

Main

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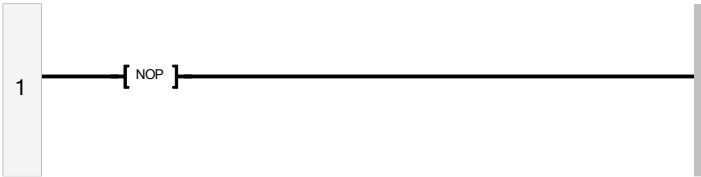
Main

Rung1 Diagram

SP6-2 Batch Process Control Copyright (c) 2023, Dogwood Valley Press, LLC

Additional internal memory:

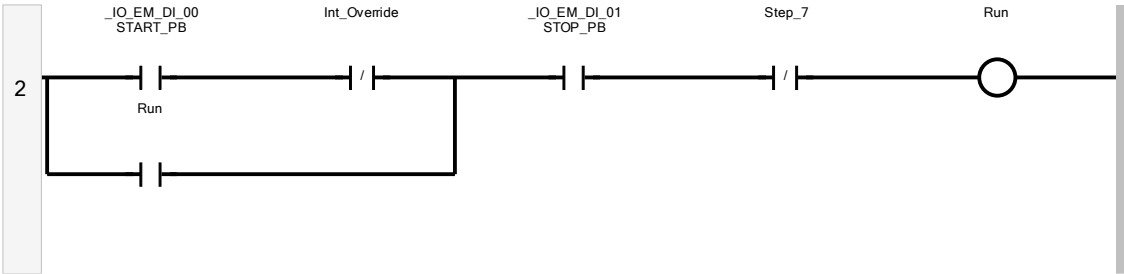
Tag	Data Type
Run	BOOL On while station running
Int_Override	BOOL Override during draining
Step_1 to Step_7	BOOL Step-in-progress bits
WaitA_Tmr	TON Delay after adding A
WaitB_Tmr	TON Delay after adding B
Stir_Tmr	TON Stir timer
Empty_Tmr	TON Times tank empty sensor in normal operation
Override_Tmr	TON Times tank empty sensor when override



Rung2 Diagram

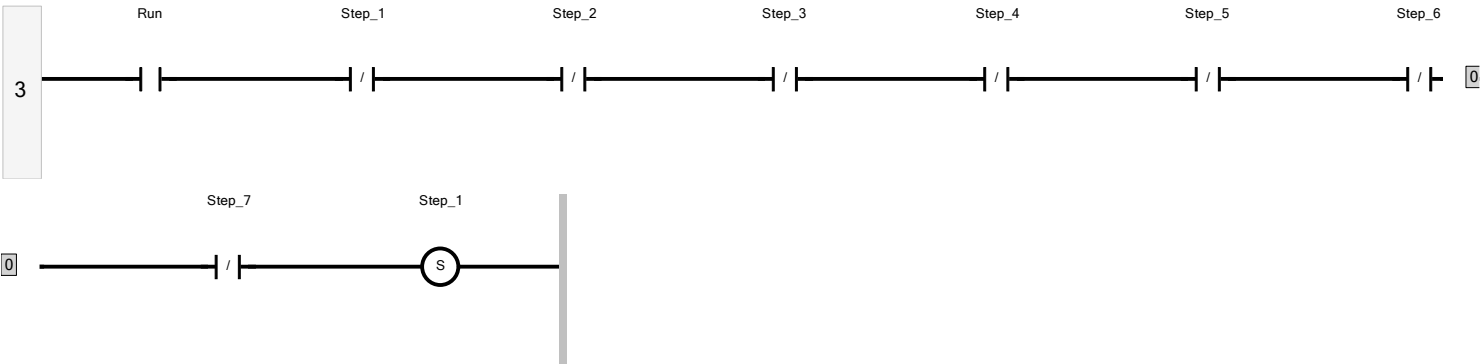
Start/stop and initial start.

During reset, prevent start.



