GENERAL MEASURE

B103B-12T

contionous dosing machine
(F01-B meter version applies)

Instruction manual

杰•曼•科•技

Ver A2

CONTENT

Due to the continuous improvement and update of our products, we reserve the right to modify this manual at any time without notice. To this end, please visit our website frequently for timely information.

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

1. An overview

B103b-12t is a kind of dynamic batching control of granualr material distribution scale, by controlling the feeding door, discharging door, discharge door for high-speed quantitative weighing and accurate flow control;Servo motor feeding, high-speed electric push rod control of the discharge door, so as to achieve customer demand flow.

1.1 Product parameters, functions and characteristics

1.1.1 Product parameters

specifications	B103B-12T
Electrical source	AC220V±10%, 50/60Hz, 500W
The quantitative range	0.3 ~ 12 t/h
The weighing accuracy	≤ 0.5% (* Note)
Weighing speed	Maximum 12T /h (* note)
Metering bucket volume	15L
Ultimate load	Instantaneous ultimate load shall not exceed 20kg
Working temperature	In 0 ~ 40 DHS C
Maximum humidity	90% R.H No condensation
Gas source	0.4 ~ 0.6 MPa

* Note: The precision and speed of rice distribution scale will fluctuate under the influence of materials, feeding and other environmental factors. The accuracy and speed are the test data of round grain rice used in the test line of our company.

1.1.2 Product features

1.Automatic quantitative metering function.

2.Support multi-flow segment self-adjustment (0.3-12T /h).

3.Automatic zero clearing, alarm function.

4.Automatic correction function of process control parameters.

5.Accumulator and count function.

6 uniform flow material function.

1.1.3 Product features

1. Intelligent: only set the target flow rate and the total amount of material, the equipment will automatically adjust the appropriate parameters in operation, so that the material outflow evenly.
2. Simple installation: standard external interface flange, fast installation.
3. Data export: built-in USB interface, data record export more convenient.
4. Simple operation: 7 inch touch screen, Chinese and English display.
5. Material: Contact material part adopts 304 stainless steel.
6. High speed and high precision quantitative ratio: servo motor drives the gate feeding (free blanking), electric push rod controls the discharge valve, which is fast and accurate.
7. The system has the characteristics of rapid and accurate weighing, stable and reliable flow performance, convenient operation, complete function and so on.

2. Precautions for safe use

2.1 Safe operation

Before installing and using the product, you should read the product instruction carefully and have the professional debug the device.

2.1.1 Basic Safety Instructions

1. The power supply complies with the requirements of this manual, and the grounding of the device complies with the requirements.
2. Before starting cleaning, maintenance and repair, turn off the power and air source.
3. Only use cleaners that do no damage to mechanical and electrical equipment.
4. The mounting frame connected with this product should be firm and firm.
5. Please cut off the power and air source when installing the metering bucket.
6. Metering bucket, parts connected with the sensor and sensor are not allowed to knock, overload and other damage to the sensor behavior.
7. The equipment is not allowed to extend any part of the body into the equipment in the process of use, and the scale body door has been installed firmly 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 machine is operated. For details, please contact the relevant local authority.

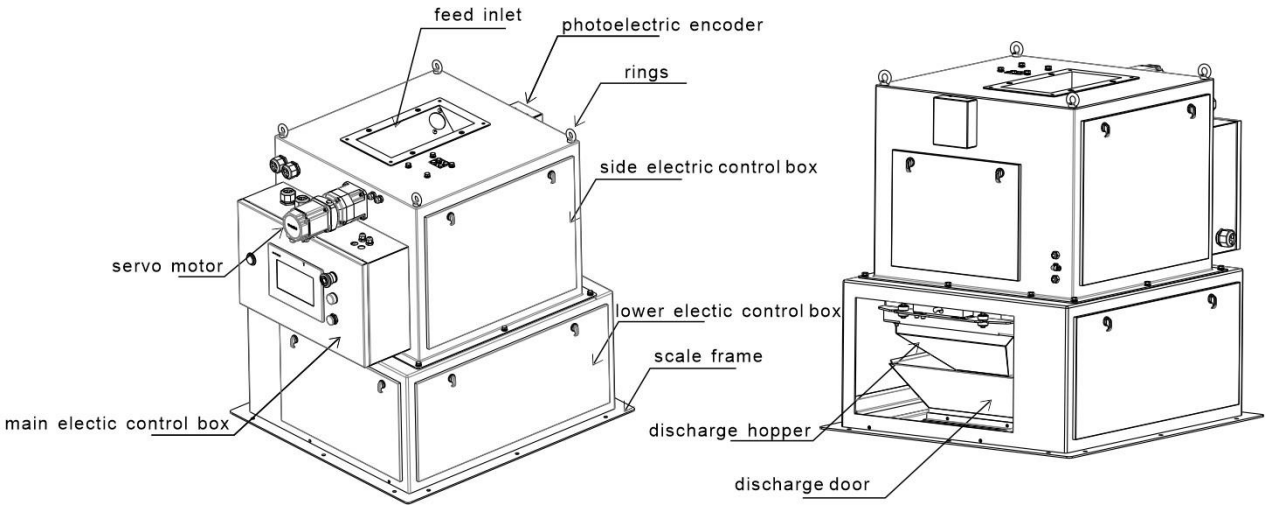
2.1.2 Operating Safety Instructions

1. To avoid dangerous accidents, only one person is allowed to operate the machine. Multiple people are not allowed to operate the machine at the same time.
2. The machine can only be operated by people who have received formal training.
3. Before running the machine, the operator (or whoever is responsible for operating the machine) must read and fully understand the operation instructions, especially the safety instructions and safety regulations.
4. Before running the machine, the operator must check that the scales are working properly and that the fixing and appearance of the machine are in order.

5. In case of danger, please immediately click the "emergency stop" button on the main interface or immediately disconnect the main power supply.
6. For electrical and electronic systems, it is not allowed to modify, replace or carry out any other non-standard operations without permission; Any modification or modification must be carried out by General Measure Technology.
7. When maintaining the equipment, especially when entering the packing area, it is necessary to wear protective devices such as hard hats.
8. Tread carefully when maintaining the platform up and down.

3. Product installation and transportation protection

3.1 Product overall appearance and organization introduction



This product is mainly for granular materials for quantitative proportioning, the material is entered by the feeding port, the quantitative process includes feeding control, weighing type quantitative, discharge control and discharge control, the final material by the discharge door according to the specified flow rate of uniform outflow.The control system of the equipment can automatically correct the process parameters according to the different material and measurement range, reducing the complexity of debugging and maintenance of the equipment, and facilitating the use of supporting customers.When in use, the air source access terminal of 0.4~0.6MPa is required. The power supply and signal communication and control ports (such as serial port connection, USB connection and I/O control port) are located in the electric control box.

