



US EXPORT-IMPORT CORPORATION

GRAPHIC CONTROL Graphic process control and reports

A15-1 HI LEVEL

ampere

Auto to bin no.

Auto start/stop

Run color

Alarm

Mouse click this graphic for manual control than select on or off.

stop color

RECIPE START RECIPE STOP HOLD BATCH STOP SET&REPORT C06 C07 MENU KEMIN EXIT

[1015,535] X=0,Y=0,W=1016,H=693 Mem : 261620 KB

C16 OVERLOAD

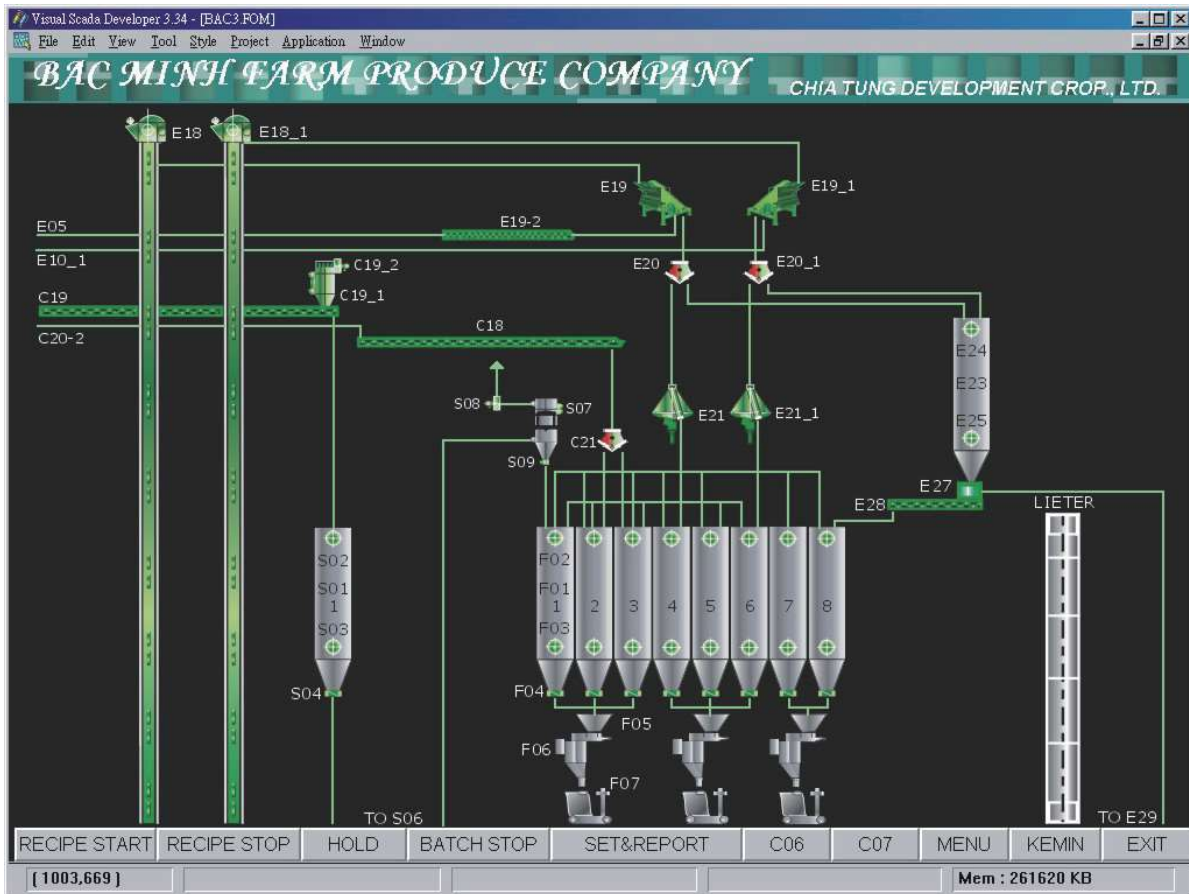
System finish

System inter-lock

Over load color

RECIPE START RECIPE STOP HOLD BATCH STOP SET&REPORT C06 C07 MENU KEMIN EXIT

[1015,525] X=0,Y=0,W=1016,H=693 Mem : 261620 KB

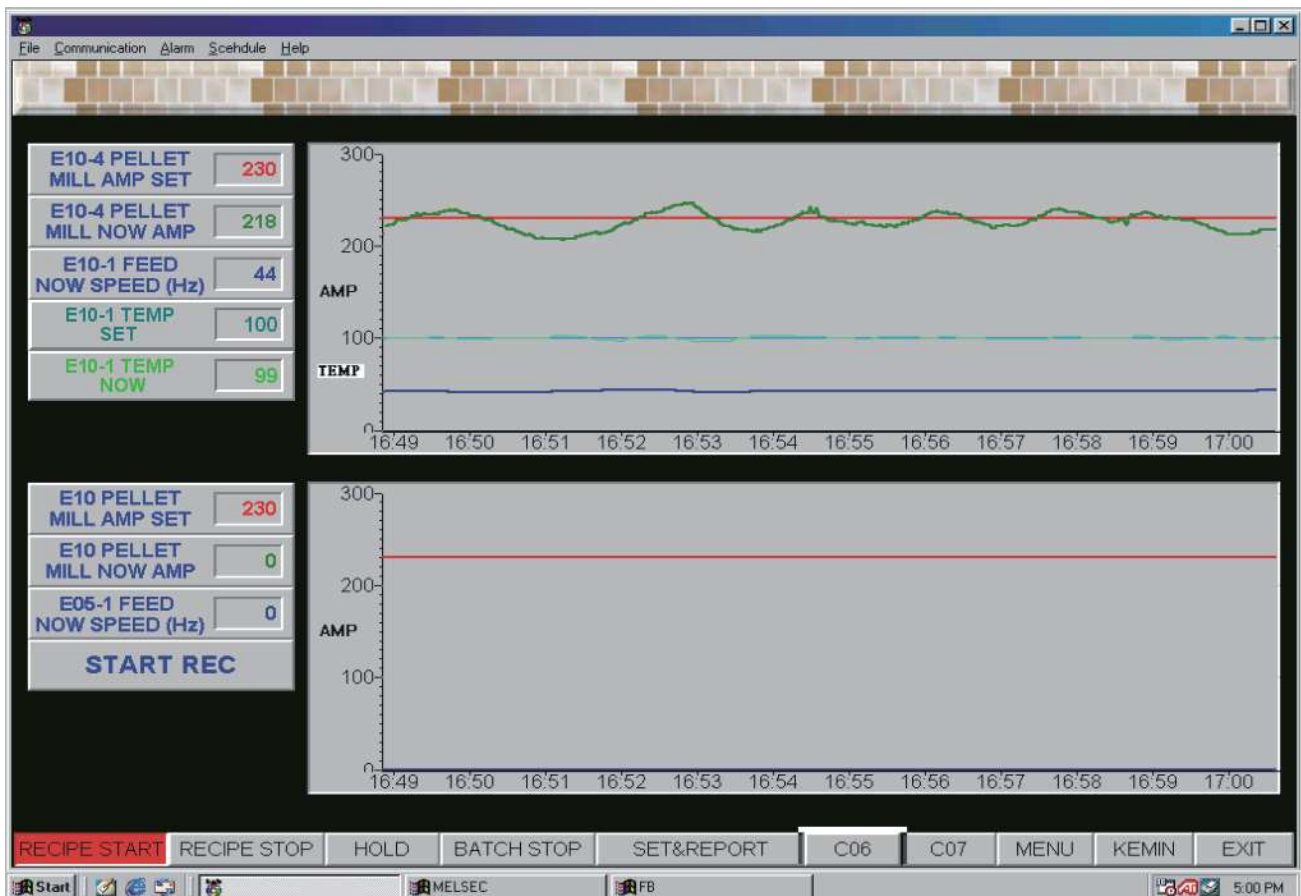


Hammer mill P.I.D control