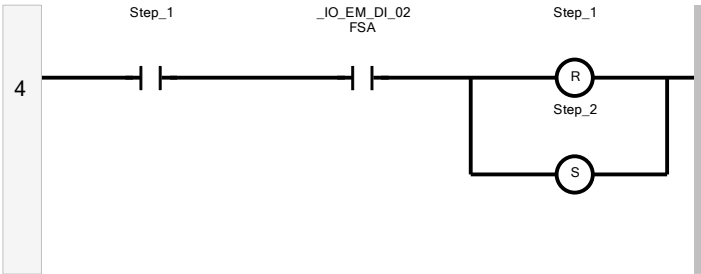
Rung3 Diagram

Initial start

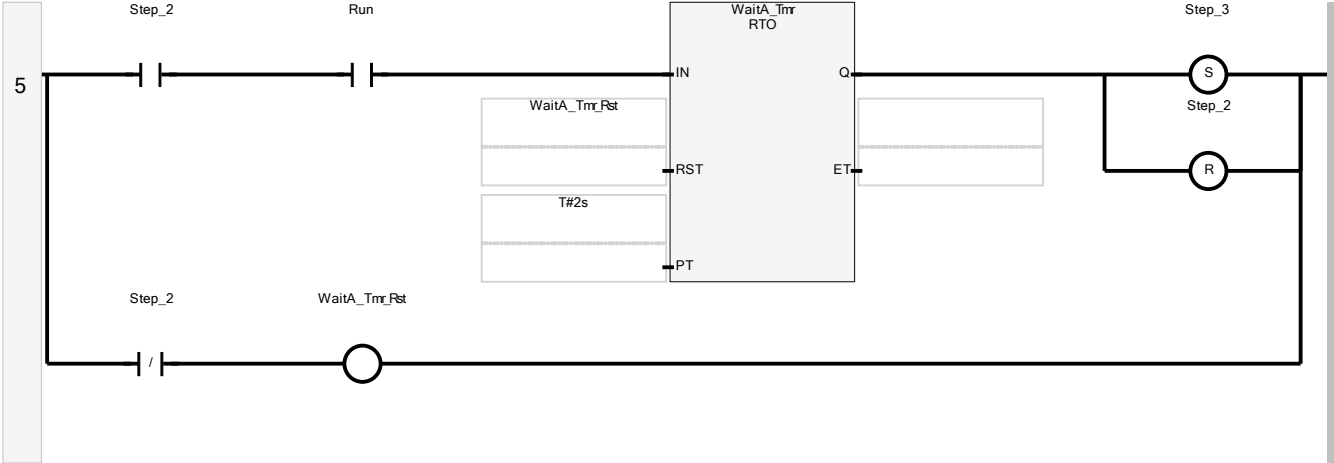


Rung4 Diagram

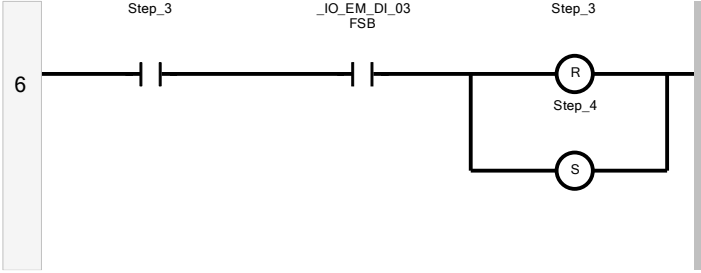
