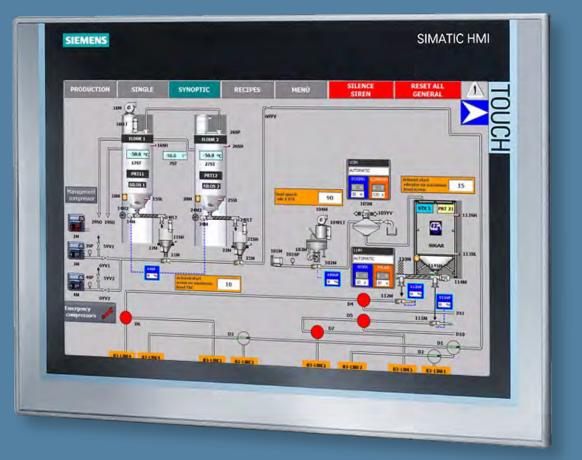
# 

PRODUCTION CONTROL RECIPES CREATION PARAMETERS SETTING OVERVIEW





# TOOL FOR THE DOSING CONTROL

automatic metering of powders and liquids continuous or batch, positive, by loss of weight, by volume or by weight silo weight control in real time automation also via the plc TP400 TP700 TP900 TP1200

#### **Process supervision system**

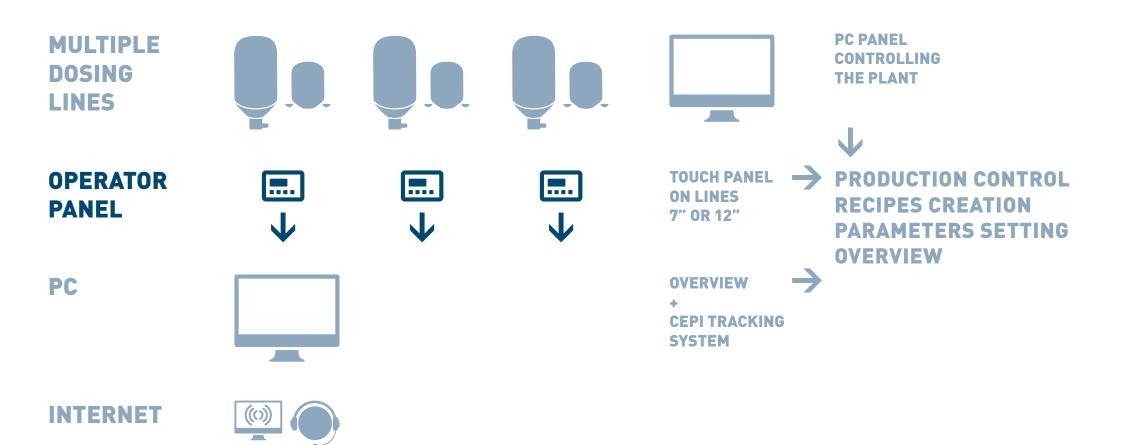
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which uses the Siemens WinCC Flexible Runtime program.

