

Addendum **Index of Figures**

Chapter 1 – Introduction		
Figure No.	Details	Page No.
1.1	Example of a Modern Control System	4
1.2	The Intelligent Main Engine	7
1.3	Working Principle of a Digitally-controlled Common Rail Engine	8

Chapter 2 – Process Control Theory		
Figure No.	Details	Page No.
2.1	A Basic Process Control System	21
2.2	The operator controls the process variable P2	22
2.3	A Typical Open Loop System Onboard Ships	23
2.4	A Manual Closed Loop System	23
2.5	A Closed Loop System	24
2.6	A Typical Application of a Temperature Control System	25
2.7	A Temperature Control System for a Lubricating Oil Cooler	26
2.8	Elements in a Closed Loop System	27
2.9	A Feedback Control System	28
2.10	The Effect of Negative Feedback	29
2.11	Terminology used in a Closed Loop System	30
2.12	Tank Level Control	31
2.13	Dead Time Representation	32
2.14	Time Constant	33
2.15	A Self-regulating System Response	34
2.16	A Non-Self-regulating System Response	34
2.17	Types of Oscillations	35
2.18	A Water Heating Process Control System	36
2.19	Dynamic Response of a Controlled System	37
2.20	Step Response	38
2.21	Characteristic Curve of the Valve System	38
2.22	A Feedforward Loop	39
2.23	Feedforward plus Feedback Loop	40
2.24	Cascade Control	41
2.25	Ratio Control	42
2.26	A Basic Digital Controller Loop	43

Addendum

Index of Figures

Chapter 2 – Process Control Theory (Continued)		
Figure No.	Details	Page No.
2.27	A Digital Controller	43
2.28	Multiple-process Control in a System	44
2.29	ISA Identification Scheme	46
2.30	Instrument Identification Symbols	48
2.31	Functional Symbols	49
2.32	Graphical Symbols of Basic Components	50
2.33	Graphical Symbols of Controllers and Actuators	51
2.34	Examples of Sensor Symbols	52
2.35	Graphical Symbols of Signal Lines	53
2.36	Examples of Regulators and Safety Valve Symbols used in P and IDs	54

Chapter 3 – Sensing Elements and Transducers		
Figure No.	Details	Page No.
3.1	Transmitter in a Closed Loop (Control Loop)	58
3.2	Elements of a Transmitter	60
3.3	Current-to-voltage Conversion	61
3.4	Current-to-voltage Conversion using a Resistor	62
3.5	Voltage-to-current Conversion	62
3.6	Pressure versus mA Current Output	64
3.7	Electric field coupling can be greatly reduced by using shielded cables	64
3.8	Co-axial and Twisted Pair Cable Arrangements	65
3.9	Signal Transmission for Electronic and Pneumatic Signals	66
3.10	Electronic Transmitter Adjusted Range	66
3.11	Pneumatic Transmitter Adjusted Range	67
3.12	Range and Linearity Error in a Temperature Sensor	68
3.13	Hysteresis and Resolution in a Temperature Sensor	69
3.14	Resolution in a Digital Temperature Sensor	70
3.15	Non-linearity in a Pressure Sensor	71
3.16	Limit Switches	71
3.17	Switch Output versus Transducer Output (Switch without Hysteresis)	72
3.18	A Pressure Switch	73
3.19	Temperature Range of Various Electrical Sensors	74

