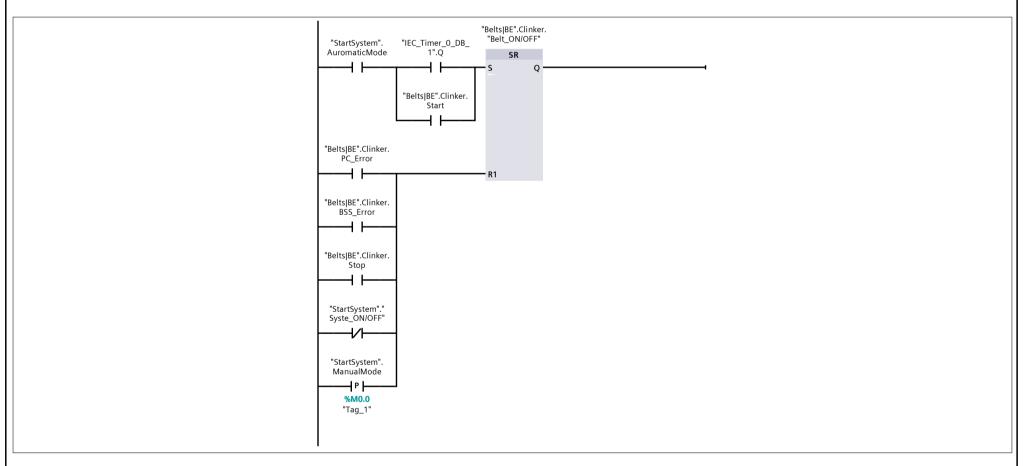
Re AutomaticModeFunction_Block	utomatic									
work 2: Main fan starts an on delay timer work 3: While the timer is counting Siren goes high. Mill is starting Alarm work 3: While the timer is counting Siren goes high. Mill is starting Alarm work 3: While the timer is counting Siren goes high. Mill is starting Alarm		:ModeFuncti	ion_Bloc	k [FC5]						
Authoratic Models function (Comment March	omaticMod eral	leFunction_Block	Properties							
Author Author Author Author On 0.1 User-defined ID Bata type Default value Comment Co	ne		Func-	Number	5		Туре	FC	Language	LAD
ton 0.1 Quendefined ID Comment Family Famil	nbering rmation									
Default value Comment July 1 Out Group Contract Automatic ModeFunction_Block Work 1: Main FAN, Main Bag Filter and Main Bag Filter rotor airlock goes on Value Spanner July 1 July 2 July 3 July 4 July 3 July 3 July 4 July 4	!	0.1			D		Comment		Family	
Work 2: Main fan starts an on delay timer Startington	ne	0.1				ault value		Comment		
More 2: Main fan starts an on delay timer Mai	nput			, , , , , , , , , , , , , , , , , , ,						
AutomaticModeFunction_Block Void AutomaticModeFunction_Block AutomaticM	nOut									
AutomaticModeFunction_Block	emp Constant									
work 1: Main FAN, Main Bag Filter and Main Bag Filter rotor airlock goes on **Gardystern** *	Return									
Work 2: Main fan starts an on delay timer Surfryster										
Work 2: Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer M	work 1: I	Main FAN, Mai	in Bag Filt	er and Main	Bag Filter ro	or airlock g	goes on			
Work 2: Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer StartSystem*, Main fan starts an on delay timer M				<u> </u>						
Work 2: Main fan starts an on delay timer **SartSystem** **S				"Sta Auro	rtSystem". "Start maticMode Syste	System"." "Sta _ON/OFF" Mai	rtSystem". nual Mode	"StartSystem". "280KW FAN"." Motor_ON/OFF"		
Work 2: Main fan starts an on delay timer **StartSystem** **S						1	- /			
Work 2: Main fan starts an on delay timer **StartSystem** **StartSystem** **StartSystem** **StartSystem** **StartSystem** **AutomaticKologie System** **StartSystem** **Start								MainBF_RotorAir		
work 2: Main fan starts an on delay timer "StartSystem"								Lock."Motor_ON/ OFF"		
work 2: Main fan starts an on delay timer "StartSystem"										
work 2: Main fan starts an on delay timer StartSystem: StartS								Main_BagFilter."		
work 2: Main fan starts an on delay timer StartSystem'								()		
work 2: Main fan starts an on delay timer StartSystem'								"Belts BE".BF_To_ OutletBE Belt."		
"StartSystem". "ToN ManualMode "StartSystem". "Timer 1_PT								Belt_ON/OFF"		
"StartSystem". "ToN ManualMode "StartSystem". "Timer 1_PT										
work 3: While the timer is counting Siren goes high. Mill is starting Alarm "StartSystem". "StartSystem". "IEC_Timer_O_ Mill_Drive."Motor_ ON/OFF" Siren AuromaticMode ManualMode Syste_ON/OFF" DB".Q ON/OFF" Siren					"280KW FAN"."	MainBF_RotorAi Lock."Motor_ON	r "StartSystem". I/ Main_BagFilter." On/Off"	"IEC_Timer_0_DB" "StartSystem". TON ManualMode Time		
"StartSystem". "StartSystem". "StartSystem"." "IEC_Timer_O_ Mill_Drive."Motor_ "StartSystem". AuromaticMode ManualMode Syste_ON/OFF" DB".Q ON/OFF" Siren			"StartSystem AuromaticMo	ode Syste_ON/OFF'						