Lifting ring: used for hoisting when the device is installed.

Feed inlet: the material to be weighed enters the scale body from here.

Servo motor and reducer: drive the feeding gate action, can make the feeding gate open at different angles, forming different feeding speed.

Photoelectric code plate: used for gate closing position and opening to the limit position of the test.

Main electric control box: inside the main control board, driver, power supply, collection measurement bucket weight, output control signal.

Side electric control box: inside the feeding controller, vibration plate, solenoid valve, relay.

Lower electric control box: inside step driver, M02 instrument, switching power supply.

The frame of the scale body: the outer frame, the upper and lower flange interfaces and the upper and lower stages are connected.

Hopper: Material unloaded from the loading and unloading hopper.

Discharge door: stepper motor controls the opening of the discharge door, thus controlling the flow rate of the material.

3.2 The installation conditions

3.2.1 Equipment installation base, installation conditions

1. Temperature: -10~40℃.

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

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

4. Air source: 0.4~ 0.6mpa.

5. Installation plane: horizontal solid steel support frame.

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

7. Harmful waves: Keep away from the source of strong harmful waves such as wireless devices.

8. Electrical and gas technical parameters are in line with and in place

3.3 Unpack and check

3.3.1 The crates

Read this manual carefully before unpacking.

1. Pay attention to the text and warning marks on the box before unpacking.

2. Before unpacking, 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 omissions.

4. After unpacking, check whether the screws on the devices are loose.

5. Before assembling the device, check whether the metal hoses are intact.

6. After unpacking the whole machine, check whether the scales and moving parts are normal.

7. After the assembly and debugging of the unpacking machine, pay attention to whether the sealing of the part through which the material passes is reliable under the predetermined pressure. This check must be made before starting the machine.

3.3.2 Spare parts for

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

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

3. The original of General Measure Technology Company must be used.

4. The company is not responsible for any loss caused by the use of other parts.

If you have any problem, please contact us in time.

3.4 Product packaging and transportation protection

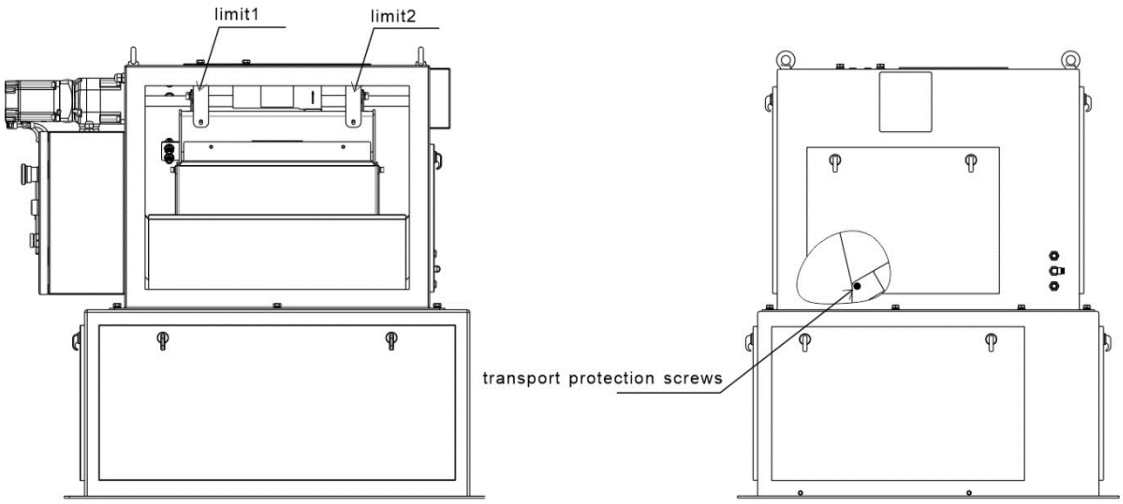
3.4.1 Product packaging requirements

1 Single, double machine two kinds of packing box.

2 Adopts wooden box packing, can be stacked in two layers, GB/T4857.3 transport package basic test, static load stacking test method.

3 Meet the vibration resistance requirements of long-distance highway transportation, GB/T4857.7 transport packaging basic test, sinusoidal vibration (fixed frequency) test method.

3.4.2 Transport protection



1. Before transportation, install and secure the two protection plates and transportation protection screws shown in limits 1 and 2 on the drawing.(Transportation protection screw: prevent damage caused by automatic opening of the unloading door during transportation.)
2. The lower flange of the equipment shall be fixed with nuts to the transport wooden box
3. Wrap the membrane around the surface of the equipment

3.4.3 Remove transport limit protection

After the equipment is unpacked and checked, remove the transportation protection plate and the transportation protection screw at the two positions of limit 1 and limit 2 as shown in the figure, and put the transportation protection plate and screw away for transportation.

3.4.4 Requirements for installation and maintenance of the equipment

1.The operator must accept the company's skills training and safety education, and hold a license.

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

3.Operators must wear short hair or long hair up, clothing and shoes and hats should be easy to work.Safety helmet and insulated shoes must be worn during testing or maintenance.

4.Operators must strictly follow the operating procedures and steps specified in the user manual.

5.Before the equipment lubrication, mechanical adjustment, maintenance and repair, it is necessary to cut off the power supply, turn off the air source, release the residual pressure in the pneumatic pipeline, and hang warning signs at the electric control cabinet, power switch and air source valve.

6.The maintenance and repair of the air pressure system must be carried out in the state of cutting off the power and completely relieving the pressure.

7.Do not operate the production line before all the safety protection facilities of the production line are in place.

8.Do not touch the moving parts of the device after it is energized.

9.Do not enter hazardous areas or cross the line while the line is in operation.

