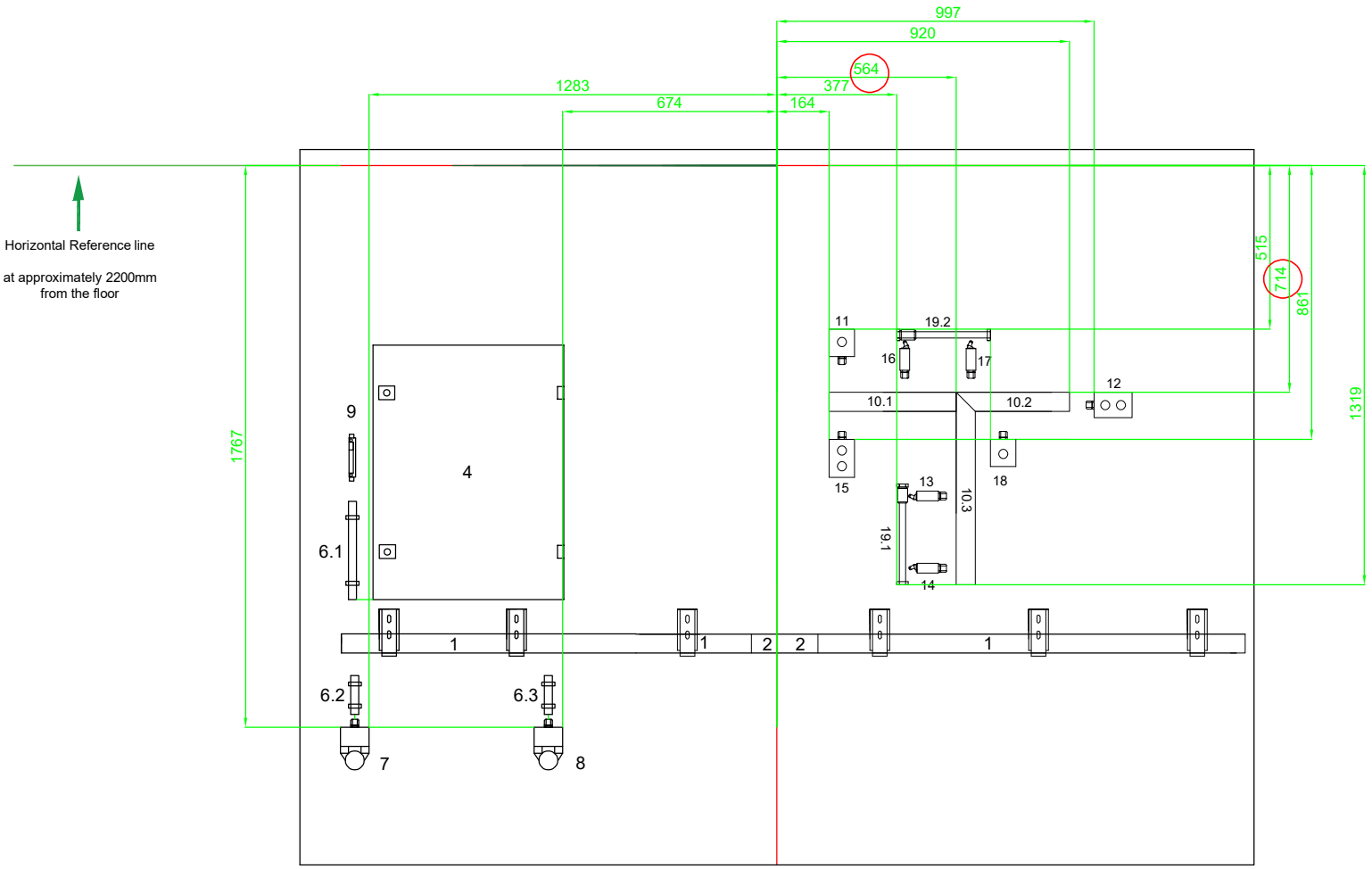


1. mesh tray horizontal
2. 90°bend for mesh tray
3. metal vertical ladder
4. control box 1 (800x600mm)
6. plastic tubeVR25
7. CEE socket(X6)
8. CEE socket(X7)
9. protective earth terminal (-X8)
10. wall duct (60*60)
11. housing (P14)
12. housing (P10,P11)
13. limit switch (S10)
14. limit switch (S11)
15. housing (P12,P13)
16. limit switch (S12)
17. limit switch (S13)
18. housing (R2)
19. metal pipe ISO25

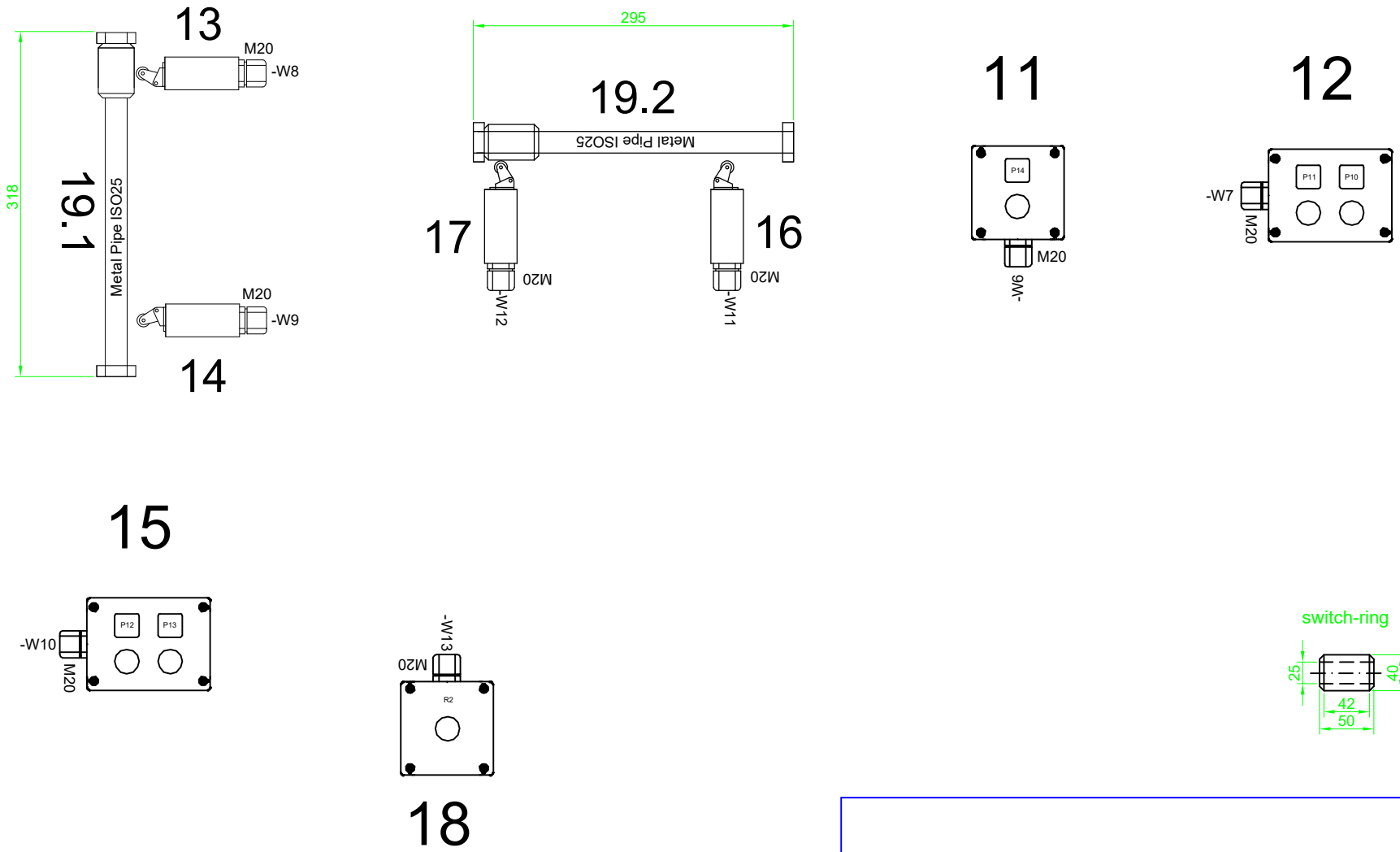
WALL INSTALLATION NOT IN SCALE

* All measurements from a horizontal and vertical line ap 10 - 30mm from the end of the booth.

All devices, which are not in the mesuarements, the mounting is up to the competitor

Dynamic part of the installation.
The measurements or measurement of item rounded by circle could be changed by lots

Skill: SKILL			
Scale: SCALE	Date: DATE	Paper: PAPER	
Drawn / Design by: DRAWN_DESIGN_BY		Drawing No: DRAWING_NO	
Description: DESCRIPTION DESCRIPTION_LINE_2		Rev: REV	Page: PAGE



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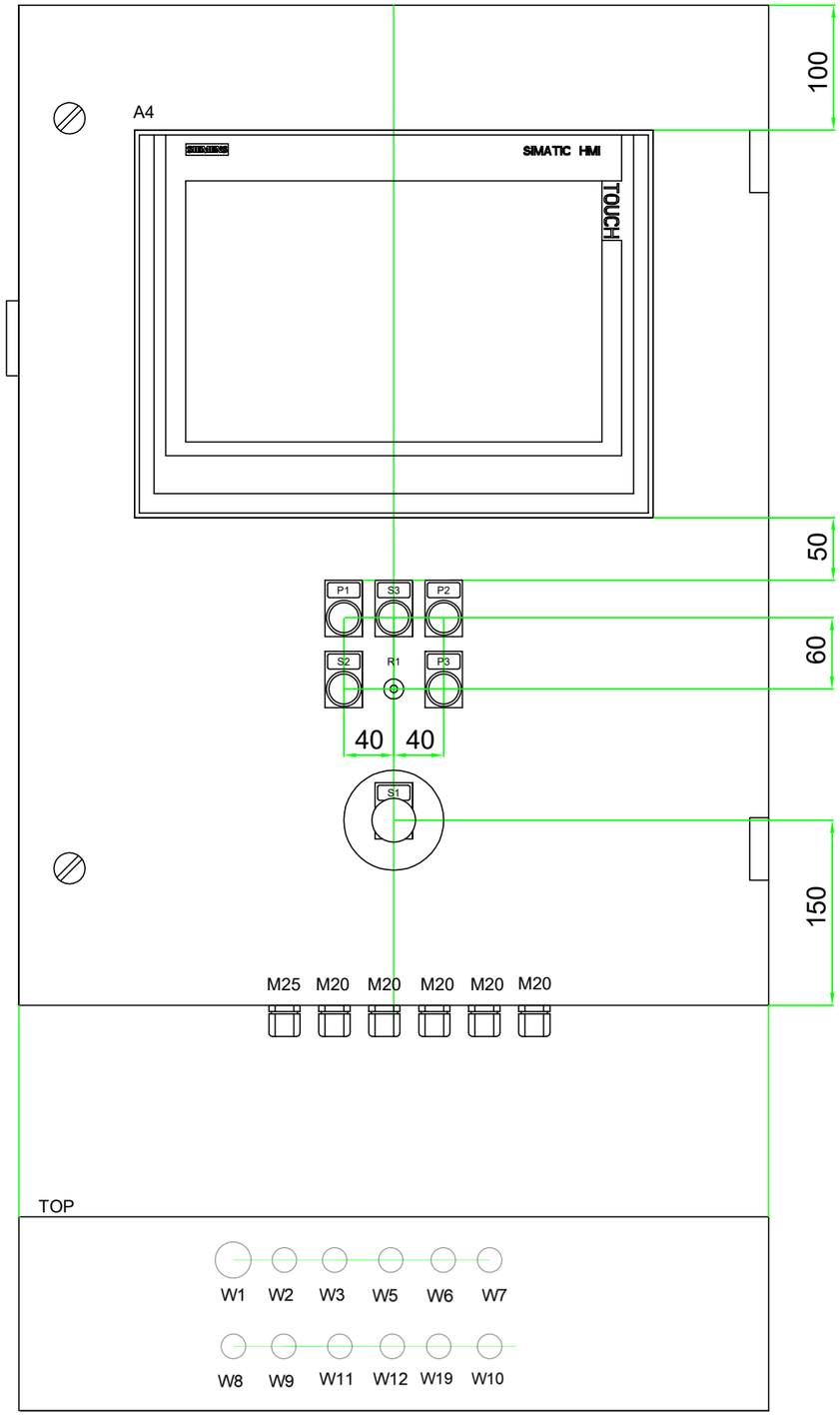

