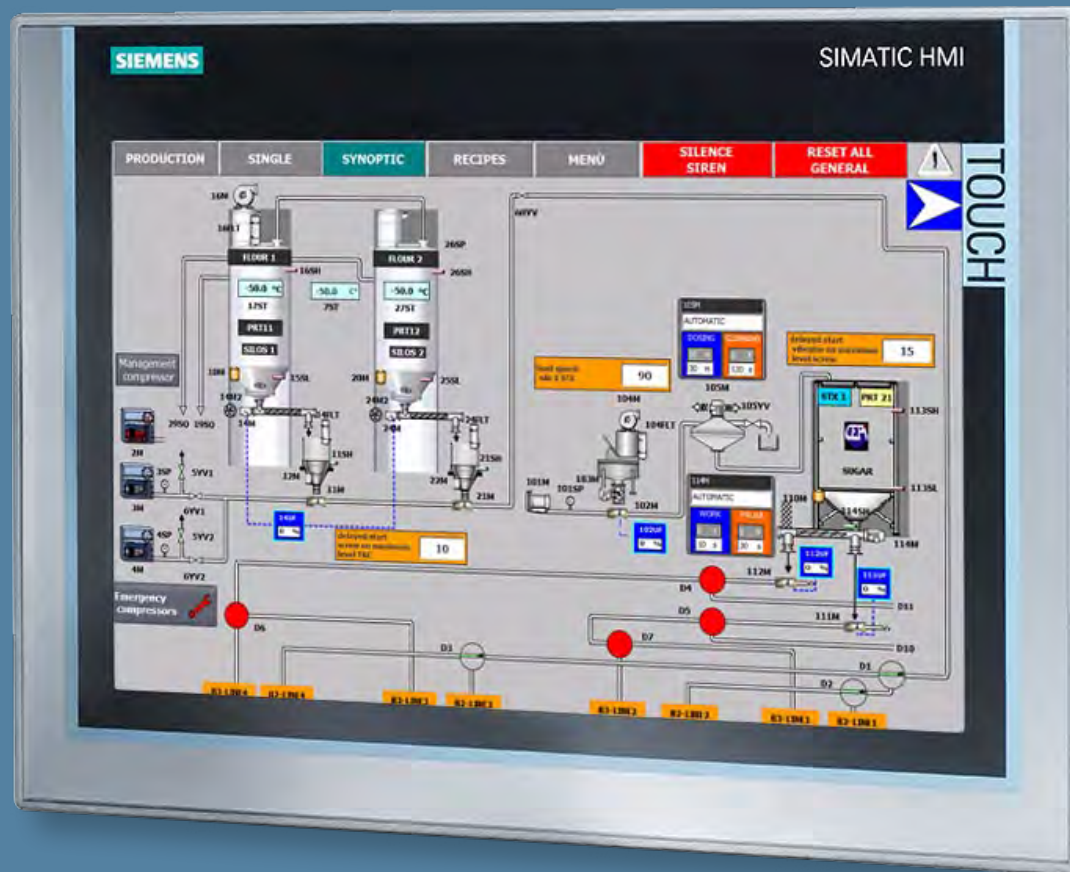


OPERATOR PANEL

TOUCH PANEL AND PC PANEL



PRODUCTION CONTROL
RECIPES CREATION
PARAMETERS SETTING
OVERVIEW



OPERATOR PANEL

TOUCH PANEL AND PC PANEL



TOOL FOR THE DOSING CONTROL

automatic metering of powders and liquids

**continuous or batch, positive, by loss of weight,
by volume or by weight**

silos weight control in real time

automation also via the plc

**TP400
TP700
TP900
TP1200**

Process supervision system
which uses the Siemens WinCC Flexible Runtime program.

The software runs on a Windows system and uses its standard command interface, keyboard and mouse.



