



AF-01K II

Vertical packaging machine

Operating instruction

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Ver A0

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

1. overview

AF-01KII. vertical packaging machine is composed of automatic quantitative unit and packaging machine, is a high-speed and high-precision packaging equipment designed for the quantitative packaging of small packets of granular materials, suitable for quantitative packaging of granular materials, the automatic quantitative unit is a double scale structure, and the operation of alternate discharging at the same time, the feeding mechanism adopts the "motor + vibration feeder" method to achieve multi-stage feeding, and the discharging is a cylinder drive mode to achieve rapid discharging. The packaging adopts a vertical packaging machine to achieve fully automatic weighing and packaging. It is suitable for a variety of different materials: rice, millet, beans and other foods. From the perspective of improving production efficiency and quality, and reducing production costs, it can replace combination scales and volumetric equipment. Provide stable and efficient packaging solutions for the small packaging market.

1.1 Product parameters, functions and features

1.1.1 Product parameters

model	AF-1KII	GM320
Electrical source	AC220V \pm 10%, 50/60Hz, 400W	AC220V \pm 10%, 50/60Hz, 3000W
The quantitative range	0.05~1kg	-
The weighing accuracy*	\pm 2g	-
Weighing speed*	\geq 3600pcs/hour	
Metering bucket volume	2.8L*2	-
Width of the packaging film	-	280mm (Can be customized)
Bag width	-	130mm (Can be customized)
Bag length	-	80-220mm (Can be customized)
Packaging coding method	-	Copper code (optional thermal transfer coding or laser coding)
Working temperature	0~40°C	

Maximum humidity	90% OF R.H is not dewy
Gas source	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. Two material speed (free blanking + vibration feeding) feeding control.Ultra-high-speed quantitation.
3. Automatic zero clearing function.
4. Automatic correction function of process control parameters.
5. Accumulative and statistical functions.
6. Packaging can be automatically coded (date of manufacture)
7. The bag length is available with cut-to-length control and color scale control.

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. Easy to operate: Standard touch screen (7 inches/10 inches optional), displayed in both Chinese and English..
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.
7. Convenient external connection: After the internal interlock of the automatic dosing unit, it is interconnected with the packaging machine through the switch, and there is no need for external PLC coordination logic.
8. The machine has the characteristics of good sealing, clear and fast sealing, compact structure, stable operation and low noise.

1.2 Working principle

When the equipment is started, the vertical packaging machine below enters the preheating preparation state, and the automatic quantitative unit above will enter the delay before feeding, and then enter the two-speed feeding process of the equipment, namely: fast and slow feeding, and the switching of each speed feeding takes the corresponding advance amount in the formula as the control cut-off point, and in order to avoid the impact of overshoot on the measurement, the corresponding prohibition judgment time is set; After the end of feeding, enter the setting process, the setting time can be set, after the end of the setting, the equipment outputs the "setting value completed" signal through the switch; The switching quantity defines the discharging allow, then when the packaging scale receives the effective switching signal of the vertical packaging machine "discharging allowing", the equipment will open the discharging door, and the unloading has two modes of zero zone delayed unloading and time control unloading, when the unloading mode is zero zone delayed unloading and the weight of the material in the metering hopper is lower than the previously set zero zone value, it will enter the delayed state after unloading to the zero zone, and then the equipment will close the unloading door to complete a quantitative process, at this time, the packaging scale will output the "one package completed" signal to the vertical packaging machine, After receiving this signal, the vertical packaging machine will carry out a package sealing action. And so on and so forth.

1.3 Main purpose and scope of application

AF-01KII. vertical packaging machine is mainly suitable for quantitative packaging of granular materials, with a packaging range of 0.5-1kg.

2. Precautions for safe use

Warning: Please read the following safety precautions carefully before use. In order to avoid compromising the personal safety of you and others, as well as the safety of your device, please use your device safely and correctly. The Company will not be held liable for any personal injury or material damage caused by the user's violation of the following items!

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

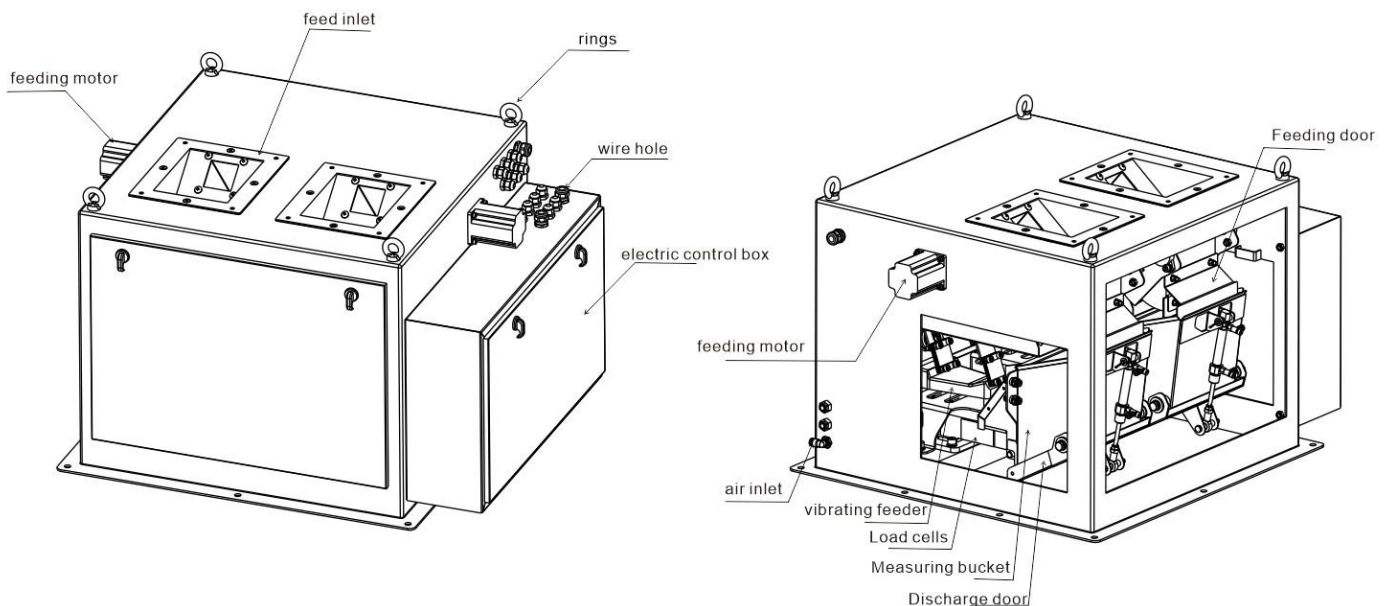
1. In order to avoid dangerous accidents, only one person is allowed to operate the machine.

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. Before the machine is running, it is necessary to check whether there are irrelevant objects in the moving parts such as the work table, conveyor belt and sealing knife holder, and it is forbidden to place tools or sundries.
6. Before the machine runs, please close the safety door of the equipment. During the operation of the machine, it is strictly forbidden to approach or touch any part of the body to the running parts. Do not put your hands or tools into the sealing knife holder. Failure to do so may result in significant bodily injury.
7. In case of any danger, click the "emergency stop" button on the main interface or disconnect the main power supply immediately.
8. 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.
9. Wear safety helmets and other protective devices when maintaining equipment, especially when entering the packaging area.

3. Product installation and transportation protection

3.1 The overall appearance and mechanism of the product are introduced

3.1.1 Automatic dosing unit



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:

Lifting ring: used for lifting during equipment installation.

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

Feeding motor: the main function of weighing is to control the feed quantity.

Vibration feeder: the main function of weighing is to control the amount of feed.

Measuring bucket: temporarily store the materials to be weighed quantitatively weighing materials and unloading.

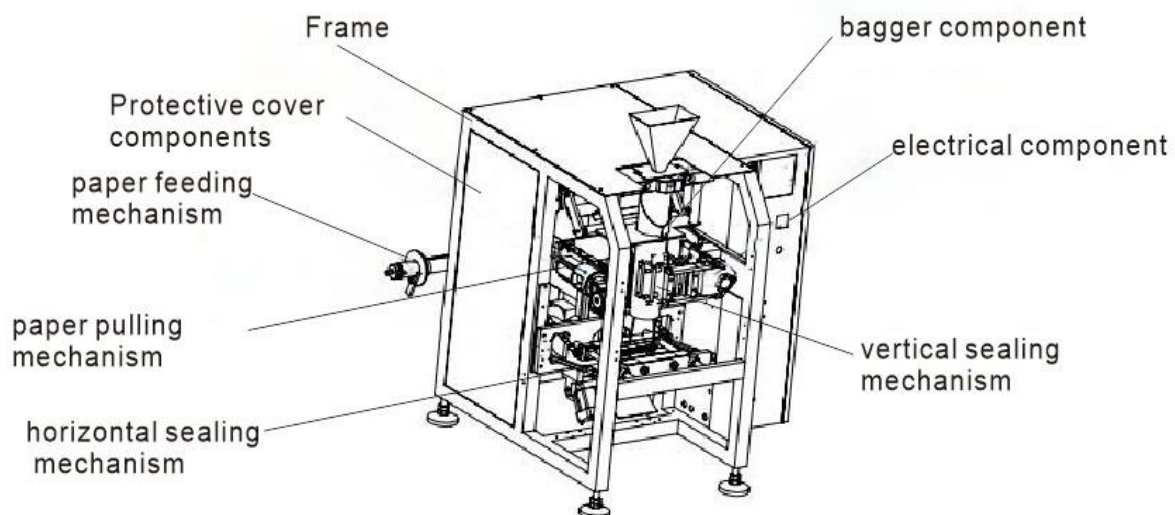
Discharge port: the material after quantitative weighing is discharged and transferred to the next process.

Electrical control box: built-in circuit board and external signal connection, I/O control connection and power connection.

Load cell: Weigh the material in the metering hopper.

Feeding door: The material to be weighed quantitatively enters the metering hopper.

3.1.2 Packing machine



Mg320 series vertical automatic packaging machine is a vertical bag forming filling sealing multifunctional packaging machine. It is mainly composed of frame , horizontal

sealing mechanism, vertical sealing mechanism, paper pulling mechanism, paper feeding mechanism, bagger component Protective cover components, and electrical component, as shown in Figure 1:

Frame:The frame is the base part of the packaging machine, and all other mechanisms and components are installed on the frame.

horizontal sealing mechanism:The horizontal sealing mechanism is a slider mechanism, driven by the cylinder, the front and back knife seats move relative to each other to complete the cross sealing. The film is pulled through the servo-driven cross seal by the cross seal clamping the packaging film up and down to complete the film pulling

vertical sealing mechanism: The left tool holder of the middle seal is a fixed one, and the right one is a movable one. During packaging, the air cylinder drives the right tool holder to move, and through the cooperation of the left knife seat, the middle sealing action is completed, and the packaging film forms a cylindrical bag.

paper pulling mechanism: The paper drawing mechanism conveys the formed cylindrical bags one bag length at a time through the friction between the timing belt and the barrel wall.

paper feeding mechanism: Film coding or code spraying, color code, photoelectric sensor detection and tracking are carried out here to supply packaging film to bagger components.

bagger component: The bag forming part of the film forms a cylinder shape through a collar bag forming device.

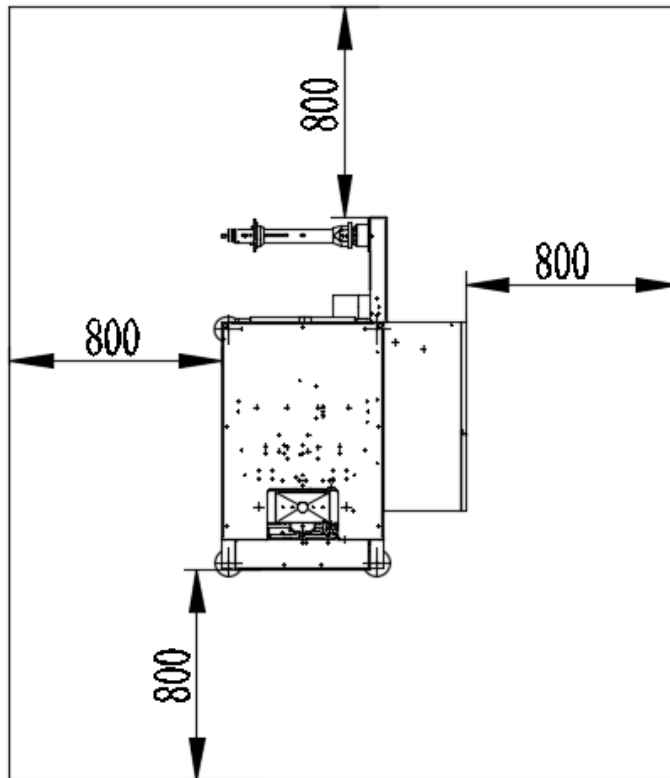
Protective cover components: This part is a part that provides safety protection to prevent damage to personnel and machine during machine operation.

electrical component: The electrical parts are used to control and coordinate the film feeding, bag forming, longitudinal sealing, transverse sealing and blanking, so that the machine can complete the packaging work according to the technological process.

3.2 The installation conditions

3.2.1 Equipment installation basis and installation conditions

1. Temperature: $-10\sim 40^{\circ}\text{C}$
2. Humidity: not more than 90% R.H.
3. Power supply: AC110~260V, 50Hz/60Hz, about 400W.
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
9. The on-site installation site must meet the following dimensional requirements.



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.

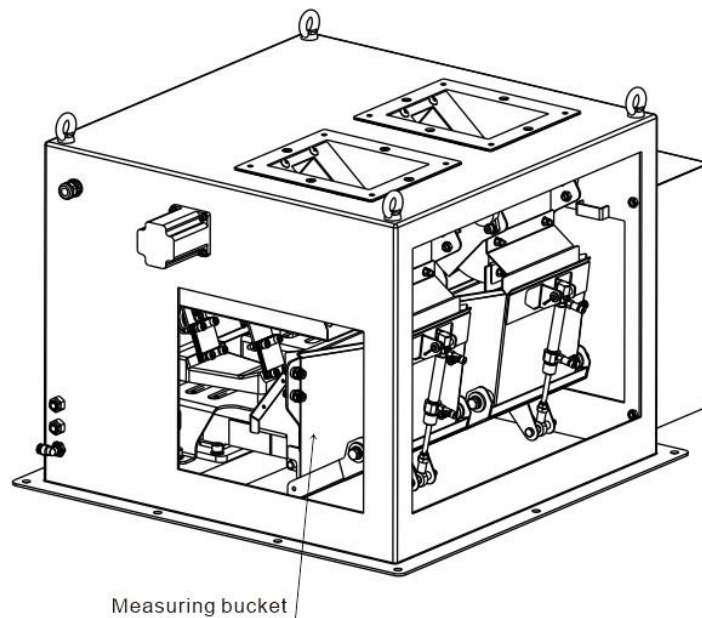
3.4 Product packaging and transportation protection

3.4.1 Packaging requirements

1. Packed in wooden cases, stackable in two layers, GB/T4857.3 Basic test for transport packages, static load stacking test method.

2GB/T4857.7 Transport package basic test, sinusoidal vibration (constant frequency) test method.

