

Batch Control

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Additional internal memory:

Symbol	Address	On while station running
RUN	B3/0	On while station running
INT_RESET	B3/1	Internal reset
STEP_1 to STEP_15	B20/1 to B20/15	Step-in-progress bits
STIR_TMR	T4:1	Times stirring step

Start/stop and initial start.

During reset prevent start. Step 15 also unlatches Run

0000

Start push button, on
when starting

START_PB

I:1/0

INT_RESET

B3/1

Stop push button, off
when stopping

STOP_PB

I:1/1

Unlatch run

STEP_15

B20/15

RUN

B3/0

RUN

B3/0

0001

RUN

B3/0

Fill Tank 1

STEP_1

B20/1

Wait for tank 2
filled

STEP_2

B20/2

Fill Tank 2

STEP_3

B20/3

Wait for tank 1
filled

STEP_4

B20/4

Heat tank 2

STEP_5

B20/5

Empty tank 1

STEP_6

B20/6

Wait for tank 2
emptied

STEP_7

B20/7

Empty tank 2

STEP_8

B20/8

Wait for tank 1
emptied

STEP_9

B20/9

Wait for liquid in
tank 2

STEP_10

B20/10

Wait for tanks 1 and
2 emptied

STEP_11

B20/11

Stir 90 secs

STEP_12

B20/12

Transfer to tank 4

STEP_13

B20/13

Empty tank 4

STEP_14

B20/14

Unlatch run

STEP_15

B20/15

Fill Tank 1

STEP_1

B20/1

Fill Tank 2

STEP_3

B20/3

Step 1 Fill Tank 1

Fill Tank 1

STEP_1

B20/1

Tank 1 full sensor,
on when full

TIF

I:1/4

Fill Tank 1

STEP_1

B20/1

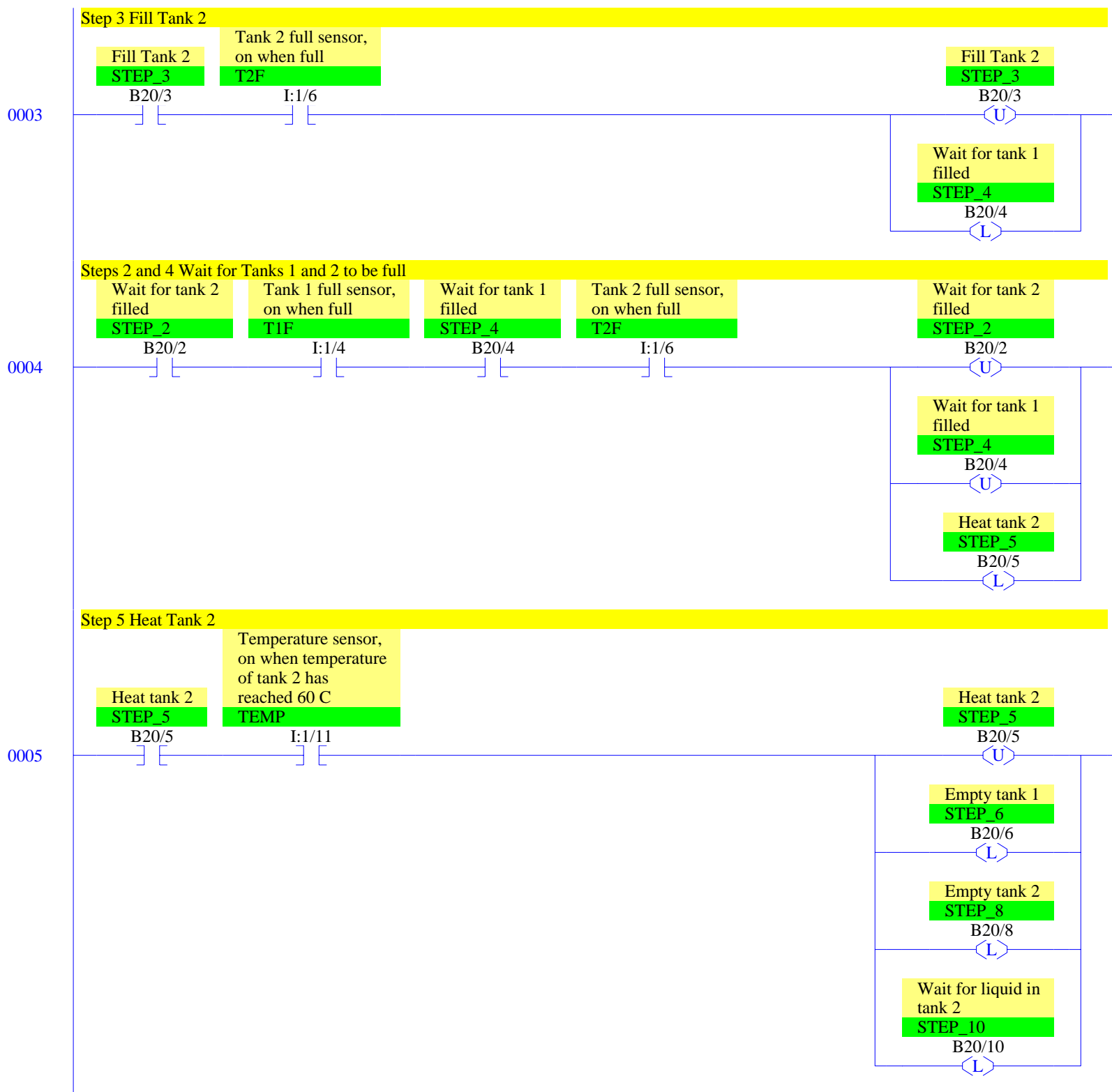
