

Batch Process Control

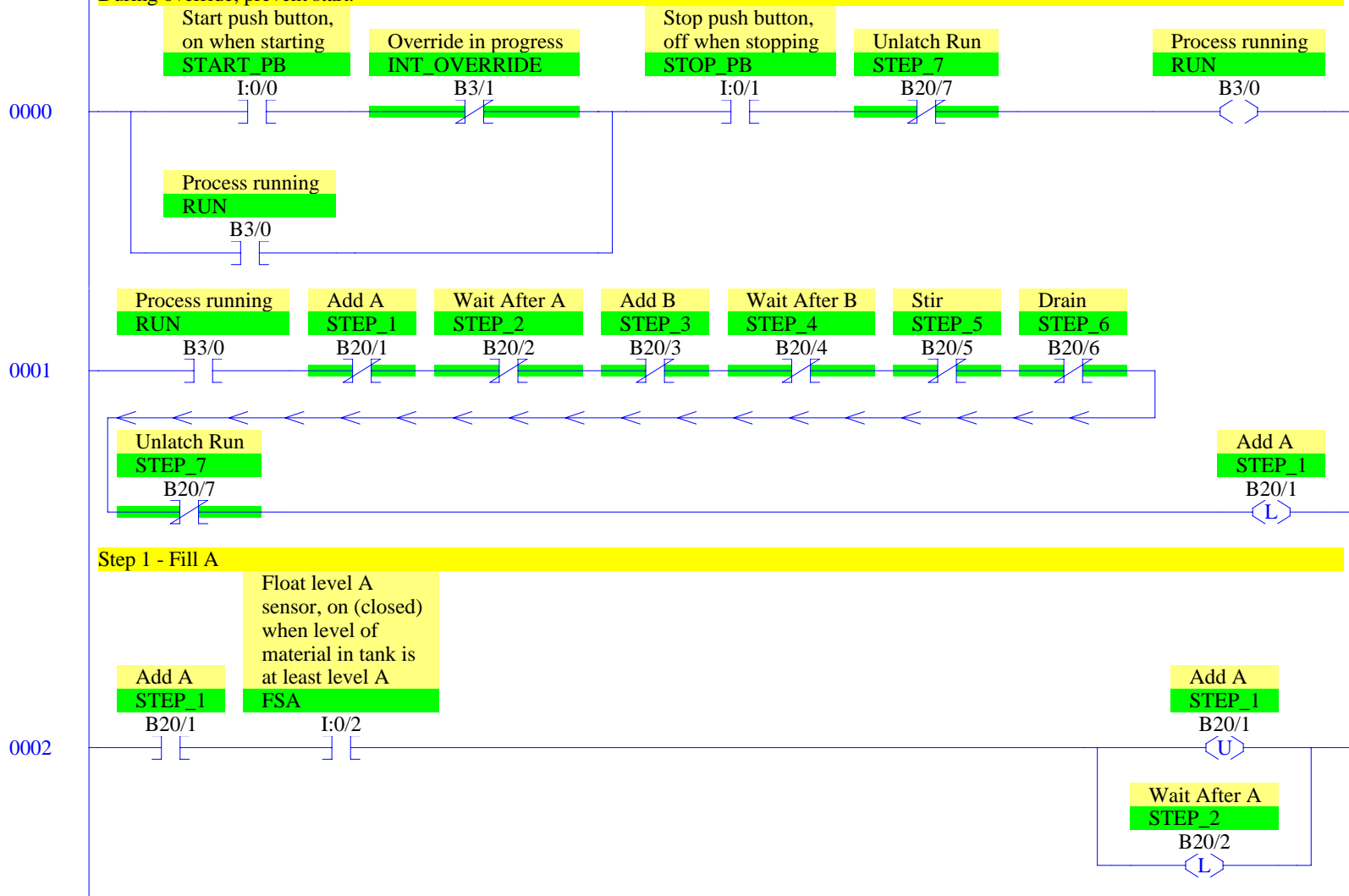
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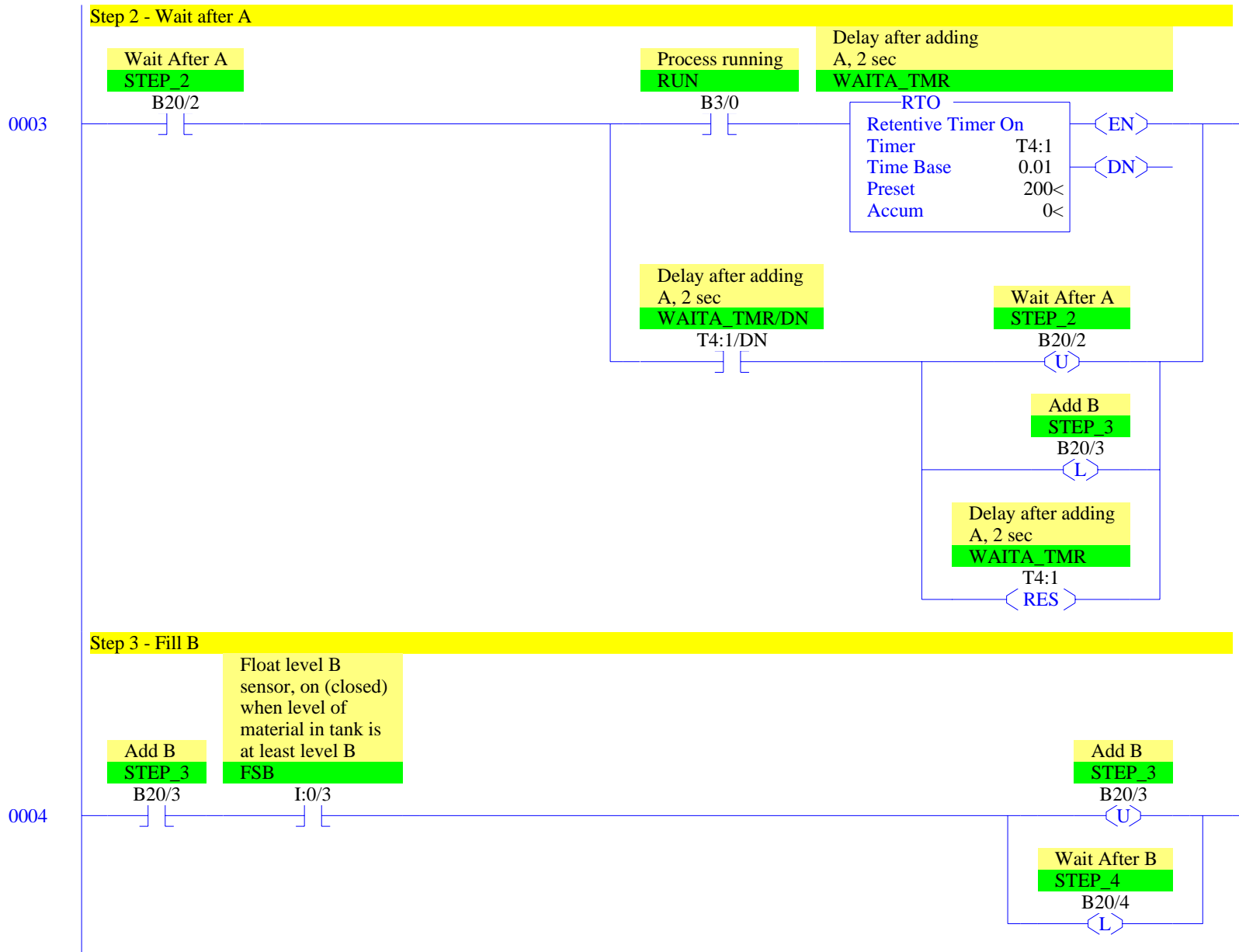
Additional internal memory:

