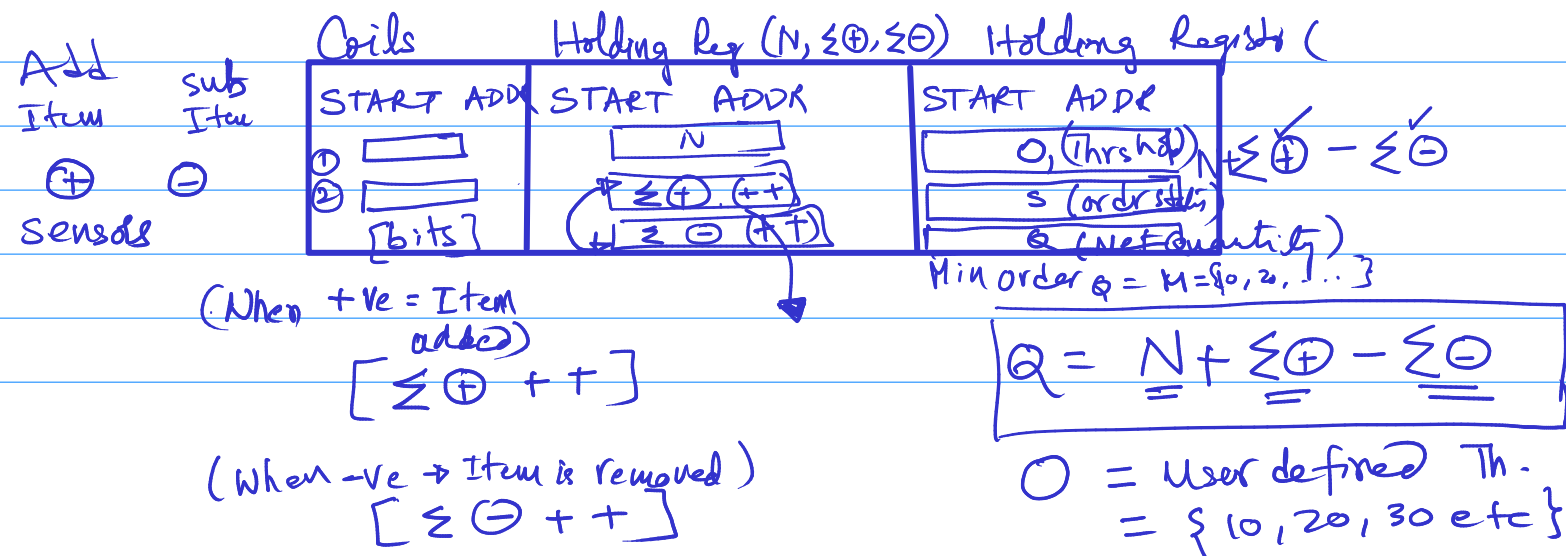
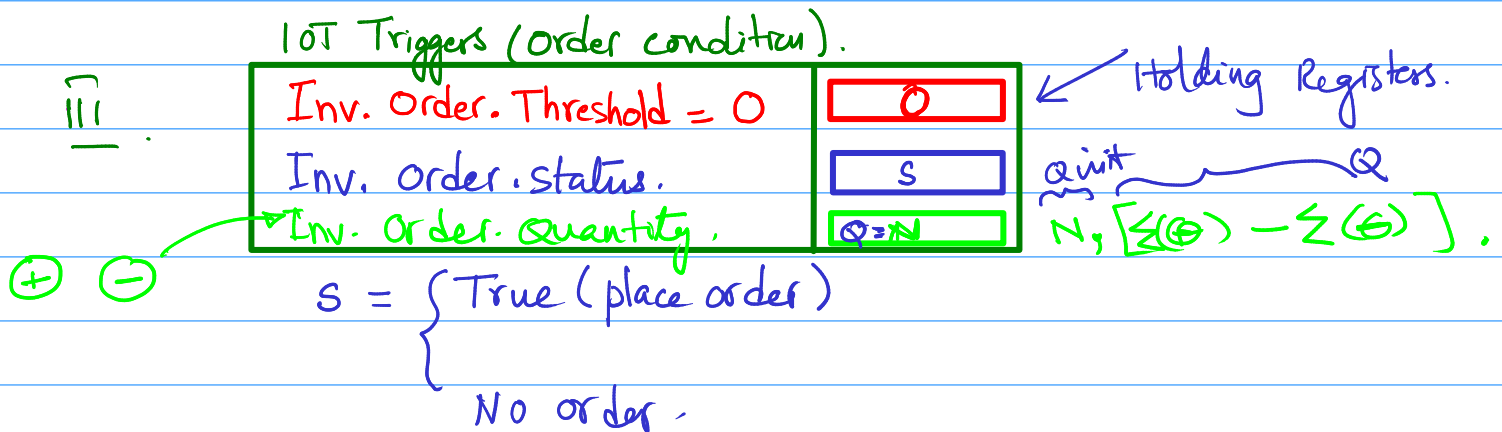