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

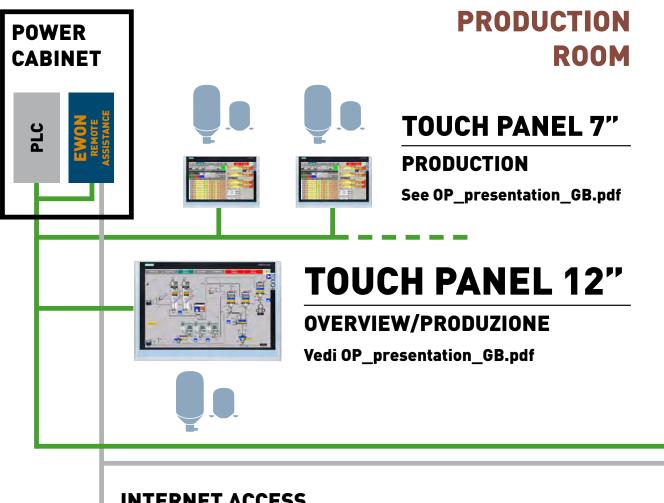












## PRODUCTION MANAGER ROOM

PC

**OVERVIEW** See OP presentation GB.pdf

**CTS TRACEABILITY** 

See CTS\_presentation\_GB.pdf



#### **INTERNET ACCESS**





# **PRODUCTION CONTROL**

PROD	оист	ION	SINGLE	5Y	NOPTIC	RECIP	E5 M	IENÚ	SILE			SET ALL	$\underline{\Lambda}$
		Provent of		and the second s	1		CONTROL	B1	SKIP	WAIT.	DOS.		PAUSE
MIXER	<u>.</u>	MIXER	2	MEXER 3		IDXER 4		Nr	Name	Set[Kg] 0.00	Net[Kg] 0.00	Tol. [Kg]	Tot [Kg]
				0-WAIT	ING					1 1			
r.	1	lame		RICH 1	EA L1ne	w		B2	SKIP	WAIT	DOS	V	PAUSE
23	0	CyclesSet (	CyclesNe		Weigh	t Net (kg) \ 448.8	Weight Net [kg] 448.	Nr	Name	Set[Kg] 0.00	Net[Kg] 0.00	Tol. [Kg] ± 0.0	Tot (Kg)
STAF	т	STOP	DOS	PAUSE	PALISE	UNLOAD	FIFO	<b>B</b> 3	SKIP	WAIT	DOS.		PAUSE
NR		Name Pro		ORIGE Kg)	SET[Kg]	DOS[ Kg]	SCR	Nr	Name	Set[Kg] 0.00	Net[Kg] 0.00	Tol. [Kg] ± 0.0	Tot (Kg)
THIS .	73	SODIL		1.200	1,200	0.000	0000000000	B4	SKIP	WAIT.	DOS.		PAUSE
2	74	AMMON		11.500	11.500	0.000	0000000000		Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]
3	71	SALT		1.600	1.600	0.000	0000000000	0		0.000	0.000	± 0.000	
4	21	Suga		62,500	62.500	0.000	0000000000	BS	SKIP	WAIT.		1	PAUSE
5	1	WATE		72.000	72.000	0.000	0000000000	Nr	Name	Set[Kg] 0.00	Net[Kg] 0.00	Tol. [Kg] ± 0.0	Tot (Kg)
6	79	TRANSF E	7>83	14.300	14.300	0.000	0001000000	B6	SKIP	WAIT.	DOS.		PAUSE
7	0	UNLO	AD	0.000	0.000	0.000	000000101	Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot (Kg)
8	12	FLOUR	2	300.000	300.000	0.000	0000000000	0		0.000	0.000	± 0.000	-31.600
9	0	UNLO	AD.	0.000	0.000	0.000	000000010	B7	SKIP	WAIT	DOS.		PAUSE
10	0			0.000	0.000	0.000	0000000000	Nr	Name	Set[Kg] 0.00	Net[Kg] 0.00	Tol. [Kg] ± 0.0	Tat (Kg)
11	0			0.000	0.000	0.000	0000000000			1		0.0	
12	0			0.000	0.000	0.000	000000000	B8 Nr	SKIP	WAIT.	Net[Kg]	Tol. [Kg]	PAUSE Tot [Kg]
13	0			0.000	0.000	0.000	0000000000	0	Name	0.00	0.000	± 0.000	
14	0			0.000	0.000	0.000	0000000000			-	-	-	

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PRODUCTION CONTROL ON LINES AND PLANT

