GENERAL MEASURE

AF-25KⅡ-103B /AF-50 KⅡ-103B

Auto filler

Operating instruction

杰•曼•科•技

531701020018 Ver A0

Content

As our products are constantly improving and updating, we reserve the right to modify this manual at any time without prior notice. To this end, please visit the company website frequently for timely information.

Company website: http://www.gmweighing.com

1. overview

AF-25KⅡ-103B / AF-50KⅡ-1036B automatic quantification unit is a weighing component for automatic quantification of granular materials. The feeding mechanism adopts the mode of "motor + vibration feeder" to realize multi-stage feeding, and the unloading is driven by cylinder to realize fast unloading.The product has the characteristics of high speed, high precision and wide range, which can be widely used in the quantitative packaging machinery of grain, feed, chemical, rubber and plastic industries.

1.1 Product parameters, functions and features

1.1.1 Product parameters

model	AF-25KⅡ-103B	AF-50KⅡ-103B
Electrical source	AC220V±10%，50/60Hz，2000W	AC220V±10%，50/60Hz，2000W
The quantitative range	5～25kg	10～50kg
The weighing accuracy	±10g	±20g
Weighing speed	≥1600pcs/hour	≥1500pcs/hour
Metering bucket volume	55L*2	86L*2
Working temperature	0～40ºC	0～40ºC
Maximum humidity	90% OF R.H is not dewy	90% OF R.H is not dewy
Gas source	0.4 ~ 0.6 MPa after 2 m/h	0.4 ~ 0.6 MPa after 2 m/h

Note: packaging accuracy and speed may fluctuate due to material, feed and other environmental factors. The precision and speed are the test data of using round grain rice in our company's test line.

1.1.2 Product features

1. Automatic weighing function.
2. Three material speed (free blanking + vibration feeding) feeding control.
3. Automatic zero clearing function.
4. Automatic correction function of process control parameters.

5. Accumulative and statistical functions.

1.1.3 Product features

1. Intelligent: only set the target value, and automatically adjust the optimal quantitative speed under the condition of ensuring the accuracy.
2. Simple installation: standard external interface flange, quick installation.
3. Data export: with USB interface, data record export is more convenient.
4. Simple operation: 7 inch /10 inch touch screen, Chinese and English display (optional).
5. Material: 304 stainless steel for contact material.
6. High speed, high precision: the combination of feeding (free feeding + vibration feeding), both fast and accurate.

1.2 Working principle

The equipment starts the three-material fast feeding process, namely: fast, medium and slow feeding. The switch of each speed feeding takes the corresponding advance quantity in the formula as the control cut-off point. In order to avoid the influence of overshoot on measurement, the corresponding prohibition discriminant time is set. After feeding, enter the value setting process, the value setting time can be set, after the end of the value, the equipment through the switch output "feeding complete" signal; The equipment receives the external "unloading" effective switching signal, the equipment will drive the cylinder to open the unloading door of the metering bucket, when the weight of the material in the metering bucket is lower than the zero zone value set before, the equipment drives the cylinder to close the unloading door, complete a quantitative process; Before starting the next quantification process, the equipment carries out a pre-feeding delay, and then the next feeding, and so on.

1.3 Main purpose and scope of application

The AF-25KⅡ-103B / AF-50KⅡ-103B equipment is mainly designed for quantitative packaging of granular materials of 25kg/50kg and below. It can be used together with vacuum shaping packaging machine. Measurable materials are mainly rice and grains of small size (such as millet, soybean, mung bean, etc.)

2. Precautions for safe use

2.1 Safe operation

Before installing and using the product, read the product instruction carefully and have the equipment tested by professional personnel

2.1.1 Basic Safety Instructions

1. The power supply meets the requirements of this manual, and the equipment grounding meets the requirements.
2. Power and air should be turned off before starting cleaning, maintenance and repair.
3. Only use cleaners that do not damage mechanical and electrical equipment.
4. The mounting frame connected with the product should be stable and reliable.
5. Please cut off the power supply and air source when installing the metering bucket.

6 metering bucket, sensor connected parts and sensors are not allowed to knock, overload and other damage to the sensor behavior.

7. During the use of the equipment, no part of the body is allowed to extend into the equipment, and the weigher door has been firmly installed before use.

8. Machines that pack materials harmful to human body should be cleaned after using special protective tools according to the existing regulations of the country where the machines are operated.For details, please contact the relevant local authorities.

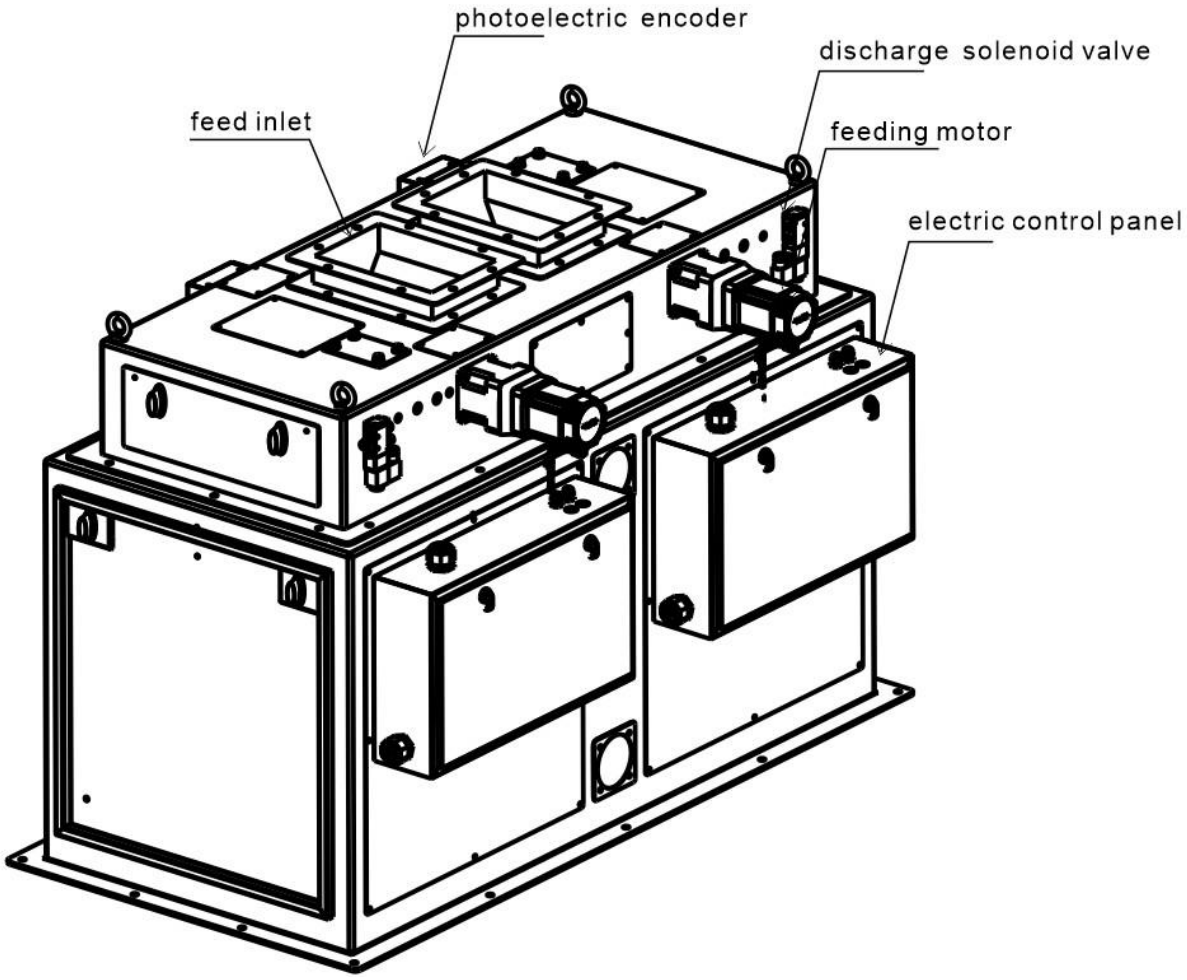
2.1.2 Operation safety instructions

1. In order to avoid dangerous accidents, only one person is allowed to operate the machine.
2. The machine should only be operated by properly trained personnel.
3. Operating instructions, especially safety instructions and regulations, must be read and fully understood by the operator (or anyone responsible for operating the machine) before the machine is run.
4. Before the machine runs, the operator must check whether the scale works normally, whether the machine is fixed and the appearance is normal.

5. In case of any danger, click the "emergency stop" button on the main interface or disconnect the main power supply immediately.
6. For the electrical and electronic system, it is not allowed to modify, replace or carry out any other non-standard operation; Any updates or modifications must be made by General Measure technologies.
7. Wear safety helmets and other protective devices when maintaining equipment, especially when entering the packaging area.
8. Be careful to step on or off the maintenance platform.

3. Product installation and transportation protection

3.1 The overall appearance and mechanism of the product are introduced



Material by the materials into the mouth, including three quantitative process speed feeding control (motor control of the coarse/fine + vibrating feeder feeding material), quantitative weighing type and discharging control, equipment control system can automatically according to the different of material and range correction process parameters, reducing the complexity of equipment debugging and maintenance, convenient supporting customers to use.When using, 0.4~ 0.5mpa, 2m³/h compressed air is needed to access the air source inlet, and the power supply, signal communication and control ports

(such as serial port connection end, USB connection and I/O control port) of the equipment are located in the electrical control box.

The double scales are arranged symmetrically according to the direction shown. Scale A is on the left and scale B is on the right.Contains the following parts:

Feeding port: the material to be weighed enters the scale body.

Photoelectric code plate: motor in position signal feedback.

Discharge solenoid valve: Control the action of the unloading cylinder.

Feeding motor: The main function of weighing is to control the feeding amount.

Electric control panel: The built-in circuit board is connected to external signals, I/O control connections, and power wiring.

3.2 The installation conditions

3.2.1 Equipment installation basis and installation conditions

1. Temperature: -10~40℃

2. Humidity: not more than 90% R.H.

3. Power supply: AC110~260V, 50Hz/60Hz, about 500W.

4. Air source: 0.4~ 0.5mpa 1.2m³/h.

5. Installation plane: horizontal solid steel support frame.

6. Static electricity: Ensure that the device is reliably grounded.

7. Harmful radio waves: keep away from powerful sources of harmful radio waves such as wireless devices.

8. Electrical and gas technical parameters meet and are in place

3.3 Unpacking and inspection

3.3.1 The crates

Please read this operation manual carefully before unpacking for

1. Pay attention to the words and warning signs on the containers before unpacking them.

2. Before unpacking the box, check whether the box is seriously squeezed and deformed during transportation. If the damage is serious, consider whether the equipment is damaged.

3. Read the packing list before unpacking and proofread it after unpacking to avoid omission.

4. After unpacking the device, check whether the screws connecting the device are loose.

5. Check whether the metal hose is in good condition before unpacking the device.

6. After unpacking the whole machine, check whether the scale is normal and whether the action of the moving parts is normal.

7. During debugging after the assembly of the unpacked machine, pay attention to whether the sealing of the parts through which the material passes under the predetermined pressure is reliable. This check must be made before starting the machine.

3.3.2 Spare parts

1. Accessories: equipment side panel opening key, packing list, invoice, product manual and quality inspection certificate.

2. Unpack the device and check whether the accessories are complete and whether the device package is intact.

3. Original General Measure Technologies must be used.

The company is not responsible for the loss caused by using other parts.

If you have any questions, please don't hesitate to contact us.

3.4 Product packaging and transportation protection

3.4.1 Packaging requirements

1 . It is packaged in wooden cases and can be stacked in two layers. GB/T4857.3 Basic Test for Transport Packages, Static Load Stacking Test Method.

2 . Meet the vibration resistance requirements of long-distance highway transportation, GB/T4857.7 Basic Test for Transportation Packages, Sinusoidal Vibration (Constant Frequency) Test Method.

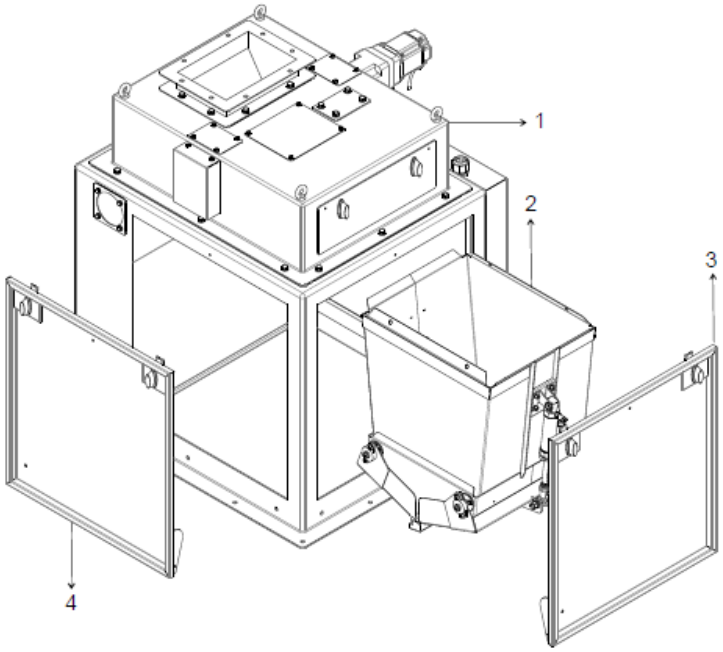
3.4.2 Transport protection

1. Before transportation, remove the metering bucket and invert it into the scale frame.

2. Use nuts at the lower flange of the equipment to secure the equipment to the transportation wooden box, and secure the unloading hopper.

3. Wrap the outer surface of the equipment with wrapping film.

3.4.3 Remove transport limit protection



This product is designed to prevent sensor damage during transportation. The method of disassembling and inverting the metering bucket inside the scale frame is adopted. After receiving the product, it is necessary to install the metering bucket. The illustration shows a single scale, and a double scale means two buckets.

The metering bucket of this product adopts a fast loading and unloading design. A single person can complete the installation of the metering bucket in 10 minutes.

As shown in the figure:

1. Open the scale frame door panel.

2. Loosen the retaining bolts of the metering bucket.

3. Take the metering bucket out of the scale frame and turn it upside down (as shown in the figure).

4. Insert the metering bucket horizontally into the metering bucket bracket (as shown by the arrow in the figure).

Note that the beveled edge of the metering bucket should catch the beveled edge of the bracket.

Take care to prevent the discharge door from opening.

5. After inserting into place, align the hole locations and lock the four eyebolts.

6. Connect the discharge cylinder air pipe.

7. Install the door panel.

3.4.4 Requirements for equipment installation and maintenance

1.The operator must accept the company's skill training and safety education, and hold a work permit.

2.The personnel responsible for operating the machine must read and fully understand the operation manual.

3.Operators must have short hair or long hair up, clothing and shoes and hats should be easy to work.Wear a safety helmet and insulating shoes during testing or maintenance.

4.The operator must strictly follow the procedures and steps stipulated in the user manual.

5.Before lubrication, mechanical adjustment, maintenance and repair of the equipment, the power supply shall be cut off, the air source shall be closed, the residual pressure in the pneumatic pipeline shall be released, and the warning signs shall be hung at the electric control cabinet, the power switch and the air source valve.

6.The maintenance and repair of the air pressure system must be carried out under the condition of cutting off the power supply and releasing the pressure completely.

7.The production line shall not be operated until all safety protection facilities are in place.

8.After the device is powered on, do not touch the moving parts of the device.

9.When the production line is in operation, do not enter dangerous areas or cross the production line.

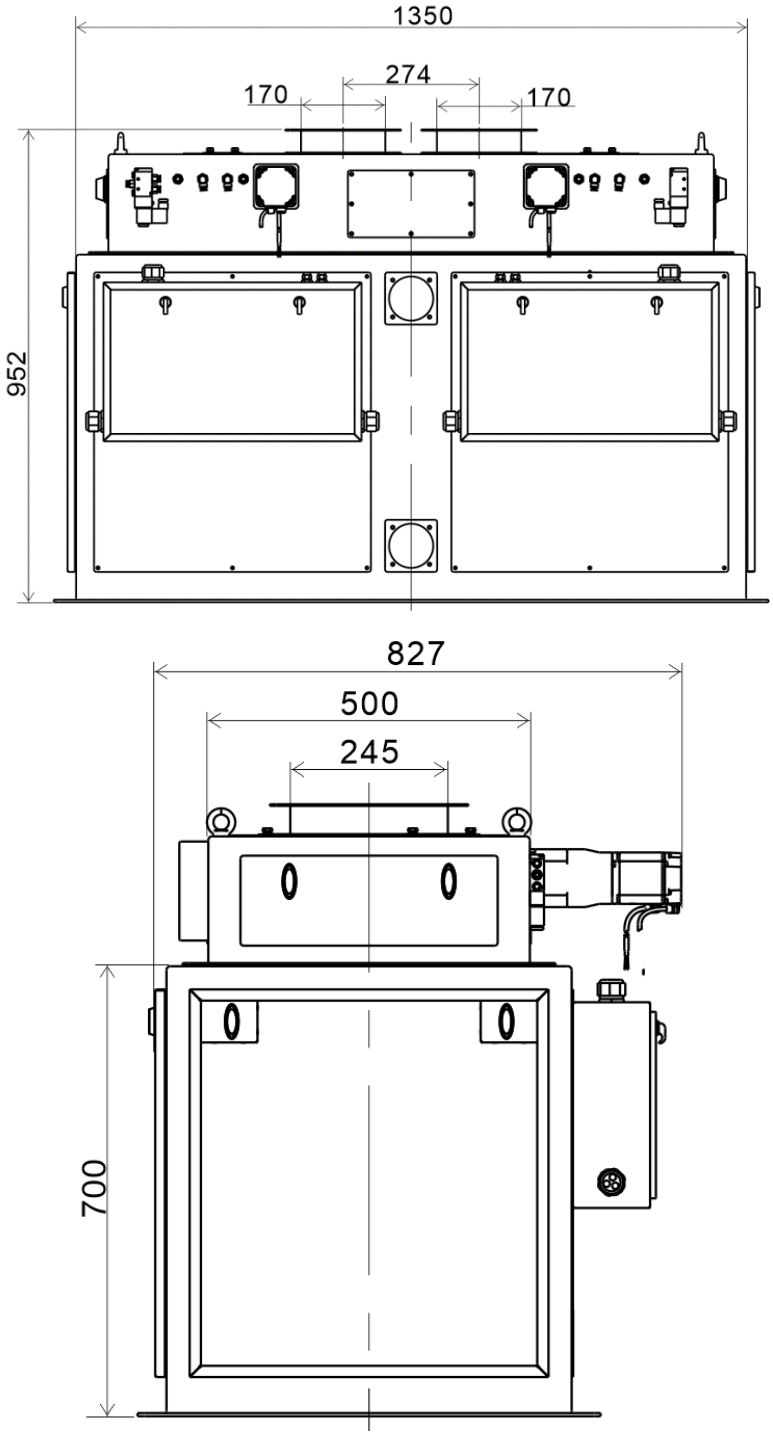
10.Do not modify the setting parameters of wiring in the control cabinet, motherboard program and driver.

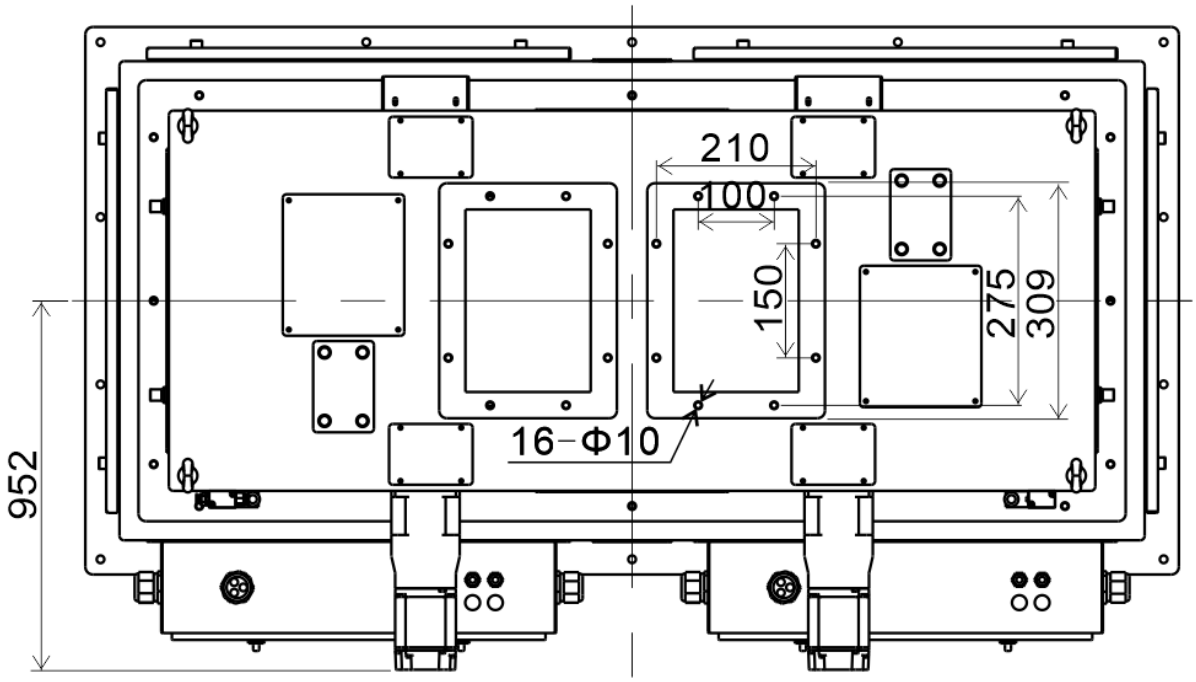
11.The tool installation is reliable and safe, and the operator understands and understands all the safety requirements of the tool.