Step 1 - Fill A



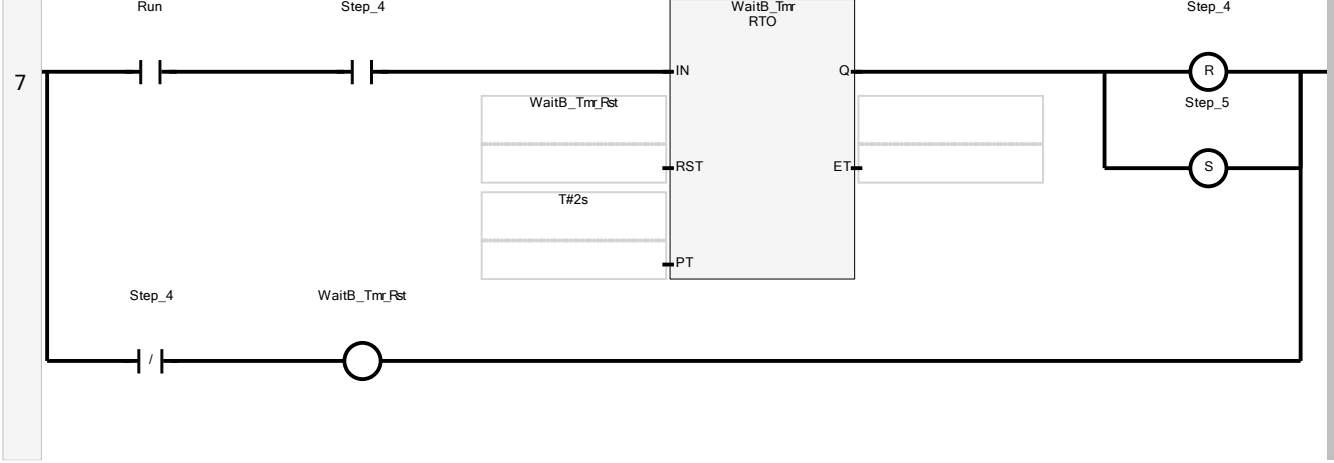
Rung5 Diagram
Step 2 - Wait after A



Rung6 Diagram
Step_3 - Fill B