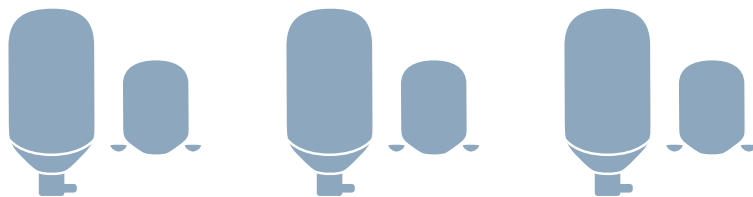
Bulk-handling systems
www.cepilos.com

OPERATOR PANEL

TOUCH PANEL AND PC PANEL



**MULTIPLE
DOSING
LINES**



**OPERATOR
PANEL**



PC



INTERNET



**TOUCH PANEL
ON LINES
7" OR 12"**

**OVERVIEW
+
CEPI TRACKING
SYSTEM**

**PC PANEL
CONTROLLING
THE PLANT**

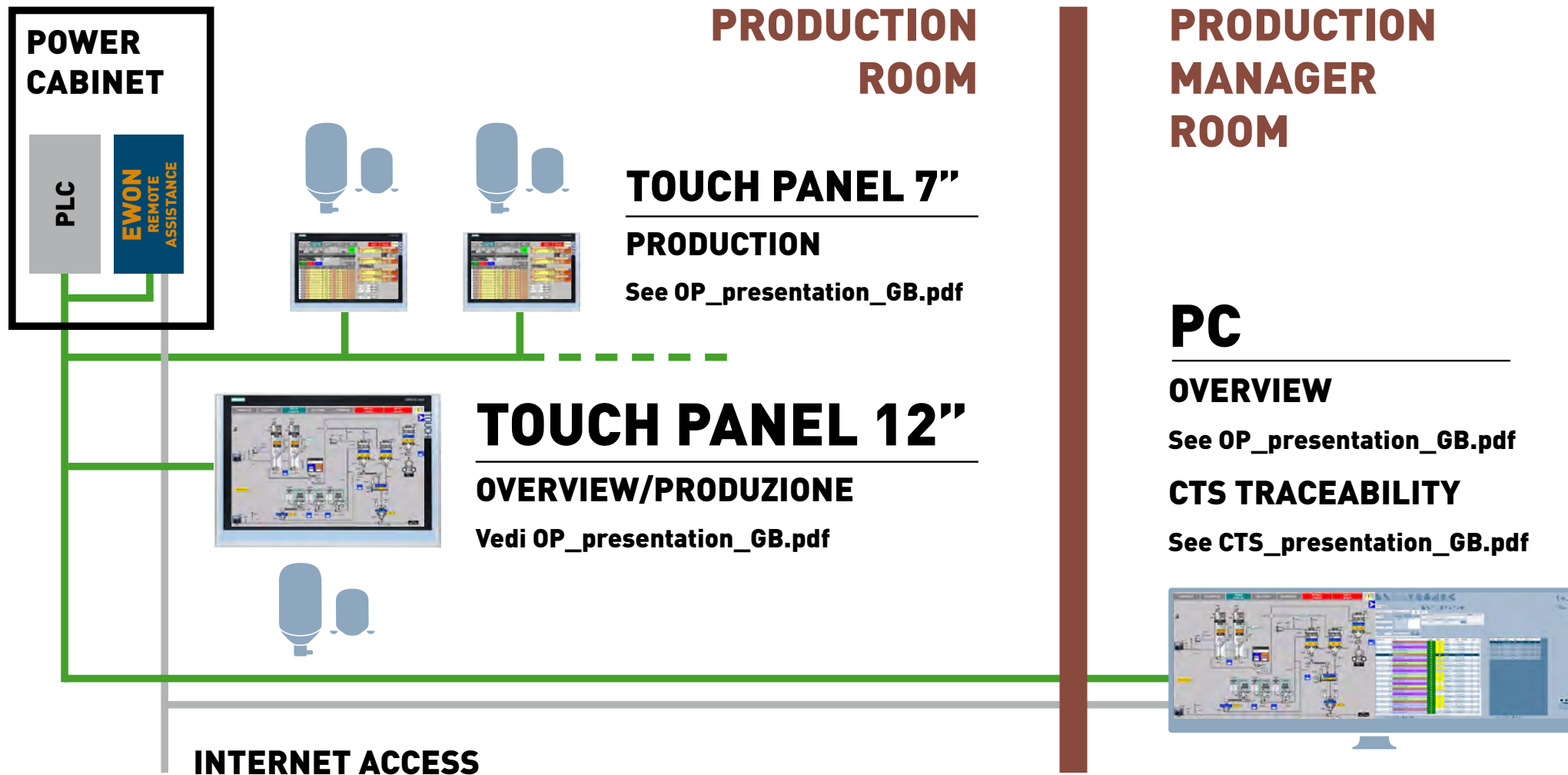


**PRODUCTION CONTROL
RECIPES CREATION
PARAMETERS SETTING
OVERVIEW**



OPERATOR PANEL

TOUCH PANEL AND PC PANEL

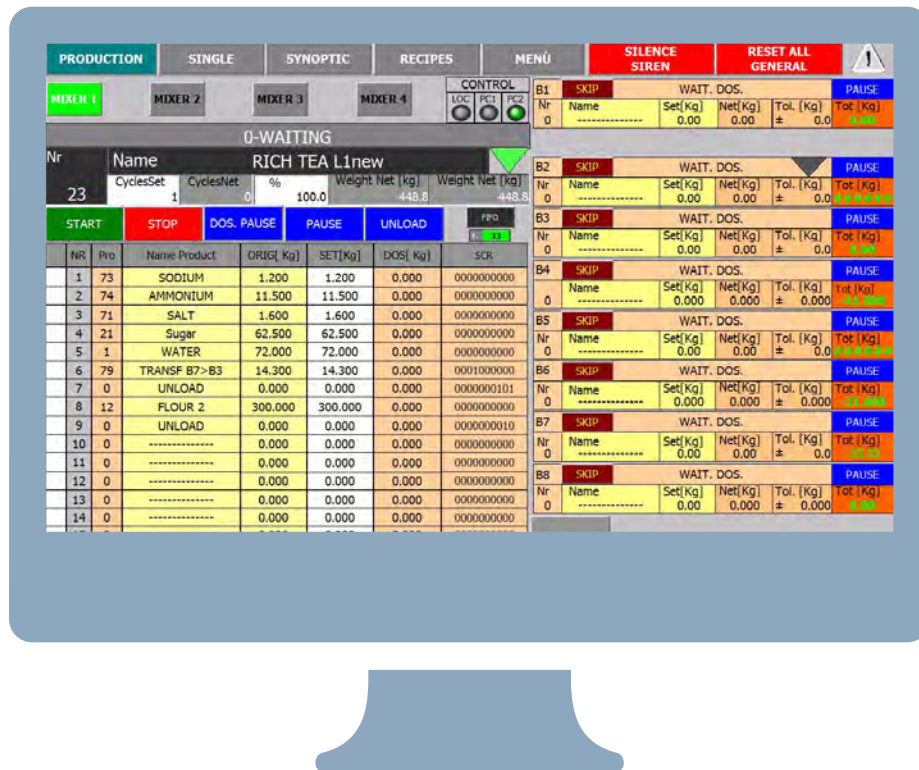


OPERATOR PANEL

TOUCH PANEL AND PC PANEL



PRODUCTION CONTROL



PRODUCTION CONTROL ON LINES AND PLANT

REMOTE AND LOCAL PRODUCTION MODALITY

SINGLE DOSING

REPORT



OPERATOR PANEL

TOUCH PANEL AND PC PANEL



PRODUCTION CONTROL

EXAMPLES

Production page

PRODUCTION		SINGLE		SYNOPTIC		RECIPES		MENÜ		SILENCE SIREN		RESET ALL GENERAL		!	
MIXER 1		MIXER 2		MIXER 3		MIXER 4		CONTROL		B1 SKIP		WAIT. DOS.		PAUSE	
Nr		Name		Set[Kg]		Net[Kg]		Tol. [Kg]		Tot [Kg]					
0		-----		0.00		0.00		± 0.0		0.00					
0-WAITING															
Nr		Name		CyclesSet		CyclesNet		%		Weight Net [kg]		Weight Net [kg]			
23		RICH TEA L1new		1		0		100.0		448.8		448.8			
START		STOP		DOS. PAUSE		PAUSE		UNLOAD		FIFO					
										33					
NR	Pro	Name Product	ORIG [Kg]	SET [Kg]	DOS [Kg]	SCR									
1	73	SODIUM	1.200	1.200	0.000	0000000000									
2	74	AMMONIUM	11.500	11.500	0.000	0000000000									
3	71	SALT	1.600	1.600	0.000	0000000000									
4	21	Sugar	62.500	62.500	0.000	0000000000									
5	1	WATER	72.000	72.000	0.000	0000000000									
6	79	TRANSF B7>B3	14.300	14.300	0.000	0001000000									
7	0	UNLOAD	0.000	0.000	0.000	0000000101									
8	12	FLOUR 2	300.000	300.000	0.000	0000000000									
9	0	UNLOAD	0.000	0.000	0.000	0000000010									
10	0	-----	0.000	0.000	0.000	0000000000									
11	0	-----	0.000	0.000	0.000	0000000000									
12	0	-----	0.000	0.000	0.000	0000000000									
13	0	-----	0.000	0.000	0.000	0000000000									
14	0	-----	0.000	0.000	0.000	0000000000									
15	0	-----	0.000	0.000	0.000	0000000000									
16	0	-----	0.000	0.000	0.000	0000000000									
COMMUNICATION MIXER OFF															