Addendum **Index of Figures**

Chapter 3 – Sensing Elements and Transducers (Continued)		
Figure No.	Details	Page No.
3.20	A Mechanical Thermometer	75
3.21	Bimetallic Strip Expansion	76
3.22	A Bimetallic Thermometer	76
3.23	RTD Resistance Change with Temperature	78
3.24	Various RTD Characteristics	78
3.25	Platinum RTD Characteristics	78
3.26	RTD and its Terminals	79
3.27	Components of an RTD	79
3.28	A 2-wire (Z Configuration) System	81
3.29	An Unbalanced Bridge Circuit	81
3.30	A 3-Wire (Y Configuration) RTD Temperature Transmitter	82
3.31	Multiple 3-wire RTDs Multiplexed into 1 Temperature Indicator	83
3.32(a)	A DIN-mounted RTD Transmitter	83
3.32(b)	An RTD's Head-mounted Temperature Transmitter	83
3.33	Connections of Various Types of RTDs in a Temperature Transmitter	84
3.34	A 4-wire (W Configuration) Approach That Enables Kelvin Sensing	84
3.35	Terminals of the RTD	85
3.36	Using a 2-Wire RTD with a 4-Wire Transmitter	85
3.37	Symbol of a Thermistor	85
3.38	Temperature versus Resistance Curves	86
3.39	Linearity Range of a Thermistor	86
3.40	A Typical Thermistor	86
3.41	Physical Specifications of a Thermistor	86
3.42	A Basic Thermistor Circuit	87
3.43	An Alternative Thermistor Circuit	87
3.44	A Simple Thermocouple Circuit	88
3.45	Basic Features of a Thermocouple	88
3.46	Internal Construction of a Typical Thermocouple	89
3.47	Characteristics of Various Thermocouples	91
3.48	Various Types of Thermocouple Junctions	92
3.49	Cold Junction Compensation	93
3.50	Cold Junction Compensation with a Filter	94
3.51	A Thermopile	95

Addendum

Index of Figures

Chapter 3 – Sensing Elements and Transducers (Continued)		
Figure No.	Details	Page No.
3.52	A Diode as a Temperature Sensor	96
3.53	Sensitivity Variation with Thermistors and Silicon Sensors	96
3.54	Comparison of Various Sensors' Characteristics	97
3.55	Infrared Temperature Sensors	98
3.56	Various Pressure Scales	99
3.57(a)	Both ends of the U T-tube open	100
3.57(b)	Pressure applied to one leg of the U T-tube	100
3.57(c)	Vacuum created in one leg of the U T-tube	101
3.58	A Potentiometric Pressure Transducer	102
3.59	Diaphragm Capsules	103
3.60	The C-type Bourdon Tube	104
3.61	Bellows	104
3.62	A Pressure Gauge Operated by Bellows	104
3.63	A Diaphragm-operated Pressure Gauge	105
3.64	A Pressure Sensor	105
3.65	A Strain Gauge	106
3.66	Strain Gauges as a Pressure Sensor	107
3.67	A Strain Gauge Pressure Transmitter	108
3.68	Bonded Strain Gauges	108
3.69	Construction of the Bonded Strain Gauge	109
3.70	The Unbonded Strain Gauge	110
3.71	Another Variant of the Unbonded Strain Gauge	110
3.72	Block Diagram of a Pressure Transducer with a Diaphragm	111
3.73	A Single Strain Gauge in a Wheatstone Bridge	112
3.74	Four Strain Gauges in a Wheatstone Bridge	112
3.75	Theory of Four Strain Gauges in a Wheatstone Bridge	113
3.76	A Basic Piezoelectric Transducer	114
3.77	Piezoelectric Pressure Sensors Using Stacks of Piezoelectric Crystals	114
3.78	A Typical Piezoelectric Pressure Sensor	115
3.79	Sectional Views of the Piezoelectric Pressure Sensor	116
3.80	A Reluctive Transducer	117
3.81	An Inductive Transducer	117