3.4.2 Transport protection



1. Before transportation, The Metering buckets shown in the figure is removed and fixed inside the wooden box.
2. The lower flange mouth of the equipment is used to fix the equipment to the wooden transport box with nuts
3. The appearance of the device wrapped by winding film

3.4.3 Requirements for equipment installation and maintenance

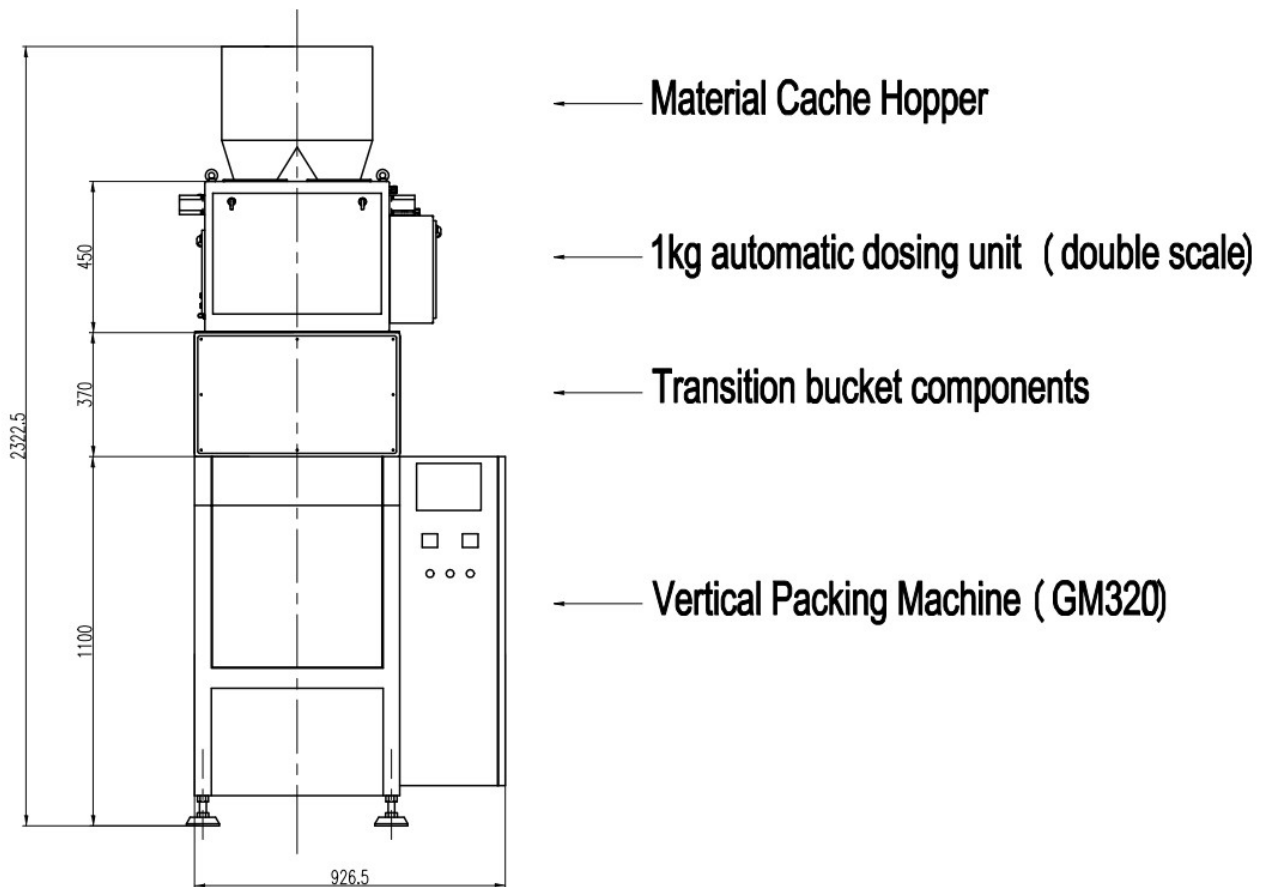
1.The operator must accept the company's skill training and safety education, and hold a work permit.

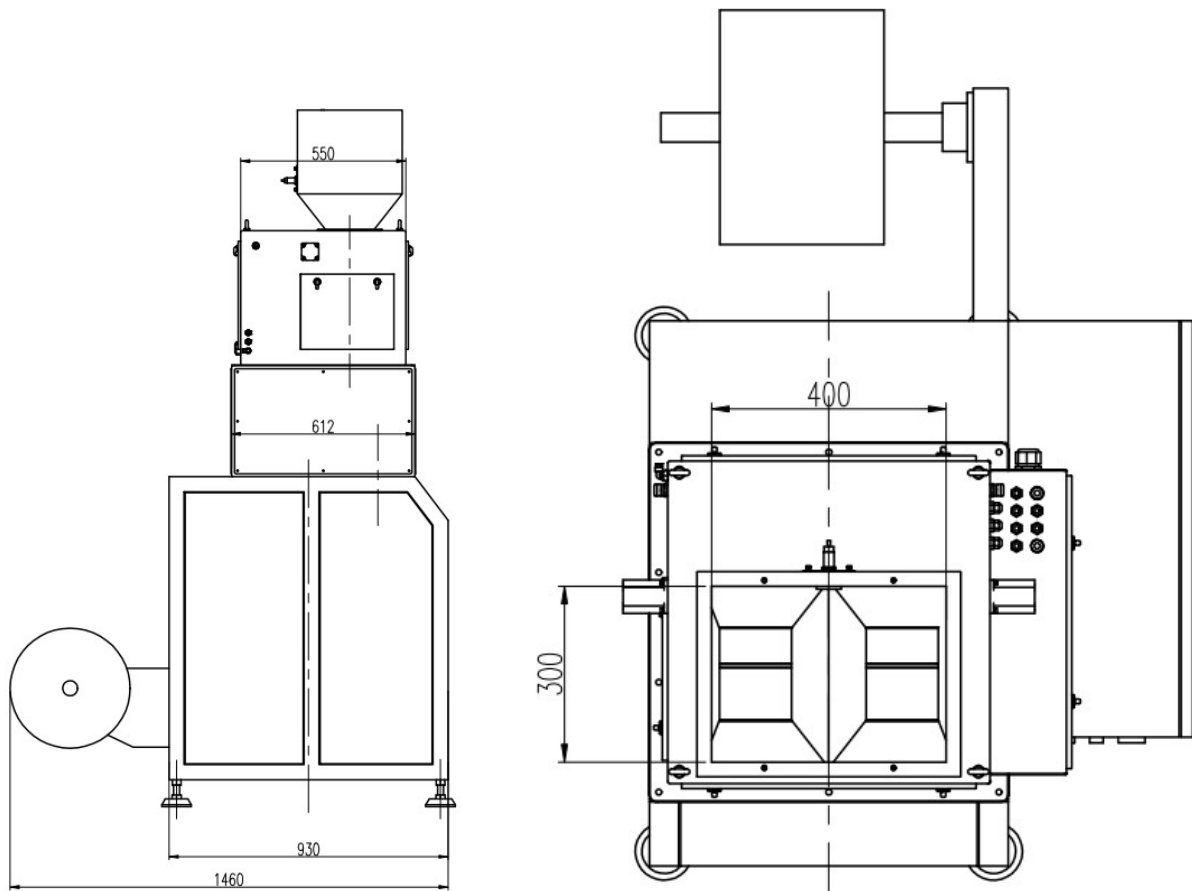
2.The personnel responsible for operating the machine must read and fully understand the operation manual.

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

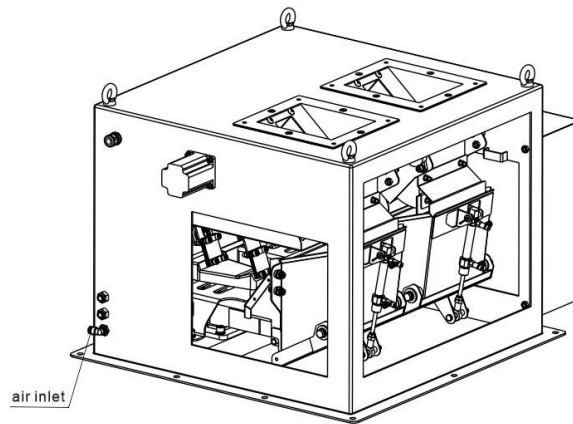
Product size unit: mm





5. Electrical connections

5.1 Air supply connection

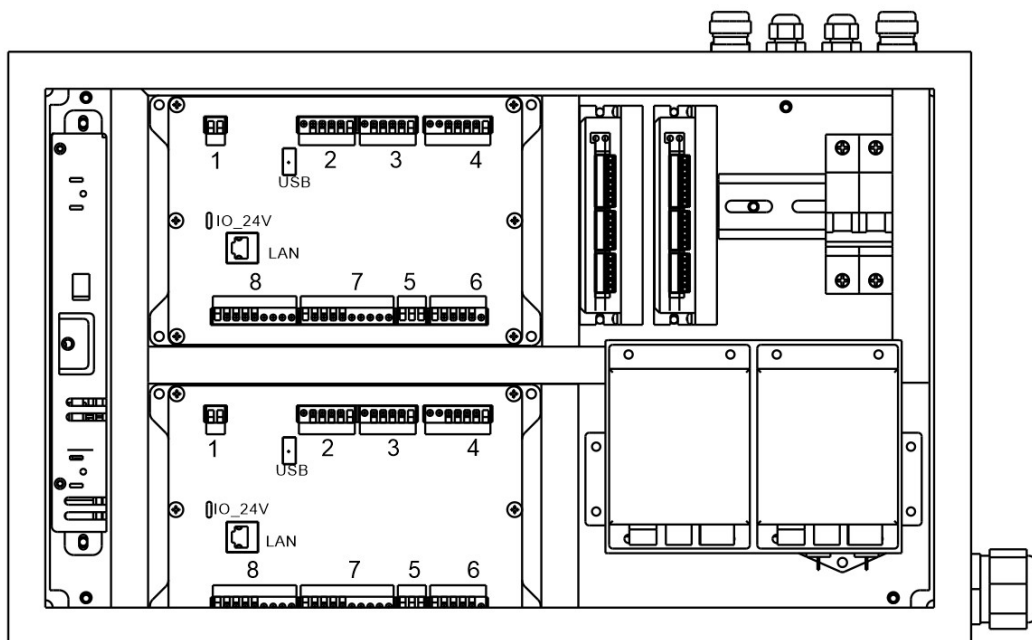


Air source inlet $\phi 6$ air pipe, air source standard: 0.4~ 0.6mpa 2m³/h

5.2 Electrical 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

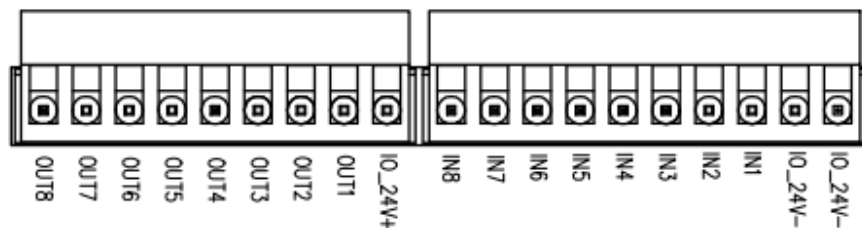
- 1: Power cord port, 24V power port of the instrument (24V+, 24V -).
- 2: Motor control port 1, (M1_24V+: 24V positive, M1_24V -: 24V negative, PU1: pulse, DR1: direction, ZT1_1: origin detection input, ZT1_2: feeding door opening limit), can also be used as a common IO port, currently used for feeding motor control.
- 3: Motor control port 2, currently used as a common IO port. The function can be customized, and the specific function can be found in the switching definition interface.
- 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 port, 8 customizable switch input interfaces (IN1, IN2, IN3, IN4, IN5, IN6, IN7, IN8), valid for low level, where IN4 has been set as interlock input, IN5 has been set as discharge allowed, and the definition of each other port can be selected by oneself..
- 8: Output ports, 8 customizable switch output interfaces (OUT1, OUT 2, OUT 3, OUT 4, OUT 5, OUT 6, OUT 7, OUT 8), where OUT4 has been set as interlock output, OUT5 has been set as one-time packaging completion, and the definition of each other port can be selected by oneself.

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

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

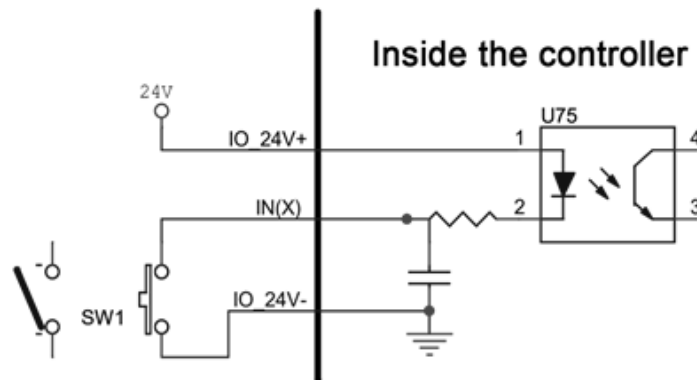
IO-24V: Internal use.

5.2.2 Switching value interface wiring description

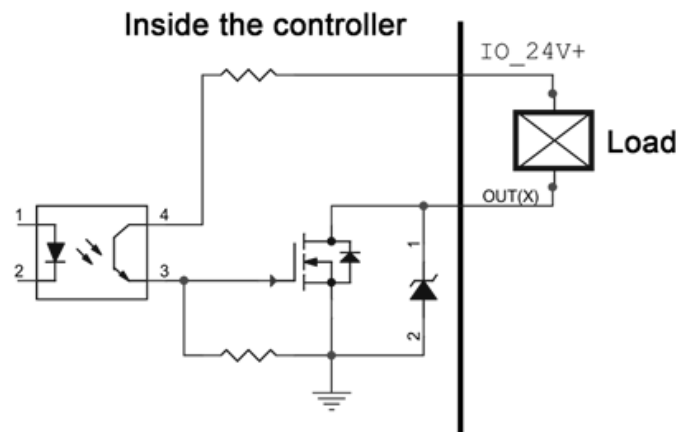


Switching value interface diagram

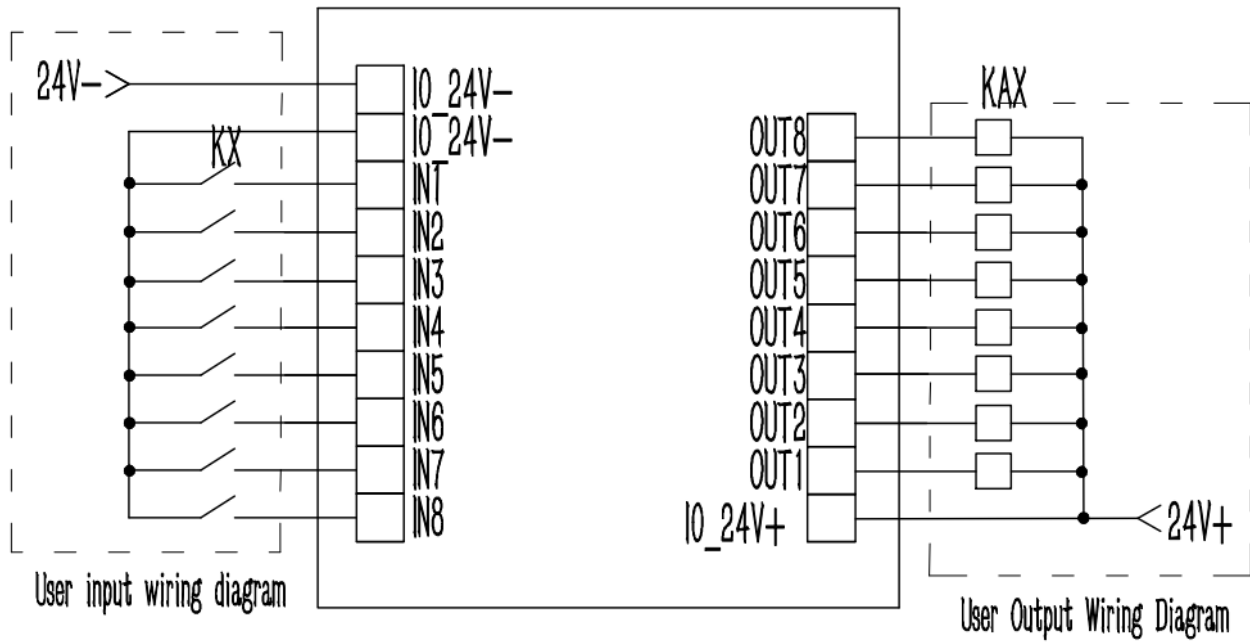
The switching value adopts photoelectric isolation method. If users need to use a switching interface, they need to provide and connect to a DC24V power supply. Switching value input is valid at low level; The output adopts the transistor collector open circuit output mode, and each drive current can 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: Feeding motor alarm 20: Discharging 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		