"StartSystem". "StartSystem"." "IEC_Timer_O_ Mill_Drive."Motor_ "StartSystem". AuromaticMode ManualMode Syste_ON/OFF" DB".Q ON/OFF" Siren			"StartSysten AuromaticMo	ode Syste_ON/OFF	——————————————————————————————————————	• •	1	"StartSystem". ET —	T#0ms	
AuromaticMode ManualMode Syste_ÓN/OFF" DB".Q ON/OFF" Siren	work 3: \	While the time	AuromaticMo	Syste_ÖN/OFF'	es high. Mill i	s starting A		"StartSystem". ET —	T#0ms	
	work 3: \	While the time	AuromaticMo	ing Siren goe			Alarm	"StartSystem". ET — PT Timer1_PT — PT "StartSystem".	T#Oms	
work 4: After timer is done the Mill starts. If Main Fan goes off the mill has to stop too	work 3: \	While the time	AuromaticMo	ing Siren goe	"StartSystem". e ManualMode	"StartSystem"."	Alarm "IEC_Timer_0_ DB".Q	"StartSystem". Timer1_PT — PT "StartSystem". Mill_Drive."Motor_ ON/OFF" Siren	T#Oms	
work 4. After timer is done the Mill starts. If Main Fan goes off the mill has to stop too	work 3: \	While the time	AuromaticMo	ing Siren goe	"StartSystem". e ManualMode	"StartSystem"."	Alarm "IEC_Timer_0_ DB".Q	"StartSystem". Timer1_PT — PT "StartSystem". Mill_Drive."Motor_ ON/OFF" Siren	T#Oms	
			AuromaticMo	ing Siren goe	"StartSystem". e ManualMode 	"StartSystem"." Syste_ON/OFF"	Alarm "IEC_Timer_0_ DB".Q	"StartSystem". Timer1_PT — PT "StartSystem". Mill_Drive."Motor_ ON/OFF" Siren	T#Oms	
			AuromaticMo	ing Siren goe	"StartSystem". e ManualMode 	"StartSystem"." Syste_ON/OFF"	Alarm "IEC_Timer_0_ DB".Q	"StartSystem". Timer1_PT — PT "StartSystem". Mill_Drive."Motor_ ON/OFF" Siren	T#Oms	
			AuromaticMo	ing Siren goe	"StartSystem". e ManualMode 	"StartSystem"." Syste_ON/OFF"	Alarm "IEC_Timer_0_ DB".Q	"StartSystem". Timer1_PT — PT "StartSystem". Mill_Drive."Motor_ ON/OFF" Siren	T#Oms	
			AuromaticMo	ing Siren goe	"StartSystem". e ManualMode 	"StartSystem"." Syste_ON/OFF"	Alarm "IEC_Timer_0_ DB".Q	"StartSystem". Timer1_PT — PT "StartSystem". Mill_Drive."Motor_ ON/OFF" Siren	T#Oms	
			AuromaticMo	ing Siren goe	"StartSystem". e ManualMode 	"StartSystem"." Syste_ON/OFF"	Alarm "IEC_Timer_0_ DB".Q	"StartSystem". Timer1_PT — PT "StartSystem". Mill_Drive."Motor_ ON/OFF" Siren	T#Oms	
			AuromaticMo	ing Siren goe	"StartSystem". e ManualMode 	"StartSystem"." Syste_ON/OFF"	Alarm "IEC_Timer_0_ DB".Q	"StartSystem". Timer1_PT — PT "StartSystem". Mill_Drive."Motor_ ON/OFF" Siren	T#Oms	
			AuromaticMo	ing Siren goe	"StartSystem". e ManualMode 	"StartSystem"." Syste_ON/OFF"	Alarm "IEC_Timer_0_ DB".Q	"StartSystem". Timer1_PT — PT "StartSystem". Mill_Drive."Motor_ ON/OFF" Siren	T#Oms	
			AuromaticMo	ing Siren goe	"StartSystem". e ManualMode 	"StartSystem"." Syste_ON/OFF"	Alarm "IEC_Timer_0_ DB".Q	"StartSystem". Timer1_PT — PT "StartSystem". Mill_Drive."Motor_ ON/OFF" Siren	T#Oms	
			AuromaticMo	ing Siren goe	"StartSystem". e ManualMode 	"StartSystem"." Syste_ON/OFF"	Alarm "IEC_Timer_0_ DB".Q	"StartSystem". Timer1_PT — PT "StartSystem". Mill_Drive."Motor_ ON/OFF" Siren	T#Oms	
			AuromaticMo	ing Siren goe	"StartSystem". e ManualMode 	"StartSystem"." Syste_ON/OFF"	Alarm "IEC_Timer_0_ DB".Q	"StartSystem". Timer1_PT — PT "StartSystem". Mill_Drive."Motor_ ON/OFF" Siren	T#Oms	
			AuromaticMo	ing Siren goe	"StartSystem". e ManualMode 	"StartSystem"." Syste_ON/OFF"	Alarm "IEC_Timer_0_ DB".Q	"StartSystem". Timer1_PT — PT "StartSystem". Mill_Drive."Motor_ ON/OFF" Siren	T#Oms	