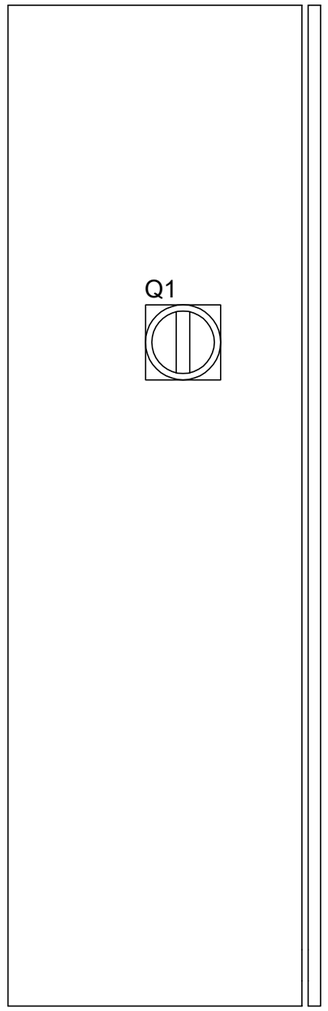

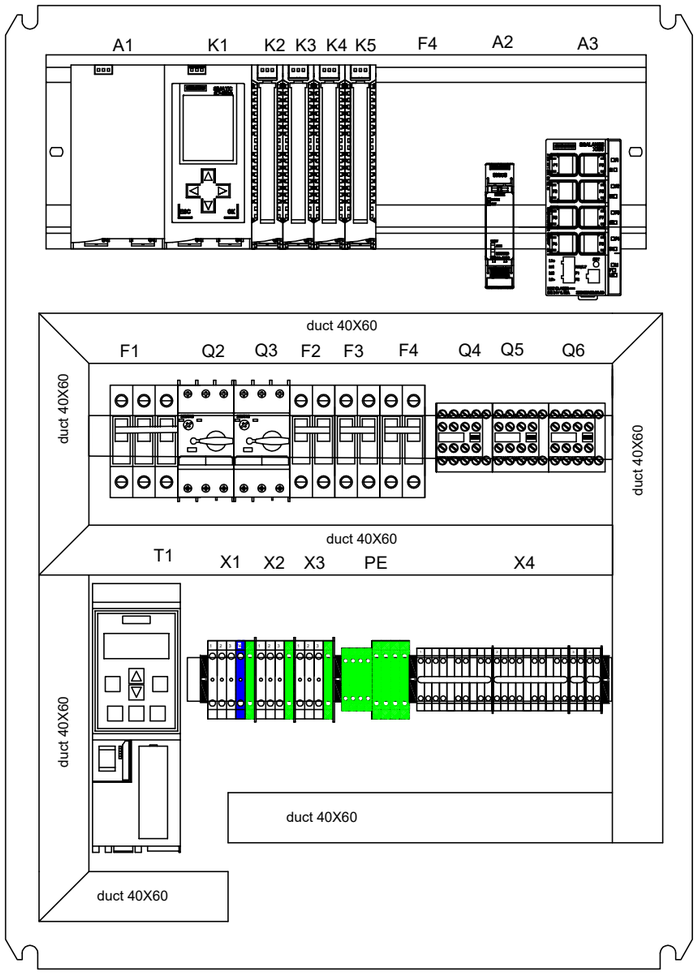

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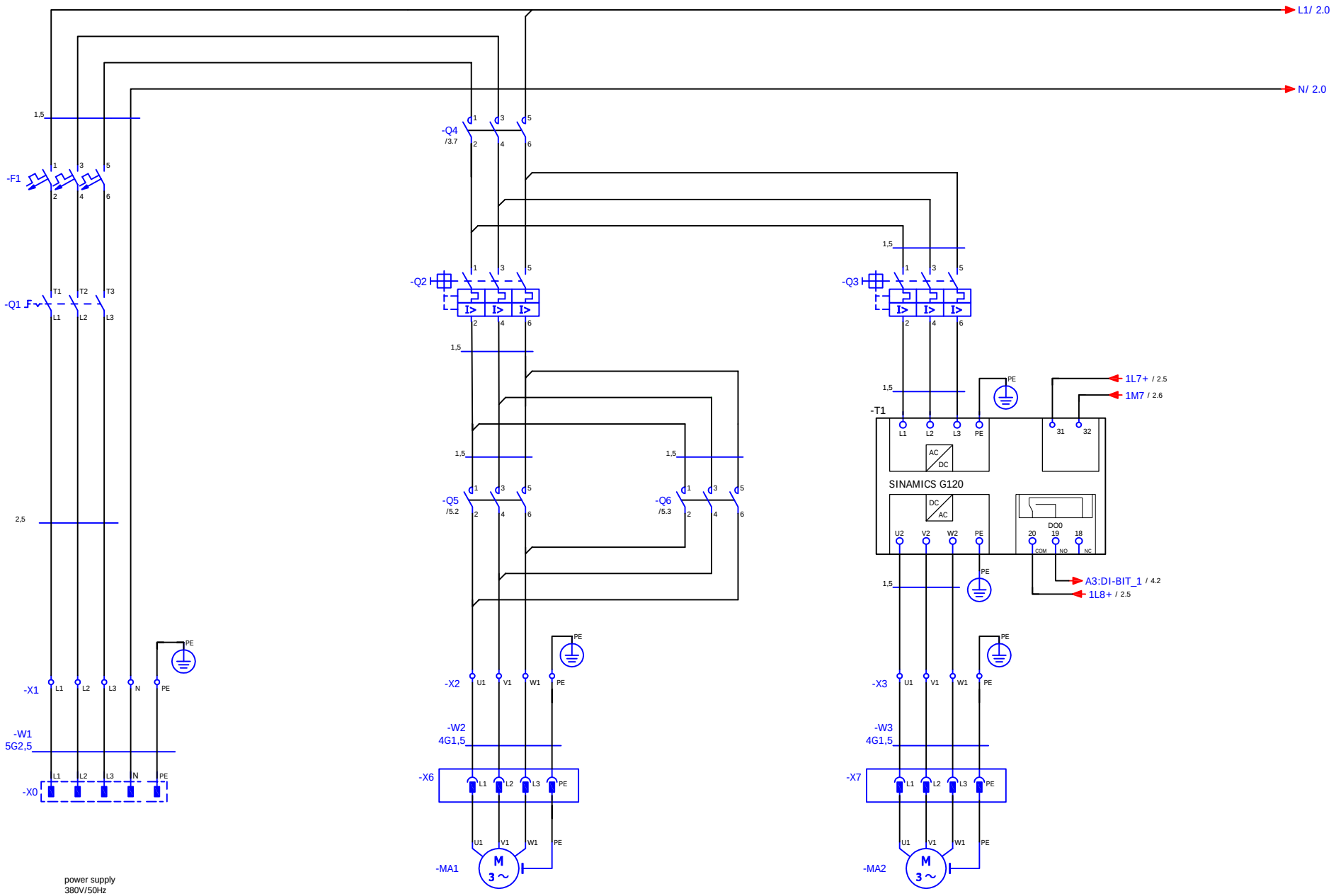
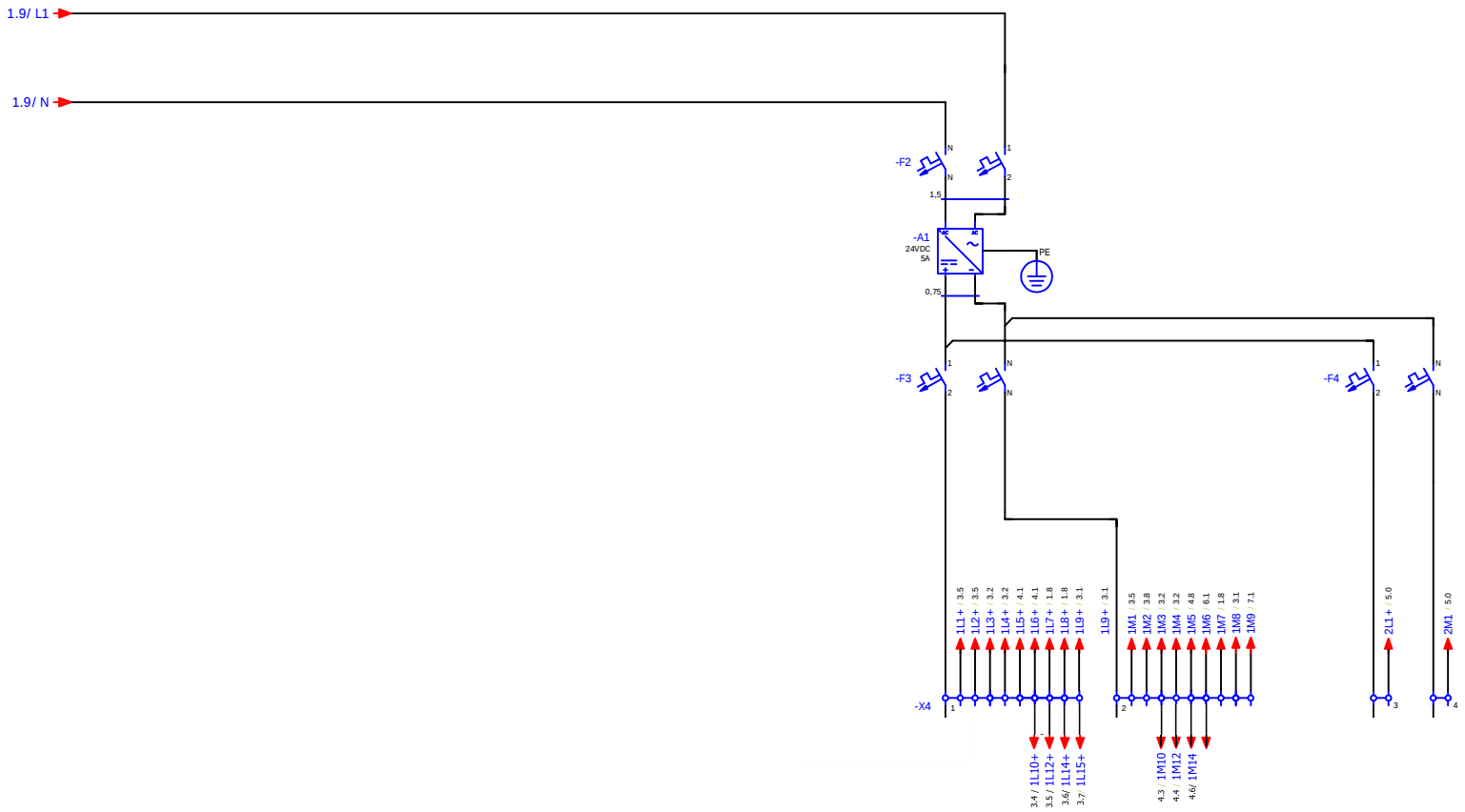
Description: DESCRIPTION DESCRIPTION_LINE_2			Rev: REV / Page: PAGE
			Appd: APPROVED_BY / Sign:



			Datum				Main Circuit		=	
			Bearb.						+	
			Gepr							Blatt 1
Änderung	Datum	Name	Urspr		Ersatz von	Ersetzt durch				Blatt 8

2

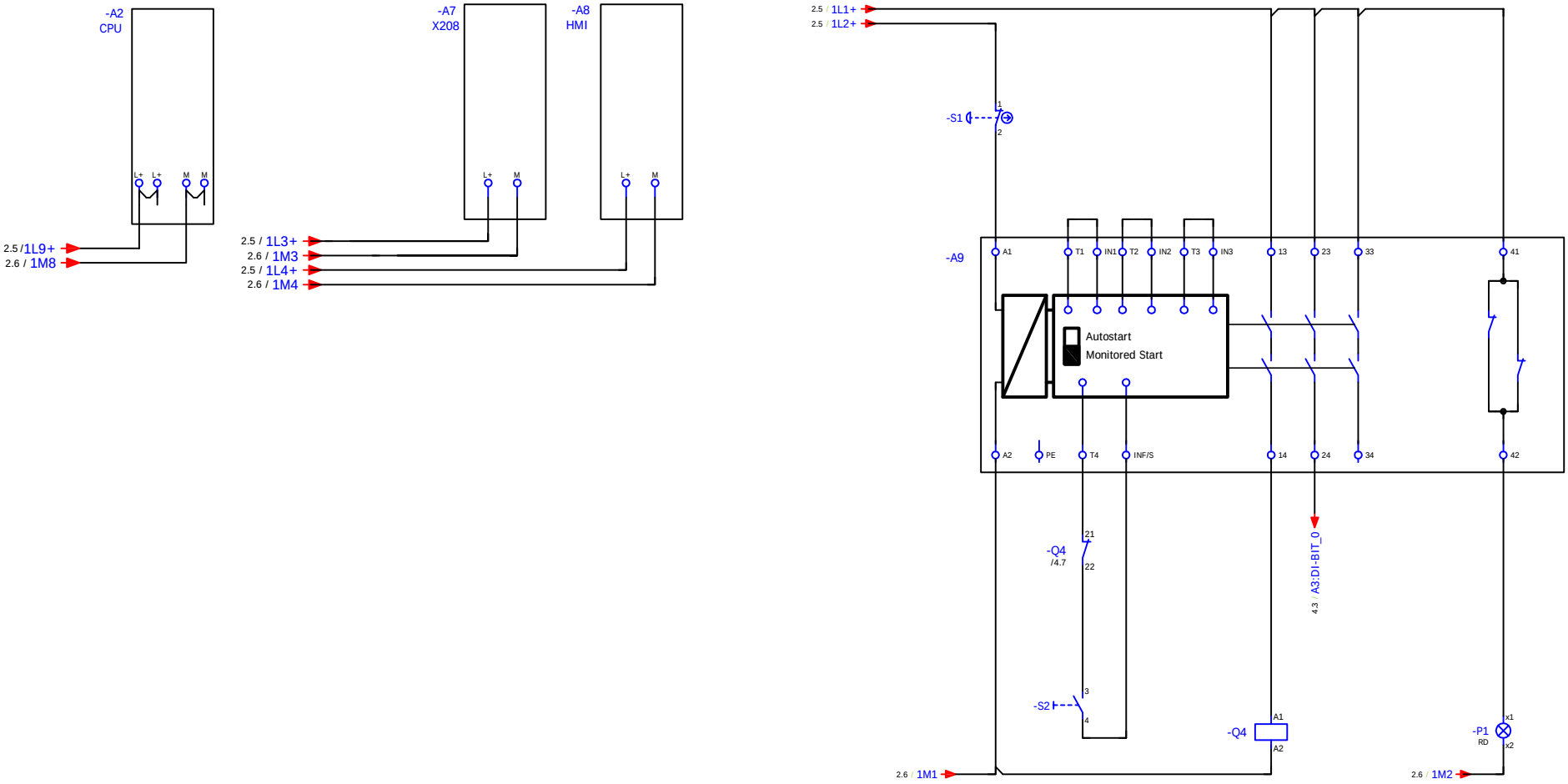


1 3

			Datum			
			Bearb.			
			Gepr			
Änderung	Datum	Name	Urspr		Ersatz von	Ersetzt durch

Control Circuit

Blatt 2
Blatt 8



Power supply 24V DC

Emergency stop relay

signal lamp
emergency stop

2

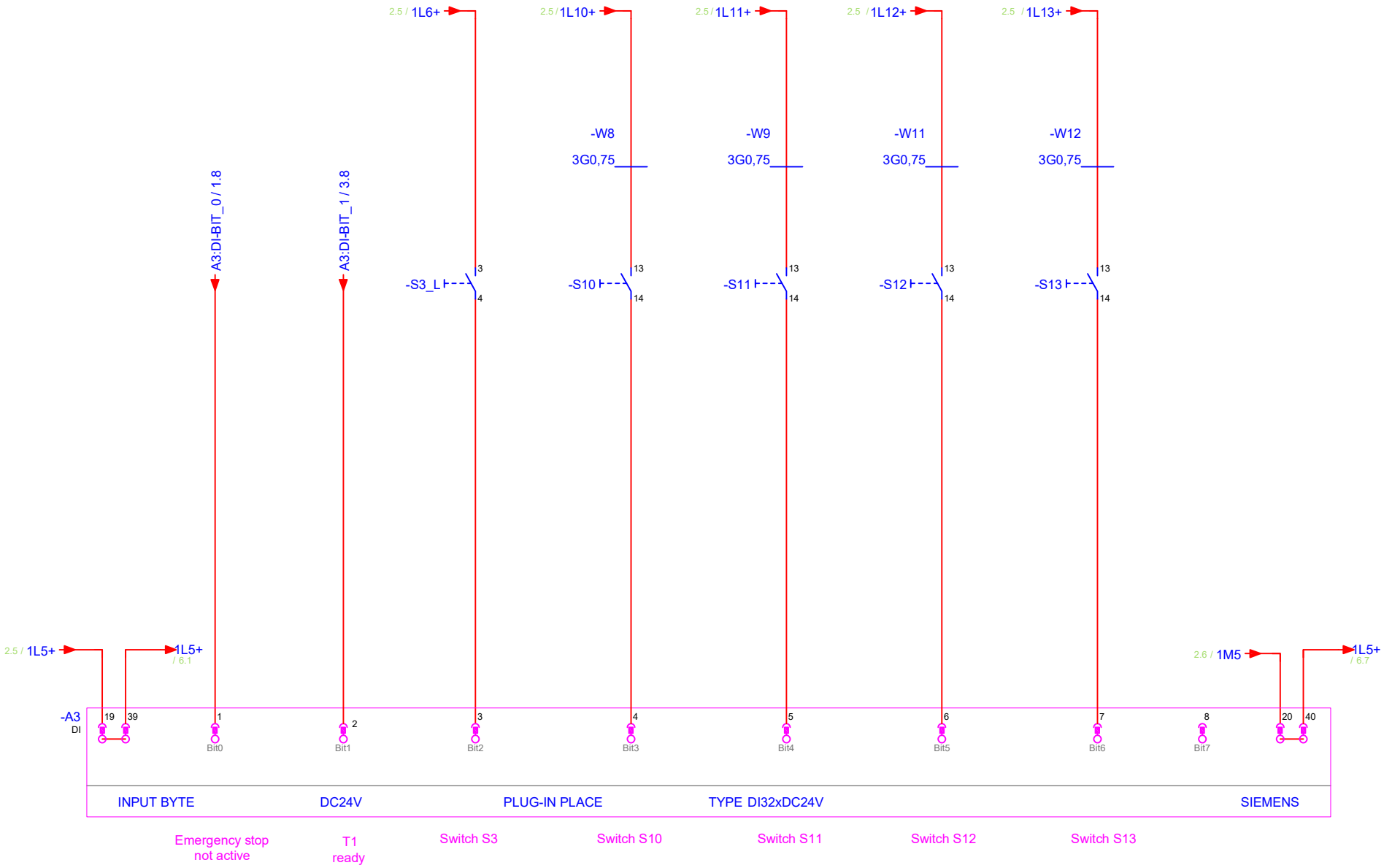
4

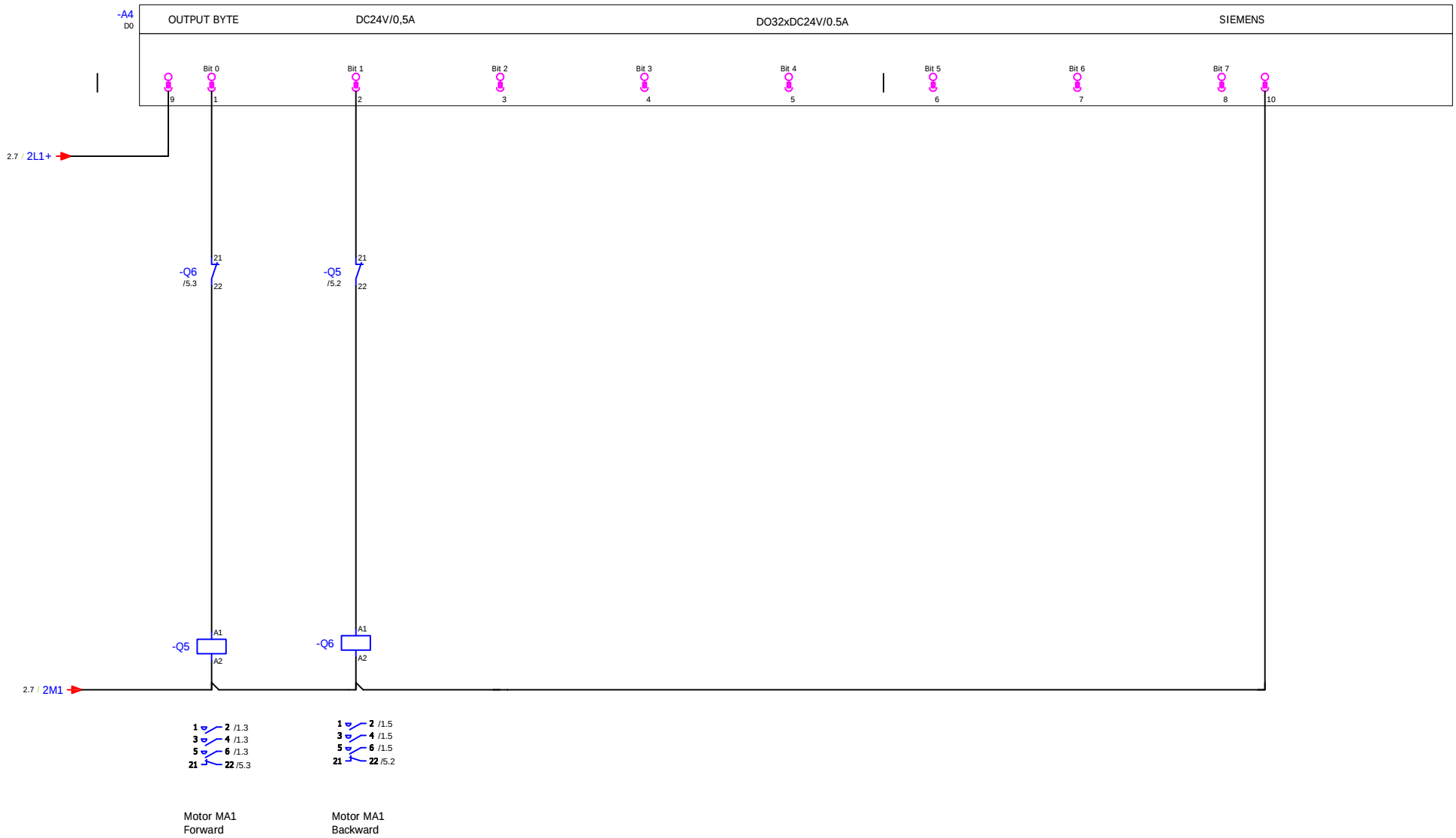
Änderung	Datum	Name	Datum Bearb. Gepr Urspr		Ersatz von	Ersetzt durch