40010	00009	The default package number	Initial value: 0. The value ranges from 0 to 99999
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 ... 40030	00014 ... 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 ... 40050	00037 ... 00049	The reserved	
40051	00050	Package formula number	Formula number and target value when "packing result weight" is generated,

40052	00051	Package target value	Manual unloading, also do a result save, but the formula number is equal to 0
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	Fixed time (slow plus end to Discharging start)	
40069	00068		
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		
40051~40084: It is possible to monitor the positive jump of the "once packaged" (4005.02) bit variable, and run the bit variable (4004.00) equal to 1 to identify register updates in this region			
The following contents are readable and writable (Write a single register function code is 0x06, write multiple registers function code is 0x10, read function code is 0x03)			
Calibration parameters			
40101	00100	The zero calibration	Write 1 to mark zero; read returns 0
40102	00101		
40103	00102	There is weight gain calibration (Input weight)	The value ranges from 0 to 999999, expressed in grams
40104	00103		

40105	00104	Material gain calibration (note	Input 1 to record the gain AD code, and read returns 0	
40106	00105	Record current AD code)		
40107	00106	Material gain calibration	The value ranges from 0 to 999999, expressed in grams	
40108	00107	(Input weight)		
40109	00108	Absolute Millivolt (read only)	Default 3 decimal points, unit: millivolt If the value is 12345, it means 12.345	
40110	00109			
40111	00110	Gain millivolts (read only)	Default 3 decimal points, unit: millivolt If the value is 12345, it means 12.345	
40112	00111			
40113	00112	Calibration result information (read only)	The	instructions
			0	There is no information
			1	Calibration is successful
			2	The current sensor voltage is unstable
			3	Input weight is not reasonable
			4	The current sensor voltage is too high
			5	The current sensor voltage is too low
			6	Excessive calibration resolution

			<p>The alarm message will be automatically eliminated after 2 seconds. Before elimination, no</p> <p>Allow to calibrate again</p>
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	<p>If the device model is AF-5K, the initial value is 10000</p> <p>If the device model is AF-10K, the initial value is 20000</p> <p>The value ranges from 1 to 999999, expressed in grams</p>
40205	00204		
40206	00205	OFL indicates the type	<p>Initial values: 0,</p> <p>0:[maximum range + 9D] display OFL;</p> <p>1:[maximum range *120%] to display OFL;</p> <p>2:[maximum range *150%] to display OFL</p>
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	<p>Initial values: 0,</p> <p>0: only alarm, lasts 1S, give up zero clearance this time, clear again next time;</p> <p>1: only alarm, lasts 1S, give up zero clearance this time, clear again next time, connect</p>

			<p>Unable to reset three times, return to stop state!Continue to report to the police</p> <p>2: alarm, but continue to wait for stability, once stable, eliminate the alarm,</p> <p>Automatically continue to run;</p> <p>3: alarm, immediately return to stop state.</p>
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	<p>Initial value: 0,0: pneumatic, 1: unidirectional general motor,</p> <p>2: common motor bidirectional, 3: one-way stepping motor</p>

40225	00224	Unloading working mode	<p>0: timing mode, discharging signal output continuous discharging time (formula</p> <p>Parameter) is turned off. Discharging abnormal after discharging</p> <p>Judge;</p> <p>1: Judge zero zone mode, signal output, until the weight is below zero zone</p> <p>Value, and then start unloading delay time, when the time is up, close unloading</p> <p>After entering the discharging delay, there is no need to distinguish the weight.</p>
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	<p>0: automatically loosens the bag after unloading. 1: automatically loosens the bag after unloading</p> <p>Manual loose bag</p>
40229	00228	Discriminant mode of feeding allowance	<p>0: judge only when start feeding, no longer judge during feeding;1:</p> <p>Keep judging during feeding.</p>
40230	00229	Allowable discharging discriminant mode	<p>0: judge only when starting unloading, no longer judge in unloading process;1:</p> <p>Keep judging during unloading.</p>
40231	00230	Over range feeding protection	<p>Initial value: 1,</p> <p>0: close;</p> <p>1: on. When on, from the calibration zero (plus zero clearing)</p> <p>Cleared part), the weight is greater than or equal to specification *1.2, then judged</p> <p>OFL, whether or not the maximum range is exceeded. Preventing zero clearing will be large</p>

			<p>After the weight is cleared to 0, the weight is small, but it is</p> <p>Overcharge. at the same time, adjust the settable value of the clearing range from 99% The whole of 20%</p>
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	Overtime and undertime alarm	Initial value: 0. The value ranges from 0 to 99999, expressed in milliseconds
40325	00324		
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	Fixed to 1 and cannot be modified
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	Initial value: 5500, range: 0~ 20000	
40334	00333	Slow addition and feeding function switch	Initial value: 0, range: 0~ 1	
40335	00334	Slow feeding single time	Initial value: 0.4, range: 0.1~ 9.999S	
40336	00335	Slow addition of feeding	Initial value: 1, range: 1~ 9	
40337	00336	Breaking weight: Cutting off the slow opening of the flow	Initial value: 1000, range: 0~ 999999	
40338	00337			
40339	00338	Slow flow break and conservative opening	Initial value: 2000, range: 2000~ 30000	
40340	00339	Single scale combination counting	Initial value: 0, range: 0~ 99	
40341	00340	Delay time for unloading	Initial value: 1000, range: 0~ 9999	
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:
40405	00404	IN2	2	I00: No definition
40406	00405	IN3	5	I01: start
40407	00406	IN4	6	I02: stop
40408	00407	(1-ZT1)	4	I03: stop
40409	00408	(1-ZT2)	23	I04: Feeding stepper motor origin (close the door to
40410	00409	(2-ZT1)	0	A level)
40411	00410	(2-ZT2)	0	I05: Feeding allowed
40412	00411	IN5	0	I06: Unloading allowed
40413	00412	IN6	0	I07: Clear alarm
40414	00413	IN7	0	I08: keep
40415	00414	IN8	0	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)
				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 I29: AB interlock input I30: Unloading servo alarm
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 11: clip bag
40417	00416	OUT2	4	
40418	00417	OUT3	5	
40419	00418	OUT4	6	
40420	00419	OUT5	7	
40421	00420	OUT6	8	
40422	00421	OUT7[DR1]	3	
40423	00422	OUT8[DR2]	8	
40424	00423	OUT9[PWM1]	0	
40425	00424	OUT10[PWM2]	0	

			<p>O12: Preset number of packets completed</p> <p>O13: Once packing is completed (unloading is completed After output 1s clock)</p> <p>O14: stop</p> <p>O15 unloading step motor direction</p> <p>O16 Discharging motor running/forward</p> <p>O17 discharging motor reverses</p> <p>O18 feeding PWM[only AVAILABLE for OUT7/OUT8]</p> <p>O19 Discharging PWM[only available at OUT7/OUT8]</p> <p>O20: Feeding servo alarm output</p> <p>O21: Fixed value completion</p> <p>O22: AB interlock output</p> <p>O23: Unloading servo alarm output</p> <p>O24: Unloading status output</p>
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	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	00445	OUT7	Same as OUT1-OUT6
40447	00446	OUT8	
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

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:

			<p>0 resets all (production use, including all the following additional also</p> <p>There are statistical data clearance, cumulative clearance, putter related parameters)</p> <p>(Super user)</p> <p>1 Reset all (clients) including all below</p> <p>2 Reset basic parameters</p> <p>3 Reset calibration parameters</p> <p>4 Reset user parameters</p> <p>5 Reset peripheral parameters</p> <p>6 Reset the adaptive parameters</p> <p>7 Reset communication parameters</p> <p>8 Reset Switch Value User-defined parameter</p> <p>9 Reset adaptive statistics</p> <p>Read: 0</p>
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
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



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	Total cumulative number of times	Maximum 9-digit Decimal number
41204	01203		
41205	01204	Total cumulative weight (upper 4 digits)	Maximum 13 bit Decimal number
41206	01205		
41207	01206	Total cumulative weight (lower 9 digits)	
41208	01207		
Dedicated address for quick plus fixed value prediction			
43001	03000	Quickly add forecast increments	Read-only, unit g
43002	03001	Weight at the time of forecasting	Read-only, unit g
43003	03002		
43004	03003	Predicted weight	Read-only, unit g
43005	03004	Predicted time	Read-only, unit g
43006	03005	Turn off the cut-off point weight after the slow plus delay	Read-only, unit g
43007	03006		
43008	03007	Average the predicted constant weight difference	Read-only, unit g
43009	03008		

43010	03009	Fixed weight	Read-only, unit g
43011	03010		
43012	03011	Quick plus prediction function switch	1: Turn on the Quick Plus Prediction feature 0: disables the quick plus prediction feature
43013	03012	Quick plus predicts the cache size for reads and writes, with a default value of 0	How many ADs to choose for prediction
43014	03013	Fast mode (fixed value prediction function switch)	The current fixed value prediction switch
43015	03014	Fast Mode Sampling Delay (Fixed Time Threshold)	The fixed value predicts how long the base weight will be sampled after the droplet is closed, in ms
43016	03015		
43017	03016	Fast Mode Sample Weight (Constant Weight Difference)	The difference between the base weight and the exact fixed weight, in g
43018	03017		
43019	03018	Quick mode setting time	When Quick Mode is enabled, this value is used instead of the fixed time
43020	03019	The number of times the quick mode resampling interval is used	After the interval of how many times, the weight is sampled again
43021	03020	The number of quick mode samples	The average of how many scales are used to calculate the sample weight

Note: The above is all the contents of Modbus communication address table of AF-01K II 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

7.1 Login screen

User Login	<div style="display: flex; justify-content: space-around;"> <div style="text-align: left;">  <div style="border: 1px solid black; padding: 2px;">Runing</div> <div style="font-size: 24px; font-weight: bold;">0.000 kg</div> <div style="font-size: 10px; border: 1px solid black; padding: 2px;">FAST MIDDLE SLOW DISC</div> </div> <div style="text-align: left;">  <div style="border: 1px solid black; padding: 2px;">Runing</div> <div style="font-size: 24px; font-weight: bold;">0.000 kg</div> <div style="font-size: 10px; border: 1px solid black; padding: 2px;">FAST MIDDLE SLOW DISC</div> </div> </div>	<div style="text-align: right;">2018-07-17 11:02:20</div> <div style="text-align: right; margin-top: 10px;">User: NON ></div>		
<h1 style="margin: 0;">General Measure Co.Ltd.</h1> <h2 style="margin: 10px 0 0 0;">GMF01-10K StepMotor/Serov Packing Scale</h2>				
<div style="border: 1px solid black; padding: 5px; margin-bottom: 5px;"> 选择语言： Select Language： </div> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="padding: 5px;">中 文 Chinese</td> <td style="padding: 5px;">English 英 文</td> </tr> </table>		中 文 Chinese	English 英 文	<div style="border: 1px solid black; padding: 10px; width: 100px; margin: 0 auto;">Login</div>
中 文 Chinese	English 英 文			

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



4. **Zeroing** Click this button to perform a reset operation.



5. **Stop** Click this button to make the device emergency stop.



6. **Stop** Click this button to start and stop the device.

7. **0.300s**

- Click this type of operation box to modify this value.

8. **RUN**

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

9. **Auto Feeding**

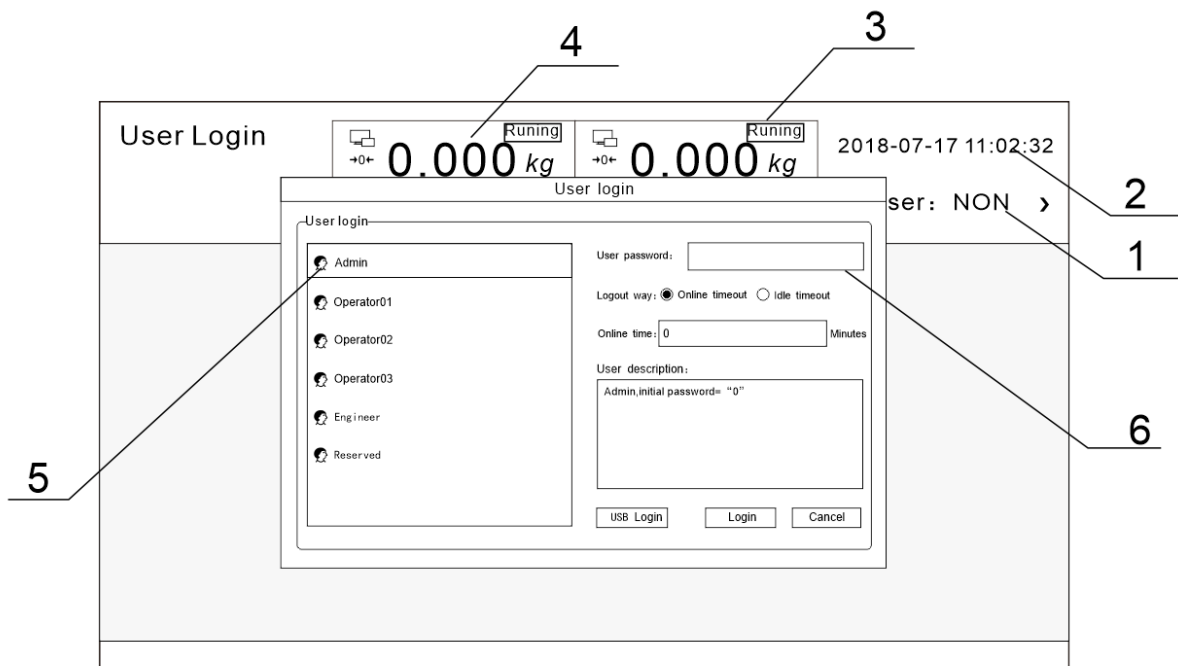
- Click this type of operation box to perform corresponding operations.



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

11. **Previous Page** Click this type of operation box to switch pages.

7.2 Touch 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.

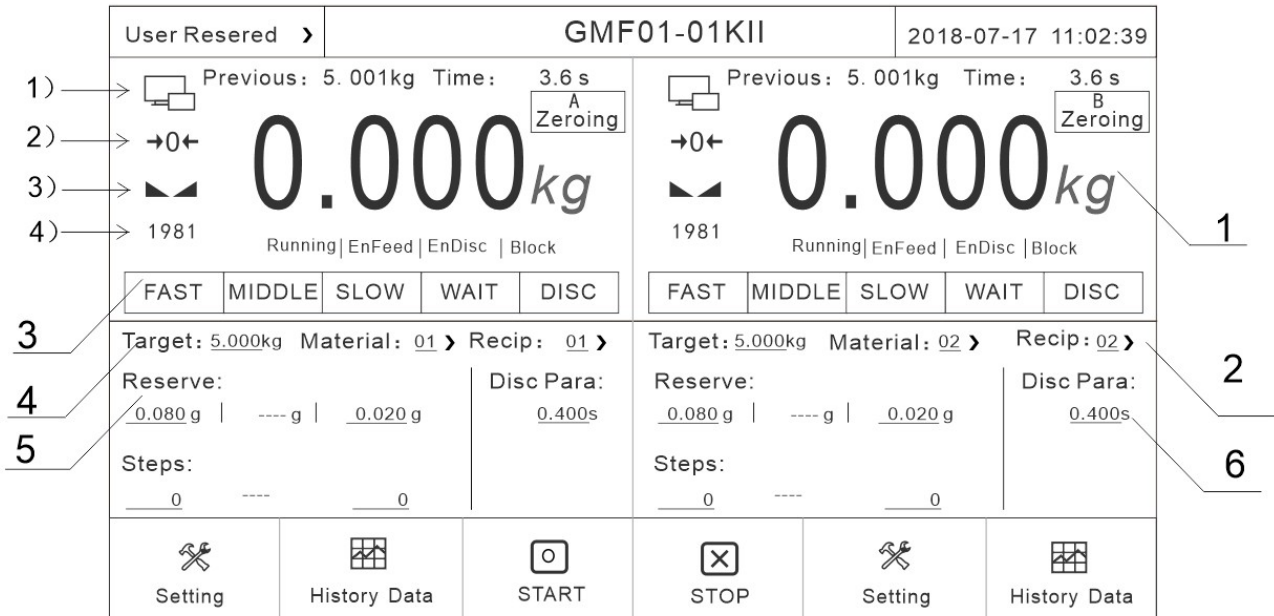
5: Login user selection area, showing all users that can be selected.

