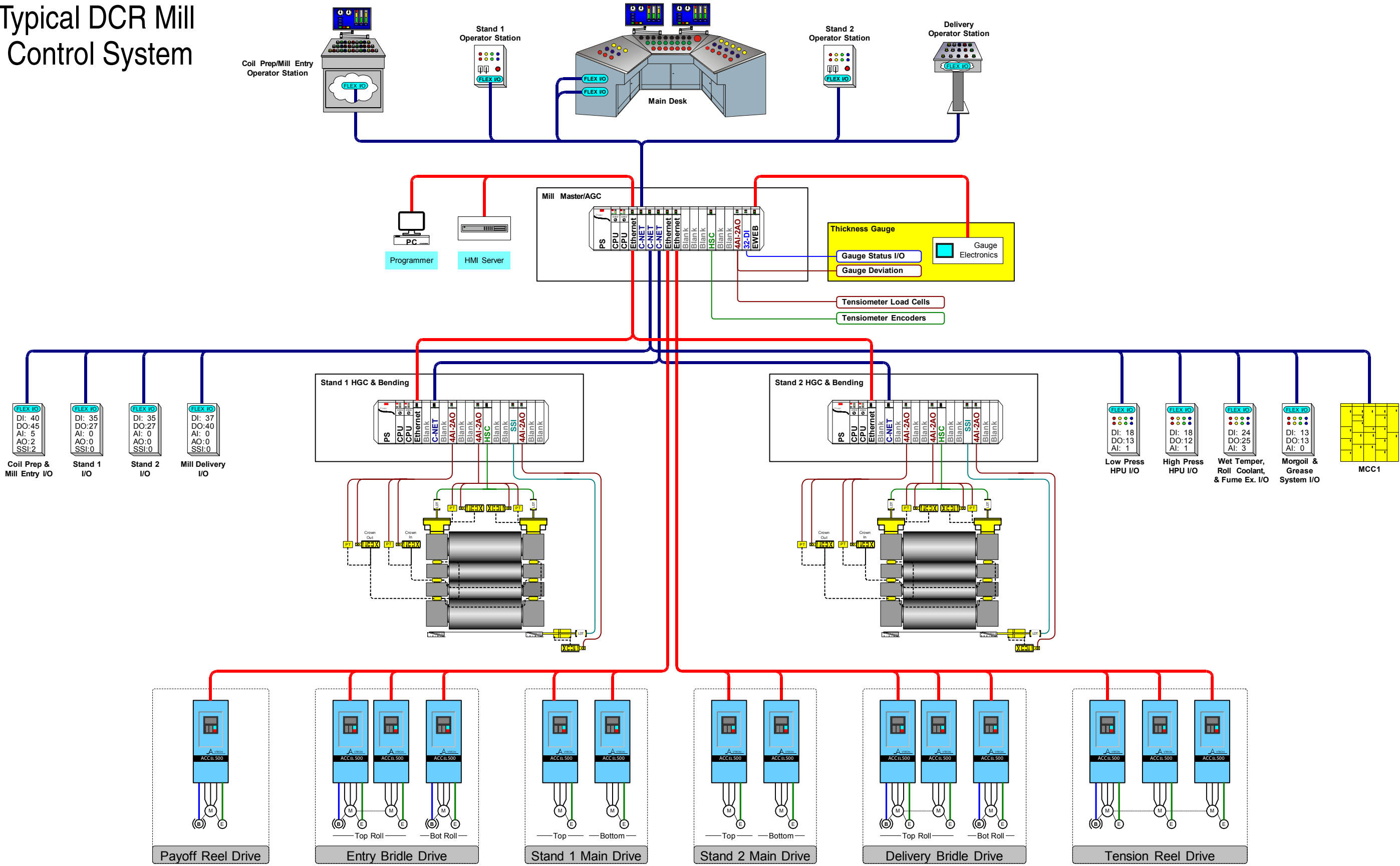


# Typical DCR Mill Control System



Coil Prep/Mill Entry Operator Station

Stand 1 Operator Station

Stand 2 Operator Station

Delivery Operator Station

Mill Master/AGC

PS	CPU	CPU	Ethernet	C-NET	C-NET	Ethernet	Ethernet	Blank	Blank	HSC	Blank	Blank	4AI-2AO	32-DI	EWEB
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Thickness Gauge

Gauge Status I/O	Gauge Electronics
Gauge Deviation	

Tensiometer Load Cells

Tensiometer Encoders

Stand 1 HGC & Bending

PS	CPU	Ethernet	C-NET	4AI-2AO	Blank	4AI-2AO	Blank	HSC	Blank	SSI	4AI-2AO	Blank	Blank
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Stand 2 HGC & Bending

PS	CPU	Ethernet	C-NET	4AI-2AO	Blank	4AI-2AO	Blank	HSC	Blank	SSI	4AI-2AO	Blank	Blank
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Coil Prep & Mill Entry I/O

DI: 40	DO: 45	AI: 5	AO: 2	SSI: 2
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Stand 1 I/O

DI: 35	DO: 27	AI: 0	AO: 0	SSI: 0
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Stand 2 I/O

DI: 35	DO: 27	AI: 0	AO: 0	SSI: 0
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Mill Delivery I/O

DI: 37	DO: 40	AI: 0	AO: 0	SSI: 0
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Low Press HPU I/O

DI: 18	DO: 13	AI: 1
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High Press HPU I/O

DI: 18	DO: 12	AI: 1
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Wet Temper, Roll Coolant, & Fume Ex. I/O

DI: 24	DO: 25	AI: 3
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Morgoil & Grease System I/O

DI: 13	DO: 13	AI: 0
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MCC1

ACCb.500

M E

Payoff Reel Drive

ACCb.500 ACCb.500 ACCb.500

M E M E M E

Top Roll Bot Roll

Entry Bridle Drive

ACCb.500 ACCb.500

M E M E

Top Bottom

Stand 1 Main Drive

ACCb.500 ACCb.500

M E M E

Top Bottom

Stand 2 Main Drive

ACCb.500 ACCb.500 ACCb.500

M E M E M E

Top Roll Bot Roll

Delivery Bridle Drive

ACCb.500 ACCb.500 ACCb.500

M E M E M E

Tension Reel Drive