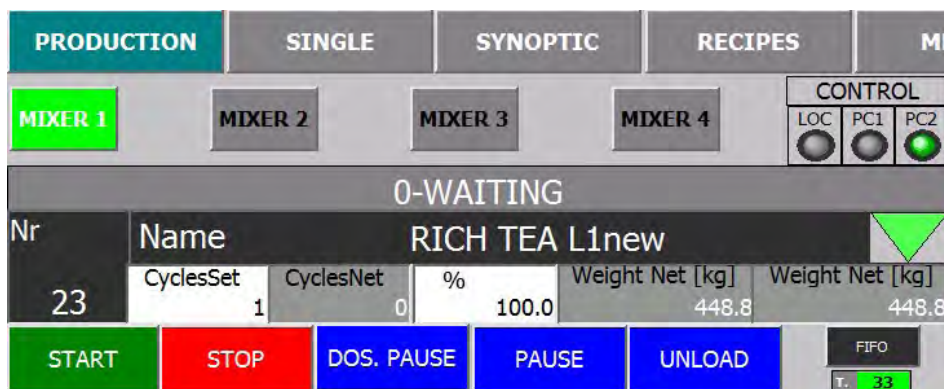
PRODUCTION CONTROL PROCEDURE



Select the production modality

Local production modality

Press LOC button to select
The recipe is started and managed elsewhere and production commands are disabled on the panel




Remote production modality


Press PC1/PC2 buttons to select
The recipe is started and managed in the panel





PRODUCTION CONTROL PROCEDURE

Name **RICH TEA L1new** 

PRODUCTION SINGLE SYNOPTIC RECIPES MENÙ **SILENCE SIREN** **RESET ALL GENERAL** 

0-WAITING

Nr.	Name Recept	Show	Prod	Nr	Name	Tot [Kg]
16	GINGER L2			23	RICH TEA L1new	448.800
17	RICH TEA L2			0	RICH TEA L1new	
18	MALTI L4			1	SODIUM	1.200
19	SNOWY L4			2	AMMONIUM	11.500
20	MALTY L2			3	SALT	1.600
21	Sugar water			4	Sugar	62.500
22	sugar water			5	WATER	72.000
23	RICH TEA L1new			6	TRANSF B7>B3	14.300
24	sugar water			7	UNLOAD	0.000
25	test l3			8	FLOUR 2	300.000
26	micro l1			9	UNLOAD	0.000
27	ammonium l1			10	-----	0.000
28	sugar water			11	-----	0.000
29	test_sona			12	-----	0.000
30	RICH TEA L3			13	-----	0.000
				14	-----	0.000
				15	-----	0.000
				16	-----	0.000

Select recipe

Click on the name field or green arrow button to access the page where the recipe can be selected

Select the recipe in the RECIPE LIST to the left

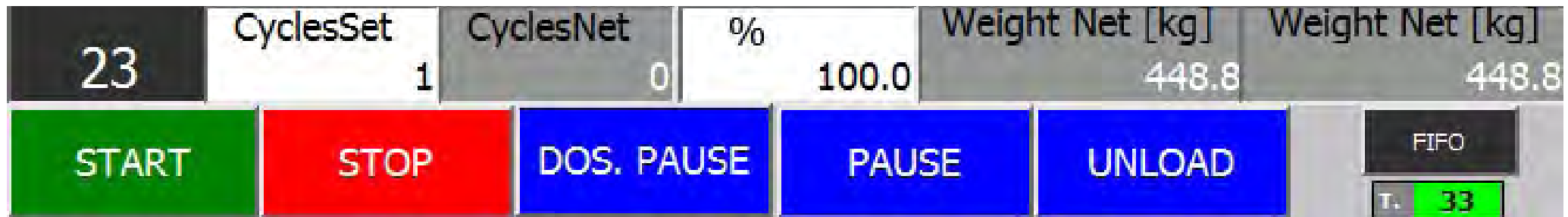
The RECIPE panel visualizes the details of the selected recipe

Press the PRODUCTION button in the top bar to go back to the PRODUCTION page





PRODUCTION CONTROL PROCEDURE



Production details

Use the **PRODUCTION DETAILS** panel to monitor or change the details for the production of the recipe

Control cycles (set and net), weight, percentage or pieces to dose, temperature...

Production commands

Press START to start the production of the selected recipe

Press UNLOAD to authorize unloading (button blinks when an unloading is required)

Press STOP to stop the recipe in production

Press PAUSE DOSING to stop the dosing on all lines temporarily

Press PAUSE to stop the production of the recipe when the current cycle ends





PRODUCTION CONTROL PROCEDURE

B1	SKIP	WAIT. DOS.				PAUSE
Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]	
0	-----	0.00	0.00	± 0.0	0.00	
B2	SKIP	WAIT. DOS.				PAUSE
Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]	
0	-----	0.00	0.00	± 0.0	#####	
B3	SKIP	WAIT. DOS.				PAUSE
Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]	
0	-----	0.00	0.00	± 0.0	0.00	
B4	SKIP	WAIT. DOS.				PAUSE
0	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]	
	-----	0.000	0.000	± 0.000	-61.000	
B5	SKIP	WAIT. DOS.				PAUSE
Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]	
0	-----	0.00	0.00	± 0.0	#####	
B6	SKIP	WAIT. DOS.				PAUSE
Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]	
0	-----	0.000	0.000	± 0.000	-31.000	
B7	SKIP	WAIT. DOS.				PAUSE
Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]	
0	-----	0.00	0.00	± 0.0	-30.50	
B8	SKIP	WAIT. DOS.				PAUSE
Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]	
0	-----	0.00	0.000	± 0.000	0.00	

0-WAITING							
COMMUNICATION MIXER OFF	<table border="0"> <tr> <td>MIXER</td> <td>CEPI</td> </tr> <tr> <td>Request Product1</td> <td>EndProduct1</td> </tr> <tr> <td>Request Product2</td> <td>EndProduct2</td> </tr> </table>	MIXER	CEPI	Request Product1	EndProduct1	Request Product2	EndProduct2
MIXER	CEPI						
Request Product1	EndProduct1						
Request Product2	EndProduct2						

	NR	Pro	Name Product	ORIG [Kg]	SET[Kg]	DOS [Kg]	SCR
	1	73	SODIUM	1.200	1.200	0.000	0000000000
	2	74	AMMONIUM	11.500	11.500	0.000	0000000000
	3	71	SALT	1.600	1.600	0.000	0000000000
	4	21	Sugar	62.500	62.500	0.000	0000000000
	5	1	WATER	72.000	72.000	0.000	0000000000
	6	79	TRANSF B7>B3	14.300	14.300	0.000	0001000000
	7	0	UNLOAD	0.000	0.000	0.000	0000000101
	8	12	FLOUR 2	300.000	300.000	0.000	0000000000
	9	0	UNLOAD	0.000	0.000	0.000	0000000010
	10	0	-----	0.000	0.000	0.000	0000000000
	11	0	-----	0.000	0.000	0.000	0000000000
	12	0	-----	0.000	0.000	0.000	0000000000
	13	0	-----	0.000	0.000	0.000	0000000000
	14	0	-----	0.000	0.000	0.000	0000000000
	15	0	-----	0.000	0.000	0.000	0000000000
	16	0	-----	0.000	0.000	0.000	0000000000

Monitor production

Hopper details

show the state of each hopper (name and number of ongoing recipe, set and net weight, tolerance...)