Addendum

Index of Figures

Chapter 3 – Sensing Elements and Transducers (Continued)		
Figure No.	Details	Page No.
3.82	An LVDT Pressure Transmitter	118
3.83	Sectional View of the LVDT	119
3.84	A Typical LVDT	119
3.85	LVDT Output Waveforms	119
3.86	A Linear Variable Differential Transformer's Output Circuit	120
3.87	A Capacitive Displacement Sensor	121
3.88	A Capacitor Bridge Circuit	121
3.89	A DP Sensor	122
3.90	A Variable Capacitance Transducer	123
3.91	Schematic Diagram of a Capacitive Sensor	123
3.92	An Optical Pressure Transducer	124
3.93	Various Sensors used for Level Measurement	125
3.94	The Pneumercator or Bubbler Gauge	126
3.95	A Bubbler Gauge with a DPT	126
3.96	A Resistance Tape Level Sensor	127
3.97	A Conductivity Probe Level Detection System	128
3.98	A Single Column Gauge	129
3.99	A Gauge Glass used in a Boiler	129
3.100	A Hydrostatic Head Level Sensor	130
3.101	A Boiler's Level Monitoring System	132
3.102	A Closed Tank, Wet Reference Leg	132
3.103	Zero Elevation for Level Compensation	134
3.104	Use of a Smart Transmitter with HART Protocol for Level Monitoring	135
3.105	Calculations Required during Level Monitoring	136
3.106	A Three-valve Manifold Being Introduced into Service	138
3.107	A Three-Valve Manifold Being Isolated from Service	139
3.108	A Basic Capacitance Level Transmitter	139
3.109	Capacitive Sensing	140
3.110	Level Measurement of Electrically Conductive Materials	141
3.111	A Capacitive Sensor Measuring the Level of a Conductive Liquid	141
3.112	The Three Capacitances formed by the Sensor	142
3.113	Calibration of the Level Sensors	144

Addendum

Index of Figures

Chapter 3 – Sensing Elements and Transducers (Continued)		
Figure No.	Details	Page No.
3.114	Capacitance-to-mA Conversion	144
3.115	An Ultrasonic Level Transmitter	146
3.116	Functional Block Diagram of a Typical Ultrasonic Level Transmitter	147
3.117	The Radar Antenna at Work	148
3.118	The Radar Principle	148
3.119	Measurement Techniques in Common Use	149
3.120	The Radar Signal in a Tank	150
3.121	The Cone and Parabolic Antennae	151
3.122	The Pulse Radar at Work	152
3.123	SAAB Tank Radar System	153
3.124	A Basic Rotameter	154
3.125	An Orifice Flow Meter	156
3.126	An Orifice in the Flow Line	156
3.127	Pressure Profile of an Orifice Plate Installation	157
3.128	Types of Orifice Plates	158
3.129	Square Root Extraction to Calculate Flow	158
3.130	Flow Measurement using Orifice Plates	159
3.131	Flow Through the Venturi Flow Meter	159
3.132	Flow through the Flow Nozzle	161
3.133	The Pitot Tube Principle	161
3.134	Flow Through a Pitot Tube	162
3.135	The Averaging Pitot Tube	162
3.136	A Simple Mass Flow Detection System	163
3.137	A Turbine Flow Meter	164
3.138	A Rotor Design of the Floating-type	165
3.139	The Electromagnetic Flow Meter	166
3.140	Circuit Diagram of an Electromagnetic Flow Meter	167
3.141	An Ultrasonic Meter Installed Directly on the Pipe	168
3.142	A Doppler Ultrasonic Flow Meter	168
3.143	The Doppler Effect Ultrasonic Flow Meter in use	169
3.144	A Transit-time Flow Meter in a Reflect Mode	170
3.145	A Transit-time Flow Meter in a Diagonal Mode	171

Addendum

Index of Figures

Chapter 3 – Sensing Elements and Transducers (Continued)		
Figure No.	Details	Page No.
3.146	Working Principle of a Transit-Time Flow Meter	172
3.147	Placement of Transit Flow Meter Transmitters	173
3.148	An Intelligent Temperature Transmitter	174
3.149	An Intelligent Transmitter's Communication	175
3.150	A Transmitter with an Analog 40 - 20 mA Output	175
3.151	A Block Diagram of a Transmitter with a Capacitive Sensor	176
3.152	A New Version of the Smart Transmitter	177
3.153	Architecture of an Intelligent Transmitter	178
3.154	A Smart Transmitter in Operation	179

