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\*\*\*\*\* Batch Reactor Control \*\*\*\*\*

Additional internal memory:

Tag	Data Type	
Run	BOOL	On while station running
Step_1 to Step_6	BOOL	Step-in-progress bits
Fast_Agit_Tmr	TIMER	Times fast agitation step
Decr_Agit_Tmr	TIMER	Times decreasing agitation step
Count_A	COUNTER	Measures amount of A being added
Count_B	COUNTER	Measures amount of B being added
Count_Out	COUNTER	Measures amount of product being drained

Conversion formulas

$AGIT\_CURR = (ACUR\_MEAS/100) * (20-0) + 0$

$AGIT\_AO = (AGIT\_RPM/1000) * (100)$

In Step\_5,  $AGIT\_RPM = 500 - Decr\_Agit\_Tmr.ACC/10000$

Start/Stop. Initial start

Start push button,  
on when starting

START\_PB  
<Local:1:I.Data.0>

Stop push button,  
off when stopping.

STOP\_PB  
<Local:1:I.Data.1>

Process running  
Run

Process running  
Run

Process Run

Step\_1

Step\_2

Step\_3

Step\_4

Step\_5

Step\_6

Step\_1

Step 1. Wait for Ready. Transition when Ready.

Ready signal, on  
when permissives are  
satisfied and batch  
cycle may begin

READY

Process running

Run

Step\_1

Step\_2

Step 2. Fill A. Transition when desired amount.

Accumulator  
indicates number of  
gallons of A added  
to mixing vessel

Step\_2

GE	Grtr Than or Eql (A>=B)
Source A	Count_A.ACC
	0
Source B	DES_A
	0.0

Process running

Run

Step\_2

Step\_3

Step 3. Fill B. Transition when desired amount.

Accumulator  
indicates number of  
gallons of B added  
to mixing vessel

Step\_3

GE	Grtr Than or Eql (A>=B)
Source A	Count_B.ACC
	0
Source B	DES_B
	0.0

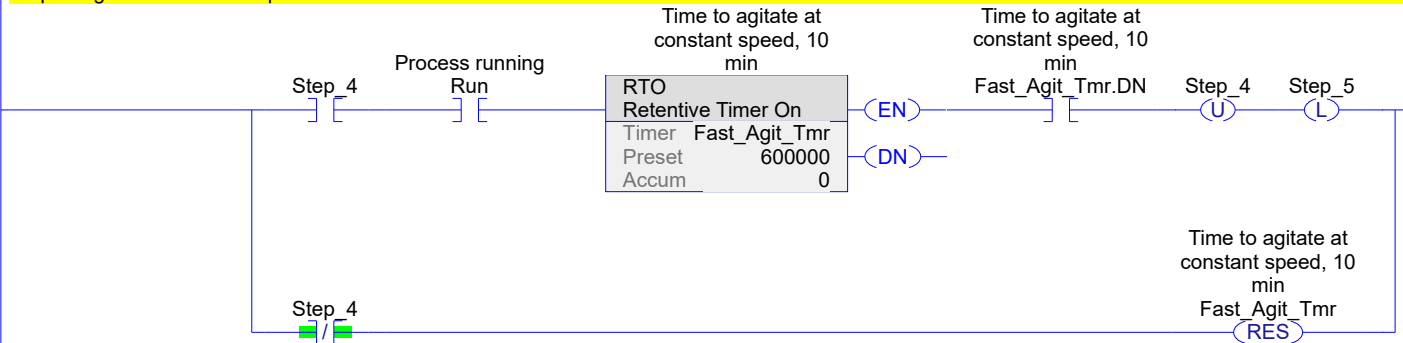
Process running

Run

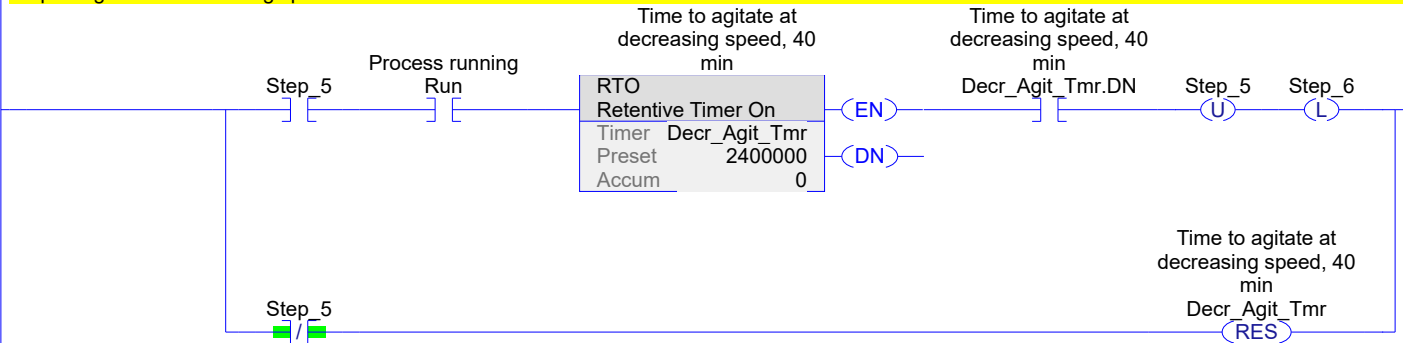
Step\_3

Step\_4

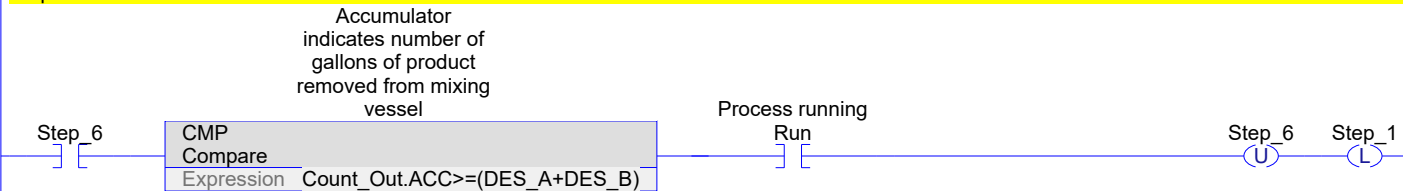
Step 4. Agitate at constant speed. Transition when at 10 min.



Step 5. Agitate at decreasing speed. Transition when at 40 min.



Step 6. Drain tank. Transition when material moved out.



\*\*\*\*\* Outputs \*\*\*\*\*

Valve Controls.

