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\*\*\*\*\* Multi-Tank Batch Control \*\*\*\*\*

Additional internal memory:

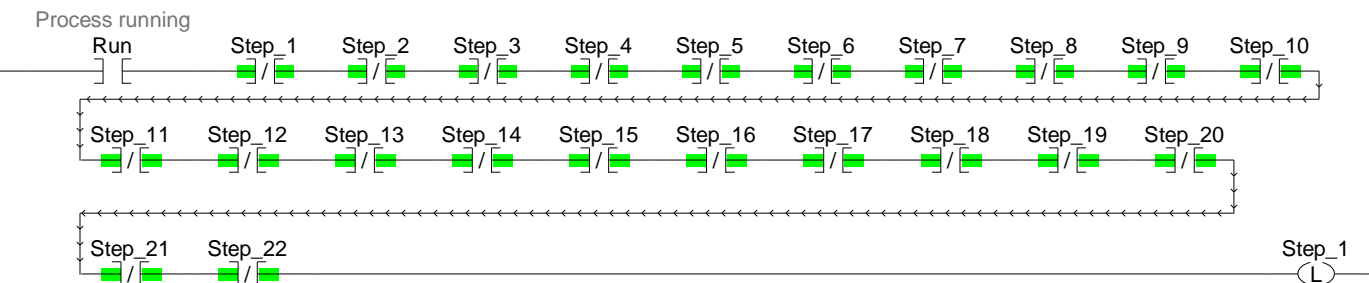
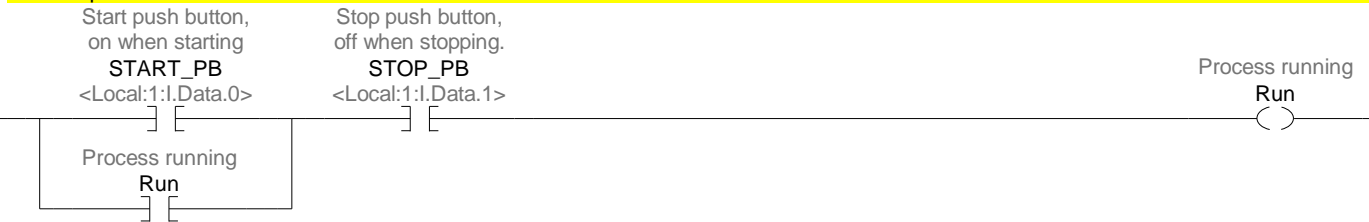
Tag	Data Type	
Run	BOOL	On while station running
Step_1 to Step_22	BOOL	Step-in-progress bits
Delay_Tmr	TIMER	Delay after emptying half of tanks
Reaction_Tmr	TIMER	Times reaction

Conversion formulas

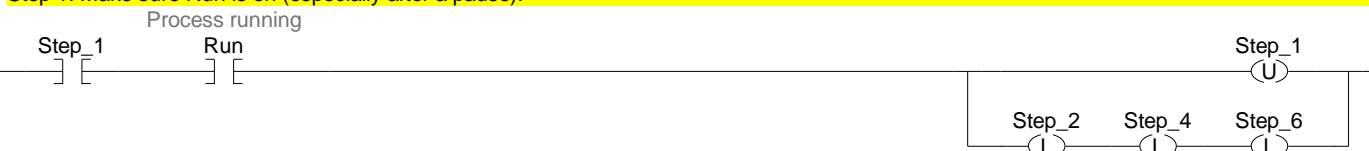
$WT10x\_VAL = (WT10x\_MEAS/100) * (1000-0) + 0$

$TT103\_VAL = (TT103\_MEAS/100) * (100-0) + 0$

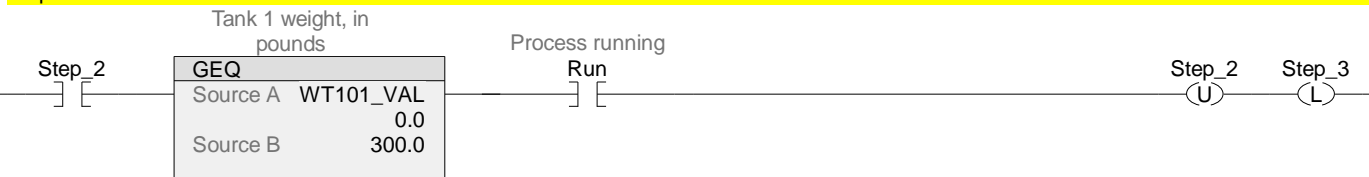
Start/Stop. Initial start



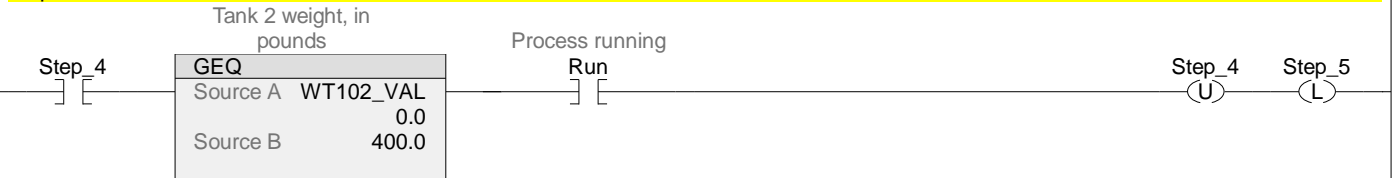
Step 1. Make sure Run is on (especially after a pause).