Totally Integrated **Automation Portal** "StartSystem". Mill_Drive."Motor_ ON/OFF" "IEC_Timer_0_ DB".Q "StartSystem". AuromaticMode SR "StartSystem". Mill_Drive.Start "StartSystem". Mill_Temp >= Real 80.0 "StartSystem"." Syste_ON/OFF" - | / |-"StartSystem". ManualMode | | | Network 5: When mill has started a timer is triggerd. The timer starts all weighfeeders, Bucket elevetors and all belts

```
%DB8
"IEC_Timer_0_DB_
1"
                                                              "StartSystem".
Mill_Drive."Motor_
ON/OFF"
                                "StartSystem"."
Syste_ON/OFF"
                                                                                                                                         TON
"StartSystem".
AuromaticMode
                                                                                                  "StartSystem".
ManualMode
                                                                                                                                                   Q·
                                                                                                                                                   ET -
                                                                                                      "StartSystem".
Timer2_PT — PT
```

Network 6: Starting Clinker WF Belt

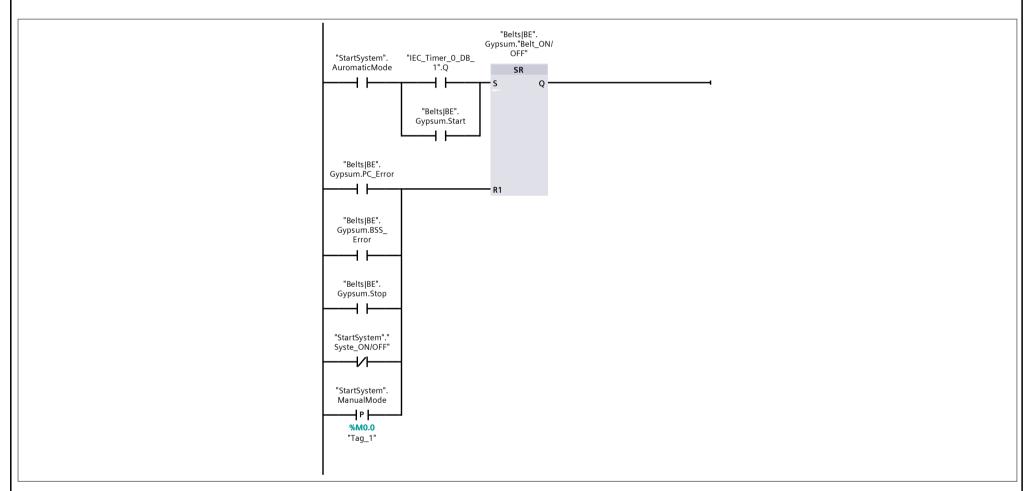


Network 7: Starting Pozzolona WF Belt

Totally Integrated Automation Portal

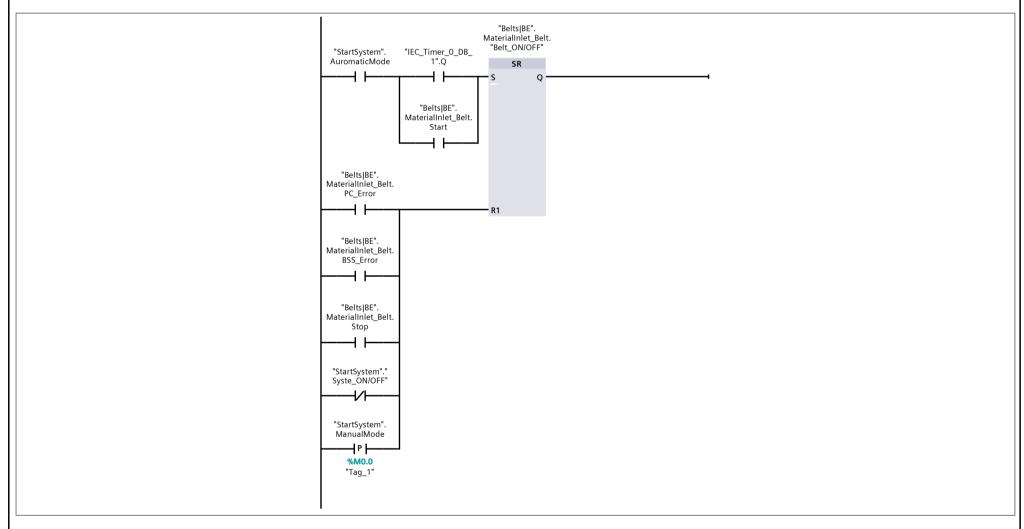
| Sautispicent | Size | Tecture | D. Dia | Department | Debugger | Debug

Network 8: Starting Gypsum WF Belt



Network 9: Starting Limestone WF Belt

Network 10: Starting Material Inlet Long Belts. If belts sways or pull code is activated specific belts go off untill reset



Network 11: Starting Course Material Long Belts. If belts sways or pull code is activated specific belts go off untill reset

Totally integrated Automation Portal

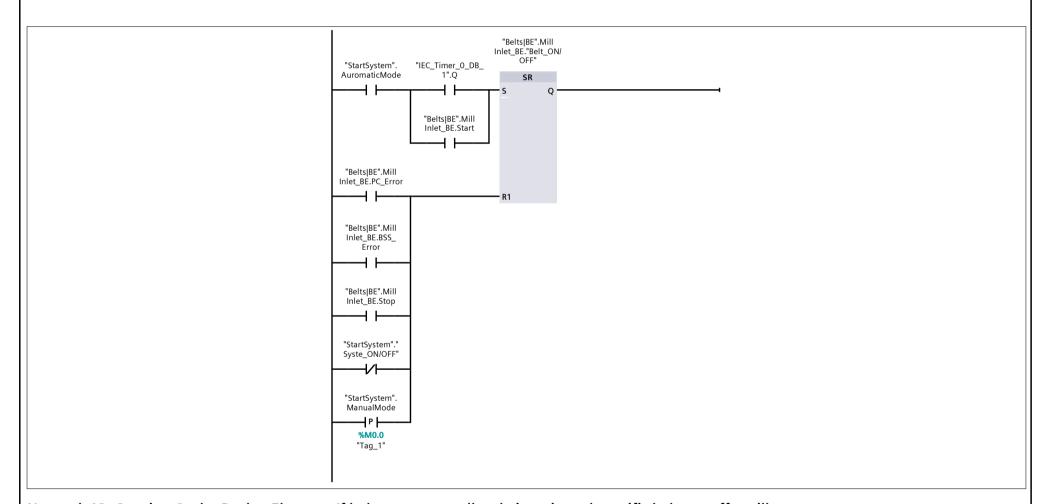
"StartSystem". "IEC_Timer_0_0.08." **
Auromation Belt." **
Auromation Belt. **

