Address Stop

Program execution of any test may be stopped at any point in the program by using the Address Stop feature. This is done by -

1. Setting the Mode Switch to ADDRESS STOP.
2. Setting the address of the desired stop in the MANUAL ADDRESS (dial) SWITCHES.
3. Pressing the Start Key.

The program is executed until the address in the address register equals the one set up in the Manual Address Switches. At this point, program execution stops. This can occur on I-, A-, or B-addresses. To continue programming from that point on, press the Program Start Key. Program execution continues until the address stop condition is again satisfied.

Single Cycle Process

If it is desirable to check the operation cycle-by-cycle from the point where the stop occurs, set the Mode Switch to Single Cycle Process, and press the Program Start Key.

Scoping Procedure

Two methods are provided in the majority of tests for indicating errors. Both methods are under the control of Sense Switch E: (1) When this switch is ON the machine stops for any detail card processed in error; (2) When OFF the machine prints the error results and continues without interruption.

In the first case, the card processed in error may be re-processed indefinitely by setting Sense Switches B and D to the ON position, and pressing the Start Key. Sense Switch D branches to the main body of the program, and Sense Switch B executes the main operation tested in the program in a tight loop repeatedly, thus permitting the use of scoping techniques.

In the second case, since the machine continues without interruption after an error is detected, the following procedure is recommended:

1. Stop the machine manually.
2. Set Sense Switches B and D to the ON position.
3. Remove cards from the hopper and perform a Non-Process Run-Out to clear the feed.
4. Remove cards for the block being tested from the stacker.
5. If the program for the error card is still in storage, replace the error card in the hopper and press the Start Key.
6. If the program for the error card is not in storage, place the Instruction Cards in front of the error card and re-run by pressing the Load Key.

The scoping loop is programmed not only for error results but also for correct results.

NOTE: It may be necessary to turn the Process Check Stop Switch OFF in order to keep the program running for scoping.