Chapter 4 – Miscellaneous Monitors		
Figure No.	Details	Page No.
4.1	Working Principle of a Viscosity Sensor	185
4.2	Sensor / Pneumatic Transmitter Assembly	186
4.3	A Viscotherm Sensor	187
4.4	Viscosity Control System	188
4.5	An Electromagnetic Viscometer	189
4.6(a)	The Fork-type Viscometer	190
4.6(b)	The Fork-type Viscometer in Operation	191
4.6(c)	A Torsion Pendulum-type Viscometer and its Working Principle	192
4.7	Application of the Fork-type Viscometer for Fuel Heater Control	193
4.8	The Torsion Meter Principle	194
4.9(a)	Proximity Torque System	194
4.9(b)	Waveforms of the System	195
4.10	Phase-shift due to Twist in the Shaft	195
4.11	The Torductor	196
4.12	The Torductor (Sectional View)	196
4.13	The Vibration Sensor	197
4.14	The Torsion Detector Ring	199
4.15	The Torsion Detection System (as fitted on a ship)	200
4.16	Block Diagram of the Torsion Detector	200
4.17	A Combustible Gas Indicator	201

Addendum

Index of Figures

Chapter 4 – Miscellaneous Monitors (Continued)		
Figure No.	Details	Page No.
4.18	Two Variants of a Combustible Gas Indicator	202
4.19	A Tankscope	203
4.20	Circuit Diagram of a Tankscope	204
4.21	The O ₂ Analyser	206
4.22	Creation of the Magnetic Field	206
4.23	The Basic Device	206
4.24	Achieving Torque Balance	207
4.25	Generating the Output Signal	207
4.26	A Resonator Circuit	207
4.27	Basic Circuit of the Munday Cell	208
4.28	Sensitive Element of the Munday Cell	209
4.29	An Oxygen Measuring Cell	210
4.30	Construction of the Cell	210
4.31	The Cell in Operation	211
4.32	The Rate of Rise Detector (Bi-metallic Strip Type)	213
4.33	The Ionisation Principle	214
4.34	An Ionization Chamber of the Combustion Detector and a Basic Circuit	215
4.35	An Infra-red Flame Detector	216
4.36	An Ultra-violet Flame Detector	216
4.37	A Basic Crankcase Oil Mist Detector	218
4.38	A Comparison-type Crankcase Oil Mist Detector	219
4.39	A Modern Comparison-type Crankcase Oil Mist Detector	220
4.40	The Line-of-sight Smoke / Oil Mist Detector	221
4.41	Output versus Frequency Graph for Various Types of Vibration	223
4.42	An Eddy Current Vibration Sensor	224
4.43	Magnetic Field of lines of Eddy Current Sensor	225
4.44	Eddy Current Vibration Sensors	225
4.45	Piezoelectric Vibration Sensors	226
4.46	Magnetic Velocity Vibration Sensors	227
4.47	A Laser Displacement Vibration Sensor	227
4.48	A Laser Doppler Vibration Sensor's Principle of Operation	229
4.49	Reference Beam Vibrometer	230

Addendum **Index of Figures**

Chapter 4 – Miscellaneous Monitors (Continued)		
Figure No.	Details	Page No.
4.50	An Opto-switch Sensor	231
4.51	Magnetic Field Orientation in Inductive Proximity Sensors	232
4.52	Inductive Proximity Sensors	232
4.53	Hall Effect-based Rotational Sensors	233
4.54	Capacitive Proximity Sensors	234
4.55	Proximity Switches for Pneumatic Cylinders	234
4.56	Optical Proximity Switches	235
4.57	An Incremental Position Encoder Assembly	236
4.58	An Incremental Position Encoder in use	237
4.59	Output of the Shaft Position Encoder	237
4.60	Two-element Synchro Chain (Initial Position of the Synchro Transmitter and Receiver)	238
4.61	A Two-element Synchro Chain (Initial Position of the Synchro Transmitter and Receiver)	240
4.62	A Torque Transmitter	240

Chapter 5 – Automatic Control System Fundamentals		
Figure No.	Details	Page No.
5.1	On / Off Control of Tank Level	244
5.2	Response Graph of an On / Off Control System	244
5.3	Continuous Control with a PID Controller	246
5.4	Response Time	247
5.5	Peak-related Criteria	248
5.6	Time Constant	249
5.7	Dead Band	249
5.8	Direct and Reverse-acting Control Action	251
5.9	Direct-acting Control Element	252
5.10	Reverse-acting Control Element	252
5.11	Hysteresis	253
5.12	Stability Plots	254
5.13	Basic Proportional Control	256
5.14	Valve Fully Open - System in a High Load Condition	257
5.15	Valve Shut - System in a No-Load Condition	257