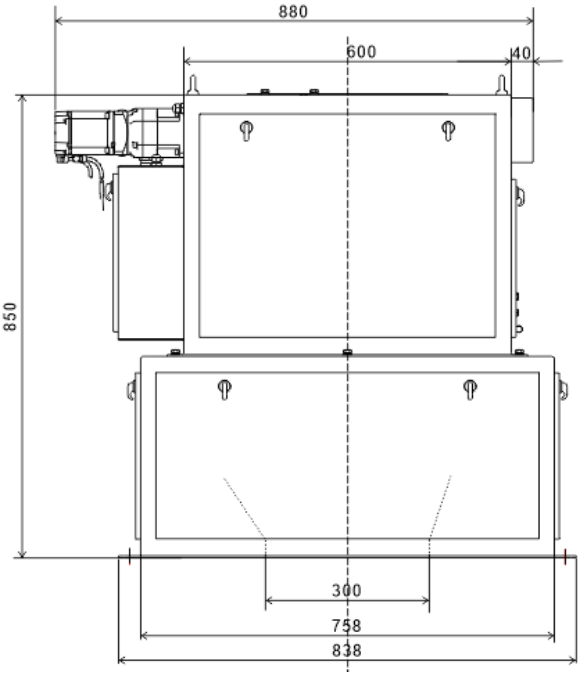
10.Do not modify the control cabinet wiring, motherboard program, drive setting parameters.

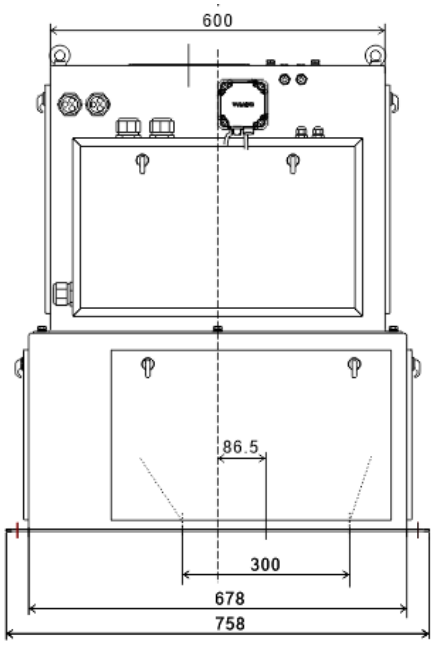
11.The installation tool is reliable and safe, and the person operating the tool understands and appreciates all the safety requirements of the tool

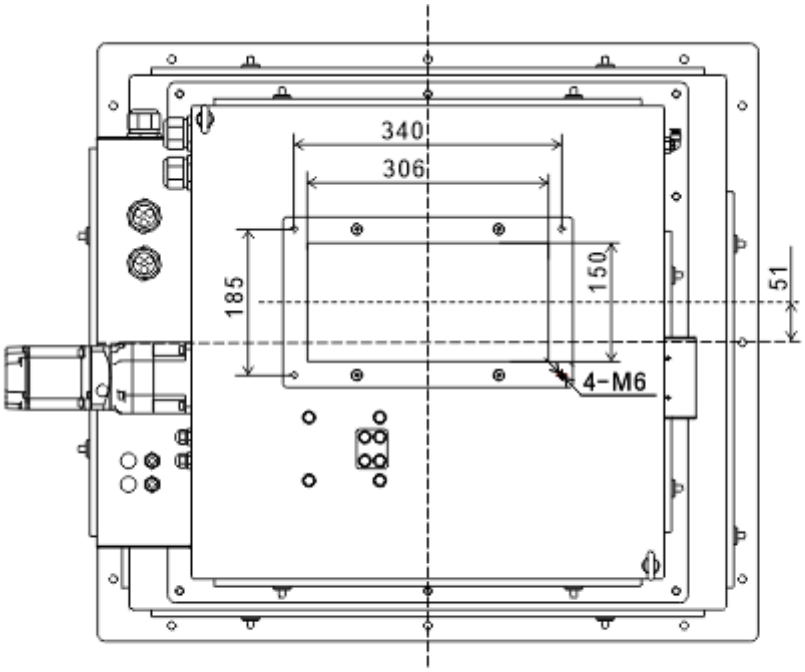
4. Product size

Product size unit: MM

4.1 Overall dimensions



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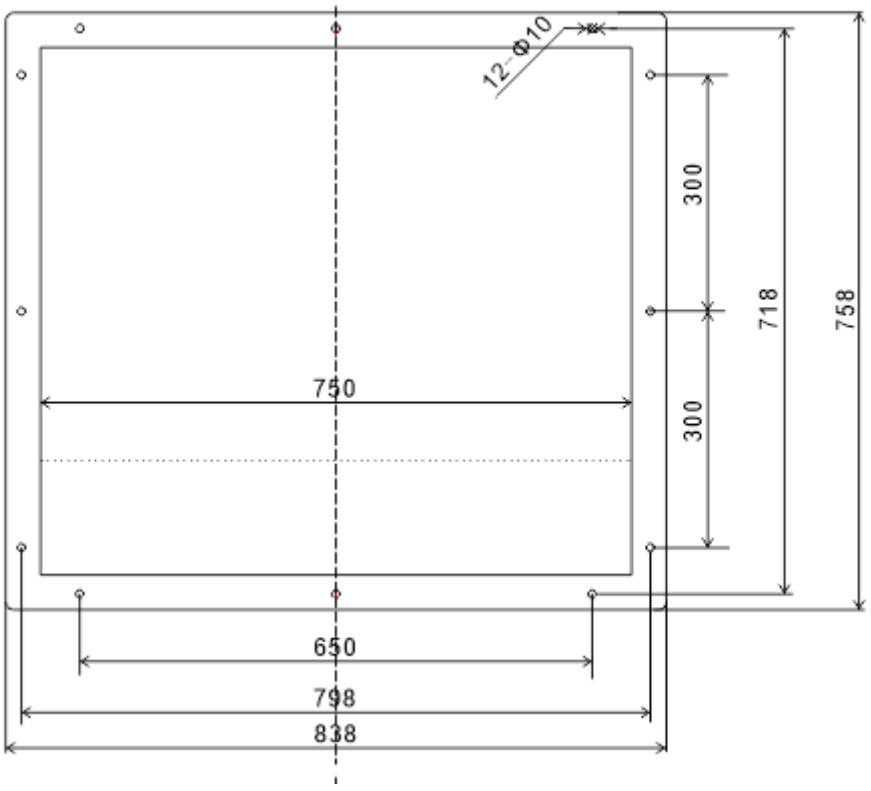
150
51
4-M6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718
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750
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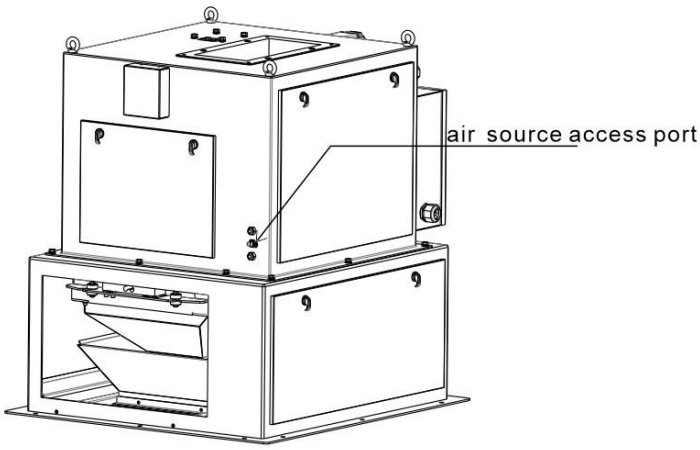
838