4. Product size

Product size unit: mm

4.1 AF-25KⅡ-103B Overall dimensions




210
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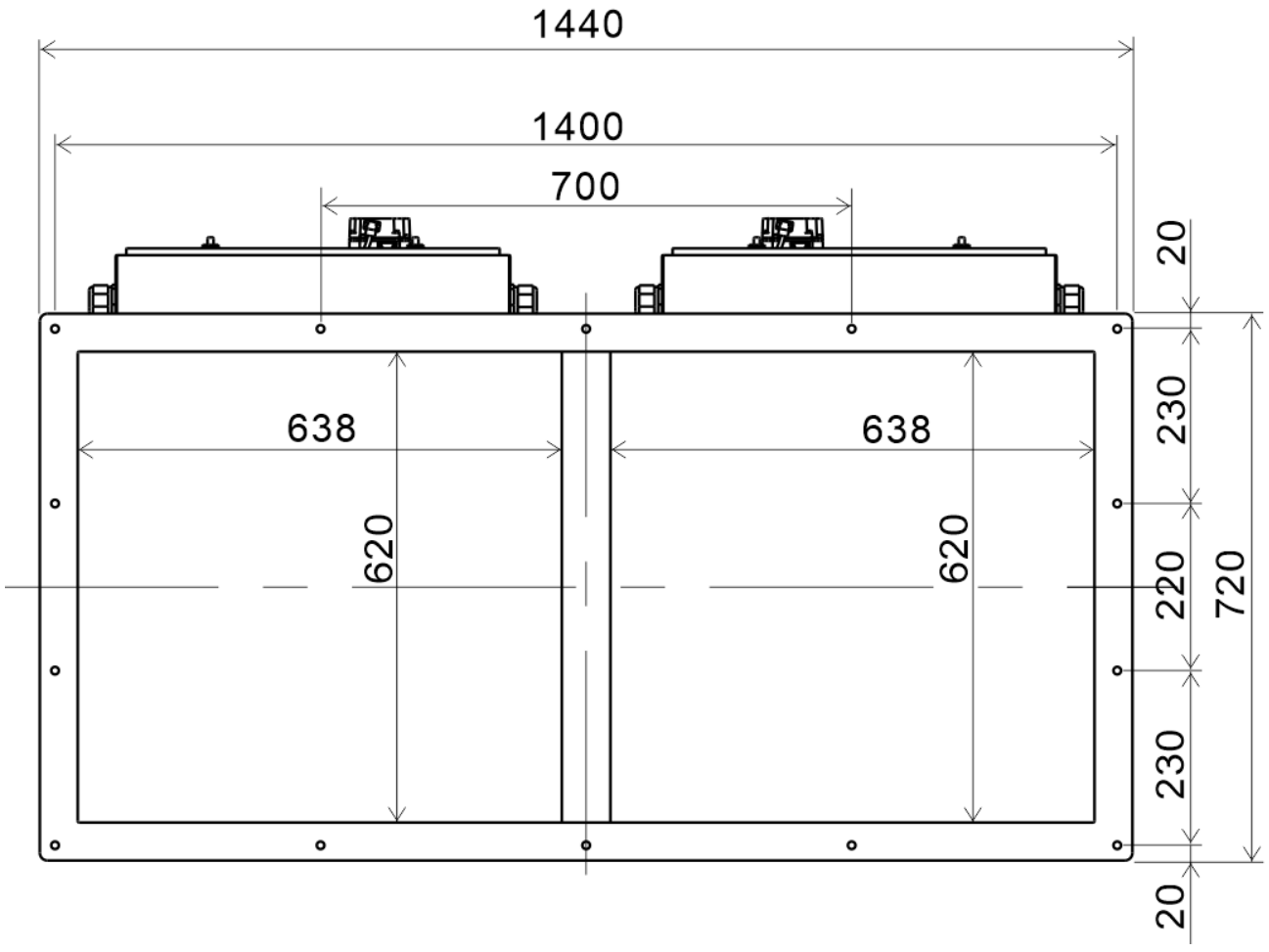
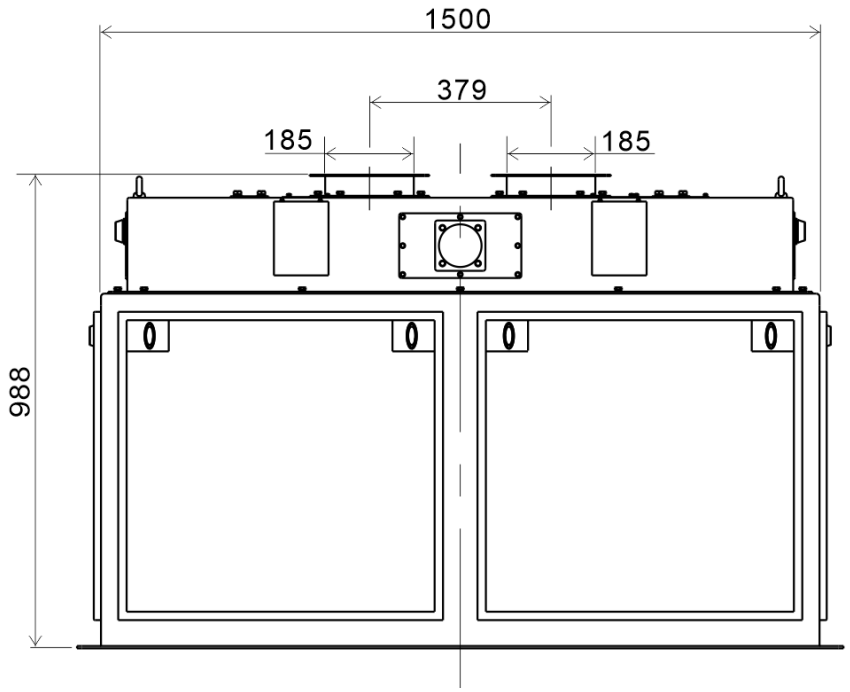
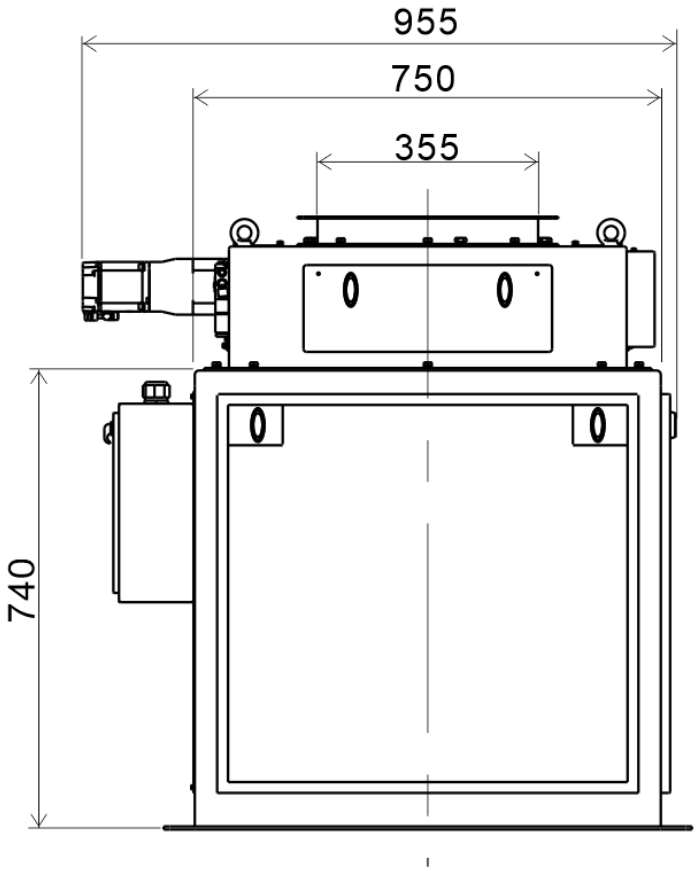
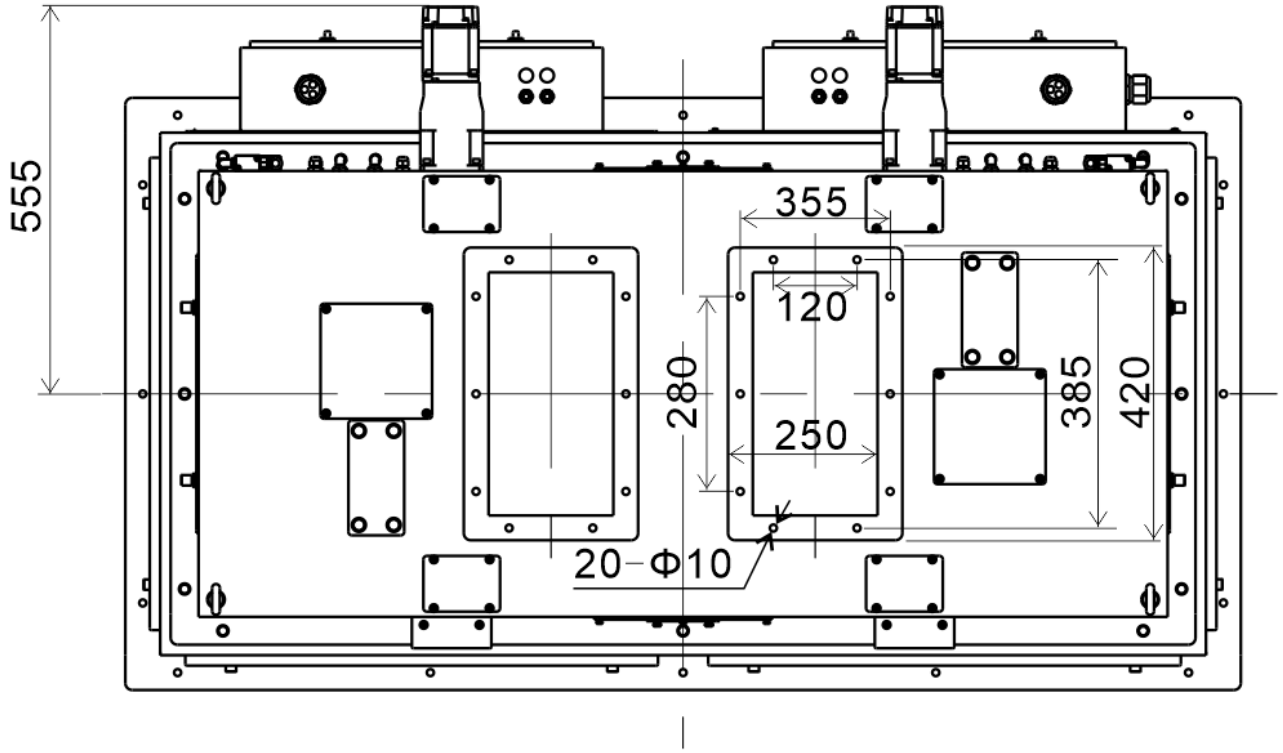
309
952
16-Φ10


1440
1400
700
20
230
220
230
20
720
638
638
620
620

4.2 AF-50KⅡ-103B Overall dimensions



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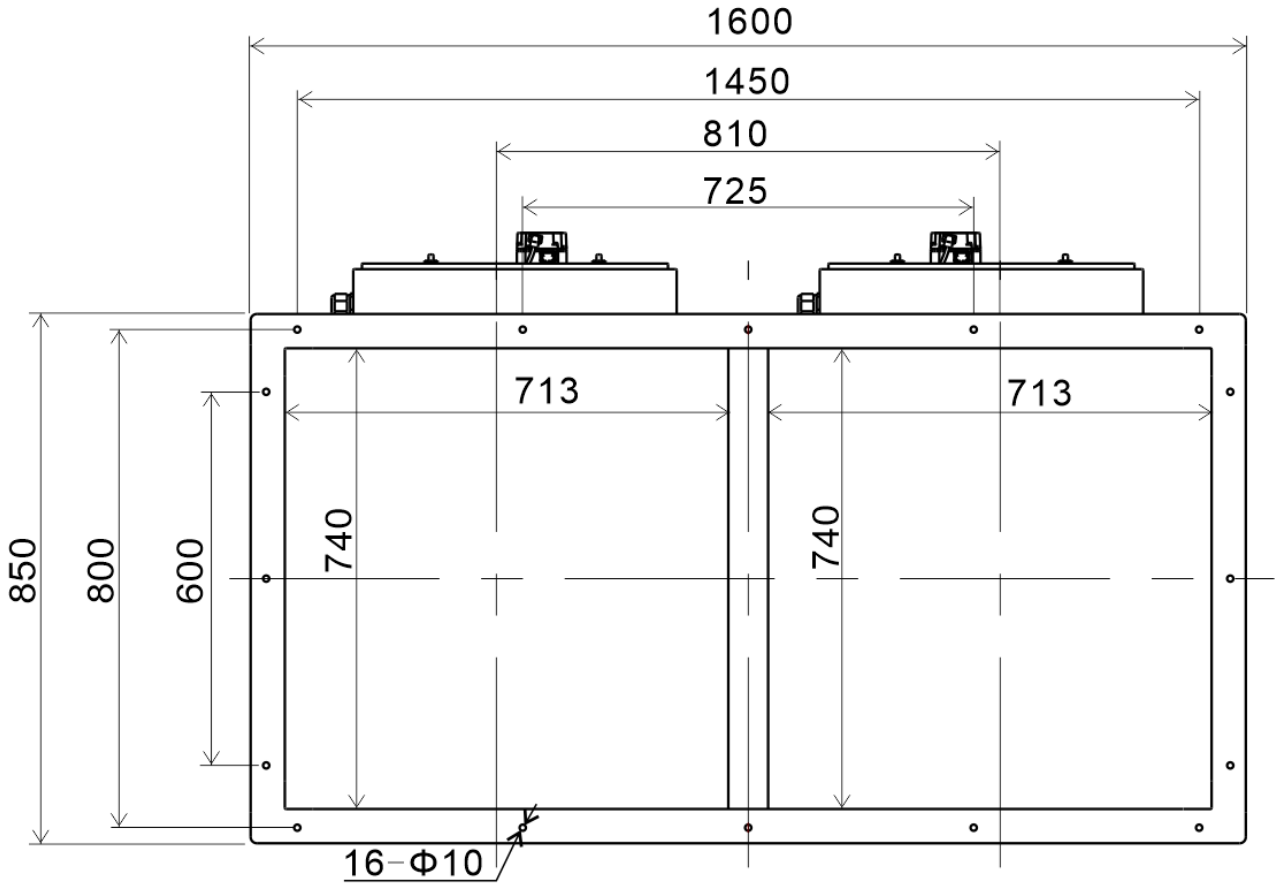
385
420
20-Φ10


1600
1450
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725
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713
740
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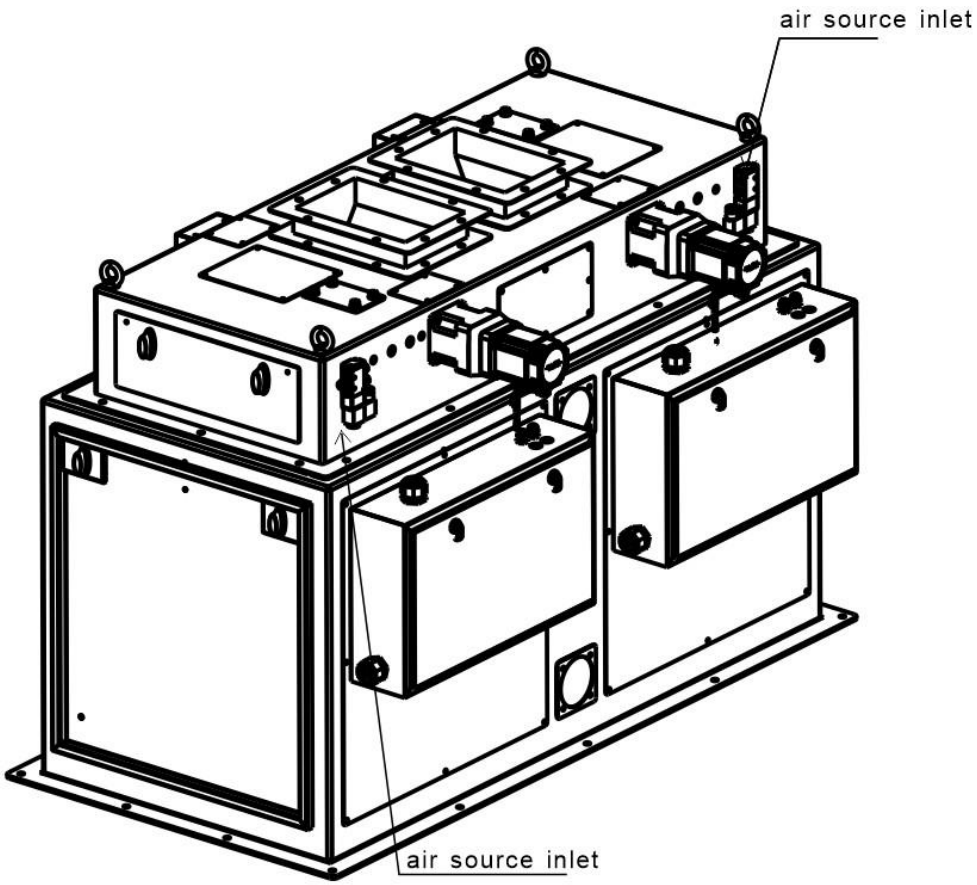
16-Φ10

5. Electrical connections

5.1Air supply connection

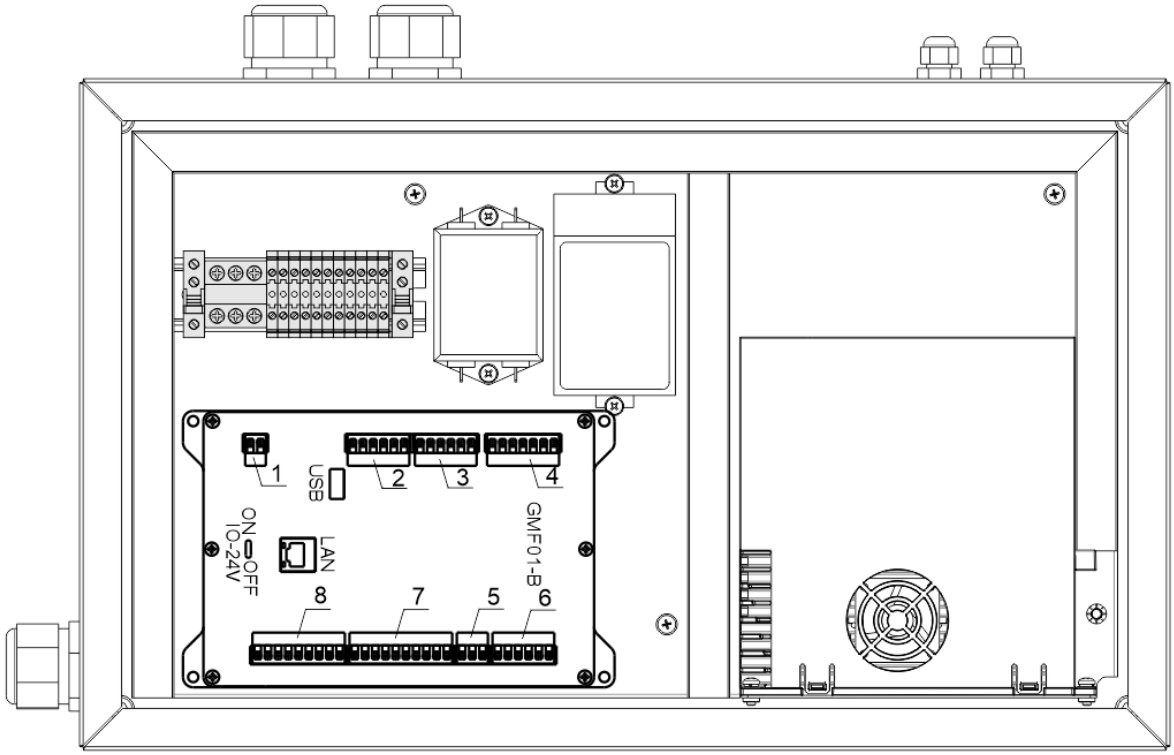


Air source inlet φ6 air pipe, air source standard: 0.4~ 0.6mpa 2m³/h

5.2Electrical connections

Insert the single-wire 220V power plug into the onsite power socket.

The internal layout of the electric control box is shown as follows:



The PCB interfaces are defined as follows:

5.2.1 External interface definition

1: Power cord port, 24V power port of the instrument (24V+, 24V -).

2: Motor control port 1, (M1_24V+: 24V positive, M1_24V -: 24V negative, PU1: pulse, DR1: direction, ZT1_1: origin detection input, ZT1_2: feeding door opening limit), can also be used as a common IO port, currently used for feeding motor control.

3: Motor control port 2, currently used as a common IO port.

4: Sensor wire ports, sensor wiring ports (SHLD, EX+, EX -, SN+, SN -, SIG+, SIG -).

5: RS485 serial communication port, serial port 1 (A1, B1, GND1) is generally used for local HMI communication.

6: Two RS485 serial communication ports, serial port 2 (A2, B2, GND2) and serial port 3 (A3, B3, GND3), can be used for upper computer communication, and both support Modbus communication.

7: Input ports, 8 customizable switching input interfaces (IN1, IN2, IN3, IN4, IN5, IN6, IN7, IN8), valid for low levels, and the definition of each port can be selected by yourself.

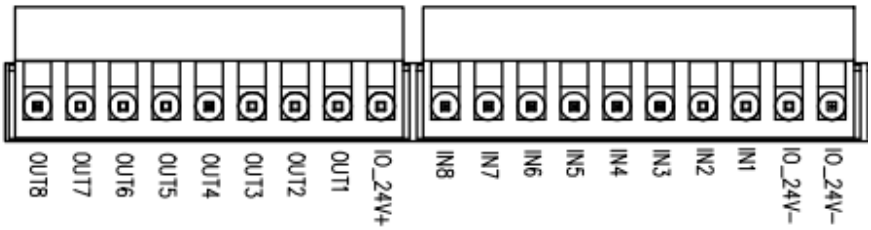
8: Output ports: 8 customizable switching output interfaces (OUT1, OUT 2, OUT 3, OUT 4, OUT 5, OUT 6, OUT 7, OUT 8). The definition of each port can be selected by yourself.

USB: USB interface can be used for various data import and export.

LAN: The network interface can be used for networking and data transmission.

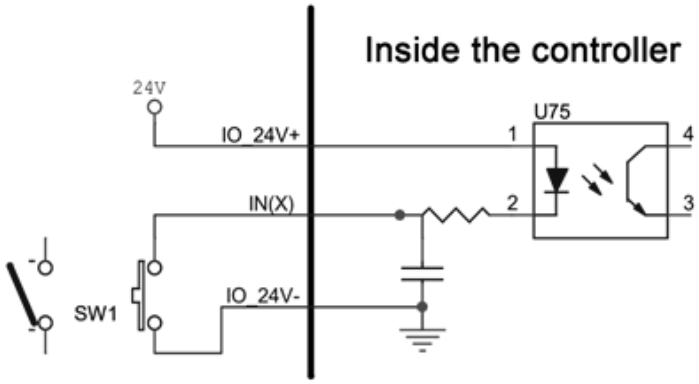
IO-24V: Internal use.

