## DB610 - <offline> - Data view "Batch\_Data" Data Block - Batch Data

Global data block DB 610

Name: Family: Version: 0.1 Author:  ${\bf Block\ version:\ 2}$ 

Code: 07/03/2015 10:35:52 AM 1nterface: 06/27/2015 12:36:16 PM Time stamp Code: Lengths (block/logic/data): 00696 00400 00000

Block: DB610 Data Block - Batch Data

| Address | Name   | Type   | Initial value                           | Actual value                            | Comment   |
|---------|--|--------|---|---|---|
| 0.0     | Current.DataReady  | BOOL   | FALSE                                   | FALSE                                   | Batch Data Complete (1=Yes)                                       |
| 2.0     | Current.FurnaceNum   | INT    | 0                                       | 0                                       | Furnace Number  |
| 4.0     | Current.CastNum  | INT    | 0                                       | 0                                       | Cast Number   |
| 6.0     | Current.TotalStacks  | INT    | 0                                       | 0                                       | Case Namber   |
| 8.0     | Current.Layers   | INT    | 0                                       | 9                                       | Number of Layers per Stack  |
| 10.0    | Current.IngotsInMould  | INT    | 0                                       | 0                                       | Ingots Counted Through the Dropout                                |
| 12.0    | Current.IngotsInModId  | INT    | 0                                       | 0                                       | Ingots Counted Through the Bropout Ingots Knocked Out with Hammer |
|         |  | INT    |   |   |   |
| 14.0    | Current.IngotsStuck  |        | 0                                       | 0                                       | Ingots Stuck in Mould   |
| 16.0    | Current.IncompStackWgt   | INT    | 0                                       | 0                                       | Total Weight of Incomplete Stacks                                 |
| 18.0    | Current.RejectIngotSingle  | INT    | 0                                       | 0                                       | Single ingots rejected  |
| 20.0    | Current.RejectIngotSkew  | INT    | 0                                       | 0                                       | Single ingots rejected Skewed                                     |
| 22.0    | Current.RejectIngotSmall   | INT    | 0                                       | 0                                       | Single Ingots rejected Too Small                                  |
| 24.0    | Current.RejectIngotLarge   | INT    | 0                                       | 0                                       | Single Ingots rejected Too Big                                    |
| 26.0    | Current.RejectIngotLayer   | INT    | 0                                       | 0                                       | Layer ingots rejected   |
| 28.0    | Current.SpareInt01   | INT    | 0                                       | 0                                       |   |
| 30.0    | Current.SpareInt02   | INT    | 0                                       | 0                                       |   |
| 32.0    | Current.SpareInt03   | INT    | 0                                       | 0                                       |   |
| 34.0    | Current.SpareInt04   | INT    | 0                                       | 0                                       |   |
| 36.0    | Current.SpareInt05   | INT    | 0                                       | 0                                       |   |
| 38.0    | Current.MeltID   | DINT   | L#0                                     | L#0                                     | Melt id   |
|         |  |        | * '                                     |   |   |
| 42.0    | Current.TotalWeight  | REAL   | 0.000000e+000                           | 0.000000e+000                           | Total Weight (tonnes)   |
| 46.0    | Current.FeedLaunderDownTime  | REAL   | 0.000000e+000                           | 0.000000e+000                           | Feed Launder Down Time (minutes)                                  |
| 50.0    | Current.CastSpeedAvg   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Average Casting Speed (tonnes/hour)                               |
| 54.0    | Current.CastSpeedMin   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Minimum Casting Speed (tonnes/hour)                               |
| 58.0    | Current.CastSpeedMax   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Maximum Casting Speed (tonnes/hour)                               |
| 62.0    | Current.FeedMetalTempAvg   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Average Feed Launder Metal Temperature (d                         |
|         |  |        |   |   | eq.C)   |
| 66.0    | Current.FeedMetalTempMin   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Minimum Feed Launder Metal Temperature (d                         |
|         |  |        |   |   | eq.C)   |
| 70.0    | Current.FeedMetalTempMax   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Maximum Feed Launder Metal Temperature (d                         |
| 70.0    | Current.reedMetarrempMax   | KEAL   | 0.000000e+000                           | 0.000000000000                          | eq.C)   |
