

APPENDIX(A)

PLC program in structured text language (STL)

FB100 : Control Function of Section01 - Feeding System

Comment:

Network 1: Calculate Max Calming Time of section

// Initiate Calming time

L 0

T #Section01.Group.CalmTime_Par #Section01.Group.CalmTime_Par -- Gorup Max Calming Time during Stoppage

// Calculated Time delay

A #Pump1_Active #Pump1_Active

JCN _101

L #_1KM01C.Motor.CalmTime_Par #_1KM01C.Motor.CalmTime_Par -- Motor Max Calming Time during stoppage

L #Section01.Group.CalmTime_Par #Section01.Group.CalmTime_Par -- Gorup Max Calming Time during Stoppage

+I

T #Section01.Group.CalmTime_Par #Section01.Group.CalmTime_Par -- Gorup Max Calming Time during Stoppage

_101: A #Pump2_Active #Pump2_Active

JCN _102

L #_1KM02C.Motor.CalmTime_Par #_1KM02C.Motor.CalmTime_Par -- Motor Max Calming Time during stoppage

L #Section01.Group.CalmTime_Par #Section01.Group.CalmTime_Par -- Gorup Max Calming Time during Stoppage

+I

T #Section01.Group.CalmTime_Par #Section01.Group.CalmTime_Par -- Gorup Max Calming Time during Stoppage

_102: A #Pump3_Active #Pump3_Active

JCN _103

L #_1KM03C.Motor.CalmTime_Par #_1KM03C.Motor.CalmTime_Par -- Motor Max Calming Time during stoppage

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