5.2.2 Switching value interface wiring description

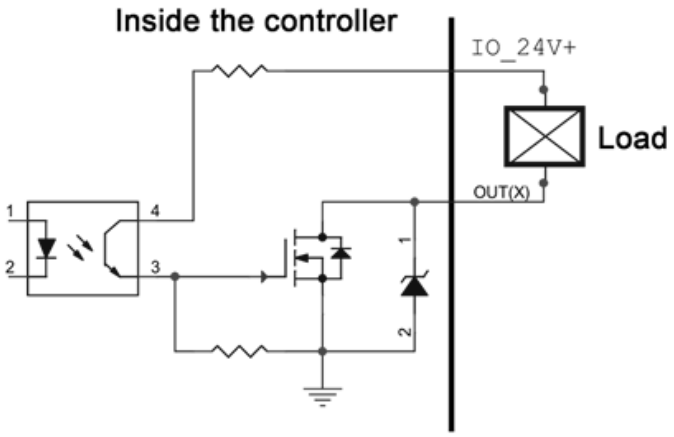


Switching value interface diagram

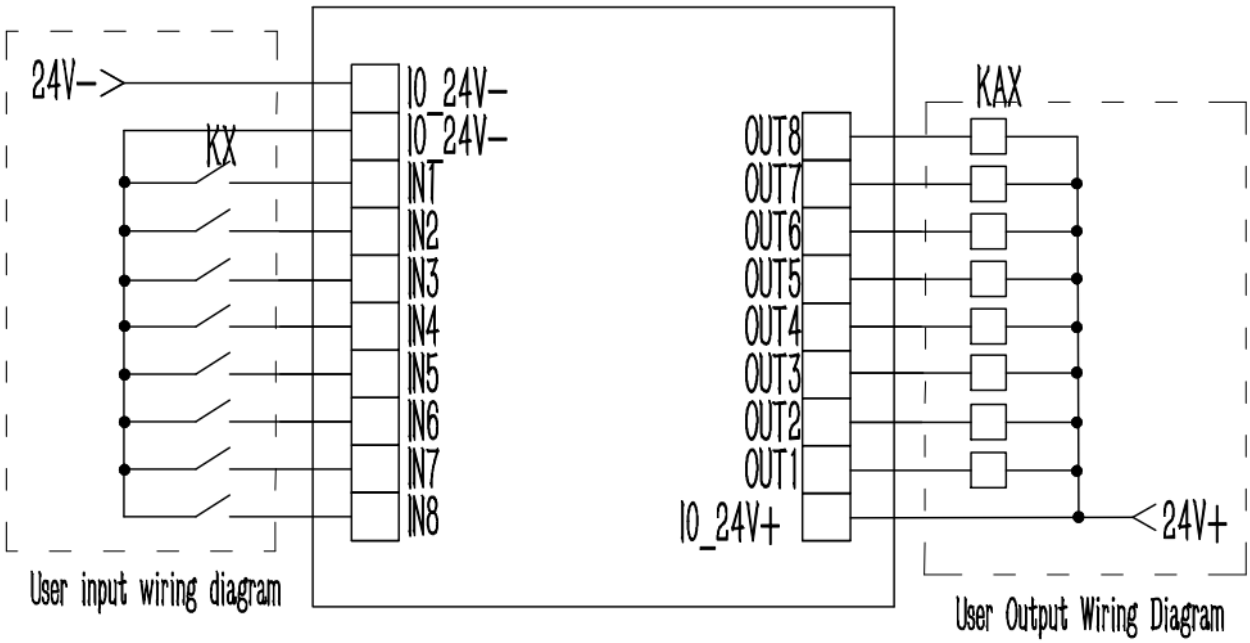
The switching value adopts photoelectric isolation method. If users need to use a switching interface, they need to provide and connect to a DC24V power supply. Switching value input is valid at low level; The output adopts the transistor collector open circuit output mode, and each drive current can reach 500mA.



Schematic diagram of input interface



Schematic diagram of output interface



Wiring diagram of user input and output ports

6. The Modbus address table

In [Communication Parameters], serial port communication is usually modbus-RTU. When the communication parameters are consistent with the Settings of the upper computer, modbus-RTU protocol is used for communication.

PLC addrss	Function	meaning	instructions	
The following is a read-only register (function code 0x03)				
Instrument status parameter				
40001	**00000**	The current weight	4 bytes, signed number	
40002	**00001**			
40003	**00002**	Instrument condition 1	position	instructions
			. 00:	The AD collection module is abnormal
			. 01:	Memory failure
			. 02:	keep
			. 03:	Abnormal sensor signal
			. 04:	The weight of overflow
			. 05:	Weight is stable
			. 06:	zero
			. 07:	Minus sign
			. 08:	Millivolts are stable
			. 09 ~. 15:	keep
40004	**00003**	Instrument status 2	**. 00.**	run

			. 01	Before loading
			. 02	Quickly add
			. 03	To add
			. 04	Slowly add
			. 05	Constant value
			. 06	Super poor
			. 07.	Owe less
			. 08	Call the police
			. 09	Waiting for the clip bag
			. 10.	Clip bag
			. 11.	discharge
			. 12.	Charging to allow
			. 13.	Discharge allow
			. 14.	jam
			. 15.	keep
40005	**00004**	Instrument status 3	**. 00:**	keep
			. 01	keep
			. 02:	Complete one package (duration 1S)
			. 03 ~. 15:	keep
40006	**00005**	Alarm queue 1	**. 00.**	No alarm
			. 01	Batch to complete
			. 02	Clear out of range (2s)
			. 03	Unstable at zero clearing (2s)
			. 04	Target value 0 cannot start (2s)

			. 05	Pause the gap
			. 06	keep
			. 07.	Disable zero clearing operation in operation (2s)
			. 08	Overage and underage alarm
			. 09	keep
			. 10.	keep
			. 11.	Discharge fault
			. 12.	Discharging timeout
			. 13.	Feeding motor running time out
			. 14.	Discharging motor running timeout
			. 15.	Unable to run during emergency stop (2S)
			. 16.	Zero clearance failure (zero clearance before feeding operation)
			. 17.	Charging a timeout
			. 18.	Steady value judgment timeout (steady value judgment method)
			. 19.	Servo motor alarm
			. 99.	Software authentication failure
40007	**00006**	Alarm queue 2	1. When there are multiple alarms at the same time, press "Happening" Up to three alarms are displayed at the same time.	
40008	**00007**	Alarm queue 3		
40009	**00008**	The default package number	Initial value: 0. The value ranges from 0 to 99999	
40010	**00009**			

40011	**00010**	Number of preset packets remaining	Initial value: 0. The value ranges from 0 to 99999
40012	**00011**		
40013	**00012**	Current gross weight	Unlike 40001, this register is not subject to constant weight retention Switch control, when the switch is on, even during unloading, also Return to actual weight
40014	**00013**		
40015	**00013**	Current display value (floating point)	Unlike 40001, this register is not subject to constant weight retention Switch control, when the switch is on, even during unloading, also Return to actual weight
40016	**00014**		
40017	**00015**	Current gross weight (floating point)	= The current display value in the format of a single-precision floating point number
40018	**00016**		
40019 **...** **40030**	**00018** **...** **00029**	The reserved	
40031	**00030**	Year (readable and writable)	Scope: 2000 ~ 2099
40032	**00031**	Month (readable and writable)	Scope: 1 ~ 12
40033	**00032**	Day (readable and writable)	Scope: 1 ~ 31
40034	**00033**	week	Scope: 1 ~ 7
40035	**00034**	Hours (readable and writable)	Scope: 0 ~ 23
40036	**00035**	Points (readable and writable)	Scope: 0 ~ 59
40037	**00036**	Second (readable and writable)	Scope: 0 ~ 59

40038	**00037**	System running time	The maximum value of a 0 to 4 byte long integer, exceeding natural reversal, in milliseconds
40039	**00038**		
40040 **...** **40050**	**00039** **...** **00049**	The reserved	
40051	**00050**	Package formula number	Formula number and target value when "packing result weight" is generated, Manual unloading, also do a result save, but the formula number is equal to 0
40052	**00051**	Package target value	
40053	**00052**		
40054	**00053**	Packing result weight	Weight unit is system unit, updated at the end of unloading
40055	**00054**		
40056	**00055**	Actual packing time (including waiting time)	Update at the end of unloading, in milliseconds
40057	**00056**		
40058	**00057**	Theoretical packing time (Not including waiting time)	
40059	**00058**		
40060	**00059**	Delay before feeding (including clear Zero additional delay)	
40061	**00060**		
40062	**00061**	Quickly add time	
40063	**00062**		
40064	**00063**	To add time	
40065	**00064**		
40066	**00065**	Slowly add time	
40067	**00066**		
40068	**00067**		

40069	**00068**	Fixed time (slow plus end to Discharging start)	
40070	**00069**	Wait for bag clamping (unloading allowed) time	
40071	**00070**		
40072	**00071**	Discharging time	
40073	**00072**		
40074	**00073**	Actual packing speed	Update at the end of unloading, unit: BPH
40075	**00074**		
40076	**00075**	Theoretical packing speed	
40077	**00076**		
40078	**00077**	deviation	Signed double word, uncombined mode: packet result - packet target value. Combination mode: the first time, fixed at 0, the second time: combined total result-set the target value
40079	**00078**		
40080	**00079**	Number of speed sampling packets Nspeed (Readable and write)	Initial value: 6. Range: 6 to 12
40081	**00080**	Generation date of subcontracting data	Decimal 8-digit month day, such as: 20160111 (2016/01/11)
40082	**00081**		
40083	**00082**	Generation time of packet data	Decimal 6-bit time, such as 160552 (16:05:52)
40084	**00083**		
40085 **...** **40100**	**00084** **...** **00099**	The reserved	
The following contents are readable and writable			

<table>
<tr><td colspan="5">(Write a single register function code is 0x06, write multiple registers function code is 0x10, read function code is 0x03)</td></tr>
<tr><td colspan="5">Calibration parameters</td></tr>
<tr><td>40101</td><td>00100</td><td rowspan="2">The zero calibration</td><td colspan="2" rowspan="2">Write 1 to mark zero; read returns 0</td></tr>
<tr><td>40102</td><td>00101</td></tr>
<tr><td>40103</td><td>00102</td><td rowspan="2">There is weight gain calibration
(Input weight)</td><td colspan="2" rowspan="2">The value ranges from 0 to 999999, expressed in grams</td></tr>
<tr><td>40104</td><td>00103</td></tr>
<tr><td>40105</td><td>00104</td><td rowspan="2">Material gain calibration (note
Record current AD code)</td><td colspan="2" rowspan="2">Input 1 to record the gain AD code, and read returns 0</td></tr>
<tr><td>40106</td><td>00105</td></tr>
<tr><td>40107</td><td>00106</td><td rowspan="2">Material gain calibration
(Input weight)</td><td colspan="2" rowspan="2">The value ranges from 0 to 999999, expressed in grams</td></tr>
<tr><td>40108</td><td>00107</td></tr>
<tr><td>40109</td><td>00108</td><td rowspan="2">Absolute Millivolt (read only)</td><td colspan="2" rowspan="2">Default 3 decimal points, unit: millivolt
If the value is 12345, it means 12.345</td></tr>
<tr><td>40110</td><td>00109</td></tr>
<tr><td>40111</td><td>00110</td><td rowspan="2">Gain millivolts (read only)</td><td colspan="2" rowspan="2">Default 3 decimal points, unit: millivolt
If the value is 12345, it means 12.345</td></tr>
<tr><td>40112</td><td>00111</td></tr>
<tr><td rowspan="6">40113</td><td rowspan="6">00112</td><td rowspan="6">Calibration result information (read only)</td><td>The results</td><td>instructions</td></tr>
<tr><td>0</td><td>There is no information</td></tr>
<tr><td>1</td><td>Calibration is successful</td></tr>
<tr><td>2</td><td>The current sensor voltage is unstable</td></tr>
<tr><td>3</td><td>Input weight is not reasonable</td></tr>
<tr><td>4</td><td>The current sensor voltage is too high</td></tr>
</table>

			5	The current sensor voltage is too low
			6	Excessive calibration resolution
			The alarm message will be automatically eliminated after 2 seconds.Before elimination, no Allow to calibrate again	
40114 **...** **40200**	**00113** **...** **00199**	The reserved		
The basic parameters				
40201	**00200**	unit	Initial value: 1,0: g;**1 kg;2: t;3: b**	
40202	**00201**	The decimal point	Initial value: 3. The value ranges from 0 to 4	
40203	**00202**	Dividing the value	Initial value: 1. Range: 1, 2, 5, 10, 20, 50	
40204	**00203**	Maximum range	If the device model is AF-5K, the initial value is 10000 If the device model is AF-10K, the initial value is 20000 The value ranges from 1 to 999999, expressed in grams	
40205	**00204**			
40206	**00205**	OFL indicates the type	Initial values: 0, **0:[maximum range + 9D] display OFL;** **1:[maximum range *120%] to display OFL;** **2:[maximum range *150%] to display OFL**	
40207	**00206**	Scale range mode	Initial values: 0, 0, 5 k;**1:25K;2:50K;3:10K;4: the reserved**	
40208	**00207**	Automatic zero clearance interval	Initial value: 80. The value ranges from 0 to 9999, expressed in milliseconds	
40209	**00208**	Start additional clearance times	Initial value: 2. The value ranges from 0 to 9	

40210	**00209**	Additional zero clearance time	Initial value: 1000. The value ranges from 0 to 9999, in milliseconds
40211	**00210**	Handling method of failure to clear data	Initial values: 0, **0: only alarm, lasts 1S, give up zero clearance this time, clear again next time;** **1: only alarm, lasts 1S, give up zero clearance this time, clear again next time, connect** Unable to reset three times, return to stop state!Continue to report to the police **2: alarm, but continue to wait for stability, once stable, eliminate the alarm,** Automatically continue to run; **3: alarm, immediately return to stop state.**
40212	**00211**	Reset the scope	Initial value: 10. Range: 0 to 99, unit: %
40213	**00212**	Sentenced to stabilizing range	Initial value: 5. Range: 0 to 99, unit: D
40214	**00213**	Sentenced to stabilizing time	Initial value: 300. The value ranges from 100 to 9999, expressed in milliseconds
40215	**00214**	Zero tracking range	Initial value: 3. Range: 0 to 9, unit: D
40216	**00215**	Zero tracking time	Initial value: 2000. The value ranges from 0 to 9999, expressed in milliseconds
40217	**00216**	Stop the AD filter series	Initial value: 9. The value ranges from 0 to 9
40218	**00217**	Add AD filter series	Initial value: 2. The value ranges from 0 to 9
40219	**00218**	Fixed value AD filter series	Initial value: 5. The value ranges from 0 to 9
40220	**00219**	Discharging AD filter series	Initial value: 2. The value ranges from 0 to 9
40221	**00220**	Power-on automatic reset switch	Initial value: 0. Range: 0 to 1

40222	**00221**	Manual unloading cumulative switch	Initial value: 0. Range: 0 to 1
40223	**00222**	Constant weight hold switch	Initial value: 1 the value ranges from 0 to 1
40224	**00223**	Unloading mechanism mode	Initial value: 0,0: pneumatic, 1: unidirectional general motor, **2: common motor bidirectional, 3: one-way stepping motor**
40225	**00224**	Unloading working mode	**0: timing mode, discharging signal output continuous discharging time (formula** Parameter) is turned off. Discharging abnormal after discharging Judge; **1: Judge zero zone mode, signal output, until the weight is below zero zone** Value, and then start unloading delay time, when the time is up, close unloading After entering the discharging delay, there is no need to distinguish the weight.
40226	**00225**	Discharge delay	Initial value: 200. The value ranges from 0 to 9999, expressed in milliseconds
40227	**00226**	Discharging timeout time	Initial value: 2000. The value ranges from 0 to 20000, expressed in milliseconds
40228	**00227**	Loose bag model	**0: automatically loosens the bag after unloading. 1: automatically loosens the bag after unloading** Manual loose bag
40229	**00228**	Discriminant mode of feeding allowance	**0: judge only when start feeding, no longer judge during feeding;**1: Keep judging during feeding.
40230	**00229**	Allowable discharging discriminant mode	**0: judge only when starting unloading, no longer judge in unloading process;**1: Keep judging during unloading.

40231	**00230**	Over range feeding protection	Initial value: 1, **0: close;** **1: on. When on, from the calibration zero (plus zero clearing)** Cleared part), the weight is greater than or equal to specification *1.2, then judged OFL, whether or not the maximum range is exceeded. Preventing zero clearing will be large After the weight is cleared to 0, the weight is small, but it is Overcharge. at the same time, adjust the settable value of the clearing range from 99% The whole of 20%
40232	**00231**	Whether the feeding mechanism contains a vibrating disk	Initial value: 0,0: no vibration plate.**1: with a vibrating disk.**
40233	**00232**	Type of feeding motor	Initial value: 1,0: step;**1: servo**
40234	**00233**	Intelligent ban switch	Initial value: 0,0: forbid intelligent ban, when using the set ban 1: intelligent ban on: automatic change according to the feeding speed Set a time limit.
40235	**00234**	Intelligent judgment switch for current cutoff	0: Off 1: On, the program automatically judges the cutoff state
40236	**00235**	Outage timeout	Setting greater than 10000 does not work, between 2000 and 10000.It will work even if the intelligent judgment switch for current cutoff is turned off
40237 **...** **40242**	**00236** **...** **00241**	The reserved	

40243	**00242**	Fixed value method	Initial value: 0,0: fixed time.**1: judge the stability value**
40244	**00243**	Fixed value stabilization timeout	Initial value: 0. The value ranges from 0 to 999. Unit: 0.1s The maximum time allowed to wait for stability when determining the stability value exceeds If the time is not stable, the "fixed value" is used to judge the stable timeout handler Method "handles.0, it doesn't work.
40245	**00244**	Fixed value judgment timeout processing method	Initial value: 0, range: 0~3, **0: The meter will consider the current weight as the stabilized weight, then** Continue with the following steps and alarm [constant value timeout] for 1S. **1: The meter will consider the current weight as the stabilized weight, then** Continue the following steps and alarm for 1S. After three consecutive times, Return to stop state, continuous alarm [continuous constant value timeout]. **2: alarm, but continue to wait for stability, once stable, eliminate the alarm,** Automatically continue running. **3: alarm, immediately return to stop state.**
40246	**00245**	Dual Scale Interlock Mode	Default 0, Range: 0-2, 0: No interlock; 1: Double scale A; 2: Double scale B;
40247 **...** **40300**	**00246** **...** **00299**	The reserved	
User preferences			
40301	**00300**	Material no.	Initial value: 1. The value ranges from 0 to 10

40302	**00301**	The formula,	Initial value: 1. The value ranges from 0 to 20
40303	**00302**	The target	Initial value: 0. The value ranges from 0 to 999999, expressed in grams
40304	**00303**		
40305	**00304**	Step up quickly	Initial value: 0, range: 0 to maximum range, unit: gram
40306	**00305**		
40307	**00306**	Add the lead quantity	Initial value: 0, range: 0 to maximum range, unit: gram
40308	**00307**		
40309	**00308**	Slow down and advance	Initial value: 0, range: 0 to maximum range, unit: gram
40310	**00309**		
40311	**00310**	Zero value	Initial value: 0, range: 0 to maximum range, unit: gram
40312	**00311**		
40313	**00312**	Discharging time	Initial value: 300. The value ranges from 0 to 99999, expressed in milliseconds
40314	**00313**		
40315	**00314**	Delay before feeding	Initial value: 0. The value ranges from 0 to 99999, expressed in milliseconds
40316	**00315**		
40317	**00316**	Fixed hold time	Initial value: 900. The value ranges from 0 to 99999, in milliseconds
40318	**00317**		
40319	**00318**	Switch for detecting overcurrent and undercurrent	Initial value: 0. Range: 0 to 1
40320	**00319**	Ultra difference	Updated at the end of unloading, range: 0~ maximum range, unit: g
40321	**00320**		
40322	**00321**	Owing to difference	Updated at the end of unloading, range: 0~ maximum range, unit: g
40323	**00322**		
40324	**00323**		

40325	**00324**	Overtime and undertime alarm	Initial value: 0. The value ranges from 0 to 99999, expressed in milliseconds
40326	**00325**	Pause switch over and under difference	Initial value: 0. Range: 0 to 1
40327	**00326**	Combined mode (read only)	Initial value: 1, Read-only 1 or 2:1 Uncombined mode 2 Combined mode
40328	**00327**	Feeding level (read only)	Initial value: Automatically determined according to the target value Feeding series,2: two-stage feeding;**3: three-stage feeding. The controller will** Automatic selection according to the range is two - stage feed or three - stage feed Material.[grade 2, fast + slow add, add lead and add open [grade 3, add + add + slow add, but add or add quickly If the lead is set to 0 or the opening is set to 0, it still does not go fast plus or medium Add]
40329	**00328**	The opening is configured independently	Initial value: 0. Range: 0 to 1
40330	**00329**	The formula is quickly widened	Initial value: 8000. Range: 0 to maximum openness
40331	**00330**	Add the opening in this formula	Initial value: 5000. Range: 1 to the maximum openness
40332	**00331**	This recipe is slow in opening	Initial value: 1800, range: 2~ maximum openness
40333	**00332**	Discharge opening of this formula	
40334	**00333**	Slow feeding function switch	Range: 0-1

40335	**00334**	Single time of slow feeding and replenishment	Range: 0.1~9.999s	
40336	**00335**	Times of slow feeding and replenishment	Range: 1~9	
40337	**00336**	Cut off the flow Cut off the flow Slow increase the opening weight	Range: 0~999999	
40338	**00337**			
40339	**00338**	Flow cutoff slow increase opening	Range: 2000~30000	
40340	**00339**	Combination method count	Range: 0-99	
40341	**00340**	Interlock delay time	Initial value: 1000, range: 0~99999, unit: milliseconds	
40342 ... 40400	**00341 ... 00399**	The reserved		
Switching parameter				
40401	**00400**	Start/end the switch test	Write 1 to start the switching test;Write 0 to end the switch measurement try	
40402	**00401**	Input switching test (Read Only)	From low to high each represents an input state	
40403	**00402**	Output switching test	Each digit represents an output state from low to high	
40404	**00403**	IN1	The initial	instructions

			1	Enter a list of definitions: I00: No definition I01: start I02: stop I03: stop I04: Feeding stepper motor origin (close the door to A level) I05: Feeding allowed I06: Unloading allowed I07: Clear alarm I08: keep I09: Open/close unloading door [originally manual unloading Function, switch discharging output state] I10: Manual unloading I11: Manual slow add I12: Manually add I13: Manual fast add [by fast open open The door] I14: Manual cleaning [open according to the maximum opening The door] I15: Start/stop (double edge: effective edge, Start;Invalid edge, stop) I16: Start/emergency stop (double edge) I17: Manual unloading (double edge) I18: Manual slow adding (double edge)
40405	**00404**	IN2	**2**	
40406	**00405**	IN3	**5**	
40407	**00406**	IN4	**6**	
40408	**00407**	(1-ZT1)	**4**	
40409	**00408**	(1-ZT2)	**23**	
40410	**00409**	(2-ZT1)	0	
40411	**00410**	(2-ZT2)	0	
40412	**00411**	IN5	0	
40413	**00412**	IN6	0	
40414	**00413**	IN7	0	
40415	**00414**	IN8	0	