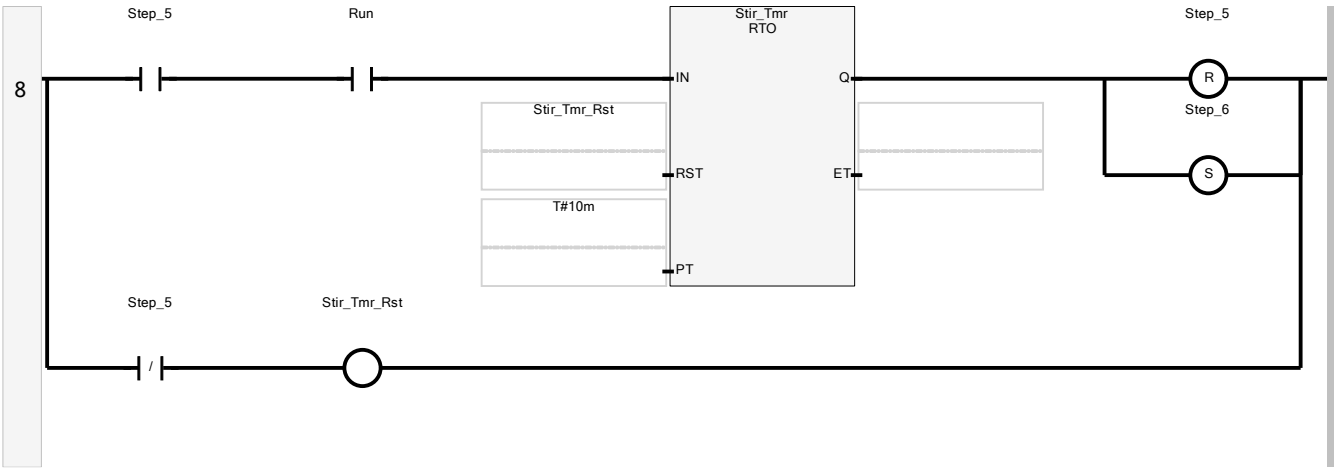


Rung7 Diagram
Step 4 - Wait after B



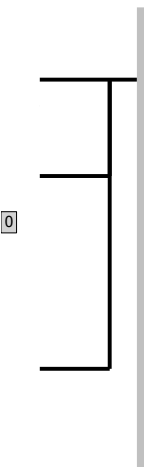
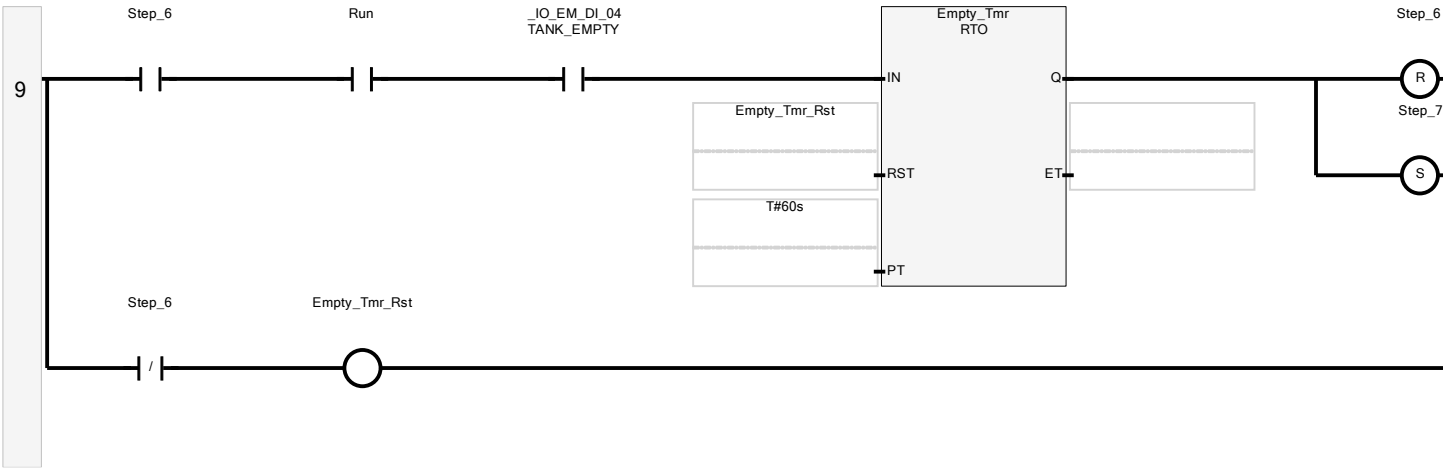
Rung8 Diagram

