		Date:	Signed:
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EFFECT — **CAUSE** — **ACTION AFTER...minutes**

Code	Failure bits DB10.DBX0.0-19.7	Datablock bit (DB10)	Report : on screen	Warning : on screen	Failure : on screen	Stop : M73 Belt conveyor wet sand bunker 1	Stop : M74 Belt conveyor wet sand bunker 2	Stop : M75 Belt conveyor wet sand bunker 3	Stop : M76 Belt conveyor wet sand bunker 4	Stop : M71 Collect conveyor wet sand	Stop : M72 Main belt conveyor wet sand	Stop : M01 Dryer drive	Stop : M18 Supply fan cooler	Stop : M21 Combustion air fan	Stop : M23 Recirculation air fan	Stop : M24 Sleeve cooling fan	Stop : M25 Exhaust fan	Stop : M33 Screw conveyor filter	Stop : M39 Screw conveyor dust	Stop : M77 Outlet belt conveyor dry sand	Stop : M63 Bucket elevator	Stop : M59 Oversize screen	Stop : E07 Filter cleaning	Start : E07 filter cleaning (fixed pause time)	Stop : E08 Filter cleaning silo's	Stop : M27 Fan filter dry sand silo's	Stop and close to bin: EP59 Oversize screen silo's/bin	Stop and close: EP101 valve dry sand silo 101	Stop and close: EP102 valve dry sand silo 102	Stop and close: EP103 valve dry sand silo 103	Stop and close: EP104 valve dry sand silo 104	Stop and close: EP105 valve dry sand silo 105	Stop : PICA1210 (Sub) pressure controller	Stop : Product supply controller TICA1101, TICA1126	Product supply to start value	Stop : Product temperature dryer controller TICA1113	TICA1126 Exhaust air temperature to start setpoint	Stop : Temperature controller TICA1101, TICA1126	Stop : E12 Burner	Close : V35 Fuel control valve	Start : Stop sequence	Increase product supply to other selected bunkers
E01	Emergency stop active	dbx0.0			X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X		X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X		
	Control voltage indication lamps, main voltage not present	dbx0.1		X																																						
E01	Control voltage not present	dbx0.2			X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X		X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X		
E01	Enclosure/panel too hot	dbx0.3		X																																						
E01	Failure communication with SCADA	dbx71.7		X																																						
No menu	No menu selected	dbx71.2		X																																						
No wet bunker	No wet sand bunker selected	dbx71.3			X	X	X	X	X																									X	X	X	X			XB	60	
No dry silo	No dry sand silo selected	dbx71.4			X	X	X	X	X	X	X	X						X	X	X	X	X					X	X	X	X	X	X		X	X	X	X			XB	60	
FSA7405	No product flow detection into dryer	dbx0.6			X	X	X	X	X	X	X																							X	X	X	X			XB	60	
FSA7401	No product flow detection on Belt M73	dbx12.3			X	X																																				1
FSA7402	No product flow detection on Belt M74	dbx12.7			X		X																																			1
FSA7403	No product flow detection on Belt M75	dbx13.3			X			X																																		1
FSA7404	No product flow detection on Belt M76	dbx13.7			X				X																																	1
M01	Dryer drive, thermistor protection	dbx1.0			X	X	X	X	X	X	X	X																						X	X	X	X			XB	60	
M01	Dryer drive, high current	dbx1.1		X																																						
M01	Dryer drive, frequency controller	dbx1.2			X	X	X	X	X	X	X	X																						X	X	X	X			XB	60	
PSA1201	Pressure air bellows too low or too high	dbx1.3			X	X	X	X	X	X	X	X																						X	X	X	X			XB	60	
M18	Supply fan cooler, thermistor protection	dbx2.0			X	X	X	X	X	X	X	X	X																					X	X	X	X	X	X	X	60	
M18	Supply fan cooler, high current	dbx2.1		X																																						
M18	Supply fan cooler, frequency controller	dbx2.2			X	X	X	X	X	X	X	X	X																					X	X	X	X	X	X	X	60	
M21	Combustion air fan, thermistor protection	dbx2.3			X	X	X	X	X	X	X	X		X																				X	X	X	X	X	X	X	60	