				I19: Manual adding (double edge) I20: Manual quick add (double edge) I21: Manual cleaning (double edge) I22: reset I23: Emergency stop [level](valid, no Start allowed, manual feeding not allowed, not allowed Manual unloading is allowed) I24: feeding stepping motor limit point. I25: Unloading stepping motor origin. I26: limit point of unloading stepping motor. I27: jam I28: Servo motor alarm I29: Double scale interlock input
40416	**00415**	OUT1	**1**	Output definition list: O00: No definition Run O01: O02: Refueling request O03: Feeding stepper motor direction [PW available The signal is set to feed PWM] O04: quick to add I add O05: O06: slow O07: fixed value O08: unloading L O09: over difference O10: alarm
40417	**00416**	OUT2	**4**	
40418	**00417**	OUT3	**5**	
40419	**00418**	OUT4	**6**	
40420	**00419**	OUT5	**7**	
40421	**00420**	OUT6	**8**	

				11: clip bag **O**12: Preset number of packets completed O13: Once packing is completed (unloading is completed After output 1s clock) O14: stop O15 unloading step motor direction O16 Discharging motor running/forward O17 discharging motor reverses O18 feeding PWM[only AVAILABLE for OUT7/OUT8] **O**19 Discharging PWM[only available at OUT7/OUT8]
40422	**00421**	OUT7[DR1]	**3**	PWM port output definition, definition value reference general Custom output port (when PWM1 is set to non-0 ,DR1,PWM1 as the corresponding motor control Output, definition invalid)(when PWM2 is set to non-0 ,DR2,PWM2 as the corresponding motor control Output, definition invalid)
40423	**00422**	OUT8[DR2]	**8**	
40424	**00423**	OUT9[PWM1]	**0**	
40425	**00424**	OUT10[PWM2]	**0**	
40426	**00425**	PWM1 function	Initial value, 1,0: off;1: charging PWM;2: unloading PWM	
40427	**00426**	PWM2 function	Initial value, 0,0: close;1: charging PWM;2: unloading PWM	
40428	**00427**	Start the	Write: 1, read: 1: running status, 0: stopped status	

40429	**00428**	scram	Write: 1, read: 1: running status, 0: stopped status
40430	**00429**	stop	Write: 1, read: 1: Stop signal has been entered (this time packing The process will stop after the end), 0: the stop signal is not entered
40431	**00430**	reset	Write: 1, read: 1: weight is 0, 0: weight is not 0
40432	**00431**	Remove alarm	Write: 1, read: 1: no alarm, 0: alarm
40433	**00432**	Choose the formula	Write: 1, read: 0
40434	**00433**	Loose bag	Write: 1, read: 1: packed, 0: not packed.
40435	**00434**	Open/close discharge door	Write: 1, switch unloading door status, valid -> invalid, invalid -> Yes Read: 1: discharging effective, 0: discharging invalid
40436	**00435**	Slowly add manually	Write: 1, read: 1: slow add effective, 0: slow add invalid.
40437	**00436**	Manually add	Write: 1, read: 1: add valid, 0: add invalid.
40438	**00437**	Quickly add manually	Write: 1, read: 1: fast add is valid, 0: fast add is invalid
40439	**00438**	Manually removing mixture	Write: 1, read: 1: cleaning effective, 0: cleaning ineffective
40440	**00439**	Manual maximum opening speed	Write: 1, read: 1: fast add is valid, 0: fast add is invalid
40441	**00440**	Automatic feeding once (fixed value junction Stop after bundle)	Write: 1, read: 1: automatic feeding, 0: not automatic feeding material
40442	**00441**	Emergency stop	Write :0/1, exit/enter emergency stop lock Read :1: emergency stop, 0: no emergency stop

40443	**00442**	Manual discharging once	Write: 1, read: 1: discharging, 0: discharging invalid
40444	**00443**	Allowed to add	Read/write 1, grant valid, read/write 0, grant invalid
40445	**00444**	Allow unloading	Read/write 1, enable/disable, read/write 0, enable/disable
40446 **...** **40500**	**00445** **...** **00499**	The reserved	
Communication parameters			
40501	**00500**	Serial port 1 Slave (read only)	Initial value, 1. Range: 1 to 99
40502	**00501**	Serial port 1 communication protocol (only Read)	Initial value: 0,0: Modbus-RTU, 1: Modbus-ASCII
40503	**00502**	Serial port 1 Baud rate (read only)	Initial value, 3, 0:9600, 1:19200, 2:38400, **3:57,600, 4:115,200**
40504	**00503**	Serial port 1 data format (only Read)	Initial value, 1,0:18N2, 1:18e1, 2:18o1, 3: **18N1**
40505	**00504**	Serial port 1Modbus double word mail Memory order (read only)	Initial value, 0,0: ABCD, 1: CDAB
40506	**00505**	Serial port 2 Slave machine number	Initial value, 1. Range: 1 to 99
40507	**00506**	Serial port 2 communication protocol	Initial value: 0,0: Modbus-RTU, 1: Modbus-**ASCII**
40508	**00507**	Serial port 2 baud rate	Initial value, 3, 0:9600, 1:19200, 2: **38400, 3:57,600, 4:115,200**

40509	**00508**	Serial port 2 data format	Initial value, 1,0:18N2, 1:18 E1, 2: **18O1, 3:18N1**
40510	**00509**	Serial port 2Modbus High Low Word Order	Initial value, 0,0: ABCD, 1: CDAB
40511	**00510**	Serial port 3 slave number	Initial value, 1. Range: 1 to 99
40512	**00511**	Serial port 3 communication protocol	Initial value: 0,0: Modbus-RTU, 1: Modbus-**ASCII**
40513	**00512**	Serial port 3 baud rate	Initial value, 3, 0:9600, 1:19200, 2: **38400, 3:57,600, 4:115,200**
40514	**00513**	Serial port 3 data format	Initial value, 1,0:18N2, 1:18 E1, 2: **18O1, 3:18N1**
40515	**00514**	Serial port 3Modbus High Low Word Order	Initial value, 0,0: ABCD, 1: CDAB
40516	**00515**	Network port IP group 1	0~255
40517	**00516**	Network port IP group 2	0~255
40518	**00517**	Network port IP group 3	0~255
40519	**00518**	Network port IP group 4	0~255
40520	**00519**	Network port number	0-~65535
40521	**00520**	Network interface communication protocol	0：Modbus-TCP/IP 1：Minicenter 2：Web

40522	**00521**	High and low byte order of network interface	0：AB-CD 1：CD-AB
40523	**00522**	MAC1	0~0xFF
40524	**00523**	MAC2	0~0xFF
40525	**00524**	MAC3	0~0xFF
40526	**00525**	MAC4	0~0xFF
40527	**00526**	MAC5	0~0xFF
40528	**00527**	MAC6	0~0xFF
40529 ... 40600	**00528 ... 00599**	The reserved	
External setting parameters			
40601	**00600**	Clip bag delay	Initial value: 500. The value ranges from 0 to 9999, expressed in milliseconds
40602	**00601**	Delay before releasing bag	Initial value: 500. The value ranges from 0 to 9999, expressed in milliseconds
40603 ... 40700	**00602 ... 00699**	The reserved	
System parameters			
40701	**00700**	Device model (ASCII code) Character) (read only)	**'G'+'M'**
40702	**00701**		**'-'+'F'**
40703	**00702**		**'0' + '1'**
40704	**00703**		**0**
40705	**00704**		**0**

40706	**00705**		**0**
40707	**00706**		**0**
40708	**00707**		**0**
40709	**00708**		**0**
40710	**00709**		**0**
40711	**00710**	Version number (read Only)	**4 bytes, unsigned number, such as** converted **decimal value to** **123456, 12.34.56, range: 0 to 999999**
40712	**00711**		
40713	**00712**	Compile date: year (read only)	**2000 ~ 2099**
40714	**00713**	Compile date: Month (read only)	**1 ~ 12**
40715	**00714**	Compile date: day (read only)	**1 to 31**
40716	**00715**	Compile date: time (read only)	**0 ~ 23**
40717	**00716**	Compile date: Fen (read only)	**0 ~ 59**
40718	**00717**	Compile date: seconds (read only)	**0 ~ 59**
40719	**00718**	Parameters of the reset	Write: **0** resets **all (production use, including all the following additional also** There are statistical data clearance, cumulative clearance, putter related parameters) (Super user) **1 Reset all (clients) including all below** **2 Reset basic parameters** **3 Reset calibration parameters** **4 Reset user parameters**

			5 Reset peripheral parameters **6 Reset the adaptive parameters** **7 Reset communication parameters** **8** Reset **Switch Value User-defined parameter** **9 Reset adaptive statistics** Read: 0
40720	**00719**	keep	
40721	**00720**	Enable/disable USB	**1: USB is** enabled**. 0: USB is disabled**
40722	**00721**	The USB device is connected (only Read)	**0: the USB** device **is connected. 1: the USB device is not connected**
40723	**00722**	USB mass storage device Connected (read Only)	**0: The USB mass storage device is connected** **1: The USB mass storage device is not connected**
40724 **...** **40750**	**00723** **...** **00749**	The reserved	
"Usb flash drive update application" function parameter			
40751	**00750**	Enter or exit the Bootloader	Read: **0: the** main **program is automatically entered after a delay of 3 seconds** **1: The** Bootloader **is installed** Write: **1: Enters the Bootloader** **2: Exits** the **Bootloader and enters the main program**
40752	**00751**	The USB device is connected (only Read)	**0: The** USB **device is connected** **1: the USB device is not connected**

40753	**00752**	USB mass storage device has been installed Connect (read Only)	**0: The** USB **mass storage device is connected** **1: The USB mass storage device is not connected**
40754	**00753**	Upgrade file scanning result (only Read)	**0: no upgrade file** **1: control board upgrade file exists**
40755	**00754**	Control board program upgrade information (read-only)	**Zero: no** **1:** The **control board is being upgraded** **2:** The **controller module fails to be upgraded** **3: The controller module is successfully upgraded** **4: The** control **board upgrade file does not match the instrument model** **5: The** upgrade **file of the control module is incorrect** **6: The upgrade file of the control board does not exist**
40756	**00755**	Reserved (read only)	
40757	**00756**	Version number of the upgrade file on the control board	Read: Version number (6 decimal digits) Write: 1 Upgrade this version of the program
40758	**00757**		
40759 **...** **40800**	**00758** **...** **00799**	The reserved	
Adaptive correlation parameters			
40801	**00800**	Adaptive master switch	Initial value: 1 the value ranges from 0 to 1
40802	**00801**	Self - adaptive & automatic scale adjustment	Initial value: 1. The value ranges from 0 to 4
40803	**00802**	Positive error function switch	Initial value: 0. Range: 0 to 1

40804 ... 40900	**00803 ... 00899**	The reserved	
Internal reserved parameter			
40901 ... 40916	**00900 ... 00915**	The reserved	
40917	**00916**	Add more time to your sentence	Initial value: 700. The value ranges from 0 to 9999, expressed in milliseconds
40918 ... 40923	**00917 ... 00922**	The reserved	
40924	**00923**	Canada time of suspension	Initial value: 700. The value ranges from 0 to 9999, expressed in milliseconds
40925	**00924**	Slow down the sentence	Initial value: 700. The value ranges from 0 to 9999, expressed in milliseconds
40926 ... 41100	**00925 ... 01099**	The reserved	
Target value data parameter [Only the target value of each formula under the current material number, it is not supported to read the target value of each formula number of different materials]			
41101	**01100**	Target value (Formula 1)	The value ranges from 0 to 999999, in grams, read-only
41102	**01101**		
41103	**01102**	Target value (Formula 2)	The value ranges from 0 to 999999, in grams, read-only
41104	**01103**		
41105	**01104**	Target value (Formula 3)	The value ranges from 0 to 999999, in grams, read-only
41106	**01105**		

41107	**01106**	Target value (Formula 4)	The value ranges from 0 to 999999, in grams, read-only
41108	**01107**		
41109	**01108**	Target value (Formula 5)	The value ranges from 0 to 999999, in grams, read-only
41110	**01109**		
41111	**01110**	Target value (Formula 6)	The value ranges from 0 to 999999, in grams, read-only
41112	**01111**		
41113	**01112**	Target value (Formula 7)	The value ranges from 0 to 999999, in grams, read-only
41114	**01113**		
41115	**01114**	Target value (Formula 8)	The value ranges from 0 to 999999, in grams, read-only
41116	**01115**		
41117	**01116**	Target value (Formula 9)	The value ranges from 0 to 999999, in grams, read-only
41118	**01117**		
41119	**01118**	Target value (Formula 10)	The value ranges from 0 to 999999, in grams, read-only
41120	**01119**		
41121 ... 41200	**01120 ... 01199**	The reserved	
Cumulative data parameter			
41201	**01200**	Clear the total accumulated data	Write 1 to clear the total cumulative data and cumulative data of all formulations Write 2 Clear the total accumulated data Do not clear the formula accumulated data
41202	**01201**	Clear cumulative formula data	Write person 0 to clear all formula accumulations Write 1 to 20 to clear the accumulated data of formula 1 to 20
41203	**01202**		

... **41500**	**...** **01499**	The reserved	
Packet record parameters			
41501	**01500**	Total number of entries	Write 0 to clear record, range: 0~50000, update at the end of unloading
41502	**01501**	View the start number of entries	Range: 1~50000, updated at the end of unloading
41503 **...** **42000**	**01502** **...** **01999**	The reserved	
Automatic adjustment of weighing parameters			
42001	**02000**	Automatic balance status adjustment	Read: Automatic balancing Status :0/1: Stop/running.2. Automatic balancing Done.[pause set back to 0 instead of 2], read only
42002	**02001**	Maximum material type	**10~40. Temporarily fixed to 10. Later adjustment. That is, maximum support insurance** Store 10 different materials, read only
42003	**02002**	=40301, current material type	read-only
42004	**02003**	=40302, current formula number	read-only
42005	**02004**	=41050, the scale of the current specification is the highest Large range points	read-only
42006	**02005**	=41096, current target value In the range point	read-only

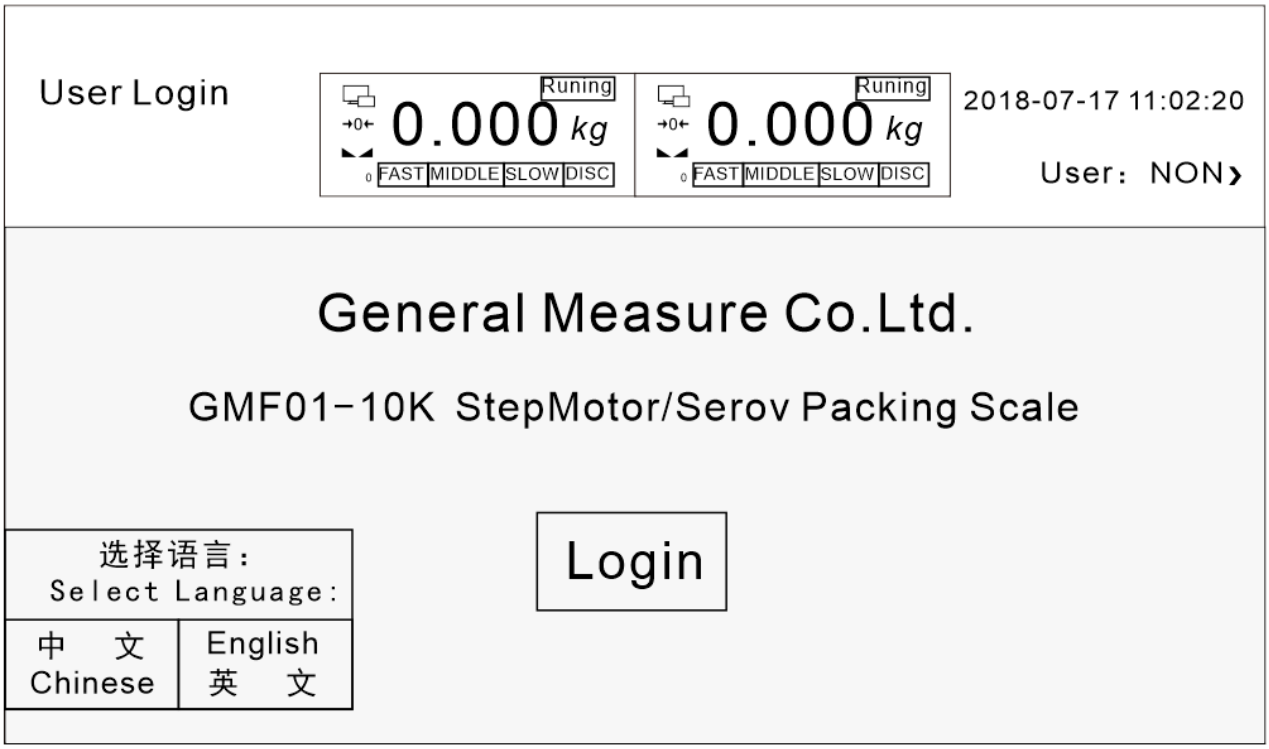
42007	**02006**	Automatic weighing times	Initial value: 6. The value ranges from 3 to 10
42008	**02007**	How many	
42009	**02008**	Qualified times	
42010	**02009**	Automatically adjust the scale grade	Initial value: 1, range: 0~4, the smaller the level, the better the speed First, each level increase, small cast time about 0.2S longer
42011	**02010**	Start/stop automatic adjustment scale	Read: Automatic balance status :0/1: Stop/run (complete state 0), write :1/0: enable/disable automatic balancing
42012	**02011**	Save the result of automatic balancing	Write 1: saves the result of automatic balancing to the current current material number Formula number, write 2: abandon save, restore the debugging result is silent Value.
42013 **...** **42020**	**01207** **...** **02019**	The reserved	
42021	**02020**	Material XSegY fast increase and advance quantity The results of	X= Material number,Y segment number, material number change, target value change [span Range range], the value of this range may change automatically
42022	**02021**		
42023	**02022**	Add material XSegY in advance The results	
42024	**02023**		
42025	**02024**	Material XSegY slowly add and advance quantity The results of	
42026	**02025**		

42027	**02026**	Material XSegY fast opening knot fruit	
42028	**02027**	Material XSegY in the opening knot fruit	
42029	**02028**	Material XSegY slow opening knot fruit	
42030	**02029**	keep	
42031	**02030**	Material XSegY fast increase and advance quantity The initial value	
42032	**02031**		
42033	**02032**	Add material XSegY in advance Amount of the initial value	
42034	**02033**		
42035	**02034**	Material XSegY slowly add and advance quantity The initial value	
42036	**02035**		
42037	**02036**	Material XSegY fast opening Starting values	
42038	**02037**	Material XSegY in the opening Starting values	
42039	**02038**	Material XSegY slow opening Starting values	
42040	**02039**	keep	

Note: The above is all the contents of Modbus communication address table of AF-25KⅡ-103B／AF-50KⅡ-103B automatic quantitative unit.If the device is equipped with a 7 - or 10-inch touch screen, read all of Chapter 7 carefully.Do not read Chapter 7 if the device is not equipped with a touch screen.

7. Touch screen Operation Instructions (optional)

7.1Login screen



Interface Description: The interface is displayed after startup and before login.

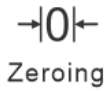
Operating instructions for buttons and operation boxes (applicable to all operating interfaces of the device):

1. Setting Click this button to enter the parameter setting interface.

2. Auto Setting Click this button to enter the automatic scale adjustment interface.

3. 

Click this button to enter the historical data interface to view relevant data.

4. 

Click this button to perform a reset operation.

5. 

Click this button to make the device emergency stop.

6. 

Click this button to start and stop the device.

7. 

Click this type of operation box to modify this value.

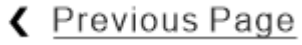
8. 

Click this type of operation box to select and set this definition.

9. 

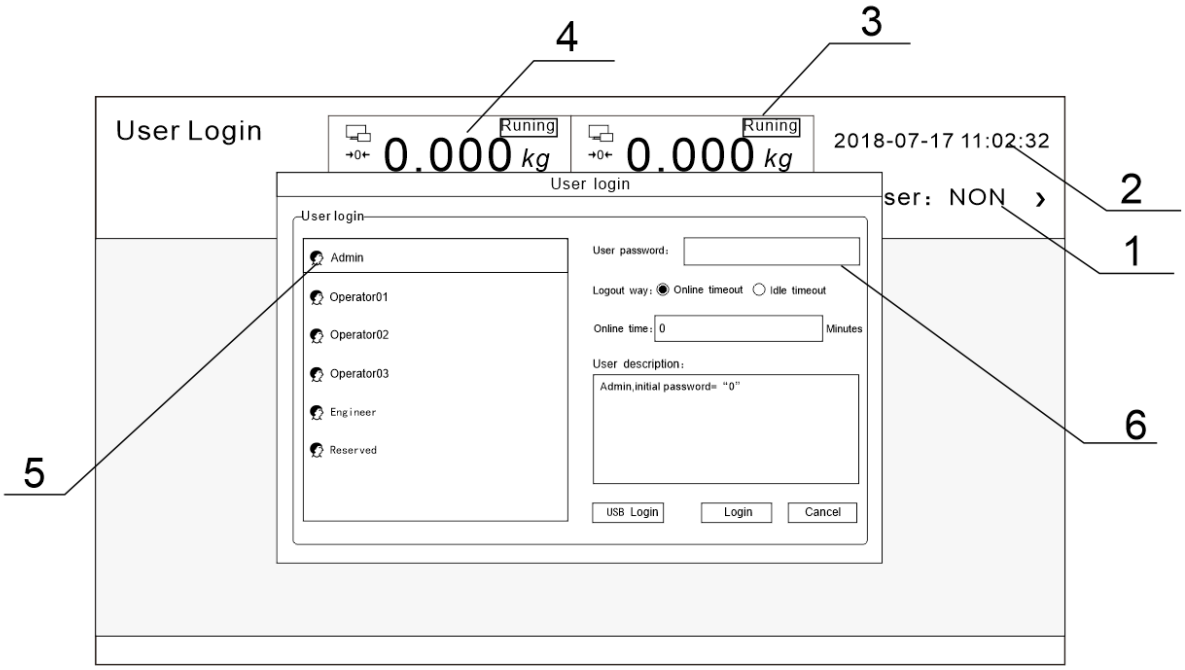
Click this type of operation box to perform corresponding operations.

10. 
Click this type of operation box to set the opening and closing of corresponding functions.

11. 

Click this type of operation box to switch pages.

7.2Touch screen login permission description



Interface description:

1: indicates the level of the current login user.

2: indicates the system date and time, indicating the current system date and time.