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. 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).














4. Current target value.

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

6. 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

Setting < HOME		 <div> <div>Running</div> <div>0.000 kg</div> <div>FAST MIDDLE SLOW DISC</div> </div>	 <div> <div>Running</div> <div>0.000 kg</div> <div>FAST MIDDLE SLOW DISC</div> </div>	2021-09-26 10:02:26 User: Rervered>
 Work Parameters > Zeroing, digital filter, stable judgment	 Recipe Parameter > Target, Reserves, Steps...	 Auto Setting > Process parameter self-learning		
 Quick mode parameter > Mode Sample Delay	 Control Parameters > Frequency, Door Opening	 History Data (HMI) > Query, export, clear data		
 Calibration > Capacity, calibration...	 I/O > Define, Test...	 Communication Para. > Protocol, baud rate, format		
 User Management > Password modification, logout	 System Information > Version, Backup, Upgrade...			

Interface description:

parameter	illustrate
Working parameters	basic parameters of the product can be set, such as zero clearance range, zero clearance time, unloading mode and so on.
Recipe Parameter	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.
Auto Setting	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.
Quick Mode parameter	When the scale body is relatively stable, this function can be turned on for fast packaging
Control parameters	parameters of the feeding motor can be set.
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.
I/O	Users can define and set the input quantity and output quantity according to their own requirements. The control board has 8 inputs and 8 outputs (for details, see 7.12 Switch Quantity Description).
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).
User management	Switch user rights.

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

A-Work Para.-1		Running	Running	2018-08-18 10:02:26
Parameters Setting	0.000 kg	0.000 kg		User : engineer
Zeroing Range:	10%	Stable range/time:	1d 0.300s	
Auto Zero Interval:	0	DigitalFilter (Running)	Feed: 7 Wait: 3 Disc: 8	
Additional Clear Nums at sart:	3	Digital filter level[STOP]	9	
Delay Time for Zeroing:	0.200s	Add to Total When(M)Disc:	<input type="checkbox"/>	
Automatic Zero When powered on:	<input type="checkbox"/>	Result Holding:	<input type="checkbox"/>	
Zero Tracking Range/Time:	1d 0.200s	Self Adaption:	<input type="checkbox"/>	
Processing of Zeroing failure:	Waiting for stability	Auto Setting/ Self Adaption Level	Level2[balanced]	
< HOME		Next Page >		

Example diagram of working parameters (4 pages)

Interface description:

parameter	illustrate
Zeroing range	Zeroing range (1% to 20% of full scale).
Automatic reset interval	During operation, the device automatically resets after completing the set number of packets.

Start additional reset times	After the device enters the operating state, the second scale starts and continues to reset before feeding. The number of executions is equal to the set value of this parameter. For example, if the start additional reset times are 2, then after starting, the second and third scales are all reset before feeding.
Zeroing additional delay	When it is necessary to reset (whether it is an automatic reset interval or an additional reset), before resetting, the device completes the pre feeding delay and after this delay, the reset operation begins.
Power on automatic reset:	When the device is powered on, it automatically performs a reset operation.
Zero point tracking range/time	The zero point tracking range is optional from 0 to 9d. If it is 0, zero point tracking will not be performed. The zero point tracking time can be set from 0.001 to 9.999.
Automatic Zeroing Failure Handling	The handling method after automatic cleaning failure, including: next package cleaning, three package failure suspension, continuous stabilization, and immediate suspension.
Stability range/time:	The stability range is optional from 0 to 99d. If the change in weight within the stability time does not exceed the stability range, it is considered stable. Otherwise, it is considered unstable.
Operation filtering level:	The filtering level used during operation, ranging from 0 to 9 levels, can be divided into three situations: feeding, constant value, and unloading. The larger the value, the better the filtering effect, but the greater the lag.
Stop filtering level:	The filtering level used in the stop state, ranging from 0 to 9 levels. The larger the value, the better the filtering effect, but the greater the lag.
When manually	Accumulated manual unloading: weight is included in the accumulation.

unloading, the packaging	
Fixed value weight maintenance	weight display remains unchanged until the unloading is completed.
Adaptive switch	If the device is turned on during operation, the device will automatically adjust the scale based on the adaptive level.
Adaptive& Automatic Scaling Level	It can be divided into five levels: Zero level is the best speed, first level is slightly better speed, second level is balanced adjustment, third level is slightly better accuracy, and fourth level is the best accuracy.
Unloading mode	divided into two modes: time controlled unloading and zero zone delayed unloading. The former is to close the unloading door when the unloading time is reached, while the latter is to start the "delay after unloading to zero zone" when the weight is less than the zero zone value. When the delay time is reached, the unloading door is closed.
Delay after unloading to the zero zone	When the weight of the material reaches the zero zone value, delay the time to close the unloading door.
Unloading timeout time	If the unloading process exceeds the set time, the device will prompt a unloading timeout alarm message and automatically return to the stop state.
Fixed value mode	divided into two modes: time fixed value and stable value judgment.

Fixed value timeout time	If the fixed value is not completed within this time, it enters the fixed value timeout processing.
Fixed value timeout processing	You can choose to not pause the timeout alarm, only pause the three guarantees alarm, continue to alarm and wait for stability, and continue to alarm and pause.
Over range feeding protection	zero point (plus the part that has been cleared from zero) and has a large weight. If it is equal to 1.2 times the upper limit of the quantitative range, it enters an overrange protection state. This function can prevent the occurrence of a situation where the weight is displayed as small but has actually overflowed after clearing the larger weight to 0.
Positive error mode	During the feeding process after opening, the error generated by the feeding result will deviate from the positive value.
Bag loosening mode	You can choose between automatic bag loosening or manual bag loosening.
Delay after bag clamping/loosening	After the bag clamping or bag loosening signal is output, delay the time to stop the signal output.
Delay before loosening the bag	If the fast heater does not end after this time, it is determined as the fast heater is cut off
The timeout period of fast addition and interruption	If the fast addition does not end after this time, it is judged that the fast addition is interrupted
Intelligent	When turned on, enter the intelligent judgment mode for fast heater disconnection. Abnormal slow feeding speed will be recognized

judgment of fast heater cutoff	Don't cut off the flow
Discharging and rapping times	Number of rapping outputs, initial value: 0, indicating that the function range is closed: 0-9
Effective time of unloading and vibrating	Effective time of rapping output, initial value: 0.5; Range: 0.0~9.9. Unit: s
Discharge rapping interval time	The interval time between each rapping, initial value: 0.5; Range: 0.0~9.9. Unit: s
Operating frequency of discharge motor	Working frequency of discharge motor, initial value: 10; Range: 1-50 Unit: kHz (discharge machine Available when the construction type is servo motor)
Starting frequency of discharge motor	Starting frequency of discharge motor, initial value: 5; Range: 1-50 Unit: kHz (discharge mechanism Available when the type is servo motor)
Unloading door closing timeout	During operation, if the unloading door is not detected to be closed in place within this time, it is judged that the unloading door has exceeded the limit Time. Initial value: 3; Range: 0.0~9.9. Unit: s (discharge mechanism type is servo electric) Available during machine hours)
The discharge motor closes the door to replenish the number of pulses	The number of pulses that go forward after triggering the signal to close the door in place

Set batch number	The set batch number.
Number of remaining batches:	The number of remaining batches.
Forced use of three-level feeding:	When turned on, enters the three-level feeding mode.
AB interlocking scale body mode	This device has already set the corresponding parameter for scales A and B when it leaves the factory. Please do not modify it without authorization.
Type of feeding mechanism	Pneumatic and servo motors are optional
Charging motor type	There are stepper motor-shaft drive, servo motor-shaft drive, and stepper motor-connecting rod options
Vibrating plate	There are options with and without vibrating plate
Type of discharge mechanism	Optional pneumatic and servo motors
Scale specifications, vibration plate, and motor type	The functions are set by the manufacturer and cannot be set by engineer users.

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

7.6Description of formula parameters

A-Rec. Para.-1		<div> <div> <div>Running</div> <div>0.000 kg</div> <div>FAST MIDDLE SLOW DISC</div> </div> <div> <div>Running</div> <div>0.000 kg</div> <div>FAST MIDDLE SLOW DISC</div> </div> </div>		2018-08-18 10:12:26
Parameters Setting				User:engineer
Target: 5.000kg		Recipe ID: 09		
Fast Remains: 3.800kg	Automatic adjustment	Fast Steps: 16001		
Middle Reserve: -----kg		Middle Steps: ----		
Slow Reserve: 0.038kg		Slow Steps: ----		
Disc Mode: Time Control Disc				
Disc Delay Time: 0.200s		Waitting Time: 0.800s		
		Multiple Disc Nums: 00		
		<div> <div>HOME</div> <div>Next Page</div> </div>		

Recipe Parameter Example Diagram (3 Pages)

Interface description:

parameter	illustrate
Target value	A quantitative weight is required.
Fast acceleration advance	During the quantitative process, if the weighing value is \geq the target value - fast acceleration advance, the fast acceleration will be turned off.
Intermediate plus advance	During the quantitative process, if the weighing value is \geq the target value - intermediate plus advance, the intermediate plus will be turned off.
Drop value	During the quantitative process, if the weighing value is \geq the target value - drop value, the slow acceleration will be turned off.
Unloading mode	Time controlled unloading or zero zone delayed unloading can be selected.

Unloading time	The unloading signal output stops after this time.
Zero zone value	During the quantitative process, if the weighing value is less than or equal to the zero zone value, the unloading delay timer will be activated.
Recipe Number	The number of the current recipe.
Quick feeding opening	The opening of the feeding door during rapid feeding of materials.
Medium opening	The opening of the feeding door when adding materials.
Slow feeding opening	The opening of the feeding door during slow feeding of materials.
Discharge opening	The opening of the discharge door when discharging. (Available when the discharge mechanism type is servo motor)
Fixed value time	The time to determine the weight after the feeding is completed.
Combination times	This is a reserved parameter, and the current device does not support the multi scale combination function.
Delay T1 before feeding	At the beginning of the quantitative process, the feeding process only starts after a delay T1 time;
Slow feeding switch	When this switch is turned on, the equipment automatically performs slow feeding.
Single replenishment	The time of a single replenishment.

time	
Maximum replenishment frequency	The maximum replenishment frequency of the equipment.
Over/under tolerance switch	A switch that enables the over/under tolerance detection function.
Over tolerance	During the quantitative process, if the weighing value is greater than the target value+over tolerance value, it is considered over tolerance.
Under tolerance	During the quantitative process, if the weighing value is less than the target value - under tolerance value, it is considered under tolerance.
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 automatically outputs invalid.
Over/under tolerance pause switch	When this switch is turned on, if over/under tolerance occurs, the device will pause and wait for user processing. At this time, it can "clear the alarm" and continue running; It can also return to the stop state after an "emergency stop".
Fast heater cutoff timeout	If the fast heater does not end after this time, it is determined as the fast heater is disconnected. If the interruption timeout is large At 10S, this function is invalid
Intelligent judgment of fast heater cutoff	Turn on the switch, and the system will automatically determine that the fast heater is disconnected. If the feeding speed slows down abnormally, it will be recognized as disconnected
Opening weight	When the fast heater is cut off, if the remaining weight to be added exceeds this value, the opening of the fast heater will become cut off

of cut-off safety opening	Flow safety opening. If it is less than this value, it will directly turn off the fast acceleration and jump to the slow acceleration
Safety opening for flow interruption	This opening ensures that the material will not become overweight when it is immediately flushed down when it comes back in. Should be set to obviousLess than normal fast acceleration opening. But this opening can also ensure that the feeding speed is greater than the slow feeding.

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

7.7The Quick Mode Parameters interface says

A-Quick Mode Para.

Running

0.000 kg

FAST MIDDLE SLOW DISC

Running

0.000 kg

FAST MIDDLE SLOW DISC

2021-09-26 10:02:26

User: Reserved

Quick Mode:

☐

Quick Mode Sample Delay:

0 mS

Quick Mode Sample Slow Reserve:

0 g

Quick Mode Waiting Time:

0.000 s

Quick Mode Sample Number:

0

Quick Mode Sample Interval:

0

Pre-Filter:

☐

Fast Infer Cutoff

☐

Fast Infer Cutoff Smoothly Sampling

☐

QDF:

☐

COM3Debug:

☐

Yon:

☐

Samp4:

☐

YΔW:

0 g

Ywc:

0.000 kg

Ywp:

0 g

Ytp:

0 uS

Quick Mode:

☐

DΔset:

0 g

Dtd:

0 mS

Dwc:

0.000 kg

DΔW:

0 g

Dwp:

0 g

Dtp:

0.000 S

DsmpN:

0 0

DdisN:

0





HOME

Interface specification:

parameter	illustrate
Quick mode switch	It is used to turn on the quick value function

Fast mode sampling delay	The fixed value predicts how long the base weight will be sampled after the droplet is closed
Fast mode sampling drop	The value of the drop calculated in fast mode
Quick mode setting time	The number of sample packets in fast mode, this time will be used as the fixed time
The number of quick mode samples	The average of how many scales are used to calculate the sample weight
The number of times the sampling interval is in fast mode	After the interval of how many times, the weight is sampled again. There is no need for a fixed time during the number of intervals, which speeds up
Quickly predict the shutdown	Through the first few samples, predict the weight of the fast add, or turn off the fast add in advance
Quick prediction turn-off smoothing sampling	After it is enabled, it is predicted based on the fast trend of the last 4 packs, and closed is predicted only based on the fast trend of the current pack
Pre-filtering	A simple filter has been added before filtering for smoother weight results
maximum permissible error	Maximum allowable error value

7.8 Calibration interface description

A-Calibration		 0.000 kg <div>Running</div> <div>FAST MIDDLE SLOW DISC</div>	 0.000 kg <div>Running</div> <div>FAST MIDDLE SLOW DISC</div>	2018-08-18 10:12:26 User:engineer
< Parameters Setting				
Unit: ["kg" only]	kg >	Decimal point:	0.000 >	
Minimum Division: [1d=0.001kg]	01 >	Capacity:	15.000kg	
Over Capacity mode:	Cap*120% >			
Step 1: Confirm that the hopper is empty and the discharge door is closed, Wait for the indication to be stable, click the buton to complete the clibration!		Step 2: Add standard weight, wait until the display is stable, input the actual weight, and click the button!		
Loadcell Output-mV:	 8.000 mV	Zero Calibration	Weight-mV:  8.000 mV	Weight Calibration
		Weight:	3.000kg	
		< HOME Calibration with materials >		

Interface specification:

parameter	illustrate
Unit	The fixed value is kg
Minimum score	1 2 5 10 20 50 Optional.
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.
Decimal point	fixed value 0.000, that is, three decimal places after the decimal point.
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".




7.9 Step 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".

7.10 Material calibration steps

Calibration with materials < Parameters Setting		 0.000 kg FAST MIDDLE SLOW DISC	 0.000 kg FAST MIDDLE SLOW DISC	2021-09-26 10:02:26 User <input type="text"/> engineer >
Step1: Empty the scale bucket and wait for the MV value to The indication should return to zero.		 12.000 mV		Zero Calibration
Step2: Click "automatic feeding"[by target value]or "(M)Fast"[by time]. Start charging.(please make sure the weight has been calibrated before automatic charging,The weight is roughly accurate,otherwise it may be filled with overflow,etc) Wait until the weight indication is stable,click"record weight" to save the current displayed value Bag claming and unloading.weigh on the standard scale to obtain the weight of the double scale (pay attention to peeling)		Target: <u>5.000kg</u> Auto Feeding Ufeeding (M) Feeding TIME: <u>1.0s</u>	Current Weight: 1.000kg Save the weight	(M) Disc
Step3: Input the weight of the weigher, click "automatic feeding", and the controller will automatically Record the weight Calibration as the weight of the scale		Standard weight: <u>3.000kg</u>	Calibration with materials	
< Weight Calibration		< HOME		

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".