M21	Combustion air fan, relay	dbx2.4			X	X	X	X	X	X	X	X		X																				X	X	X	X	X	X	X	60	
M21	Combustion air fan, high current	dbx2.5		X																																						
M23	Recirculation air fan, thermistor protection	dbx3.2			X	X	X	X	X	X	X	X			X																			X	X	X	X	X	X	X	60	
M23	Recirculation air fan, high current	dbx3.3		X																																						
M23	Recirculation air fan, frequency controller	dbx3.4			X	X	X	X	X	X	X	X			X																			X	X	X	X	X	X	X	60	
M24	Sleeve cooling fan, high current	dbx3.7		X																																						
M24	Sleeve cooling fan, relay	dbx4.0			X	X	X	X	X	X	X	X				X																		X	X	X	X	X	X	X	60	
M25	Exhaust fan, thermistor protection	dbx4.4			X	X	X	X	X	X	X	X	X	X	X	X	X						X										X	X	X	X	X	X	X	X	60	
M25	Exhaust fan, high current	dbx4.5		X																																						
M25	Exhaust fan, frequency controller	dbx4.6			X	X	X	X	X	X	X	X	X	X	X	X	X						X										X	X	X	X	X	X	X	X	60	
M27	Fan filter dry sand silo's, relay	dbx6.0			X																				X	X																
M27	Fan filter dry sand silo's, high current	dbx6.1		X																																						
M33	Screw conveyor filter, relay	dbx5.0			X	X	X	X	X	X	X	X						X																X	X	X	X			XB	15	
M33	Screw conveyor filter, high current	dbx5.1		X																																						

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CAUSE		Datablock bit (DB10)	EFFECT	Report : on screen	Warning : on screen	Failure : on screen	Stop : M73 Belt conveyor wet sand bunker 1	Stop : M74 Belt conveyor wet sand bunker 2	Stop : M75 Belt conveyor wet sand bunker 3	Stop : M76 Belt conveyor wet sand bunker 4	Stop : M71 Collect conveyor wet sand	Stop : M72 Main belt conveyor wet sand	Stop : M01 Dryer drive	Stop : M18 Supply fan cooler	Stop : M21 Combustion air fan	Stop : M23 Recirculation air fan	Stop : M24 Sleeve cooling fan	Stop : M25 Exhaust fan	Stop : M33 Screw conveyor filter	Stop : M39 Screw conveyor dust	Stop : M77 Outlet belt conveyor dry sand	Stop : M63 Bucket elevator	Stop : M59 Oversize screen	Stop : E07 Filter cleaning	Start : E07 filter cleaning (fixed pause time)	Stop : E08 Filter cleaning silo's	Stop : M27 Fan filter dry sand silo's	Stop and close to bin: EP59 Oversize screen silo's/bin	Stop and close: EP101 valve dry sand silo 101	Stop and close: EP102 valve dry sand silo 102	Stop and close: EP103 valve dry sand silo 103	Stop and close: EP104 valve dry sand silo 104	Stop and close: EP105 valve dry sand silo 105	Stop : PICA1210 (Sub) pressure controller	Stop : Product supply controller TICA1101, TICA1126	Product supply to start value	Stop : Product temperature dryer controller TICA1113	TICA1126 Exhaust air temperature to start setpoint	Stop : Temperature controller TICA1101, TICA1126	Stop : E12 Burner	Close : V35 Fuel control valve	ACTION AFTER...minutes	Start : Stop sequence	Increase product supply to other selected bunkers
M39	Dust screw conveyor, relay	dbx6.4				X	X	X	X	X	X	X	X						X	X															X	X	X	X			XB		15	
M39	Dust srew conveyor, high current	dbx6.5			X																																							
M59	Over size screen, power relay	dbx7.4				X	X	X	X	X	X	X	X						X	X	X	X	X												X	X	X	X			XB		15	
M59	Over size screen, no running signal	dbx7.5				X	X	X	X	X	X	X	X						X	X	X	X	X												X	X	X	X			XB		15	
M59	Over size screen, high current	dbx7.6			X																																							
M63	Bucket elevator, thermistor protection	dbx8.5				X	X	X	X	X	X	X	X						X	X	X	X													X	X	X	X			XB		60	
M63	Bucket elevator, high current	dbx8.6			X																																							
M63	Bucket elevator, frequency controller	dbx8.7				X	X	X	X	X	X	X	X						X	X	X	X													X	X	X	X			XB		60	
SA8635	Bucket elevator, zero speed detection	dbx9.5				X	X	X	X	X	X	X	X						X	X	X	X													X	X	X	X			XB		60	