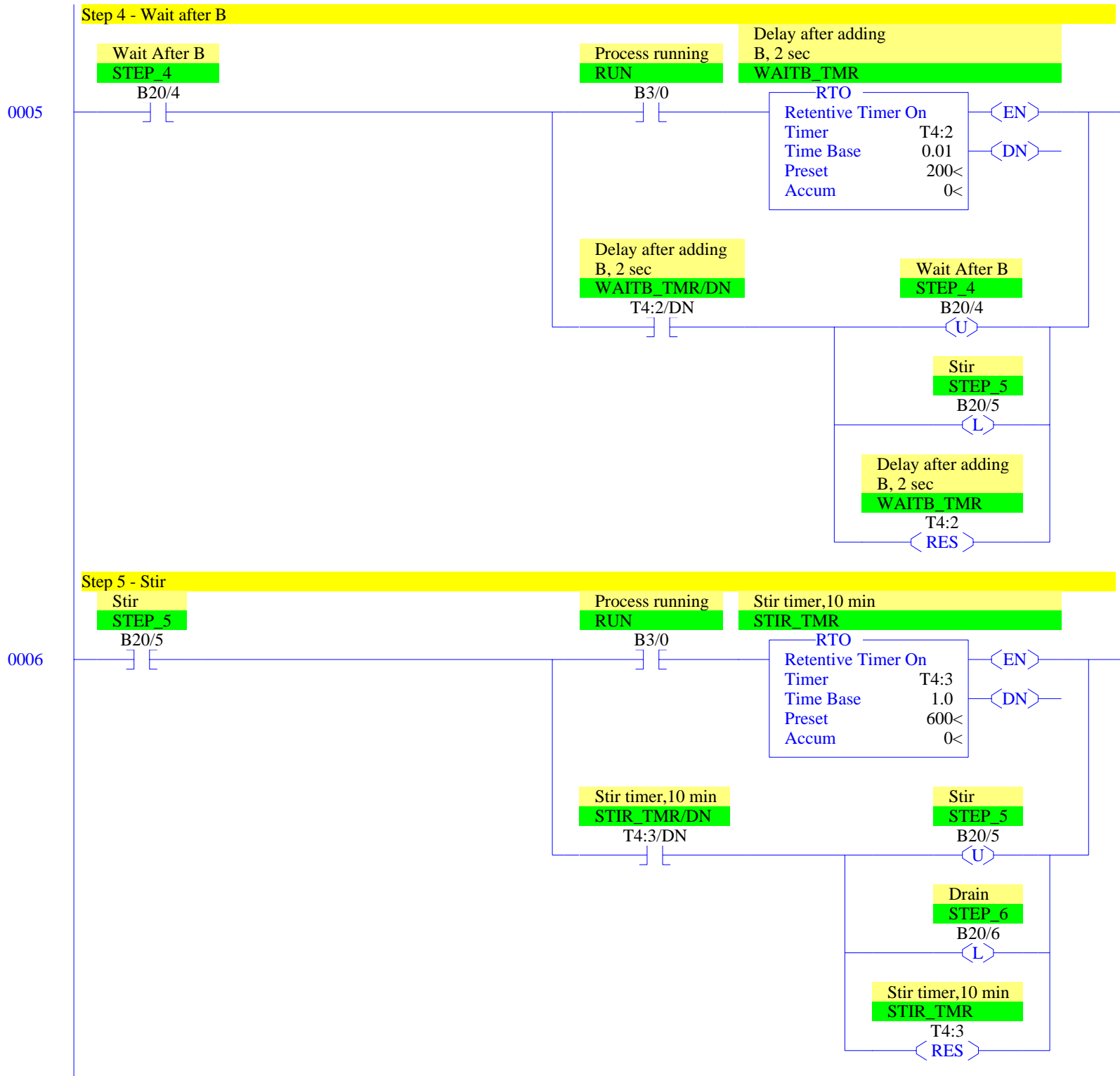
Symbol	Address	
RUN	B3/0	On while station running
INT_OVERRIDE	B3/1	Override during draining
STEP_1 to STEP_7	B20/1 to B20/7	Step-in-progress bits
WAITA_TMR	T4:1	Delay after adding A
WAITB_TMR	T4:2	Delay after adding B
STIR_TMR	T4:3	Stir timer
EMPTY_TMR	T4:4	Times tank empty sensor in normal operation
OVERRIDE_TMR	T4:5	Times tank empty sensor when override

Start/stop and initial start.