Control Circuit

=
+

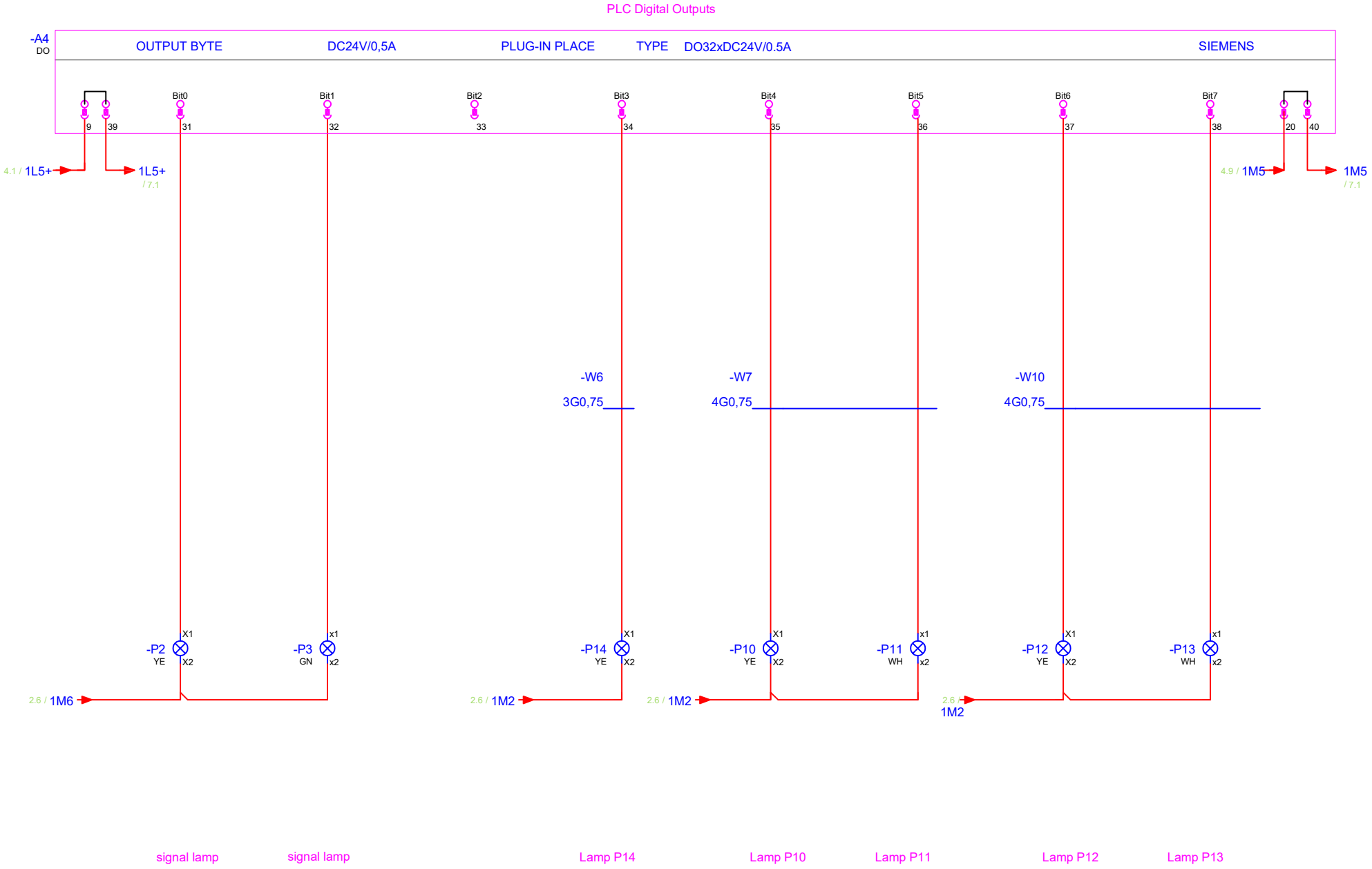
Blatt 3
Blatt 8

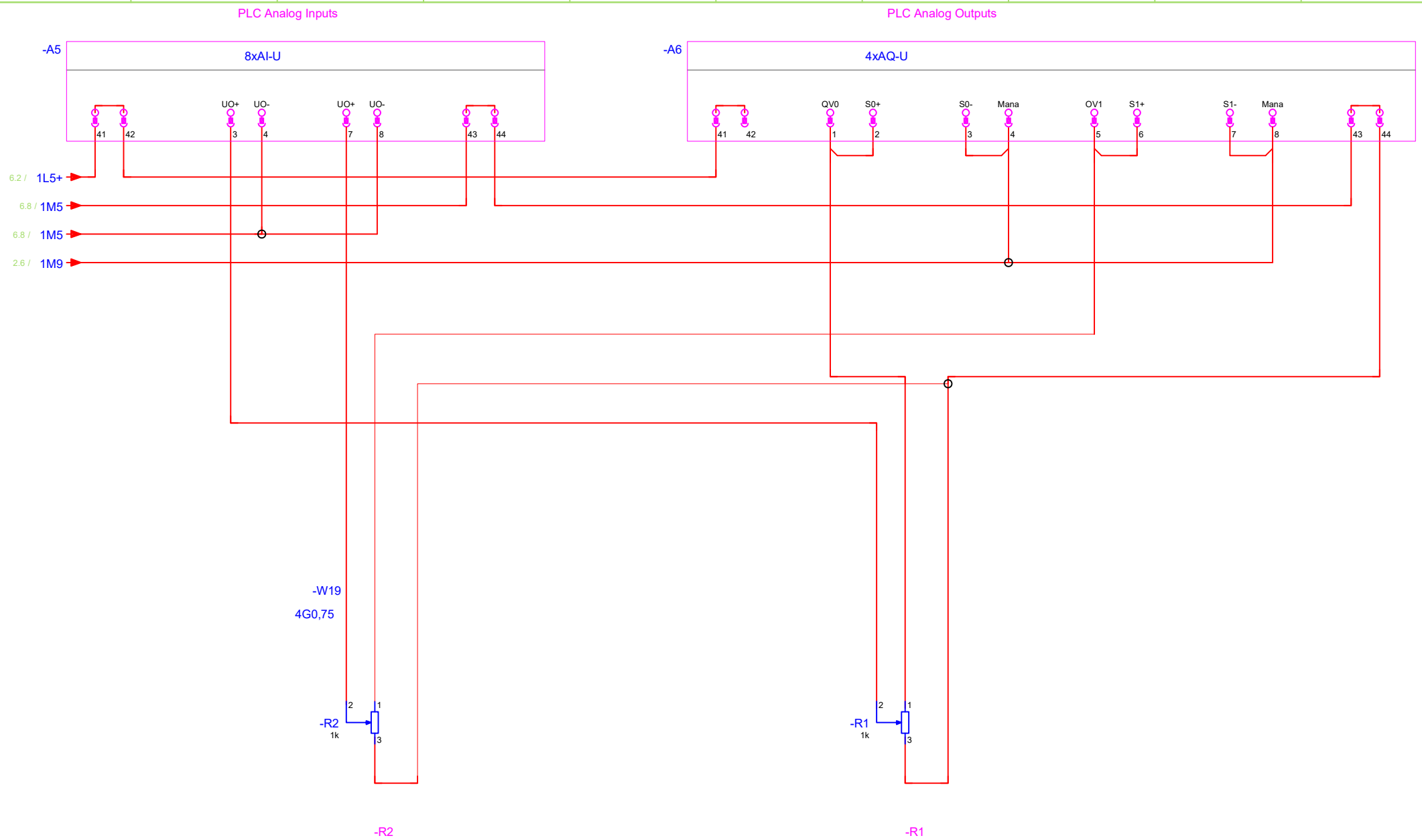

2.5 / 1L6+
2.5 / 1L10+
2.5 / 1L11+
2.5 / 1L12+
2.5 / 1L13+
-W8
3G0,75
-W9
3G0,75
-W11
3G0,75
-W12
3G0,75
A3:DI-BIT_0 / 1.8
A3:DI-BIT_1 / 3.8
-S3_L
-S10
-S11
-S12
-S13
2.5 / 1L5+
1L5+
/ 6.1
2.6 / 1M5
1L5+
/ 6.7
-A3
DI
Bit0
Bit1
Bit2
Bit3
Bit4
Bit5
Bit6
Bit7
INPUT BYTE
DC24V
PLUG-IN PLACE
TYPE DI32xDC24V
SIEMENS
Emergency stop
not active
T1
ready
Switch S3
Switch S10
Switch S11
Switch S12
Switch S13



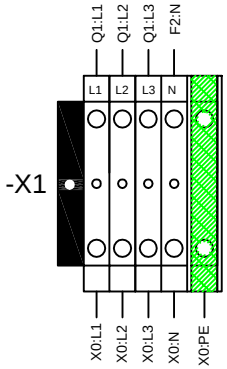
4 6

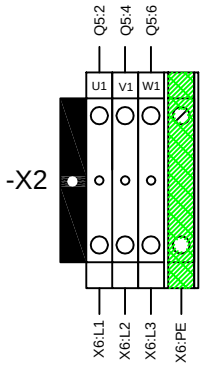
			Datum				Control Circuit	=
			Bearb.					+
			Gepr					Blatt 5
Änderung	Datum	Name	Urspr		Ersatz von	Ersetzt durch		Blatt 8

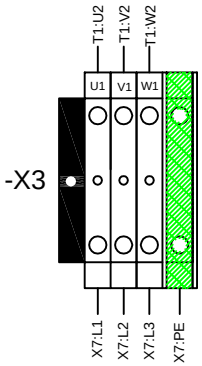

PLC Digital Outputs
-A4
DO
OUTPUT BYTE
DC24V/0,5A
PLUG-IN PLACE
TYPE
DO32xDC24V/0.5A
SIEMENS
Bit0
Bit1
Bit2
Bit3
Bit4
Bit5
Bit6
Bit7
9
39
31
32
33
34
35
36
37
38
20
40
4.1 / 1L5+
1L5+
/ 7.1
4.9 / 1M5
1M5
/ 7.1
-W6
3G0,75
-W7
4G0,75
-W10
4G0,75
-P2
YE
X1
X2
-P3
GN
x1
x2
-P14
YE
-P10
YE
-P11
WH
-P12
YE
-P13
WH
2.6 / 1M6
2.6 / 1M2
2.6 / 1M2
2.6 / 1M2
signal lamp
Manual Mode
signal lamp
Automatic Mode
Lamp P14
Lamp P10
Lamp P11
Lamp P12
Lamp P13

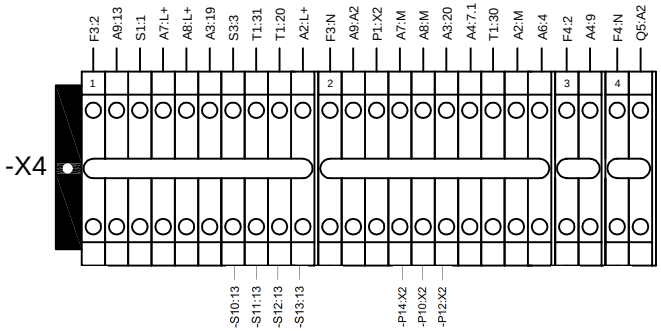


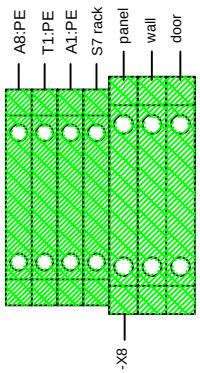
			Date				Control Circuit		=	
			Proofreading						+	
			Audit							Page 8
Modify	Datum	Name	Urspr		Replaced by	Replaced by				Page 8 / 8



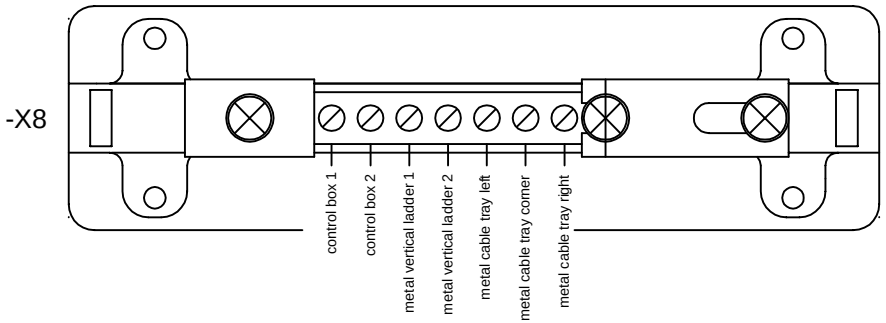








-PE
control box 1



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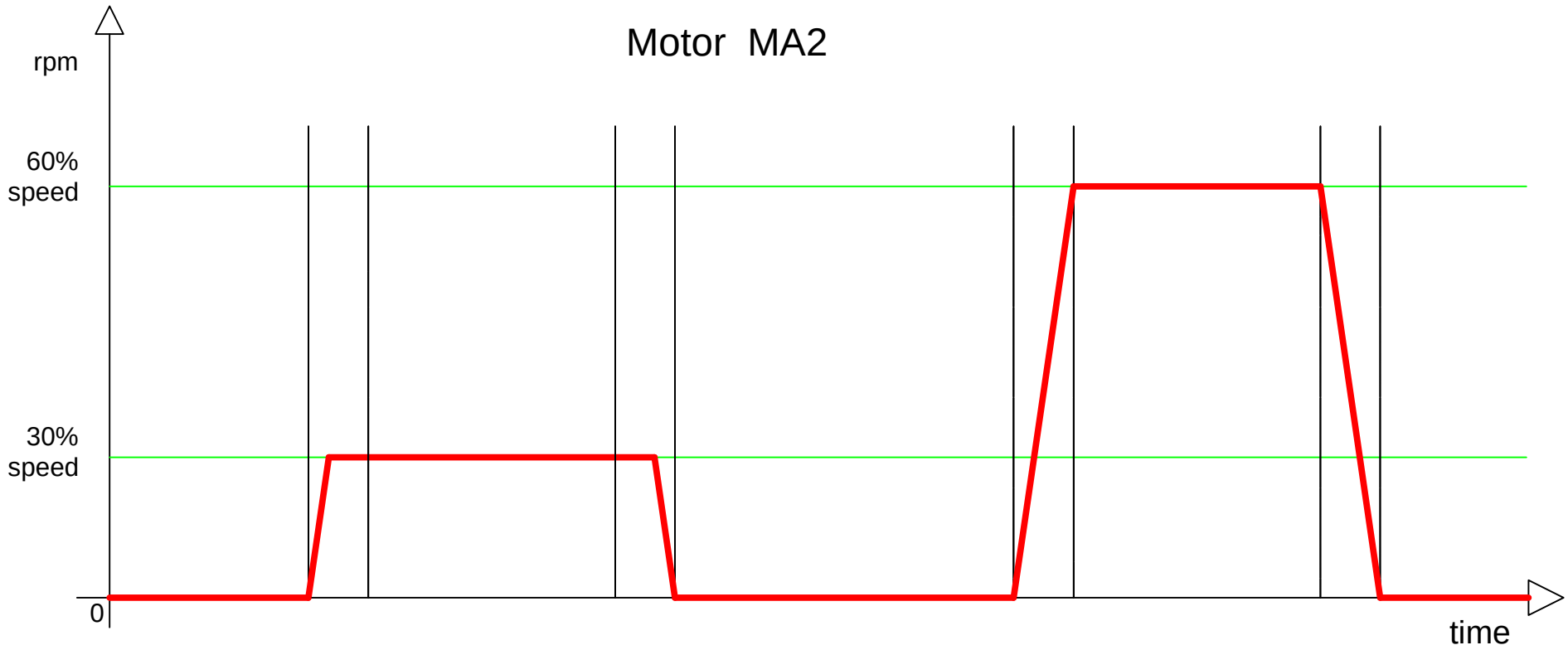
Scale: SCALE	Date: DATE	Paper: PAPER	
Drawn / Design by: DRAWN_DESIGN_BY		Drawing No: DRAWING_NO	
Description: DESCRIPTION		Rev: REV	Page: PAGE
DESCRIPTION_LINE_2		Appd: APPROVED_BY	Sign:



The changes in speed and the 0-speed will be reached in 3 seconds. The ramps must be programmed in the frequency converter.