Addendum

Index of Figures

Chapter 5 – Automatic Control System Fundamentals (Continued)		
Figure No.	Details	Page No.
5.16	Proportional Band	258
5.17	The Relationship between P-band and Offset	259
5.18	Relationship between Output and P Band	260
5.19	Fast and Slow Processes	260
5.20	Controller Output with Varying Proportional Bands	262
5.21	Performance of a Proportional Controller with Varying P-Band Value	263
5.22	Additional Control Signal to Remove the Offset	264
5.23	A Two-term “Proportional plus Integral” Controller	264
5.24	Integral Action Output	265
5.25	Proportional and Integral Action	266
5.26	Controller Output Signal with Various Resets	266
5.27	System Behaviour with Different Integral Settings	267
5.28	P + I Function after a Step Change in Load	268
5.29	P + D Control	269
5.30	Rate Action Time	270
5.31	P + D Control Output with Change in Ramp Input	271
5.32	Derivative Action Response	271
5.33	A Large System under P and P + D Action	272
5.34	Elements in a PID Controller	272
5.35	Response of P, I and D to a Step Input	273
5.36	Characteristics of Various Control Modes	274
5.37	Desired Response to a Step Change	275

Chapter 6 – Pneumatic Controllers		
Figure No.	Details	Page No.
6.1	Schematic Diagram of a Pneumatic Device	280
6.2	Typical Level Control Using an Electronic / Pneumatic System	281
6.3	A Nozzle-flapper Arrangement	281
6.4	Various Outputs due to the Effect of the Baffle / Nozzle Position	282
6.5	A Nozzle-flapper’s Characteristic Curve	283
6.6	A Nozzle- flapper Arrangement with Negative Feedback	284
6.7	A Nozzle- flapper with a Negative Feed Back Bellow	285

Addendum

Index of Figures

Chapter 6 – Pneumatic Controllers (Continued)		
Figure No.	Details	Page No.
6.8	Output with Negative Feedback	286
6.9	Layout of the Moment-balance Mechanism	288
6.10	The Motion-balance Mechanism	288
6.11(a)	The Angle Motion-balance Mechanism Working at 9 psi	289
6.11(b)	The Angle Motion-balance Mechanism Working at 3 and 15 psi	290
6.12	Fundamentals of a Motion-balance Controller Mechanism	290
6.13	The Angular Motion-balance Mechanism	291
6.14	The Angle-balance Mechanism at Work	291
6.15	A Stack-type Pneumatic Differential Pressure Transmitter	292
6.16	Sectional View of a Stack-type Differential Pressure Transmitter	293
6.17	A Continuous Bleed-type Pneumatic Relay	294
6.18	A Relay Valve (Continuous Bleed-type)	295
6.19	A Non-bleed-type Pneumatic Relay	295
6.20	A Non-Bleed Relay's Characteristic	296
6.21	A Pneumatic Relay Valve used in Normal Controllers	297
6.22	A Pneumatic Booster Relay Valve Assembly	297
6.23	Input / Output Pressure Relationship of the Pneumatic Relay	298
6.24	Direct and Reverse-acting Relays	299
6.25	Construction of a Pilot Relay Valve	299
6.26	A Pneumatic Pressure Transmitter	300
6.27	A Motion-balance Pressure Transmitter	302
6.28	A Force-balance Temperature Transmitter	303
6.29	Schematic Diagram of an Electronic Force-balance Transmitter	304
6.30	Construction of a Differential Pressure Transmitter	305
6.31	Working Principle of a Square Root Extractor	307
6.32	Linear Flow Output from a Square Root Extractor	308
6.33	A Pneumatic Square Root Extractor	308
6.34	An Electro-pneumatic (I/P) Converter	309
6.35	A Current-to-pneumatic Converter	310
6.36	An Electro-pneumatic (I/P) Transducer used in Process Control	310
6.37	A Stack-type I/P Converter	311
6.38	A Pneumatic Controller as Installed Onboard a Ship	312