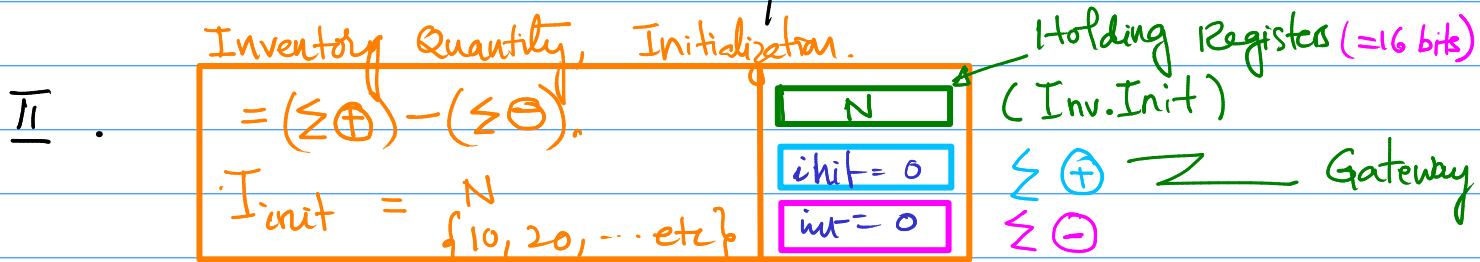
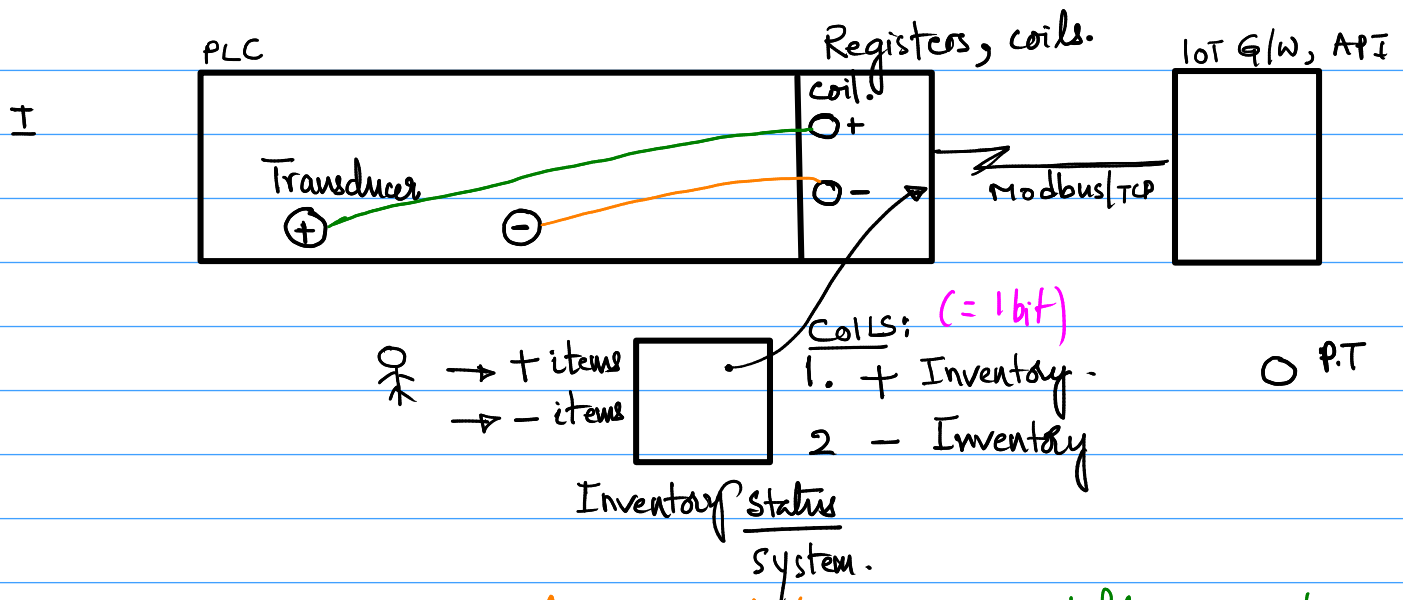