Skill: SKILL			
Scale: SCALE	Date: DATE	Paper: PAPER	
Drawn / Design by: DRAWN_DESIGN_BY		Drawing No: DRAWING_NO	
Description: DESCRIPTION		Rev: REV	Page: PAGE
DESCRIPTION_LINE_2		Appd: APPROVED_BY	Sign:

CABLE LIST

Nr.	Cable type	intern		extern	Description
W1	RVV-5G2,5	X1	------>	X0	Power Supply 3x400V+N+PE
W2	RVV-4G1,5	X2	------>	X6	CEE socket 400V (MA1)
W3	RVV-4G1,5	X3	------>	X7	CEE socket 400V (MA2)
W5	RV-6	PE	------>	X8	protective earth terminal
W6	RVV-3G0,75	S7-1500	------>	P14	Signal lamp
W7	RVV-4G0,75	S7-1500	------>	P10,P11	Signal lamp
W8	RVV-3G0,75	S7-1500	------>	S10	Limit switch
W9	RVV-3G0,75	S7-1500	------>	S11	Limit switch
W10	RVV-4G0,75	S7-1500	------>	P12,P13	Signal lamp
W11	RVV-3G0,75	S7-1500	------>	S12	Limit switch
W12	RVV-3G0,75	S7-1500	------>	S13	Limit switch
W19	RVV-4G0,75	S7-1500	------>	R2	potentiometer

SAFETY REPORT – COMMISSIONING

Competitor

Name, Province ..... / .....

Booth No.: .....

1. VISUAL INSPECTION:

The visual inspection includes:

☐ Controlbox 1 ☐ Protective earth terminal ☐ Plant installation

2. MEASUREMENT:

2.1 LOW IMPEDANCE TESTING:

Control box 1:

CEE- plug / PE	---	X1/PE	..... Ω
CEE- plug / PE	---	panel	..... Ω
CEE- plug / PE	---	side wall	..... Ω
CEE- plug / PE	---	door	..... Ω
CEE- plug / PE	---	S7-rack	..... Ω
CEE- plug / PE	---	T1/PE	..... Ω
CEE- plug / PE	---	A8/PE (HMI)	..... Ω

Wall Installation:

CEE- plug / PE	---	vertical ladder 1	..... Ω
CEE- plug / PE	---	vertical ladder 2	..... Ω
CEE- plug / PE	---	cable tray right side	..... Ω
CEE- plug / PE	---	cable tray corner	..... Ω
CEE- plug / PE	---	cable tray left side	..... Ω
CEE- plug / PE	---	MOTOR MA1	..... Ω
CEE- plug / PE	---	MOTOR MA2	..... Ω
CEE- plug / PE	---	X8	..... Ω

2.2. ISOLATION MEASUREMENT:

Allowed only in the presence of an expert !!!

Preparations for insulation test:

Competitor must wear safety glasses, long sleeves and insulated electrician gloves during insulation testing and Voltage on test.

Loose all wires that could cause damages for the Automation equipment! Loose motor cable wires at motor side phase wire connectors before call the marking group, After insulation test connect the wires back. These phases happens at competition time.

Before the insulation test, disconnect PLC PSU's, VSD's and MOTOR(-X6 ,-X7)

Main circuit X1 – Power supply:			(write the lowest value)
X1/PE	---	L1, L2, L3, N	..... MΩ
X1/L1, L2, L3,	---	L1, L2, L3, N	..... MΩ
Main circuit X2 –CEE socket X6:			
X2/PE	---	X2/ L1, L2, L3	..... MΩ
X2/L1, L2, L3	---	X2/ L1, L2, L3	..... MΩ
Main circuit X3– CEE socket X7:			
X3/PE	---	X3/ L1, L2, L3	..... MΩ
X3/L1, L2, L3	---	X3/ L1, L2, L3	..... MΩ

SAFETY REPORT – COMMISSIONING

Allowed only in the presence of an expert !!!

2.3. TESTING:RESIDUAL CURRENT DEVICE(RCD) :

☐Function OK	☐ Function not OK

PLUG IN POWER CORD

TURN MAIN POWER ON

SWITCH ON Q1

2.4.VOLTAGE MEASUREMENT---X1:

L1-X1	---	N-X1	 V
L2-X1	---	N-X1	 V
L3-X1	---	N-X1	 V
L1-X1	---	L2-X1	 V
L1-X1	---	L3-X1	 V
L2-X1	---	L3-X1	 V

2.5. ROTATIONAL FIELD MEASUREMENT – X1:

☐ Rotating field is left-handed (CCW)	☐ Rotating field is right-handed (CW)

2.6.CONFIRM THE FUNTION OF Q1, TURN Q1 OFF

L1-F1	---	N-X1	 V
L2-F1	---	N-X1	 V
L3-F1	---	N-X1	 V
L1-F1	---	PE-X1	 V
L2-F1	---	PE-X1	 V
L3-F1	---	PE-X1	 V
L1-F1	---	L2-F1	 V
L1-F1	---	L3-F1	 V
L2-F1	---	L3-F1	 V

Operation of Q1 confirm_____

2.7.SWITCH ON Q1, F1:

Measure Voltage of F2(230V AC)	
☐OK	☐ not OK

2.8.SWITCH ON F2:

☐OK	☐ not OK

2.9.SWITCH ON PLC POWER SUPPLY:

Measure Voltage of F3,F4 (24V DC)	
☐OK	☐ not OK

3.0.SWITCH ON F3,

☐OK	☐ not OK

3.1. EMERGENCY STOP FUNCTION:

☐OK	☐ not OK

3.2. RESET FUNCTION:

☐OK	☐ not OK

3.3.SWITCH ON F4,

☐OK	☐ not OK

3.4. INSTALLATION SAFETY IMPROVED,CHECK COMPLETE:

☐OK	☐ not OK

For the accuracy

_____ _____ _____

Signature by Competitor Signature by Expert C.C.

_____ _____

Signature by Expert C.C.

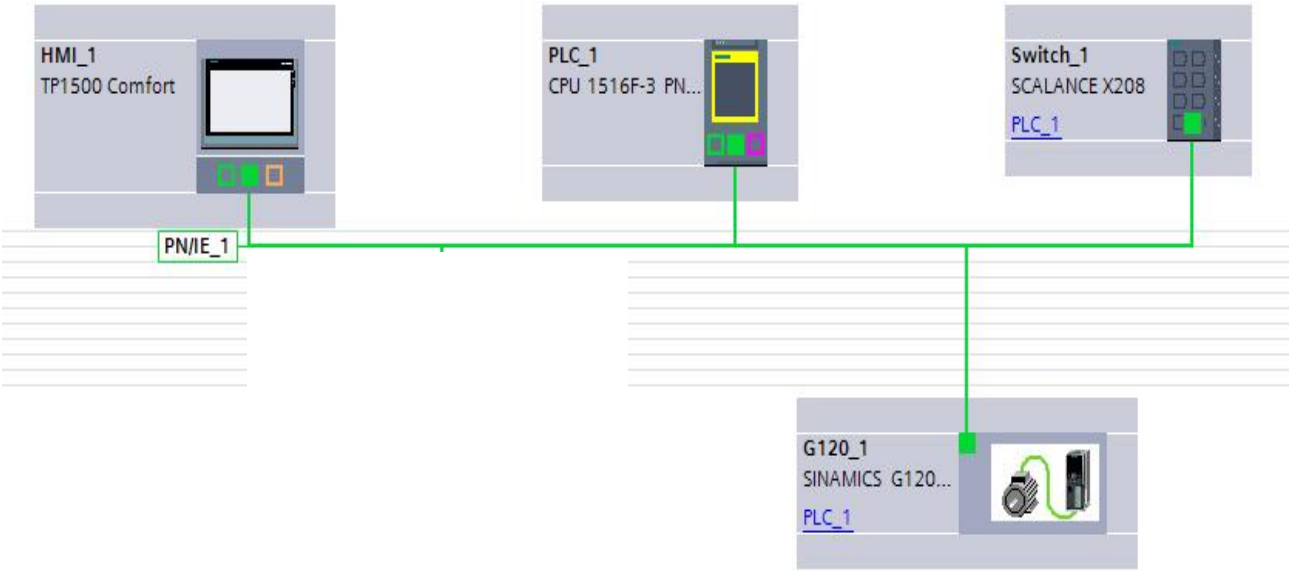
Date: _____ _____ _____

Signature by Expert C.C.

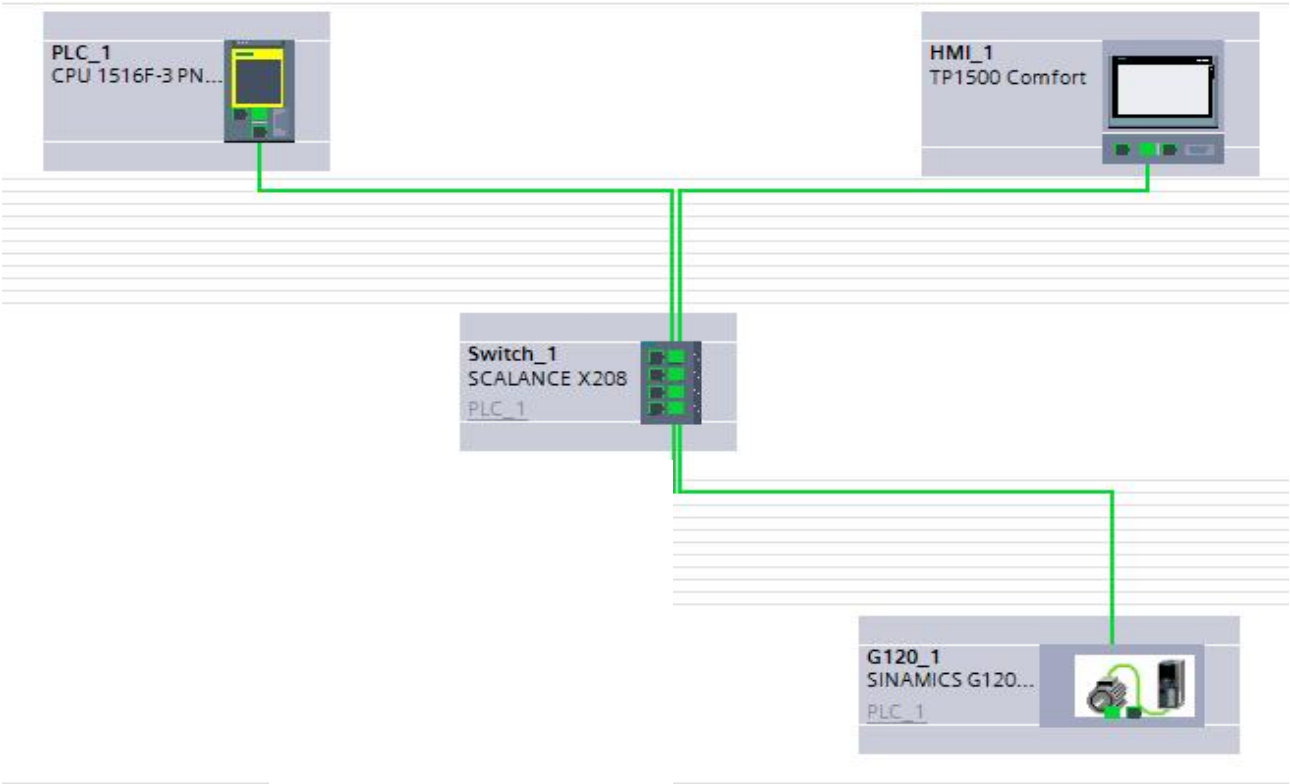
AFTER COMPETITOR'S AND EXPERT'S SIGNATURES COMPETITION TIME STARTS AGAIN.