"StartSystem". **
Auromation Belt. **

"StartSystem". **

"StartSy

Network 12: Starting Inlet Bucket Elevetor. If belts sways or pull code is activated specific belts go off untill reset

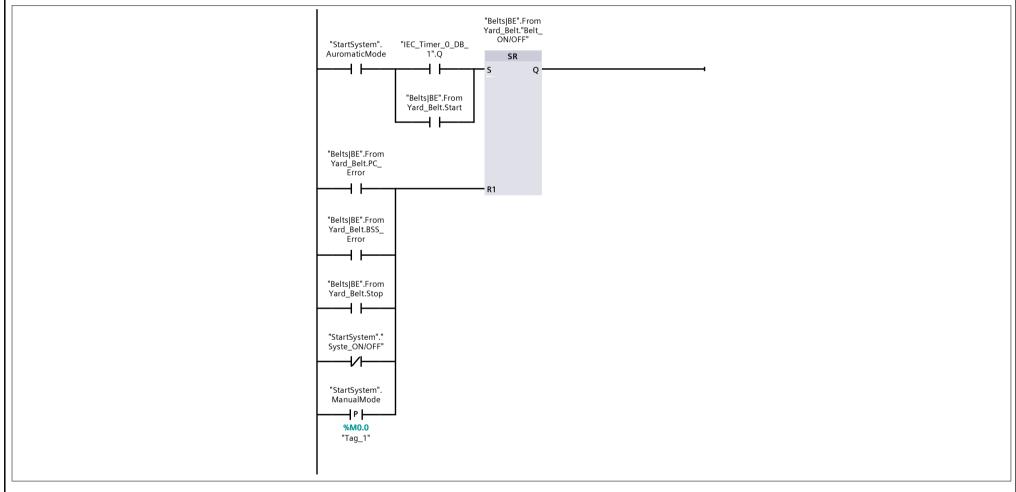


Network 13: Starting Outlet Bucket Elevetor. If belts sways or pull code is activated specific belts go off untill reset

Totally integrated Automation Portal

"SarrSystem" | "EC_Timer_O_DE | Single Starr | Single Star

Network 14: Starting Belt From Material Yard to hoppers. If belts sways or pull code is activated specific belts go off untill reset



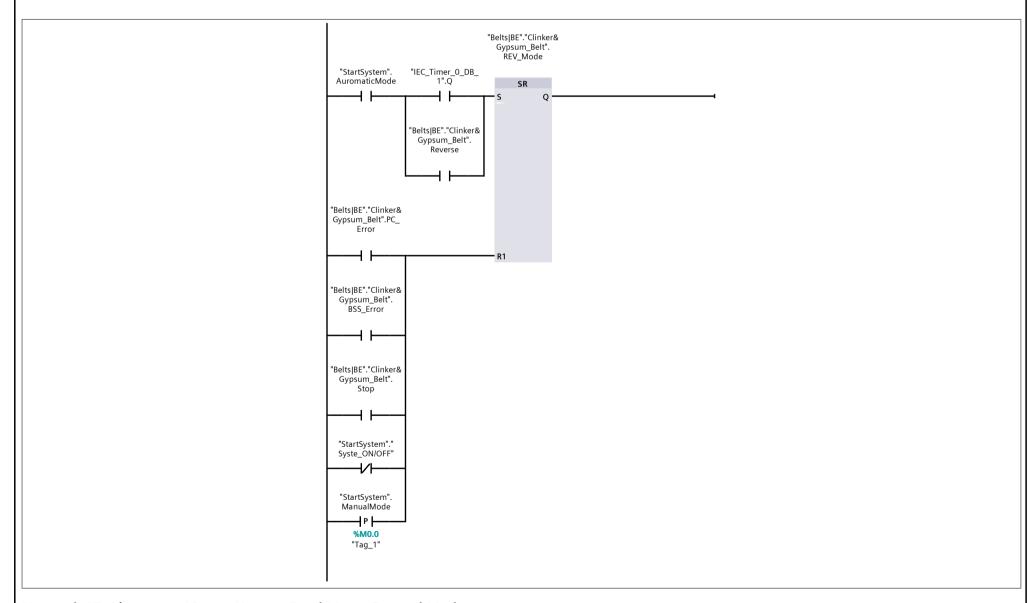
Network 15: Clinker&Gypsum Hopper Feed Motor Foward Mode