14-Sep-2021.



Net Quantity, $Q = N + \sum \oplus - \sum \ominus$

(or T) $O =$ User defined threshold

order status, $S =$ if $O - Q < 0$

$Q < O$

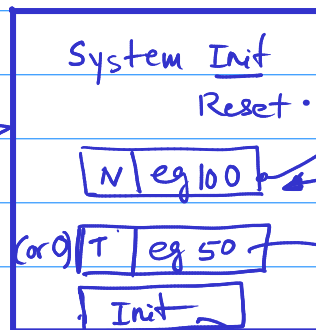
$Q > O$

S-Reg ✓
0 0 0 - - - 1

1 0 1 1 1 0

HMI

1. Screen -



Holding Register (N).

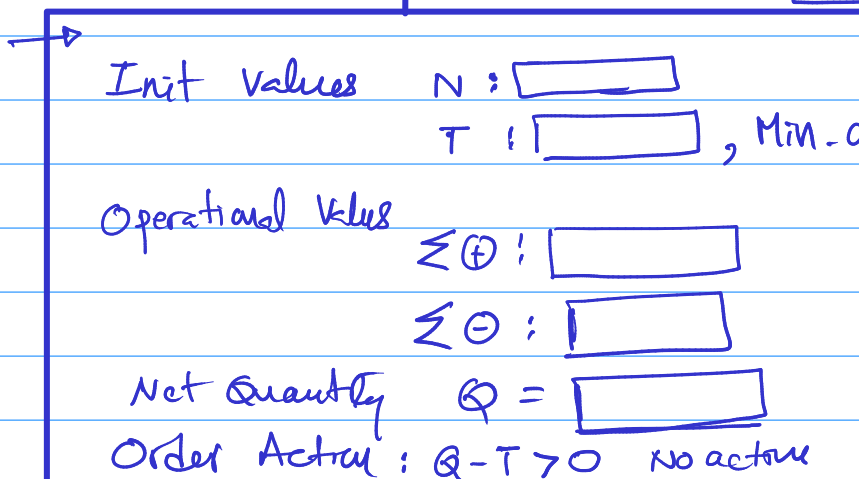
100

Holding Reg(T)

T/O 50, 60

$\sum \oplus = 0$
 $\sum \ominus = 0$
 $S = 0$
 $Q = N$
 $C, P_1 = 0$
 $C, P_2 = 0$

3rd Screen



Init Values

N :

T :

, Min-order Quantity = $M = \underline{\underline{\{10, 20 \dots\}}}$

Operational Values

$\sum \oplus$:

$\sum \ominus$:

Net Quantity

$Q =$

Order Action : $Q - T > 0$ No action

$Q - T < 0$ order .