B20/1

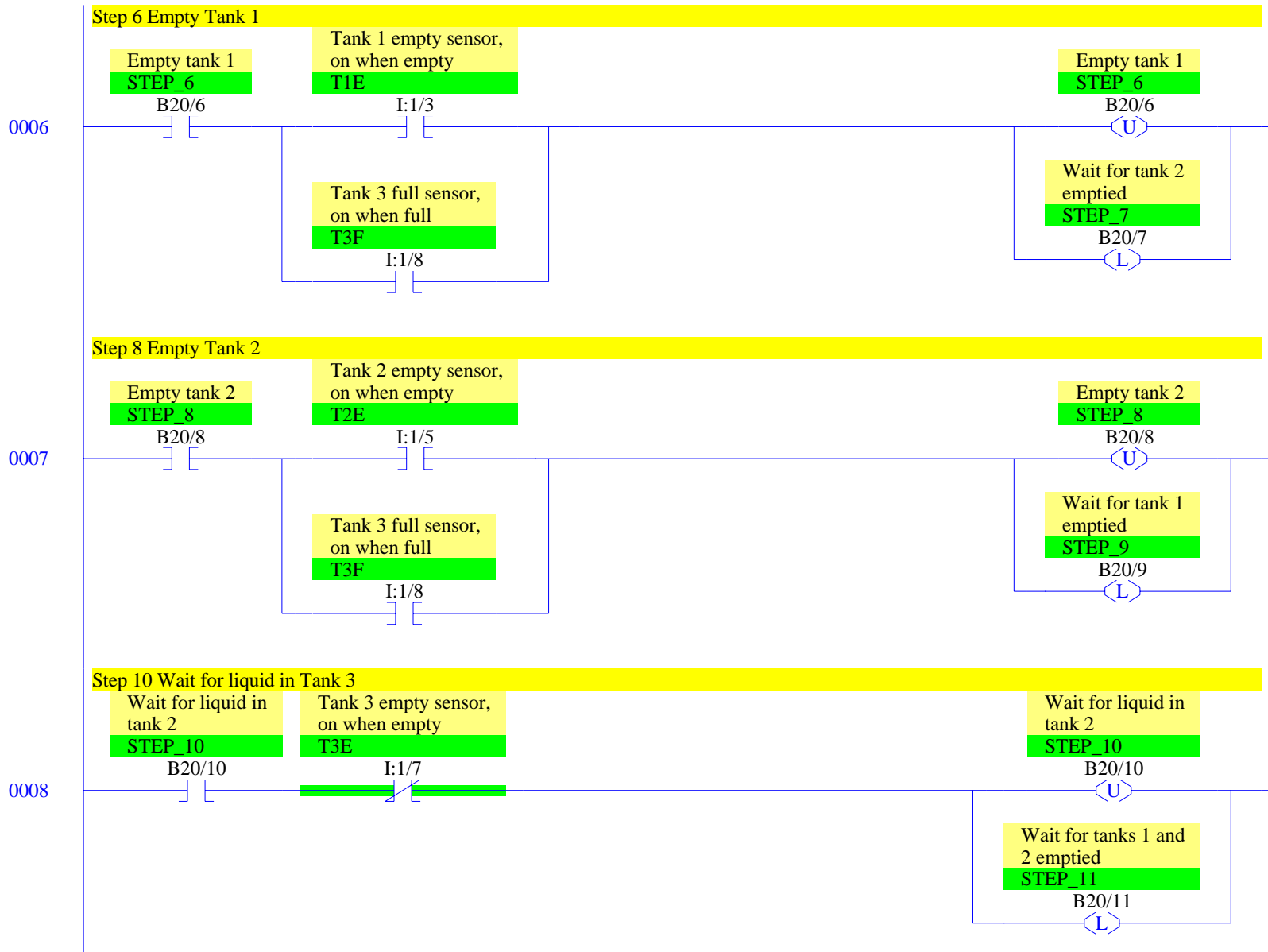
Wait for tank 2
filled

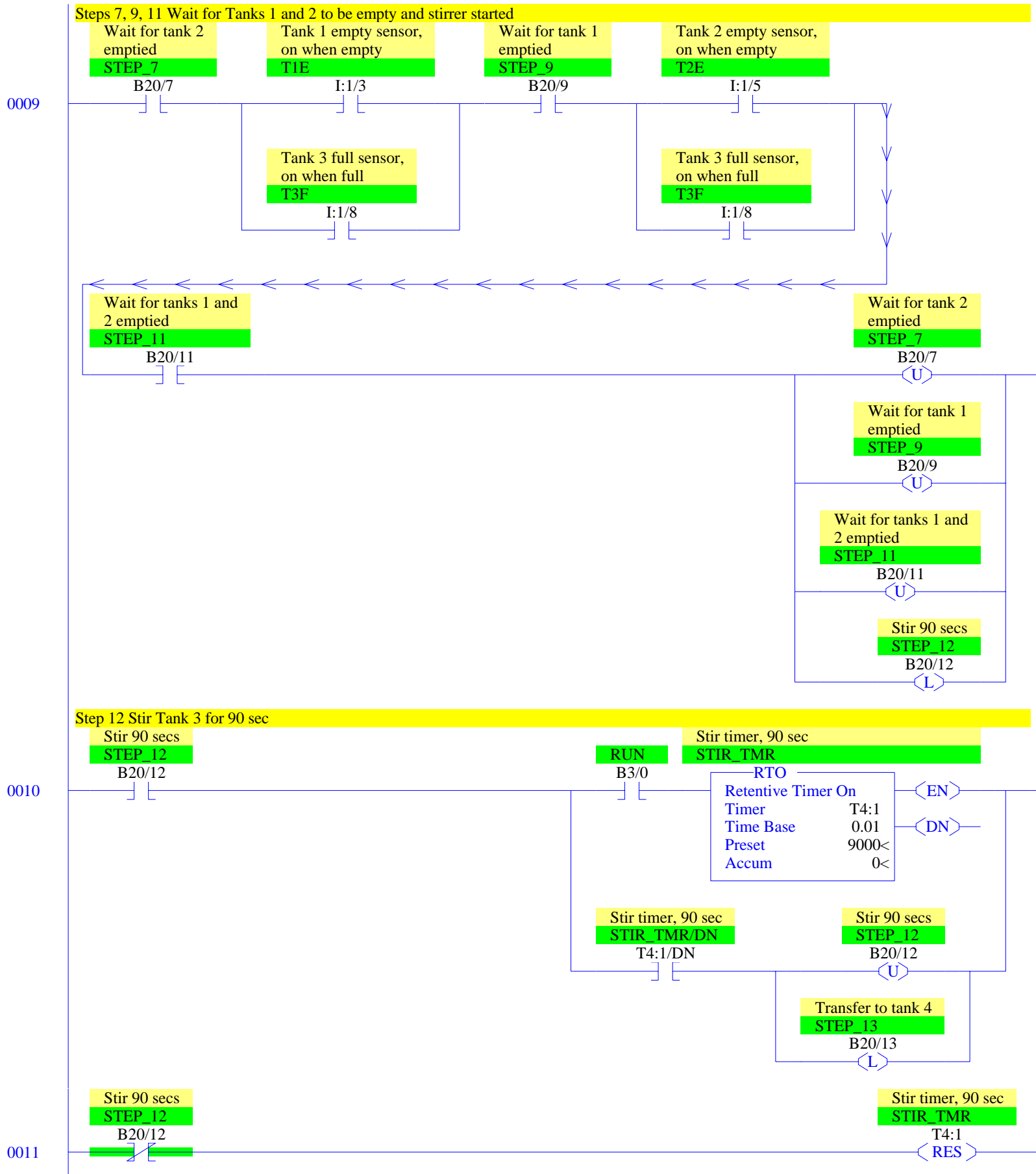
STEP_2

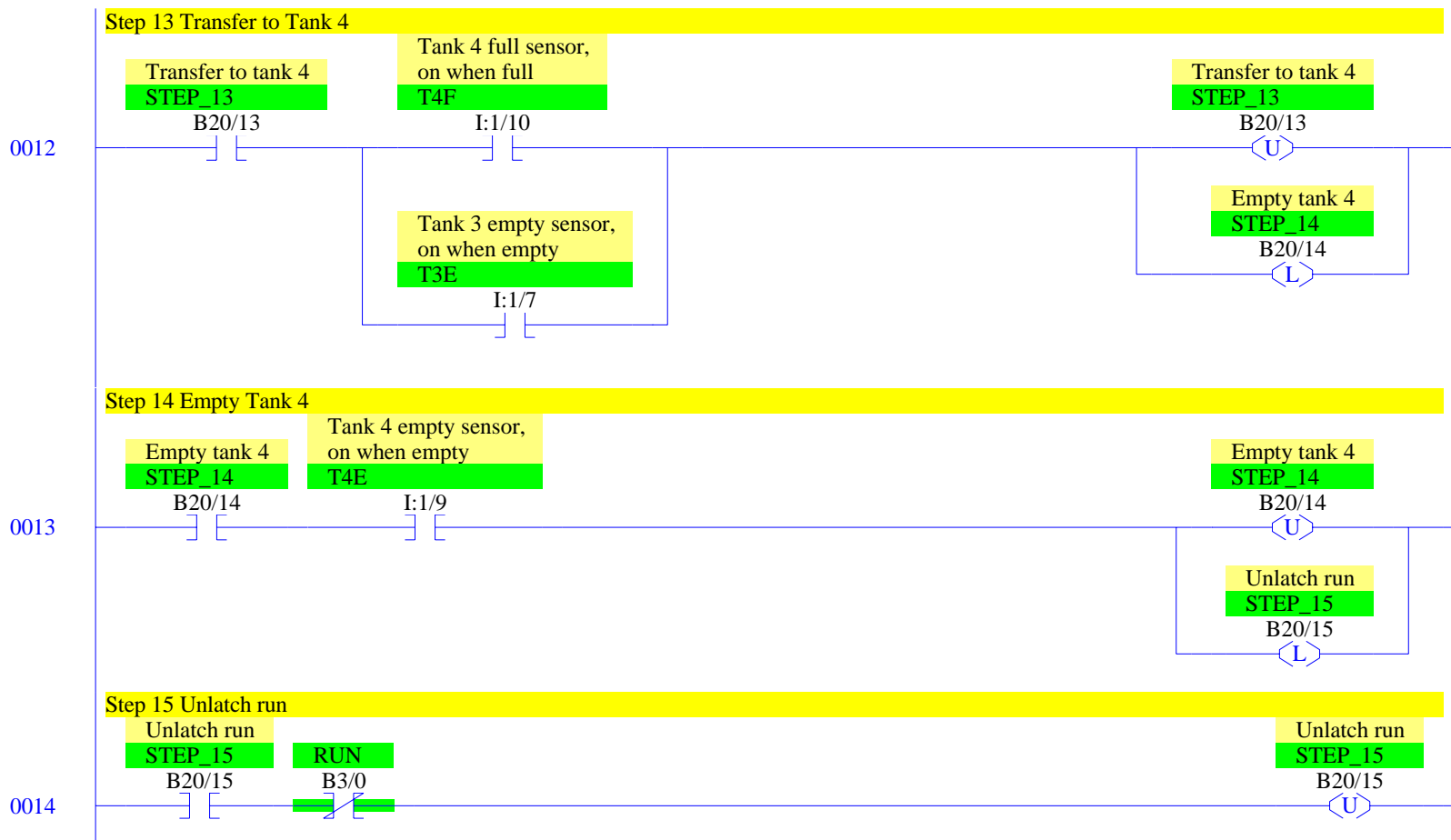
B20/2

0002

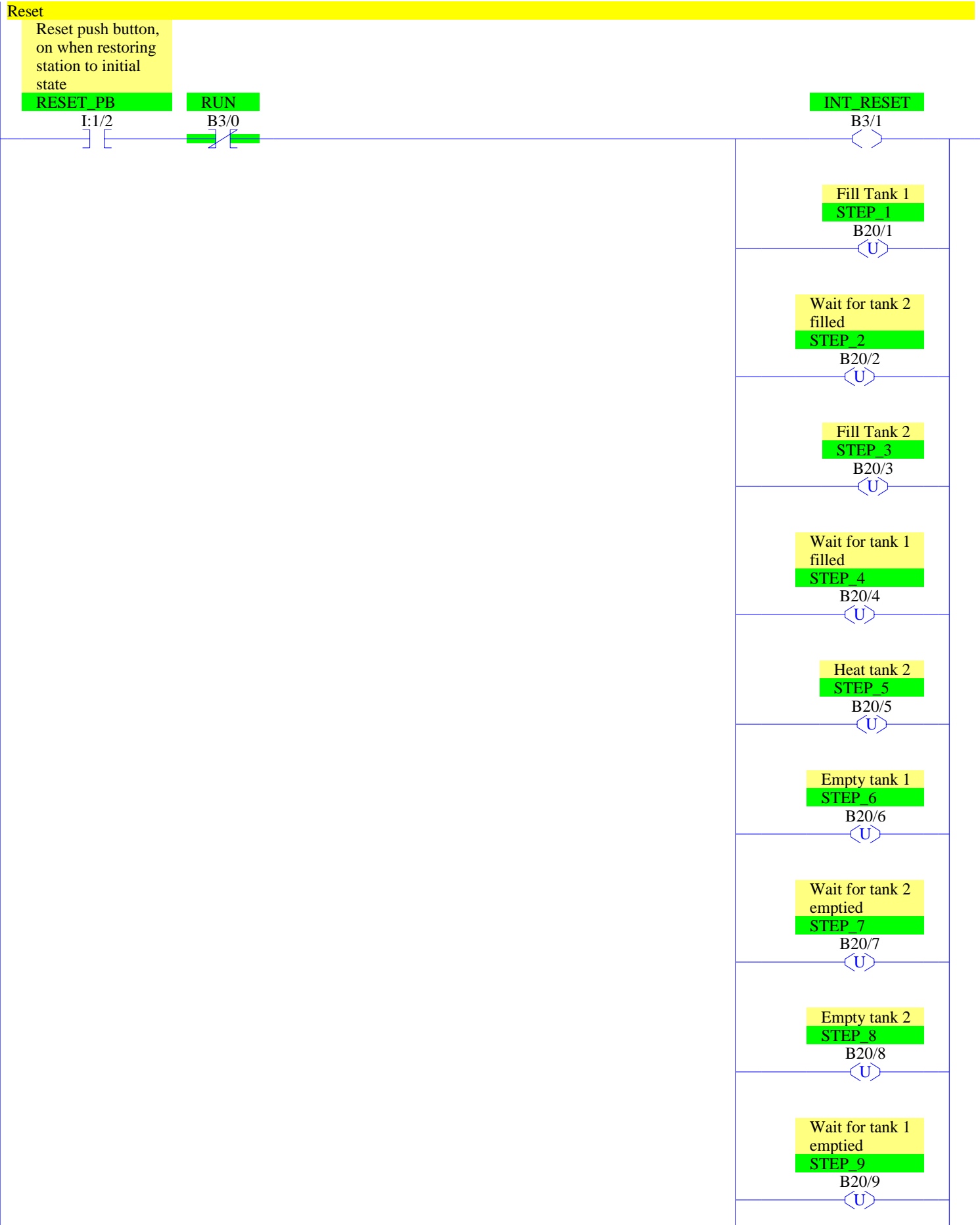


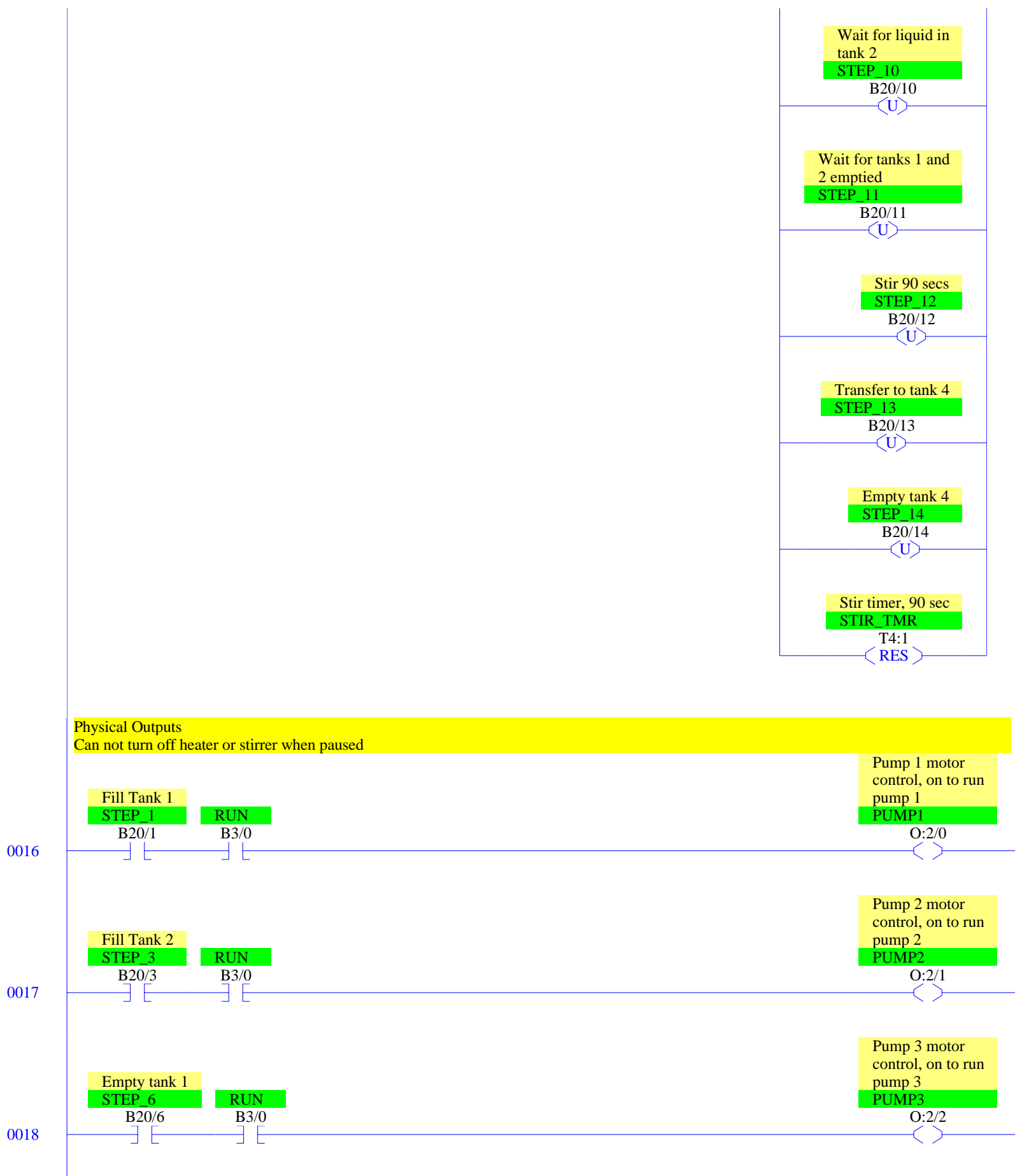


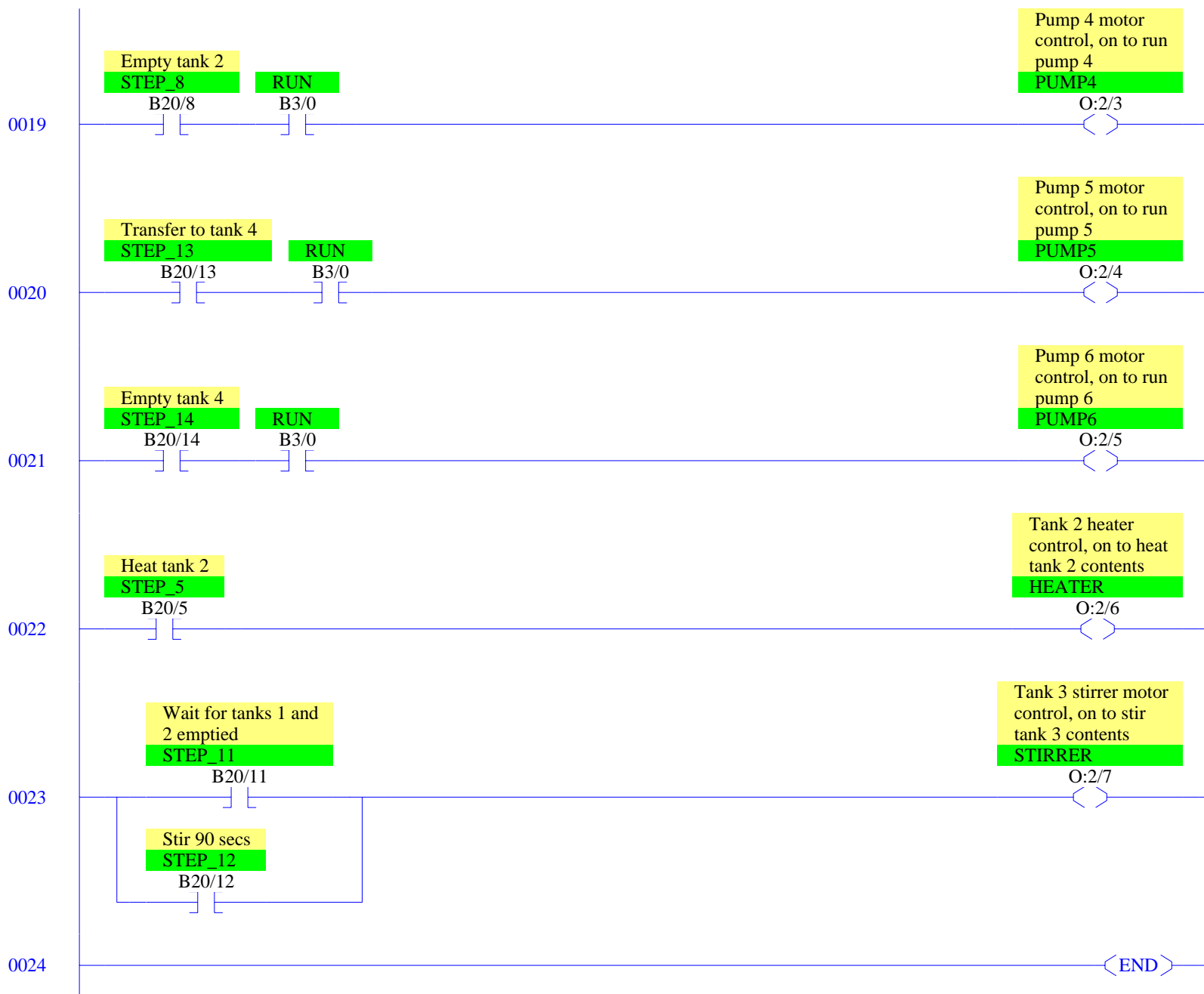




0015







RSLogix 500 Cross Reference Report - Sorted by Address

O:2/0	- {PUMP1} Pump 1 motor control, on to run pump 1 OTE - File #2 - 16
O:2/1	- {PUMP2} Pump 2 motor control, on to run pump 2 OTE - File #2 - 17
O:2/2	- {PUMP3} Pump 3 motor control, on to run pump 3 OTE - File #2 - 18
O:2/3	- {PUMP4} Pump 4 motor control, on to run pump 4 OTE - File #2 - 19
