

FC20 - <offline>

"Xfer Sequences"	Xfer Unit Sequences
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Name: _____ Family: _____

Author: Version: 0.1

Block version: 2

Time stamp Code: 06/26/2011 08:39:45 PM

Interface: 05/20/2005 09:54:20 AM

Lengths (block/logic/data): 02776 02540 00006

Name	Data Type	Address	Comment
IN		0.0	
OUT		0.0	
IN_OUT		0.0	
TEMP		0.0	
RETURN		0.0	
RET_VAL		0.0	

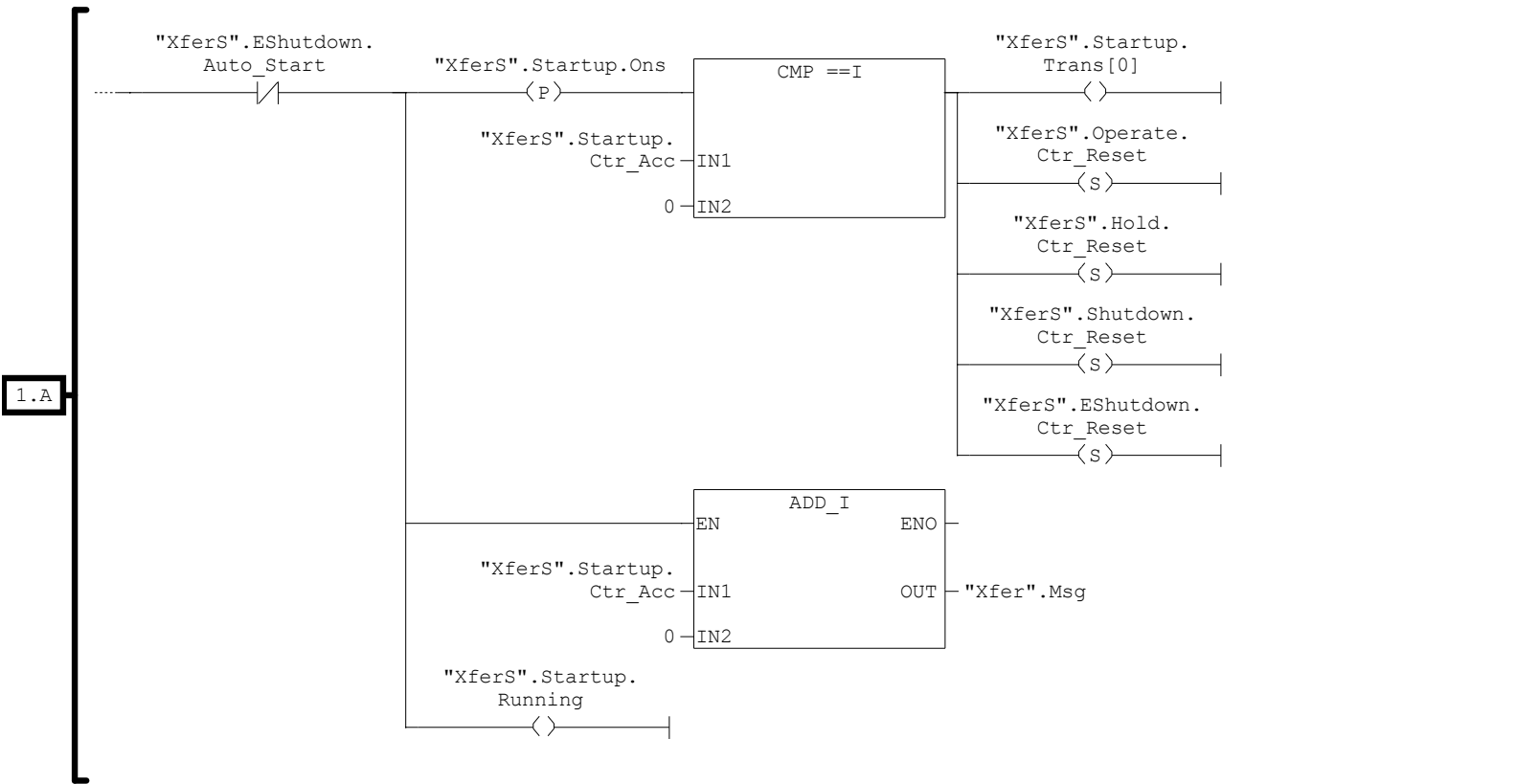
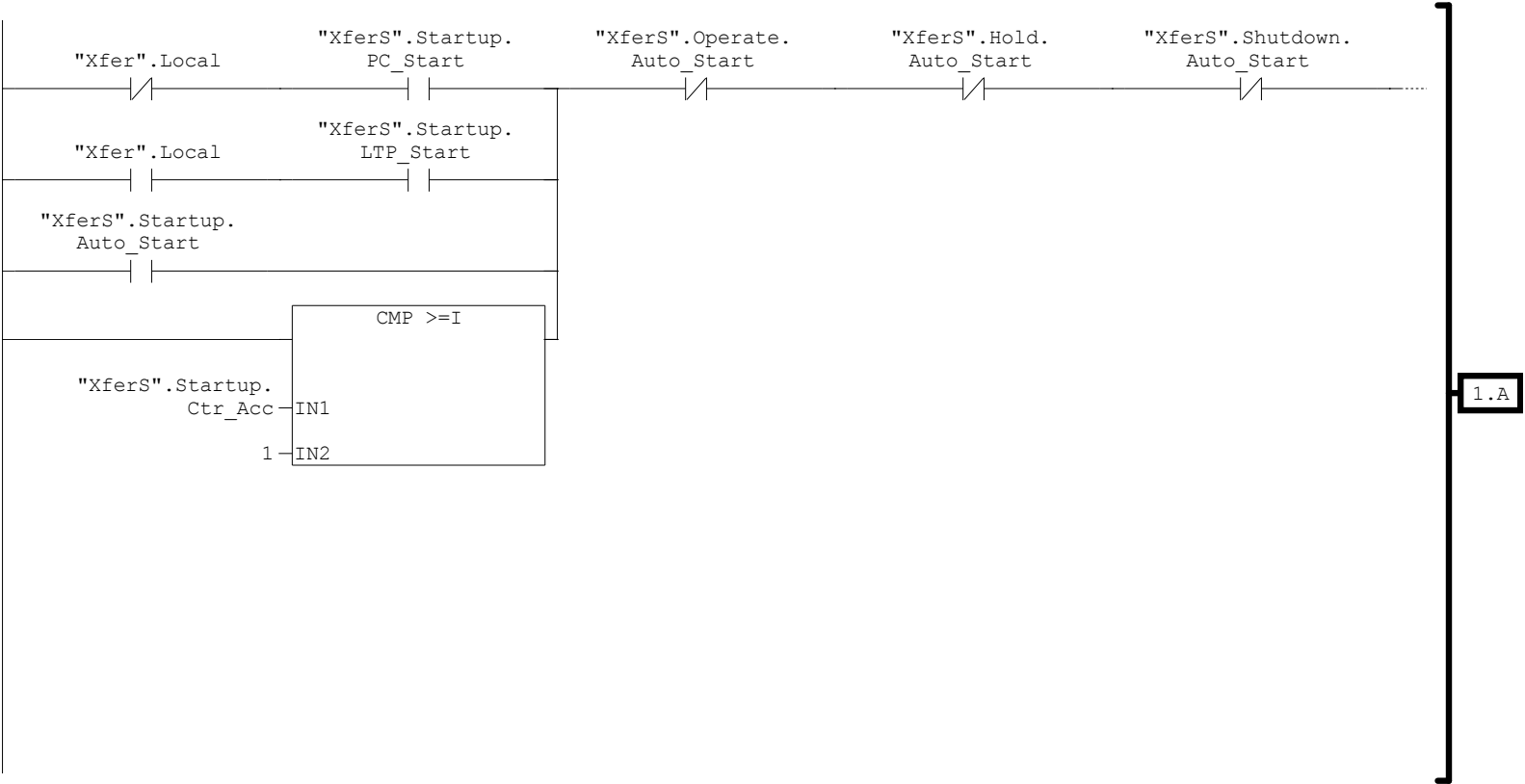
Block: FC20