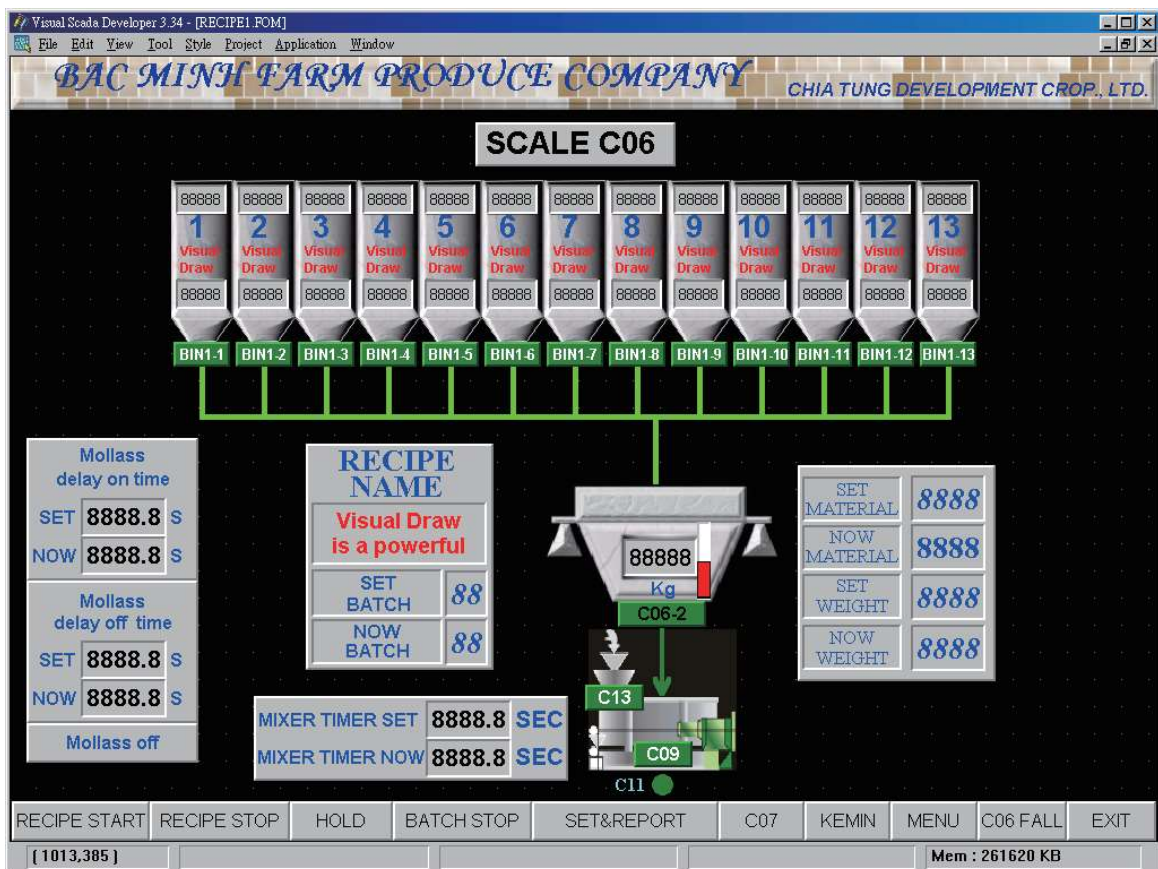


The operation of hammer mill are done by graphic on the monitor and programmer format, step 1 is to pre-set the required working ampere of main motor the P.I.D. mode will automatic control and regulate the speed of feeder by current ampere auto-feedback mode in order to run the motor at the pre-set ampere. The above figure is illustrate the hammer mill is starting-up while the bin is empty. The feeder is automatic stop and then automatic start again.

Pellet mill P.I.D control



Batch dosing system



Batch dosing system

Visual Scada Developer 3.34 - [RECIPE2.FOM]

BAC MINH FARM PRODUCE COMPANY CHIA TUNG DEVELOPMENT CROP. LTD.