7.11 Description of switch quantity interface

A-I/O-1:Input


Parameters Setting



Running

0.000 kg

FAST MIDDLE SLOW DISC



Running

0.000 kg

FAST MIDDLE SLOW DISC

2018-08-18 10:12:26

User:engineer

Port	Define	Status	Port	Define	Status
IN01	START	<input checked="" type="radio"/>	IN05	Bag clamping request	<input checked="" type="radio"/>
IN02	Emergency Stop	<input checked="" type="radio"/>	IN06	undefined	<input checked="" type="radio"/>
IN03	Clear alarm	<input checked="" type="radio"/>	IN07	undefined	<input checked="" type="radio"/>
IN04	Interlock input	<input checked="" type="radio"/>	IN08	undefined	<input checked="" type="radio"/>

A-IO A

B-IO B

OUT 1 2 3 4 5 6 7 8

OUT 1 2 3 4 5 6 7 8

A-I/O Test: ☐

To B Scale To B Scale

HOME
Next Page

Switching Quantity Example Diagram (3 Pages)

Parameter Description:

parameter	illustrate
Input	Input ports (IN01, IN02, IN03, IN04, IN05, IN06, IN07, IN08) can be customized by customers
	(PWM1-ZT1_1, PWM1-ZT1_2) is fixed as the photoelectric signal of the motor in place; Input Port (PWM2-ZT2_1, PWM2-ZT2_2) is a universal switching value, where PWM2-ZT2_1 has been set as servo alarm by default, PWM2-ZT2_2 Customizable by customers (When the corresponding PWM port function is set to motor control, PWM1-ZT1_1, PWM1-ZT1_2, PWM2-ZT2_1, and PWM2-ZT2_2 are fixed as motor in position photoelectric and cannot be set. When set to switch value, they are used as ordinary input ports)
Output	(OUT01, OUT02, OUT03, OUT04, OUT5, OUT6, OUT7, OUT8) can be customized by customers

	<p>(DR1, PU1) is the direction signal and pulse signal of the motor; The output ports (DR2, PU2) are general-purpose switching variables, The default setting for DR2 is slow acceleration, while the default setting for PU2 is unloading</p> <p>(DR1, PU1, DR2, and PU2 are fixed to the motor direction and pulse when the corresponding PWM port function is set to motor control)</p> <p>Impulse output, cannot be set. When set to a switching value, as a normal input port)</p>
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
IN2	2	I03: stop I04: Feeding stepper motor origin (close the door to
IN3	5	A level) I05: Feeding allowed I06: Unloading allowed
IN4	6	I07: Clear alarm I08: keep
IN5	0	I09: Open/close unloading door [originally manual unloading

IN6	0	Function, switch discharging output state] I10: Manual unloading
IN7	0	I11: Manual slow add I12: Manually add I13: Manual fast add [by fast open open
IN8	0	The door] I14: Manual cleaning [open according to the maximum opening
ZT1_1	4	The door] I15: Start/stop (double edge: effective edge,
ZT1_2	24	Start;Invalid edge, stop) I16: Start/emergency stop (double edge)
ZT2_1	0	I17: Manual unloading (double edge) I18: Manual slow adding (double edge)
ZT2_2	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)

		<p>I24: feeding stepping motor limit point.</p> <p>I25: Unloading stepping motor origin.</p> <p>I26: limit point of unloading stepping motor.</p> <p>I27: jam</p> <p>I28: Servo motor alarm</p> <p>I29: Double scale interlock input</p> <p>I29: AB interlock input</p> <p>I30: Unloading servo alarm</p>
--	--	---

Output definition:

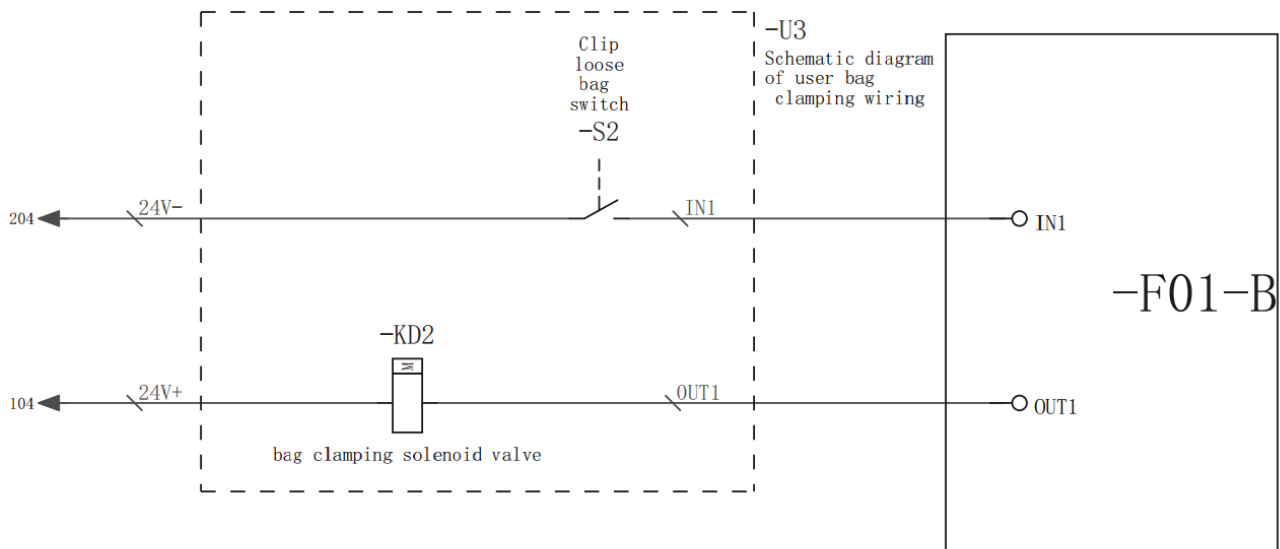
The port number	The initial value	Custom list
OUT1	1	O00: No definition
OUT2	4	Run O01:
OUT3	5	O02: Refueling request
OUT4	6	O03: Feeding stepper motor direction [PW available
OUT5	7	The signal is set to feed PWM]
OUT6	0	O04: quick to add
OUT7	0	I add O05:
OUT8	0	O06: slow
DR1	3	O07: fixed value
PU1	0	O08: unloading L
DR2	8	O09: over difference
PU2	0	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 unloading step motor direction
		O16 Discharging motor running/forward
		O17 discharging motor reverses
		O18 feeding PWM[only AVAILABLE for OUT7/OUT8]

		O19 Discharging PWM[only available at OUT7/OUT8] O20: Feeding servo alarm output O21: Fixed value completion O22: AB interlock output O23: Unloading servo alarm output O24: Unloading status output
PWM1 function	2	1: general switching quantity 2: feeding motor control 3: unloading motor control
PWM2 function	1	

Peripherals and external linkage:

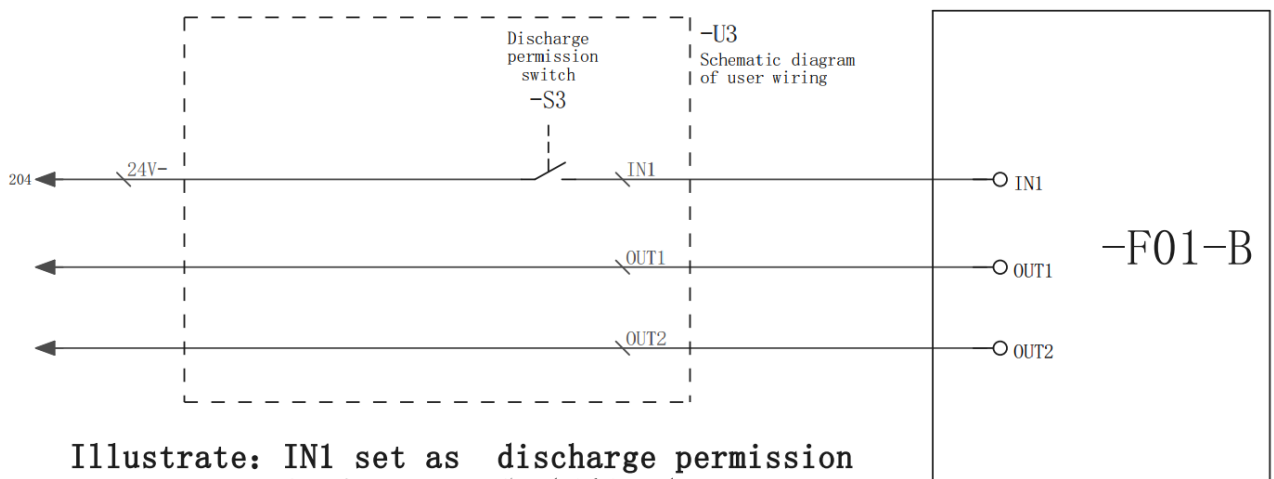
(The following ports IN1, OUT1, etc. are examples. Users can use other ports as needed, but the corresponding port definitions need to be modified.)

1. Bag clamping/loosening mode: The parameters that need to be set are bag loosening mode, delay after bag clamping/loosening, delay before bag loosening (refer to 7.5 working parameter introduction for specific settings), input port IN1 set to bag clamping/loosening request, and output port OUT1 set to bag clamping. The working logic is as follows: When IN1 receives a bag clamping/loosening request, OUT1 outputs a bag clamping signal. The packaging scale unloads the bag when it detects the bag clamping output signal after the set value is completed. After the unloading is completed, OUT1 stops outputting the bag clamping signal, which means the bag is loosened. This is a complete bag clamping/loosening unloading process. The wiring method is as follows:



Illustrate: IN1 set as bag clamping/loosening request.
OUT1 set as bag clamping output.

2. Allowing unloading mode A: Set IN1 as unloading allowed, OUT1 as fixed value completion, and OUT2 as unloading. When the external judgment is completed and the self preparation is completed, the unloading permission is given. After receiving the effective unloading, it indicates that the unloading permission has been received by the packaging scale, and the unloading permission is turned off. The wiring method is as follows:



Illustrate: IN1 set as discharge permission
OUT1 set as Stabilized
OUT2 set as DISC

Allow unloading mode B: Set IN1 as unloading allowed, OUT1 as one package completed. This mode is mainly used with vertical packaging machines. When the vertical packaging machine is ready, it will output the unloading permit, the packaging scale will discharge the material after receiving the unloading permission signal, and the packaging completion signal will be output once after the unloading is completed, and the vertical

packaging machine will carry out the packaging action and turn off the unloading permission output at the same time, and the unloading permission signal will be output again after the packaging is completed, so that the cycle continues to operate. The wiring refers to the figure above, and OUT2 does not need to be wired.

3. The difference between the clamp/loosen bag mode and the allow to unload mode: When using the clamp/loosen bag mode on the packaging scale, it is necessary to receive a clamp/loosen bag request before outputting the clamp bag. Only when both the clamp bag signal and the fixed value completion signal exist can the material be unloaded. When the packaging scale uses the allowed unloading mode, as long as it receives the allowed unloading signal, it can be unloaded when it exists simultaneously with the fixed value completion signal.

Note: The above logic is only applicable when "the two scales work completely independently". Our double scale has been connected to the interlock line at the factory, and the double scale works together, please refer to the chapter on double scale interlocking for details. When working independently as a double station, the interlock line should be removed.

7.12 Control Parameters screen Description

A-Control Parameters		<div> <div> <div>Running</div> <div>0.000 kg</div> <div>FAST MIDDLE SLOW DISC</div> </div> <div> <div>Running</div> <div>0.000 kg</div> <div>FAST MIDDLE SLOW DISC</div> </div> </div>		2018-08-18 10:12:26	
Parameters Setting				User:engineer	
Disable judgment Time		0.700/ 0.700/ 0.700 s		Feeding StepMotor Status: RUN CLOSE ZERO 2198	
Disable judgment Time Auto Adjust		<input type="checkbox"/>			
		Feeding StepMotor Work Frequency		60.0kHz	
		Feeding StepMotor Start Frequency		20.0kHz	
		Fast Steps:		6123	
Feeding StepMotor Max.Step:		20000		Fast Steps: 4123	
		Slow Steps:		2	
				Feeding StepMotor Steps Tab	
< HOME					

Interface specification



parameter	illustrate
Prohibition time	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

for fast, medium, and slow acceleration	
Slow acceleration intelligent prohibition switch	When this switch is turned on, the slow acceleration intelligent prohibition function is enabled.
Motor Subdivision	Set value of motor subdivision
Reducer reduction ratio	The reduction ratio of the current reducer.
Maximum angle of feeding gate	the maximum opening angle of the current feeding gate.
Maximum opening degree of charging motor (pulse number)	To protect the motor, the maximum opening degree allowed after starting the motor is allowed.
Initial Opening Calibration Value	The calibration value of the current initial opening
Feeding motor status	four states can be seen: stop, open, origin, and opening.
Feeding motor	the frequency at which the feeding motor operates normally.

operating frequency	
Starting frequency of charging motor	the frequency at which the charging motor is started.
Quick heater opening	the current fast heater opening value.
Medium Plus Opening	The current medium plus opening value.
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".

7.13 Communication Parameters screen description

A-Communication Para.		<div>  <div> <div>Running</div> <div>0.000 kg</div> <div>FAST MIDDLE SLOW DISC</div> </div> </div>		<div>  <div> <div>Running</div> <div>0.000 kg</div> <div>FAST MIDDLE SLOW DISC</div> </div> </div>		2018-08-19 10:09:36	
Parameters Setting				User:engineer			
A-COM1		Used to this HMI, Cannot set:		A-LAN		The LAN port on the controller. Not the LAN port on this HMI.	
ID:		001		IP and Port:		0.0.0.0:000	
Protocol:		Modbus-RTU		Protocol:		Modbus-TCP/IP	
BAUD:		[may not be default, adaptive] 57600		DoubleWord Format:		AB-CD	
Byte Format:		[Parity bit can be different] 1-8-E-1		MAC:		00:00:00:00:00:00	
DoubleWord Format		AB-CD					
HMI parameters:		COM2 57600 Even					
				HOME		Next Page	

Example diagram of communication parameters (2 pages)

Interface description:

parameter	illustrate
Address number	Slave number. The ID number of the serial communication
Protocol Type	Communication protocol. Select the protocol for serial communication
Baud Rate	Select the baud rate of the serial port.
Byte Format	Data format. Initial value; 1-8-E-1 (8-bit data bit-even parity - 1-bit stop bit;)
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.

Current HMI communication parameters	Displays the current communication parameters of the touch screen.
IP and Port	IP address.
MAC	MAC address.

7.14 Historical data page description

A-History Data		Runing →0← 0.000 kg <div style="display: flex; justify-content: space-around; font-size: 0.8em;"> FAST MIDDLE SLOW DISC </div>		Runing →0← 0.000 kg <div style="display: flex; justify-content: space-around; font-size: 0.8em;"> FAST MIDDLE SLOW DISC </div>		2018-08-19 10:09:36 User:engineer >	
< HOME							



Index	TIME	Mat.Rec	Target	ACT.	Time	E	Sec.	Total PCS			
									Total	0P. 0L.	
									Select	0P. 0L.	
									Goto	0P. 0L.	
									Auto Refresh	<input type="checkbox"/>	
									(M)Refresh		
									Export to Udisk		
FirstPage	PreviousPage	NextPage	LastPage	Setting	Claer Data	<	HOME				

Interface description:

parameter	illustrate
Automatic refresh/Manual refresh	Refreshes data.