REMOTE AND LOCAL PRODUCTION MODALITY

SINGLE DOSING

REPORT







## **PRODUCTION CONTROL** EXAMPLES

P	PRODUCTION SINGLE SYNOPTIC				NOPTIC	RECIP	ES M	ENÙ		SILENCE SIREN		ET ALL NERAL	
MI	XER		MIXER 2	MIXER 3	M	IXER 4	CONTROL LOC PC1 PC2	B1 Nr	SKIP	WAIT.		Tel [Ka]	PAUSE
		-	-	, Marine Marine			$  \mathbf{O}   \mathbf{O}   \mathbf{O}  $	0	Name	Set[Kg] 0.00	Net[Kg] 0.00	Tol. [Kg] ± 0.0	Tot [Kg]
				0-WAITI	ING								
Nr		N	ame	RICH T	EA L1ne	w		B2	SKIP	WAIT.	DOC		PAUSE
			vclesSet CvclesNet				Veight Net [kg]	Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]
	23		1	0 10	0.00	448.8	448.8						*****
	STAR	т	STOP DOS.	PAUSE	PAUSE	UNLOAD	FIFO	B3	SKIP	WAIT.	DOS.		PAUSE
							1. 33	Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]
	NR	Pro	Name Product	ORIG[ Kg]	SET[Kg]	DOS[ Kg]	SCR	0		0.00		± 0.0	0.00
	1	73	SODIUM	1.200	1.200	0.000	0000000000	B4	SKIP	WAIT.	DOS. Net[Kg]		PAUSE
	2	74	AMMONIUM	11.500	11.500	0.000	0000000000	0	Name		0.000	Tol. [Kg] ± 0.000	Tot [Kg] 61.000
	3	71	SALT	1.600	1.600	0.000	0000000000	B5	SKIP	WAIT.	DOS.		PAUSE
	4	21	Sugar	62.500	62.500	0.000	0000000000	Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]
	5	1	WATER	72.000	72.000	0.000	0000000000	0		0.00	0.00	± 0.0	######
	6	79	TRANSF B7>B3	14.300	14.300	0.000	0001000000	B6	SKIP	WAIT.			PAUSE
	7	0	UNLOAD	0.000	0.000	0.000	000000101	Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]
111	8	12	FLOUR 2	300.000	300,000	0.000	0000000000	0		0.000	0.000	± 0.000	
	9	0	UNLOAD	0.000	0.000	0.000	000000010	B7	SKIP	WAIT.		- 1 54 3	PAUSE
3 - 1	10	0		0.000	0.000	0.000	0000000000	Nr	Name	Set[Kg]	Net[Kg] 0.00	Tol. [Kg] ± 0.0	Tot [Kg] -30.50
	11	0		0.000	0.000	0.000	0000000000	B8	SKIP	WAIT.		0.0	PAUSE
	12	0		0.000	0.000	0.000	0000000000	Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]
	13	0		0.000	0.000	0.000	0000000000	0			0.000	± 0.000	0.00
	14	0		0.000	0.000	0.000	0000000000						
	15	0		0.000	0.000	0.000	0000000000	COMM	UNICATION				
	16	0		0.000	0.000	0.000	0000000000	MI	XER OFF				
<			1	A		Contraction of the local division of the loc							

#### **Production page**



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## 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

PROD	UCTION	SINGLE	SYNOPTIC	REC	IPES	MENÙ	SILENCE		RESET GENER	
		0-WAITING			Nr	Name 23 RICH TEA L1r	Tot I new 4	<b>Ka</b> 48.800		
	Nr.	Name Recept	Show Prod	NR	0	RICH TEA L1new	SET[Kg]	T[°C]	Spd%	SCR
	16	GINGER 1.2		1	73	SODIUM	1.200	0.0	0	0000000000
	17	RICH TEA L2		2	74	AMMONIUM	11.500	0.0	0	000000000
				3	71	SALT	1.600	0.0	0	0000000000
1	18	MALTI L4		4	21	Sugar	62.500	0.0	0	0000000000
	19	SNOWY L4		5	1	WATER	72.000	0.0	0	0000000000
	20	MALTY L2		6	79	TRANSF B7>B3	14.300	0.0	0	0001000000
	21	Sugar water		7	0	UNLOAD	0.000	0.0	0	000000101
	22	sugar water		8	12	FLOUR 2	300.000	0.0	0	0000000000
	23	RICH TEA L1new		9	0	UNLOAD	0.000	0.0	0	000000010
	24	sugar water		10	0		0.000	0.0	0	0000000000
II	25	test 13		11	0		0.000	0.0	0	0000000000
	26	micro I1		12	0		0.000	0.0	0	0000000000
				13	0		0.000	0.0	0	0000000000
	27	ammoniun 11		14	0		0.000	0.0	0	0000000000
	28	sugar water		15	0		0.000	0.0	0	0000000000
	29	test_sona		16	0		0.000	0.0	0	0000000000
Y	30	RICH TEA L3								