Step 5 - Stir 10 minutes



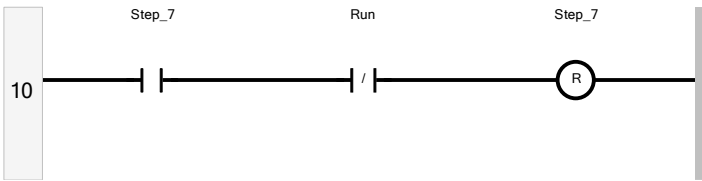
Rung9 Diagram

Step 6 - Drain

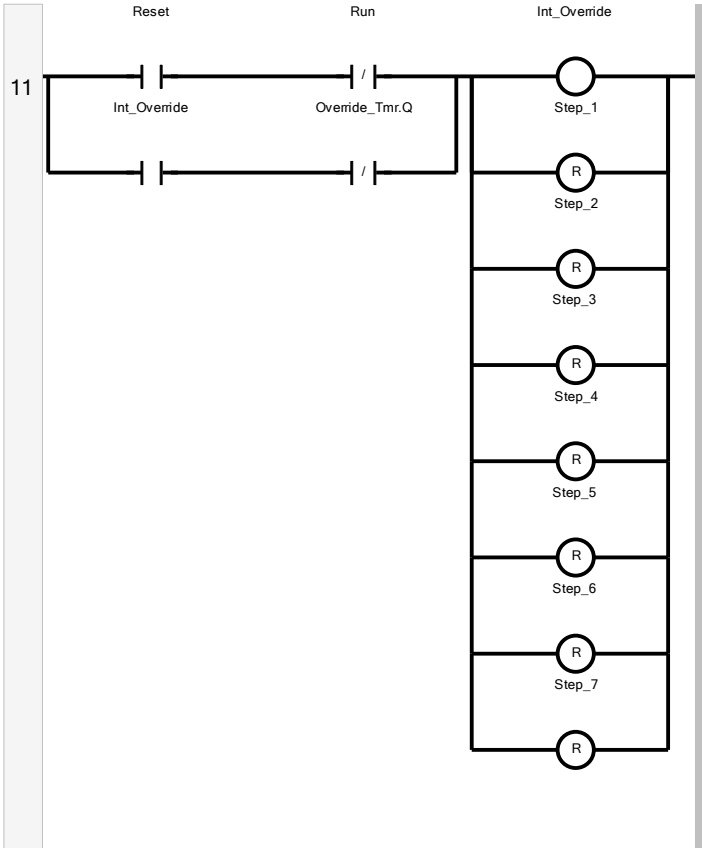


Rung10 Diagram

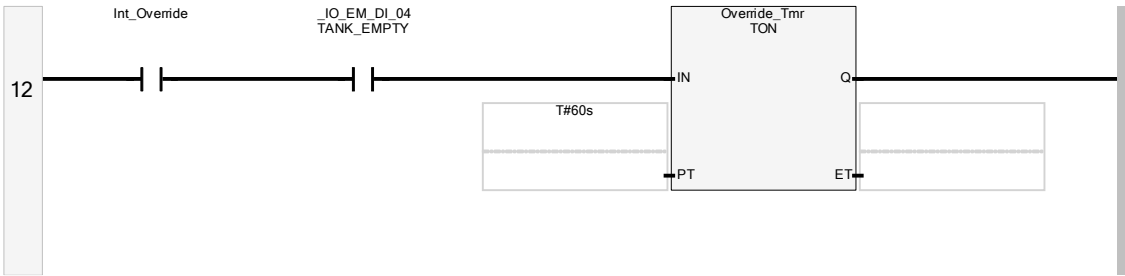
Step 7 - Unlatch run



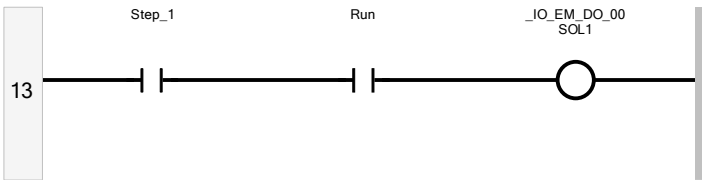
Rung11 Diagram
Reset empties tank



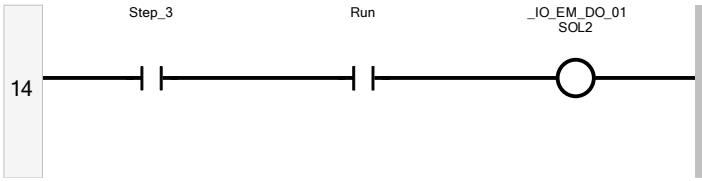
Rung12 Diagram
Timer for reset



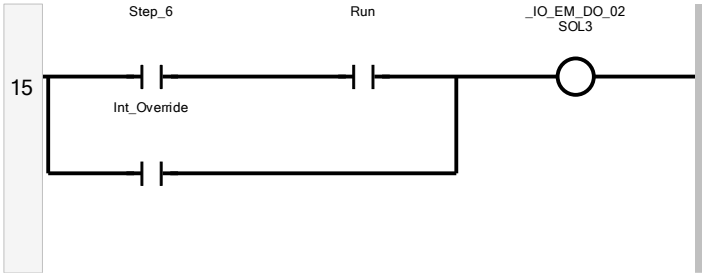
Rung13 Diagram
Physical outputs
Solenoid controls



Rung14 Diagram



Rung15 Diagram



Rung16 Diagram

Stirrer control