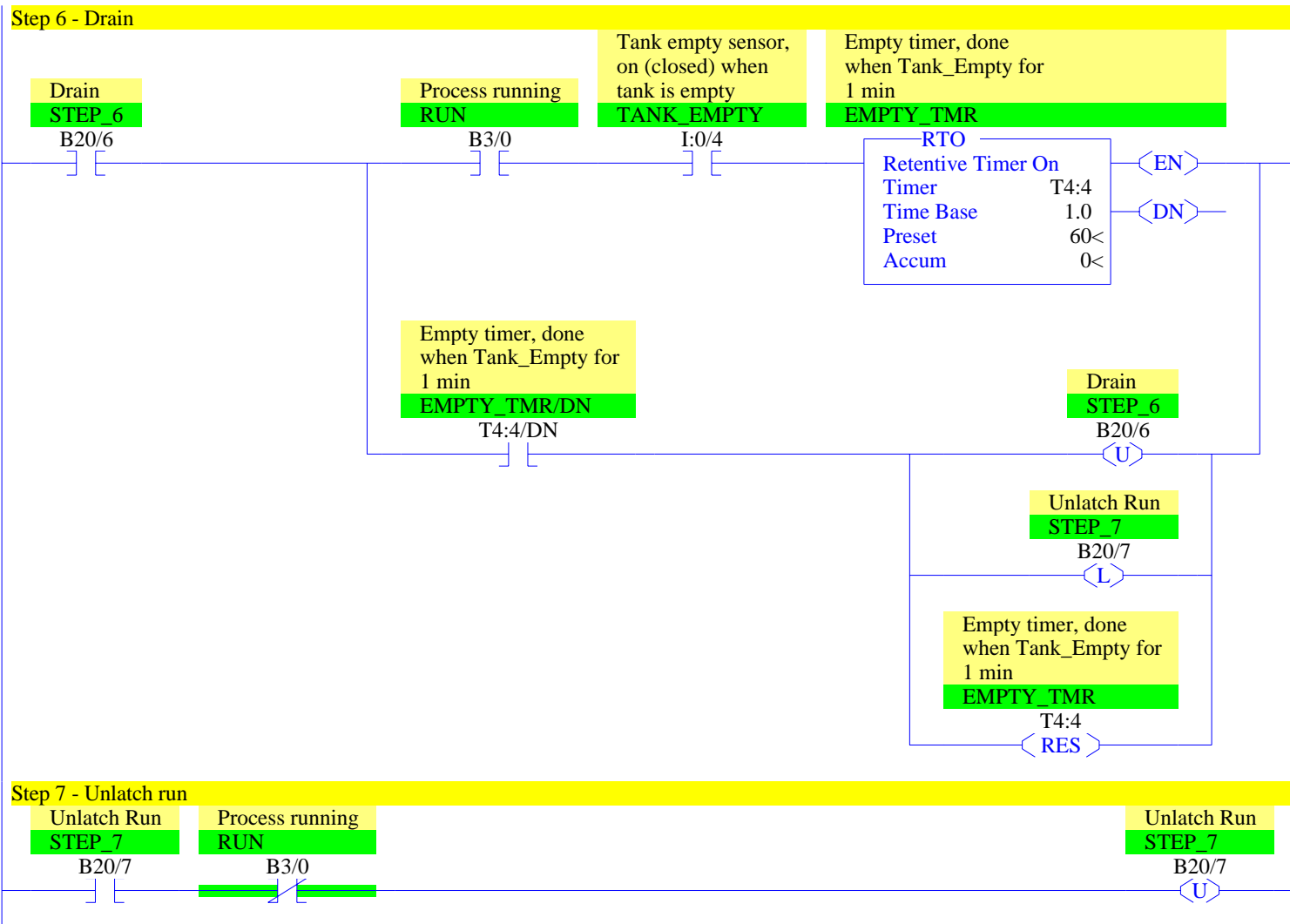
During override, prevent start.