#### 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

23	CyclesSet 1	CyclesNet %	100.0	Weig	ht Net [kg] 448.8	Weight Net [kg] 448.8
START	STOP	DOS. PAUSE	PAU	SE	UNLOAD	FIFO T. 33

#### **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



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## 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.			PAUSE						
Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]						
0		0.00	0.00	± 0.0	0.00						
B4	SKIP	WAIT.			PAUSE						
0	Name	Set[Kg] 0.000	Net[Kg] 0.000	Tol. [Kg] ± 0.000	Tot [Kg]						
_				1 0.000							
B5	SKIP	WAIT.			PAUSE						
Nr 0	Name	Set[Kg] 0.00	Net[Kg] 0.00	Tol. [Kg] ± 0.0	Tot [Kg]						
B6	SKIP	WAIT.		- 0.0	PAUSE						
Nr		Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]						
0	Name	0.000	0.000	± 0.000	-31.600						
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.									
Nr	Name	Set[Kg]	Net[Kg]	Tol. [Kg]	Tot [Kg]						
0		0.00	0.000	± 0.000	0.00						

	0-WAITING													
	MUNICA IXER OF		<b>IIXER</b> equest Produ equest Produ			I roduct1 roduct2	0							
N	R Pro	Nar	ne Product	ORIG[ Kg]	SET[Kg]	DOS[ Kg]	SCR							
1	L 73	5	ODIUM	1.200	1.200	0.000	000000000							
-	2 74	AM	MONIUM	11.500	11.500	0.000	000000000							
3	3 71	1	SALT	1.600	1.600	0.000	0000000000							
4	1 21	1	Sugar	62.500	62.500	0.000	0000000000							
5	5 1	1	WATER	72.000	72.000	0.000	0000000000							
e	5 79	TRA	NSF B7>B3	14.300	14.300	0.000	0001000000							
7	7 0	L	INLOAD	0.000	0.000	0.000	000000101							
8	3 12	F	LOUR 2	300.000	300.000	0.000	0000000000							
9	0	L	INLOAD	0.000	0.000	0.000	000000010							
1	0 0			0.000	0.000	0.000	0000000000							
1	1 0			0.000	0.000	0.000	000000000							
1	2 0			0.000	0.000	0.000	0000000000							
1	3 0			0.000	0.000	0.000	000000000							
1	4 0	- 44		0.000	0.000	0.000	0000000000							
1	5 0			0.000	0.000	0.000	000000000							
1	6 0			0.000	0.000	0.000	000000000							