Usb disk export	You can export historical data.
Clear data	Clear historical data.
Historical Data (HMI)	Can view historical data saved on HMI
Historical data (controller)	Can view historical data saved on the controller
Communication Exception Record	Can view the history of communication exceptions
Alarm Record	Can view alarm records
set up	Can set the time range for data storage

7.15 Description of automatic balance adjustment interface

A-Automatic		<div>  <div> <div>Running</div> <div>0.000 kg</div> <div>FAST MIDDLE SLOW DISC</div> </div> </div>		<div>  <div> <div>Running</div> <div>0.000 kg</div> <div>FAST MIDDLE SLOW DISC</div> </div> </div>		2018-08-18 10:42:26	
Parameters Setting				User:engineer			
Material ID/Name: 03/ Material 03		Auto Setting/ Self Adaption Level: Level2[balanced]					
Recipe ID/Tareget: 01 / 5.000kg		Steps Auto Adjust <input type="checkbox"/>		Levels			
Fast Remains: 2.000 1.600kg		Fast Steps: 1		6123			
Middle Reserve:		Middle Steps:					
Slow Reserve: 0.008 0.005kg		Slow Step: 1123		2			
Previous: 24.998 Total Time: 3.982		Remaining NUMS: 00		Current Status: END			
Fast: 2.232 Middle: 0.000 Slow: 1.234		Auto Setting Nums: 09		<div>Give up</div>			
Wait: 0.900 Disc: 0.000 T1: 1.004				<div>Start Auto Setting</div> <div>SAVE</div>			
HOME							

Interface description:

parameter	illustrate
Material No./Name	You can set the material number and name
Recipe Number/Target Value:	Set the recipe number and target value
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
Automatic adjustment of opening	automatic adjustment function switch for the opening of the feeding door
Feeding Level	Two or three levels of feeding, automatically set by the system based on the target value
Quick charging opening	the opening of the fast charging door.
Medium feeding opening	the opening of the medium feeding door.
Slow feeding opening	the opening of the slow feeding door.

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.

7.16 Describes the user management interface

User Management	<div> <div>0.000 kg</div> <div>Running</div> <div>FAST MIDDLE SLOW DISC</div> </div>	<div> <div>0.000 kg</div> <div>Running</div> <div>FAST MIDDLE SLOW DISC</div> </div>	2018-08-18 10:45:20
Parameters Setting	User:engineer		
Current User	Engineer		
Change Password	>		
Log-off, Re-login	>		
Auto Login:	<input type="checkbox"/>		
< HOME			

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".

7.17 System information interface description

SYS Info-1: Name and Version		<div> <div>→0+ 0.000 kg</div> <div>Runing</div> <div>FAST MIDDLE SLOW DISC</div> </div>		<div> <div>→0+ 0.000 kg</div> <div>Runing</div> <div>FAST MIDDLE SLOW DISC</div> </div>		2018-08-18 10:02:26	
Parameters Setting				User:engineer			
Device Name:		AF-5K StepMotor/Serov Packing Scale					
Model :		AF-5K				COM1 ID Config	
Software Version:		Weighing controller:		Ver:03.02.00		2018/08/08 18:18:18	
		A-U-disk Upgrade					
PLC:							
HMI:		Ver:01.00.02		2018/08/09 18:19:19			
Manufacturer:		杰曼科技					
Support Hotline:		(+86) 0000-00000000					
				HOME		Next Page	

Example diagram of system information (3 pages)

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. Vertical Packing Machine Operation Instructions

8.1 Equipment commissioning

8.1.1 Steps for mounting paper

1、The packaging film is loaded on the paper support tube, and the film is pulled out in a counterclockwise direction.

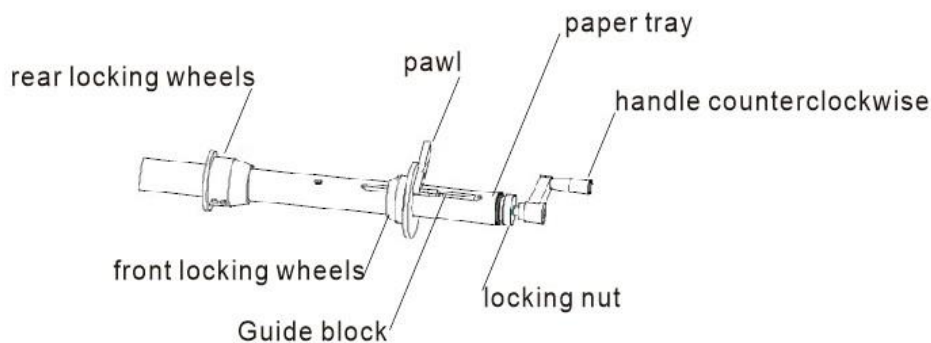


Figure 8-1 Schematic diagram of the paper tube

The operation method is as follows: as shown in Figure 8-1, loosen the locking nut, turn the handle counterclockwise to widen the distance between the front and rear locking wheels, remove the front locking wheel, tilt the rear swing rod mechanism, install the packaging film roll on the paper tray, then install the front locking wheel, insert the front end of the pawl into the slot of the paper tray, clamp it between the guide block and the front locking wheel, install the handle, and turn the handle clockwise, Place the packaging film roll in the center of the paper tray automatically, tighten the lock nut, and put the rear swing rod mechanism back to the original state.

2、Wear packaging film

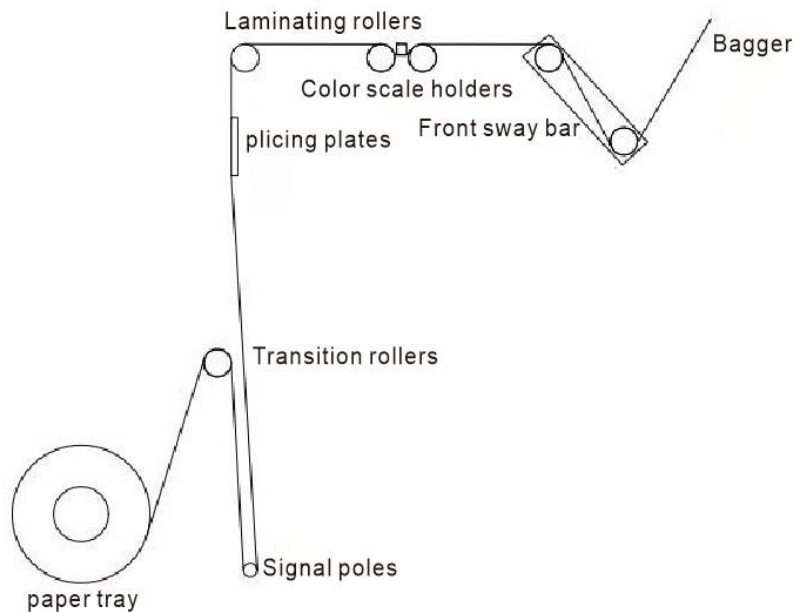


Figure 8-2 Schematic diagram of film bagging

The direction of the packaging film is as shown in Figure 8-2. Pass the packaging film from the surface of the paperboard, through the rear fixed roller, through the code printer, through the electric eye, through the front fixed roller, through the tensioning roller in front of the bagger, out of the bagger, and pull it to the end seal.

When using the same kind of packaging film, when loading the film for the second time, just put the packaging film roll into the paper tray, pull the packaging film to the cardboard, and pull the tail end of the first roll back to the cardboard, and the two are connected, so that the second roll of film can be installed.

8.1.2 Tension adjustment

When the packaging film passes through the bag-forming machine, if the tension is uneven, it will cause the paper to go unsmoothly. It must be adjusted well before starting the machine. The adjustment method is as follows:

1、As shown in Figure 20, first loosen the adjustable handles on the left and right sides;

2、Gently rotate the left and right swing rods forward or backward, that is, swing the tensioning roller to change the relative position of the tensioning roller and the bag-forming device, so as to achieve the purpose of uniform tension when the paper film enters the bag-forming device;

3、After adjustment, the left and right adjustable handles should be tightened.

When working normally, on the tensioning roller, the packaging film is located between the left and right two paper stops, and the center line of the paper film is in a plumb plane with the symmetrical center line of the bag former, if it is not in a plane, the tensioning roller needs to be adjusted. Here's how to adjust it:

1、Loosen the left butterfly twist first;

2、Rotate the adjustment twist on the right clockwise or counterclockwise to move the centerline of the paper film on the tensioning roller to the left or right until the symmetrical centerline is in a plane with the bagger;

3、After adjustment, tighten the butterfly twist.

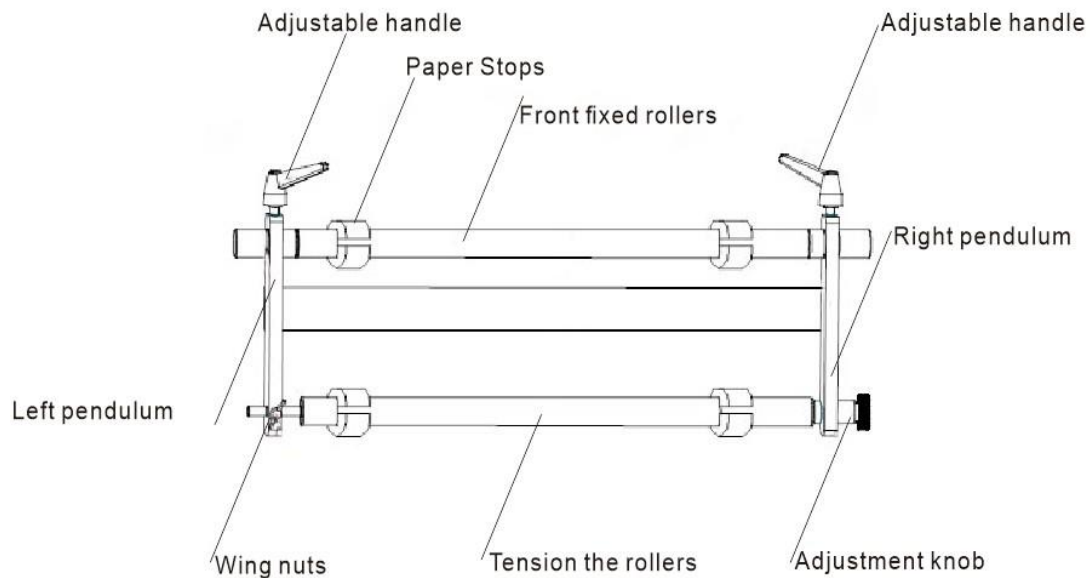


Figure 8-3 Schematic diagram of the front pendulum mechanism

8.1.3 Adjustment of vertical sealing part

The effect of middle seal should be no air leakage and clear lines. Note that the middle seal parts of the machine have been carefully adjusted and strictly inspected before leaving the factory. Generally, they do not need to be adjusted. In normal operation, it is only necessary to adjust the relative position between the left and right cutter bases of the middle seal and the bagger according to the size of the packaging film. Generally, the distance between them is 2mm (see Figure 8). The adjustment method is as follows:

1. Loosen the locking handle A;
2. Turn the adjustment handle clockwise or counterclockwise until the distance between the left and right knife holders and the bag-forming device is about 2 mm;
3. After adjustment, tighten the locking handle A.

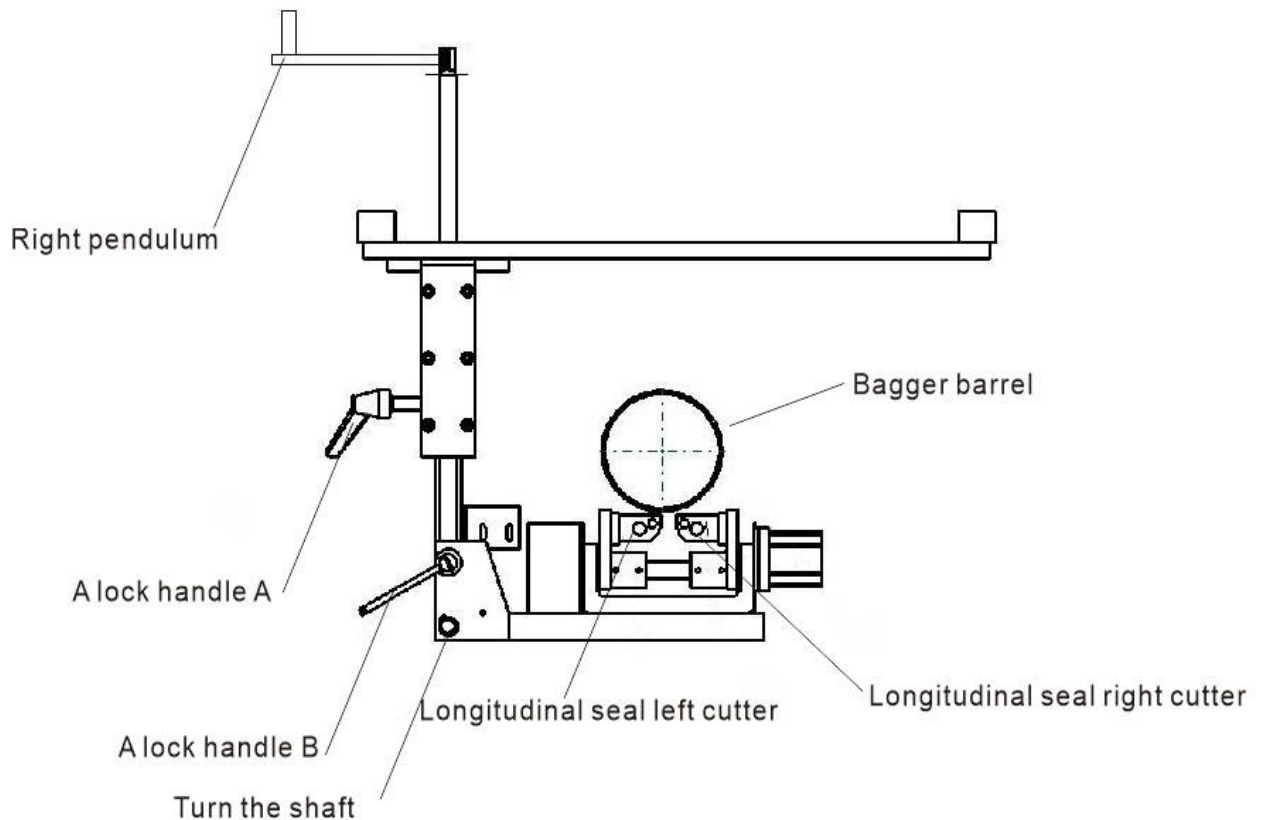


Figure 8-4 Schematic diagram of the middle sealing mechanism

When the packaging film is packed into a bagger, the sealing part of the middle seal needs to be opened, and the opening method is:

1. Loosen the locking handle B;
2. Rotate the sealing part of the middle seal clockwise (rotate around the axis of rotation) until it is perpendicular to the connecting plate of the middle seal.
3. After the packaging film is installed, turn the middle sealing part back to its original state, and tighten the locking handle B.