| 7.4.0   | Current.CastCoolWtrFlowZ1Avg   | REAL   | 0.000000e+000                           | 0.000000e+000                           |   |
| 74.0    | Current.CastCoolWtrFloWZlAVg   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Average Casting Cooling Water Zone 1 Flow                         |
|         |  |        |   |   | (litres/min)  |
| 78.0    | Current.CastCoolWtrFlowZ1Min   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Minimum Casting Cooling Water Zone 1 Flow                         |
|         |  |        |   |   | (litres/min)  |
| 82.0    | Current.CastCoolWtrFlowZ1Max   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Maximum Casting Cooling Water Zone 1 Flow                         |
|         |  |        |   |   | (litres/min)  |
| 86.0    | Current.CastCoolWtrFlowZ2Avg   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Average Casting Cooling Water Zone 2 Flow                         |
|         |  |        |   |   | (litres/min)  |
| 90.0    | Current.CastCoolWtrFlowZ2Min   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Minimum Casting Cooling Water Zone 2 Flow                         |
| 30.0    | odilene.odocoodineli iowaliiin   | 11212  | 0.0000000000000000000000000000000000000 | 0.0000000000000000000000000000000000000 | (litres/min)  |
| 94.0    | Current.CastCoolWtrFlowZ2Max   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Maximum Casting Cooling Water Zone 2 Flow                         |
| 34.0    | Current.castcoolwtrriowZzmax   | KEAL   | 0.0000000000000                         | 0.000000e+000                           | (litres/min)  |
| 000     |  |        |   | 0.000000.000                            |   |
| 98.0    | Current.CastCoolWtrSuppTempAvg   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Average Casting Cooling Water Supply Temp                         |
|         |  |        |   |   | erature (deg.C)   |
| 102.0   | Current.CastCoolWtrSuppTempMin   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Minimum Casting Cooling Water Supply Temp                         |
|         |  |        |   |   | erature (deg.C)   |
| 106.0   | Current.CastCoolWtrSuppTempMax   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Maximum Casting Cooling Water Supply Temp                         |
|         |  |        |   |   | erature (deg.C)   |
| 110.0   | Current.CastCoolWtrTankTempAvq   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Average Casting Cooling Water Tank Temper                         |
|         |  |        |   |   | ature Average (deg.C)   |
| 114.0   | Current.CastCoolWtrTankTempMin   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Minimum Casting Cooling Water Tank Temper                         |
| 111.0   | Jarrane. Jarrane i da la constitución de la constit | 1,777  |   | 0.000000000000                          | ature Minimum (deg.C)   |
| 118.0   | Current.CastCoolWtrTankTempMax   | REAL   | 0.000000e+000                           | 0.000000e+000                           | Maximum Casting Cooling Water Tank Temper                         |
| 110.0   | Current.CastCoolwtriankTempMax   | KEAL   | 0.000000e+000                           | 0.000000e+000                           |   |
|         |  |        |   |   | ature Maximum (deg.C)   |
| 122.0   | Current.CoolCabWtrFlowAvg  | REAL   | 0.000000e+000                           | 6.381920e-001                           | Average Cooling Cabinet Water Flow (litre                         |
|         |  |        |   |   | s/min)  |
| 126.0   | Current.CoolCabWtrFlowMin  | REAL   | 0.000000e+000                           | 0.000000e+000                           | Minimum Cooling Cabinet Water Flow (litre                         |
|         |  |        |   |   | s/min)  |
| 130.0   | Current.CoolCabWtrFlowMax  | REAL   | 0.000000e+000                           | 2.278646e+000                           | Maximum Cooling Cabinet Water Flow (litre                         |
|         |  |        |   |   | s/min)  |
| 134.0   | Current.CoolCabWtrTempAvg  | REAL   | 0.000000e+000                           | 1.381922e+001                           | Average Cooling Cabinet Water Temperature                         |
| 101.0   |  |        |   | 1.0010220,001                           | (deq.C)   |
| 138.0   | Current.CoolCabWtrTempMin  | REAL   | 0.000000e+000                           | 0.000000e+000                           | Minimum Cooling Cabinet Water Temperature                         |
| 130.0   | Carrenc.coorcapwcrrempMin  | IVEAT. | 0.000000e+000                           | 0.0000000000000000000000000000000000000 |   |
| 142.0   | Current Cool Cabit - TM  | DEAT   | 0.000000e+000                           | 1.467014e+001                           | (deg.C)   |
| 142.U   | Current.CoolCabWtrTempMax  | REAL   | 0.000000e+000                           | 1.40/0140+001                           | Maximum Cooling Cabinet Water Temperature                         |
|         |  |        |   |   | (deg.C)   |
| 146.0   | Current.SpareReal01  | REAL   | 0.000000e+000                           | 0.000000e+000                           |   |
| 150.0   | Current.SpareReal02  | REAL   | 0.000000e+000                           | 0.000000e+000                           |   |
| 1 100.0 | carrenc.shareveging  | WEAT   | 0.000000e+000                           | 0.000000e+000                           |   |