#### **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

PRODU	JCTION	SINGLE	SYN	OPTIC	RECIP	PES	ME	NÙ		SILE			SET ALL	
MIXER 1		MIXER 2	MIXER 3	MD	KER 4		PC1 PC2	B1 Nr 0	SKIP Name		WAIT. Set[Kg] 0.00	DOS. Net[Kg] 0.00	Tol. [Kg] ± 0.	PAUSE Tot [Kg] 0 0.00
		_	0-WAITI SINGLE	10.24				B2	SKIP	_	WAIT.	DOC		PAUSE
Nr	Na	me		OUR 2				Nr 0	Name		Set[Kg] 0.00	Net[Kg] 0.00	Tol. [Kg] ± 0.	Tot [Kg]
12	SET	[Kg] 300.00						B3 Nr 0	SKIP Name		WAIT. Set[Kg] 0.00	DOS. Net[Kg] 0.00	Tol. [Kg] ± 0.	PAUSE Tot [Kg] 0 0.00
				1		Г	X	B4	SKIP Name		WAIT. Set[Kg]	DOS. Net[Kg]	Tol. [Kg]	PAUSE Tot [Kg]
B1	B2	B3 B4	B5 B6	B7	B8			0 B5 Nr	SKIP Name		0.000 WAIT. Set[Kg]	0.000 DOS. Net[Kg]	± 0.00	0 -61.000 PAUSE Tot [Kg]
STAR	r i	STOP P	AUSE	UNLOAD	т.	33		0 B6			0.00 WAIT.	0.00 DOS.	± 0.	D # # # # # # # PAUSE
			END1 I	END1				Nr 0			Set[Kg] 0.000	Net[Kg] 0.000	Tol. [Kg] ± 0.00	
								B7 Nr 0	SKIP Name		WAIT. Set[Kg] 0.00	Net[Kg] 0.00	Tol. [Kg] ± 0.	PAUSE Tot [Kg] 0 - 30.50
NR	Pro	Name Product	DOS[ Kg]	SCR				B8	SKIP	1	WAIT.	DOS.		PAUSE
1	73	FLOUR 2	0.000	000000000				Nr O	Name		Set[Kg] 0.00	Net[Kg] 0.000	Tol. [Kg] ± 0.00	Tot [Kg] 0 0.00
2	74 71		0.000	0000000000					UNICATION XER ON	MIXER Request P	Product1	CE	PI Product1	0
								MI	XER UN	Request F		-	dProduct2	ŏ

#### Single dosing





### **PRODUCTION CONTROL** EXAMPLES

L11 Recipe	0-WAITING [C.set [C.net [%] [Tot [Kg]]								
10 test_3			56.0						
- 2 0 Tot [Kg] 0.000		Set[Kg] 0.000 Net [Kg] 0.000	+						
START STOP		USE OS. unloa	ding						
START STOP			ding						

Production page on Touch panel TP400 controlling the line





# **RECIPE CREATION**

ODUCTI	ON SINGLE	s	YNOPTIC		RECIP	ES M	ENÙ	SILENC		RESET AL GENERA
Ν.	Name		Nr 30	Nan	RICH T		Tot [Kg] 452.800	12	/02/201	6 20:36:45
16	GINGER L2	2	A		L1	2 12	13		Z 14	
17	RICH TEA L2	2	V	N. pas	N. pro.	Name product	SET [Kg]	Spd %	T [°C]	Unloading
18	MALTI L4	3	D)	1	21	Sugar	62.500	0	0.0	
19	SNOWY L4	2	2	2	1	WATER	76.000	0	0.0	
19	SNOWT LT	-	2	3	61	SALT	1.600	0	0.0	
20	MALTY L2	2		4	64	AMMONIUM	11.500	0	0.0	
21	Sugar water	2	3	5	63	SODIUM	1.200	0	0.0	
22	sugar water	Ð	2	6	69	TRASF B6>B	3 14.300	0	0.0	0000100000
23	RICH TEA Linew	3	2	7	0	UNLOAD	0.000	0	0.0	0000000101
	KICH TEX EINEW		2	8	11	FLOUR 1	300.000	0	0.0	
24	sugar water	Ð	2	9	0	UNLOAD	0.000	0	0.0	0000000010
25	test I3	3	3	10	0		0.000	0	0.0	
26	micro I1	D		11	0		0.000	0	0.0	
27	ammoniun I1	D	2	12	0		0.000	0	0.0	
-			2	13	0		0.000	0	0.0	