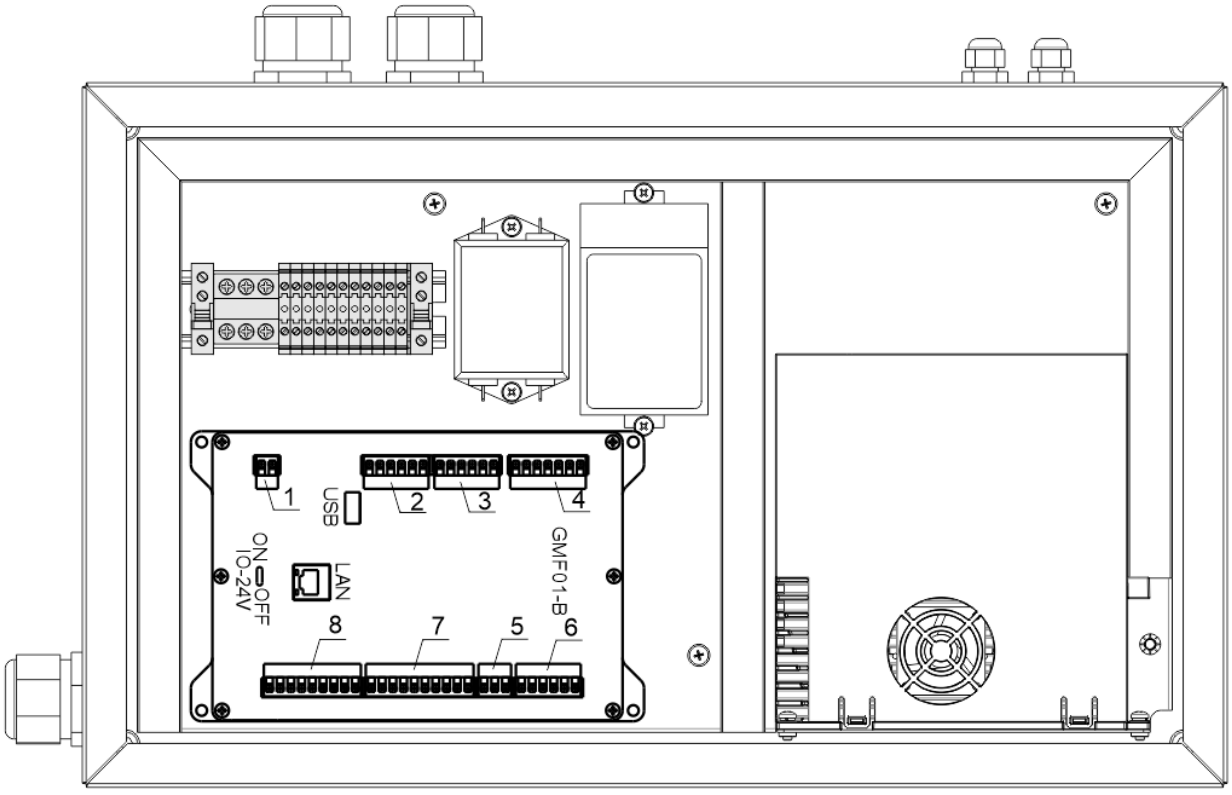
5. Electrical connections

5.1Air supply connection



Air source inlet φ8 air pipe, air source standard: 0.4~ 0.6mpa.

5.2Electrical connections



5.2.1 External interface definition

1: power cable port, 24V power port of the meter (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 ordinary IO port, currently used as feeding motor control.

3: motor control port 2, (M2_24V+ : 24V positive, M2_24V- : 24V negative, PU2: pulse, DR2: direction, ZT2_1: discharge electric mechanism in place, ZT2_2: undefined), can also be used as an ordinary IO port, the current use to make material motor control.

4: sensor wire port, sensor wiring port (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, and serial port 2 (A2, B2, GND2) has been used for M02 instrument communication.

6: RS485 serial communication port, serial port three (A3, B3, GND3), can be used for host computer communication, support Modbus communication.

7: input port, 8 can be customized switch input interface (IN1, IN2, IN3, IN4, IN5, IN6, IN7, IN8), for low level effective, IN3 is set as emergency stop, IN4 is defined as servo alarm input.The definition of all other ports can be selected by yourself.

8: Output port, 8 customizable switch quantity output interface (OUT1, OUT 2, OUT 3, OUT 4, OUT5, OUT 6, OUT 7, OUT 8), in which OUT5 is set to discharge, the definition of all other ports can be selected.

USB: USB interface can carry out a variety of data import and export.

LAN: Network port for networking and data transfer.

Io-24v: Internal use.