Example 21.4 Xfer Sequences

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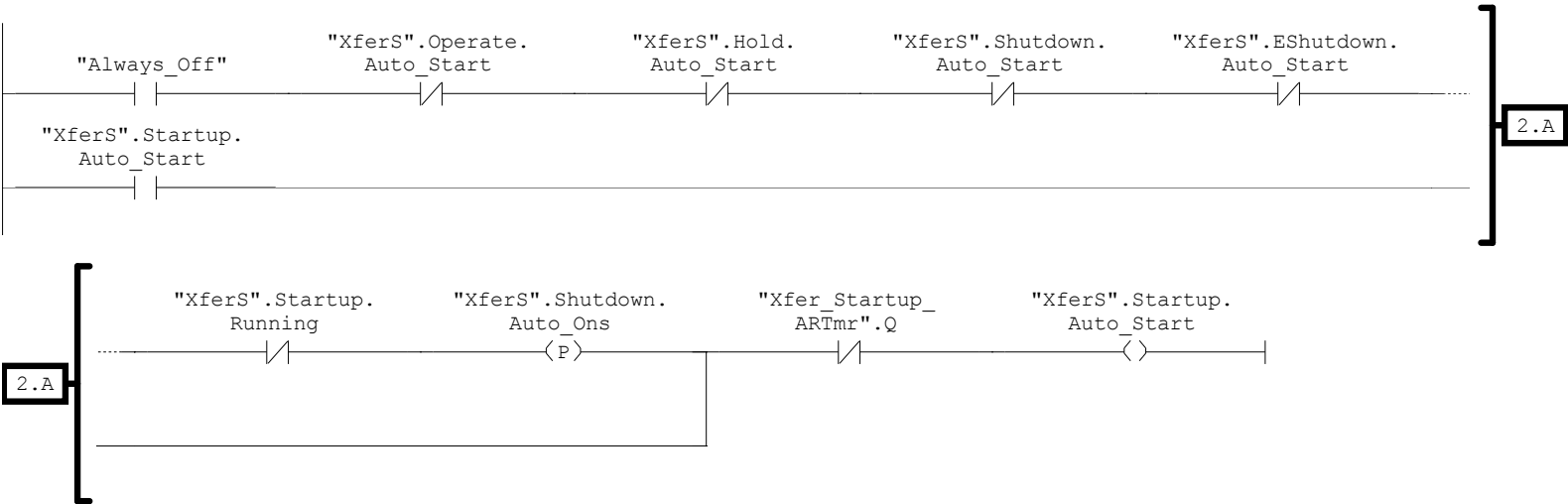
Network: 1 Start Transfer Sequence

Start Transfer - Operator requests and auto sequence starts. Maintain message number for OI

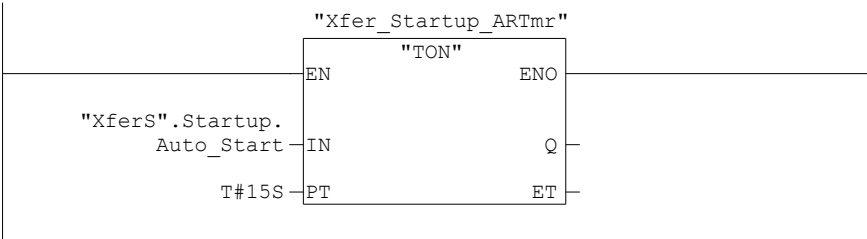


Network: 2 Auto start request

Auto-start for Startup - Not Used

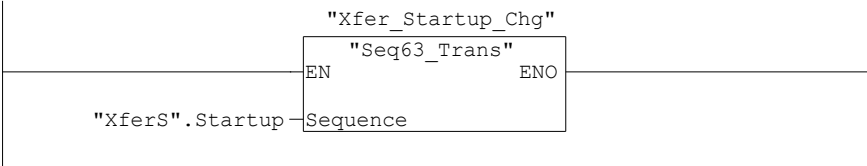


Network: 3



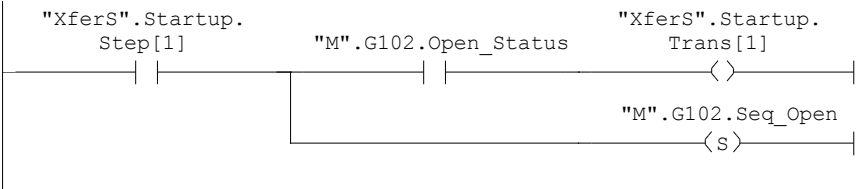
Network: 4

Change step-in-progress bit when step changes.

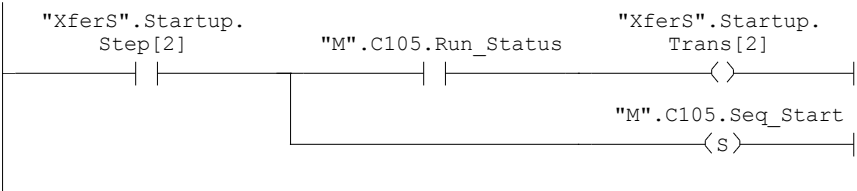


Network: 5 Step transition bits

Start Transfer step 1 - Open CIP Tank slide gate G-102



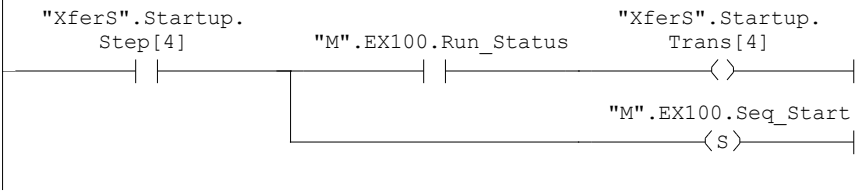
Network: 6	Step transition bits
Start Transfer step 2 - Start conveyor C-105	