State bar

shows the current state of the dosage on the line

Communication with mixer

shows the requests from the mixer and the replies from the CEPI system

Recipe report

shows the details of the ongoing recipe: state of the step, name and number of product dosed in step, set and net weight, temperature...





PRODUCTION CONTROL EXAMPLES

PRODUCTION
SINGLE
SYNOPTIC
RECIPES
MENÙ
SILENCE SIREN
RESET ALL GENERAL

MIXER 1
MIXER 2
MIXER 3
MIXER 4

CONTROL

LOC
 PC1
 PC2

0-WAITING
SINGLE

Nr	Name
12	FLOUR 2

SET[Kg]
300.000

X

START
STOP
PAUSE
UNLOAD

T. 33

END1
END1

Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]
B1 SKIP WAIT. DOS. PAUSE					
0	-----	0.00	0.00	± 0.0	0.00
B2 SKIP WAIT. DOS. PAUSE					
0	-----	0.00	0.00	± 0.0	0.00
B3 SKIP WAIT. DOS. PAUSE					
0	-----	0.00	0.00	± 0.0	0.00
B4 SKIP WAIT. DOS. PAUSE					
0	-----	0.000	0.000	± 0.000	-61.000
B5 SKIP WAIT. DOS. PAUSE					
0	-----	0.00	0.00	± 0.0	-31.600
B6 SKIP WAIT. DOS. PAUSE					
0	-----	0.000	0.000	± 0.000	-30.500
B7 SKIP WAIT. DOS. PAUSE					
0	-----	0.00	0.00	± 0.0	0.00
B8 SKIP WAIT. DOS. PAUSE					
0	-----	0.00	0.000	± 0.000	0.00

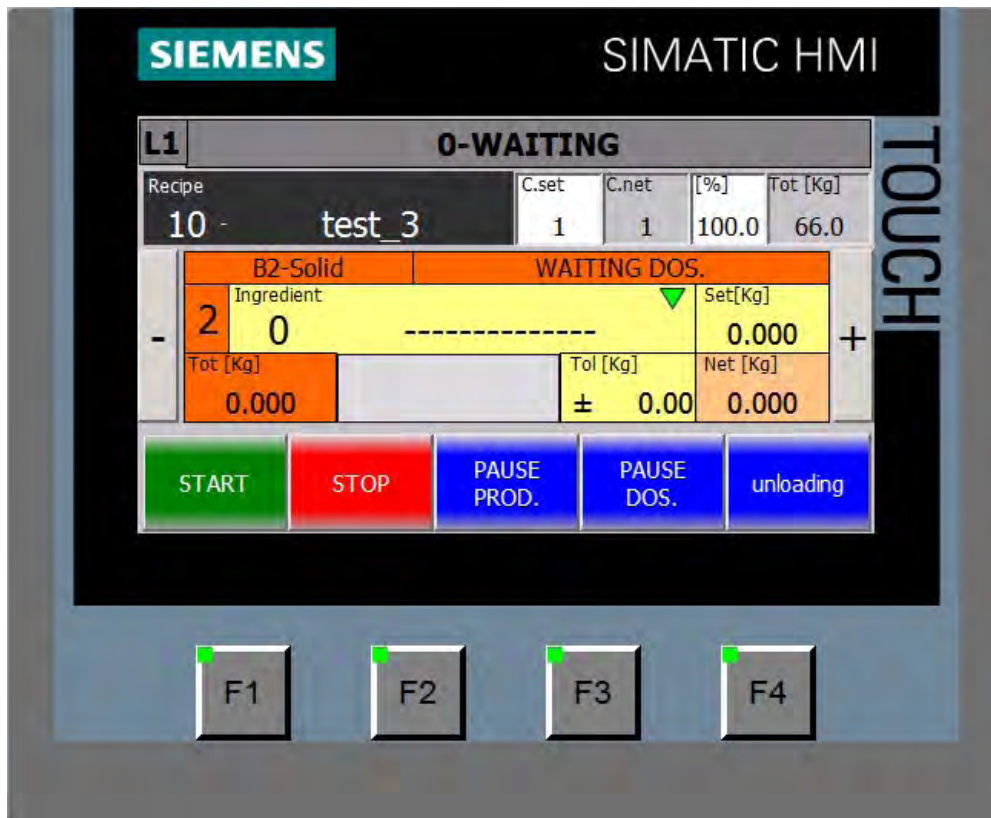
COMMUNICATION MIXER ON	MIXER	CEPI
	Request Product1	EndProduct1
	Request Product2	EndProduct2

Single dosing





PRODUCTION CONTROL EXAMPLES



Production page
on Touch panel TP400
controlling the line





RECIPE CREATION

PRODUCTION		SINGLE		SYNOPTIC		RECIPES		MENÙ		SILENCE SIREN		RESET ALL GENERAL	
N.	Name	Nr	Name	Tot [Kg]									
16	GINGER L2	30	RICH TEA L3	452.800									
17	RICH TEA L2												
18	MALTI L4												
19	SNOWY L4												
20	MALTY L2												
21	Sugar water												
22	sugar water												
23	RICH TEA L1new												
24	sugar water												
25	test l3												
26	micro l1												
27	ammonium l1												
28	sugar water												



CREATE RECIPES FOR LINES AND PLANT, SEND THEM TO SUPERVISOR AND VICEVERSA



OPERATOR PANEL

TOUCH PANEL AND PC PANEL



RECIPE CREATION

EXAMPLES

Recipe page

PRODUCTION		SINGLE		SYNOPTIC		RECIPES		MENÙ		SILENCE SIREN		RESET ALL GENERAL		!	
N.		Name		Nr		Name		Tot [Kg]		12/02/2016 20:36:45		✕		💾	
16		GINGER L2		30		RICH TEA L3		452.800							
17		RICH TEA L2													
18		MALTI L4													
19		SNOWY L4													
20		MALTY L2													
21		Sugar water													
22		sugar water													
23		RICH TEA L1new													
24		sugar water													
25		test l3													
26		micro l1													
27		ammonium l1													
28		sugar water													
29		test_sona													
30		RICH TEA L3													