5.2.2 Wiring instructions for switch quantity interface

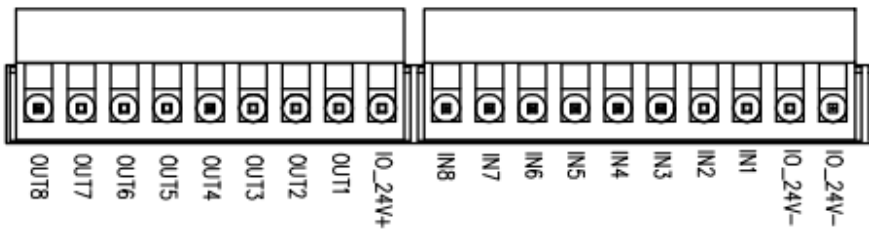
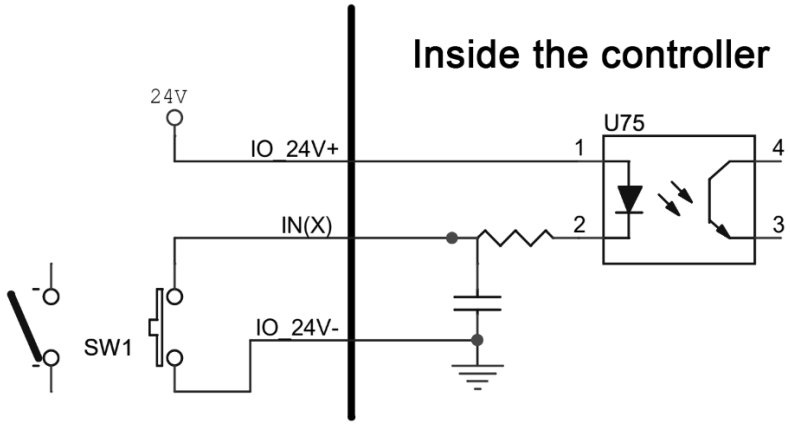
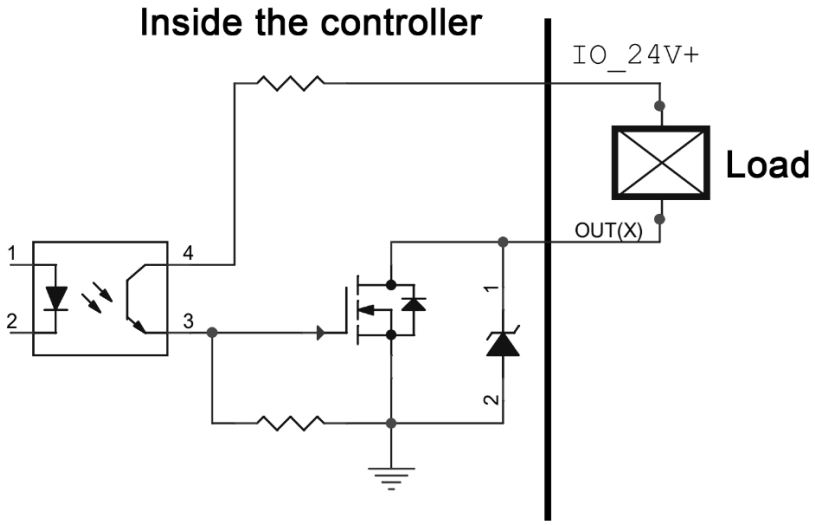


Diagram of switch gauge interface

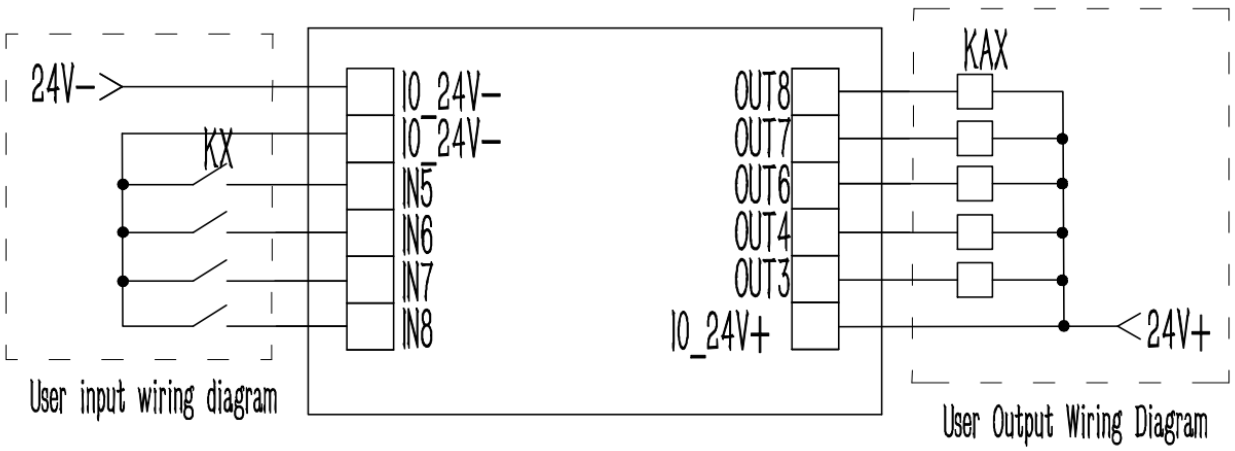
Switching quantity adopts photoelectric isolation mode.If users need to use the switching interface, they need to provide and access the DC24V power supply.The switching quantity input is valid at low level;Output adopts transistor collector open-circuit output mode, each drive current up to 500mA.



Schematic diagram of input interface



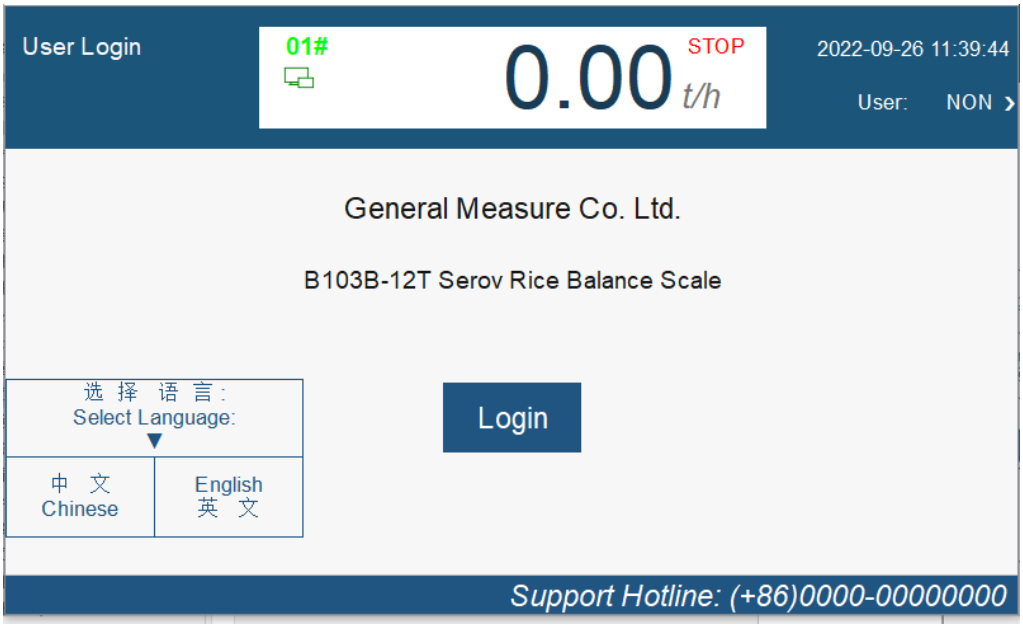
Output interface schematic



Schematic diagram of user input and output port wiring

6. Touch screen operation instructions

6.1Login screen



Parameter description: After boot before login interface. The display information can be customized in the system information page, and automatic login can be set in the user interface.

6.2Touch screen login permission description

Parameter Description:

1: Login information, showing the level of the currently logged in user.