3: indicates the working status of the equipment.

4: Weight display area, display the current weight and weight unit, if the weight overflow or sensor overflow, there will be text prompt in this area, such as: "weight overflow", "weight overflow", etc.

5: Login user selection area, showing all users that can be selected.

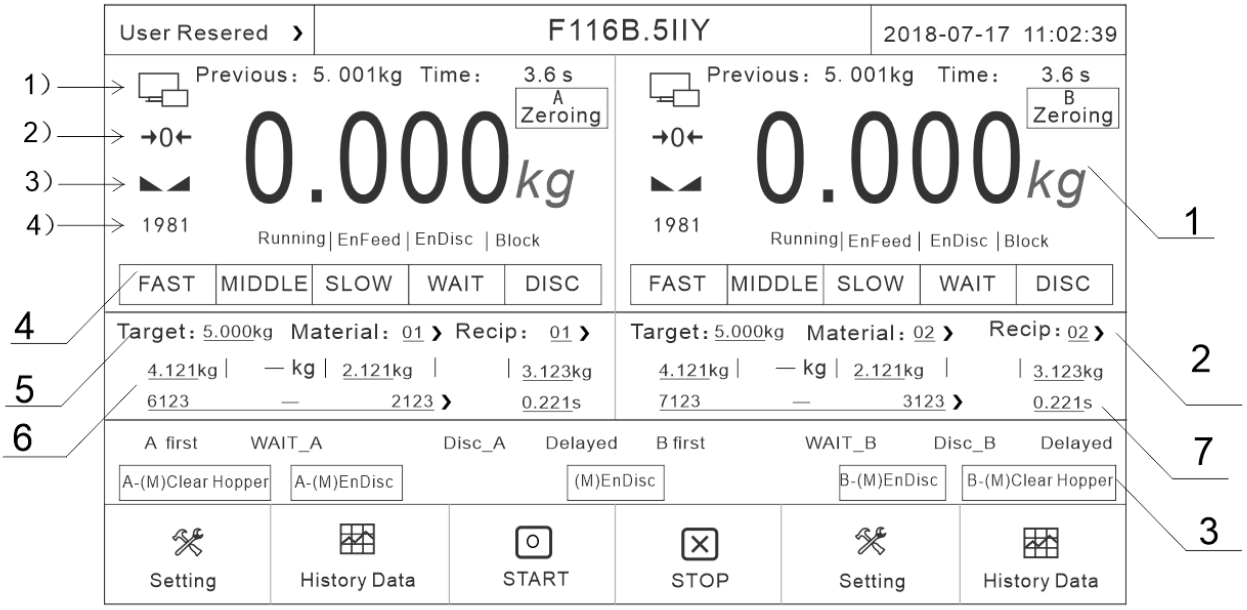
6: User password input box, select a user account and enter the corresponding user password

user name	user	Password	limits of authority
Admin	administrators	0	Not allowed: scale calibration/switching value/motor parameters, etc

Operator01	Operator01	1	it is not allowed to set the scale calibration/switching value/motor parameters/system information, etc
Operator02	Operator02	2	
Operator03	Operator03	3	
Engineer	Engineer	Please obtain the password from the manufacturer	Unlimited operation
Reserved	Reserved	No user action required	No user action required

For specific operation methods, please refer to Chapter 7.1 "Operating Instructions for Buttons and Operation Boxes".

7.3Main Interface description



Interface description:

1. Current weight and equipment status, where:

1）Communication status. When the communication is normal, the icon is green.
2）Zero flag. When the current weight is at zero, the icon is green.
3）Weight stability indicator. When the weight is stable, the indicator icon is green.
4）Opening mark, opening of current material door.

In addition, there are allowed feeding, unloading, operation or stop status display.

2. The current material number and formula number can be set to replace the formula or material. Click the "Formula Setting" button on the right to modify the current formula parameters.

3. Currently available manual operation: manual discharging A, manual discharging A, manual discharging, manual discharging B, manual discharging B, all the buttons can manually control the corresponding action (the operation is invalid during operation).

4. Each state of the device when it is running. When the device is in the stopped state, the corresponding manual operation can be performed (the runtime operation is invalid).

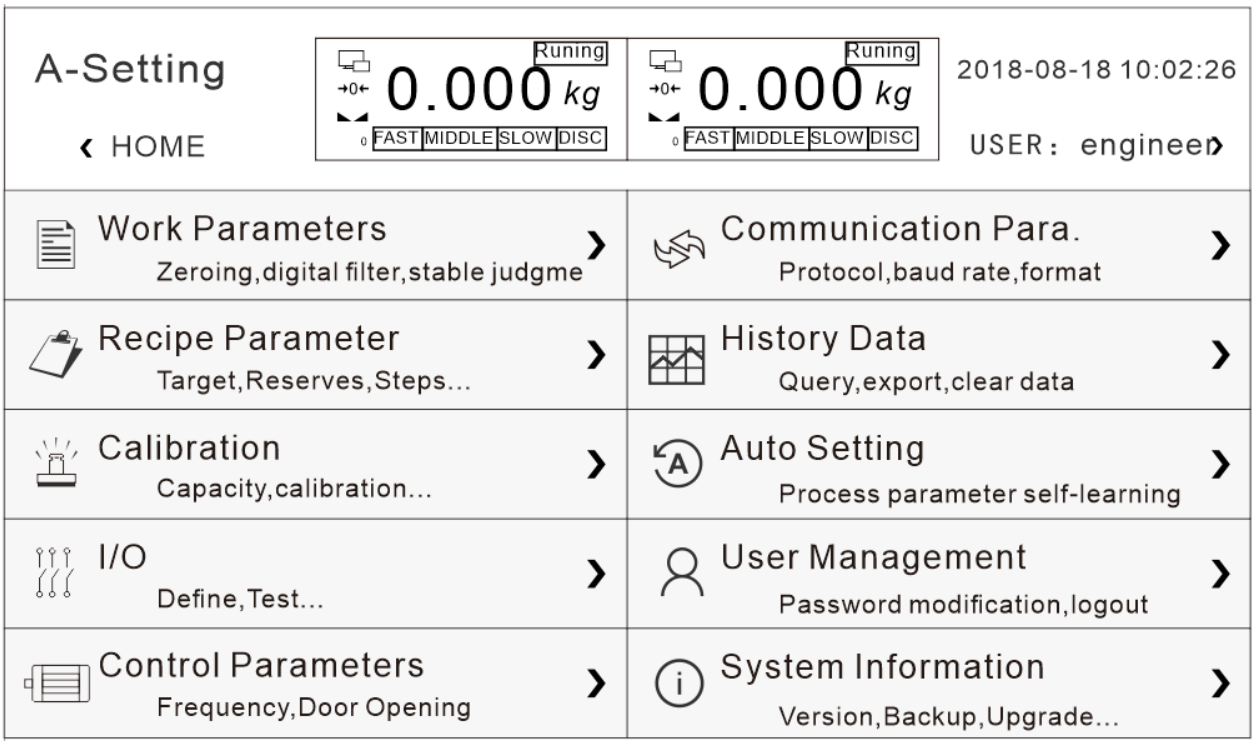
5. Current target value.

6. The feed cut-off advance value and target value under the current formula.

7. Discharge time and feeding door opening Settings under the current formula.

For specific operation methods, please refer to Chapter 7.1 "Operating Instructions for Buttons and Operation Boxes".

7.4The parameter setting page is described



Interface description:

Working parameters: basic parameters of the product can be set, such as zero clearance range, zero clearance time, unloading mode and so on.

Communication parameters: the communication parameters of the product can be set. Serial port 1 is used to communicate with the touch screen. The parameters cannot be modified, but can be adjusted automatically through the serial port. Serial port 2 can be used as an external serial communication interface. The communication parameters can be set by oneself, but should be consistent with the communication equipment (see 7.10 Communication Interface description for details).

Formula parameters: can modify the current formula number, as well as the parameter value of the current formula to modify, such as modify the lead quantity, material door opening, unloading time, etc.

Historical data: You can query previous packing records on the historical data screen and export the packing records to a USB flash drive.

Calibration scale: zero calibration, weight calibration, material calibration, and maximum range setting.

Automatic balance: Can only set up the target and the scale number, click the start after adjustment scale button, the equipment is up and running, in setting the number of times to adjust the value of each schedule, after completing the scale number, if meet the needs of users, the user can press the save button, will automatically adjust the data as the current formula value after the nc data, if give up, The debugging data is restored to the factory default data.

On/Off quantity: Users can define and set the input quantity and output quantity according to their own requirements. The control board has 4 inputs and 6 outputs (for details, see 7.8 Switch Quantity Description).

User management: Switch user rights.

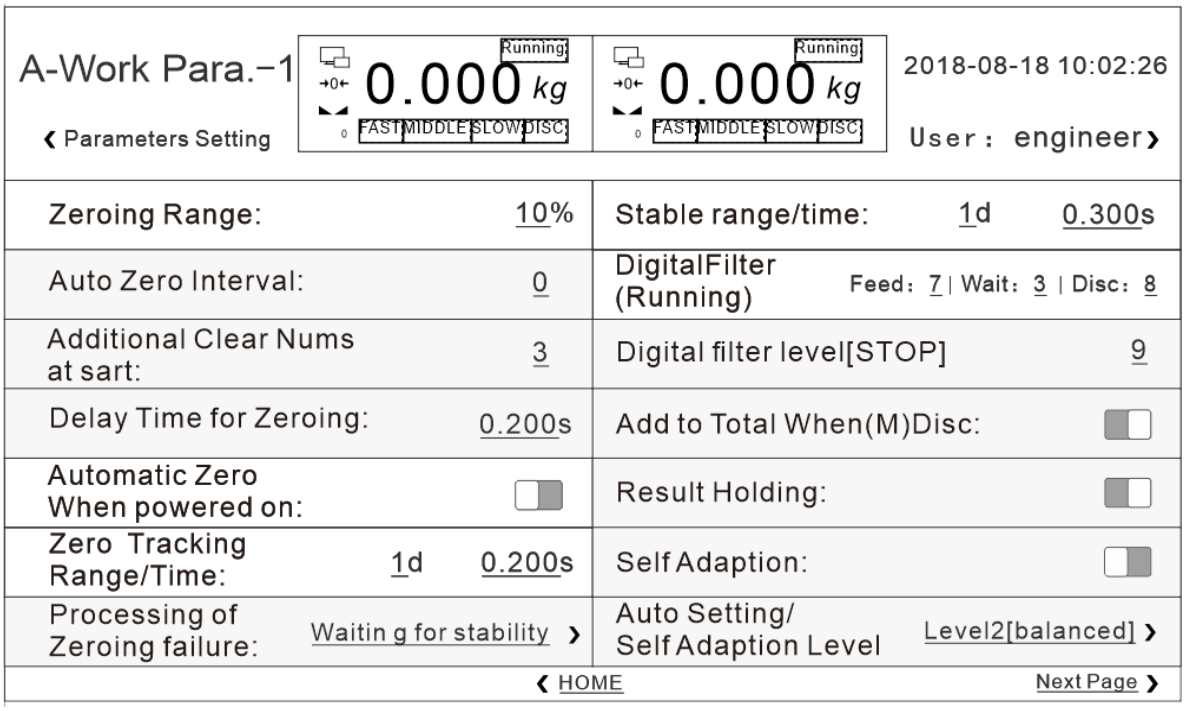
Control parameters: parameters of the feeding motor can be set.

System information: Displays the current touch screen software version and control board software version. You can also update the control board program using the USB flash drive (for details, see 7.14 USB Flash Drive Upgrade Description).

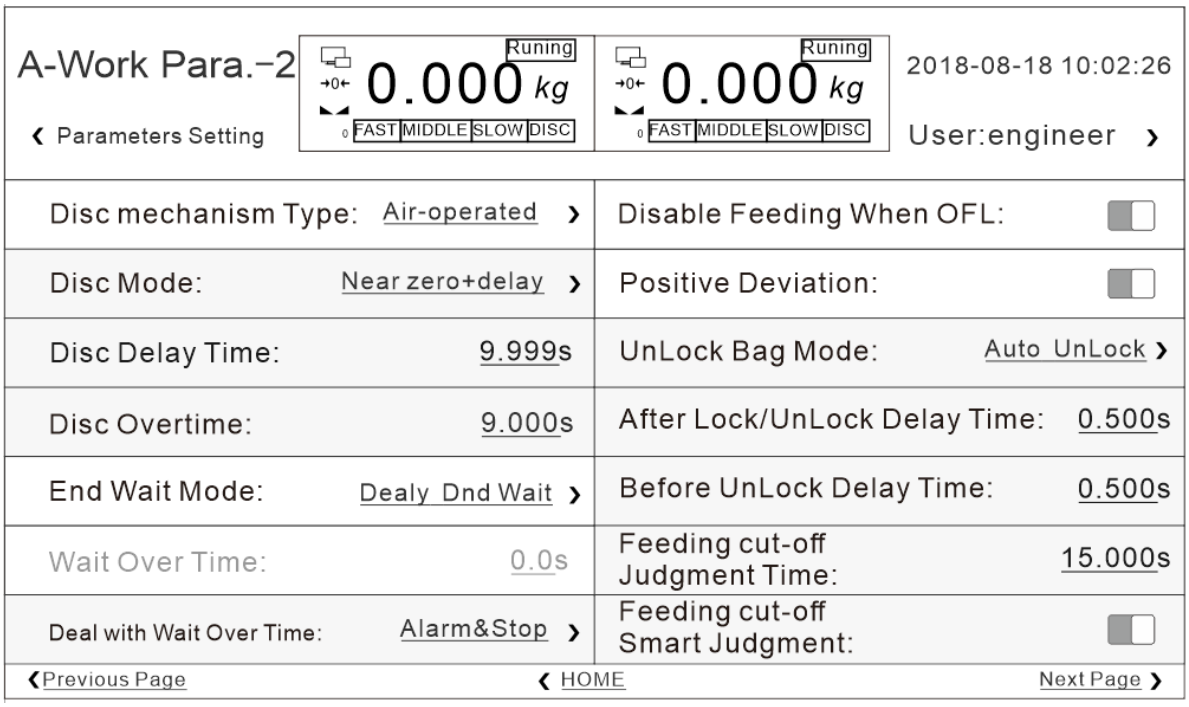
Users can also reset the parameters, time and screen display related Settings.

For specific operation methods, please refer to Chapter 7.1 "Operating Instructions for Buttons and Operation Boxes".

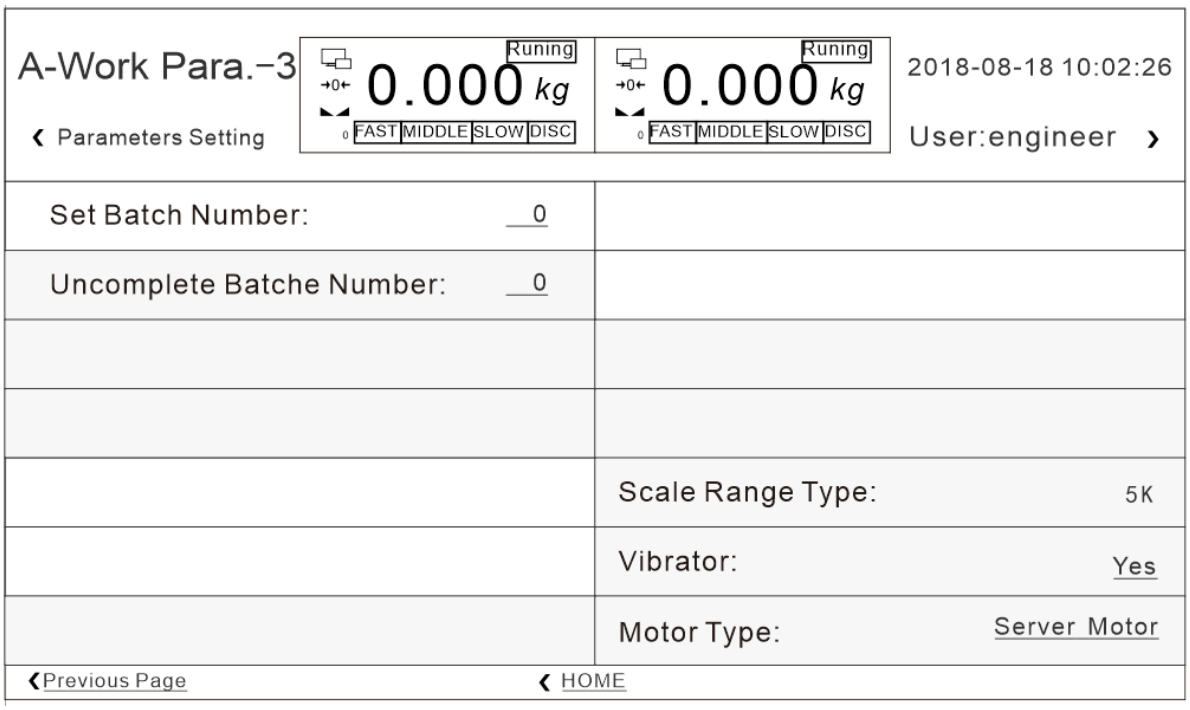
7.5 Description of working parameters



Working parameters 1 diagram



Working parameters 2 diagram



Working parameters 3 diagram

Interface description:

（1）Clearing range: clearing range (1%-20% of the full range).

（2）Automatic zeroing interval: during operation, the device automatically zeroing after completing the set number of packets.

（3）Start additional zeroing times: after the equipment enters the running state, the second scale shall start, and zeroing shall be performed continuously before feeding, and the number of times shall be equal to the set value of this parameter. For example, the number of additional zeroing is 2, the second and third scales are zeroed before feeding after starting.

（4）Additional delay of zero clearing: when zero clearing is needed (whether automatic zero clearing interval or additional zero clearing interval), before zero clearing, the equipment completes the delay before feeding + after this delay, the operation of zero clearing begins.

（5）Automatic zeroing when the device is powered on: The device is automatically zeroed when it is powered on.

（6）Zero-point tracking range/time: zero-point tracking range 0-9D This parameter is optional. Zero-point tracking time ranges from 0.001 to 9.999.

（7）Automatic clearing failure handling: Indicates the handling method after automatic clearing failure, including clearing the next packet again, suspending the three-packet failure, continuing to wait for stability, and suspending the packet immediately.

（8）Stability range/time: the range of stability evaluation is 0~99d, which is optional. If the weight change within the stability evaluation time does not exceed the range of stability evaluation, it is considered as stable; otherwise, it is considered as unstable.

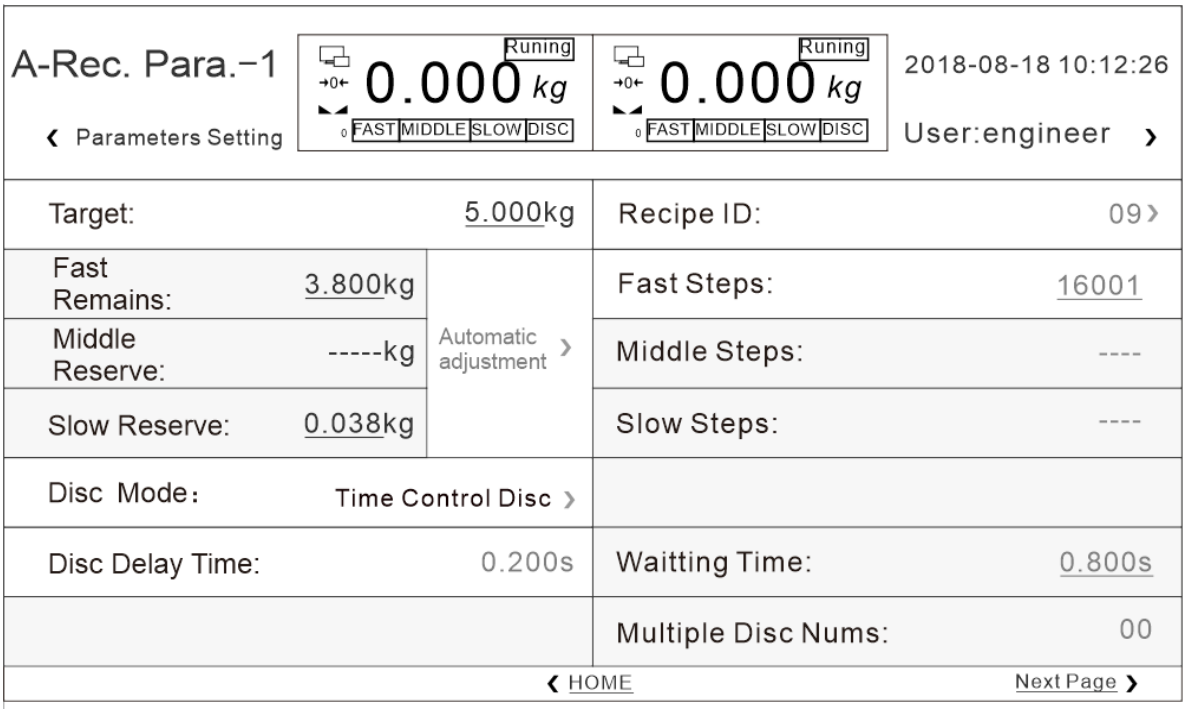
（9）Operation filtering level: the filtering level used in the operation process, ranging from 0 to 9, which can be divided into feeding, fixed value and unloading. The higher the value,

the better the filtering effect, but the greater the lag.
（10）Stop filtering level: the filtering level used in the stopped state, 0-9, the larger the value, the better the filtering effect, but the greater the lag.
（11）Manual unloading accumulation: when manual unloading, packing weight is counted into the accumulation.
（12）Constant weight retention: the weight display shall remain unchanged after the end of the fixed time until the unloading is completed.
（13）Adaptive switch: If this switch is turned on during the operation of the device, the device will automatically adjust the scale according to the adaptive level.
（14）Adaptive & automatic balancing grade: it can be divided into five grades: zero grade for optimal speed, first grade for slightly better speed, second grade for equalization, third grade for slightly better accuracy, and fourth grade for optimal accuracy.
（15）Unloading mechanism type: pneumatic and electric, can be selected according to the specific structure of the equipment.
（16）Discharging mode: it can be divided into two modes: time control discharging mode and zero-zone delay discharging mode. The discharging door is closed when the unloading time is from discharging to discharging; the unloading door is closed when the unloading weight is less than zero zone value when the delay time is started.
（17）Unloading timeout time: if the unloading process exceeds the set time, the equipment will prompt the unloading timeout alarm message and automatically return to the stop state.
（18）Fixed value mode: it can be divided into two modes: time fixed value and judgment stable value.
（19）Fixed value timeout: If the fixed value is not completed within this time, the fixed value timeout processing will be entered.
（20）Fixed value timeout processing: optional timeout alarm without suspension, three-packet alarm before suspension, continuous alarm and wait for stability, continuous alarm and pause.
（21）Overrange protection: when turned on, from zero to zero (plus the part cleared), the weight is large
When it is equal to 1.2 times of the upper limit of the quantitative range, it enters the state of overrange protection. This function can prevent the occurrence of the situation that the weight is small but it has been overflowed after the larger weight is cleared to 0.
（22）Positive error mode: in the process of feeding after opening, the error generated by feeding results will be positive.
（23）Bag loosening mode: You can choose between automatic bag loosening or manual bag loosening.
（24）Delay after bag clamping/loosening: After the bag clamping or bag loosening signal is output, delay the time to stop the signal output.
（25）Delay before bagging: After delaying this time, the bagging signal is output.
（26）Fast heater cutoff timeout: If the material does not reach the set value after delaying this time, it is determined as fast heater cutoff.
（27）Intelligent judgment of fast heater cutoff: When turned on, it enters the intelligent judgment mode of fast heater cutoff.
（28）Set Batch Number: The set batch number.

