You assign qualifiers to IEC steps. Qualifiers describe how a step action is processed.

Qualifiers are processed by the SFCActionControl function block in the library IecSfc.library. The library is automatically integrated into the project by the SFC plug-in.

Available qualifiers

N	Non-stored	The action is active as long as the step.
R	overriding Reset	The action is deactivated.
S	Set (Stored)	PLC Engineering executes this action as soon as the step is active. The action execution is continued even when the step has been deactivated until it gets a reset.
L	time Limited	PLC Engineering executes this action as soon as the step is active. The action is executed until the step is deactivated or the given time span has elapsed.
D	time Delayed	PLC Engineering begins executing the action only after the given delay time has elapsed following step activation and the step is still active. The action is executed until the step is deactivated.
P	Pulse	PLC Engineering executes the action exactly two times: one time when the step is activated and one time when the step is deactivated.
SD	Stored and time Delayed	PLC Engineering begins executing the action only after the given delay time has elapsed following step activation. The action is executed until it gets a reset.
DS	Delayed and Stored	PLC Engineering begins executing the action only after the given delay time has elapsed following step activation and the step is still active. The action is executed until it gets a reset.

SL	Stored and time limited	PLC Engineering executes this action as soon as the step is activated. It is executed until the specified time has elapsed or it gets a reset.

You have to specify the times for the L, D, SD, DS, and SL qualifiers in the format of a TIME constant.

When an IEC action is deactivated, it is executed one more time. This means that PLC Engineering executes this kind of action at least two times. This also applies to actions with the P qualifier.

See also

- ↘ “Programming in SFC”