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







#### RECIPE CREATION EXAMPLES

DUCTI	ON SINGLE		SYNOPTIC		RECIP	ES MI	ENÙ	SILENC	E	RESET ALL GENERAL	Â
N.	Name		Nr 30	Nan		TEA L3	Tot [Kg] 452.800	12	/02/201	6 20:36:45	
16	GINGER L2	D	$\triangle$		11	V L2	V L3		2 L4		
17	RICH TEA L2	D	$\checkmark$	N. pas	N. pro.	Name product	SET [Kg]	Spd %	T [°C]	Unloading	Options
18	MALTI L4	D	<b>D</b>	1	21	Sugar	62.500	0	0.0		
19	SNOWY L4	D		2	1	WATER	76.000	0	0.0	-	
20	MALTY L2	N		3	61	SALT	1.600	0	0.0		
20	MALIY L2	-		4	64	AMMONIUM	11.500	0	0.0		
21	Sugar water	D		5	63	SODIUM	1.200	0	0.0		
22	sugar water	D	2	6	69	TRASF B6>B3	3 14.300	0	0.0	0000100000	
23	RICH TEA Linew	N.	R	7	0	UNLOAD	0.000	0	0.0	0000000101	
		D	R	8	11	FLOUR 1	300.000	0	0.0		
24	sugar water	1000		9	0	UNLOAD	0.000	0	0.0	0000000010	
25	test I3	D		10	0		0.000	0	0.0		
26	micro l1	D		11	0		0.000	0	0.0		
27	ammoniun l1	D		12	0		0.000	0	0.0		
28	sugar water	D	2	13	0		0.000	0	0.0		
20	Sugar Water	_		14	0		0.000	0	0.0		
29	test_sona	D		15	0		0.000	0	0.0		
30	RICH TEA L3	D	P	16	0		0.000	0	0.0		

#### Recipe page





#### RECIPE CREATION PROCEDURE

ODUCTI	ON SINGLE		SYNOP	тіс		RECIP	ES M	ENÙ	SILENC	E	RESET ALL GENERAL	
Ν.	Name		N	lr 30	Nan F		TEA L3	Tot [Kg] 452.800			6 20:36:45	
16	R L2	D	4	$\Delta$		L1	L2	V L3		L4		
17	RA L2	D			N. pas	N. pro.	Name product	SET [Kg]	Spd %	T [°C]	Unloading	Options
18	MALTI L4	D	1	D	1	21	Sugar	63 500	0	0.0		
19	SNOWY L4	D	2	D	2	1	WATER	3	0	0.0		[
				D	3	61	SALT	1.600	0	0.0		
20	MALTY L2	3		D	4	64	AMMONIUM	11.500	0	0.0		
21	Sugar water	D		D	5	63	SODIUM	1.200	0	0.0		
22	sugar water	D			6	69	TRASF B6>B3	3 14.300	0	0.0	0000100000	
23	RICH TEA L1new	D		D	7	0	UNLOAD	0.000	0	0.0	0000000101	
		-		D	8	11	FLOUR 1	300.000	0	0.0		
24	sugar water	D	Ī	D	9	0	UNLOAD	0.000	0	0.0	0000000010	
25	test I3	D	Ī	D	10	0		0.000	0	0.0		
26	micro l1	D		D	11	0		0.000	0	0.0		
27	ammoniun I1	D		D	12	0		0.000	0	0.0		
28	sugar water	D			13	0		0.000	0	0.0		
20	sugar water			D	14	0	(	0.000	0	0.0		
29	test_sona	D		D	15	0		0.000	0	0.0		
30	RICH TEA L3	D		D	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



PA550		9	>		<b>J</b>	2
PRODOTTO		PESO		TEM		
42	•	3,000	Kg	0,0	°C	
SCARICO						
🛃 B1 - LIQUIDI						
🛃 B2 - POLVERI						
🛃 B3 - OLIO						
B4 - TRIMIX						
ODZIONI						
OPZIONI						
M					_	
	TE	MPO OF	ZION	EIO	s	
M						