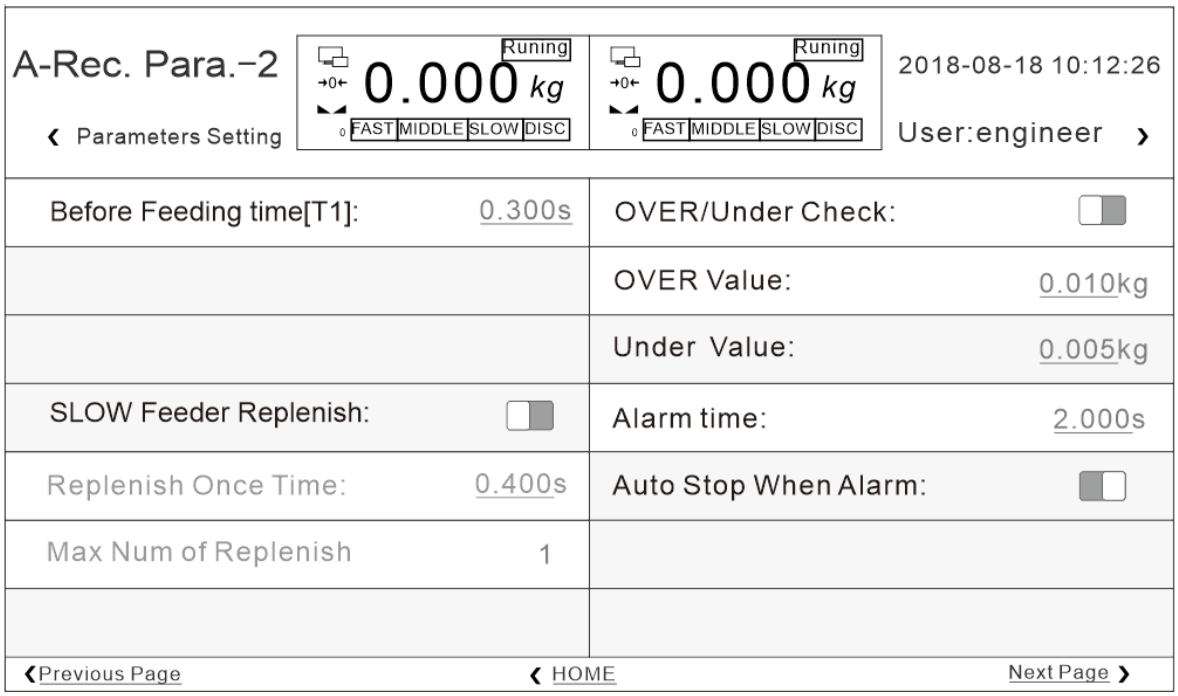
（29）Number of remaining batches: The number of remaining batches.
（30）Compulsory use of three-level feeding (shared by AB scale).
（31）AB interlock scale mode: When turned on, it enters the three-level feeding mode.
（32）Forced shutdown of A (only used when A scale fails): A scale can be directly closed.
（33）Scale specification, vibration plate and motor type: these functions are set by the manufacturer, but not by engineers and users.

For specific operation methods, please refer to Chapter 7.1 "Operating Instructions for Buttons and Operation Boxes".

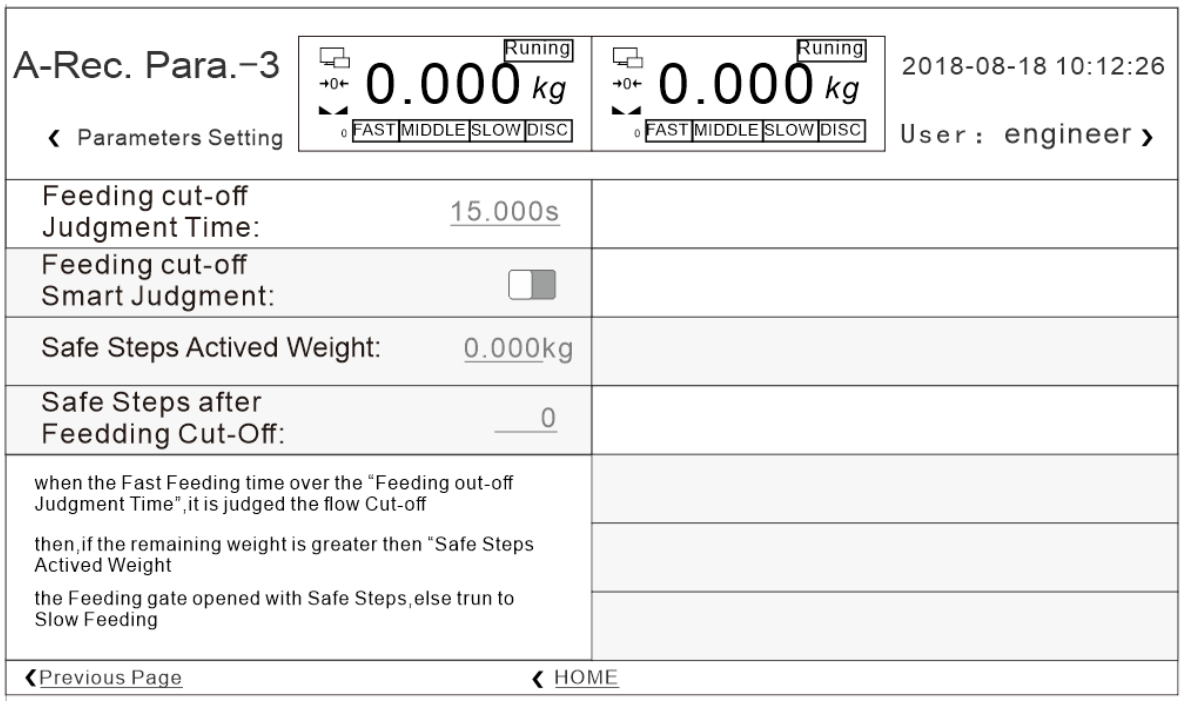
7.6Description of formula parameters



Formula parameters 1 diagram



Formula parameters 2 figure



Formula parameter 3 diagram

Interface description:

（1）Target value: A quantitative weight is required.
（2）Rapid acceleration advance: During the quantitative process, if the weighing value is ≥

the target value - the rapid acceleration advance, the rapid acceleration will be turned off.

（3）Intermediate dosing advance: During the dosing process, if the weighing value is ≥ the target value - intermediate dosing advance, the intermediate dosing will be turned off.

（4）Drop value: During the quantitative process, if the weighing value is ≥ the target value - drop value, the slow heater will be turned off.

（5）Unloading mode: You can select time controlled unloading or zero zone delayed unloading.

（6）Unloading time: Unloading signal output stops after lasting for this time.

（7）Zero zone value: During the quantitative process, if the weighing value is ≤ zero zone value, the unloading delay timer will be started.

（8）Recipe Number: The number of the current recipe.

（9）Quick feeding opening: The opening of the feeding door during fast feeding of materials.

（10）Medium dosing opening: the opening of the feeding door when adding materials.

（11）Slow feeding opening: The opening of the feeding door during slow feeding of materials.

（12）Fixed value time: the time to determine the weight after feeding is completed.

（13）Combination Times: This is a reserved parameter. Currently, the device does not support the multi scale combination function.

（14）Delay before feeding T1: When the quantitative process starts, the feeding process starts after a delay of T1 time;

（15）Slow feeding and replenishment switch: When this switch is turned on, the equipment automatically performs slow feeding and replenishment.

（16）Single Replenishment Time: The time of a single replenishment.

（17）Maximum Replenishment Times: The maximum number of replenishment times for the equipment.

（18）Over/under tolerance switch: A switch that enables the over/under tolerance detection function.

（19）Over tolerance: During the quantitative process, if the weighing value is greater than the target value+over tolerance, it will be judged as over tolerance.

（20）Under tolerance: During the quantitative process, if the weighing value is less than the target value - under tolerance, it is judged as under tolerance.

（21）Over/under tolerance alarm time: The duration of the over/under tolerance alarm output after detecting over/under tolerance. After this time, the over/under tolerance alarm automatic output is invalid.

（22）Over/under tolerance pause switch: When this switch is turned on, if over/under tolerance occurs, the device pauses for user processing, and can then "clear the alarm" and continue running; You can also return to the stop state after an "emergency stop".

（23）AB interlocking scale body mode: There are single scale, A scale, and B scale options. When using dual scale interlocking, it can be set to A scale or B scale.

（24）AB interlock delay time: The interlock delay time is a limit time given to another weighing machine. It is specified that the output is valid within this time, and the other weighing machine cannot be unloaded. The default time is 1s

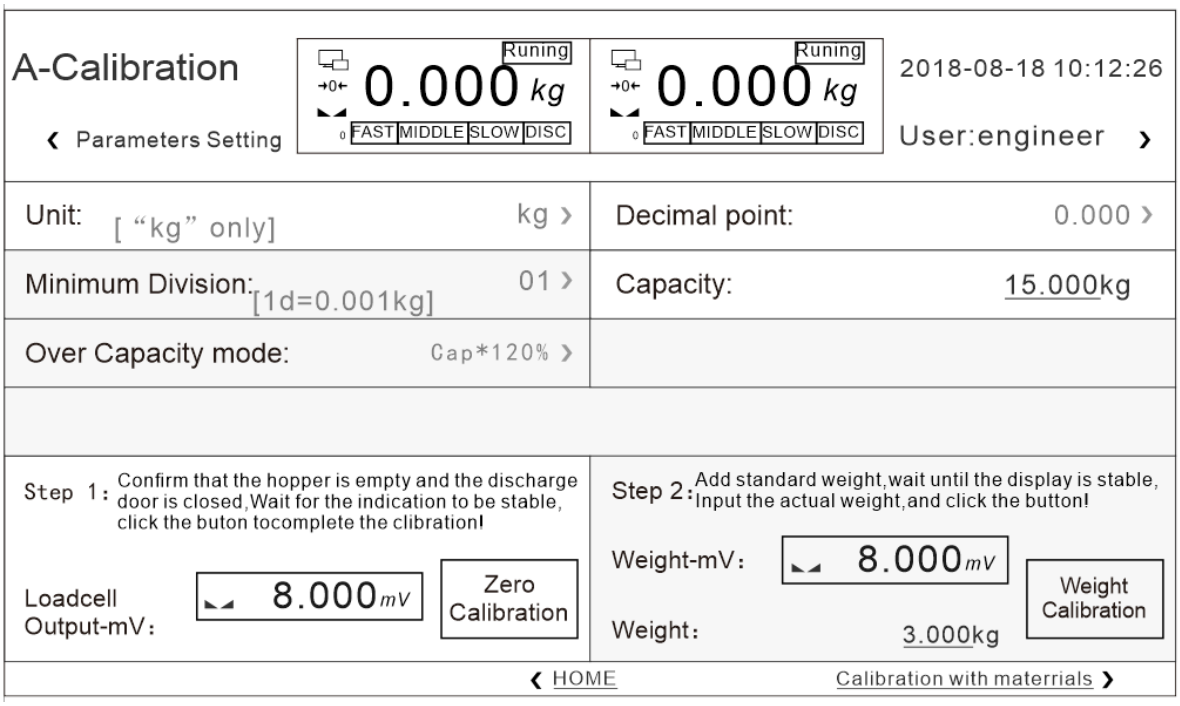
（25）Fast heater cutoff timeout: If the set value is not reached after exceeding this time, it is determined as fast heater cutoff.

（26）Intelligent judgment of fast heater cutoff: Turn on the switch, and the system will

automatically determine the fast heater cutoff.
（27）Opening weight of cut-off safety opening: When the material weight is higher than this value during cut-off, the safety opening will be opened, otherwise the original opening will remain unchanged.
（28） Safety opening degree of flow cutoff: This opening degree can ensure that the material will not be overweight when it is washed down instantaneously when it comes again.Target value: The weight to be quantified.

For specific operation methods, please refer to Chapter 7.1 "Operating Instructions for Buttons and Operation Boxes".

7.7Calibration interface description



Interface specification

（1）Unit: The fixed value is kg
（2）Minimum score: 1 2 5 10 20 50 Optional.
（3）Display mode of overrange: there are three options: when the current weight is greater than: maximum range + 9D, maximum range *120%, and maximum range *150%, the device will prompt weight overflow.
（4）Decimal point: fixed value 0.000, that is, three decimal places after the decimal point.
（5）Maximum range: maximum range of the device (do not set it to more than 20.00kg).

For specific operation methods, please refer to Chapter 7.1 "Operating Instructions for Buttons and Operation Boxes".

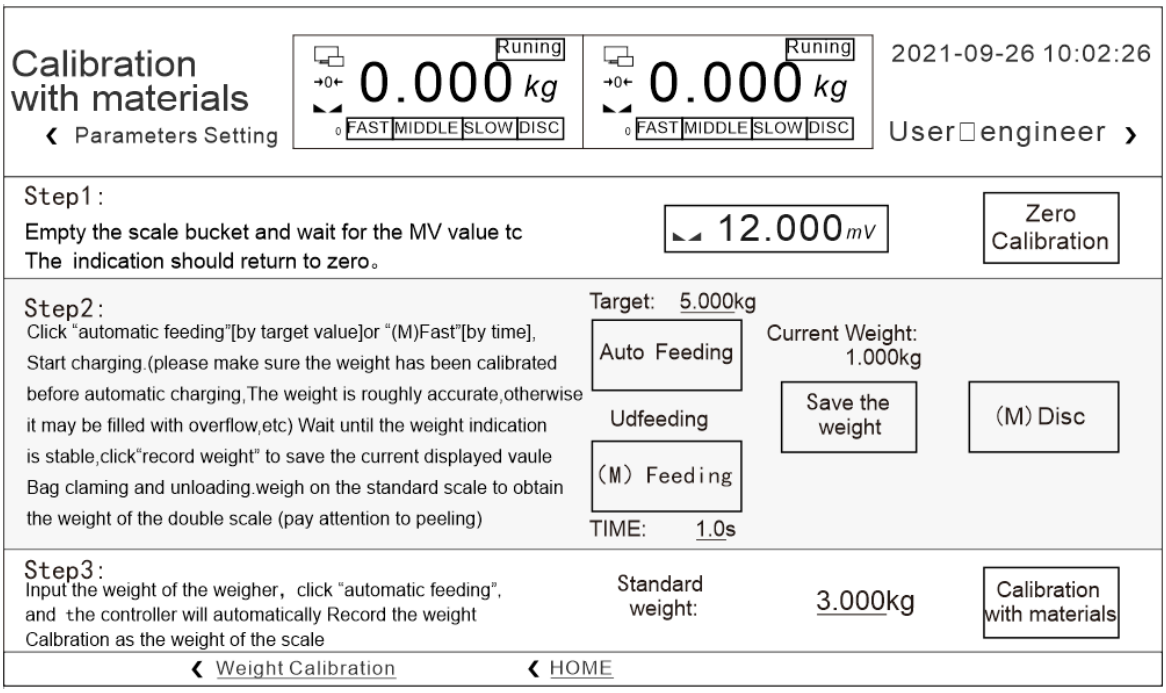
7.8Step of weight calibration

1. Zero point calibration: empty the hopper and close the discharge door.Click "Zero point Calibration" after the weight is stabilized. During the calibration process, the weight display area above will display the calibration result, and stability will be displayed after successful calibration.

2. Gain calibration: Add weights to the weighing mechanism, click the weight input box after the weight is stable, input the weight of the weight, click "weight Calibration", the weight display area above the calibration process will also display the calibration result.After successful calibration, the weight displayed in the weight display area is the input weight.Otherwise gain calibration fails. Try again.

For specific operation methods, please refer to Chapter 7.1 "Operating Instructions for Buttons and Operation Boxes".

7.9Material calibration steps



1. Zero calibration: the method is the same as the zero calibration of the weight calibration scale.

2. Gain calibration:

A. Use "automatic feeding" (automatically run a scale according to the current formula target value) or "manual feeding" (click once to start fast adding, click again to close fast adding), stop feeding and wait for the weight to stabilize, click "Record Weight" to save the current displayed value.

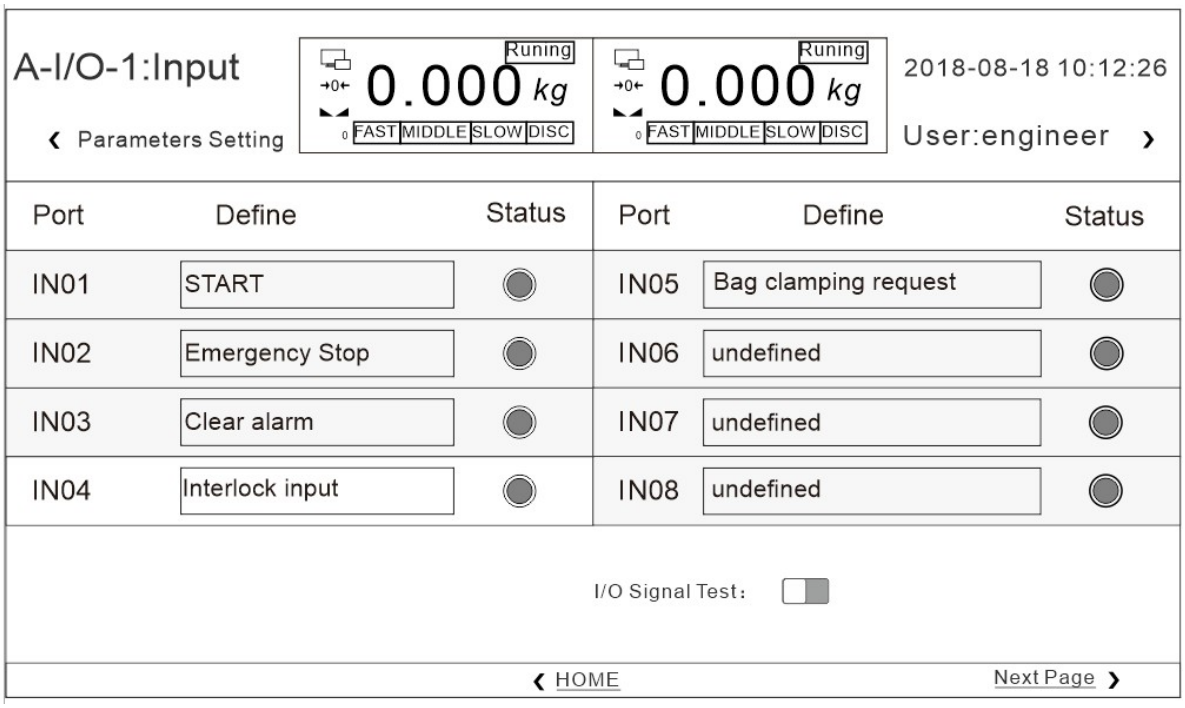
B. Place the bag or container prepared in advance at the unloading port, click "Manual unloading", unload all the materials in the hopper into the bag or container, weigh the

materials in the bag or container (pay attention to remove the weight of the bag or container).

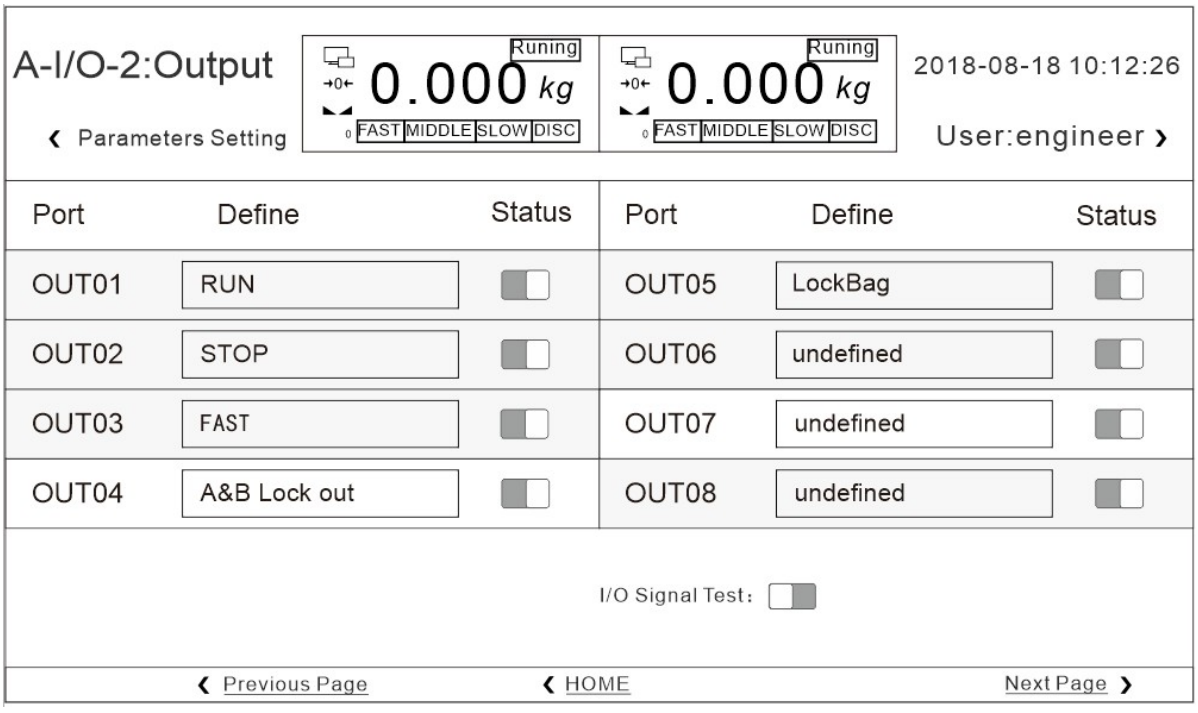
C. Click the input box of "Compound weight", enter the weight of the material obtained by the compound weight, and click "Material Calibration" for calibration. Wait until the calibration succeeds.After successful weight calibration is completed, exit the menu.