Network: 7	Step transition bits
Start Transfer step 3 - Spare step	

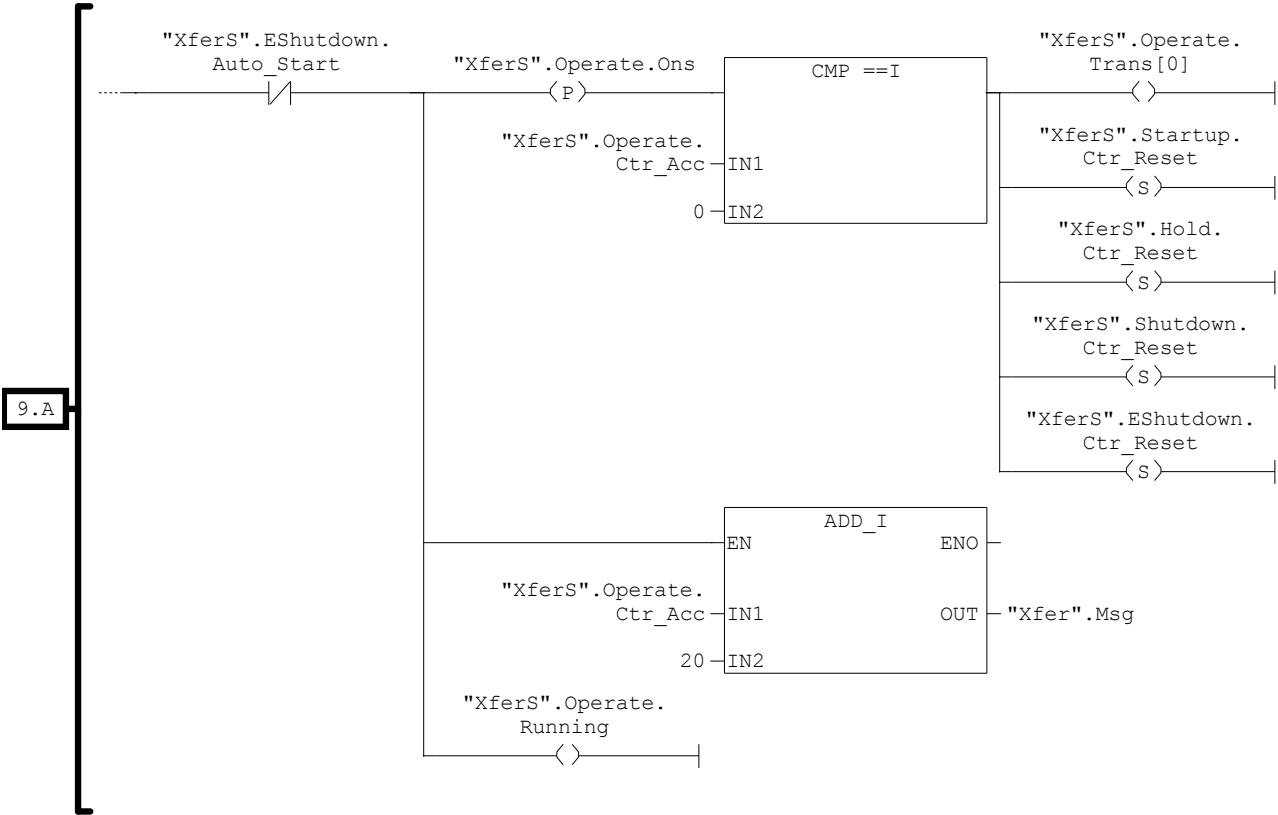
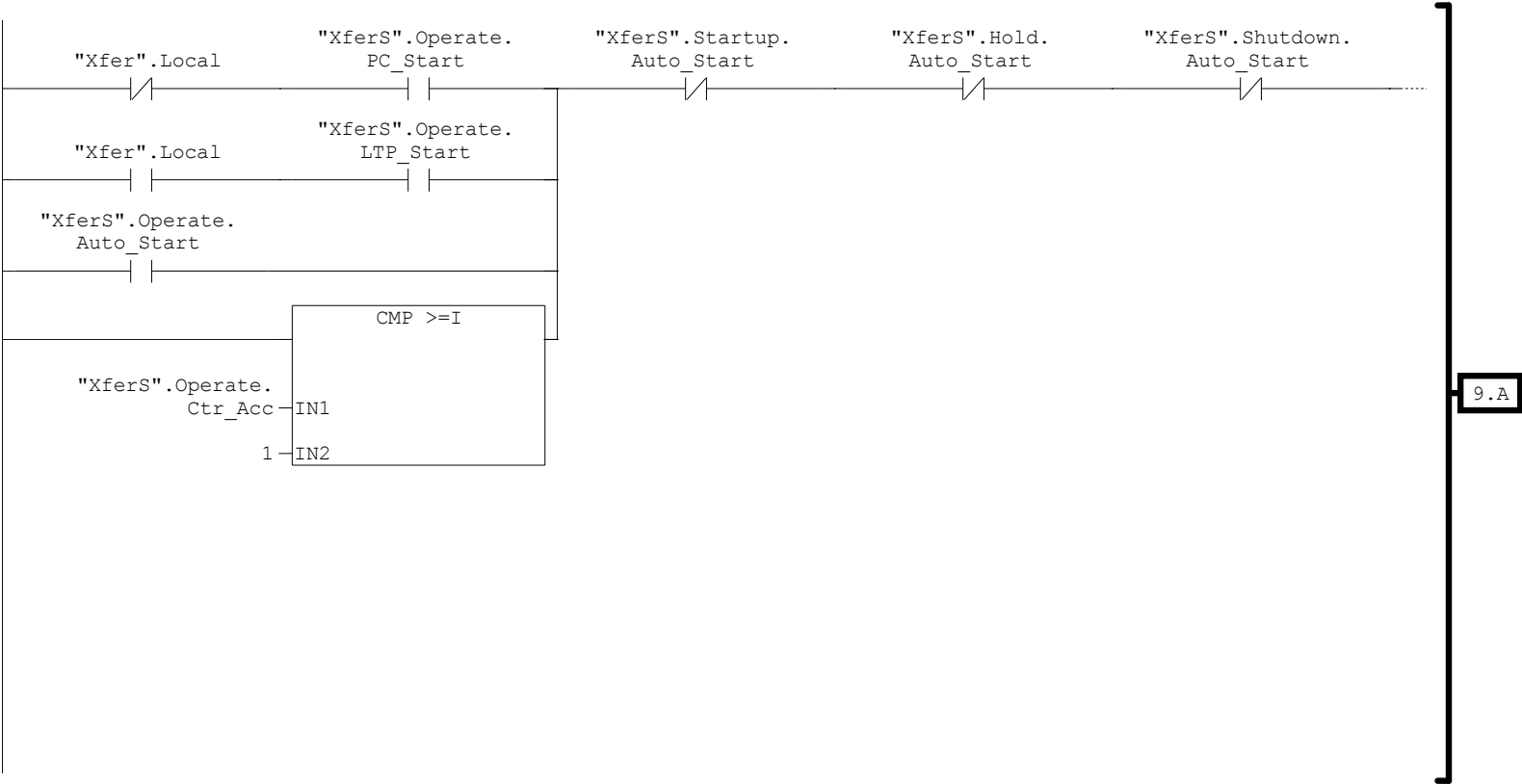


Network: 8	Step transition bits
Start Transfer step 4 - Start airlock EX100	



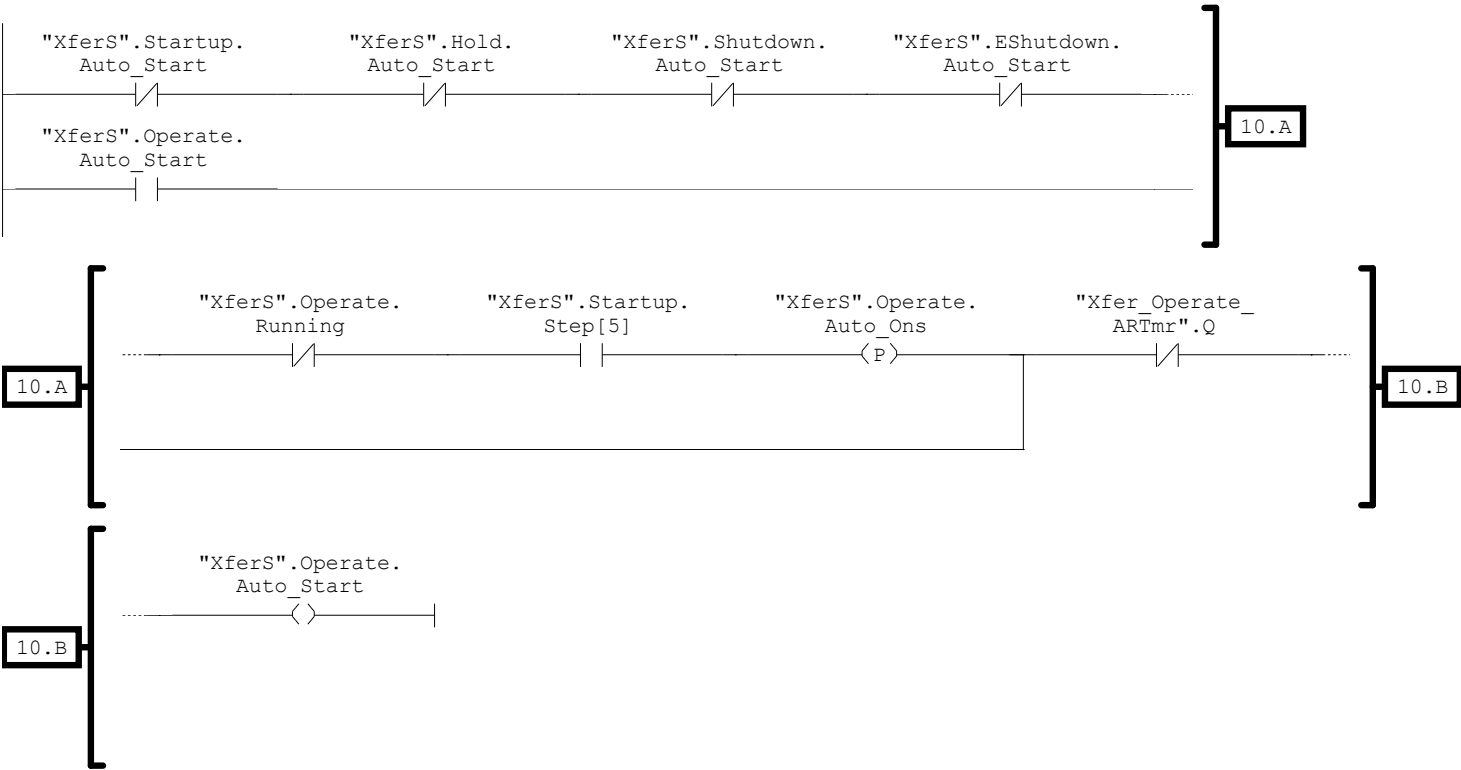
Network: 9 Operate Sequence

Operate - Operator requests and auto sequence starts. Maintain message number for OI