N. pas	N. pro.	Name product	SET [Kg]	Spd %	T [°C]	Unloading	Options
1	21	Sugar	62.500	0	0.0		
2	1	WATER	76.000	0	0.0		
3	61	SALT	1.600	0	0.0		
4	64	AMMONIUM	11.500	0	0.0		
5	63	SODIUM	1.200	0	0.0		
6	69	TRASF B6>B3	14.300	0	0.0	0000100000	
7	0	UNLOAD	0.000	0	0.0	0000000101	
8	11	FLOUR 1	300.000	0	0.0		
9	0	UNLOAD	0.000	0	0.0	0000000010	
10	0	-----	0.000	0	0.0		
11	0	-----	0.000	0	0.0		
12	0	-----	0.000	0	0.0		
13	0	-----	0.000	0	0.0		
14	0	-----	0.000	0	0.0		
15	0	-----	0.000	0	0.0		
16	0	-----	0.000	0	0.0		





RECIPE CREATION PROCEDURE

PRODUCTION		SINGLE		SYNOPTIC		RECIPES		MENÙ		SILENCE SIREN		RESET ALL GENERAL		!		
Nr	30	Name	RICH TEA L3			Tot [Kg]	452.800			12/02/2016 20:36:45			X		Save	
			<input checked="" type="checkbox"/>	L1	<input checked="" type="checkbox"/>	L2	<input checked="" type="checkbox"/>	L3	<input checked="" type="checkbox"/>	L4						
N.	Name	N. pas	N. pro.	Name product	SET [Kg]	Spd %	T [°C]	Unloading	Options							
16	RICH TEA L2															
17	RICH TEA L2															
18	MALTI L4															
19	SNOWY L4															
20	MALTY L2															
21	Sugar water															
22	sugar water															
23	RICH TEA L1new															
24	sugar water															
25	test l3															
26	micro l1															
27	ammonium l1															
28	sugar water															
29	test_sona															
30	RICH TEA L3															
		1	21	Sugar	62.500	0	0.0									
		2	1	WATER	3	0	0.0									
		3	61	SALT	1.600	0	0.0									
		4	64	AMMONIUM	11.500	0	0.0									
		5	63	SODIUM	1.200	0	0.0									
		6	69	TRASF B6>B3	14.300	0	0.0	0000100000								
		7	0	UNLOAD	0.000	0	0.0	0000000101								
		8	11	FLOUR 1	300.000	0	0.0									
		9	0	UNLOAD	0.000	0	0.0	0000000010								
		10	0	-----	0.000	0	0.0									
		11	0	-----	0.000	0	0.0									
		12	0	-----	0.000	0	0.0									
		13	0	-----	0.000	0	0.0									
		14	0	-----	0.000	0	0.0									
		15	0	-----	0.000	0	0.0									
		16	0	-----	0.000	0	0.0									

Recipe list (1)

Select the recipe with the VISUALIZE button (2)

List can contain up to 300 recipes

Recipe detail (3)

Visualizes the details of the selected recipe

Click on any step and enter product number and name, weight, speed of dosing, temperature, unloading step...





RECIPE CREATION PROCEDURE

Nr	Name	Tot [Kg]	Date/Time	Options	Save
30	RICH TEA L3	452.800	12/02/2016 20:36:45	<input type="checkbox"/> L1 <input type="checkbox"/> L2 <input checked="" type="checkbox"/> L3 <input type="checkbox"/> L4	<input type="checkbox"/> <input type="checkbox"/>

PASSO 9

← 2 →

PRODOTTO	PESO	TEMP.
42	3,000 Kg	0,0 °C

SCARICO

B1 - LIQUIDI

B2 - POLVERI

B3 - OLIO

B4 - TRIMIX

OPZIONI

DISABILITA

TEMPO OPZIONE 0 s

OPTIONS 8

Disable

Optional Time	Work Time	Pause Time
0 m	0 m	0 m

Step options

to select an activity as a step (mixing, cooling...) and set a duration time for such activities (8)

Unloading steps

Step is green if includes an unloading. Click on arrow to see what hopper is unloaded in the step (9)

Header, step options and unloading steps

Flag the lines the recipe is destined to (4)

Press RESET to reset all recipe steps (5)

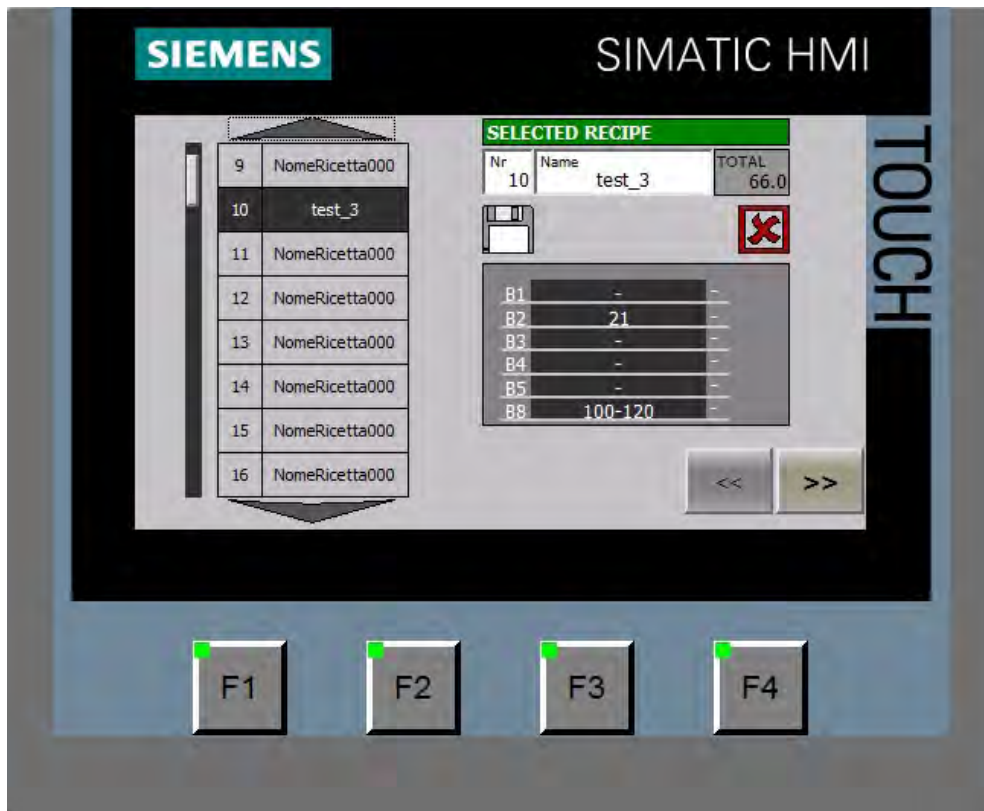
Press SAVE to save the recipe (6)