M71	Belt conveyor wet sand, thermistor protection	dbx11.0				X	X	X	X	X	X																								X	X	X	X			XB		60	
M71	Belt conveyor wet sand, high current	dbx11.1			X																																							
M71	Belt conveyor wet sand, frequency controller	dbx11.2				X	X	X	X	X	X																								X	X	X	X			XB		60	
SA7715	Belt conveyor wet sand, zero speed detection	dbx11.3				X	X	X	X	X	X																								X	X	X	X			XB		60	
M72	Main belt conveyor wet sand, thermistor protection	dbx11.4				X	X	X	X	X	X	X																							X	X	X	X			XB		60	
M72	Main belt conveyor wet sand, high current	dbx11.5			X																																							
M72	Main belt conveyor wet sand, frequency controller	dbx11.6				X	X	X	X	X	X	X																							X	X	X	X			XB		60	
SA7725	Main belt conveyor wet sand, zero speed detection	dbx11.7				X	X	X	X	X	X	X																							X	X	X	X			XB		60	
M73	Belt conveyor wet sand bunker 1, thermistor protection	dbx12.0				X	X																																					1
M73	Belt conveyor wet sand bunker 1, high current	dbx12.1			X																																							
M73	Belt conveyor wet sand bunker 1, frequency controller	dbx12.2				X	X																																					1
M74	Belt conveyor wet sand bunker 2, thermistor protection	dbx12.4				X		X																																				1
M74	Belt conveyor wet sand bunker 2, high current	dbx12.5			X																																							
M74	Belt conveyor wet sand bunker 2, frequency controller	dbx12.6				X		X																																				1
M75	Belt conveyor wet sand bunker 3, thermistor protection	dbx13.0				X			X																																			1
M75	Belt conveyor wet sand bunker 3, high current	dbx13.1			X																																							
M75	Belt conveyor wet sand bunker 3, frequency controller	dbx13.2				X			X																																			1
M76	Belt conveyor wet sand bunker 4, thermistor protection	dbx13.4				X				X																																		1
M76	Belt conveyor wet sand bunker 4, high current	dbx13.5			X																																							
M76	Belt conveyor wet sand bunker 4, frequency controller	dbx13.6				X				X																																		1
M77	Outlet belt conveyor dry sand, relay	dbx14.0				X	X	X	X	X	X	X	X						X	X	X														X	X	X	X			XB		60	
M77	Outlet belt conveyor dry sand, high current	dbx14.1			X																														X	X	X	X			XB			
SA8775	Outlet belt conveyor dry sand, zero speed detection	dbx14.2				X	X	X	X	X	X	X	X						X	X	X														X	X	X	X			XB		60	
	Failure bits (valves/filter) DB10.DBX20.0-39.7																																											
EP59/ES8591	Valve oversize screen, not to silo's	dbx21.6				X	X	X	X	X	X	X	X						X	X	X	X	X					X							X	X	X	X			XB		30	
EP59/ES8592	Valve over size screen, not to bin	dbx21.7				X	X	X	X	X	X	X	X						X	X	X	X	X					X							X	X	X	X			XB		30	
EP101/ES8401	Valve dry sand silo 101, not opened	dbx20.0				X	X	X	X	X	X	X	X						X	X	X	X	X						X						X	X	X	X			XB		30	
EP101/ES8402	Valve dry sand silo 101, not closed	dbx20.1				X	X	X	X	X	X	X	X						X	X	X	X	X						X						X	X	X	X			XB		30	

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AMPP INDUSTRIAL AUTOMATION

		Datablock bit (DB10)	EFFECT	Report : on screen	Warning : on screen	Failure : on screen	Stop : M73 Belt conveyor wet sand bunker 1	Stop : M74 Belt conveyor wet sand bunker 2	Stop : M75 Belt conveyor wet sand bunker 3	Stop : M76 Belt conveyor wet sand bunker 4		Stop : M71 Collect conveyor wet sand	Stop : M72 Main belt conveyor wet sand		Stop : M01 Dryer drive	Stop : M18 Supply fan cooler	Stop : M21 Combustion air fan	Stop : M23 Recirculation air fan	Stop : M24 Sleeve cooling fan	Stop : M25 Exhaust fan		Stop : M33 Screw conveyor filter	Stop : M39 Screw conveyor dust	Stop : M77 Outlet belt conveyor dry sand	Stop : M63 Bucket elevator	Stop : M59 Oversize screen		Stop : E07 Filter cleaning	Start : E07 filter cleaning (fixed pause time)	Stop : E08 Filter cleaning silo's	Stop : M27 Fan filter dry sand silo's	Stop and close to bin: EP59 Oversize screen silo's/bin	Stop and close: EP101 valve dry sand silo 101	Stop and close: EP102 valve dry sand silo 102	Stop and close: EP103 valve dry sand silo 103	Stop and close: EP104 valve dry sand silo 104	Stop and close: EP105 valve dry sand silo 105	Stop : PICA1210 (Sub) pressure controller		Stop : Product supply controller TICA1101, TICA1126	Product supply to start value	Stop : Product temperature dryer controller TICA1113	TICA1126 Exhaust air temperature to start setpoint		Stop : Temperature controller TICA1101, TICA1126	Stop : E12 Burner	Close : V35 Fuel control valve	ACTION AFTER...minutes	Start : Stop sequence	Increase product supply to other selected bunkers	
CAUSE																																																	
EP102/ES8411	Valve dry sand silo 102, not opened	dbx20.2				X	X	X	X	X		X	X		X							X	X	X	X	X							X						X	X	X	X				XB		30		
EP102/ES8412	Valve dry sand silo 102, not closed	dbx20.3				X	X	X	X	X		X	X		X							X	X	X	X	X							X						X	X	X	X				XB		30		
EP103/ES8421	Valve dry sand silo 103, not opened	dbx20.4				X	X	X	X	X		X	X		X							X	X	X	X	X								X					X	X	X	X				XB		30		
EP103/ES8422	Valve dry sand silo 103, not closed	dbx20.5				X	X	X	X	X		X	X		X							X	X	X	X	X								X					X	X	X	X				XB		30		
EP104/ES8431	Valve dry sand silo 104, not opened	dbx20,6				X	X	X	X	X		X	X		X							X	X	X	X	X									X				X	X	X	X				XB		30		
EP104/ES8432	Valve dry sand silo 104, not closed	dbx20,7				X	X	X	X	X		X	X		X							X	X	X	X	X									X				X	X	X	X				XB		30		
EP105/ES8441	Valve dry sand silo 105, not opened	dbx21.0				X	X	X	X	X		X	X		X							X	X	X	X	X										X			X	X	X	X				XB		30		
EP105/ES8442	Valve dry sand silo 105, not closed	dbx21.1				X	X	X	X	X		X	X		X							X	X	X	X	X										X			X	X	X	X				XB		30		
E08	Filter cleaning unit silo's not OK	dbx22.4				X																							X																					
	Failure bits (min/max SP) DB10.DBX40.0-49.7																																																
PICA1210_H	(Sub) pressure dryer too high	dbx40.0				X	X	X	X	X		X	X		X	X	X	X	X	X							X									X			X	X	X	X		X	X	X		60		
PICA1210_L	(Sub) pressure dryer too low	dbx40.1				X	X	X	X	X		X	X		X	X	X	X	X	X							X									X			X	X	X	X		X	X	X		60		
PDICA3200_H	Pressure difference filter high	dbx40.3			X																							X																						
TICA1113_L	Product temperature dryer low (warning)	dbx40.6			X																																												
TICA1113_LL	Product temperature dryer too low (failure)	dbx40.7				X	X	X	X	X		X	X		X																									X	X	X	X						60		
TICA1113_H	Product temperature dryer high (warning)	dbx41.0			X																																												
TICA1120_H	Product temperature cooler, high (warning)	dbx41.3			X																																												
TSA1102_HH	Supply air temperature too high (failure)	dbx41.4				X	X	X	X	X		X	X		X																									X	X	X	X		X	X	X		60		
TICA1101_H	Supply air temperature high (warning)	dbx41.6			X																																												
TSA3110_HH	Exhaust air temperature too high (failure)	dbx41.5				X	X	X	X	X		X	X		X																									X	X	X	X		X	X	X		60		
TICA1126_H	Exhaust air temperature high (warning)	dbx41.7			X																																												
PIA1201_L	Pressure undercase 1st section dryer, low (warning)	dbx42.0			X																																												
PIA1201_H	Pressure undercase 1st section dryer, high (warning)	dbx42.1			X																																												
PIA1203_L	Pressure undercase cooler section, low (warning)	dbx42.2			X																																												
PIA1203_H	Pressure undercase cooler section, high (warning)	dbx42.3			X																																												