O:2/4	- {PUMP5} Pump 5 motor control, on to run pump 5 OTE - File #2 - 20
O:2/5	- {PUMP6} Pump 6 motor control, on to run pump 6 OTE - File #2 - 21
O:2/6	- {HEATER} Tank 2 heater control, on to heat tank 2 contents OTE - File #2 - 22
O:2/7	- {STIRRER} Tank 3 stirrer motor control, on to stir tank 3 contents OTE - File #2 - 23
I:1/0	- {START_PB} Start push button, on when starting XIC - File #2 - 0
I:1/1	- {STOP_PB} Stop push button, off when stopping XIC - File #2 - 0
I:1/2	- {RESET_PB} Reset push button, on when restoring station to initial state XIC - File #2 - 15
I:1/3	- {T1E} Tank 1 empty sensor, on when empty XIC - File #2 - 6, 9
I:1/4	- {T1F} Tank 1 full sensor, on when full XIC - File #2 - 2, 4
I:1/5	- {T2E} Tank 2 empty sensor, on when empty XIC - File #2 - 7, 9
I:1/6	- {T2F} Tank 2 full sensor, on when full XIC - File #2 - 3, 4
I:1/7	- {T3E} Tank 3 empty sensor, on when empty XIC - File #2 - 12 XIO - File #2 - 8
I:1/8	- {T3F} Tank 3 full sensor, on when full XIC - File #2 - 6, 7, 9
I:1/9	- {T4E} Tank 4 empty sensor, on when empty XIC - File #2 - 13
I:1/10	- {T4F} Tank 4 full sensor, on when full XIC - File #2 - 12
I:1/11	- {TEMP} Temperature sensor, on when temperature of tank 2 has reached 60 C XIC - File #2 - 5
B3/0	- {RUN} OTE - File #2 - 0 XIC - File #2 - 0, 1, 10, 16, 17, 18, 19, 20, 21 XIO - File #2 - 14, 15