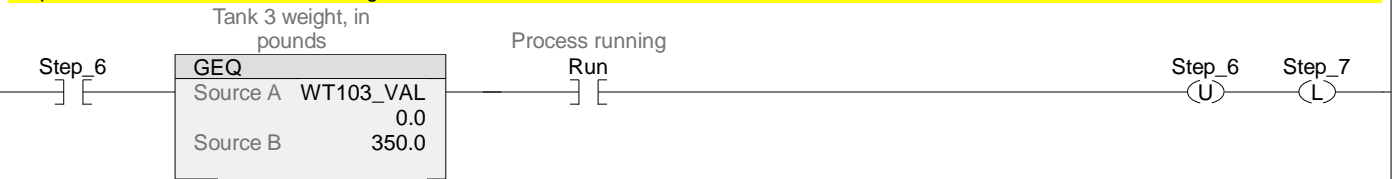
Step 2. Fill Tank 1. Transition to wait when full.



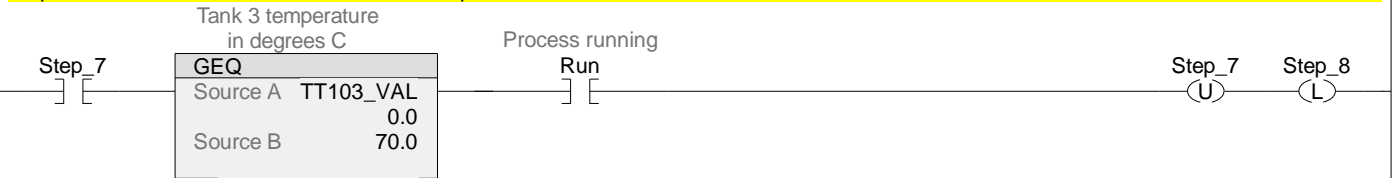
## Step 4. Fill Tank 2. Transition to wait when full.



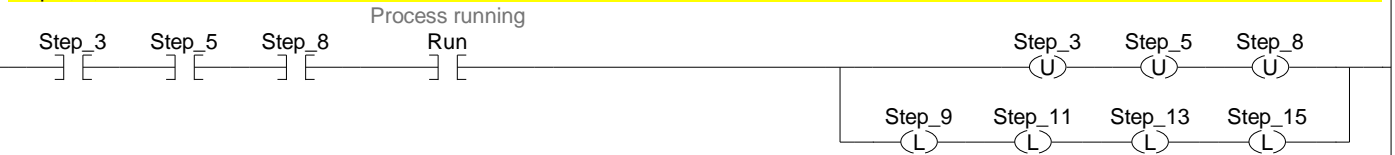
## Step 6. Fill Tank 3. Transition to heating when full.



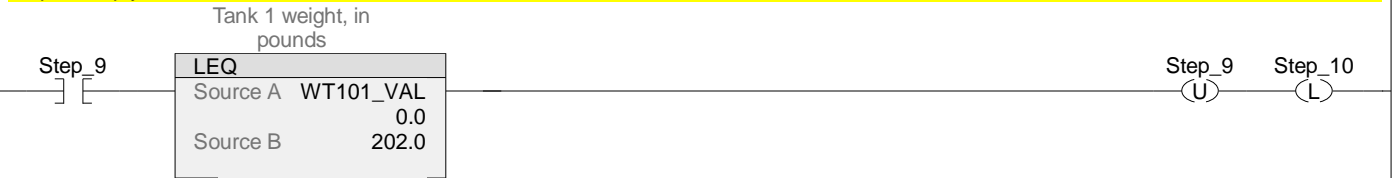
## Step 7. Heat Tank 3. Transition to wait when temperature &gt;= 70.



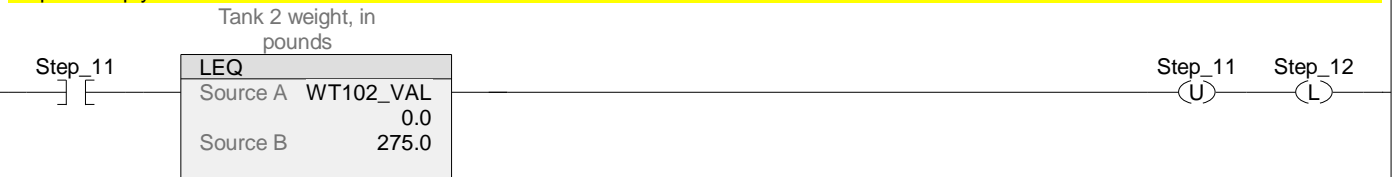
## Step 3, 5, 8. Wait until all tanks full and Tank 3 heated.