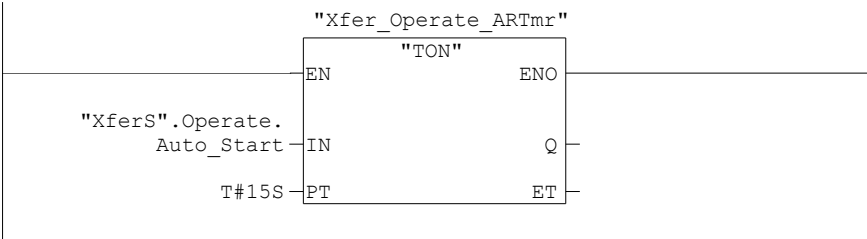


Network: 10 Auto start request

Auto-start for Operate

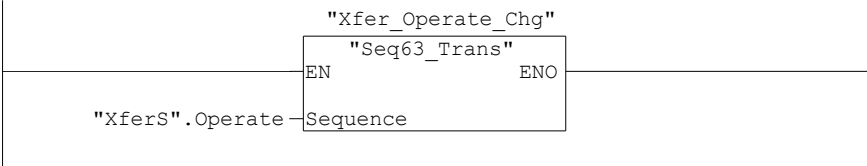


Network: 11



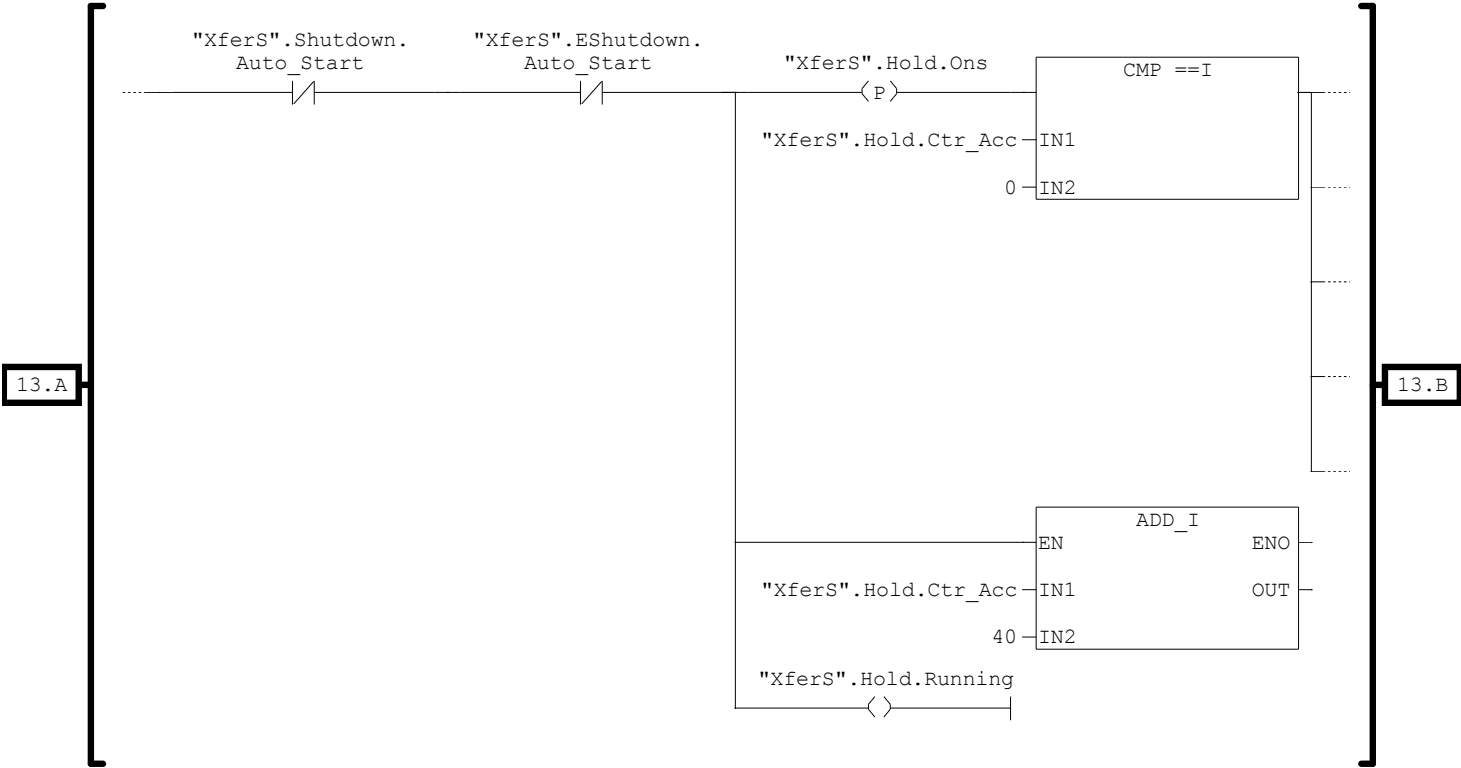
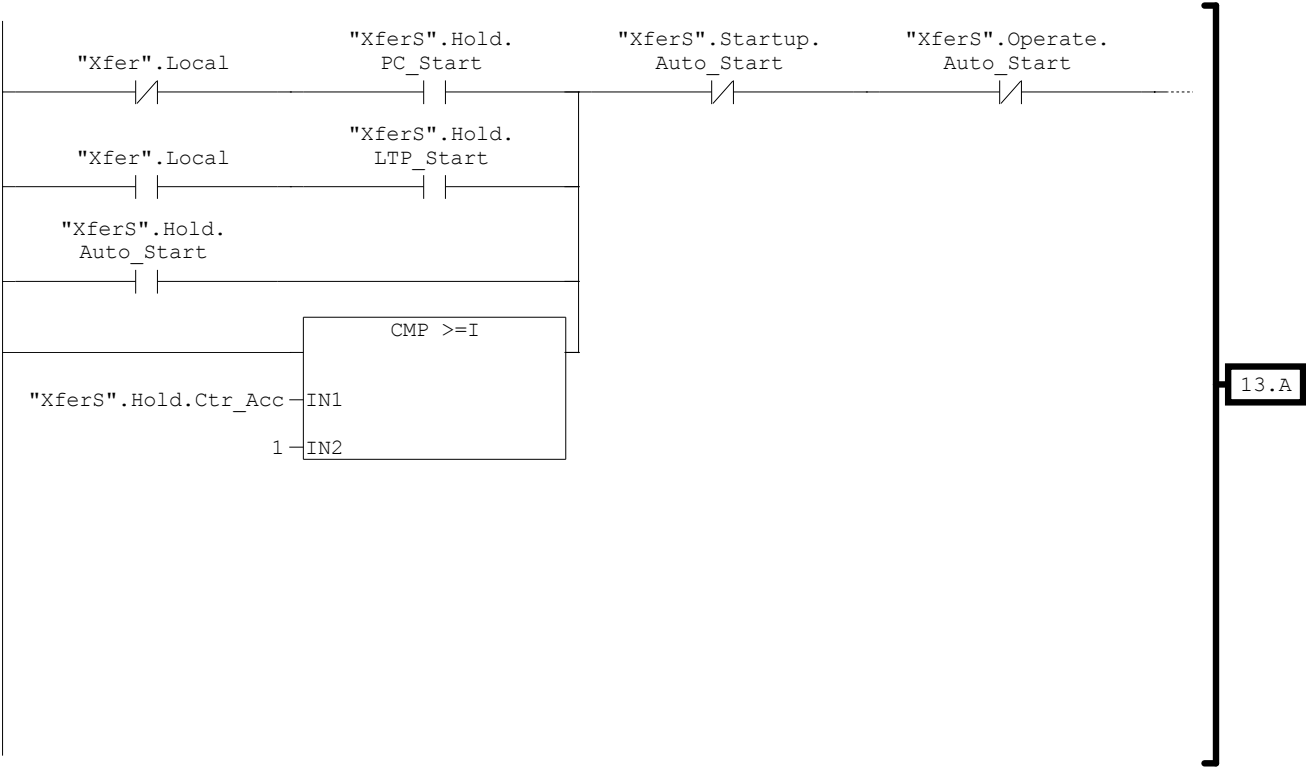
Network: 12

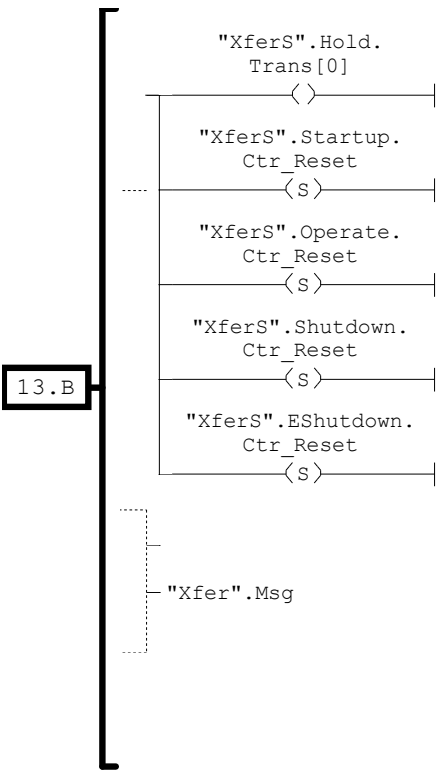
Change step-in-progress bit when step changes.