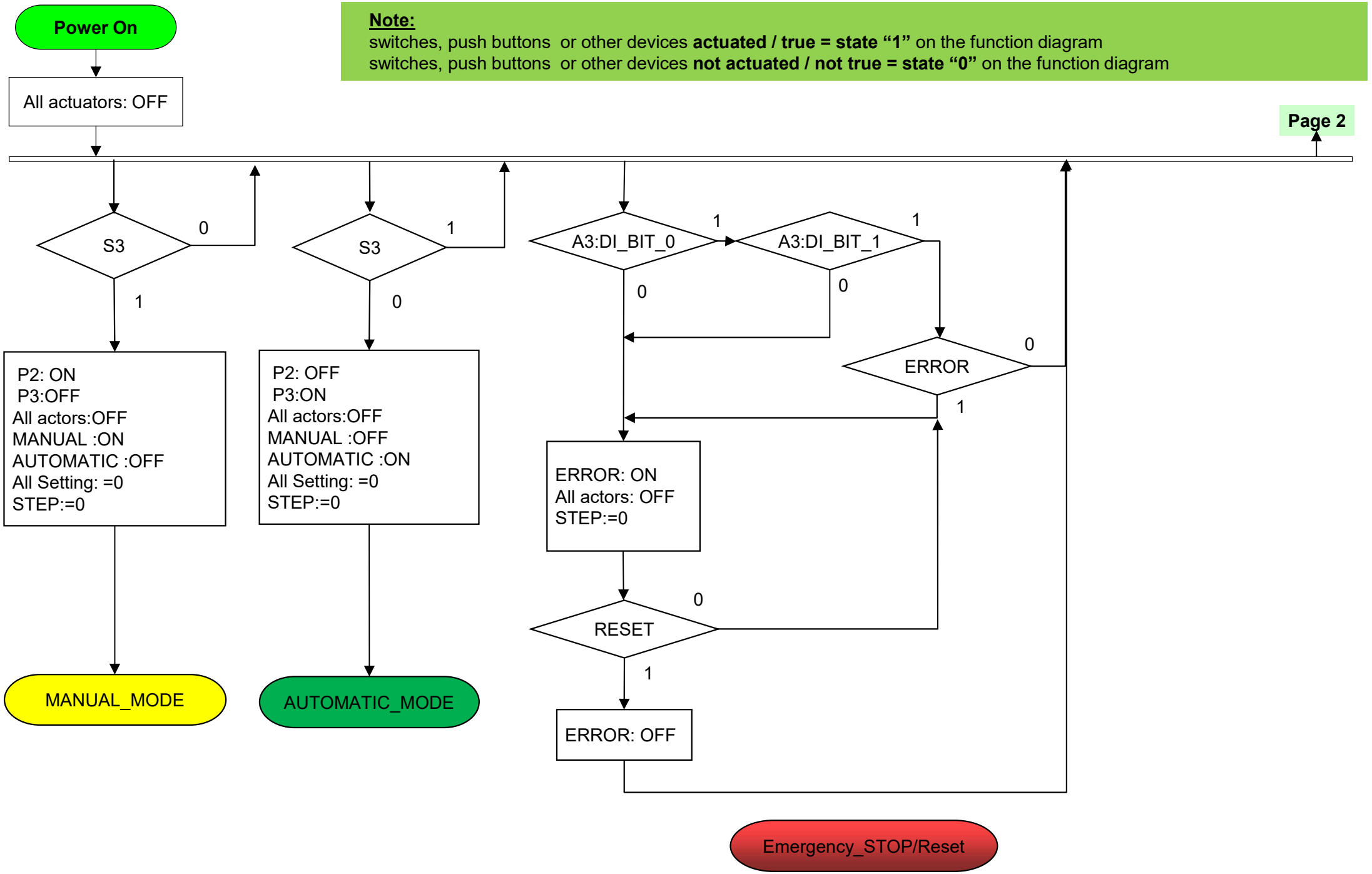
PROFINET CONNECTIONS

OVERVIEW TECHNOLOGY



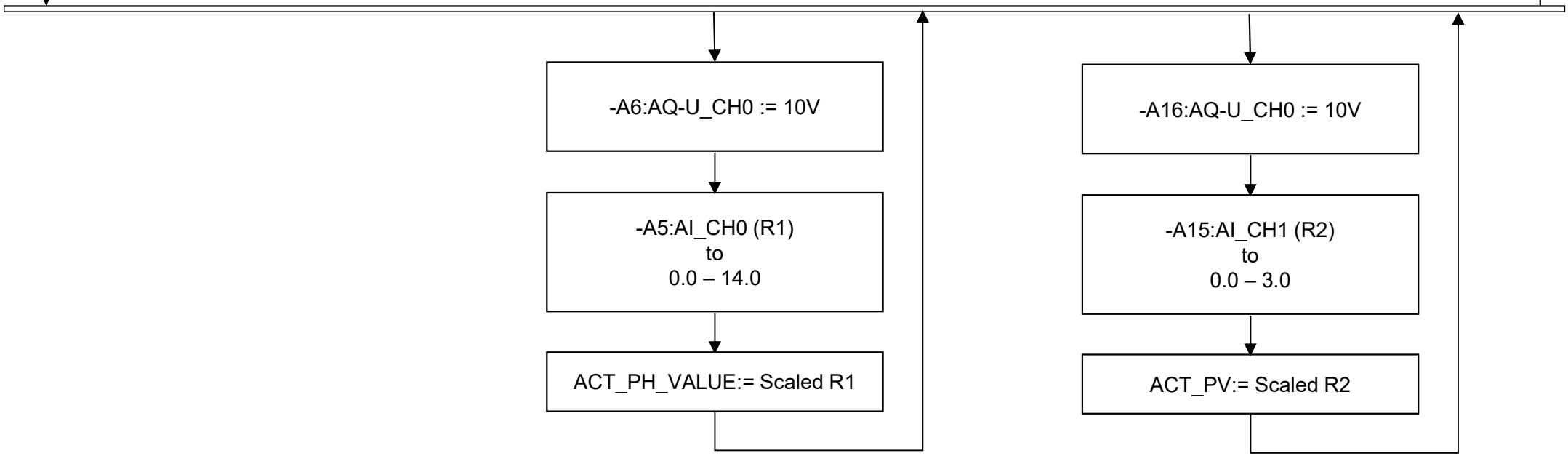
OVERVIEW TOPOLOGY



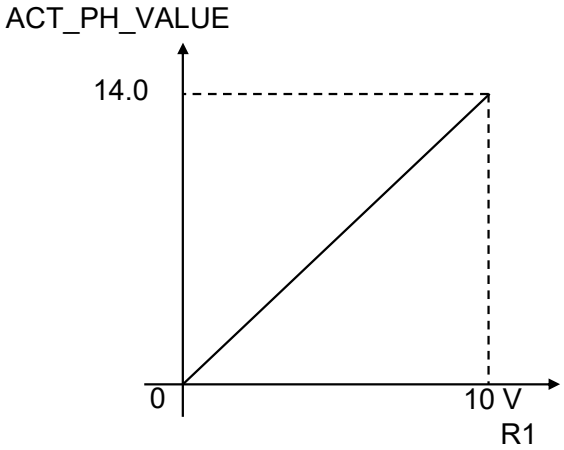

Power On
All actuators: OFF
Note:
switches, push buttons or other devices actuated / true = state "1" on the function diagram
switches, push buttons or other devices not actuated / not true = state "0" on the function diagram
Page 2
S3
0
1
P2: ON
P3:OFF
All actors:OFF
MANUAL :ON
AUTOMATIC :OFF
All Setting: =0
STEP:=0
MANUAL_MODE
S3
1
0
P2: OFF
P3:ON
All actors:OFF
MANUAL :OFF
AUTOMATIC :ON
All Setting: =0
STEP:=0
AUTOMATIC_MODE
A3:DI_BIT_0
1
0
A3:DI_BIT_1
1
0
ERROR
0
1
ERROR: ON
All actors: OFF
STEP:=0
RESET
0
1
ERROR: OFF
Emergency_STOP/Reset