For specific operation methods, please refer to Chapter 7.1 "Operating Instructions for Buttons and Operation Boxes".

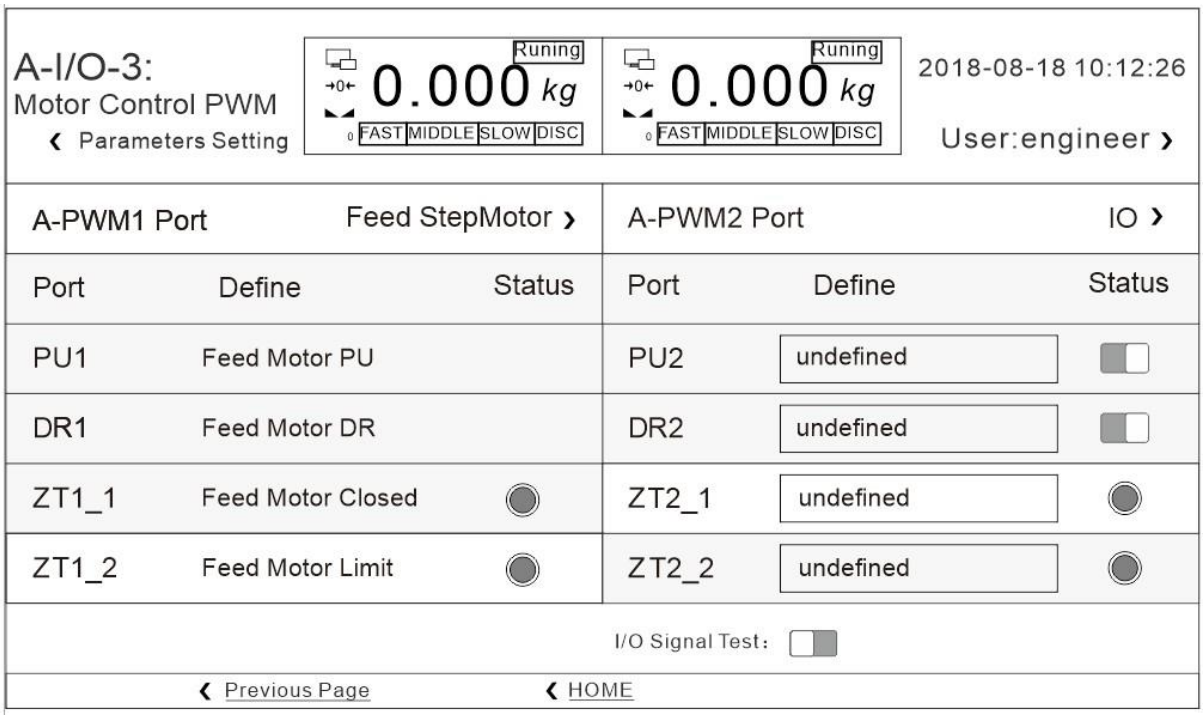
7.10 Description of switch quantity interface



Switching quantity 1 diagram



Switching quantity 2 diagram



Switching quantity 3 diagram

Parameter Description:

(1) Input ports (IN01, IN02, IN03, IN04, IN05, IN06, IN07, IN08) can be customized by customers:

(2) The input ports (ZT1_1, ZT1_2) are fixed as photoelectric signals for the motor in place; The input ports (ZT2_1, ZT2_2) are general-purpose switching values, where ZT2_ 1 has been set as servo alarm by default, ZT2_ 2 Customer customizable.

(3) The output ports (OUT01, OUT02, OUT03, OUT04, OUT5, OUT6, OUT7, OUT8) can be customized by the customer.

(4) The output ports (DR1, PU1) are direction signals and pulse signals of the motor; The output ports (DR2, PU2) are general-purpose switching values, where the default setting for DR2 is slow acceleration, and the default setting for PU2 is unloading.

(5) Switching value test: After being turned on, you can test whether the corresponding switching value signal is normal.

For specific operation methods, please refer to Chapter 7.1 "Operating Instructions for Buttons and Operation Boxes".

Input definition:

The port number	The initial value	Custom list

IN1	**1**	**I00: No definition** **I01:** start **I02: stop** **I03: stop** **I04:** Feeding **stepper motor origin (close the door to** A level) **I05: Feeding allowed** **I06:** Unloading **allowed** **I07: Clear alarm** **I08: keep** **I09: Open/close unloading door [originally manual unloading** Function, switch discharging output state] **I10: Manual unloading** **I11: Manual slow add** **I12: Manually add** **I13:** Manual **fast add [by fast open open** The door] **I14:** Manual **cleaning [open according to the maximum opening** The door] **I15: Start/stop (double edge: effective edge,** Start;Invalid edge, stop)
IN2	**2**	
IN3	**5**	
IN4	**6**	
IN5	**0**	
IN6	**0**	
IN7	**0**	
IN8	**0**	
ZT1_1	**4**	

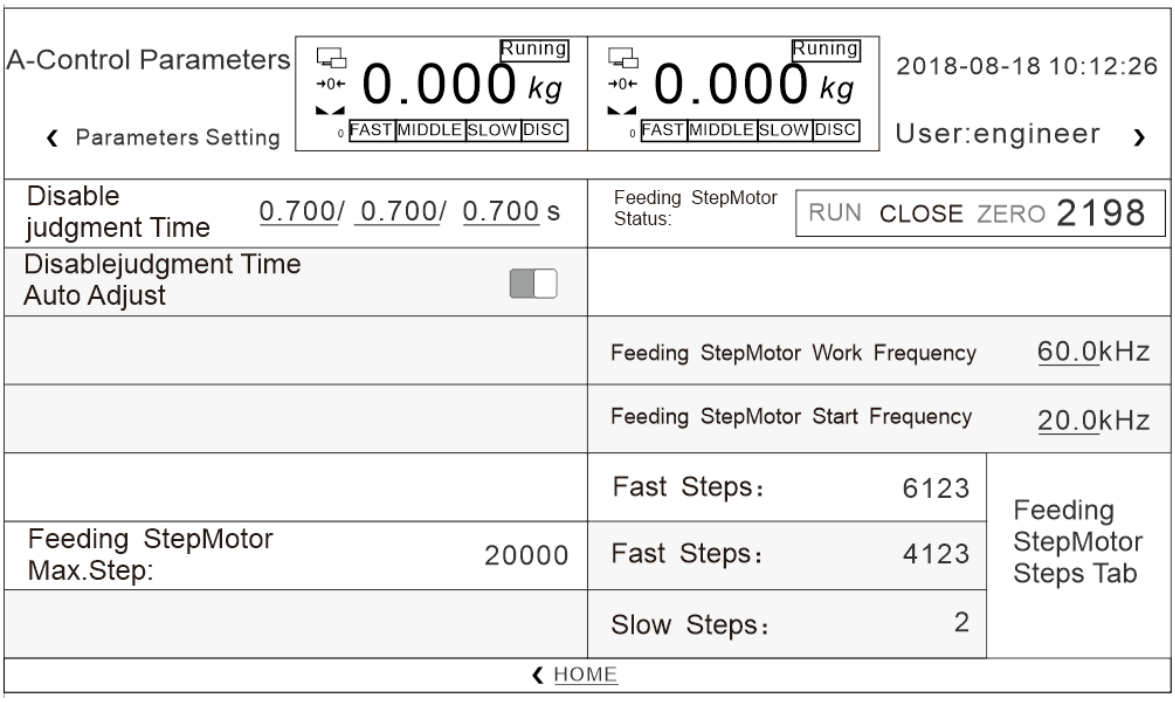
ZT1_2	**24**	**I16: Start/emergency stop (double edge)** **I17: Manual** unloading **(double edge)**
ZT2_1	**0**	**I18: Manual** slow **adding (double edge)** **I19: Manual adding (double edge)**
ZT2_2	**0**	**I20: Manual** quick **add (double edge)** **I21: Manual cleaning (double edge)** **I22: reset** **I23:** Emergency **stop [level](valid, no** Start allowed, manual feeding not allowed, not allowed Manual unloading is allowed) **I24: feeding stepping motor limit point.** **I25: Unloading** stepping **motor origin.** **I26: limit point of unloading stepping motor.** **I27: jam** **I28: Servo motor alarm** **I29:Double scale interlock input**

Output definition:

The port number	The initial value	Custom list
OUT1	**1**	**O00: No definition** **Run O01:** **O02: Refueling request** **O03: Feeding stepper motor direction [PW available** The signal is set to feed PWM] **O04: quick to add** **l add O05:** **O06: slow** **O07: fixed value** **O08: unloading L** **O09: over difference** **O10: alarm** **11: clip bag** **O12: Preset number of packets completed** **O13: Once packing is completed (unloading is** completed After output 1s clock) **O14: stop** **O15: direction of discharging stepper motor** **O16:** Discharging **motor running/forward** **O17: The** unloading **motor reverses** **O18: Feeding PWM[only available at OUT7/OUT8]**
OUT2	**4**	
OUT3	**5**	
OUT4	**6**	
OUT5	**7**	
OUT6	**0**	
OUT7	**0**	
OUT8	**0**	
DR1	**3**	
PU1	**0**	
DR2	**8**	
PU2	**0**	

		O19: Discharging PWM[only available at OUT7/OUT8] **O20: Servo motor alarm** **O21: Completion of setting value** **O22: Double scale interlock output**
PWM1 function	**1**	**1: general switching quantity** **2: feeding motor control** **3: unloading motor control**
PWM2 function	**0**	

7.11 Control Parameters screen Description



Interface specification

(1) Prohibition time for fast, medium, and slow acceleration: At the beginning of quantification, to avoid overshoot, weight judgment is not performed at this time. Fast acceleration, medium acceleration, and slow acceleration are always effective

(2) Slow acceleration intelligent prohibition switch: When this switch is turned on, the slow acceleration intelligent prohibition function is enabled.

(3) Motor Subdivision: Set value of motor subdivision.

(4) Reducer reduction ratio: The reduction ratio of the current reducer.

(5) Maximum angle of feeding gate: the maximum opening angle of the current feeding gate.

(6) Maximum opening degree of charging motor (pulse number): To protect the motor, the maximum opening degree allowed after starting the motor is allowed.

(7) Initial Opening Calibration Value: The calibration value of the current initial opening.

(8) Feeding motor status: four states can be seen: stop, open, origin, and opening.

(9) Feeding motor operating frequency: the frequency at which the feeding motor operates normally.

(10) Starting frequency of charging motor: the frequency at which the charging motor is started.

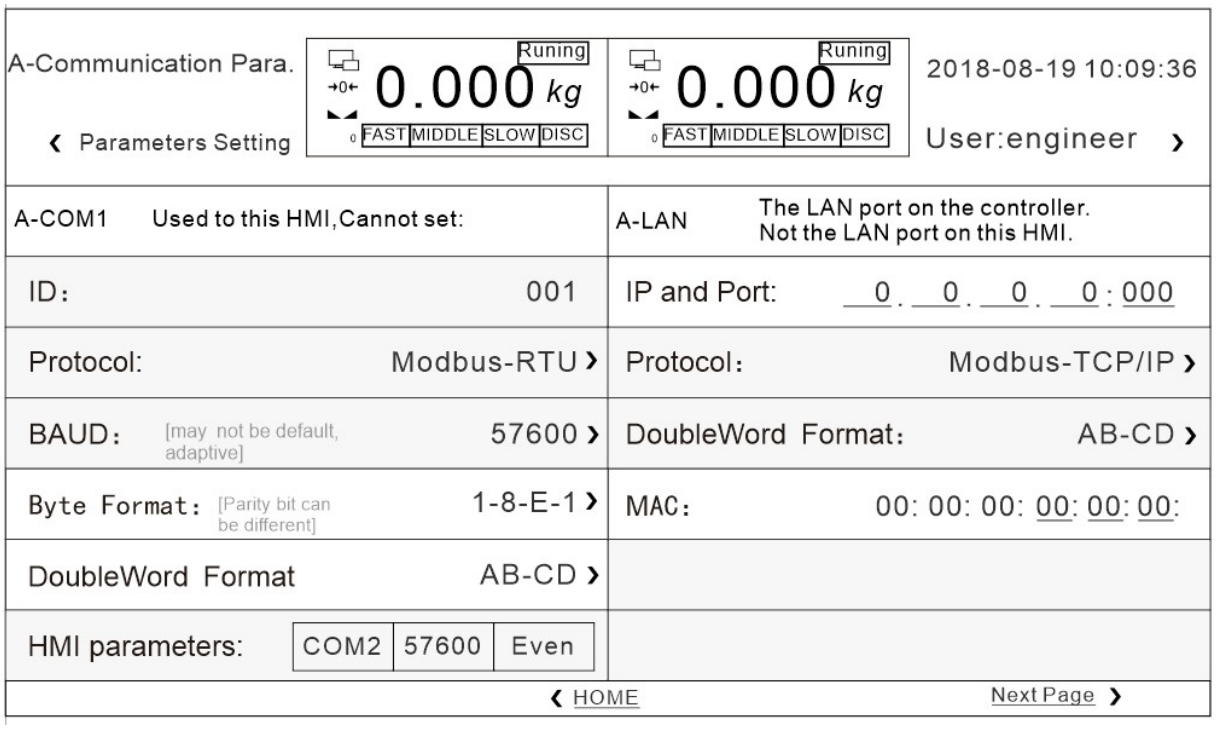
(11) Quick heater opening: the current fast heater opening value.

(12) Medium Plus Opening: The current medium plus opening value.

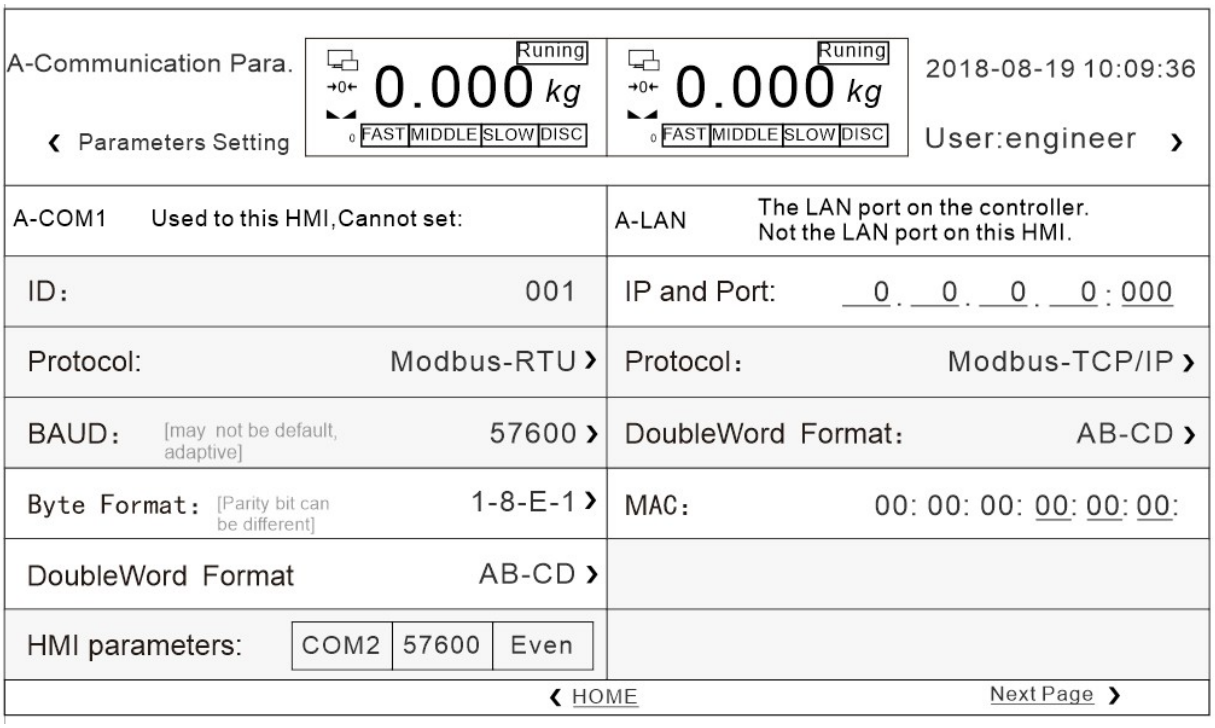
(13) Slow heater opening degree: the current slow heater opening degree value.

For specific operation methods, please refer to Chapter 7.1 "Operating Instructions for Buttons and Operation Boxes".

7.12 Communication Parameters screen description



Communication parameter 1 diagram



Communication parameter 2 diagram

Interface description:

(1) Address number: Slave number. The ID number of the serial communication

(2) Protocol Type: Communication protocol. Select the protocol for serial communication.

(3) Baud Rate: Select the baud rate of the serial port.

(4) Byte Format: Data format. Initial value; 1-8-E-1 (8-bit data bit-even parity - 1-bit stop bit;)

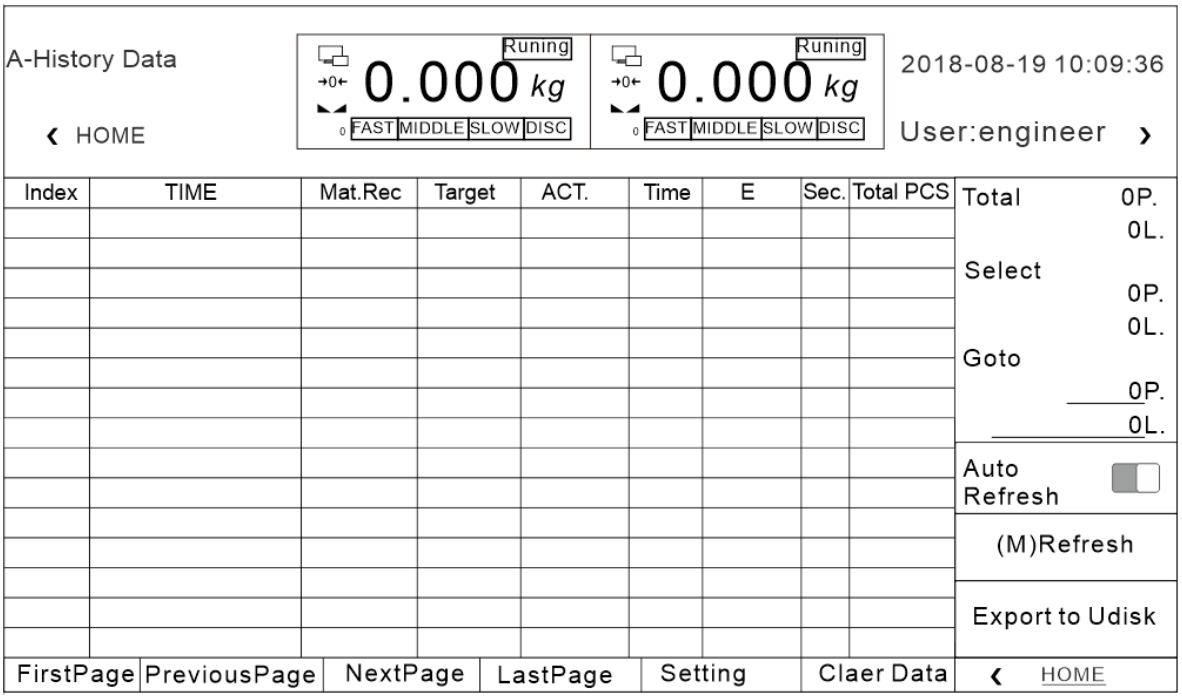
(5) Double word register order: Modbus high and low words The order in which high words come first is AB-CD, and the order in which low words come first is CDAB.

(6) Current HMI communication parameters: Displays the current communication parameters of the touch screen.

(7) IP and Port: IP address.

(8) MAC: MAC address.

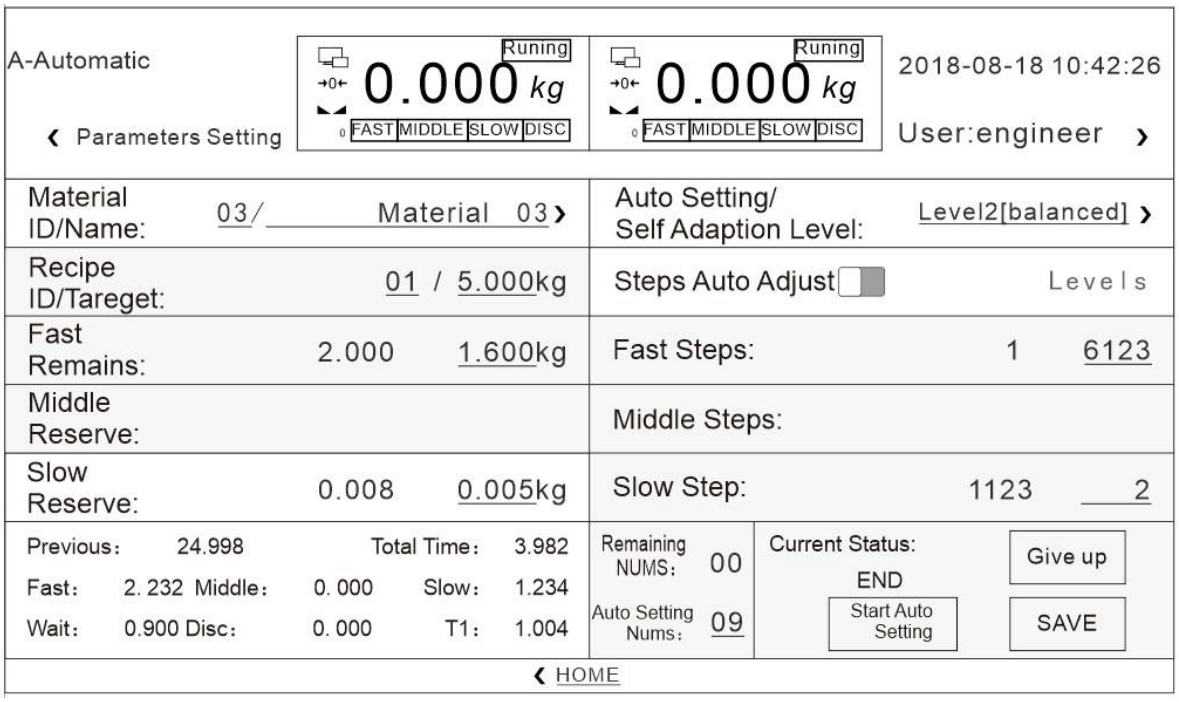
7.13 Historical data page description



Interface description:

（1）Automatic refresh/Manual refresh: Refreshes data.
（2）Usb disk export: You can export historical data.
（3）Clear data: Clear historical data.