09/24/2015 09:54:34 AM

| Address | Name   | Type          | Initial value                           | Actual value                            | Comment   |
|---------|--|---------------|---|---|---|
| 154.0   | Current.SpareReal03                            | REAL          | 0.000000e+000                           | 0.000000e+000                           | Commerce  |
| 158.0   | Current.ProductName                            | STRING [ 40 ] | 11                                      | 11                                      | Product Name  |
| 200.0   | Previous.DataReady                             | BOOL          | FALSE                                   | FALSE                                   | Batch Data Complete (1=Yes)                                     |
| 202.0   | Previous.FurnaceNum                            | INT           | 0                                       | 0                                       | Furnace Number  |
| 204.0   | Previous.CastNum                               | INT           | 0                                       | 0                                       | Cast Number   |
| 206.0   | Previous.TotalStacks                           | INT           | 0                                       | 0                                       |   |
| 208.0   | Previous.Layers                                | INT           | 0                                       | 0                                       | Number of Layers per Stack                                      |
| 210.0   | Previous.IngotsInMould                         | INT           | 0                                       | 0                                       | Ingots Counted Through the Dropout                              |
| 212.0   | Previous.IngotsKnockedOut Previous.IngotsStuck | INT           | 0                                       | 0                                       | Ingots Knocked Out with Hammer Ingots Stuck in Mould            |
| 214.0   | Previous.Ingotsstuck Previous.IncompStackWgt   | INT           | 0                                       | 0                                       | Total Weight of Incomplete Stacks                               |
| 218.0   | Previous.RejectIngotSingle                     | INT           | 0                                       | 0                                       | Single ingots rejected  |
| 220.0   | Previous.RejectIngotSkew                       | INT           | 0                                       | 0                                       | Single ingots rejected Skewed                                   |
| 222.0   | Previous.RejectIngotSmall                      | INT           | 0                                       | 0                                       | Single Ingots rejected Too Small                                |
| 224.0   | Previous.RejectIngotLarge                      | INT           | 0                                       | 0                                       | Single Ingots rejected Too Big                                  |
| 226.0   | Previous.RejectIngotLayer                      | INT           | 0                                       | 0                                       | Layer ingots rejected   |
| 228.0   | Previous.SpareInt01                            | INT           | 0                                       | 0                                       |   |
| 230.0   | Previous.SpareInt02                            | INT           | 0                                       | 0                                       |   |
| 232.0   | Previous.SpareInt03 Previous.SpareInt04        | INT           | 0                                       | 0                                       |   |
| 234.0   | Previous.SpareInt05                            | INT           | 0                                       | 0                                       |   |
| 238.0   | Previous.MeltID                                | DINT          | L#0                                     | L#0                                     | Melt id   |
| 242.0   | Previous.TotalWeight                           | REAL          | 0.000000e+000                           | 0.000000e+000                           | Total Weight (tonnes)   |
| 246.0   | Previous.FeedLaunderDownTime                   | REAL          | 0.000000e+000                           | 0.000000e+000                           | Feed Launder Down Time (minutes)                                |
| 250.0   | Previous.CastSpeedAvg                          | REAL          | 0.000000e+000                           | 0.000000e+000                           | Average Casting Speed (tonnes/hour)                             |
| 254.0   | Previous.CastSpeedMin                          | REAL          | 0.000000e+000                           | 0.000000e+000                           | Minimum Casting Speed (tonnes/hour)                             |
| 258.0   | Previous.CastSpeedMax                          | REAL          | 0.000000e+000                           | 0.000000e+000                           | Maximum Casting Speed (tonnes/hour)                             |
| 262.0   | Previous.FeedMetalTempAvg                      | REAL          | 0.000000e+000                           | 0.000000e+000                           | Average Feed Launder Metal Temperature (d                       |
|         |  |               |   |   | eg.C)   |
| 266.0   | Previous.FeedMetalTempMin                      | REAL          | 0.000000e+000                           | 0.000000e+000                           | Minimum Feed Launder Metal Temperature (d                       |
| 270.0   | Previous.FeedMetalTempMax                      | REAL          | 0.000000e+000                           | 0.000000e+000                           | eg.C)  Maximum Feed Launder Metal Temperature (d                |
| 270.0   | rievious.reedMetailempMax                      | KEAL          | 0.000000000                             | 0.0000000000000000000000000000000000000 | eq.C)   |