Totally Integrated
Automation Portal

Technique Copum, part:

Technique Copum,

Network 16: Clinker&Gypsum Hopper Feed Motor Reverse Mode

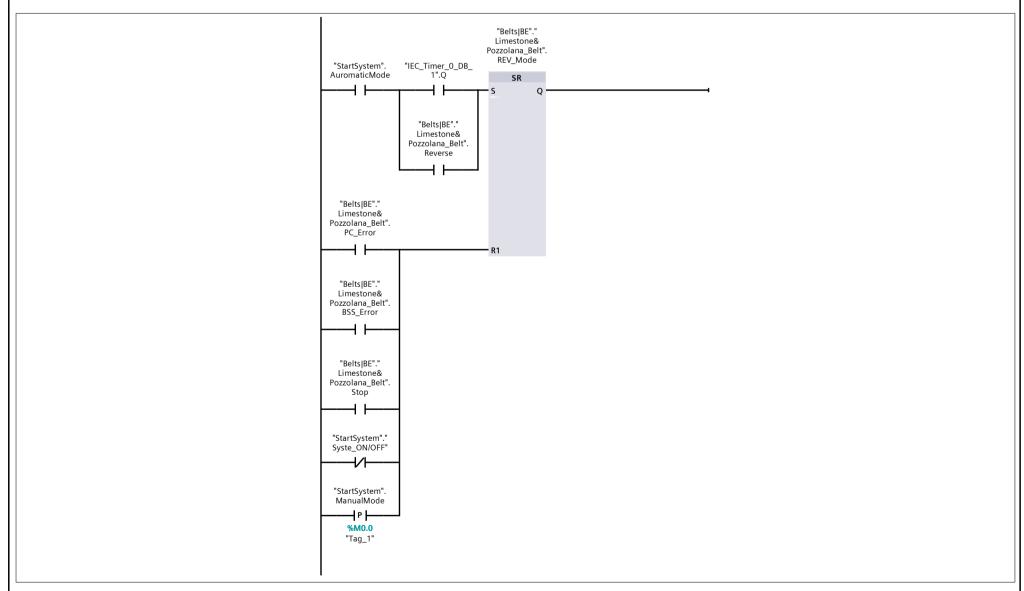


Network 17: Limestone&Pozzo Hopper Feed Motor Foward Mode

Totally Integrated **Automation Portal** "Belts|BE"." Limestone& Pozzolana_Belt". FWD_Mode "IEC_Timer_0_DB_ 1".Q "StartSystem". AuromaticMode SR "Belts|BE"." Limestone& Pozzolana_Belt". Foward "Belts|BE"." Limestone&
Pozzolana_Belt".
PC_Error "Belts|BE"." Limestone& Pozzolana_Belt". BSS_Error "Belts|BE"." Limestone& Pozzolana_Belt". Stop "StartSystem"." Syste_ON/OFF" "StartSystem". ManualMode

Network 18: Limestone&Pozzo Hopper Feed Motor Reverse Mode

%M0.0 "Tag_1"



Network 19: Reset both Timers. When the last belt goes on or when the system is switched off.

This helps to stop and start the motors above.

	1			
Totally Integrated Automation Portal				
	 vstem goes off reset tempera	ture to 23 degrees celcius and lev	vel to 0	l
recevor 20. When s	ystem goes on reset tempere	reare to 25 degrees cereius and rev		
	"StartSystem"." Syste_ON/OFF"			
	Syste_ON/OFF"	EN — ENO	MOVE EN — ENO	
	"StartSystem". ManualMode	23.0 — IN "StartSystem". OUT1 — Mill_Temp	0 — IN "StartSystem". ■ OUT1 — Silo_Level	
	P			
	"Tag_1"			
	I			
	1			