The recipe header shows number, name, total weight and time of last memorization (7)





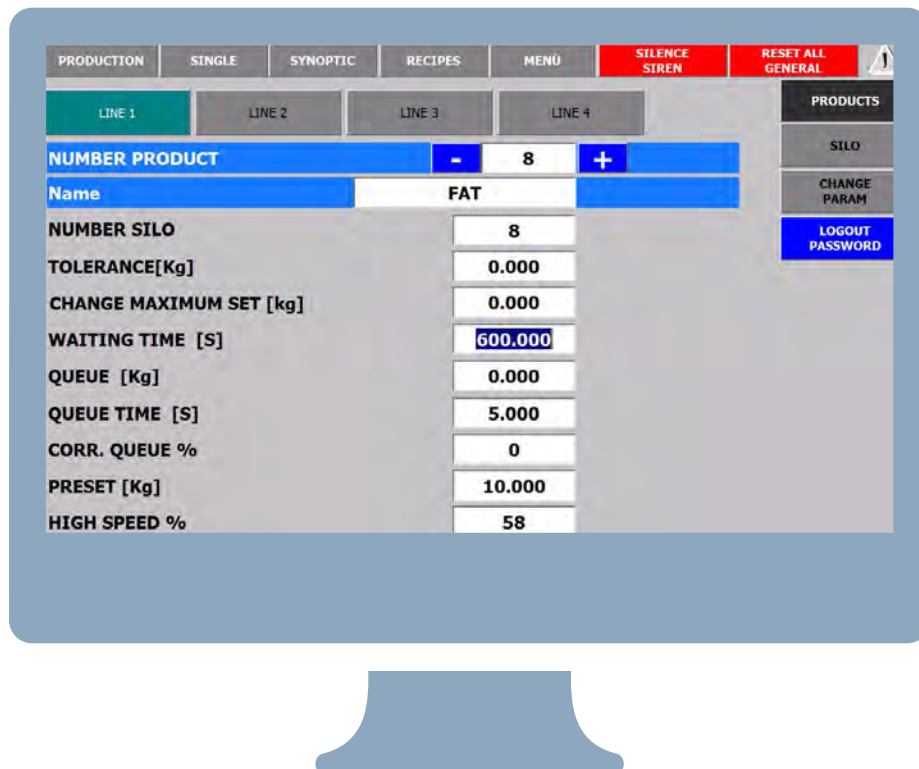
RECIPE CREATION EXAMPLES



Recipe creation
on Touch panel TP400
controlling the line



PARAMETERS SETTING



SET:

- PRODUCT PARAMETERS FOR THE DOSING, STORING AND CHANGE
- HOPPER PARAMETERS
- PLANT AND LINE DATA
- SYSTEM PARAMETERS





PARAMETERS SETTING EXAMPLES

PRODUCTION	SINGLE	SYNOPTIC	RECIPES	MENÙ	SILENCE SIREN	RESET ALL GENERAL	
LINE 1	LINE 2	LINE 3	LINE 4	PRODUCTS			
NUMBER PRODUCT			-	8	+		
Name			FAT				
NUMBER SILO			8				
TOLERANCE [Kg]			0.000				
CHANGE MAXIMUM SET [kg]			0.000				
WAITING TIME [S]			600.000				
QUEUE [Kg]			0.000				
QUEUE TIME [S]			5.000				
CORR. QUEUE %			0				
PRESET [Kg]			10.000				
HIGH SPEED %			58				
SLOW SPEED %			18				
				SILO			
				CHANGE PARAM			
				LOGOUT PASSWORD			

Product parameters
for the dosing





PARAMETERS SETTING EXAMPLES

PRODUCTION	SINGLE	SYNOPTIC	RECIPES	MENÙ	SILENCE SIREN	RESET ALL GENERAL	
							PRODUCTS
							SILO
							CHANGE PARAM
							LOGOUT PASSWORD
NUMBER SILO		-	8	+			
Name	FAT						
STOCKS [Kg]	10171.1	LOAD	0.0	[Kg]			
MIN STOCK [Kg]	500.0						
Mx SILO [Kg]	10500.0						
MAX BARGRAPH [Kg]	12000.0						

Product parameters
for the storing





PARAMETERS SETTING EXAMPLES

PRODUCTION	SINGLE	SYNOPTIC	RECIPES	MENÜ	SILENCE SIREN	RESET ALL GENERAL	
LINE 1	LINE 2	LINE 3	LINE 4	PRODUCTS			
				SILO			
NUMBER PRODUCT				-	11	+	CHANGE PARAM
Name	FLOUR 1			LOGOUT PASSWORD			
NUMBER SILO	11						
STOCK PRODUCTS 1	11						
STOCK PRODUCTS 2	12						
STOCK PRODUCTS 3	0						
STOCK PRODUCTS 4	0						
CURRENT STOCK	0						
CHANGE CONTROL	MINIMUM LEVEL						