2: System date and time, the date and time of the current system.

3: device working status, current device status indication.

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

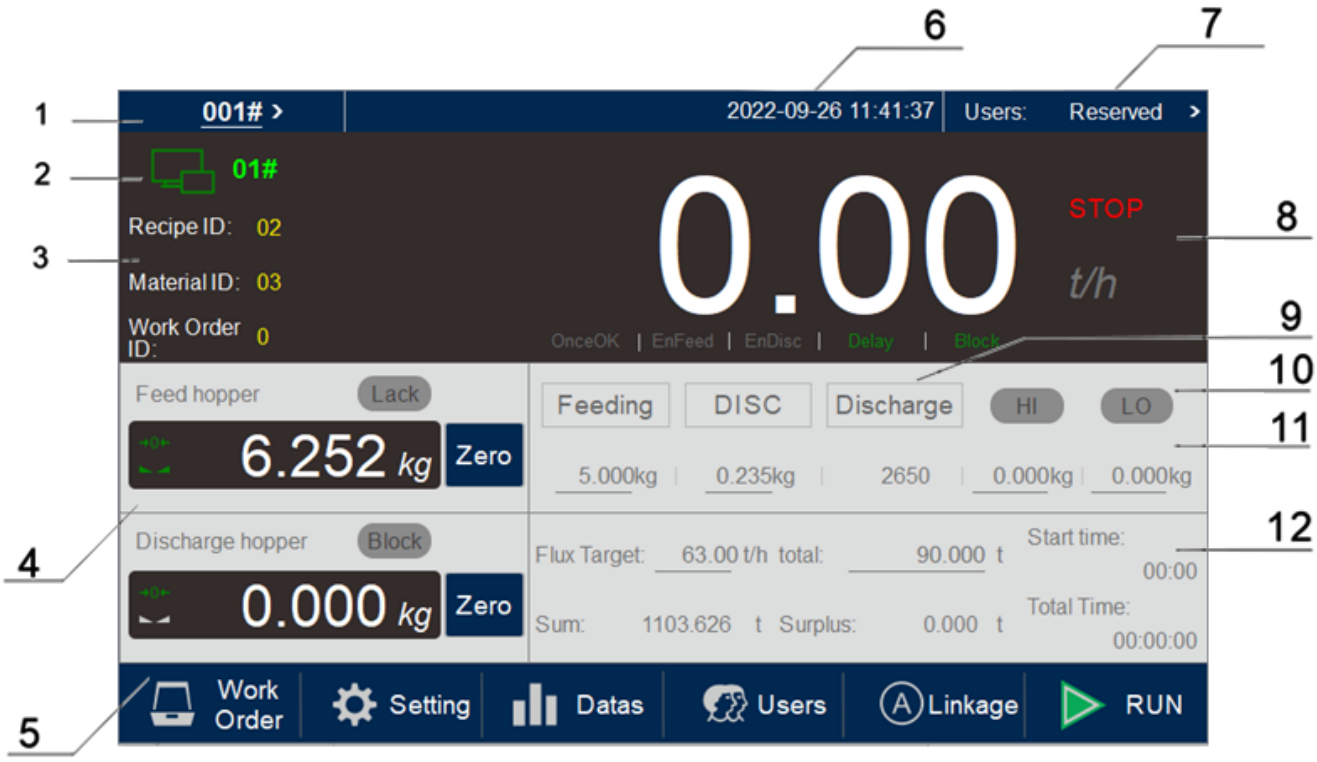
5: Log in to the user selection area and display all the current selectable users.

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

The user name	The user	password	permissions
Admin	The administrator	0	Do not: calibrate scale/switch

			quantity/motor parameters, etc
Operator01	01 operators	1	Do not: calibration scale/switch/motor parameters/system information and other Settings.
Operator02	The operator.	2	
Operator03	The operator 03	3	
Engineer	The engineer	Obtain the password from the manufacturer	Unlimited operation
Reserved	keep	No action for the user	No action for the user

6.3Home Screen Instructions



Parameter Description:

1. Identification box ① indicates the number of the current device (scale number) :

2. Logo box ② Communication status: When the communication is normal, the icon is green.

3. Logo box ③ shows formula, material number and work order.

4. The upper part of the identification frame is the weight display of the feed hopper, and the lower part is the weight display of the discharge hopper.

5. ⑤ Main function key area: including work order, setting, data, user, linkage, start and stop, etc

The key.

6. Identifier box ⑥ System time area: Used to display the system time.

7. Identifier box ⑦ Current user information: display the current login user ID.

8. Identifier box ⑧ Traffic display area: used to display the current traffic.

9. Logo box ⑨ Current Status display area: displays the current working status.

10. Logos box ⑩ Level display area: Displays the current level.

11. Shortcut parameter setting area of the marker box: you can quickly set parameters closely related to the running of the meter.

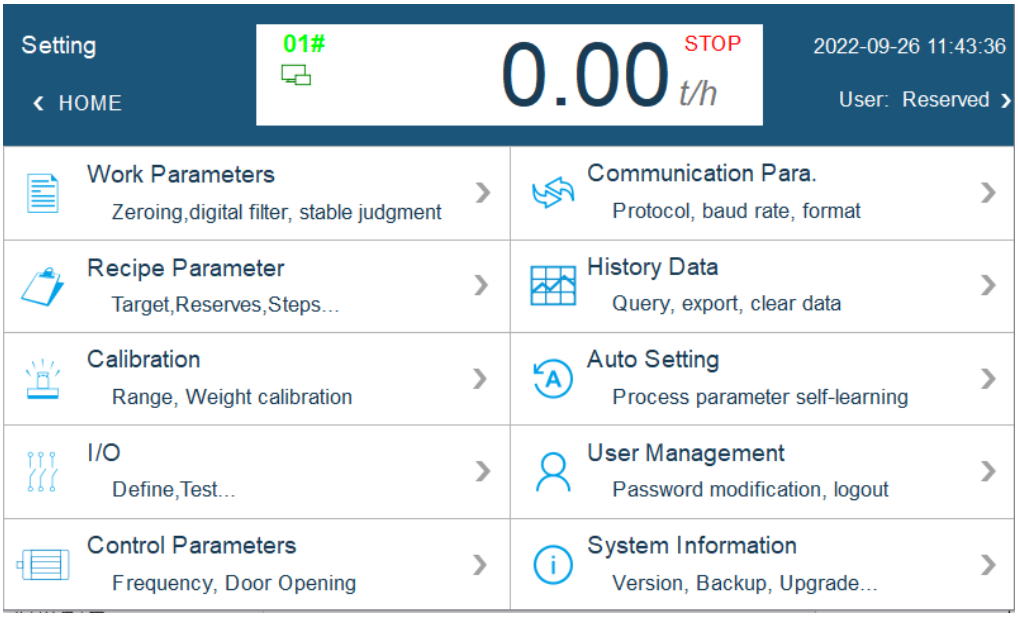
After clicking on the parameters, the current dialog box will be displayed in the upper left corner

Set the name of the parameter.