7.14 Description of automatic balance adjustment interface



Interface description:

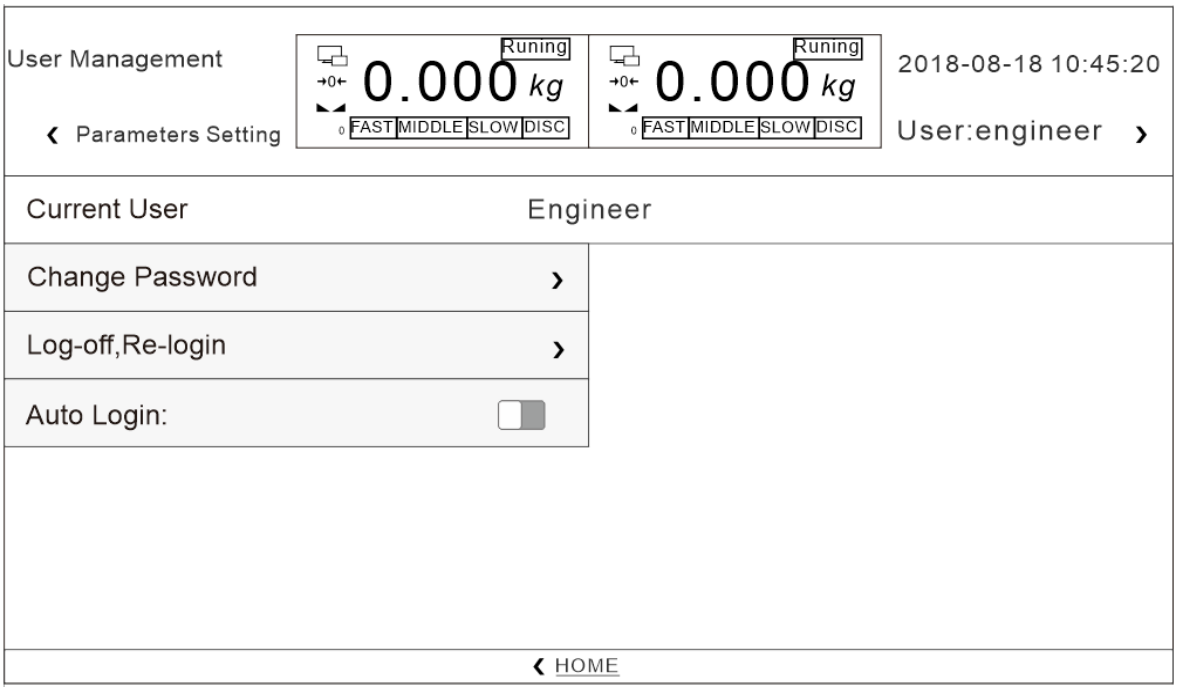
(1) Material No./Name: You can set the material number and name;
(2) Recipe Number/Target Value: Set the recipe number and target value;
(3) Adaptive&Automatic Scaling Level: There are four levels in total, with Level 0 being the fastest, and the higher the level, the slower the speed;
(4) Automatic adjustment of opening: automatic adjustment function switch for the opening of the feeding door;
(5) Feeding Level: Two or three levels of feeding, automatically set by the system based on the target value;
(6) Quick charging opening: the opening of the fast charging door.
(7) Medium feeding opening: the opening of the medium feeding door.
(8) Slow feeding opening: the opening of the slow feeding door.
(9) Scale adjustment times: You can set the scale adjustment times.

Automatic weighing steps and description

Schedule and the opening is divided into two columns, as shown in the above, in front of its value for the automatic tuning weigh the value of the former at the back of the numerical value for automatic adjustment scale, users only need to set the number of scales (range 3-10), click on "start adjustment scale" can be in the process of automatic adjustment scale, equipment according to set automatically adjustable scale level automatically adjustable scale, At the same time, users can choose to save or abandon the adjusted value of automatic balancing according to the adjustment value of automatic balancing. Save the adjusted value of automatic balancing into the current formula. If you give up, the value before automatic balancing will still be used.If the balance adjustment

fails to meet the requirements of the user after completion, the customer can start the automatic balance adjustment again, and the equipment will adjust and modify again on the basis of the completion of the last balance adjustment.Users can also manually modify the lead and opening parameters.

7.15 Describes the user management interface



Interface description:

Displays the current logged-in user, can change password and set automatic logged-in.

The user level of this system is divided into four levels, from high to low: reserved user (used by manufacturers), engineer, administrator and operator.

The cancellation

After a user logs in, to log out or switch to another user, click User Logout→

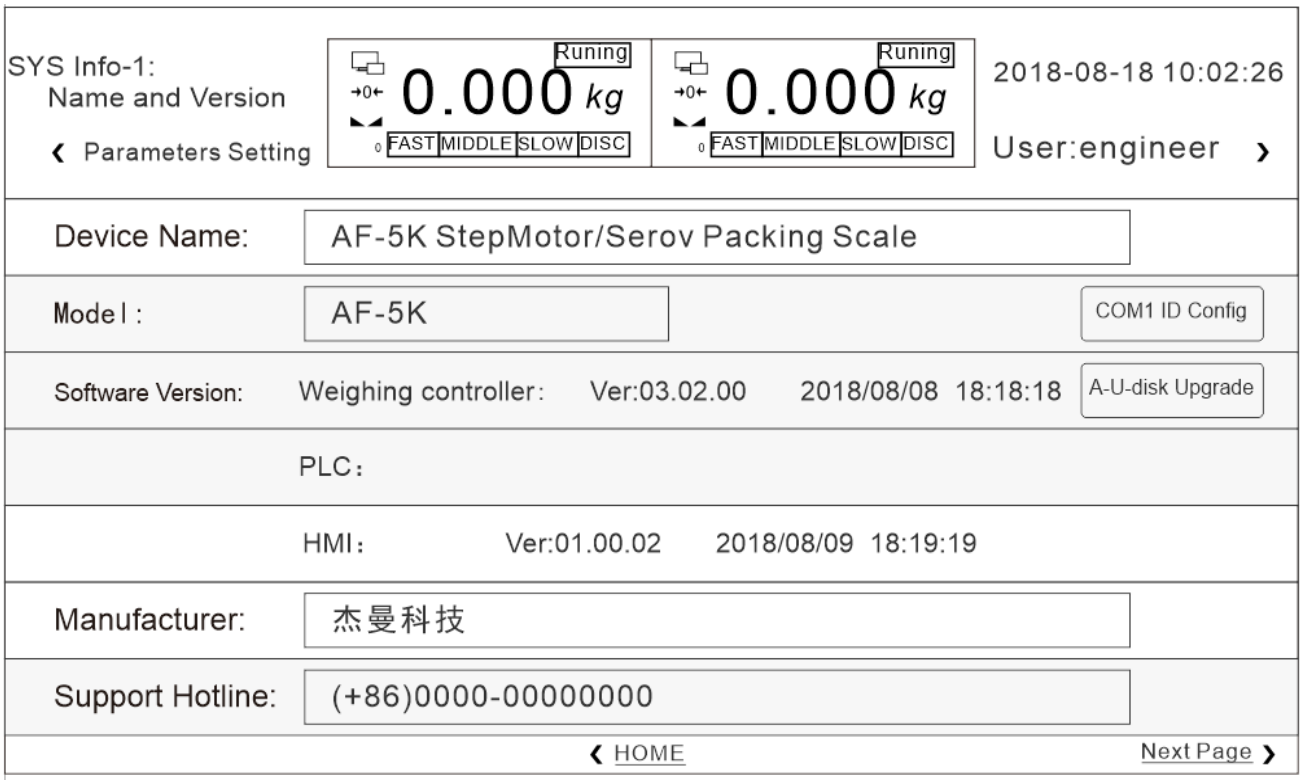
To switch a user, log out of the user management page and enter the user ID and password on the login page

Change the password

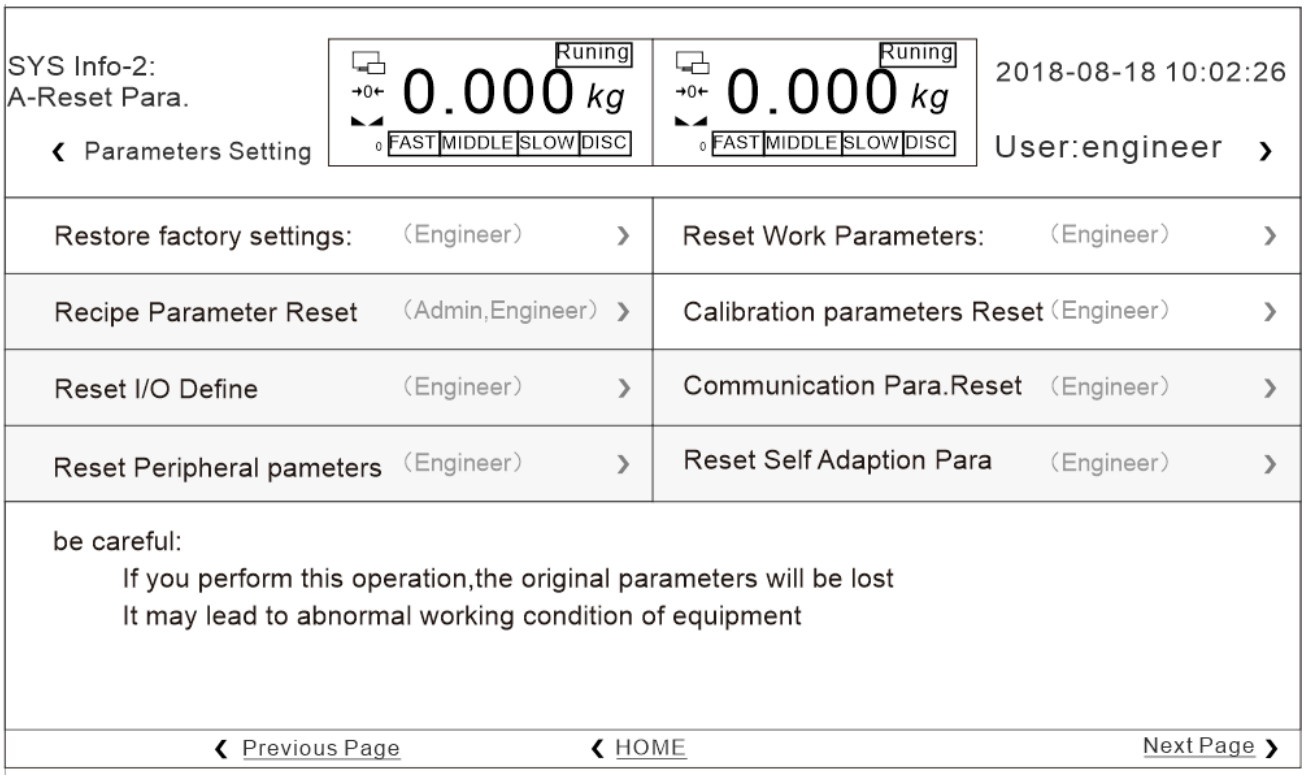
Path: parameter setting, user management, password modification, click on the password input box, and follow the prompts

For specific operation methods, please refer to Chapter 7.1 "Operating Instructions for Buttons and Operation Boxes".

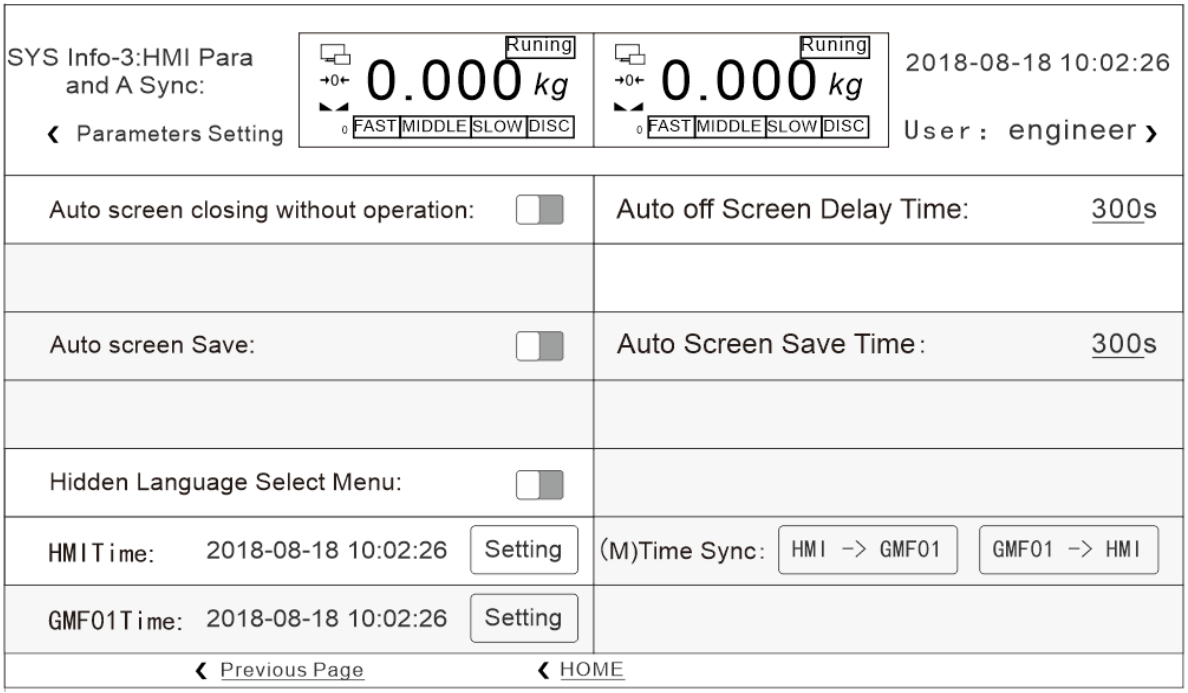
7.16 System information interface description



System information 1 figure



System information 2 figure



System information 3 figure

Interface description:

System information 1 Shows the device information diagram.You can see the device name, model number, software version, manufacturer, technical support number, and so on.

System info 2 shows the restoration of factory Settings.Engineers and reserved users can reset all parameters.Specific instructions are as follows:

Restore factory Settings - Reset all system parameters to their default Settings.

Operating parameter reset - Resets basic system parameters to their default Settings.

Calibration parameter reset - Reset system calibration parameters to their default Settings.

Recipe parameter Reset - Resets system recipe parameters to their default Settings.

Peripheral parameter reset - Resets system peripheral parameters to their default Settings.

Adaptive parameter Reset - Resets system adaptive parameters to default Settings.

Communication parameter reset - Resets system communication parameters to default Settings.

Switch quantity definition reset - Reset the system switch quantity definition to the default configuration.

System info 3 The screen setting diagram is shown.Engineers can set the parameters of the touch screen.

Usb disk upgrade system:

This operation is very important and cannot be performed unless necessary.If the operation is necessary, please contact the company and complete under the guidance of professional personnel.

8. Basic Function description

8.1 Basic running process

After the external input running signal is effective, the equipment enters the running state and begins the automatic quantitative process.The specific process is as follows:

1. Judgment before starting, whether the target value is set reasonably, whether the size of the feeding door needs to be adjusted, etc.
2. Delay time before starting feeding.
3. If the self-adaptive function is turned on, judge whether self-learning is needed again (if the current formula does not have fast increase lead amount and fall value parameters, self-learning needs to be restarted); otherwise, feed directly according to the current formula parameters.The following describes the process after the adaptive function is enabled
4. If the adaptive function is turned on, the first scale learns the approximate fast increase and drop value.
5. Start feeding normally from the second scale, and according to the feeding results of each scale, the controller will calculate automatically to judge whether the fast adding value and the drop value are appropriate and make automatic correction.
6. Start the fixed hold time after feeding.
7. Record the current weight value as the result of the scale after the fixed holding time.
8. If the overcurrent and undercurrent detection switch is turned on, the overcurrent and undercurrent detection function is processed.
9. Judge the bag input signal is effective, then output unloading.
10. When the unloading time is up, close the unloading output and start the loosening bag to delay the loosening bag.
11. After the completion of a basic packaging process, proceed to the next packaging process and start the delay time before feeding.

8.2 Overage and underage detection function

After the over-under-difference switch is opened and the feeding is completed during operation, the current feeding result is judged after the fixed holding time ends:

Target value - underdifference value ≤ feeding result ≤ target value + out-of-tolerance value, then judged as qualified.

Feeding result > target value + overerror value, then judged as overerror, output overerror alarm signal.

If the feeding result is less than the target value - underdifference value, it is judged as underdifference, and the over-underdifference alarm signal is output.

When the overgap occurs, if the overgap suspension switch is opened, the controller will temporarily schedule the packaging operation, prompting the overgap suspension and waiting for the user to process. The user can input the clear alarm signal to continue the

packaging operation, or input the emergency stop signal to enter the stop state and stop the packaging operation.

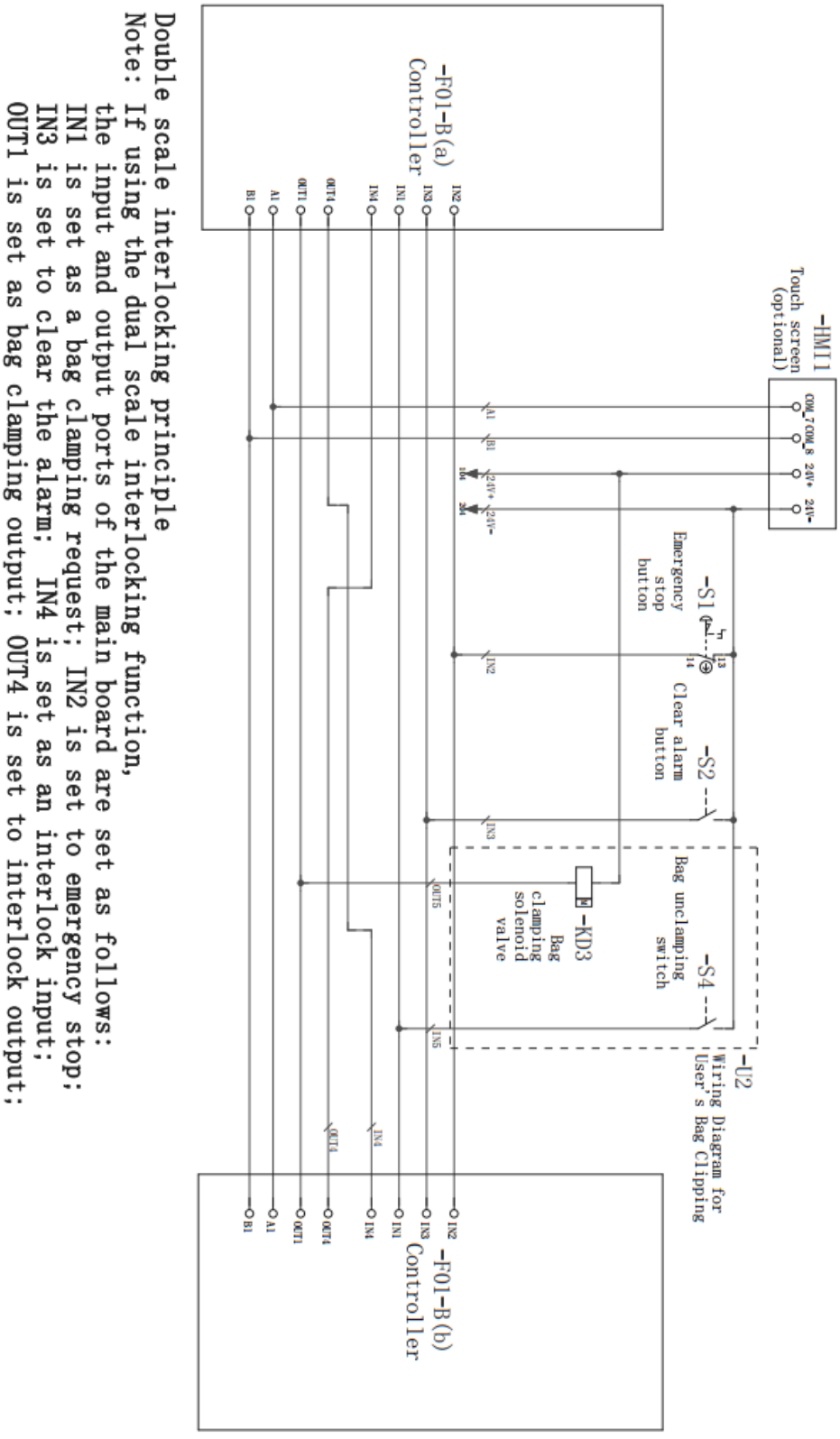
8.3 Overage and underage detection function

1. After setting the AB scale, the unloading delay time, and the on-off signal, it defaults to the dual scale mode.

2. After the external input operation signal is valid, the device enters the operation state.

3. Judge whether the bag clamping signal is valid. In the dual scale mode, Scale A responds to the bag clamping and unloads the material. At the same time, it will output an interlock signal to Scale B, and then Scale B will automatically cancel the bag clamping request (here is an example).

4. After completing a basic packaging process, proceed to the next packaging process.



Schematic Diagram of Double Scale Interlock

9. Common failure analysis and troubleshooting

Common faults in use, causes and handling methods.

The serial number	The fault phenomenon	fault	To deal with
1	Equipment start does not fall material	1. No material in storage bin 2. Storage bin stop door is not opened 3. Air source leakage connection 4. Air source pressure is too low or no pressure	1. Add material to storage bin 2. Open the storage bin stop door 3. Connect the air source 4. Increase air pressure or turn on air pressure switch
2	No unloading after weighing	1. The device cannot receive the bagging signal 2. The number of combinations of single scales is not set to 0	1. Check and eliminate 2. Set the corresponding combination times as required
3	The actual weighing has been out of tolerance	1.Equipment not calibrated 1. Fast increase the time limit setting is too large	1. To a scale 2. Fast increase the time limit appropriately reduced
4	The value is unstable	1.Strong winds or strong vibrations in the surrounding environment 2.Weight sensor failure	1.Check and eliminate 2.Check the sensor and replace if necessary
5	The weight is not up to standard	1.Weight sensor failure 2.Not cleared before use 3.Equipment not calibrated 4.Incomplete unloading	1.Check the sensor and replace if necessary 2.Stop reset 3.recalibrate 4.Increase discharge time appropriately

6	Data cannot be exported	1.U disk is damaged 2.The USB interface of the electrical control box is damaged	1.Replace the U disk 2.Check the interface

10. Maintenance and warranty

To ensure the weighing accuracy of the equipment, do not place the equipment in a cold and damp environment. Clean the dust generated by materials inside the equipment regularly according to the use condition. Remember to close the door of the electric control cabinet after daily use or maintenance.

● Warranty principle

In principle, the first installation and debugging should be carried out by our professional and technical personnel or companies entrusted by our company.

Equipment failure caused by the following conditions is not covered by our warranty:

- Do not follow the operation instructions
- Installation without professional guidance
- Make structural changes to the equipment
- Unauthorized damage to equipment
- Programming and operation errors
- Natural equipment damage