Product parameters
for the change





PARAMETERS SETTING EXAMPLES

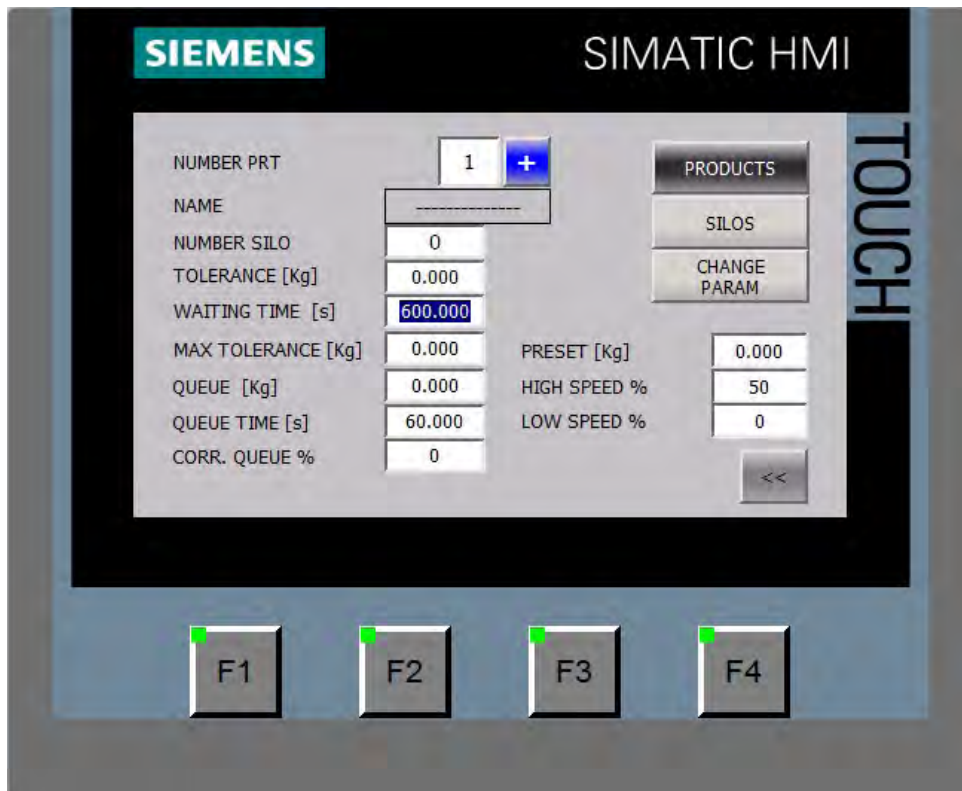
PRODUCTION	SINGLE	SYNOPTIC	RECIPES	MENÜ	SILENCE SIREN	RESET ALL GENERAL	
LINE 1	LINE 2	LINE 3	LINE 4				
Hopper		1					
WEIGHT MAX [KG]		999.000					
WEIGHT MIN [KG]		0.100					
DELTA TIME FOR WEIGHT STABLE [s]		1.0					
DELTA TIME FOR WEIGHT STABLE [Kg]		0.200					
UNLOADING END TIME [S]		10.000					
END CYCLE TIME [S]		0.500					
RECIRCLE TIME [S]		10.000					