OPTIONS Disable			8	
Optional Time	Work Time	Pa	ause Time	-

#### 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 reciped 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

SIEMI	ENS	SIMATIC HMI
9	NomeRicetta000	SELECTED RECIPE
10	test_3	10 test_3 66.0
11	NomeRicetta000	
12	NomeRicetta000	81
13	NomeRicetta000	<u>B2</u> <u>21</u> - B3 <u>-</u> -
14	NomeRicetta000	<u>84</u> <u>85</u>
15	NomeRicetta000	<u>B8 100-120 -</u>
16	NomeRicetta000	~ >>

Recipe creation on Touch panel TP400 controlling the line



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# **PARAMETERS SETTING**

PRODUCTION	SINGLE SYNOPTI	C RECIPES	MENÜ	SILENCE SIREN	RESET ALL GENERAL
LINE 1	LINE 2	LINE 3	LINE 4		PRODUCTS
NUMBER PRODU	ст	-	8	+	SILO
Name		FAT	1		CHANGE PARAM
NUMBER SILO			8		LOGOUT
TOLERANCE[Kg]			0.000		
CHANGE MAXIM	UM SET [kg]		0.000		
WAITING TIME	[S]		00.000		
QUEUE [Kg]			0.000		
QUEUE TIME [S	1		5.000		
CORR. QUEUE %	<b>,</b>		0		
PRESET [Kg]			10.000		
HIGH SPEED %			58		





PRODUCT PARAMETERS FOR THE DOSING, STORING AND CHANGE

HOPPER PARAMETERS
PLANT AND LINE DATA

SYSTEM PARAMETERS







PRODUCTION	SINGLE SYNOP	TIC RECIPES	MENÙ	SILENCE SIREN	RESET ALL GENERAL	Â
LINE 1	LINE 2	LINE 3	LINE 4		PROL	DUCTS
NUMBER PRO	DUCT	-	8	+	SI	LO
Name		FAT				NGE
NUMBER SIL	D		8			
TOLERANCE[	Kg]		0.000			
CHANGE MAX	(IMUM SET [kg]		0.000			
WAITING TI	ME [S]	6	00.000			
QUEUE [Kg]			0.000			
QUEUE TIME	[S]		5.000			
CORR. QUEUI	E %		0			
PRESET [Kg]		t	.0.000			
HIGH SPEED	%		58			
SLOW SPEED	%		18			

# **Product parameters** for the dosing





				SILO
NUMBER SILO	-	8 +	_	CHANGE PARAM
Name	FAT			LOGOUT PASSWORD
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





PRODUCTION SINGLE SYNOP	TIC RECIPES	MENÙ	SILENCE SIREN	RESET ALL GENERAL
LINE 1 LINE 2	LINE 3	LINE 4		PRODUCTS
				SILO
NUMBER PRODUCT	-	11	+	CHANGE PARAM
Name	FLOU	JR 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 L	EVEL	

# **Product parameters** for the change





PRODUCTION	SINGLE	SYNOPTIC	RECIPES	MENÙ	SILENCE SIREN	RESET ALL GENERAL
LINE 1	LINE 2	LINE 3	LINE 4			
Hopper					1 +	1
WEIGHT MA	Х [КG]				999.000	
WEIGHT MI	N [KG]				0.100	
DELTA TIME	E FOR WEIG	HT STABLE	[s]		1.0	
DELTA TIME	FOR WEIG	HT STABLE	[Kg]		0.200	
UNLOADING		[S]			10.000	
END CYCLE	TIME [S]				0.500	