| 274.0   | Previous.CastCoolWtrFlowZ1Avg                  | REAL          | 0.000000e+000                           | 0.000000e+000                           | Average Casting Cooling Water Zone 1 Flow                       |
|         |  |               |   |   | (litres/min)  |
| 278.0   | Previous.CastCoolWtrFlowZ1Min                  | REAL          | 0.000000e+000                           | 0.000000e+000                           | Minimum Casting Cooling Water Zone 1 Flow                       |
|         |  |               |   |   | (litres/min)  |
| 282.0   | Previous.CastCoolWtrFlowZ1Max                  | REAL          | 0.000000e+000                           | 0.000000e+000                           | Maximum Casting Cooling Water Zone 1 Flow                       |
|         |  |               |   |   | (litres/min)  |
| 286.0   | Previous.CastCoolWtrFlowZ2Avg                  | REAL          | 0.000000e+000                           | 0.000000e+000                           | Average Casting Cooling Water Zone 2 Flow                       |
| 290.0   | Previous.CastCoolWtrFlowZ2Min                  | REAL          | 0.000000e+000                           | 0.000000e+000                           | (litres/min)  Minimum Casting Cooling Water Zone 2 Flow         |
| 290.0   | Previous.CastCoolWtrFloWZZMin                  | KEAL          | 0.000000e+000                           | 0.000000e+000                           | (litres/min)  |
| 294.0   | Previous.CastCoolWtrFlowZ2Max                  | REAL          | 0.000000e+000                           | 0.000000e+000                           | Maximum Casting Cooling Water Zone 2 Flow                       |
| 231.0   | TICVIOUS.CUSCOOTWCIIIOWZZNAX                   | TUBLIE        | 0.0000000000000000000000000000000000000 | 0.00000001000                           | (litres/min)  |
| 298.0   | Previous.CastCoolWtrSuppTempAvq                | REAL          | 0.000000e+000                           | 0.000000e+000                           | Average Casting Cooling Water Supply Temp                       |
|         |  |               |   |   | erature (deg.C)   |
| 302.0   | Previous.CastCoolWtrSuppTempMin                | REAL          | 0.000000e+000                           | 0.000000e+000                           | Minimum Casting Cooling Water Supply Temp                       |
|         |  |               |   |   | erature (deg.C)   |
| 306.0   | Previous.CastCoolWtrSuppTempMax                | REAL          | 0.000000e+000                           | 0.000000e+000                           | Maximum Casting Cooling Water Supply Temp                       |
| 210 0   | D ' C 10 177                                   | DEST          | 0.000000.000                            | 0.000000e+000                           | erature (deg.C)   |
| 310.0   | Previous.CastCoolWtrTankTempAvg                | REAL          | 0.000000e+000                           | 0.000000e+000                           | Average Casting Cooling Water Tank Temper ature Average (deg.C) |
| 314.0   | Previous.CastCoolWtrTankTempMin                | REAL.         | 0.000000e+000                           | 0.000000e+000                           | Minimum Casting Cooling Water Tank Temper                       |
| 311.0   | Trevious.cusecoorwer runk rempilin             | TUBLIE        | 0.0000000000000000000000000000000000000 | 0.00000001000                           | ature Minimum (deg.C)   |
| 318.0   | Previous.CastCoolWtrTankTempMax                | REAL          | 0.000000e+000                           | 0.000000e+000                           | Maximum Casting Cooling Water Tank Temper                       |
|         | _  |               |   |   | ature Maximum (deg.C)   |
| 322.0   | Previous.CoolCabWtrFlowAvg                     | REAL          | 0.000000e+000                           | 0.000000e+000                           | Average Cooling Cabinet Water Flow (litre                       |
|         |  |               |   |   | s/min)  |
| 326.0   | Previous.CoolCabWtrFlowMin                     | REAL          | 0.000000e+000                           | 0.000000e+000                           | Minimum Cooling Cabinet Water Flow (litre                       |
| 330.0   | D '  | REAL          | 0.000000e+000                           | 0.000000e+000                           | s/min)  Maximum Cooling Cabinet Water Flow (litre               |
| 330.0   | Previous.CoolCabWtrFlowMax                     | KEAL          | 0.000000e+000                           | 0.000000e+000                           | s/min)  |
| 334.0   | Previous.CoolCabWtrTempAvg                     | REAL          | 0.000000e+000                           | 0.000000e+000                           | Average Cooling Cabinet Water Temperature                       |
|         |  |               |   |   | (deg.C)   |
| 338.0   | Previous.CoolCabWtrTempMin                     | REAL          | 0.000000e+000                           | 0.000000e+000                           | Minimum Cooling Cabinet Water Temperature                       |
|         |  |               |   |   | (deg.C)   |
| 342.0   | Previous.CoolCabWtrTempMax                     | REAL          | 0.000000e+000                           | 0.000000e+000                           | Maximum Cooling Cabinet Water Temperature                       |
|         |  |               |   |   | (deg.C)   |
| 346.0   | Previous.SpareReal01                           | REAL          | 0.000000e+000                           | 0.000000e+000                           |   |
| 350.0   | Previous.SpareReal02                           | REAL          | 0.000000e+000                           | 0.000000e+000                           |   |
| 354.0   | Previous.SpareReal03                           | REAL          | 0.000000e+000                           | 0.000000e+000                           | Draduct Name  |
| 358.0   | Previous.ProductName                           | STRING [ 40 ] | I                                       | 1 1 1                                   | Product Name  |