Addendum

Index of Figures

Chapter 6 – Pneumatic Controllers (Continued)		
Figure No.	Details	Page No.
6.39	A Pneumatic Proportional Controller	313
6.40	A Pneumatic Controller for Fuel Oil Temperature Control	314
6.41	Change of Proportional Band in a Balance Beam-type of Proportional Controller	315
6.42	A Pneumatic P + I Controller	317
6.43	Example of Pneumatic P and I Control	318
6.44	Adjustments inside a P and I Controller	319
6.45	A Pneumatic Level Controller	320
6.46	A Basic Pneumatic PID Controller	321
6.47	A Pneumatic PID Controller's Component Layout	323
6.48	An Alternate Design of a Pneumatic PID Controller	324
6.49	A Stack-type P and I Controller	328
6.50	A Stack-type PID Controller	330
6.51(a)	Feedforward with a Feedback Control Configuration	332
6.51(b)	Split Range Control	333
6.52	Cascade Control Configuration	333
6.53	A Jacket Cooling Water Control System	335
6.54	A Piston Cooling Water Control System	336
6.55	A Lubricating Oil Temperature Control System	337
6.56	Two-term Control of a Boiler's Water Level Control System	339
6.57	Three-term Control of a Boiler's Water Level Control System	340
6.58	A Steam Temperature Control System for a Boiler	341
6.59	A Deaerator's Water Level Control System	342
6.60	Effects of Changing Proportional Band	344
6.61	Effects of Changing Integral Action Time on a P + I Controller	344
6.62	Effects of Changing Derivative Action Time on a P + I + D Controller	345
6.63	Oscillations Observed in a Proportional Controller	347
6.64	Controller Settings as per Ziegler and Nichols Method to overcome Undamped Oscillations	348
6.65	Change in Transient Response by Reducing the P Band	349

Addendum **Index of Figures**

Chapter 7 – Electronic Analog and Digital Controllers		
Figure No.	Details	Page No.
7.1	An Electronic Controller	353
7.2	Negative Feedback	354
7.3	An Electronic PID Controller	355
7.4	Schematic Diagram of an Electronic PID Controller	356
7.5	Block Diagram of a PID Controller	357
7.6	A Block Diagram of a PID System for a Ship's Steering System	358
7.7	A Graphical Representation of a PID Control System	359
7.8	A Simplified Block Diagram of a PID System for a Rudder	360
7.9	Electronic Steering Control - Auto-pilot Mode	361
7.10 (a)	A Typical Continuous Feedback System	362
7.10 (b)	A Voltage to Current Converter	363
7.11	A Digital Controller in a Continuous Feedback System	364
7.12	Example of a Digital Controller in a Continuous Feedback System	364
7.13	Direct Digital Control System (DDC) Architecture	365
7.14	A Digital Controller Programmed in a Function Block Language	366
7.15	A Simple Speed Control Diagram	367
7.16	Electronic Fuel Control (EFC) System Components	368
7.17	Engine Speed Control Electronic Governor System	370
7.18	Components of a DCS	371
7.19	Distributed Control System (DCS) Architecture	372
7.20	Block Diagram of a Distributed Control System (DCS)	373
7.21	HART Signal Superimposed on a 4-20 mA Signal (Not to scale)	375
7.22	The HART Master-slave Protocol	375
7.23	HART Communication	376
7.24(a)	Use of the HART Protocol	376
7.24(b)	Use of the HART Protocol (Continued)	377
7.25	HART-based Instruments with PID Algorithms	377
7.26	A HART Loop	378
7.27	A HART Hand-held Communicator in Use	379
7.28	A HART Field Device Multidrop Connection	380
7.29	HART Devices Connected through Multiplexers	381
7.30	A WirelessHART Networking System	383