Network: 13 Hold Sequence

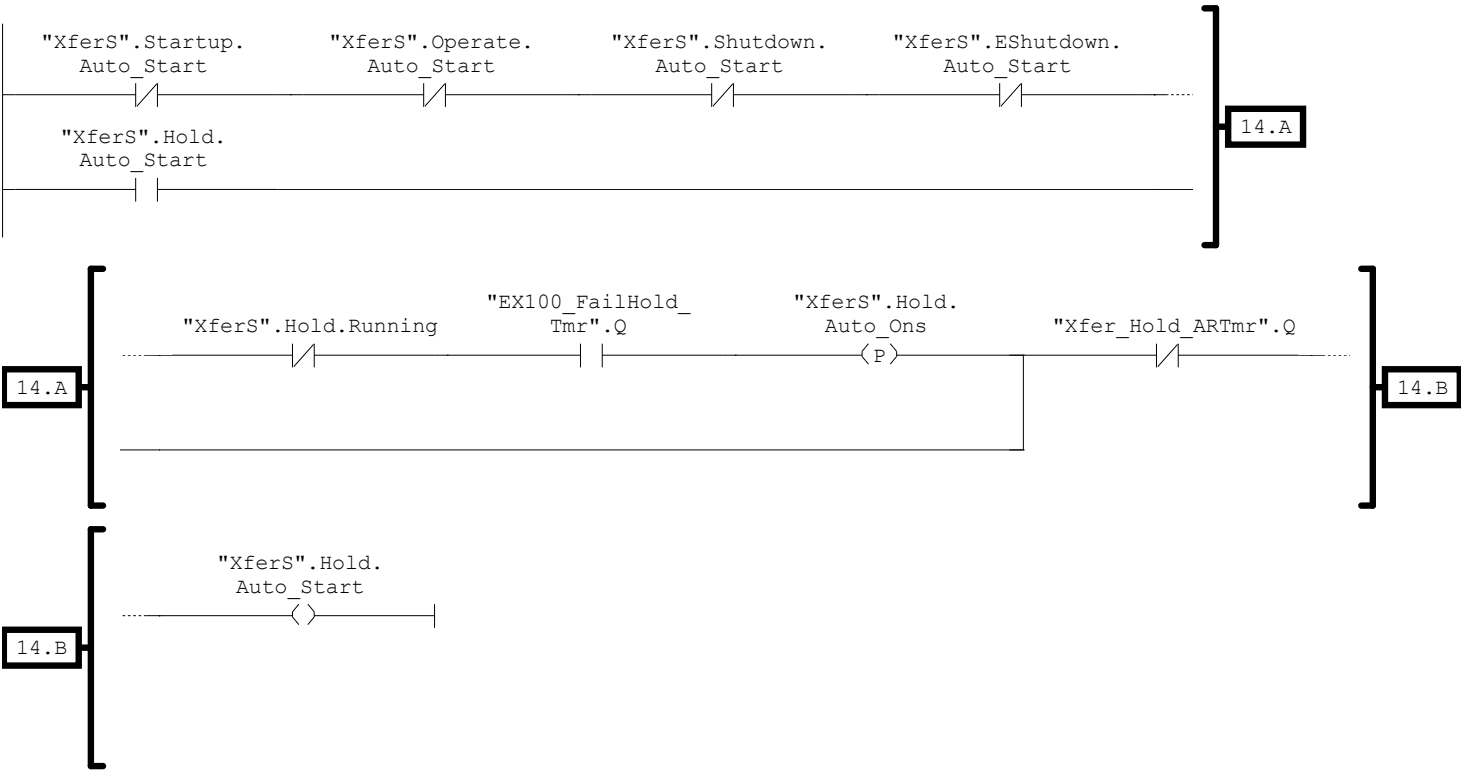
Hold - Operator requests and auto sequence starts. Maintain message number for OI



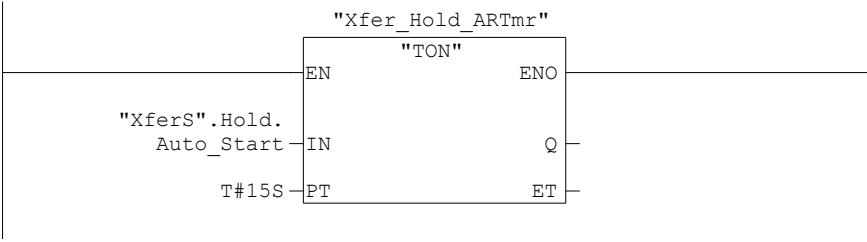


Network: 14 Auto start request

Auto-start for Hold

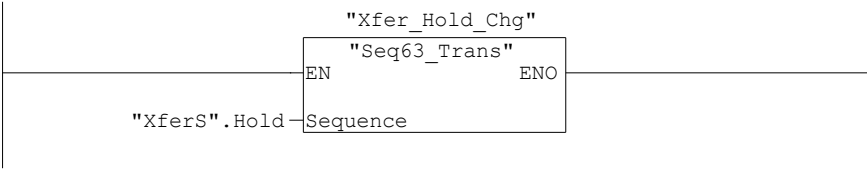


Network: 15



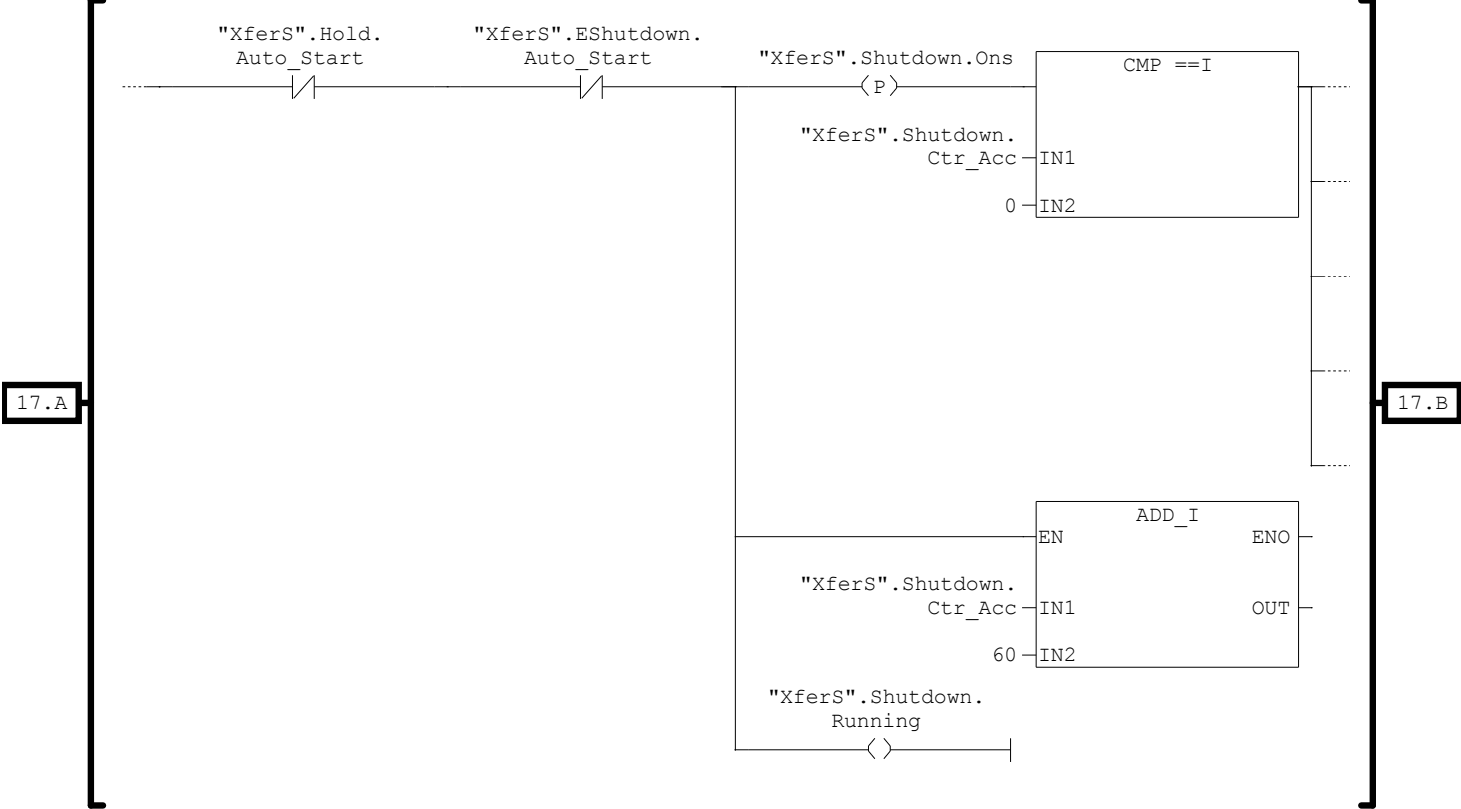
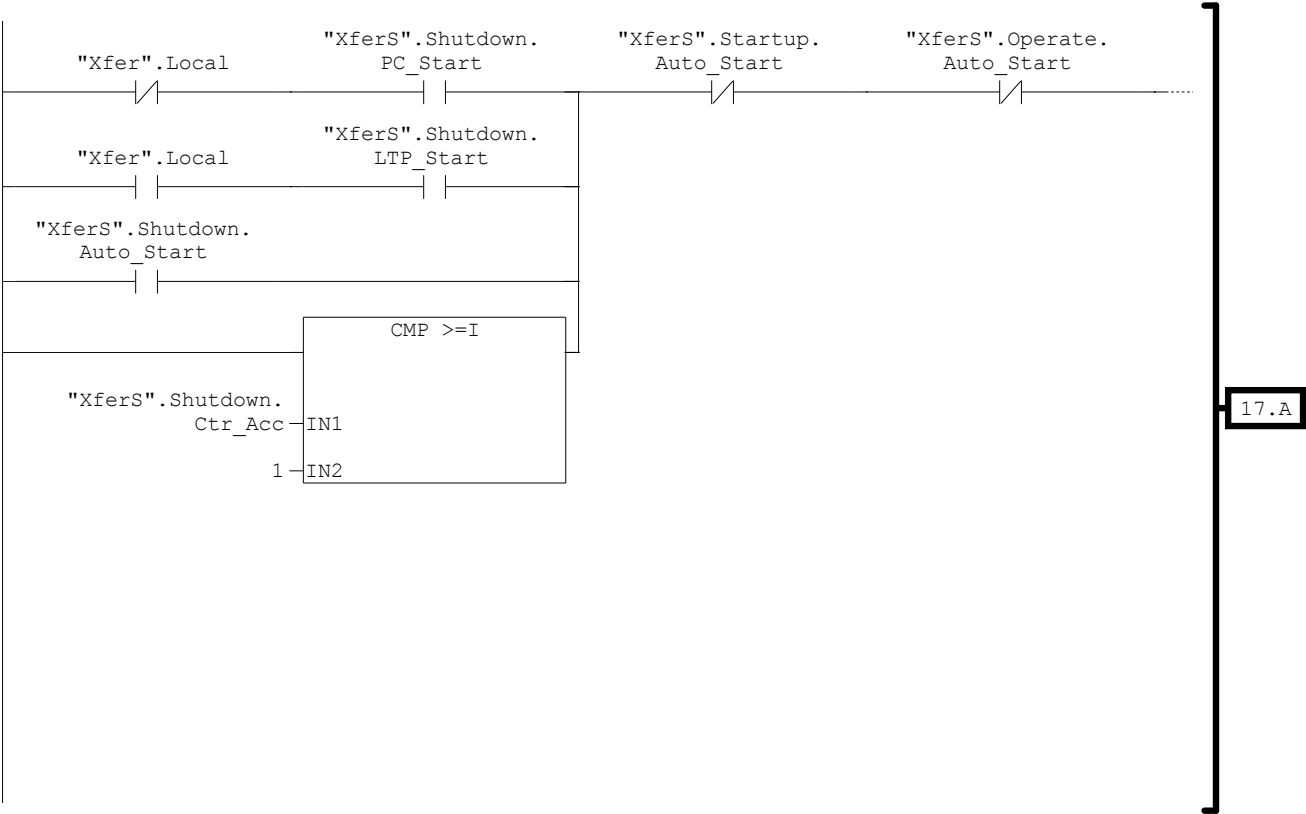
Network: 16