12. Identifier Box ⑫ Recipe information display area: You can view the total amount of current tasks and current traffic, task workers

Total time spent on tasks.

6.4Parameter setting interface description



Parameter description:

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

Communication parameters: the communication parameters of this product can be set. The serial port 1 is used to communicate with its own touch screen, the parameters can not be modified, but can be adjusted automatically through the serial port;The serial port 2 can be used as an external serial communication interface, and the communication parameters can be set by themselves, but they should be unified with the communication device (see 6.10 Communication interface description for details).

Formula parameters: the current formula number can be modified, as well as the current formula parameter value modification, such as modification of the lead, the opening of the material door, unloading time, etc.

Historical data: the historical data interface can query the previous packaging records, and the packaging record data can be exported to the U disk.

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

Automatic scale adjustment: 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, If abandoned, the debugging data will be restored to the factory default data.

On/off quantity: the user can define and set the input quantity and output quantity according to their own needs. The control board has 4 input and 6 output channels (see 6.8 Switch Quantity description for details).

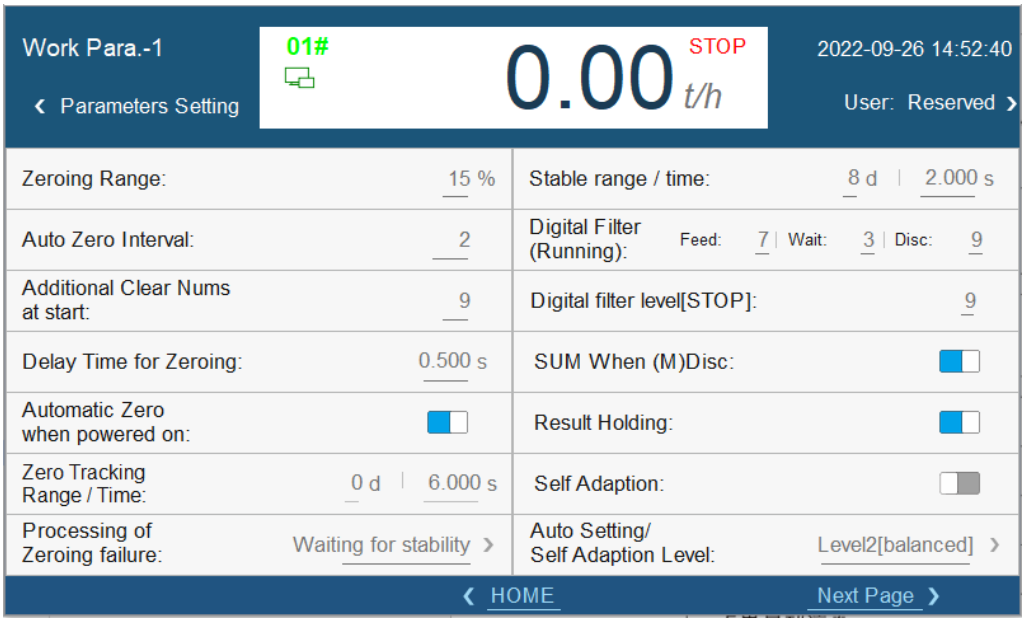
User management: User rights can be switched.

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

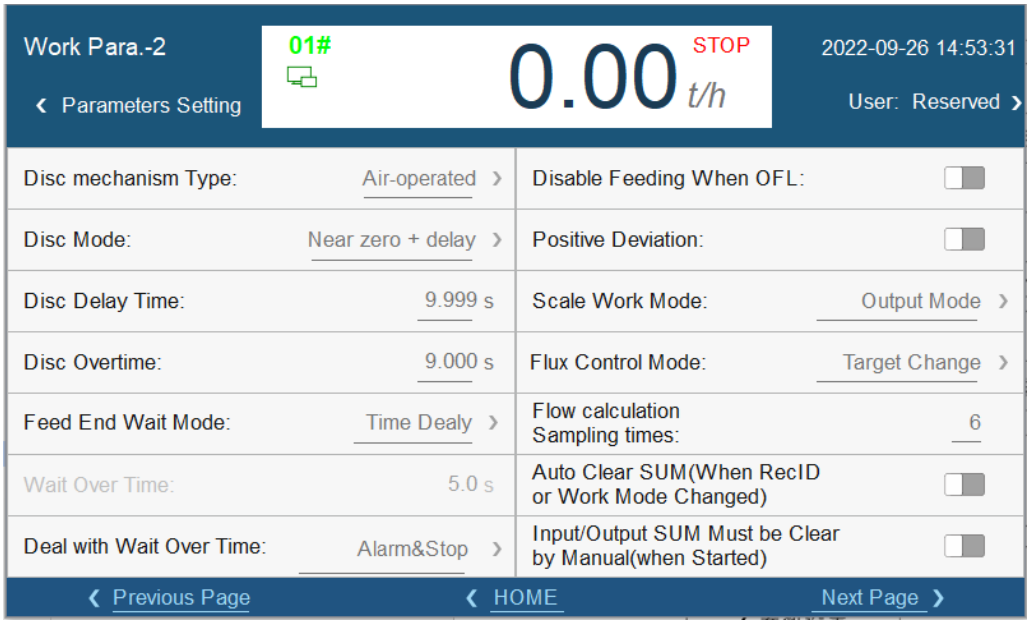
System information: display the current touch screen software version and control board software version, also can use the USB flash drive to update the control board program (for details, see 6.14 USB flash drive upgrade instructions).