DOSING

SCALE C07

Visual Draw is a powerful

SET MATERIAL 8888
NOW MATERIAL 8888
SET WEIGHT 8888
NOW WEIGHT 8888

SET BATCH 88
NOW BATCH 88

MIXER TIMER SET 8888.8 SEC
MIXER TIMER NOW 8888.8 SEC

88888.8 Kg
C07-2
C13
C09
C11

RECIPE START RECIPE STOP HOLD BATCH STOP SET&REPORT C06 KEMIN MENU C07 FALL EXIT

[990,686] Mem : 261620 KB

Batch dosing system

Visual Scada Developer 3.34 - [RECIPE3.FOM]

BAC MINH FARM PRODUCE COMPANY CHIA TUNG DEVELOPMENT CROP. LTD.

DOSING

SCALE KEMIN

Visual Draw is a powerful

SET MATERIAL 8888
NOW MATERIAL 8888
SET WEIGHT 888.88 Kg
NOW WEIGHT 888.88 Kg

SET BATCH 88
NOW BATCH 88

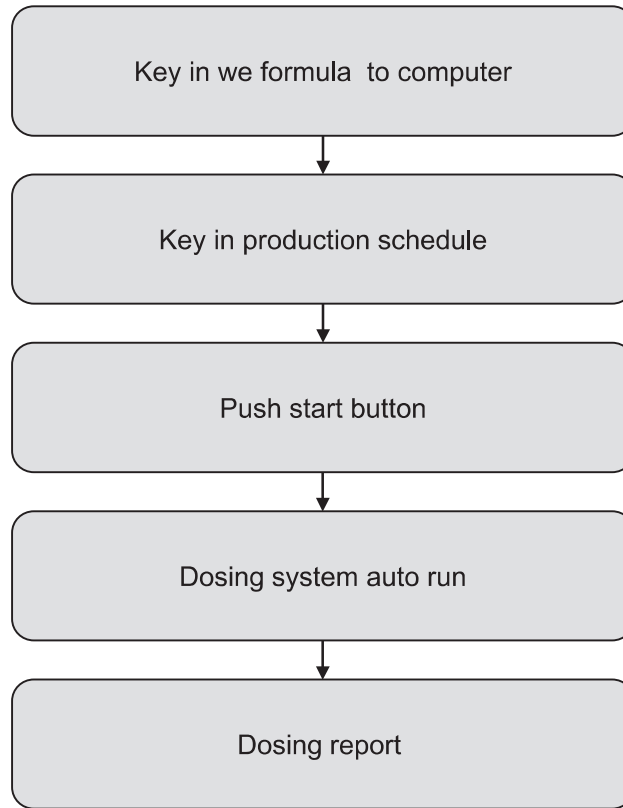
MIXER TIMER SET 8888.8 SEC
MIXER TIMER NOW 8888.8 SEC

888.88 Kg
TO MIXER
C13
C09
C11

RECIPE START RECIPE STOP HOLD BATCH STOP SET&REPORT C06 C07 MENU KEMIN FALL EXIT

[1012,663] Mem : 261620 KB

easy 5 step dosing procedure, give you nicely dosing and completion report



dosing management - can remember 10000 dosing record in computer

Serial	ID	Name	Type	Date	Weight	User
0007	DREAM 5	DREAM 5		2003.9.12	1931	
0008	WS 5004	WS 5004		2003.9.13	1918	
0009	TIME 4	TIME 4		2003.9.15	1909	
0010	WS 5005	WS 5005		2003.9.17	1934	

Serial	ID	Name	Bin1	Weight	Scale	Feed Condit	Value	Remark
0010	10	FISH OIL		20	0000			
0001	1	FISH MEAL	1	466	0001			
0002	2	SQUID LIVER	2	320	0001			
0003	3	CORN GLUTEN	3	25	0001			
0005	5	DREAM	5	60	0001			
0007	7	WDT A/C	7	20	0001			
0008	8	WHEAT FLOUR	8	520	0001			
0009	9	SOYA BEAN	9	500	0001			

schedule management – available to key in today all schedule let system auto run

Schedule

Serial	ID	NO	NAME	BATCH	CURR...	STATURS	MULTI.	START	STAR...	END D...	END T...	OPER.	Class1
1	0010	WS 50...	WS 5005	5	5	Finish(★)	1	2003-0...	13:09:27	2003-0...	13:52:00	0	0

NAME | VALUE

Class1
 Class2
 Operator
 Customer
 Other

C:\WOOSUNG Thread is Running... Built : Jun 3 2003, 09:18:52 整批列印, 0x4E(M)

material management - can change bin name anytime

Material Management

Setting(S) Product Feeding LOg AUX.

Serial	ID	Name	Bin1	Bin2	Bin3	Bin4	Bin5	Bin6	Replace 1	Replace 2	Date	Scale	LogIn
0001	1	FISH MEAL	1								2003.8.20	0001	
0002	2	SQUID LIVER	2								2003.7.10	0001	
0003	3	CORN GLUTEN	3								2003.9.10	0001	
0004	4	WOOSUNG	4								2003.9.10	0001	
0005	5	DREAM	5								2003.9.10	0001	
0006	6	TIME	6								2003.9.10	0001	
0007	7	WDT A/C	7								2003.9.10	0001	
0008	8	WHEAT FLOUR	8								2003.9.10	0001	
0009	9	SOYA BEAN	9								2003.7.10	0001	
0010	10	FISH OIL									2003.8.22	0000	

New Edit DEL Print Exit

batch report record every batch weight. And system can member every batch over 10 years

Recipe Batch Report

Date: 2003/ 9/10 UP DOWN Print Exit

Schedule: 13:33:45, WOOSUNG 6 Batch: 3 UP DOWN

Detail

Finish Date: 2003-09-10 Finish Time: 13:51:01 Batch: 3 To 5 Operator: KHANH
 Class1: A Class2: MID Customer: Order: -1
 Recipe ID: WOOSUNG Rcp. Name: WOOSUNG Time USE: 276 SEC