Change step-in-progress bit when step changes.



Network: 17 Shutdown Sequence

Shutdown - Operator requests and auto sequence starts. Maintain message number for OI





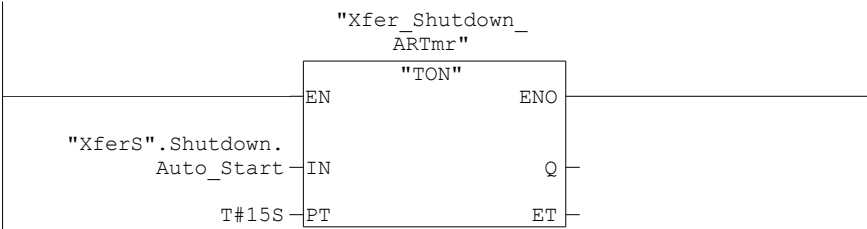
Auto-start for Shutdown



18.B

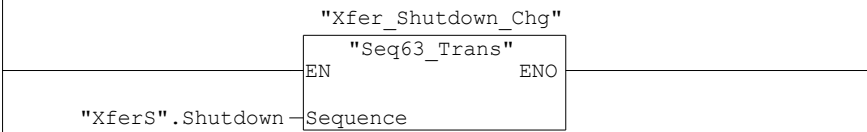
18.B

Network: 19



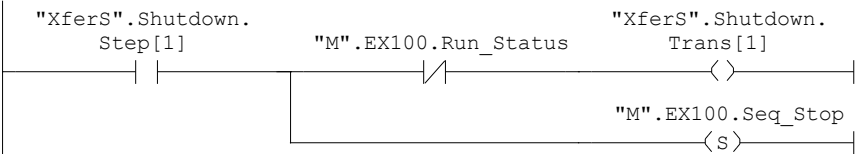
Network: 20

Change step-in-progress bit when step changes.



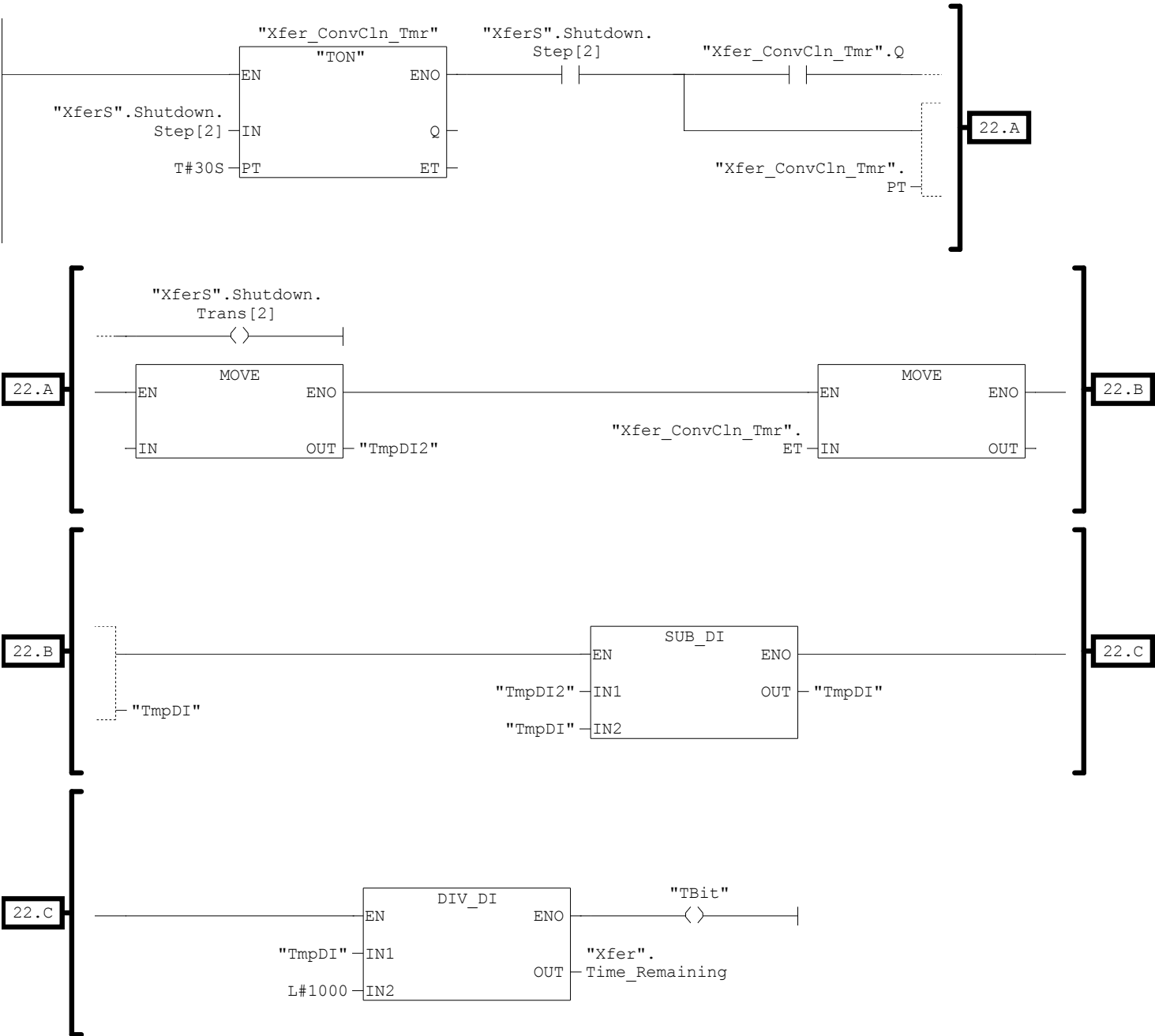
Network: 21 Step transition bits

Shutdown step 1 - Stop airlock



Network: 22 Times cleaning of C6100

Shutdown step 2 - Wait 30 seconds for C-6100 to clear.