8.1.4 Use of electric eye tracking system

After the adjustment of the film length setting is completed, the packaging film is installed, the color mark electric eye is adjusted, and the cutting knife position is aligned (that is,

8.1.5 Precautions for the adjustment and use of bag-forming device

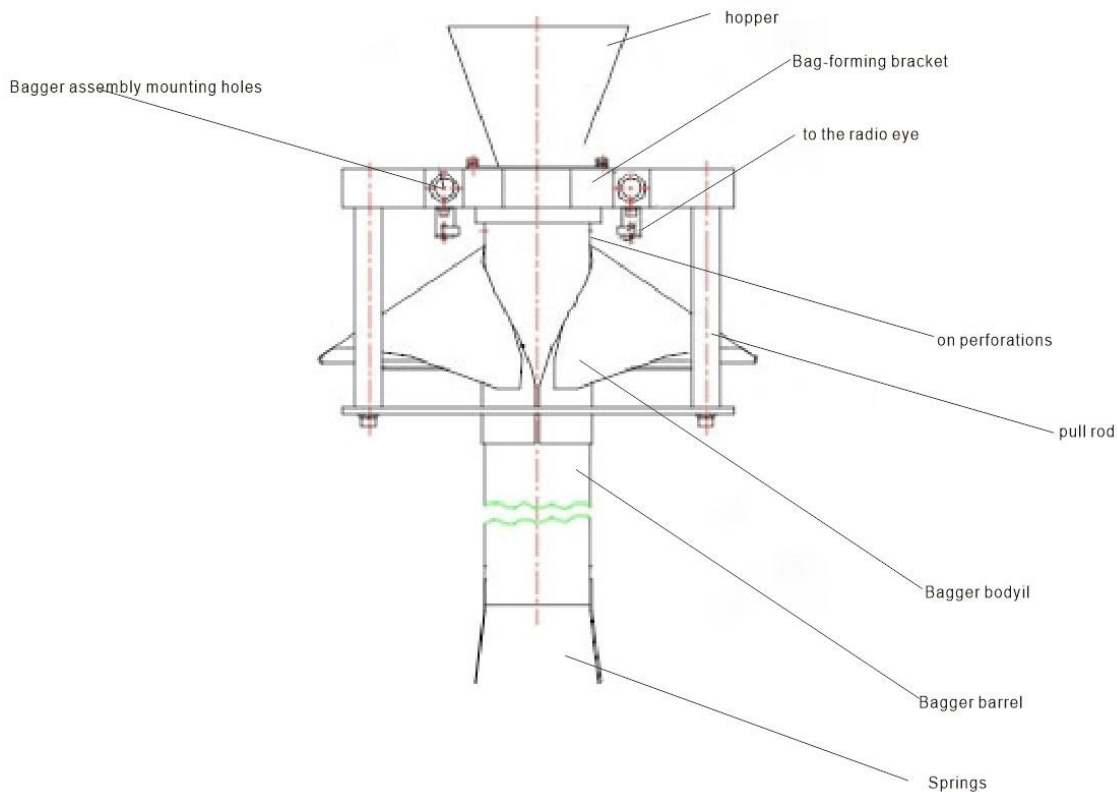


Figure 8-6 Schematic diagram of the bagger assembly

The bagger is located above the front protective cover of the machine. It is composed of the installation support of the bagger and the components of the bagger (as shown in Figure 10). It forms the packaging film here. The adjustment effect of the bagger directly affects the quality of the bag and the paper pulling effect. It is difficult for non professionals to adjust the bagger well. Note: before the machine leaves the factory, the bagger components (including bagger accessories) have been carefully adjusted and strictly inspected. Generally, adjustment is not required.

When the bag-forming assembly needs to be replaced due to the change of packaging film width, it is only necessary to remove the two locking handwheels installed on the mounting holes of the bag-forming assembly, remove the original bag-forming assembly, replace the bag-forming assembly that will be used, and then install and tighten the two locking handwheels.

If the counter-radio eye is used, during the packaging process, the debris in the food will accumulate into the counter-perforation of the bag-forming cylinder, if not removed in time, it will affect the normal operation of the counter-radio eye, resulting in the phenomenon of malfunction of the machine, empty bags, etc.; In addition, accumulated debris can fall between the paper film and the bagger barrel, causing the paper to slip. So be sure to clean up the food crumbs on the perforation frequently.

Note: In the standard configuration, the main unit does not need to be used for the radio eye when it is used with the metering system, such as the combination scale.

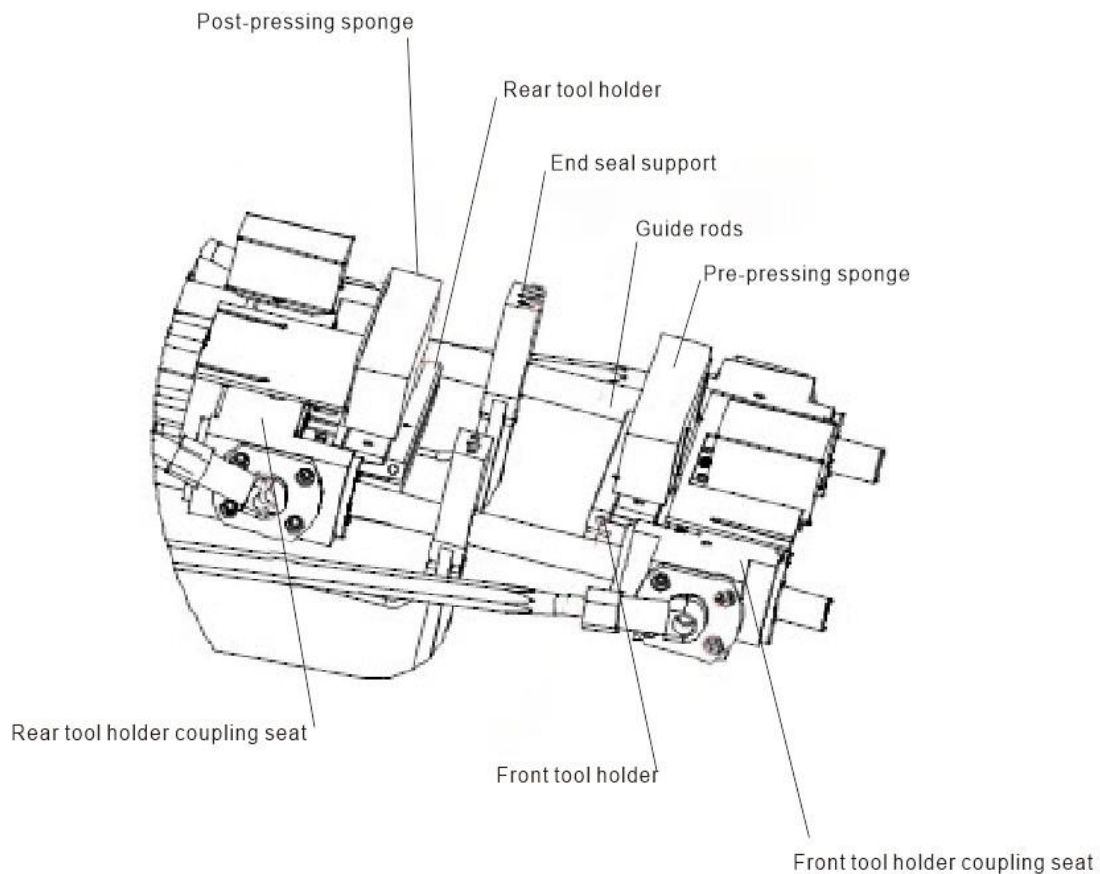


Figure 8-7 Schematic diagram of the horizontal sealing mechanism

Due to the high temperature of the sealing part of the tool holder before and after the horizontal sealing, the packaging film is very easy to adhere to it, and if it is not removed in

time, it will lead to the subsequent packaging bag sealing is not firm. Therefore, it is necessary to frequently brush the sealing parts (teeth) of the front and rear tool holders with a wire brush sticky to silicone lubricating oil, especially the front tool holders. The installation position of the front and rear pressing sponge is related to the air and exhaust of the bag if you want to inflate the bag. If you want to inflate the bag, as shown in Figure 8-7, the front and rear pressing sponges are respectively installed on the upper surface of the front and rear tool holder connection seats.

8.2 Operating Instructions

8.2.1 The vertical packaging machine is mainly operated

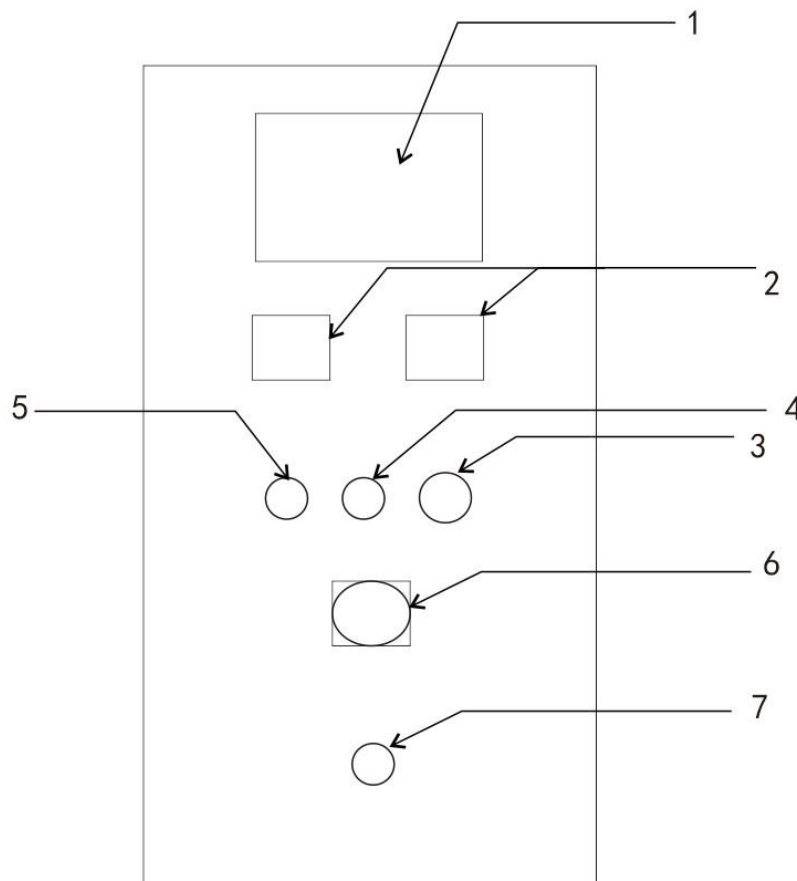


Figure 8-8 Schematic diagram of the main operation

Figure 8-8 shows the following examples:

- 1 is the operation touch screen;
2. It is the longitudinal seal and horizontal seal temperature controller of the packaging machine;
- 3 is the emergency stop button;
- 4 is the stop button;
- 5 is the start button;
- 6 power switches;
- 7 is the power socket of the discharge belt.

8.2.2 Initial Interface

Please select the language to enter the system, as shown in Figure 8-9:



Figure 8-9 Initial Interface Diagram

8.2.3 Operation interface

As shown in Figure 8-10:

Stop		Product		
Length	150 mm	Empty Yield	543	Clear
Film Speed	9.5 Lv.	Yield	2046	Clear
Speed	60 p/min	Act speed	0	
Chain bag	0	0	Clear	Start
Pre-count OFF	0	0	Clear	
Production		Marker ctrl	Run once	Long Bag
Operation	Function	Time Set	Parameter	Alarm
Return				

Figure 8-10 Operation Interface

1. In the upper left corner, there are "Running Stop..." and "Running..." indicates the current state of the machine.
2. If "the operation stops... When there is a "alarm not reset" flashing at the back, it means that the packaging machine is in the alarm state and cannot start running, you need to click on the alarm screen below to view the alarm content, and remove the fault, click "reset", so that the machine can start running in a normal state.
3. There is "current product" in the upper left corner: click on the back box, (if you do not log in to the touch screen, you will jump out of the prompt level login, click to log in, enter the level login screen, enter the password "8888" and click "ENT", and then click the back button, you can.))

4. In the upper right corner, the current product button enters the product selection interface, as shown in Figure 8-11, you can save 6 kinds of product parameters, and when using, select the corresponding product;

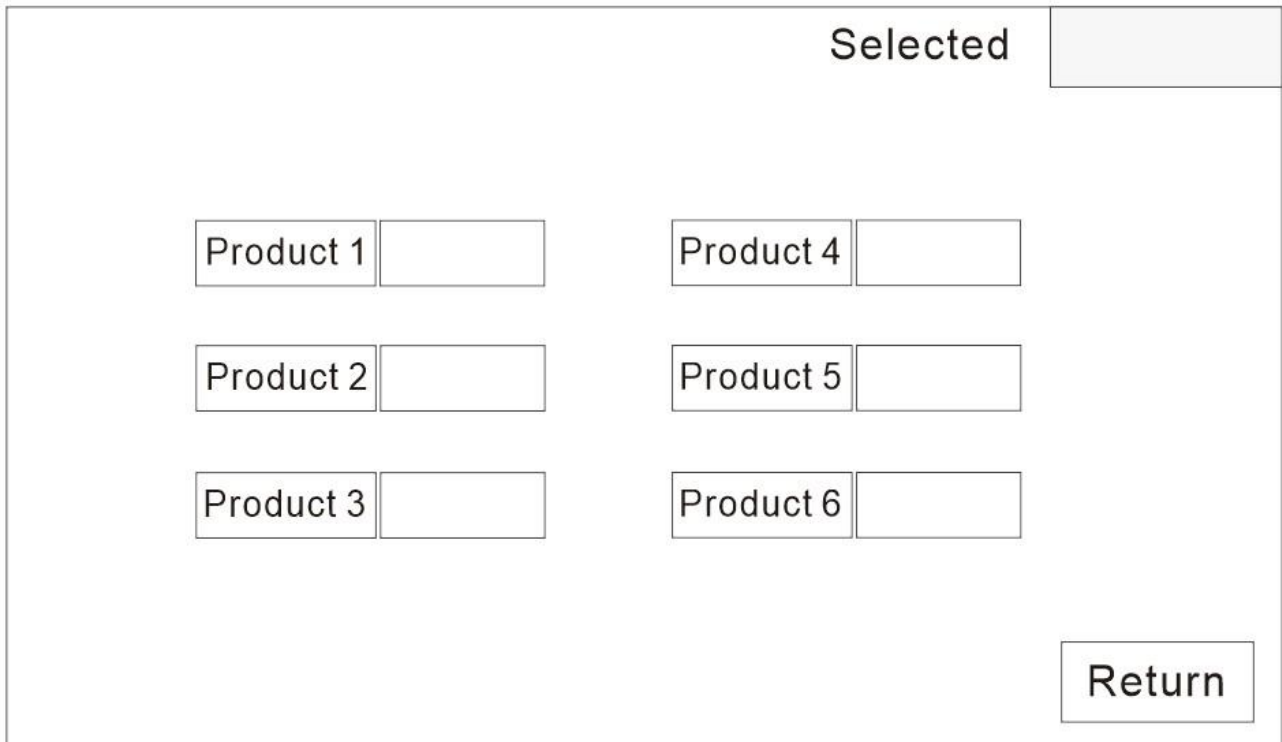


Figure 8-11 Product Interface

5. "Bag length" sets the length of the packaging bag, due to the difference of the packaging film, may cause the difference between the set value and the actual value, the set value can be adjusted appropriately, so that the actual needs are met.

6. "Packing speed" sets the running speed of the packaging machine, the setting range is 10-120 bags/min, the running speed of the packaging machine is affected by many factors, so the set speed is not equal to the actual speed, and the parameters of the packaging machine need to be adjusted in order to achieve the ideal speed.

7. "Package" sets the number of packages, and the frameless number display at the back indicates the number of packages that have been recorded, and when the number of packages reaches the set value, the cutter will cut off. Each time you set the value of a

linked package, you should click the "Clear" button after the number of consecutive packages to clear the current continuous package count.

8. "Number of Produced Packages" and "Number of Empty Packages" show the cumulative production quantity of the current packaging machine in the corresponding mode, which cannot be set. You can click the clear button at the back to clear the production quantity.

9. "Empty bag mode/production mode" switch state, no product is filled in empty bag mode, product is filled in production mode; Adjust the machine in the empty bag mode, when the machine runs stably and the bag type meets the requirements, in the shutdown state, switch to the production mode, click the start button, and the equipment starts production.

10. "Continuous operation/single cycle", in the continuous operation state, the equipment runs continuously, and the stop button can be stopped by clicking the stop. (Take a picture of the emergency stop button, or the machine alarm, the machine shutdown is an abnormal alarm!))

11. "Fixed-length control/color mark control" switch state, the length of the packaging bag under the fixed-length control is determined by the set value, and the bag length under the color code control is controlled by the color mark on the packaging film, but the bag length should still be set, and the bag length setting should be set to the distance between the two color codes.

12. "Make long bag" in the shutdown state, click once, make the bag once.

13. After the "preset counting" is turned on, the production of the packaging machine starts to count, and the counting is according to the state of the shutdown switch. If the downtime is displayed, after the time is set, the counting will be carried out until the packaging machine is paused, and the operation will automatically start to continue counting.

8.2.4 Parameter setting interface

The timing is set as shown in Figure 8-12, and the setting range is 0-2.00S. The function of the delay time is to leave it to the film pulling action, as long as the time is enough to pull the film. The operation time is performed once at the set operation time for

the corresponding function after the delay time has expired. (Table 1 shows the values set for the corresponding time, which is for reference only and is generally applicable.))