Serial	Material ID	Material Name	Set	Actual	Error	
1	1	FISH MEAL	557.000	557.000	0.000	
2	2	SQUID LIVER	300.000	299.000	-1.000	★
3	4	WOOSUNG	40.000	40.000	0.000	
4	8	WHEAT FLOUR	520.000	520.000	0.000	
5	9	SOYA BEAN	457.000	458.000	1.000	★
6	10	FISH OIL	20.000	20.000	0.000	
Sun(Auto+Repla			1894.000	1894.000	0.000	
Sun(Man)			0.000	0.000	0.000	
Total			1894.000	1894.000	0.000	

total batch report

Recipe Batch Report

Date: 2003/ 9/12 UP DOWN Print Exit

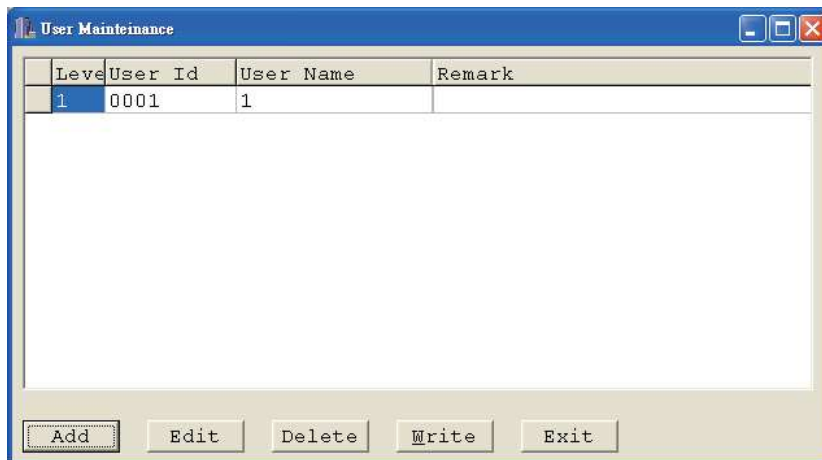
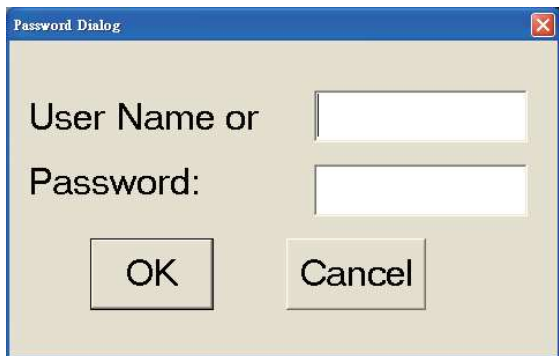
Schedule: 09:20:10, WOOSUNG 0 Batch: 9999 UP DOWN

Detail

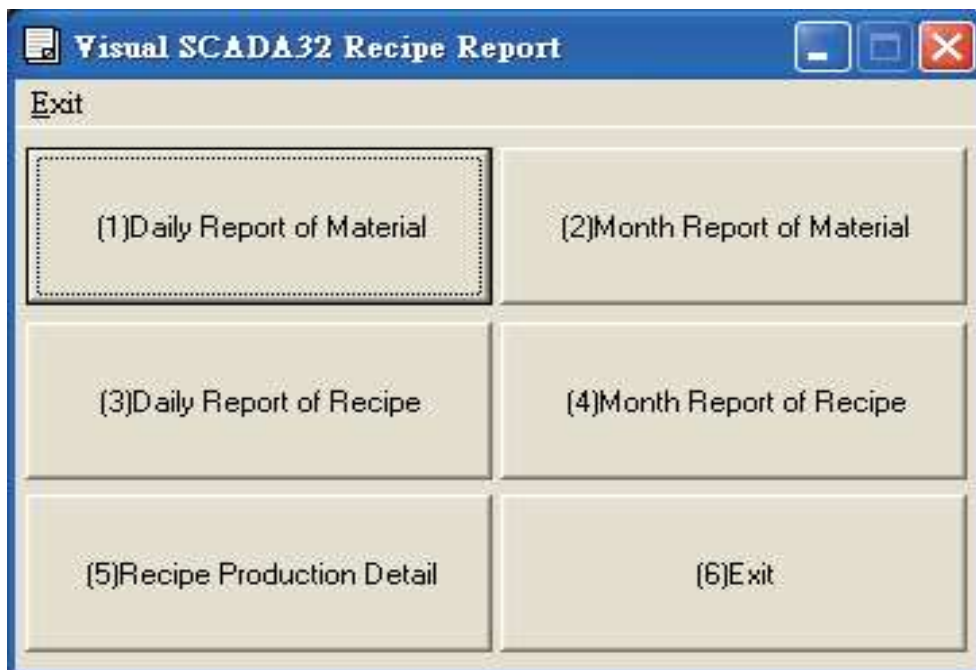
Finish Date: 2003-09-12 Finish Time: 09:35:43 Total Batch 5 Operator: KHANH
 Class1: Class2: MORNING Customer: Order: -1
 Recipe ID: WOOSUNG Rcp. Name: WOOSUNG Time USE: 289 SEC