Hopper parameters





PARAMETERS SETTING EXAMPLES



Product parameters
on Touch panel TP400
controlling the line

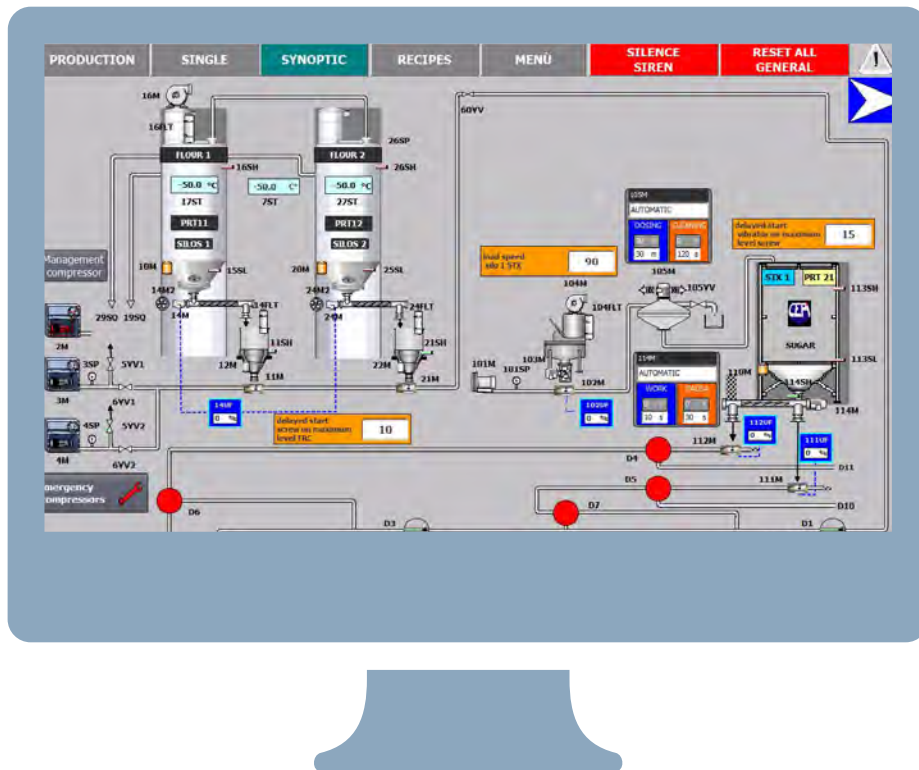


OPERATOR PANEL

TOUCH PANEL AND PC PANEL



OVERVIEW



**OVERVIEW
OF THE PLANT**

**MAINTENANCE
WITH MANUAL
WORKING MODALITY**



OPERATOR PANEL

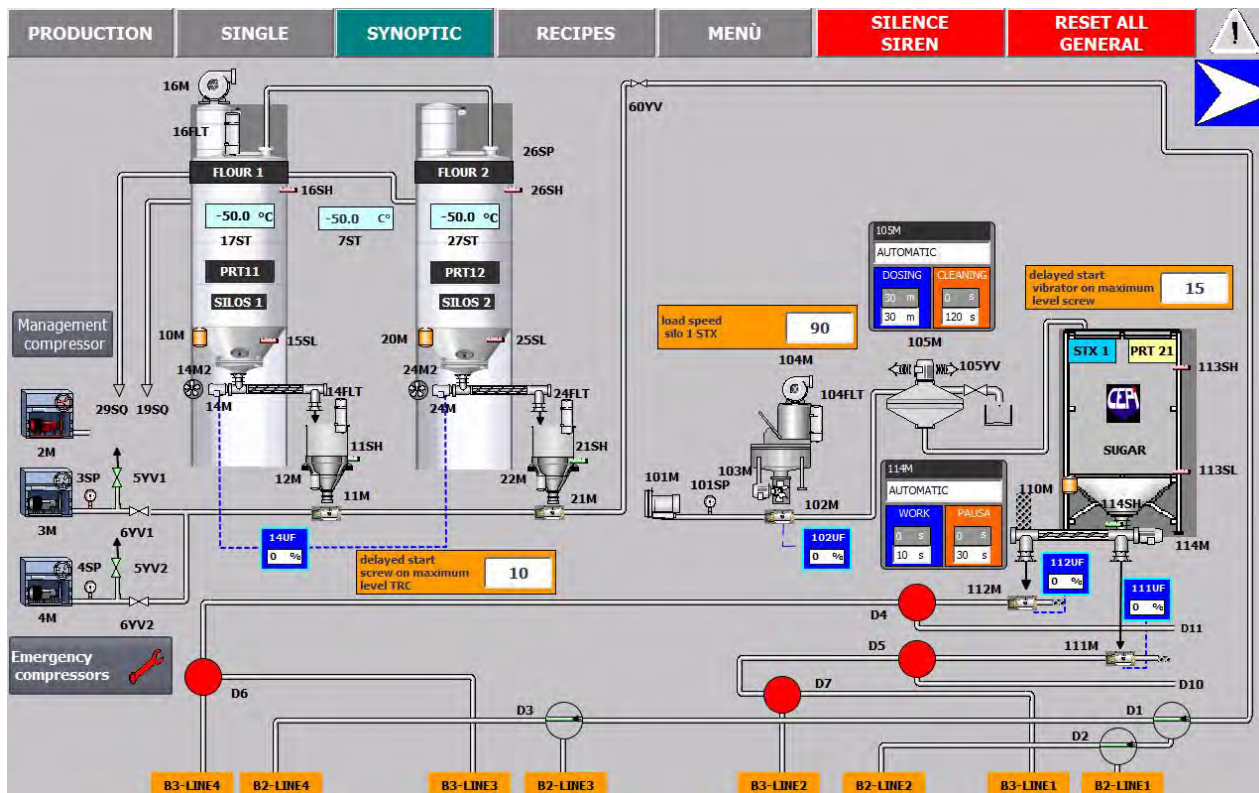
TOUCH PANEL AND PC PANEL



OVERVIEW

EXAMPLES

Overview of silos



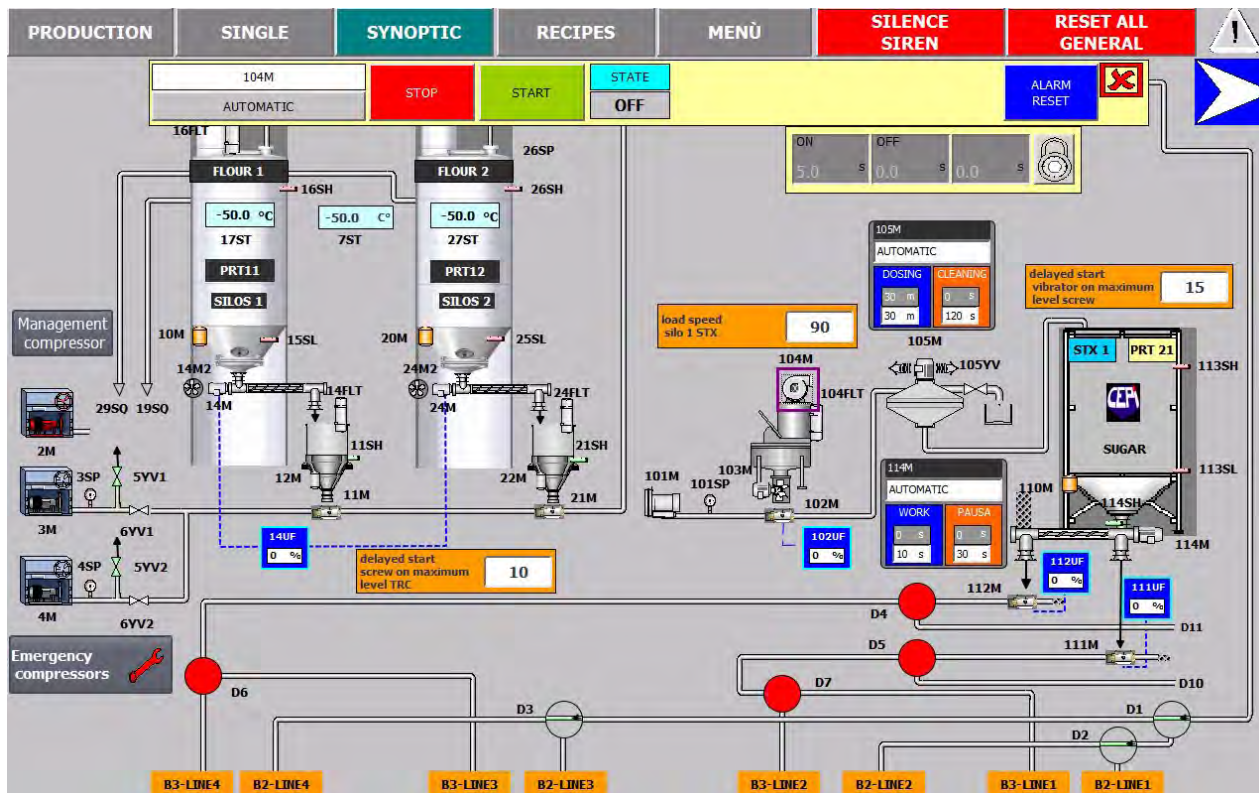
OPERATOR PANEL

TOUCH PANEL AND PC PANEL



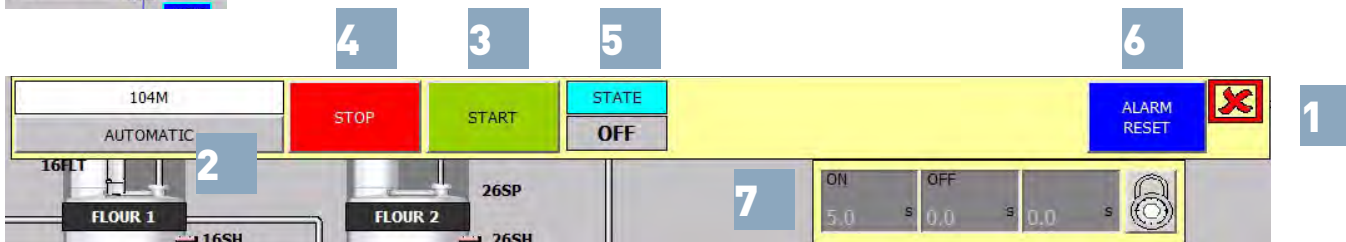
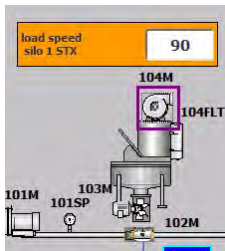
OVERVIEW EXAMPLES

Maintenance





MAINTENANCE PROCEDURE



Command an utility in the manual working modality

Manual commands

Click on the utility to visualize its manual commands (1)

AUTOMATIC/MANUAL button

Press to switch the utility to the manual or automatic working modality (2)

RUN

Press to start the utility (3)

STOP

Press to stop the utility (4)

STATE

Shows the state of the utility
If the utility is under inverter, its speed is shown in the SPEED (%) field (5)

RESET

Press to reset eventual alarms of the selected utility only (6)

TIMES panel

Set sensitive times for the utilities. Special parameters for filters and sensors (7)

