

**FOOD PROCESSING**

**Project Overview:**

The project involved the system upgrade of the plants sausage manufacture. A previous manual process which relied upon operators to add product manually based on time duration resulted in an inconsistent product. Using PLC control operator error could be minimised providing a more consistent end product.

A User-friendly Operator Interface allowed the operator to select the product to be manufactured. The sequence would run the required number of steps prompting for operator intervention as and when required.

**SANITARIUM HEALTHFOODS**

**Details:**

The system used the Allen Bradley Micrologix 1500 complete with PanelView Plus Operator Interface.

Functions include:

- Batch processing
- Selection of up to 7 types of product
- Mixing control (high / low speed)
- Vacuum Pump
- Water solenoid control
- Cooking oil supply
- Status display
- Alarm functions

PLC - Micrologix 15000

HMI - RS View

NETWORKS - DF1



for service contact Automation IT phone 07 3299 3844

**LL Sausage Mix 1 of 2**

**MIXING ACKNOWLEDGE READY FINAL STEP**

STEP 0	<b>Lid Interlock</b>	OPEN	Hot Dog
STEP 1	<b>Mixer Hi Speed</b>	RUNNING	START STEP1 [K9]
STEP 2	<b>Mixer Lo Speed</b>		AKNOWLEDGE [K10]
STEP 3	<b>Stirrer</b>	RUNNING	Number Cooks [K11]
STEP 4	<b>Vacuum Pump</b>	RUNNING	MAIN MENU [K12]
STEP 5	<b>Water (mL)</b>		
STEP 6	<b>Oil (mL)</b>		
<b>STEP 7</b>	<b>Motor Current</b>	25	
STEP 8	<b>Elapsed Time</b>	12	
STEP 9			
<b>1 of 7</b>			

Mixer Low Speed Selection Enabled      Water Activate Disabled Engage Hose