QI7700_H	Moisture product infeed, high (warning)	dbx42.5			X																																												
QI8700_H	Moisture product dry sand, high (warning)	dbx43.0			X																																												
QIA3423_H	Dust measurement recirculation air, high (warning)	dbx43.3			X																																												
QIA3423	Dust measurement recirculation air, failure instrument	dbx43.4			X																																												
QIA3425_H	Dust measurement exhaust air, high (warning)	dbx43.6			X																																												
QIA3425	Dust measurement exhaust air, failure instrument	dbx43.7			X																																												
	Failure bits (mA signals) DB10.DBX50.0-59.7																																																
PICA1210	(Sub) pressure dryer (mA signal out of range) *1	dbx50.1				X	X	X	X	X		X	X		X	X	X	X	X	X							X									X			X	X	X	X		X	X	X		60		
PDICA3200	Pressure difference filter (mA signal out of range)	dbx50.2				X																						X																						

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AMPP INDUSTRIAL AUTOMATION

		Datablock bit (DB10)	EFFECT	Report : on screen	Warning : on screen	Failure : on screen	Stop : M73 Belt conveyor wet sand bunker 1	Stop : M74 Belt conveyor wet sand bunker 2	Stop : M75 Belt conveyor wet sand bunker 3	Stop : M76 Belt conveyor wet sand bunker 4		Stop : M71 Collect conveyor wet sand	Stop : M72 Main belt conveyor wet sand		Stop : M01 Dryer drive	Stop : M18 Supply fan cooler	Stop : M21 Combustion air fan	Stop : M23 Recirculation air fan	Stop : M24 Sleeve cooling fan	Stop : M25 Exhaust fan		Stop : M33 Screw conveyor filter	Stop : M39 Screw conveyor dust	Stop : M77 Outlet belt conveyor dry sand	Stop : M63 Bucket elevator	Stop : M59 Oversize screen		Stop : E07 Filter cleaning	Start : E07 filter cleaning (fixed pause time)	Stop : E08 Filter cleaning silo's	Stop : M27 Fan filter dry sand silo's	Stop and close to bin: EP59 Oversize screen silo's/bin	Stop and close: EP101 valve dry sand silo 101	Stop and close: EP102 valve dry sand silo 102	Stop and close: EP103 valve dry sand silo 103	Stop and close: EP104 valve dry sand silo 104	Stop and close: EP105 valve dry sand silo 105		Stop : PICA1210 (Sub) pressure controller		Stop : Product supply controller TICA1101, TICA1126	Product supply to start value	Stop : Product temperature dryer controller TICA1113	TICA1126 Exhaust air temperature to start setpoint		Stop : Temperature controller TICA1101, TICA1126	Stop : E12 Burner	Close : V35 Fuel control valve	ACTION AFTER...minutes	Start : Stop sequence	Increase product supply to other selected bunkers	
CAUSE																																																				
TICA1101	Supply air temperature (mA signal out of range)	dbx50.4				X	X	X	X	X		X	X		X																								X	X	X	X		X	X	X		60		
TICA1126	Exhaust air temperature (signal out of range)	dbx50.5				X	X	X	X	X		X	X		X																								X	X	X	X		X	X	X		60		
TICA1113	Product temperature dryer (signal out of range) **2	dbx50.6				X	X	X	X	X		X	X		X																								X	X	X	X				XB		60		
TIA1120	Product temperature cooler (signal out of range)	dbx51.0			X																																													
TI1401	Supply air temperature cooler (signal out of range)	dbx51.3			X																																												
M21	Combustion air fan, current (mA signal out of range)	dbx51.4			X																																												
M24	Sleeve cooling fan (mA signal out of range)	dbx51.5			X																																												
M27	Fan filter dry sand silo's, current (mA signal out of range)	dbx51.6			X																																												
M33	Screw conveyor filter, current (mA signal out of range)	dbx51.7			X																																												
M39	Screw conveyor dust filter, current (mA signal out of range)	dbx52.0			X																																												