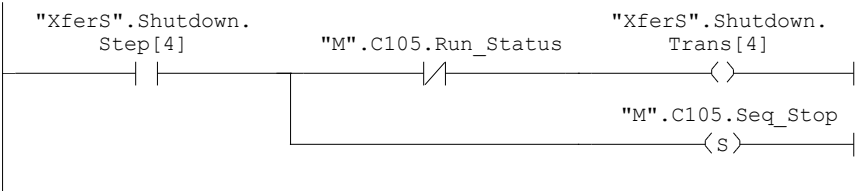


Network: 23 Step transition bits

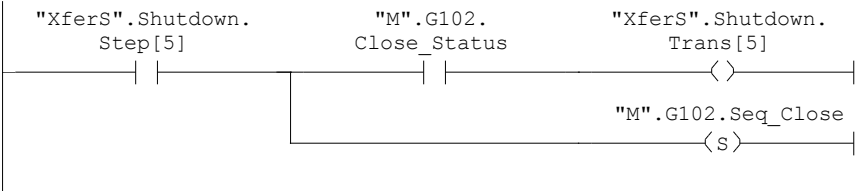
Shutdown step 3 - Spare step



Network: 24 Step transition bits
Shutdown step 4 - Stop soda ash screw conveyor.



Network: 25 Step transition bits
Shutdown step 5 - Close slide gate

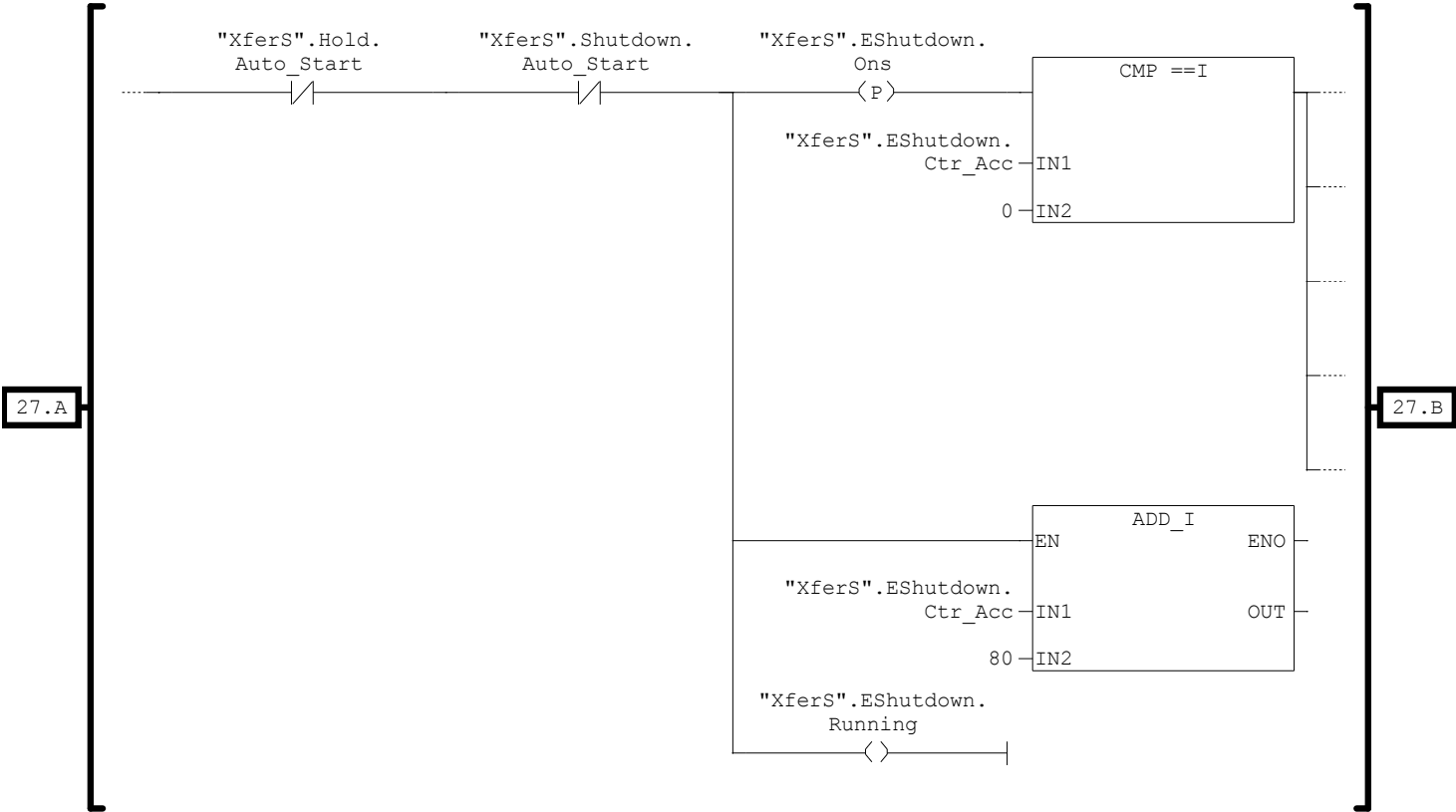
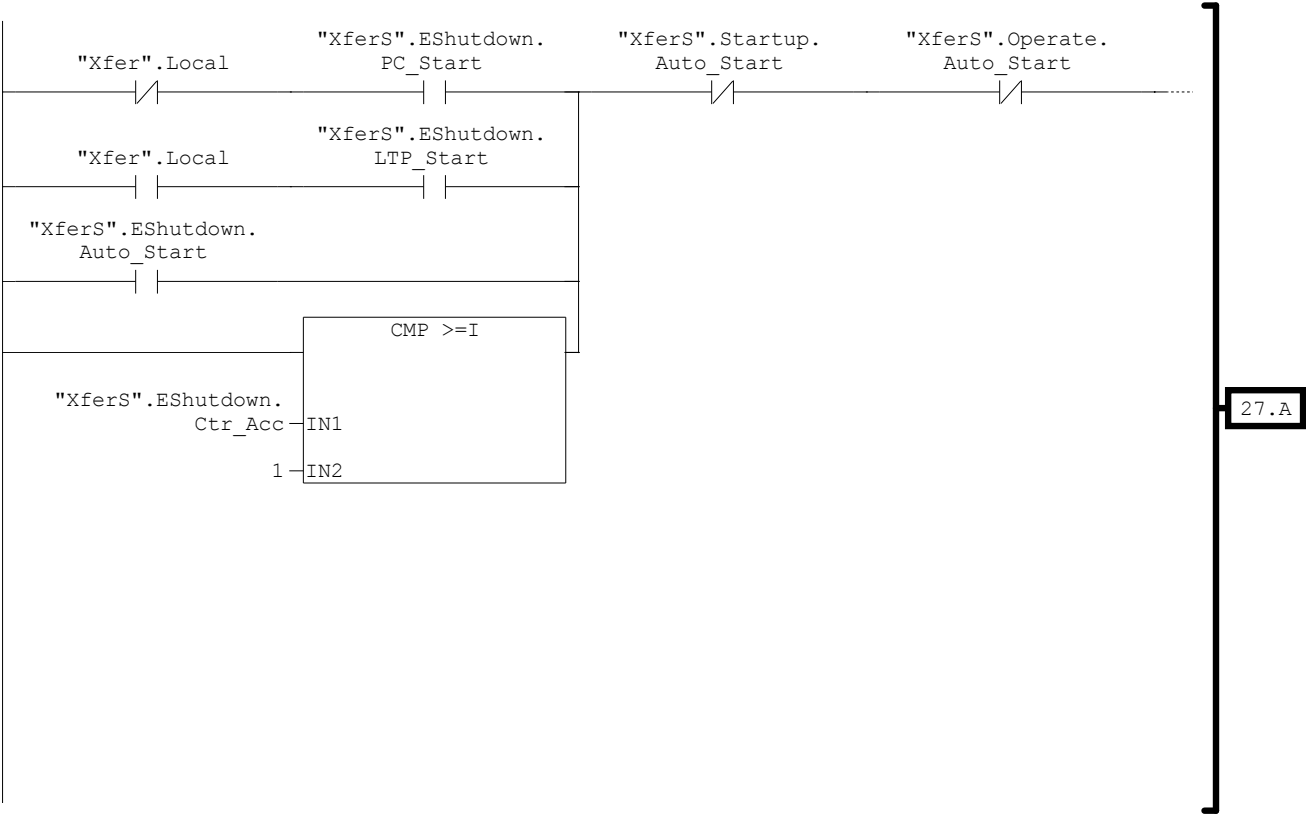