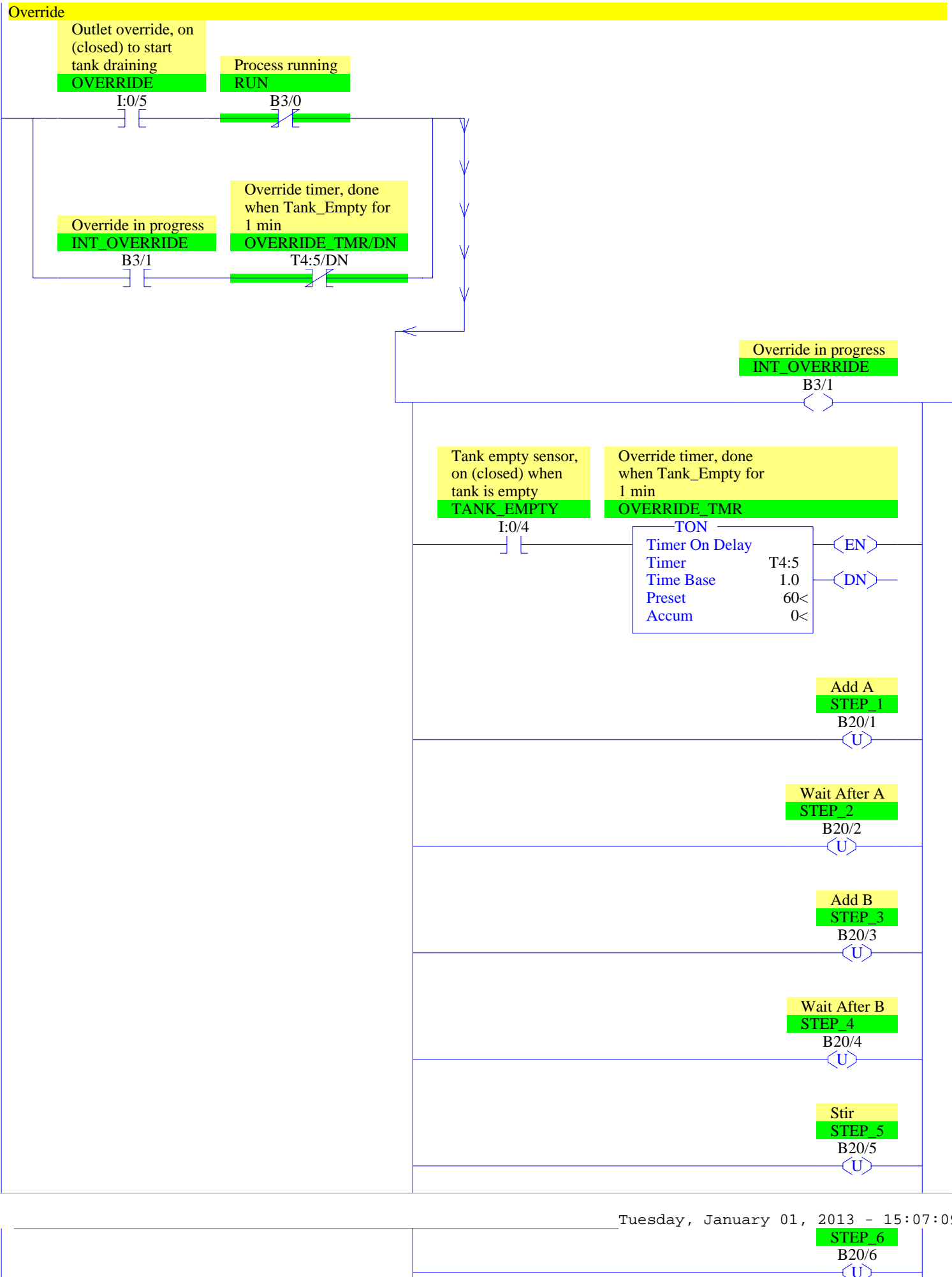


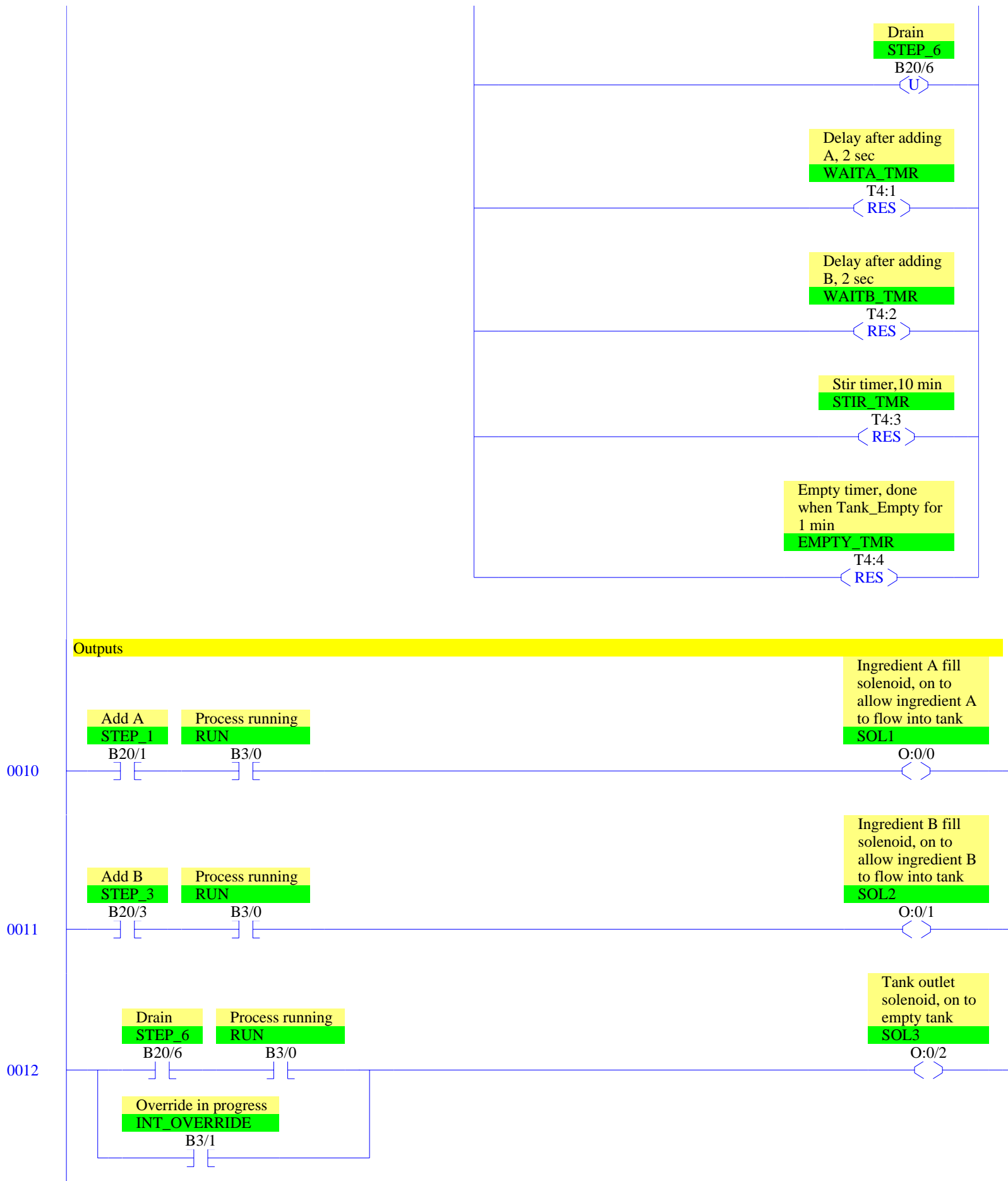
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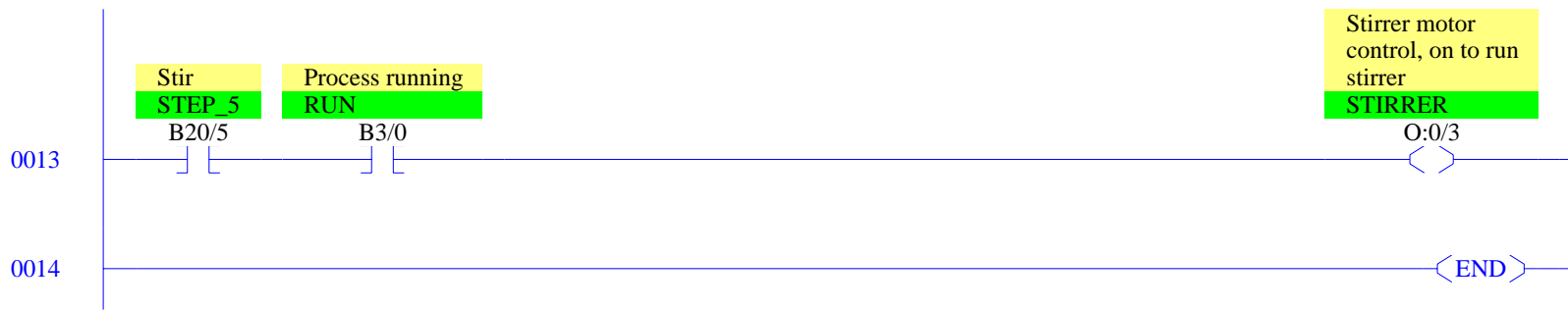


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RSLogix 500 Cross Reference Report - Sorted by Address

O:0/0	- {SOL1} Ingredient A fill solenoid, on to allow ingredient A to flow into tank OTE - File #2 - 10
O:0/1	- {SOL2} Ingredient B fill solenoid, on to allow ingredient B to flow into tank OTE - File #2 - 11
O:0/2	- {SOL3} Tank outlet solenoid, on to empty tank OTE - File #2 - 12
O:0/3	- {STIRRER} Stirrer motor control, on to run stirrer OTE - File #2 - 13
I:0/0	- {START_PB} Start push button, on when starting XIC - File #2 - 0
I:0/1	- {STOP_PB} Stop push button, off when stopping XIC - File #2 - 0
I:0/2	- {FSA} Float level A sensor, on (closed) when level of material in tank is at least 1 XIC - File #2 - 2