Serial	Material ID	Material Name	Set	Actual	Error	
1	1	FISH MEAL	2721.000	2721.000	0.000	
2	2	SQUID LIVER	270.000	271.000	1.000	
3	3	CORN GLUTEN	120.000	122.000	2.000	
4	4	WOOSUNG	120.000	119.000	-1.000	
5	8	WHEAT FLOUR	1560.000	1558.000	-2.000	
6	9	SOYA BEAN	900.000	903.000	3.000	
Sun(Auto+Repla			5691.000	5694.000	3.000	
Sun(Man)			0.000	0.000	0.000	
Total			5691.000	5694.000	3.000	

password. Protect our system and dosing procedure



report menu



material day report

A screenshot of a report window with a menu bar (檔案(F), 編輯(E), 格式(O), 檢視(V), 說明(H)) and a title bar. The report content is as follows:

```

104520030910 00:00:00104620030910 23:59:59
=====
1047 1048 1049 1050 1051 1052 1053
=====
1 1 FISH MEAL 8095.00 8085.00 -10.00 0.12%
2 2 SQUID LIVER 4480.00 4474.00 -6.00 0.13%
3 3 CORN GLUTEN 300.00 303.00 3.00 1.00%
4 5 DREAM 300.00 304.00 4.00 1.33%
5 8 WHEAT FLOUR 7800.00 7817.00 17.00 0.22%
6 9 SOYA BEAN 6870.00 6903.00 33.00 0.48%
7 4 WOOSUNG 400.00 399.00 -1.00 0.25%
8 10 FISH OIL 200.00 200.00 0.00 0.00%
=====
28445.00 28485.00
=====

```


material week or month report

MR T6D.tmp - 記事本

檔案(F) 編輯(E) 格式(O) 檢視(V) 說明(H)

104520030901 00:00:00104620030929 23:59:59

```

=====
1047 1048      1049                1050                1051                1052                1053
-----
1   1          FISH MEAL           61191.00           61125.00           -66.00             0.11%
2   2          SQUID LIVER        30422.00           30409.00           -13.00             0.04%
3   8          WHEAT              57200.00           57526.00           326.00             0.57%
4   9          SOYA BEAN          49675.00           49891.00           216.00             0.43%
5  10          FISH OIL            900.00             900.00             0.00              0.00%
6   5          CORN GLUTEN        2970.00            3026.00            56.00             1.89%
7   6          REUSE2 M/5,6      1180.00            1193.00            13.00             1.10%
8   3          CORN GLUTEN        1700.00            1711.00            11.00             0.65%
9   4          WOOSUNG            1420.00            1419.00            -1.00             0.07%
10  7          WDT A/C            660.00             637.00            -23.00            3.48%
=====
                                207318.00          207837.00
=====

```

daily dosing report

RR T6B.tmp - 記事本

檔案(F) 編輯(E) 格式(O) 檢視(V) 說明(H)

104520030903 00:00:00104620030903 23:59:59

```

=====
1047 1054      1055                1056
-----
1   WS 5005      WS 5005                9224.00
2   WS 5004      WS 5004                9204.00
=====
                                18428.00
=====

```

weekly or monthly dosing report

RR16C.tmp - 記事本

檔案(F) 編輯(E) 格式(O) 檢視(V) 說明(H)

104520030901 00:00:00104620030929 23:59:59

=====

	1047	1054	1055	1056
1	WS 5005		WS 5005	38035.00
2	WS 5004		WS 5004	18798.00
3	DREAM 4		DREAM 4	32023.00
4	WS 5006		WS 5006	9227.00
5	DREAM 2		DREAM 2	3671.00
6	DREAM 5		DREAM 5	28549.00
7	WS 5003		WS 5003	9247.00
8	DREAM 6		DREAM 6	9472.00
9	TIME 4		TIME 4	24643.00
10	DREAM 3		DREAM 3	9519.00
11	WOOSUNG 6		WOOSUNG 6	18959.00
12	WOOSUNG 0		WOOSUNG 0	5694.00
				=====
				207837.00
				=====