Page 1

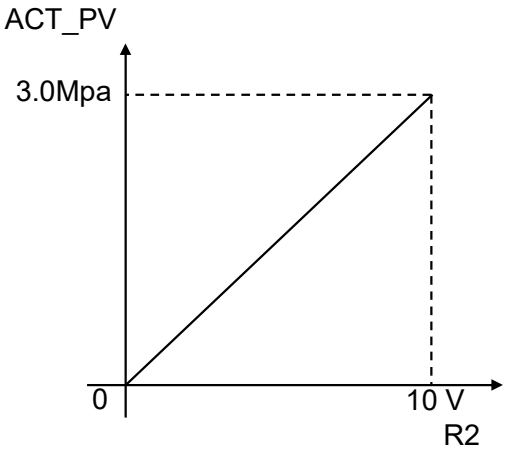
Page 3

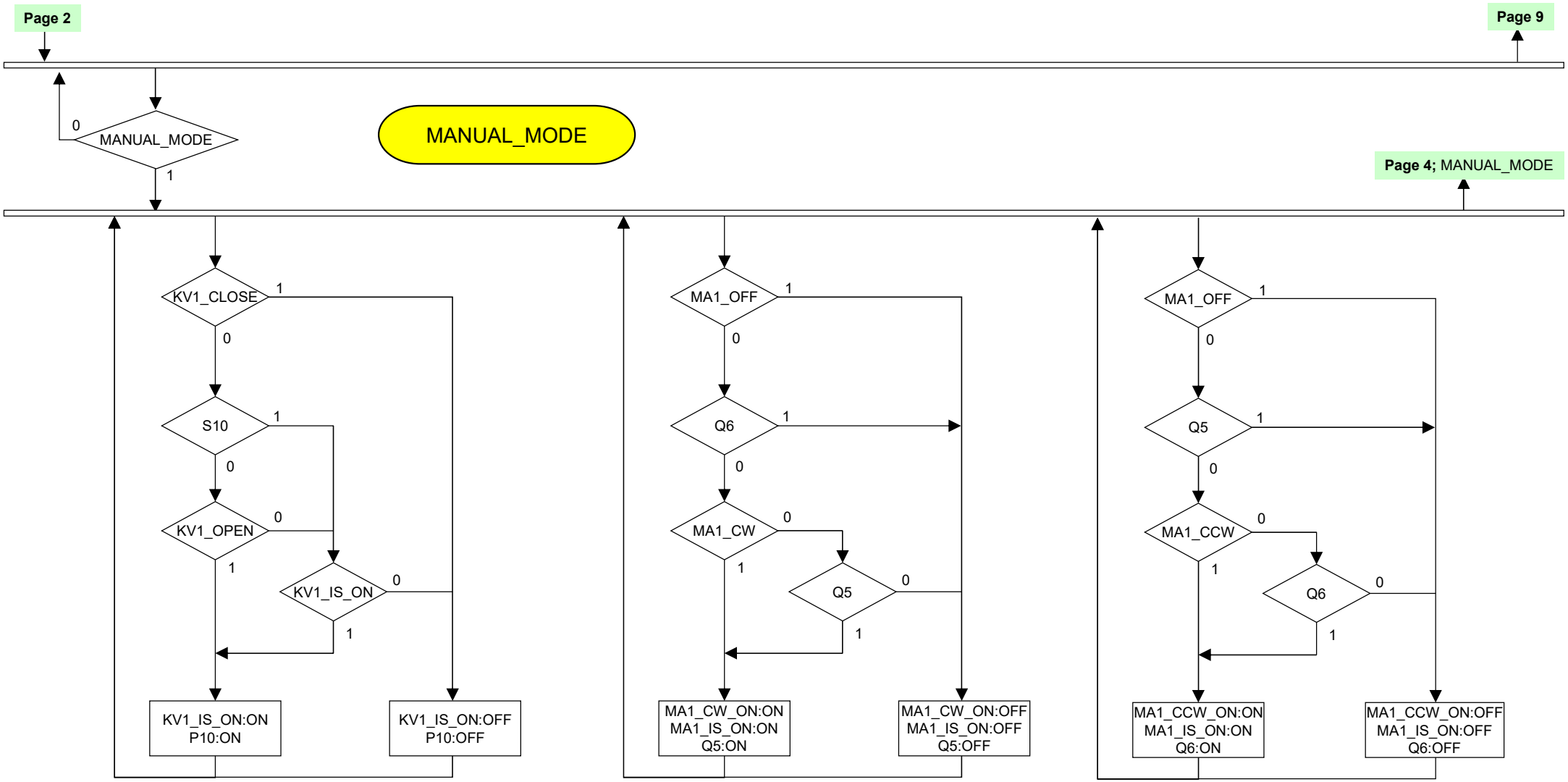


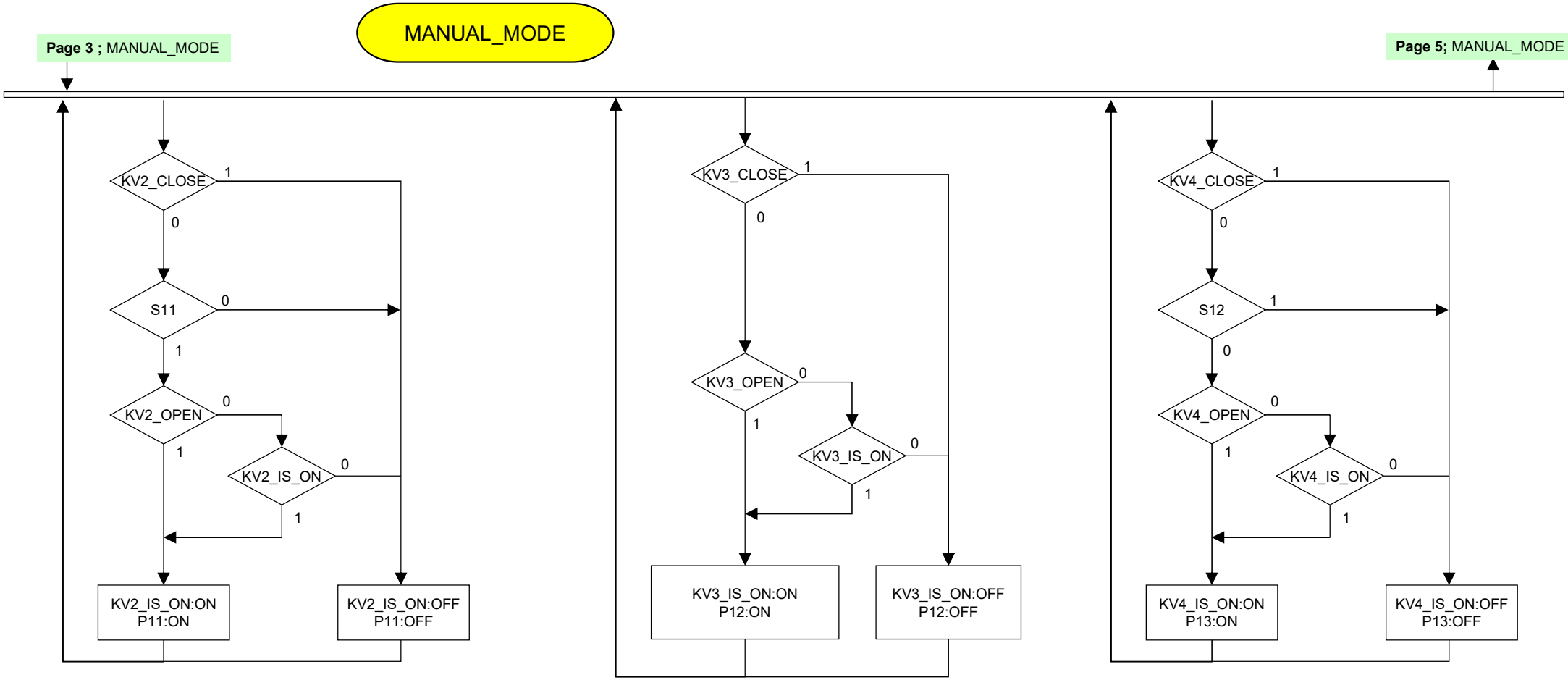
Potentiometer R1

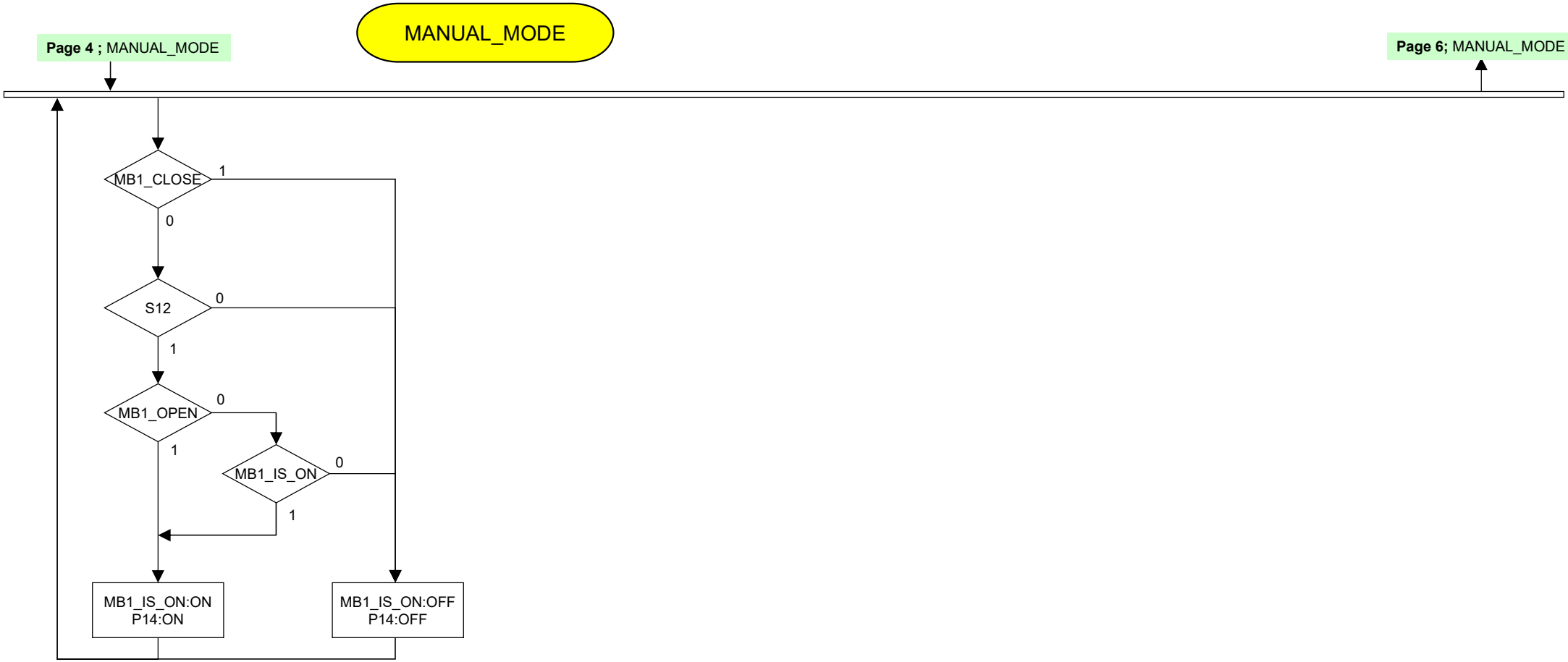


Potentiometer R2

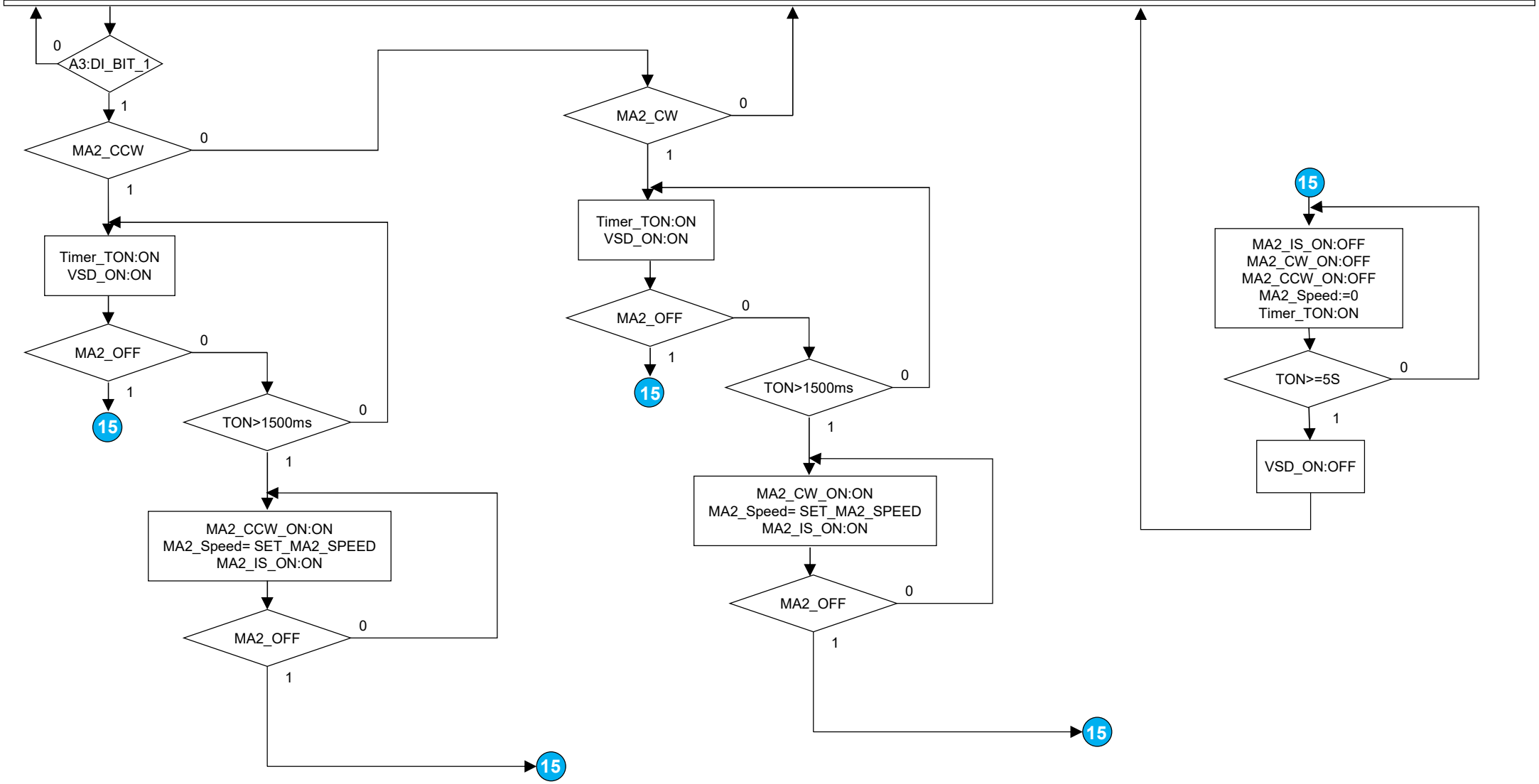


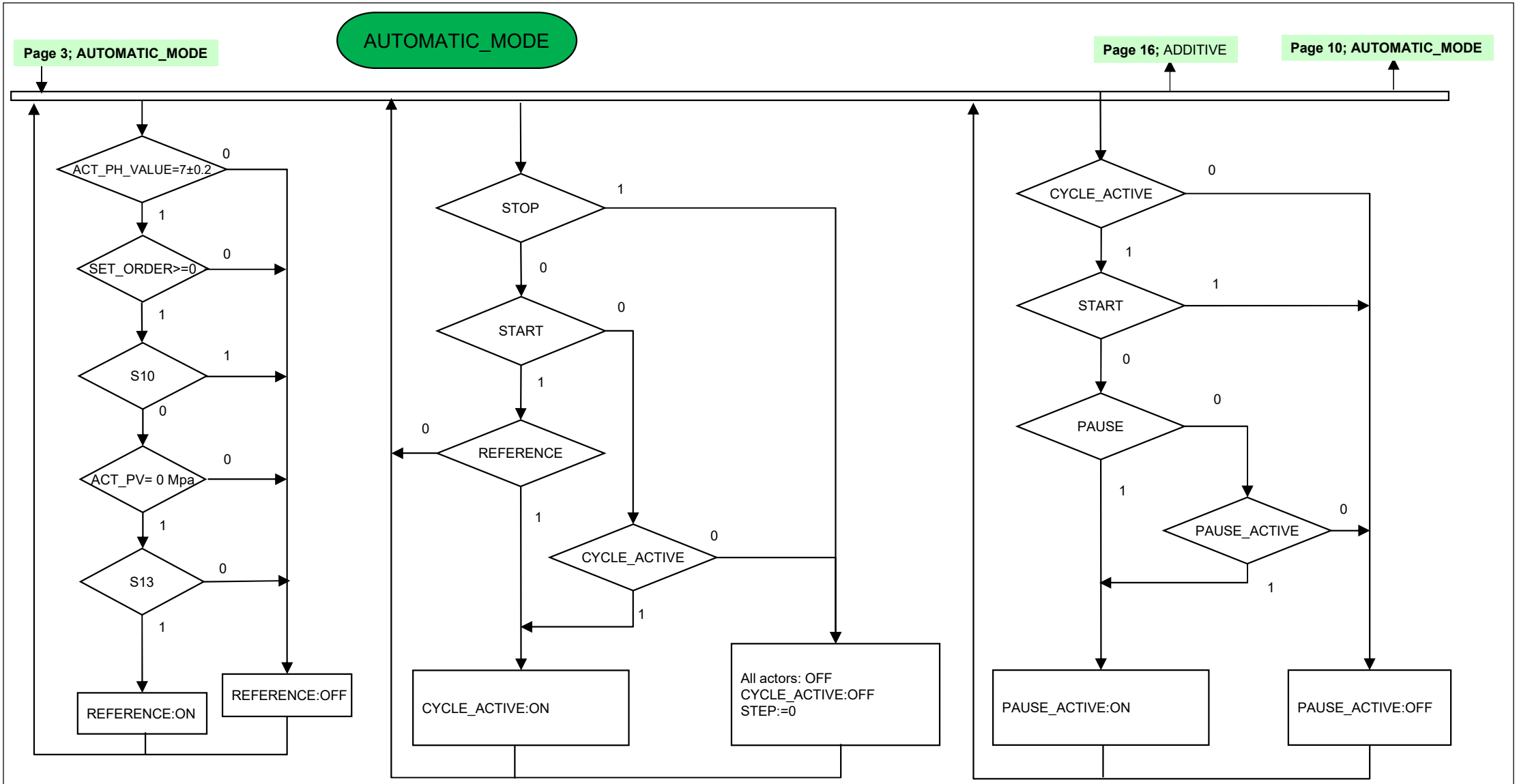

Page 2
Page 9
MANUAL_MODE
0
1
MANUAL_MODE
Page 4; MANUAL_MODE
KV1_CLOSE
1
0
S10
1
0
KV1_OPEN
0
1
KV1_IS_ON
0
1
KV1_IS_ON:ON
P10:ON
KV1_IS_ON:OFF
P10:OFF
MA1_OFF
1
0
Q6
1
0
MA1_CW
0
1
Q5
0
1
MA1_CW_ON:ON
MA1_IS_ON:ON
Q5:ON
MA1_CW_ON:OFF
MA1_IS_ON:OFF
Q5:OFF
MA1_OFF
1
0
Q5
1
0
MA1_CCW
0
1
Q6
0
1
MA1_CCW_ON:ON
MA1_IS_ON:ON
Q6:ON
MA1_CCW_ON:OFF
MA1_IS_ON:OFF
Q6:OFF


MANUAL_MODE
Page 3 ; MANUAL_MODE
Page 5; MANUAL_MODE
KV2_CLOSE
S11
KV2_OPEN
KV2_IS_ON
KV2_IS_ON:ON
P11:ON
KV2_IS_ON:OFF
P11:OFF
KV3_CLOSE
KV3_OPEN
KV3_IS_ON
KV3_IS_ON:ON
P12:ON
KV3_IS_ON:OFF
P12:OFF
KV4_CLOSE
S12
KV4_OPEN
KV4_IS_ON
KV4_IS_ON:ON
P13:ON
KV4_IS_ON:OFF
P13:OFF


MANUAL_MODE
Page 4 ; MANUAL_MODE
Page 6; MANUAL_MODE
MB1_CLOSE
1
0
S12
0
1
MB1_OPEN
0
1
MB1_IS_ON
0
1
MB1_IS_ON:ON
P14:ON
MB1_IS_ON:OFF
P14:OFF

MANUAL_MODE

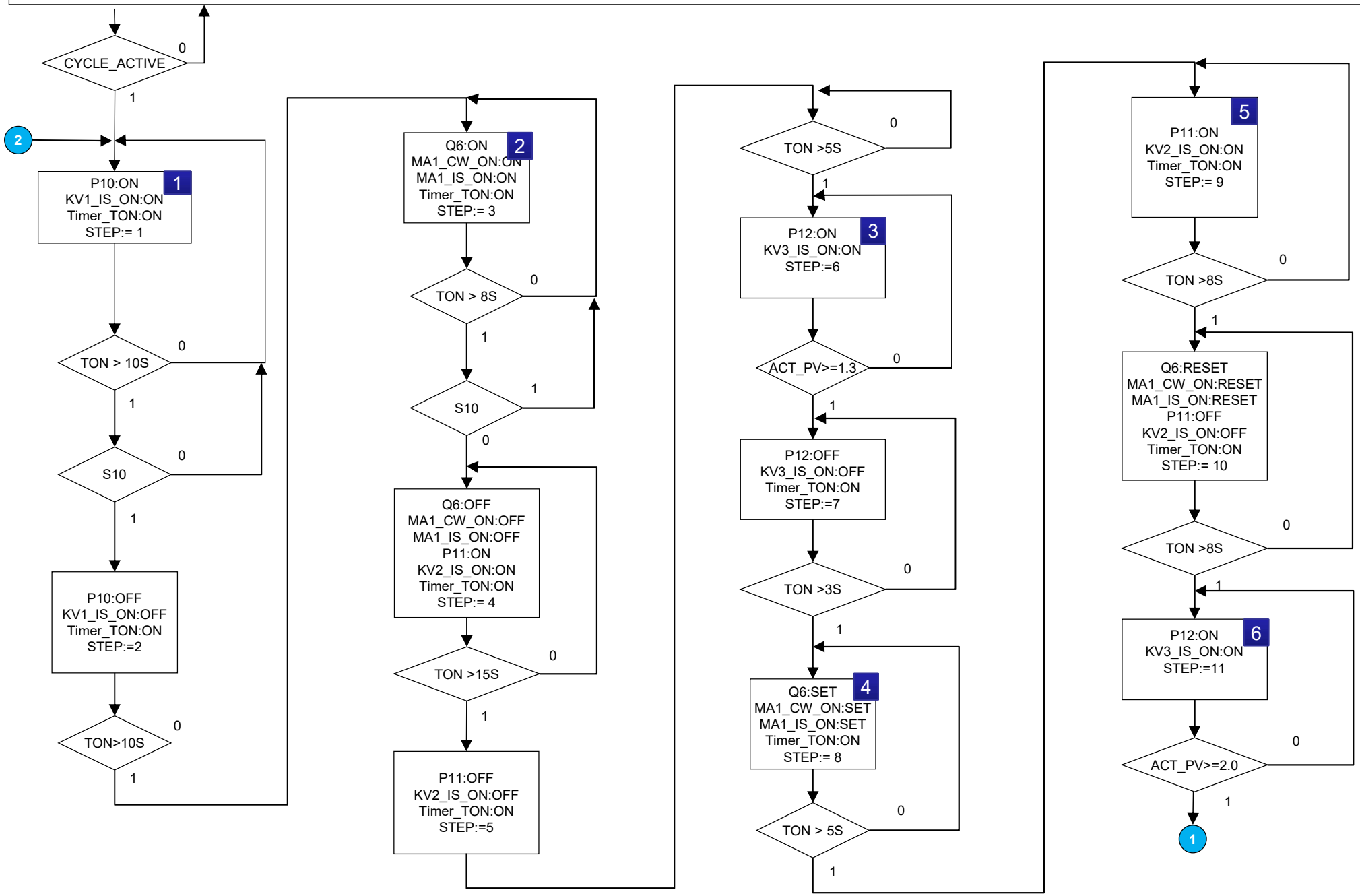

A3:DI_BIT_1
0
1
MA2_CCW
0
1
Timer_TON:ON
VSD_ON:ON
MA2_OFF
0
1
15
TON>1500ms
0
1
MA2_CCW_ON:ON
MA2_Speed= SET_MA2_SPEED
MA2_IS_ON:ON
MA2_OFF
0
1
15
MA2_CW
0
1
Timer_TON:ON
VSD_ON:ON
MA2_OFF
0
1
15
TON>1500ms
0
1
MA2_CW_ON:ON
MA2_Speed= SET_MA2_SPEED
MA2_IS_ON:ON
MA2_OFF
0
1
15
15
MA2_IS_ON:OFF
MA2_CW_ON:OFF
MA2_CCW_ON:OFF
MA2_Speed:=0
Timer_TON:ON
TON>=5S
0
1
VSD_ON:OFF


AUTOMATIC_MODE
Page 3; AUTOMATIC_MODE
Page 16; ADDITIVE
Page 10; AUTOMATIC_MODE
ACT_PH_VALUE=7±0.2
SET_ORDER>=0
S10
ACT_PV= 0 Mpa
S13
REFERENCE:ON
REFERENCE:OFF
STOP
START
REFERENCE
CYCLE_ACTIVE
CYCLE_ACTIVE:ON
All actors: OFF
CYCLE_ACTIVE:OFF
STEP:=0
CYCLE_ACTIVE
START
PAUSE
PAUSE_ACTIVE
PAUSE_ACTIVE:ON
PAUSE_ACTIVE:OFF
0
1

