SINGLE-INGREDIENT NET WEIGHT BATCHING
(TA-1191-6-BATCH1-1)

   This unit is used for single ingredient batching with a
single speed feed or dual speed feed.
 The unit will be started by the local function or start
button.
   The target weight value has an associated pre-act setting
and optional fast-feed setting for dual speed systems.
   For example, if the setpoint was set to the value of 1000,
and its pre-act was set to 50, then the final feed relay
output will turn off when the weight crosses 950. By using
this pre-act value, compensation for lag time can be made.
   The fast-feed setting allows for the fast-feed relay to
drop out at an amount early before final cutoff.

   This unit also has an Auto-Print feature that will generate
a print data output when the setpoint has been reached. It
will print after loading and a non-motion condition exists.
When the printer prints, the amount will be added to a total
accumulator for later total printing and clearing.

SETPOINT / FAST-FEED and PRE-ACT ENTRY:

   Setpoint number 1 is for final target setting, and #5
is for fast-feed setting.

   Pre-act value is set by using setpoint number 11

1. Press and hold the SETPOINT button until the DATA lamp
   lights.
2. Use the keypad to enter the Setpoint desired, (1 or 5 or
   11)
3. The display will show the current value of the setpoint or
   pre-act that was selected.
4. Use the keypad to alter this value if desired, then press
   the ENTER button to store the new value, and the display
   will return to the weigh mode.
5. Repeat steps 1 to 4, for all settings that need
   to be changed.

NOTE: The setpoint values are stored in non-volatile memory
       and will not be lost if power to the TR-1 is
       interrupted.

Emergency Abort:
   To stop the batch cycle, press the CLEAR button until the
lamps stop flashing. This will turn any relays that were on
to the off condition and set the display to GROSS weight.

Operation:

1. Press the local front panel FUNCTION button, or START
   button, and note that all the indicator lights to the
   right of the display will flash. This indicates that the
   unit is in the run mode.
2. The TR-1 will auto-tare to display a NET weight of zero.
3. The relays will energize.
4. The TR-1 monitors the net weight until the setpoint values
   are reached, and turns off the optional fast-feed and then
   the final feed relays. The lights will stop flashing.
5. When the weight is stable (no motion), the optional
   printer will print, and the amount will be added to the
   total accumulator.
6. The TR-1 will stay in the NET weight mode, until the
   weight gets down to within 5 graduations of zero, then it
   will go to the GROSS weight display mode.

Total Printing and Clearing: OPTIONAL

   The total can be printed at any time the unit is not in the
run mode.

1. Press and hold the PRINT button until the printer prints.
2. The display will show ------.
3. To clear the total, press the CLEAR button now.
4. To keep the total, press the ENTER button.

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 TR-1 CONTROL RELAY TO CUSTOMER VALVES

RELAY OUTPUT
TERMINAL --------------- CUSTOMER WIRING
ON TR-1
                              FINAL SLOW FILLING VALVE
 ____                         2 AMP MAX LOAD
I    I____ADD A FUSE_____/\/\/\/\/_____ L2
I__2_I                        AIR SOLINOID           110VAC
                               OR RELAY

 ____
I    I_____ L1
I__3_I


                              FAST FILLING VALVE
 ____                         2 AMP MAX LOAD
I    I____ADD A FUSE_____/\/\/\/\/_____ L2
I__4_I                        AIR SOLINOID           110VAC
                               OR RELAY

 ____
I    I_____ L1
I__5_I
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TR-1 CONTROL RELAY TO CUSTOMER VALVES   DC VERSION

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RELAY OUTPUT
TERMINAL --------------- CUSTOMER WIRING
ON TR-1
                              FINAL SLOW FILLING VALVE
 ____                         2 AMP MAX LOAD
I    I____ADD A FUSE_____/\/\/\/\/_____ PLUS 5 TO 60 VDC
I__2_I                        AIR SOLINOID
                               OR RELAY

 ____
I    I_____ MINUS
I__3_I


                              FAST FILLING VALVE
 ____                         2 AMP MAX LOAD
I    I____ADD A FUSE_____/\/\/\/\/_____ PLUS 5 TO 60 VDC
I__4_I                        AIR SOLINOID
                               OR RELAY

 ____
I    I_____ MINUS
I__5_I
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