B3/1	- {INT_RESET} OTE - File #2 - 15 XIO - File #2 - 0
T4:1	- {STIR_TMR} Stir timer, 90 sec RTO - File #2 - 10 RES - File #2 - 11, 15
T4:1/DN	- XIC - File #2 - 10
B20/1	- {STEP_1} Fill Tank 1 OTL - File #2 - 1 OTU - File #2 - 2, 15 XIC - File #2 - 2, 16 XIO - File #2 - 1
B20/2	- {STEP_2} Wait for tank 2 filled OTL - File #2 - 2 OTU - File #2 - 4, 15 XIC - File #2 - 4 XIO - File #2 - 1
B20/3	- {STEP_3} Fill Tank 2 OTL - File #2 - 1 OTU - File #2 - 3, 15 XIC - File #2 - 3, 17

RSLogix 500 Cross Reference Report - Sorted by Address

B20/4	XIO - File #2 - 1 - {STEP_4} Wait for tank 1 filled OTL - File #2 - 3 OTU - File #2 - 4, 15 XIC - File #2 - 4 XIO - File #2 - 1
B20/5	- {STEP_5} Heat tank 2 OTL - File #2 - 4 OTU - File #2 - 5, 15 XIC - File #2 - 5, 22 XIO - File #2 - 1
B20/6	- {STEP_6} Empty tank 1 OTL - File #2 - 5 OTU - File #2 - 6, 15 XIC - File #2 - 6, 18 XIO - File #2 - 1
B20/7	- {STEP_7} Wait for tank 2 emptied OTL - File #2 - 6 OTU - File #2 - 9, 15 XIC - File #2 - 9 XIO - File #2 - 1
B20/8	- {STEP_8} Empty tank 2 OTL - File #2 - 5 OTU - File #2 - 7, 15 XIC - File #2 - 7, 19 XIO - File #2 - 1
B20/9	- {STEP_9} Wait for tank 1 emptied OTL - File #2 - 7 OTU - File #2 - 9, 15 XIC - File #2 - 9 XIO - File #2 - 1
B20/10	- {STEP_10} Wait for liquid in tank 2 OTL - File #2 - 5 OTU - File #2 - 8, 15 XIC - File #2 - 8 XIO - File #2 - 1
B20/11	- {STEP_11} Wait for tanks 1 and 2 emptied OTL - File #2 - 8 OTU - File #2 - 9, 15 XIC - File #2 - 9, 23 XIO - File #2 - 1
B20/12	- {STEP_12} Stir 90 secs OTL - File #2 - 9 OTU - File #2 - 10, 15 XIC - File #2 - 10, 23 XIO - File #2 - 1, 11
B20/13	- {STEP_13} Transfer to tank 4 OTL - File #2 - 10 OTU - File #2 - 12, 15 XIC - File #2 - 12, 20 XIO - File #2 - 1
B20/14	- {STEP_14} Empty tank 4 OTL - File #2 - 12 OTU - File #2 - 13, 15 XIC - File #2 - 13, 21 XIO - File #2 - 1
B20/15	- {STEP_15} Unlatch run OTL - File #2 - 13 OTU - File #2 - 14 XIC - File #2 - 14 XIO - File #2 - 0, 1