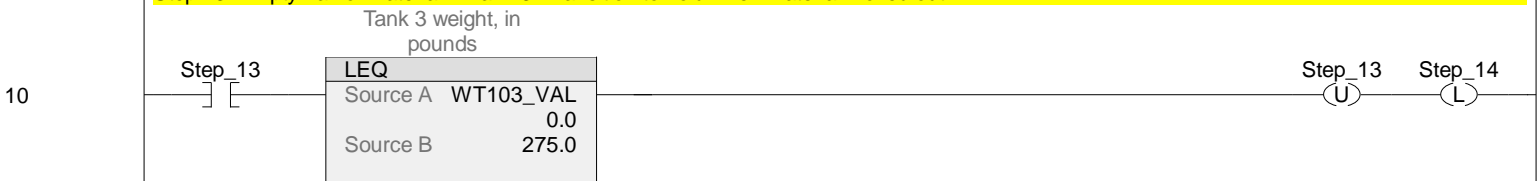
## Step 9. Empty Tank 1. Transition to hold when material moved out.



## Step 11. Empty half of material in Tank 2. Transition to hold when material moved out.



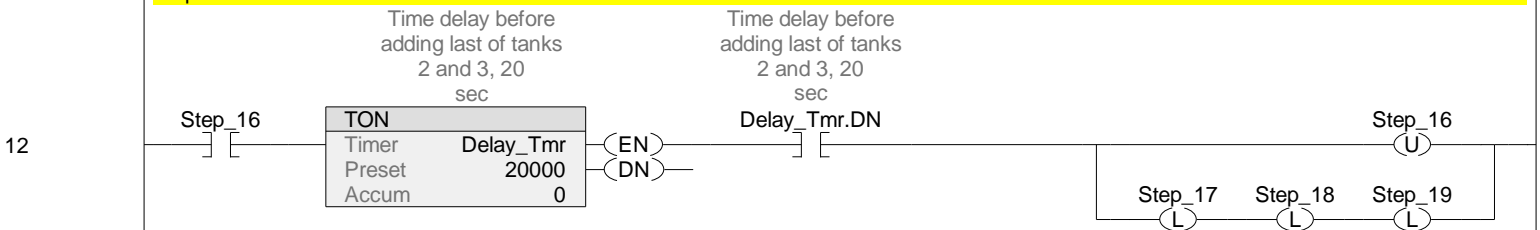
Step 13. Empty half of material in Tank 3. Transition to hold when material moved out.



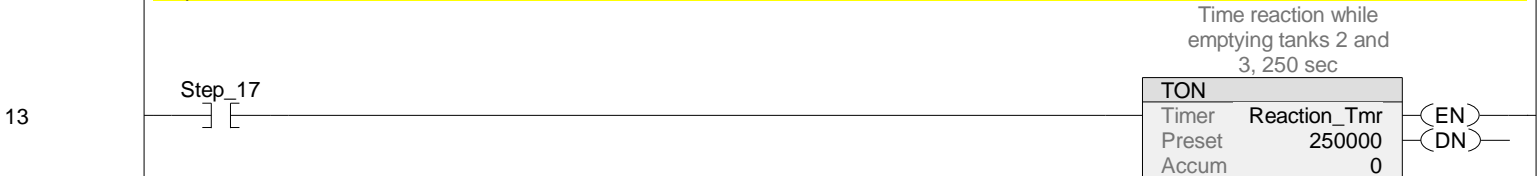
Steps 10, 12, 14, 15. Stir while waiting until all tanks have unloaded appropriate amount of material.



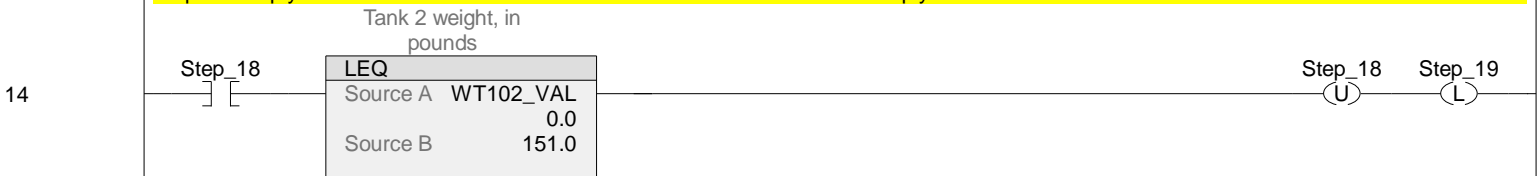
Step 16. Wait for 20 seconds.



Step 17 - 250 sec reaction time.



Step 18. Empty remainder of material in Tank 2. Transition to hold when tank empty.



Step 20. Empty remainder of material in Tank 3. Transition to hold when tank empty.