M59	Oversize screen, current (mA signal out of range)	dbx52.1			X																																												
M77	Outlet conveyor dry sand, current (mA signal out of range)	dbx52.2			X																																												
QI7700	Moisture measurement wet sand, (mA signal out of range)	dbx52.4			X																																												
TI7100	Temperature measurement wet sand, (mA signal out of range)	dbx52.5			X																																												
QI8700	Moisture measurement dry sand, (mA signal out of range)	dbx52.6			X																																												
TI8100	Temperature measurement dry sand, (mA signal out of range)	dbx52.7			X																																												
QIA3423	Dust measurement recirculation air, (mA signal out of range)	dbx53.1			X																																												
QIA3425	Dust measurement exhaust air, (mA signal out of range)	dbx53.2			X																																												
PIA1201	Pressure undercase 1st section dryer (mA signal out of range)	dbx53.3			X																																												
PIA1202	Pressure undercase 2nd section dryer (mA signal out of range)	dbx53.4			X																																												
PIA1203	Pressure undercase cooler section (mA signal out of range)	dbx53.5			X																																												
FI2410	Gas flow measurement (mA signal out of range)	dbx53.6			X																																												
	Failure bits (burner) DB10.DBX60.0-69.7																																																	
E12-PSL3	Burner: Gas-leakage control	dbx60.0				X	X	X	X	X		X	X		X																								X	X	X	X		X	X	X		60		
E12-PSL2	Burner: Air pressure control	dbx60.1				X	X	X	X	X		X	X		X																								X	X	X	X		X	X	X		60		
E12-PSH1	Burner: High gas pressure	dbx60.2				X	X	X	X	X		X	X		X																								X	X	X	X		X	X	X		60		
E12-PSL1	Burner: Low gas pressure	dbx60.3				X	X	X	X	X		X	X		X																								X	X	X	X		X	X	X		60		
E12-OK	Burner: Flame failure, not ok	dbx60.4				X	X	X	X	X		X	X		X																								X	X	X	X		X	X	X		60		
	Burner: General failure ETAMATIC	dbx60.5				X	X	X	X	X		X	X		X																								X	X	X	X		X	X	X		60		
	Burner: Not ready (No automatic operation within 10 minuts)	dbx60.6				X	X	X	X	X		X	X		X																								X	X	X	X		X	X	X		60		
	Burner: No communication with burner cabinet	dbx60.7				X	X	X	X	X		X	X		X																								X	X	X	X		X	X	X		60		
	Failure bits (general) DB10.DBX70.0-71.7																																																
LSA7301	Level wet sand bunker 1 low (flashlight active)	dbx70.0			X																																												
LSA7302	Level wet sand bunker 2 low (flashlight active)	dbx70.1			X																																												
LSA7303	Level wet sand bunker 3 low (flashlight active)	dbx70.2			X																																												
LSA7304	Level wet sand bunker 4 low (flashlight active)	dbx70.3			X																																												
LSA8301	Level dry product silo 101 high	dbx70.5			X																																											X		
LSA8302	Level dry product silo 102 high	dbx70.6			X																																											X		
LSA8303	Level dry product silo 103 high	dbx70.7			X																																											X		
LSA8304	Level dry product silo 104 high	dbx71.0			X																																											X		
LSA8305	Level dry product silo 105 high	dbx71.1			X																																											X		
	***1: operator can run exhaust fan manual in AUTO mode**																																																	
	****2: TICA1113 can be switched off**																																																	
	XB: Close calculated steps based on burner temperature																																																	

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