Addendum

Index of Figures

Chapter 7 – Electronic Analog and Digital Controllers (Continued)		
Figure No.	Details	Page No.
7.31	A Fieldbus Networking System	385
7.32	Fieldbus in Process Control	386
7.33	A Fieldbus PID Block with a Smart Transmitter and a Smart Control Valve Positioner	387
7.34	A Smart Transmitter with a PID Block and Fieldbus Communication Circuit	388
7.35	Differences between Analog and Fieldbus Communication Systems	389
7.36	A Fieldbus Control Networking System	390
7.37	A MODBUS System Interconnecting HART Field Devices	391
7.38	Modbus Master Communicating with Slaves	392
7.39	Modbus-based Wireless Process Control System	392
7.40	Interconnection of a System Bus in a Common-rail Camless Engine	393
7.41	A Fuzzy Logic Controller	394
7.42	Fuzzy Set Theory	394
7.43	A Block Diagram of a Fuzzy Logic Control System	395
7.44	Computational Structure of a Fuzzy Controller	395
7.45	Height Defuzzification	396
7.46	Block Diagram for a Steam Turbine	397
7.47	Fuzzy Set Mapping of a Turbine's Operation	398
7.48	Evaluation of Fuzzy Rules – Rule 2	399
7.49	Evaluation of Fuzzy Rules – Rule 3	400
7.50	Throttle Settings based on Fuzzy Rules	401
7.51	Human Machine Interface (HMI) Utilization by a SCADA System	402
7.52	A SCADA Connection System	403
7.53	A Basic Block Diagram of a SCADA Application	404
7.54	Typical SCADA Architecture	405
7.55	A SCADA Master in a Wide Area Network	406

Chapter 8 – Programmable Logic Controllers		
Figure No.	Details	Page No.
8.1	A Programmable Logic Controller	409
8.2	A PLC in a Process Control System	410
8.3	A PLC in an Automated System	411

Addendum **Index of Figures**

Chapter 8 – Programmable Logic Controllers (Continued)		
Figure No.	Details	Page No.
8.4	Comparison between Traditional Control and a PLC	412
8.5	Block Diagram of a PLC	413
8.6	Inside a PLC	413
8.7	Role of a CPU in a PLC	414
8.8	The Step Process in a PLC's Operation	417
8.9	The Schematic Representation of Operational Cycle of a PLC	417
8.10(a)	Parts of a CPU	419
8.10(b)	Memory of a CPU	419
8.11	PLC Modules	420
8.12	Various Inputs to a PLC	422
8.13	An Input-adjustable Interface	424
8.14	Output Sinking and Input Sourcing	425
8.15(a)	PNP Sourcing and NPN Sinking	425
8.15(b)	Sinking and Sourcing	425
8.16	Analog and Digital Outputs of a PLC	426
8.17	An Output-adjustable Interface	427
8.18	A PLC's Relay Output	427
8.19	Switching the Output of a PLC with Sinking and Sourcing	428
8.20	A Load (contact) Symbol	428
8.21	A LoadNot (normally closed contact) Symbol	429
8.22	An Out (coil) Symbol	429
8.23	An OutBar (normally closed coil) Symbol	430
8.24	PLC Registers	431
8.25	Latch Instructions	433
8.26(a)	A Counter with 2 Inputs – Reset and Pulse	434
8.26(b)	The Ladder of a Counter with 2 inputs – Reset and Pulse	435
8.26(c)	An Up-down Counter	435
8.26(d)	An Up-down Counter with 3 Inputs	436
8.27	A Typical Timer Instruction Symbol	437
8.28	An Increment Timer	437
8.29	A Timer with Enable and Reset Functions	438
8.30	A 10ms Increment Timer	438

Addendum **Index of Figures**

Chapter 8 – Programmable Logic Controllers (Continued)		
Figure No.	Details	Page No.
8.31	Control Relay Logic in the PLC	439
8.32(a)	Logical Functions Incorporated in a PLC	440
8.32(b)	OR Gate Equivalent in a PLC	440
8.32(c)	AND Gate Equivalent in a PLC	440
8.32(d)	NOT Gate Equivalent in a PLC	440
8.32(e)	NOR Gate Equivalent in a PLC	441
8.32(f)	NAND Gate Equivalent in a PLC	441
8.32(g)	Exclusive OR Gate Equivalent in a PLC	441
8.33	Assigning of States and I/Os	442
8.34	A Ladder Logic Diagram	443
8.35	A Ladder Logic Diagram with Input and Output	444
8.36	Programming a PLC	444
8.37(a)	Ladder Logic for a Motor	445
8.37(b)	Alternative Ladder Logic	446
8.38(a)	Switching on a Light	446
8.38(b)	Switching on a Light with Multiple Switches	447
8.39	Dispensing Oil from a Tank	448
8.40	Use of an Internal Utility Relay	448
8.41(a)	Scans during a Process	449
8.41(b)	Scans during a Process (Continued)	450
8.42	Reservoir Level Control	451
8.43	A Ladder Diagram for Reservoir Level Control	452