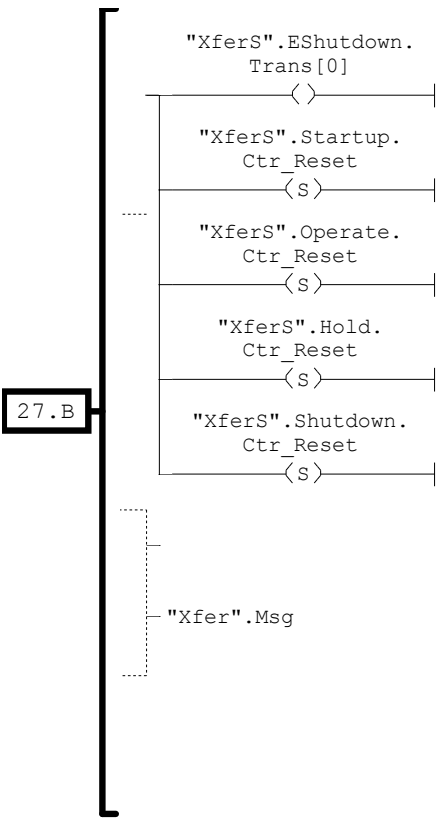
Network: 26 Step transition bits
Shutdown step 6 - Spare step



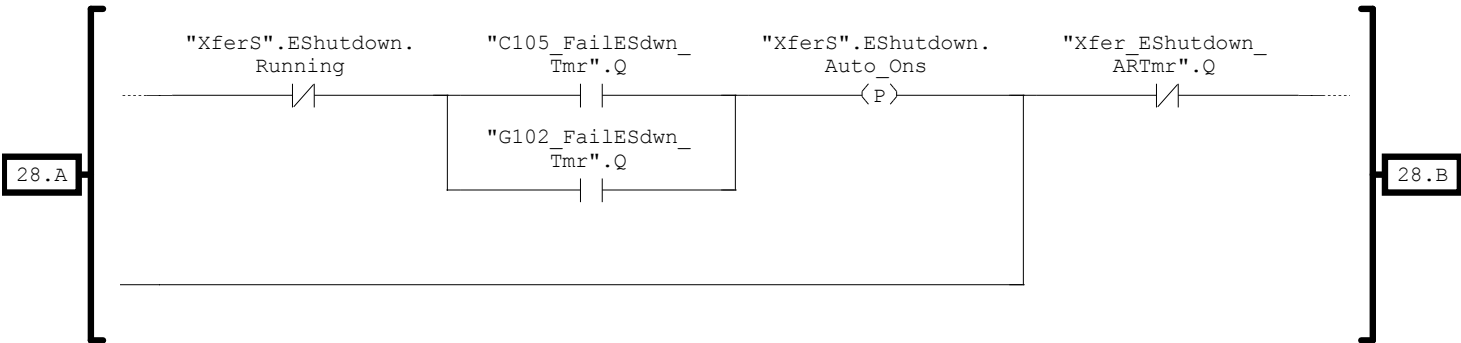
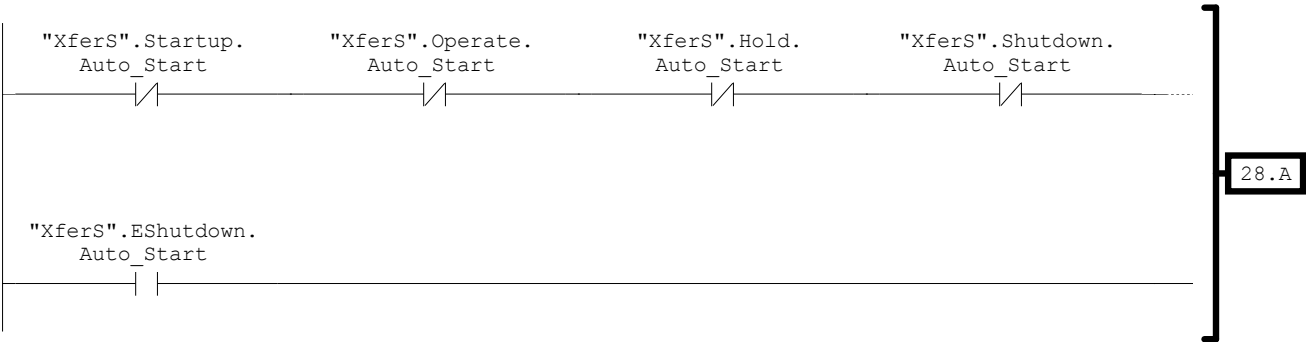
Network: 27 E-Shutdown Sequence

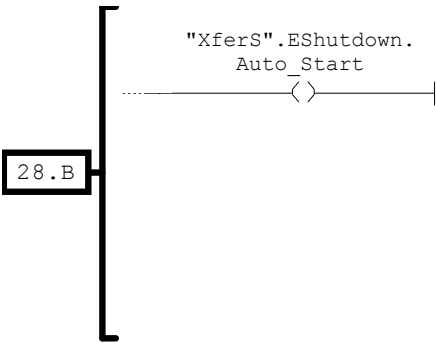
EShutdown - Operator requests and auto sequence starts. Maintain message number for OI



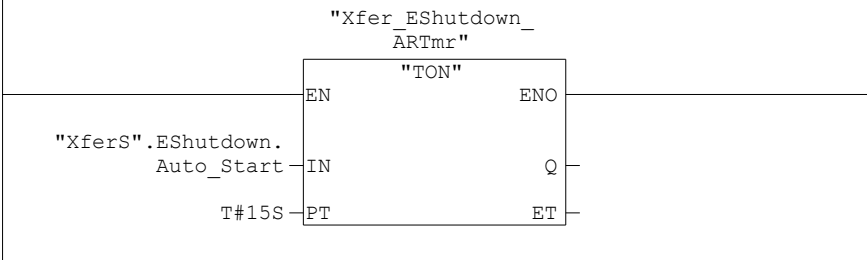


Network: 28 Auto start request
Auto-start for E-Shutdown



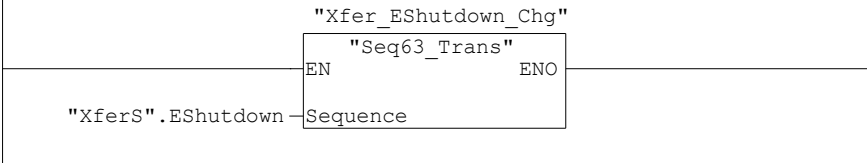


Network: 29



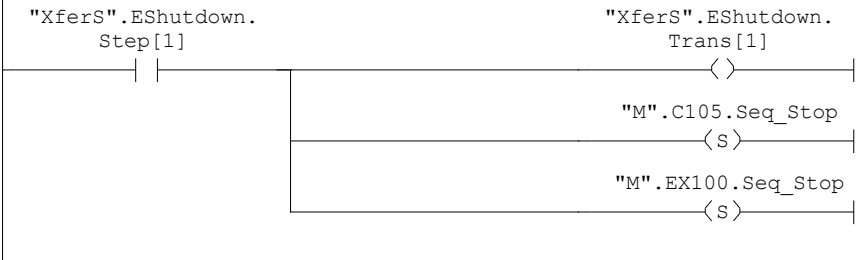
Network: 30

Change step-in-progress bit when step changes.

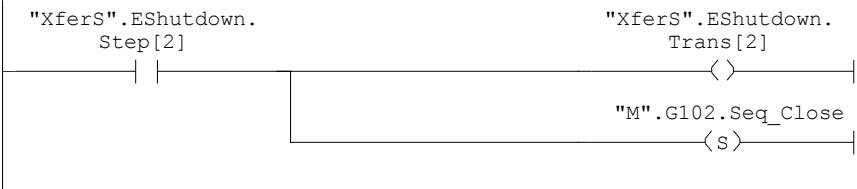


Network: 31 Step transition bits

E-Shutdown step 1 - Stop airlock and conveyor



Network: 32 Step transition bits
E-Shutdown step 2 - Close slide gate



Network: 33 Step transition bits
E-Shutdown step 3 - Spare



Network: 34 Step transition bits

E-Shutdown step 4 - Wait 15 seconds for equipment to shut down before allowing maintenance mode.