I:0/3	- {FSB} Float level B sensor, on (closed) when level of material in tank is at least 1 XIC - File #2 - 4
I:0/4	- {TANK_EMPTY} Tank empty sensor, on (closed) when tank is empty XIC - File #2 - 7, 9
I:0/5	- {OVERRIDE} Outlet override, on (closed) to start tank draining XIC - File #2 - 9
B3/0	- {RUN} Process running OTE - File #2 - 0 XIC - File #2 - 0, 1, 3, 5, 6, 7, 10, 11, 12, 13 XIO - File #2 - 8, 9
B3/1	- {INT_OVERRIDE} Override in progress OTE - File #2 - 9 XIC - File #2 - 9, 12 XIO - File #2 - 0
T4:1	- {WAITA_TMR} Delay after adding A, 2 sec RTO - File #2 - 3 RES - File #2 - 3, 9
T4:1/DN	- XIC - File #2 - 3
T4:2	- {WAITB_TMR} Delay after adding B, 2 sec RTO - File #2 - 5 RES - File #2 - 5, 9
T4:2/DN	- XIC - File #2 - 5
T4:3	- {STIR_TMR} Stir timer, 10 min RTO - File #2 - 6 RES - File #2 - 6, 9
T4:3/DN	- XIC - File #2 - 6
T4:4	- {EMPTY_TMR} Empty timer, done when Tank_Empty for 1 min RTO - File #2 - 7 RES - File #2 - 7, 9
