

BULK LOAD FILLING SYSTEM

This system will fill a container to the specified total by filling and dumping a smaller weigh-hopper. Each draft will be printed and the total printed when the process is complete.

SET-UP

Batch parameter entries:

Before the system can be run, the batch parameters must be set. They need only be set once, but can be altered whenever necessary.

#1 is the batch draft size that the weigh-hopper can be loaded to.

#2 is the amount early to stop filling the weigh-hopper and only allow the slow feed relay to be on. NOTE: This is an option that may not be available in this unit.

#3 is the amount early to stop the filling process. This is a freefall compensation.

#4 is the weight value that the weigh-hopper must dump down to before the dump gate closes to determine the net weight and start the next filling process.

#5 is the total tolerance. If the total is to be 120,000 lbs and an under weight amount of 119,900 is tolerable, then set this value to 100 for the 100lb under tolerance amount.

Once these values are set, they will not be lost if power is removed.

1. Assure the system is not running (no lamps flashing).
2. Press the FUNCTION button until the DATA lamp lights.
3. Enter the parameter (1-5) that you wish to change, and press the ENTER button.
4. The display will then show the current setting for that parameter.
5. Use the keypad to alter this value and press the ENTER button to save the new value.

OPERATION:

1. Assure that the RUN / HOLD switch is in the RUN position
2. Press and hold the SETPOINT button until the DATA lamp lights.
3. The display will show the current total amount to batch.
4. Use the keypad to alter this value if necessary, then press the ENTER button.

NOTE: If the total does not need to be changed, steps 2,3, & 4 can be bypassed and are not necessary to start the batch process.

5. Press the START button, and note that the small lamps to the right of the display start flashing. This indicates that the system is in the RUN mode.
6. The system will fill the weigh hopper to the draft size or the amount to reach the total batch.
7. The system will print the GROSS weight and optional time/date.
8. The system will dump to the zero interlock value.
9. The system will determine the net weight after the dump Gate closes, and accumulate that to the total batch.
10. If more drafts are needed, the system cycles to step #5.
11. When the total is reached, the total will be printed and the system will stop.

NOTES:

To place the system on hold, turn the rotary switch to the HOLD position. This will suspend the operation until returned to the RUN position.

To force a short draft to be printed and the dump cycle to start (for example, there is no material left to finish). Press the PRINT button.

To abort the process before the total is reached, press the STOP button, and the system will finish the draft and stop.

SYSTEM RUN RELAY OUTPUT OPTION

This option can be used to control the material feed to the scale system. If a conveyor needs to be turned on when the system is running then turned off when the system stops, this relay can be used to control that device.

MAIN BOARD CONECTION

_____ CUSTOMER LOAD
I A I _____ / \ / \ / \ / \ _____ L2
I _____ I
1 AMP MAX. 110VAC
SCALE DUMP RELAY
_____ L1
I B I _____
I _____ I

70RCK4 CONTROL BARRIER STRIP TO CUSTOMER CONTROLS

TERMINAL ----- CUSTOMER WIRING

_____ CUSTOMER LOAD
I 2 I _____ / \ / \ / \ / \ _____ L2
I _____ I
1 AMP MAX. 110VAC
FINAL FEED FILL
_____ L1
I 3 I _____
I _____ I

_____ / \ / \ / \ / \ _____ L2
I 4 I _____ 110VAC
I _____ I
FAST FEED (OPTIONAL)
_____ L1
I 5 I _____
I _____ I

GATE CLOSED SENSOR SWITCH

_____ 0 0 _____ L1
I 6 I _____
I _____ I

ALLOWS FILLING OF SCALE WHEN CLOSED

_____ L2
I 7 I _____
I _____ I

_____ / \ / \ / \ / \ _____ L2
I 8 I _____ 110VAC
I _____ I
FEEDER CONVEYOR (OPTIONAL)
_____ L1
I 9 I _____
I _____ I