		Delay		Action	
Vertical-seal		0.25		0.40	S
End-seal		0.25		0.45	S
Cutter		0.30		0.20	S
Code		0.20		0.20	S
Inflation		0.00		0.00	S
Cooling time				0.00	S
Operation	Function	Time Set	Parameter	Alarm	Return

Figure 8-12 Timing Setting Interface

1. "Longitudinal sealing" according to the characteristics of the packaging film, the set temperature, and the speed of the film to set the appropriate time, the middle seal will delay the time to the set time action once. Each cycle starts with the film pulling, so if necessary, the longitudinal seal should be jogged once at the function setting interface.
2. "Horizontal seal" is the same as vertical sealing,
3. "Cutter" sets the delay time and action time, starting from the horizontal sealing action signal, and the delay time arrives, so as to set the action time and action once.
4. "Coding" is the same as the cutter, and the delay time timing starts from the completion of the horizontal seal pull-down.
5. "Inflation" is the action before sealing the horizontal sealing action to inflate the packaged product.

6. "Cooling and blowing" blows and cools the sealed product, and the time is set according to the actual situation.

Table 1 Time setting reference

Time function	The range of the delay value	The range of action values
Middle seal	0.2-1.0	0.3-2.0
Horizontal sealing	0.3-1.2	0.3-2.0
Cutter	0.2-0.6	0.1-0.6
print	0.1-0.3	0.2-0.8
aeration	0.2	0.2
Cool and blow		0.1-2.0

8.2.5 Function setting interface

If necessary, click the switch button of the corresponding function to turn it on. If it is off, the actuator will not operate during operation.

In the shutdown state and there is no alarm, click the jog button to correspond to the function action.

Vertical-seal	ON	JOG	Film-pulling	ON	JOG
End-seal	ON	JOG	Inflation	ON	JOG
Cutter	ON	JOG	Cutter2	ON	JOG
Code	ON	JOG	Film-releasing	ON	JOG
Cooling	ON	JOG	Discharge	ON	JOG
Operation	Function	Time Set	Parameter	Alarm	Return

Figure 8-13 Function Setup Interface

8.2.6 System Setup Interface

Scale Set	ON	Scale Set
Film-releasing set	Discharge set	
IO	<div> <div> X0 X0 Vertical-seal Heat Alarm</div> <div> X1 X1 End-seal Heat Alarm</div> <div> X2 X2 Color Marker</div> <div> X3 X3 Start</div> <div> X4 X4 Stop</div> <div> X5 X5 EMG</div> <div> X6 X6 Servo Alarm</div> <div> X7 X7 Code Alarm</div> </div> <div> <div> X10 X10 Vertical-seal sensor</div> <div> X11 X11 End-seal sensor</div> <div> X12 X12 Film-releasing sensor</div> <div> X13 X13 Film-Stop sensor</div> <div> X14 X14 No-Film sensor</div> <div> X15 X15 NC</div> <div> X16 X16 Scale Signal</div> <div> X20 X20 NC</div> </div> <div> <div> Y0 Y0 Pluse</div> <div> Y1 Y1 NC</div> <div> Y2 Y2 Vertical-seal</div> <div> Y3 Y3 End-seal</div> <div> Y4 Y4 Cut</div> <div> Y5 Y5 Cut2</div> <div> Y6 Y6 Code</div> <div> Y7 Y7 Film-releasing</div> </div> <div> <div> Y10 Y10 Discharge</div> <div> Y11 Y11 Belt Compression</div> <div> Y12 Y12 NC</div> <div> Y13 Y13 Inflation</div> <div> Y14 Y14 Cooling</div> <div> Y15 Y15 Scale</div> </div>	

Figure 8-14 System Settings Interface

There is input and output point monitoring at the bottom of the screen for equipment failure debugging.

1. Release setting

Select the "film release is three electric eyes" mode, that is, "film release (top)", "stop film (bottom)", and "no film (middle)" three electric eyes to control the action of the film release motor, the film release detects that the signal film release motor starts to act, and the film stop detects the signal to stop the film. If no film detects a signal, it will alarm and stop, and the alarm content is no film alarm.

Select the mode of "single electric eye film release", that is, it is an electric eye to detect and release the film, and every time a signal is detected, the film release motor will stop the film release after the time set by the "single electric eye film release time". When the film is continuously pulled to the number of times set by "single electric eye film pulling allowable without film release", and the film release signal is still not detected, the alarm will be stopped, and the alarm content is no film alarm. This machine is factory set to three-electric eye discharge mode.

Film-releasing Set			
Film-releasing Jog		Three Sensors	
Film-releasing time	0.20	S	Timeout
		0.30	S
Film-pulling Times With No Film-releasing		003	C
			Return

Figure 8-15 Setting up the film release interface

2. Discharging setting

The discharging action of this machine can be set by default when the discharging is turned on in the test mode, and when it is necessary to operate in the empty bag or shutdown state, it can be set to this point.

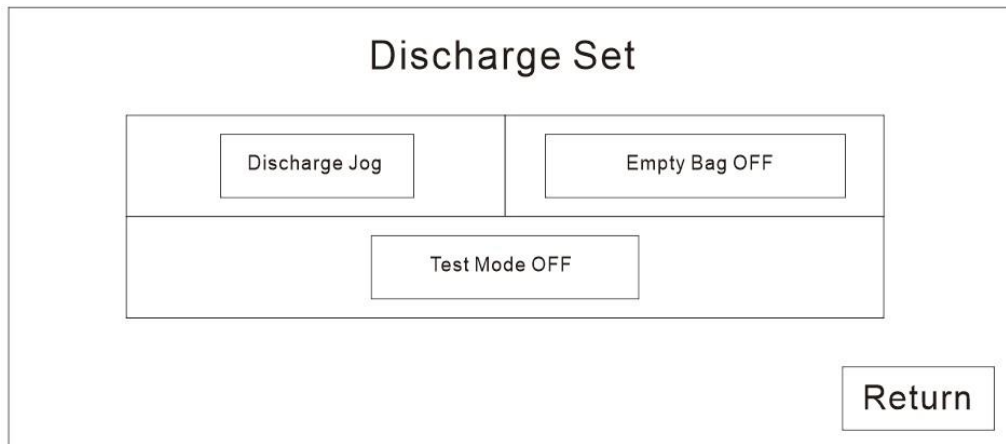


Figure 8-16 Discharge Setup Interface

3. Detailed settings



Figure 8-17 Combination scale setup interface

Equipment production, packaging machine action delay, packaging machine after receiving the scale feedback signal, delay this set time after the action,

When it is set to run continuously, after the delay time of the packaging machine's action is up, the timing of the re-request delay will be started, and the timing will be sent out again.

Long signal/short signal selection, under normal circumstances, the long signal is selected, when the long signal is selected on, the electronic scale of the packaging machine has kept the output until the electronic scale output blanking completes the signal reset output. When the short signal is selected to open, the output of the electronic scale of the packaging machine will automatically reset at about 0.2S, and the same electronic scale signal will be sent out again after waiting for the feedback signal of the electronic scale.

8.2.7 Alarm interface

As shown in Figure 8-18, when the machine has an alarm, the interface will automatically jump to the alarm interface, according to the alarm event, remove the fault, click the reset button, and the interface will automatically jump to the operation interface!

Stop		Event Log			10:02:26	
Serial No.	Trigger date	Trigger time	content	Recovery time	R E S E T	

Operation	Function	Time Set	Parameter	Alarm	Return
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Figure 8-18: Alarm interface

Fault events and solutions:

1. Emergency stop The emergency stop of the device is photographed, rotate the emergency stop button, release the emergency stop, and click the reset button.
2. The packaging material is finally detected by the sensor that detects the packaging material, reinstalls the new roll film, and clicks to reset.
3. The safety door is not closed The front door and side door (acrylic door) of the device are opened or not closed, ensure that the two doors are completely closed, click to reset.
4. Servo alarm with screw servo alarm.
5. Coding alarm The ribbon of the coding machine is not detected, or it is used up.
6. Lack of material alarm The material in the silo is insufficient, add the material, click to reset.
7. Poor position of longitudinal seal The position of the longitudinal seal is not closed, confirm that the position is correct, and click reset.
8. Stirring overload The stirring motor is overloaded, confirm the overload cause and release it, click the reset button on the overheat protection relay protecting the stirring motor, and click reset.
9. Feeding overload The stirring motor is overloaded, confirm the overload cause and release it, click the reset button on the overheat protection relay that protects the stirring motor, and click reset.
10. The temperature of the longitudinal seal is abnormal, and the difference between the actual temperature of the longitudinal seal tool seat and the setting exceeds the error setting value, and when the temperature is restored, click to reset.
11. The temperature of the horizontal seal is abnormal, the actual difference between the temperature of the horizontal seal knife seat and the setting exceeds the error setting value, and when the temperature is restored, click to reset.
12. Abnormal color mark tracking In the color mark mode, the color mark is not captured, confirm that the color mark sensor can detect the color mark, and the color mark needs to be adjusted! Click Reset.

8.2.8 Operational Operations

Through the adjustment of the above steps, the machine can be in normal production, but before normal production, some inspection and trial operation should be carried out.

1. Pre-operation inspection items (pay attention to personal safety)

- 1) Whether the pressure of the instrument is normal;
- 2) Whether the pneumatic device is leaking;
- 3) Lubrication of each part;
- 4) Whether there are people or sundries in the forbidden area where the equipment is running;
- 5) Whether the control switch and indicator light are flexible and easy to use;

Special attention: Before starting the machine, the debris in the barrel, knife holder and packaging film should be cleared, so as to avoid damage to the cutter caused by mistakenly cutting debris when starting the machine. The packaging film tension adjustment roller, the outer surface of the bagger and the photoelectric probe should be kept clean.

2. Packing machine operation steps

- 1) Open the air source valve;
- 2) Turn on the main power switch, heating switch, and temperature control switch
- 3) Confirm whether the system is powered on, and observe whether there is alarm information;
- 4) If there is an alarm message, refer to the system maintenance and troubleshooting chapter or the manual of the faulty equipment to troubleshoot;
- 5) According to the production of products, through the touch screen, call the corresponding product data. For details about how to call the touchscreen, see Touch Screen Settings in the Debugging article.

6) Press the "start" button, and the machine enters the running state.

3. Carry out trial operation

Test run, check whether the packaging effect is good, if it is good, enter normal production, otherwise, make relevant adjustments, see the debugging for specific adjustment methods.

4. Monitor the project in operation

- 1) Whether the pneumatic device is leaking;
- 2) Whether the action of each component is coordinated;
- 3) Whether the sealing effect is ideal;
- 4) Whether the operation of the motor is normal, whether there is abnormal noise or overheating.

5. Stop the packaging machine

※ Normal parking

Under normal circumstances, press the "Stop" button on the control panel.

※ Emergency stop

In case of emergency, press the "emergency stop" button on the control panel and the machine stops immediately and locks itself, so to unlock it, simply turn a little to the right.

9. Basic Function description

9.1 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. After the automatic quantitative unit is fixed, the input signal from the vertical packaging machine is effective, and the output is discharged. After the unloading is completed, the automatic quantitative unit outputs a packaging completion signal to the vertical packaging machine after receiving the signal, and begins to seal the bag.
10. After a basic packaging process is completed, the next packaging process is carried out, and the delay time before starting the feeding..

9.2 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 \leq feeding result \leq 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.

10. Common failure analysis and troubleshooting

Common faults in use, causes and handling methods.

1. Automatic quantitative unit.

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 number of combinations of single scales is not set to 0	1. Set the corresponding combination times as required
3	The actual weighing has been out of tolerance	1. Equipment not calibrated 4. 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
7	After the fixed value, the material is directly discharged without bagging	Whether the pinch loose bag request and unloading are not defined	Confirm and modify the corresponding parameters
8	After starting, turn off Quick Plus when the amount is not enough	Check whether the disconnection function is enabled	Confirm and modify the corresponding parameters
9	Drive reported E100	Overcurrent alarm	1. Check whether U, V, and W are reversed or short-circuited 2. Check whether there is a short circuit inside the motor 3. Check whether a short circuit has occurred inside the servo drive

2. Packing machine.

The serial number	The fault phenomenon	fault	To deal with
1	Electric eye positioning	<ol style="list-style-type: none"> 1. The length of the bag is not set accurately. 2. The tensioning roller is too dirty. 3. The electric eye does not respond. 	<ol style="list-style-type: none"> 1. Reset the length 2. Clean up the dirt and black spots on the tensioning roller. 3. Check whether there is any problem with the color code, adjust the distance between the electric eye and the packaging film or the sensitivity knob on the electric eye, when the color code is aligned with the electric eye, the red light on the electric eye should be extinguished, the color code should be removed, and the red light should be on
2	The horizontal seal is not firmly sealed or the film is rotten	<ol style="list-style-type: none"> 1. The temperature is not enough or too high. 2. The tool holder is not clean. 3. The front and rear tool seats are misaligned. 4. Poor paper. 5. The horizontal sealing pressure is not enough. 6. The pressure delay is not enough. 	<ol style="list-style-type: none"> 1. Adjust the temperature appropriately. 2. Use a wire brush to glue the silicon sliding brush to remove the debris on the tool holder. 3. Readjust the tool holder. 4. Change the paper. 5. Adjust the throttle valve of the horizontal seal cylinder. 6. Re-set the end seal delay time through the touch screen.
3	The temperature control meter does not control the temperature or does not display	<ol style="list-style-type: none"> 1. The heating element is damaged. 2. The solid state relay is damaged. 3. The thermocouple is damaged. 4. The temperature control meter is damaged due to excessive voltage or instability. 5. The plug-in terminal is loose. 	<ol style="list-style-type: none"> 1. Replace the heating element. 2. Replace the solid state relay. 3. Replace the thermocouple. 4. Replace the temperature control meter. 5. Re-tighten the terminal.
4	The longitudinal seal is not	<ol style="list-style-type: none"> 1. The temperature is not enough or too high. 2. The tool holder is not 	<ol style="list-style-type: none"> 1. Adjust the temperature appropriately. 2. Use a wire brush to glue the silicon

	firmly sealed or the film is rotten	clean. 3. Poor paper. 4. The pressure of the middle sealing cylinder is not enough.	lubricating oil brush to remove the debris on the tool holder. 3. Change the paper. 4. Adjust the throttle valve of the middle seal cylinder.
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11. 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.

Among them, the maintenance and inspection of vertical packaging machines are divided into three categories, namely daily, monthly and semi-annual.

1. Maintenance and cleaning of the machine every day or shift:

(1) At the end of each shift, the machine should be cleaned;

(2) Before cleaning the machine, turn off the power and make sure the heater is cooled to avoid high temperature burns.

(3) When cleaning, do not spray water or steam directly on the machine;

(4) Areas to be cleaned:

※ If product debris accumulates on the product transportation line, remove it with compressed air or other methods.

※ If film debris adheres to the sealing surface of the longitudinal seal or end seal, brush it off with a wire brush coated with silicone lubricating oil.

* Use a soft cloth to wipe off dirt from the control panel, protective cover, and countertop.

(5) Every time you change shifts, the water in the air filter should be drained cleanly.

2. Monthly maintenance and inspection of the machine:

(1) Add grease to the bearing of the end seal component, and the grade of the grease is 2# general lithium grease (GB7234-87);

(2) Add grease to the chain (wheel) in the transmission parts, and the grade of the grease is 2# general lithium grease (GB7234-87);

(3) Check whether the chain and belt of the transmission parts are tightened, and if they are loose, adjust them;

(4) Check whether the set screws or nuts of each part are loose, and if they are loose, tighten them.

3. Do relevant inspections on the machine every six months:

(1) Check whether the belt (V-belt and paper drawing synchronous belt) of the transmission part is worn, if the wear is serious, it needs to be replaced with a new one.

(2) Check all kinds of wearing parts and pay attention to timely replacement.

(3) Check whether the wiring on the electrical wiring board is firm, if it is loose, fasten it, check whether there is dust or dirt in the inverter and circuit board, and blow it clean with clean and dry compressed air.

Please insist on cleaning and maintaining the machine every day, and check it regularly, so that the machine can give full play to its maximum efficiency, safe production, and maintain good performance for a long time.

- 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