#### Hopper parameters





#### PARAMETERS SETTING EXAMPLES

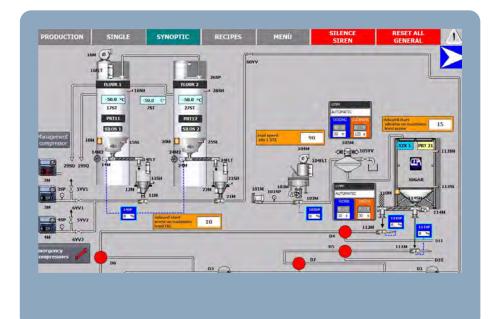
NUMBER PRT	1	•	PRODUCTS	10001
NAME			SILOS	
NUMBER SILO	0	-	CHANGE	(
TOLERANCE [Kg] WAITING TIME [s]	0.000	_	PARAM	
MAX TOLERANCE [Kg]	0.000	DRECET [Val	0.000	
QUEUE [Kg]	0.000	PRESET [Kg] HIGH SPEED %	50	
QUEUE TIME [s]	60.000	LOW SPEED %	0	
CORR. QUEUE %	0			
			<<	
1000 L 10	-	and the second s	-	
1000		and a second		
F1	F2	F3	F4	

Product parameters on Touch panel TP400 controlling the line





# **OVERVIEW**







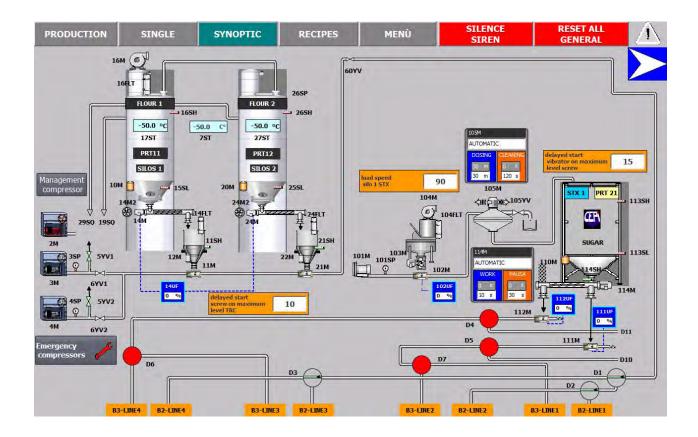
MAINTENANCE WITH MANUAL WORKING MODALITY







#### **OVERVIEW** EXAMPLES

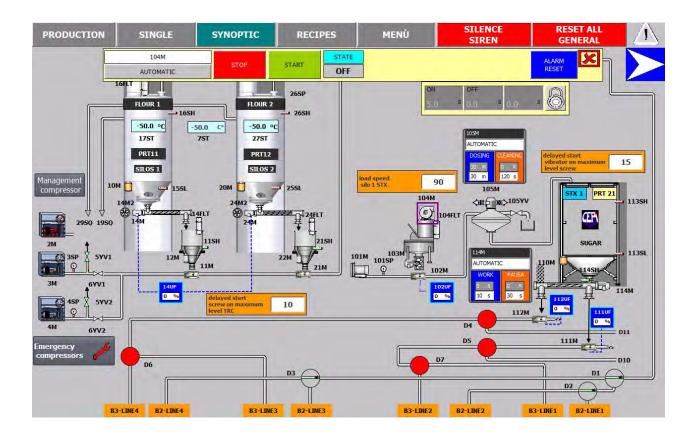


**Overview of silos** 





#### OVERVIEW EXAMPLES

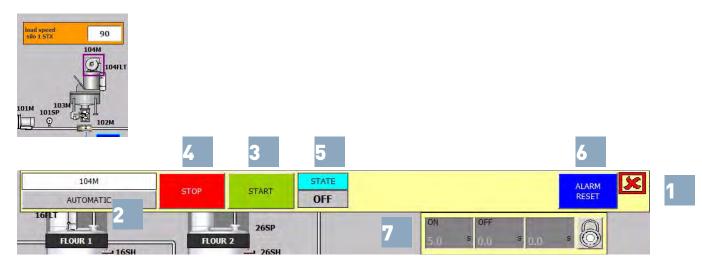


#### Maintenance





#### MAINTENANCE PROCEDURE



#### 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)

#### 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)