Page 10; AUTOMATIC_MODE

AUTOMATIC_MODE

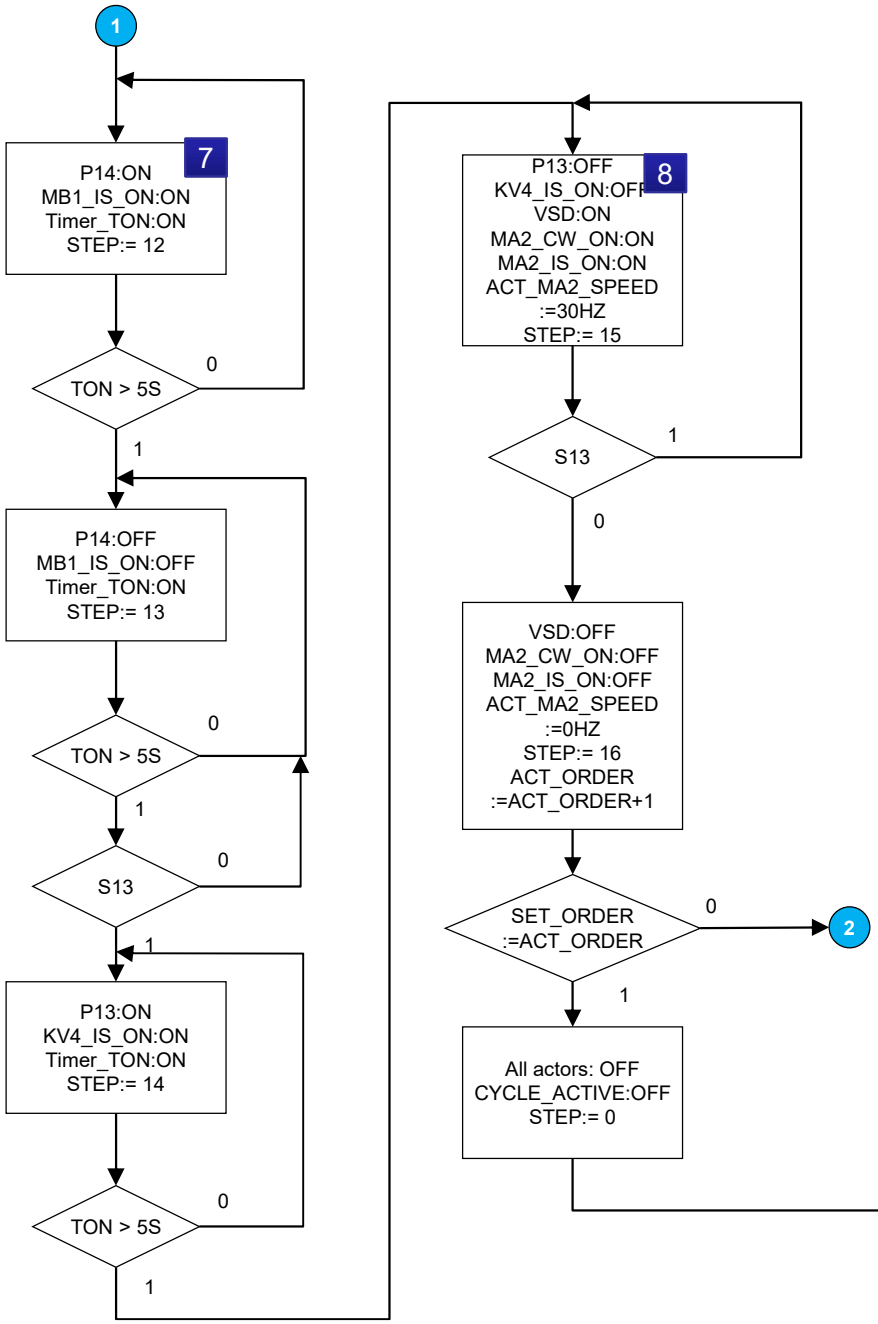
Page 12; AUTOMATIC_MODE

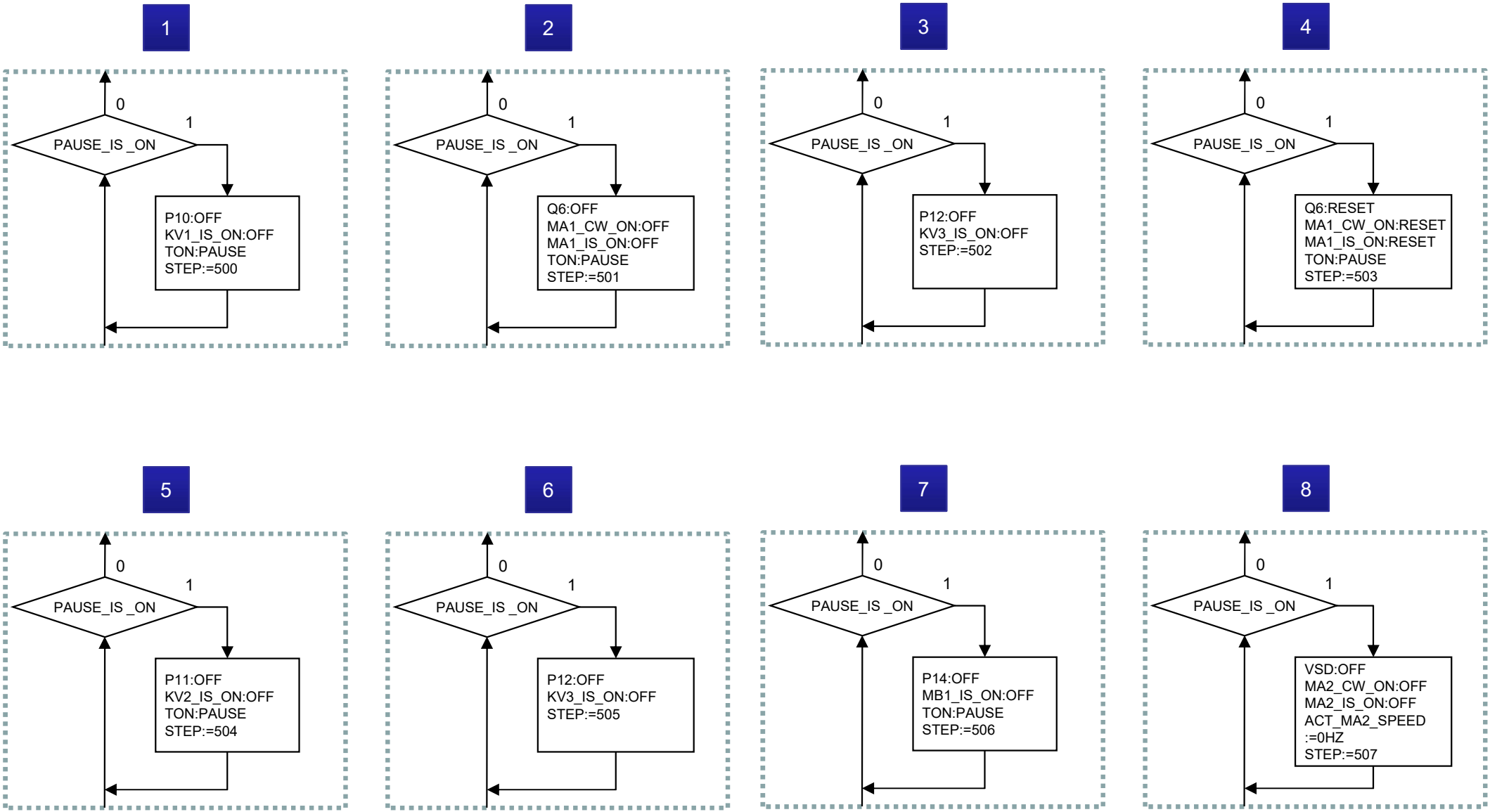


Page 11; AUTOMATIC_MODE

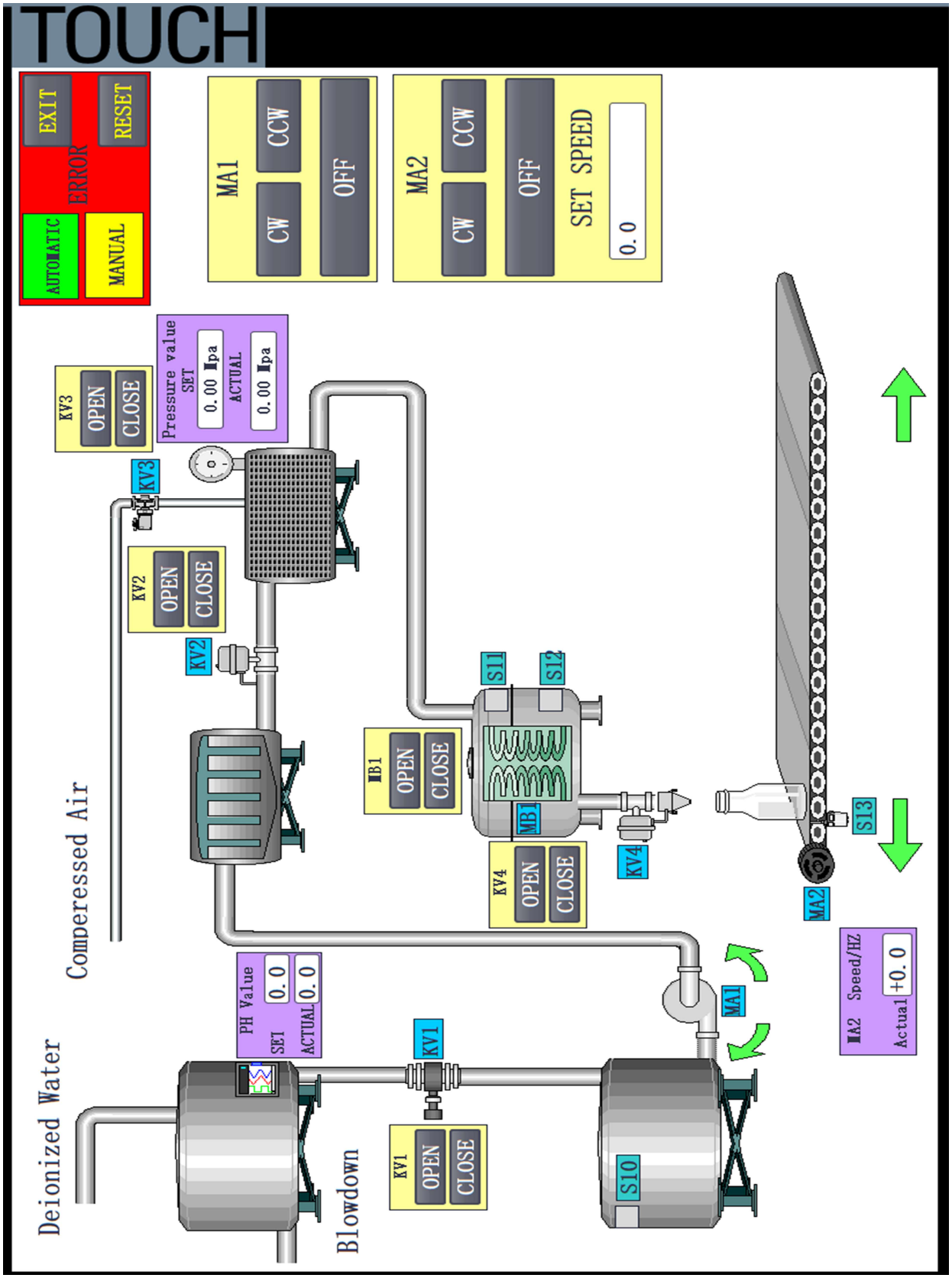
AUTOMATIC_MODE

Page 13; AUTOMATIC_MODE

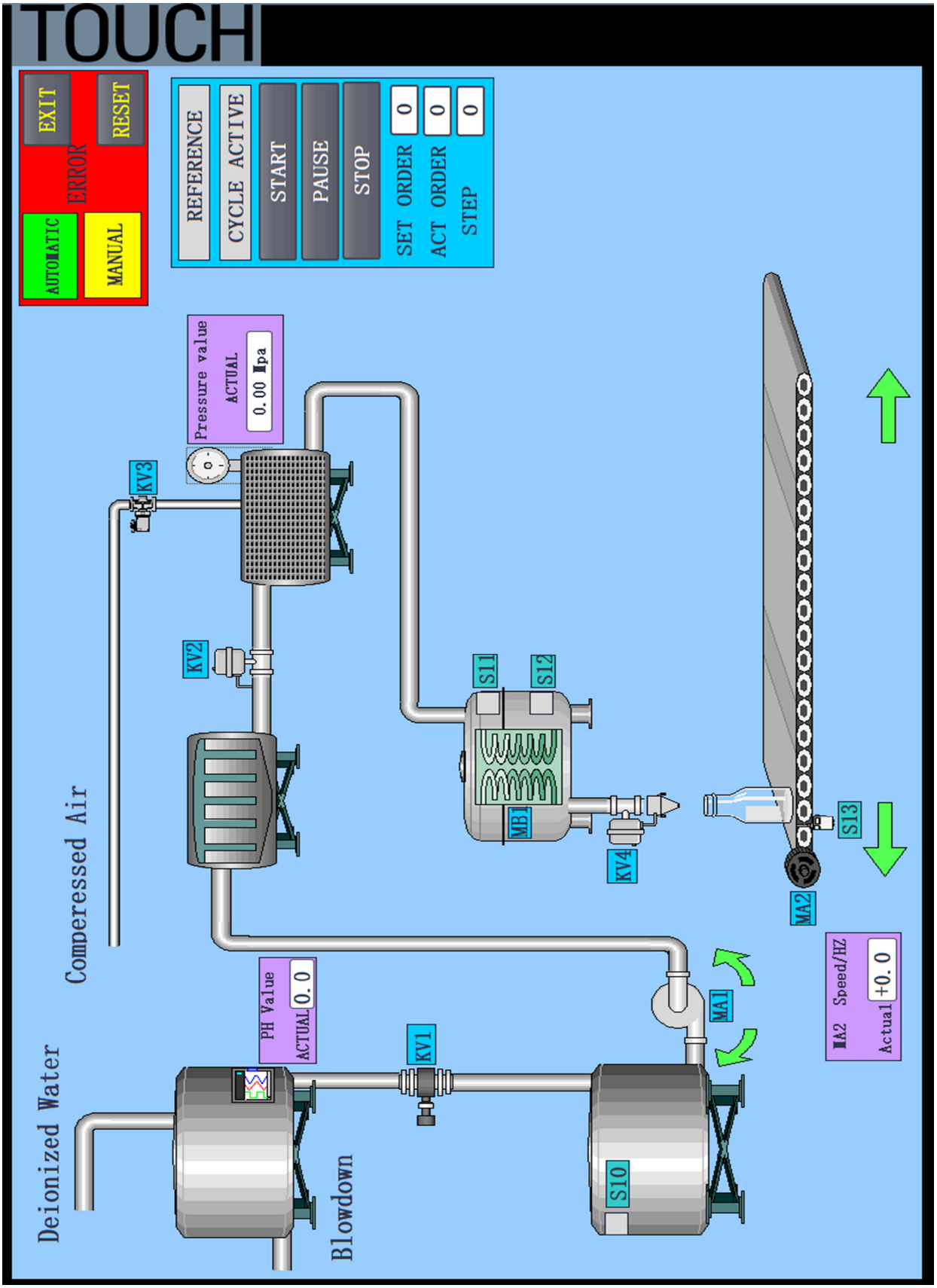



1
0
1
PAUSE_IS _ON
P10:OFF
KV1_IS_ON:OFF
TON:PAUSE
STEP:=500
2
0
1
PAUSE_IS _ON
Q6:OFF
MA1_CW_ON:OFF
MA1_IS_ON:OFF
TON:PAUSE
STEP:=501
3
0
1
PAUSE_IS _ON
P12:OFF
KV3_IS_ON:OFF
STEP:=502
4
0
1
PAUSE_IS _ON
Q6:RESET
MA1_CW_ON:RESET
MA1_IS_ON:RESET
TON:PAUSE
STEP:=503
5
0
1
PAUSE_IS _ON
P11:OFF
KV2_IS_ON:OFF
TON:PAUSE
STEP:=504
6
0
1
PAUSE_IS _ON
P12:OFF
KV3_IS_ON:OFF
STEP:=505
7
0
1
PAUSE_IS _ON
P14:OFF
MB1_IS_ON:OFF
TON:PAUSE
STEP:=506
8
0
1
PAUSE_IS _ON
VSD:OFF
MA2_CW_ON:OFF
MA2_IS_ON:OFF
ACT_MA2_SPEED
:=0HZ
STEP:=507

HMI-CONFIGURATION SCREEN OVERVIEW_MANUAL MODE



SCREEN OVERVIEW_AUTO MODE



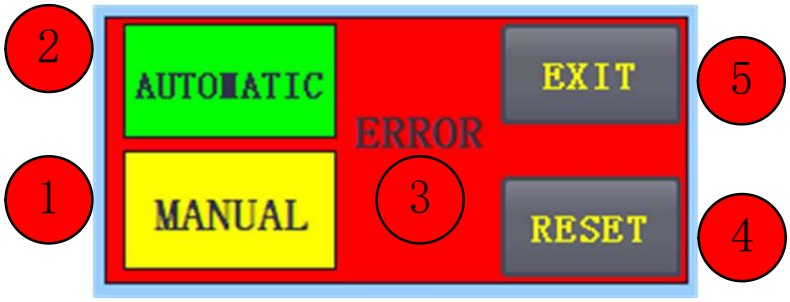
HMI VARIABLES

SYMBOL	TYPE	COMMENT	IN USE
A3:DI_BIT_0	BOOL	PLC-Input	Read
A3:DI_BIT_1	BOOL	PLC-Input	Read
S3	BOOL	PLC-Input	Read
P2	BOOL	PLC-Output	Read
P3	BOOL	PLC-Output	Read
Q5	BOOL	PLC-Output	Read
Q6	BOOL	PLC-Output	Read
S10	BOOL	PLC-Input	Read
S11	BOOL	PLC-Input	Read
S12	BOOL	PLC-Input	Read
S13	BOOL	PLC-Input	Read
P10	BOOL	PLC-Output	Read
P11	BOOL	PLC-Output	Read
P12	BOOL	PLC-Output	Read
P13	BOOL	PLC-Output	Read
P14	BOOL	PLC-Output	Read
KV1_OPEN	BOOL	PLC-Variable	Write
KV1_CLOSE	BOOL	PLC-Variable	Write
KV1_IS_ON	BOOL	PLC-Variable	Read
KV2_OPEN	BOOL	PLC-Variable	Write
KV2_CLOSE	BOOL	PLC-Variable	Write
KV2_IS_ON	BOOL	PLC-Variable	Read
KV3_OPEN	BOOL	PLC-Variable	Write
KV3_CLOSE	BOOL	PLC-Variable	Write
KV3_IS_ON	BOOL	PLC-Variable	Read
KV4_OPEN	BOOL	PLC-Variable	Write
KV4_CLOSE	BOOL	PLC-Variable	Write
KV4_IS_ON	BOOL	PLC-Variable	Read
ACT_ORDER	REAL	PLC-Variable	Read
SET_ORDER	REAL	PLC-Variable	Read/Write