T4:4/DN	- XIC - File #2 - 7
T4:5	- {OVERRIDE_TMR} Override timer, done when Tank_Empty for 1 min TON - File #2 - 9
T4:5/DN	- XIO - File #2 - 9
B20/1	- {STEP_1} Add A OTL - File #2 - 1 OTU - File #2 - 2, 9 XIC - File #2 - 2, 10 XIO - File #2 - 1
B20/2	- {STEP_2} Wait After A OTL - File #2 - 2 OTU - File #2 - 3, 9 XIC - File #2 - 3 XIO - File #2 - 1
B20/3	- {STEP_3} Add B OTL - File #2 - 3 OTU - File #2 - 4, 9 XIC - File #2 - 4, 11 XIO - File #2 - 1
B20/4	- {STEP_4} Wait After B OTL - File #2 - 4 OTU - File #2 - 5, 9 XIC - File #2 - 5

RSLogix 500 Cross Reference Report - Sorted by Address

B20/5	XIO - File #2 - 1
	- {STEP_5} Stir
	OTL - File #2 - 5
	OTU - File #2 - 6, 9
	XIC - File #2 - 6, 13
	XIO - File #2 - 1
B20/6	- {STEP_6} Drain
	OTL - File #2 - 6
	OTU - File #2 - 7, 9
	XIC - File #2 - 7, 12
	XIO - File #2 - 1
B20/7	- {STEP_7} Unlatch Run
	OTL - File #2 - 7
	OTU - File #2 - 8
	XIC - File #2 - 8
	XIO - File #2 - 0, 1