alarm report

HAlarm32

Start Date: 2003/ 9/ 3
 Start Time: 0:00
 Load Time: 24:00

Alarm Level To
 Alarm Group 0

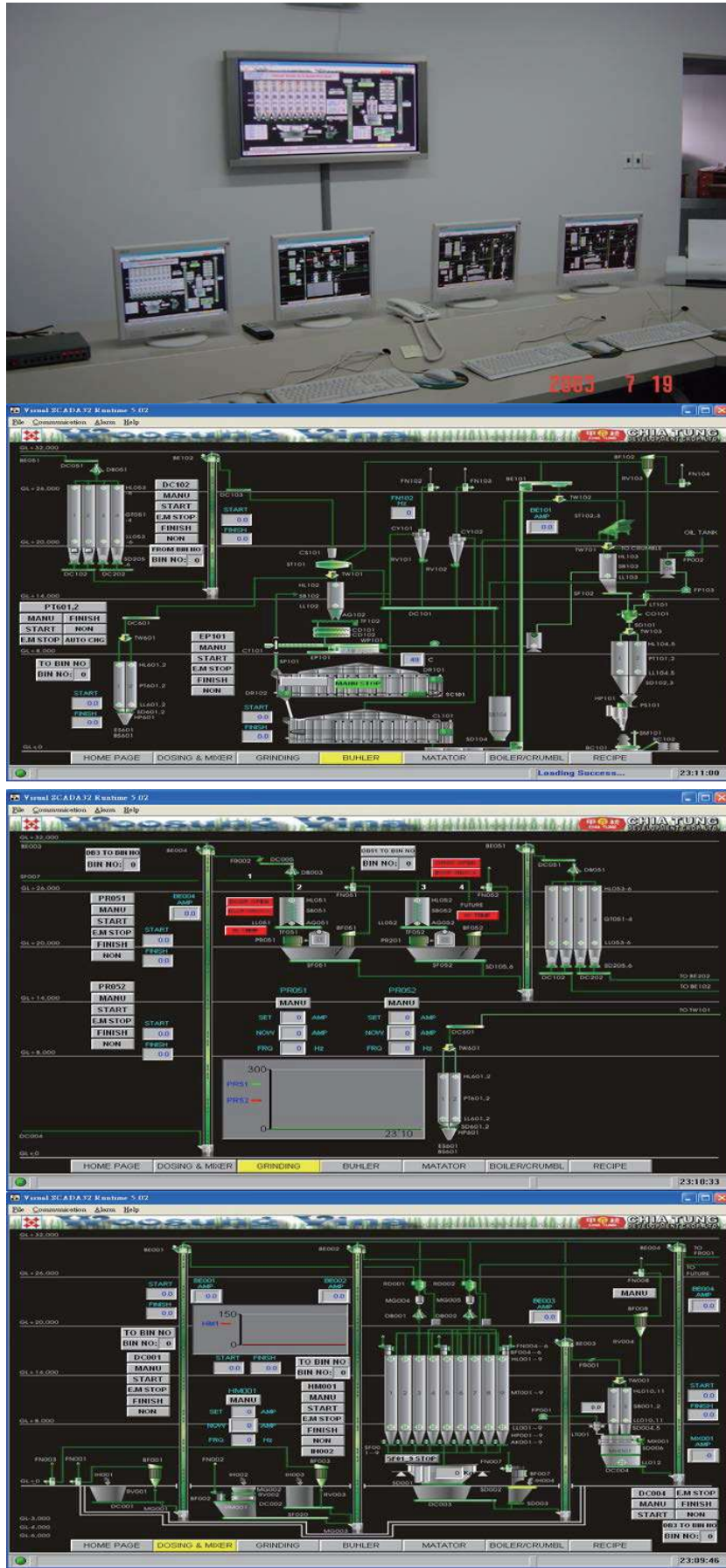
Alarm Tag: View Chart

Buttons: Refresh, Exit, Print Statistic, Print List

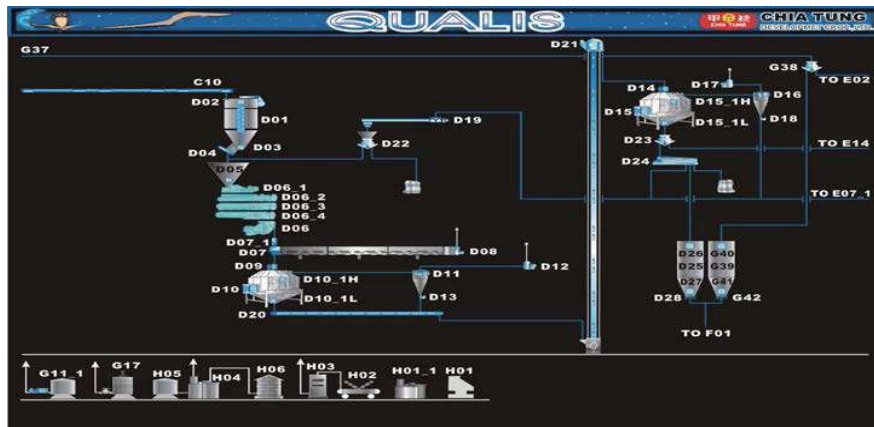
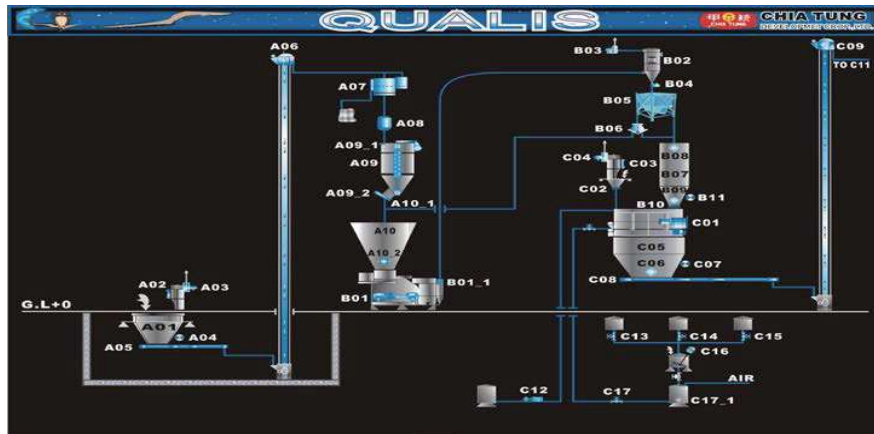
Tag Name	Alarm Times	Alarm Time
BUHLER_ALM	12	3:53:32
HLO04	2	7:31:32
HLO06	2	7:31:32
HLO10	2	0:10:29
HLO11	22	0:37:55
HLO51	25	0:27:56
HLO52	48	0:29:14

Alarm Date	Alarm Time	Tag Name	Alarm Value	Alarm Level	Alarm Group	Message	OK Time	Act Time
2003/09/03	07:56:38	HLO04	1			ON	08:52:05	08:52:05
2003/09/03	07:56:38	HLO06	1			ON	08:52:05	08:52:05
2003/09/03	07:56:38	PRO51_POSI	1			ON	08:52:05	08:52:05
2003/09/03	07:56:38	HLFP202	1			ON	08:52:05	08:52:05
2003/09/03	07:56:38	BUHLER_ALM	1			ON	08:52:05	08:52:05
2003/09/03	07:56:38	SD205NC	1			ON	08:52:05	08:52:05
2003/09/03	07:56:38	SD104NC	1			ON	08:52:05	08:52:05
2003/09/03	07:56:38	SD204NC	1			ON	08:52:05	08:52:05
2003/09/03	10:26:57	HLO04	1			ON	17:02:02	17:02:02
2003/09/03	10:26:57	HLO06	1			ON	17:02:02	17:02:02
2003/09/03	10:26:57	PRO51_POSI	1			ON	11:39:36	11:39:36
2003/09/03	10:26:57	HLFP202	1			ON	11:27:06	11:27:06
2003/09/03	10:26:57	BUHLER_ALM	1			ON	12:36:47	12:36:47
2003/09/03	10:26:58	SD205NC	1			ON	17:02:02	17:02:02
2003/09/03	10:26:58	SD104NC	1			ON	17:02:02	17:02:02
2003/09/03	10:26:58	SD204NC	1			ON	17:02:02	17:02:02
2003/09/03	11:27:31	HLFP202	1			ON	11:30:11	11:30:11
2003/09/03	11:30:29	HLFP202	1			ON	11:53:29	11:53:29
2003/09/03	11:30:37	HLO11	1			ON	11:30:38	11:30:38
2003/09/03	11:31:08	HLO11	1			ON	11:31:22	11:31:22
2003/09/03	11:31:30	HLO11	1			ON	11:31:56	11:31:56