HMI VARIABLES

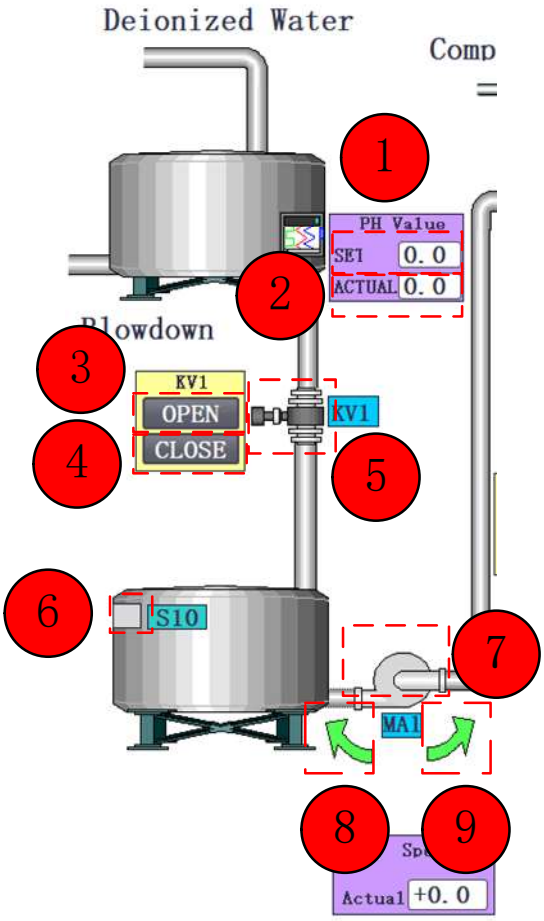
SYMBOL	TYPE	COMMENT	IN USE
MB1_OPEN	BOOL	PLC-Variable	Write
MB1_CLOSE	BOOL	PLC-Variable	Write
MB1_IS_ON	BOOL	PLC-Variable	Read
ACT_PH_VALUE	REAL	PLC-Variable	Read
ACT_PV	REAL	PLC-Variable	Read
SET_PH_VALUE	REAL	PLC-Variable	Read/Write
SET_PV	REAL	PLC-Variable	Read/Write
MA1_CW	BOOL	PLC-Variable	Write
MA1_CCW	BOOL	PLC-Variable	Write
MA1_CW_ON	BOOL	PLC-Variable	Read
MA1_CCW_ON	BOOL	PLC-Variable	Read
MA1_OFF	BOOL	PLC-Variable	Write
MA1_IS_ON	BOOL	PLC-Variable	Read
MA2_CW	BOOL	PLC-Variable	Write
MA2_CCW	BOOL	PLC-Variable	Write
MA2_CW_ON	BOOL	PLC-Variable	Read
MA2_CCW_ON	BOOL	PLC-Variable	Read
MA2_OFF	BOOL	PLC-Variable	Write
MA2_IS_ON	BOOL	PLC-Variable	Read
ACT_MA2_SPEED	REAL	PLC-Variable	Read
SET_MA2_SPEED	REAL	PLC-Variable	Read
ERROR	BOOL	PLC-Variable	Read
RESET	BOOL	PLC-Variable	Write
MANUAL_MODE	BOOL	PLC-Variable	Read
AUTOMATIC_MODE	BOOL	PLC-Variable	Read
REFERENCE	BOOL	PLC-Variable	Read
CYCLE_ACTIVE	BOOL	PLC-Variable	Read
START	BOOL	PLC-Variable	Write
PAUSE	BOOL	PLC-Variable	Write
PAUSE_ACTIVE	BOOL	PLC-Variable	Read
STOP	BOOL	PLC-Variable	Write
STEP	INT	PLC-Variable	Read

DETAILS MODE



POSITION	VARIABLE	ACTION	COMMENT
1	MANUAL_MODE	Background Control Colour	Not Actuated Colour = GRAY Actuated Colour = YELLOW Activate Screen :"MANUAL"
2	AUTOMATIC_MODE	Background Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN Activate Screen :"AUTOMATIC"
3	ERROR	Text field Visibility	Not Actuated Invisible Actuated Visible
		Background Control Colour	Not Actuated Colour = GRAY Actuated Colour = RED
4	RESET	Button Control	"State 1" while button is pressed
5	EXIT	Button Control	Exit the system

DETAILS CONTROL

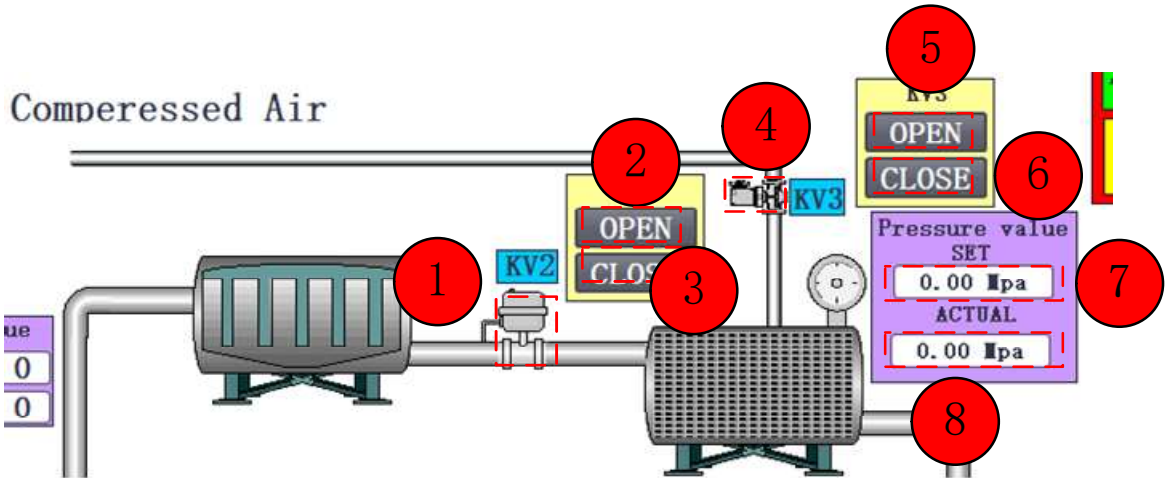


DESCRIPTION	SYMBOL LIBRARY	SYMBOL LIBRARY ITEM
Finalpieces_Tanks	Tanks	Tanks 2
Finalpieces_Tanks	Tanks	Tank support 2
Finalpieces_Pipes	Pipes	Short horizontal pipe
Finalpieces_Pipes	Pipes	90°curve 2
Finalpieces_Sensors	Sensors	Strip Chart Recorder
Finalpieces_Valves	Valves	Control valve 3

DESCRIPTION	SYMBOL LIBRARY	SYMBOL LIBRARY ITEM
Finalpieces_Valves	Valves	Control valve - horizontal
Finalpieces_Pumps	Pumps	Horizontal pump(left)
Finalpieces_Arrows	Arrows	Curving arrow

POSITION	VARIABLE	ACTION	COMMENT
1	SET_PV	Input/Output Field	Value: 0.0 to 14.0
2	ACT_PV	Output Field	Value: 0.0 to 14.0
3	KV1_OPEN	Button Control	"State 1" while button is pressed
4	KV1_CLOSE	Button Control	"State 1" while button is pressed
5	KV1_IS_ON	Foreground Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN
6	S10	Background Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN
7	MA1_IS_ON	Foreground Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN
8	MA1_CW_ON	Foreground Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN
9	MA1_CCW_ON	Foreground Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN

DETAILS CONTROL

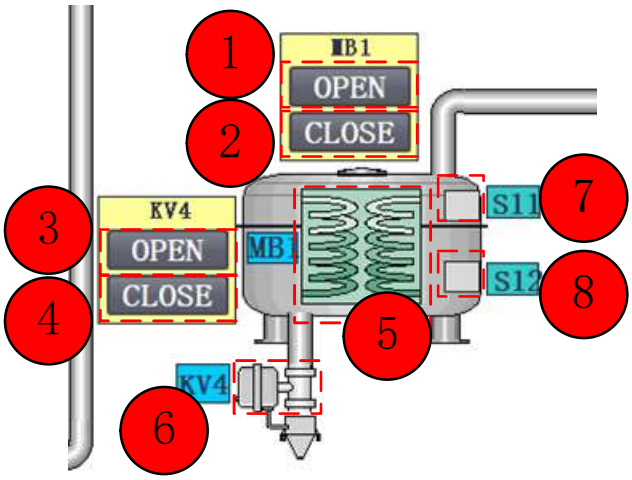


DESCRIPTION	SYMBOL LIBRARY	SYMBOL LIBRARY ITEM
Finalpieces_Tanks	Tanks	Very smooth tank 2
Finalpieces_Chemical	Chemical	Filter system 2
Finalpieces_Tanks	Tanks	Tank support 2
Finalpieces_Valves	Valves	Control valve - horizontal
Finalpieces_Textures	Textures	Steel Grating,Small Rectangles
Finalpieces_Sensors	Sensors	Pressure guage

POSITION	VARIABLE	ACTION	COMMENT
1	KV2_IS_ON	Foreground Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN
2	KV2_OPEN	Button Control	"State 1" while button is pressed
3	KV2_CLOSE	Button Control	"State 1" while button is pressed

POSITION	VARIABLE	ACTION	COMMENT
4	KV3_IS_ON	Foreground Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN
5	KV3_OPEN	Button Control	"State 1" while button is pressed
6	KV3_CLOSE	Button Control	"State 1" while button is pressed
7	SET_PH_VALUE	Input/Output Field	Value: 0.0 to 10.0
8	ACT_PH_VALUE	Output Field	Value: 0.0 to 10.0

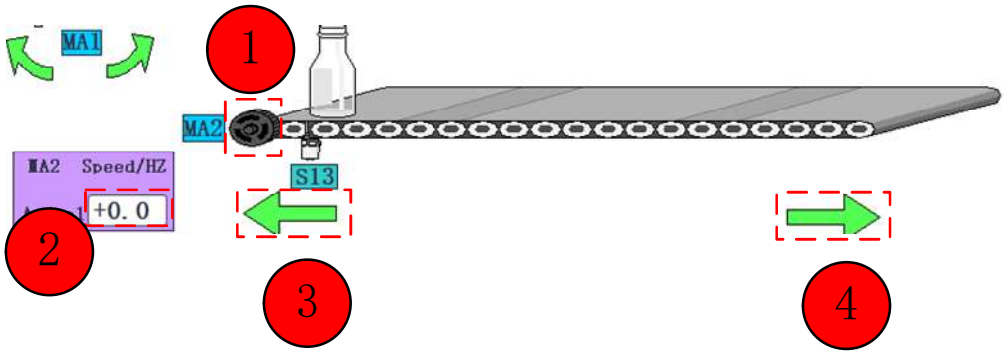
DETAILS CONTROL



DESCRIPTION	SYMBOL LIBRARY	SYMBOL LIBRARY ITEM
Finalpieces_Tanks	Tanks	Tank 22
Finalpieces_Process Heating	ProcessHeating	Heat exchanger 1
Finalpieces_Valves	Valves	Control valve - horizontal
Finalpieces_Material Handing	MaterialHanding	Simple weigh hopper
Finalpieces_Pipes	Pipes	Short horizontal pipe
Finalpieces_Pipes	Pipes	90°curve 2

POSITION	VARIABLE	ACTION	COMMENT
1	MB1_OPEN	Button Control	"State 1" while button is pressed
2	MB1_CLOSE	Button Control	"State 1" while button is pressed
3	KV4_OPEN	Button Control	"State 1" while button is pressed
4	KV4_CLOSE	Button Control	"State 1" while button is pressed
5	MB1_IS_ON	Foreground Control Colour	Not Actuated Colour = GREEN Actuated Colour = RED
6	KV4_IS_ON	Foreground Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN
7	S11	Background Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN
8	S12	Background Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN

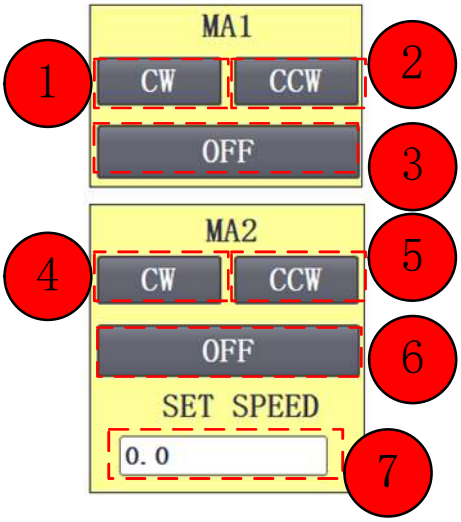
DETAILS CONTROL



DESCRIPTION	SYMBOL LIBRARY	SYMBOL LIBRARY ITEM
Finalpieces_Conveyors, Misc	Conveyors,Misc	Retracted pusher 2
Finalpieces_Motors	Motors	Smart motor
Finalpieces_Arrows	Arrows	Straight arrow 1
Finalpieces_Containers	Containers	Bottle

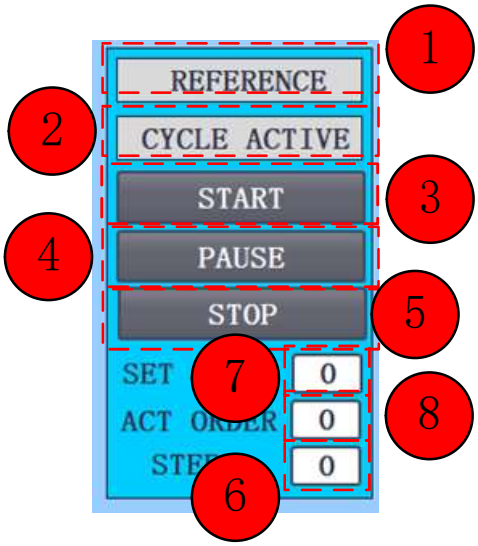
POSITION	VARIABLE	ACTION	COMMENT
1	MA2_IS_ON	Foreground Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN
2	ACT_MA2_SPEED	Output field	Value: -50.0 to 50.0
3	MA3_CW_ON	Foreground Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN
4	MA3_CCW_ON	Foreground Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN

DETAILS CONTROL



POSITION	VARIABLE	ACTION	COMMENT
1	MA1_CW	Button Control	"State 1" while button is pressed
2	MA1_CCW	Button Control	"State 1" while button is pressed
3	MA1_IS ON	Button Control	"State 1" while button is pressed
4	MA2_CW	Button Control	"State 1" while button is pressed
5	MA2_CCW	Button Control	"State 1" while button is pressed
6	MA2_IS ON	Button Control	"State 1" while button is pressed
7	SET_MA2_SPEED	Input/Output field	Value: 0.0 to 50.0

DETAILS CONTROL



POSITION	VARIABLE	ACTION	COMMENT
1	REFERENCE	Background Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN
2	CYCLE_ACTIVE	Background Control Colour	Not Actuated Colour = GRAY Actuated Colour = GREEN
3	START	Button Control	"State 1" while button is pressed
4	PAUSE	Button Control	"State 1" while button is pressed
5	STOP	Button Control	"State 1" while button is pressed
6	STEP	Output Field	Value: 0 to 999
4	PAUSE_ACTIVE	Background Control Colour	Not Actuated Colour = GRAY Actuated Colour = YELLOW
7	SET_ORDER	Input/Output Field	Value: 0 to 99
8	ACT_ORDER	Output Field	Value: 0 to 99