Chapter 9 – Final Control Elements		
Figure No.	Details	Page No.
9.1	A Final Control Element in Use	455
9.2	Parts of a Final Control Element	459
9.3	Diaphragm Actuators	460
9.4	Forces on the Valve	461
9.5	Various Combinations of Actuators and Valves	461
9.6	Diaphragm-operated Air-to-close Pneumatic Valve	462
9.7	Diaphragm-operated Air-to-open Pneumatic Valve	463

Addendum **Index of Figures**

Chapter 9 – Final Control Elements (Continued)		
Figure No.	Details	Page No.
9.8	Variation of Fluid Pressure When Passing Through a Control Valve	464
9.9	Construction of a Control Valve Body with an Actuator	465
9.10	A 3-Port Valve	466
9.11	Valve Characteristics	467
9.12	Various Types of Valve Plugs	468
9.13	Control Valve Hysteresis	470
9.14	Block Diagram of a Control Valve Positioner	471
9.15	A Single-seated Control Valve with a Positioner (Air-to-close)	471
9.16	Working Principle of a Valve Positioner	472
9.17	A Motion Balance Valve Positioner	473
9.18	A Pneumatic Valve Positioner - Variant 1	474
9.19	A Pneumatic Valve Positioner - Variant 2	475
9.20	A Force-balance Positioner	476
9.21	A Cylindrical Valve Positioner	477
9.22	Spool Valve Movement with respect to Variation of Controller Output	478
9.23	Cylinder Bore versus Response Time	478
9.24	An Electro-Pneumatic Force-balance Positioner	480
9.25	A Control Valve with a Positioner	480
9.26	Digital Fieldbus Technology with a Local User Interface	483
9.27	Block Diagram of a Digital Valve Positioner	484
9.28	Closed Loop Control of a Digital Positioner	485
9.29	Calibration of a Digital Valve Positioner	486
9.30	A Digital Valve Positioner with a HART Protocol	487
9.31	Working Principle of a Double-action Digital Valve Controller	488
9.32	Operation of a Piezo Valve	489

Chapter 10 – Calibration of Process Components		
Figure No.	Details	Page No.
10.1	The Basics of Calibration	493
10.2	Calibration Under Controlled Conditions	496
10.3	A Basic Transmitter	496
10.4	Linearity of Output	497

✈ Addendum ✈

Index of Figures

Chapter 10 – Calibration of Process Components (Continued)		
Figure No.	Details	Page No.
10.5	Zero Error	498
10.6	Span Error	499
10.7	Combined Zero and Span Error	499
10.8	Hysteresis Calibration Error	500
10.9	Calibration Adjustment	501
10.10	A Calibration Flow Chart	503
10.11	The PT 100 Calibrator	503
10.12	Calibration of an RTD Temperature Transmitter	504
10.13	A Temperature Calibrator	505
10.14	Calibration of a Thermocouple-type Temperature Transmitter	505
10.15	A Loop Calibrator	506
10.16	A Digital Pressure Calibrator	506
10.17	A Pressure Calibrator by Fluke Corporation	507
10.18	Calibration of a Pressure Transmitter	507
10.19	Calibration of a Differential Pressure Transmitter	508
10.20	Calibration of an I/P Converter	509
10.21	HART Information of the Field Device and the Function Tree	511
10.22	Calibration of a Smart Transmitter	512
10.23	Basic Diagram to Connect a HART Device with a Loop	513
10.24	Calibration of a DP Transmitter with a HART Device in the Loop	514