WOOSUNG VIETNAM



GUYOMARCH VITNAM



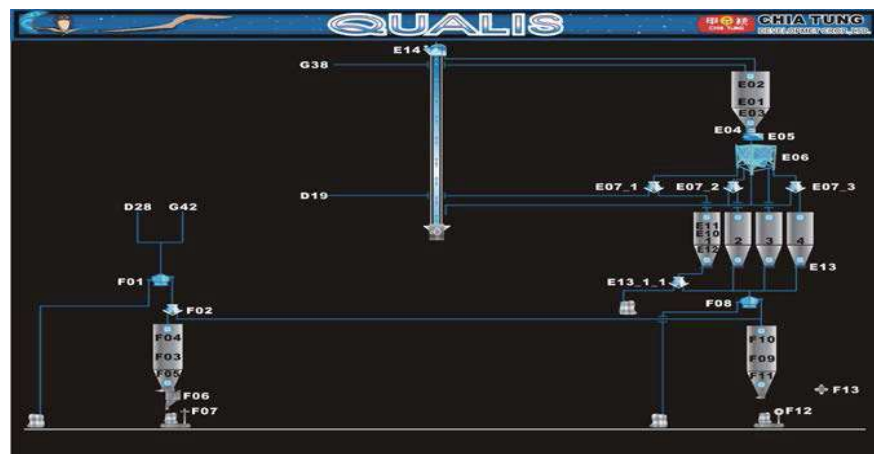
QUALIS CHIA TUNG

Control interface showing a control panel with various parameters and a 3D model of a boiler. The interface includes a menu for 'G11 SYSTEM' and 'G30 SYSTEM', and a 'BOILER PCM' section with a 3D model of a boiler. The control panel displays various parameters such as 'SET', 'NOW', 'PRAM', and 'MENU SET' for different systems.

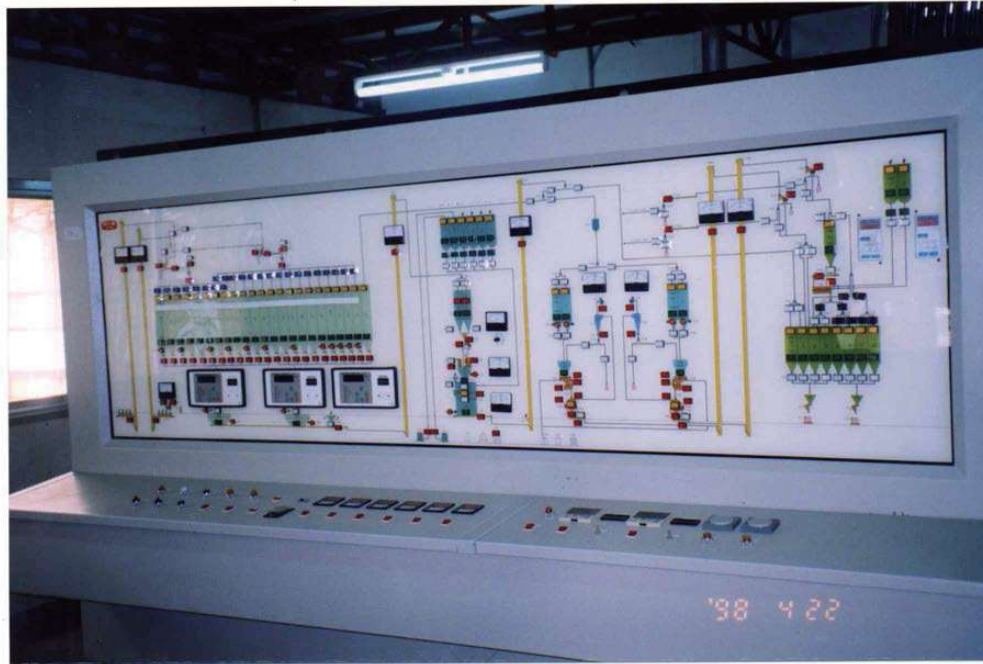
Parameter	Value	Unit
SET	888.8	°C
NOW	888.8	°C
PRAM	8888	kg/h
MENU SET	888.8	Hz
SET	888.8	%
NOW	8888	kg/h
MENU SET	888.8	Hz
SET	888.8	Hz
NOW	8888	Hz
PRAM	8888	Hz

NON BZ STOP MIXER EXTRUDER PELLET BAGGING TIME SET REPORT

Mem : 261620 KB

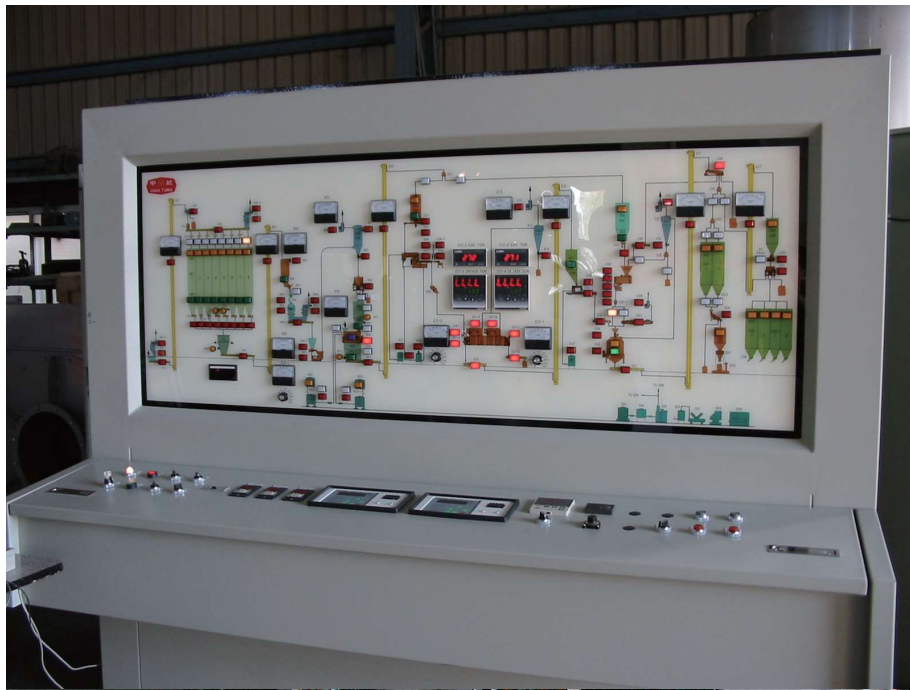


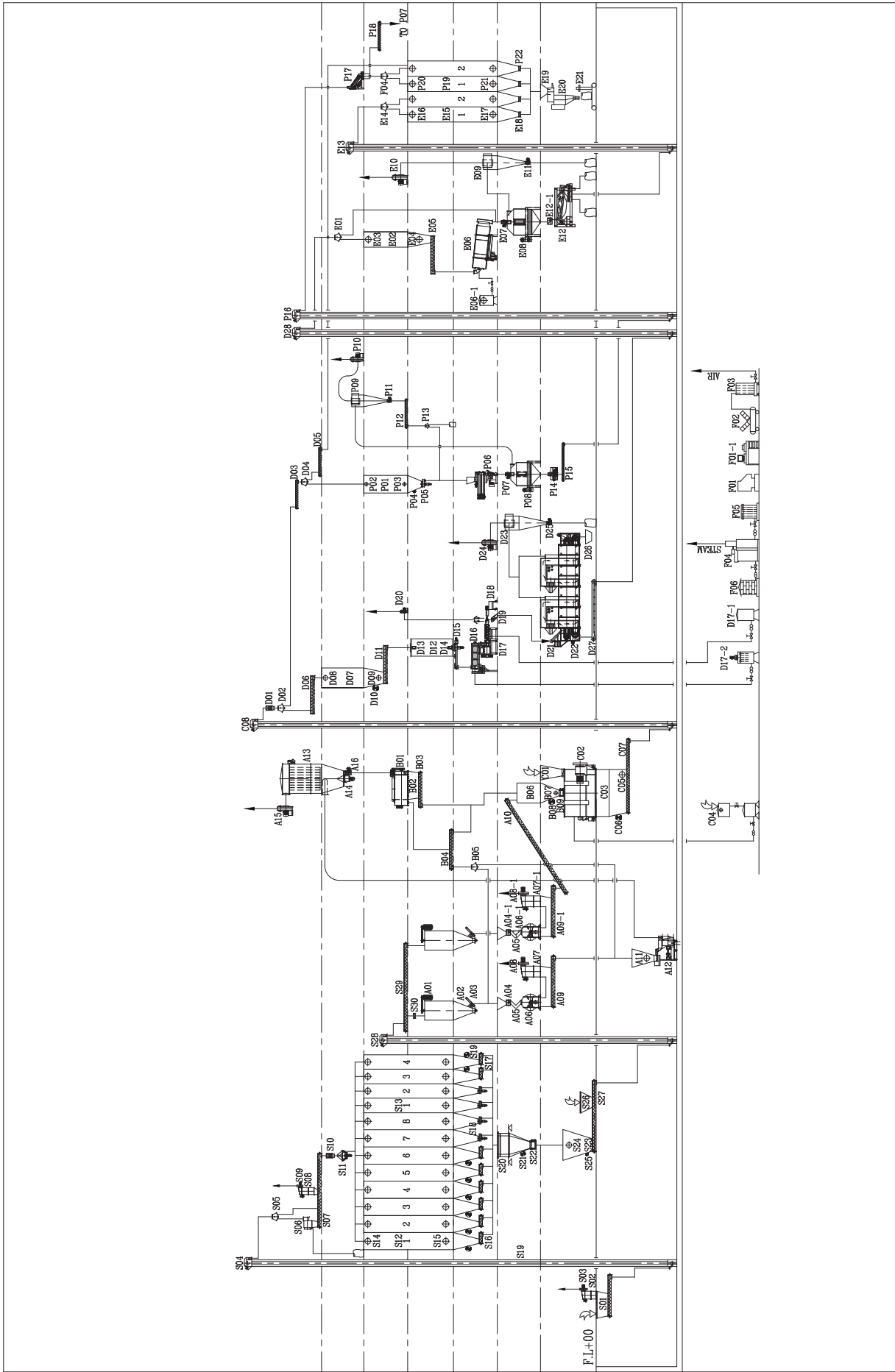
CONTROL PANEL




CENTRAL CONTROL PANEL

1. Control panel box made of SS41 mild steel 2.0mm thickness. With anti corrosive painting and finishing with hot oven paint coating. There is an ARCRY board in front face with mimic process diagram and indication lamp, operation bottom switch, ampere meter. RPM meter for variable speed control and indication of speed. A key switch to start and stop the whole system.
2. There is a main no-fuse break to receive the incoming power supply for short-circuit protection then divided into three branches through copper BUS-BAR and branch no fuse breaker. There is also a no fuse beaker for motor and control devices.
3. Motor starter: with individual magnetic contactor for every motor and thermo type overload protection. For motors 20HP or bigger are quipped with Y - starter.
4. Multiple function frequency inverter for variable speed of feeder for hammermill, pelletmill and molasses pump which has speed tuning in mimic panel board.
5. PLC process control for inter-lock control, process logic program and inter-phase signal transmission for batch dosing and mixing control.





 Marketed by US EXPORT IMPORT CORP	Eng. Name 4TPH FLOATING FISH FEED + 6 TPH SINKING FISH FEED OR 10TPH POULTRY	Drawn By LIN	Approved By Scale/Unit	DATE REVISION	Sheet No.
	Drawing No. D:\DWG3\LF\LF20211201	Checked By	NO	NO	