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

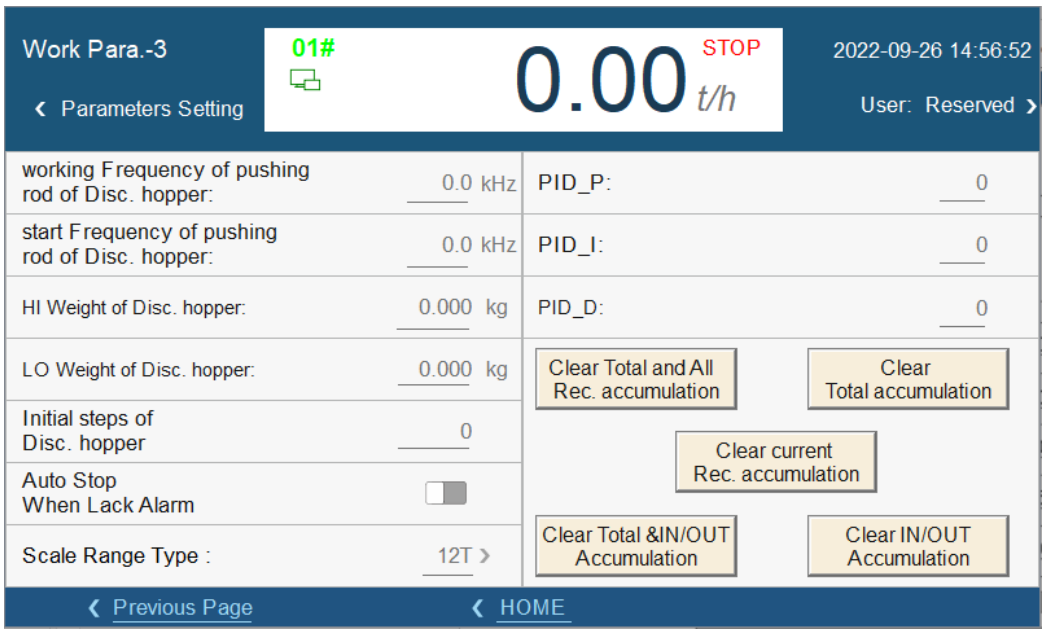
6.5 Working parameter interface description



Working Parameters 1 Figure



Working Parameter 2 figure



Working parameter 3 figure

Parameter description:

（1）Clear range: Clear range (1% to 20% of full scale).

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

（3）Start additional zeroing times: after the equipment enters the running state, the second scale begins, continuous zeroing is performed before feeding, and the execution times are equal to the set value of this parameter. For example, start additional zeroing

times for 2, then after the start, the second, three scales before feeding are zeroing.

（4）Zeroing additional delay: when the need for zeroing (whether automatic zeroing interval to or additional zeroing), zeroing before the completion of the equipment feeding delay + this delay after the start of zeroing operation.

（5）Automatic zero clearing on power: When the device is powered on, it automatically performs zero clearing operation.

（6）Zero tracking range/time: The zero tracking range is 0 to 9 days. If the value is 0, zero tracking is not performed. The zero tracking time can be set from 0.001 to 9.999.

（7）Automatic zeroing failure processing: processing methods after automatic zeroing failure, including: re-clearing the next packet, suspending the three-packet failure, continuing to wait for stability, and suspending immediately.

（8）Stability range/time: The stability range is optional from 0 to 99d. If the weight change within the stability time does not exceed the stability range, it is considered stable; otherwise, it is considered unstable.

（9）Operation filtering level: the filtering level used in the operation process, 0-9 level, is divided into feeding, fixed value and unloading three cases, the higher the value, the better the filtering effect, but the greater the lag.

（10）Stop filtering level: the filtering level used in the stop state, 0~9 level, the higher the value, the better the filtering effect, but the greater the lag.

（11）Manual unloading accumulation: when manual unloading, the packing weight is included in the accumulation.

（12）Fixed weight retention: after the end of the fixed value time, the weight display remains unchanged until the unloading is completed.

（13）Adaptive switch: If this switch is turned on during the operation of the equipment, the equipment will automatically adjust the scale according to the adaptive level.

（14）Adaptive & automatic scale adjustment level: it can be divided into five levels: zero level is the best speed, the first level is slightly better speed, the second level is balanced adjustment, the third level is slightly better accuracy, the fourth level is the best accuracy.

（15）Type of unloading mechanism: divided into pneumatic and electric, can be selected according to the specific structure of the equipment.

（16）Unloading mode: It is divided into two modes: time controlled unloading and zero zone delay unloading. The former is to close the unloading door when the unloading time is

to discharge, and the latter is to start the "delay after unloading to zero zone" when the delay time is to.

（17）Delay after unloading to zero zone: when the weight of the material reaches zero zone value, the delay time is used to close the unloading door.

（18）Unloading timeout time: If the unloading process exceeds the set time, the equipment will prompt the unloading timeout alarm information and automatically return to the stop state.

（19）Fixed value mode: It is divided into two modes: time fixed value and stable value.

（20）Fixed value timeout: If the fixed value is not completed within this time, it will enter the fixed value timeout processing.

（21）Fixed timeout processing: You can choose not to suspend the timeout alarm, pause the three packets alarm, continue to alarm and wait for stability, continue to alarm and pause.

（22）Overrange feeding protection: when opened, calculated from the calibration zero (plus the part cleared by zero), the weight is large

When it is equal to 1.2 times of the upper limit of the quantitative range, it will enter the state of over-range protection. This function can prevent the situation that the larger weight is cleared to 0 by zero cleaning, and the weight is shown to be small, but the actual feeding overflow occurs.

（23）Positive error mode: in the feeding process after opening, the error generated by the feeding result will be biased to positive value.

（24）Flow scale mode: delivery mode, receiving mode is optional.

（25）Flow scale control mode: target value switch, time control is optional.

（26）Flow window sampling length: 1 ~ 6 optional.

（27）When changing the formula or the delivery mode, the collection and delivery accumulative amount and total amount are automatically cleared: The default value is off.

（28）When starting, you must manually clear the collection and delivery accumulation: The default is off.

（29）Hopper push rod frequency: 1 ~ 25KHz optional.

（30）Hopper push rod start frequency: 10 ~ 25KHz optional.

（31）Hopper feeding level weight: 8 ~ 17KG optional, hopper loaded material upper limit;Out of the hopper

After the material weight reaches the set feeding level value for a period of time, start to enlarge the hopper mouth.

（32）Hopper lower level weight: 0.5 ~ 17KG optional, hopper loaded material lower limit;Out of the hopper

After the material weight reaches the set discharging level value for a period of time, start to close the hopper mouth.

（33）Initial opening of hopper: 5000 ~ 45,000 optional.

（34）Automatic pause after lack of material alarm: it is closed by default, and the lack of material alarm will be suspended after opening.

（35）Scale specification: 12T.

（36）PID parameter _P value: 10 ~ 1000 Optional.

（37）PID parameter _I value: 10 to 1000 Optional.

（38）PID parameter _D value: 10 to 1000 Optional.

（39）Clear Total Accumulations and all formulations accumulations: You can clear total accumulations and all formulations accumulations

（40）Clear Total Accumulations: Clear total accumulations.

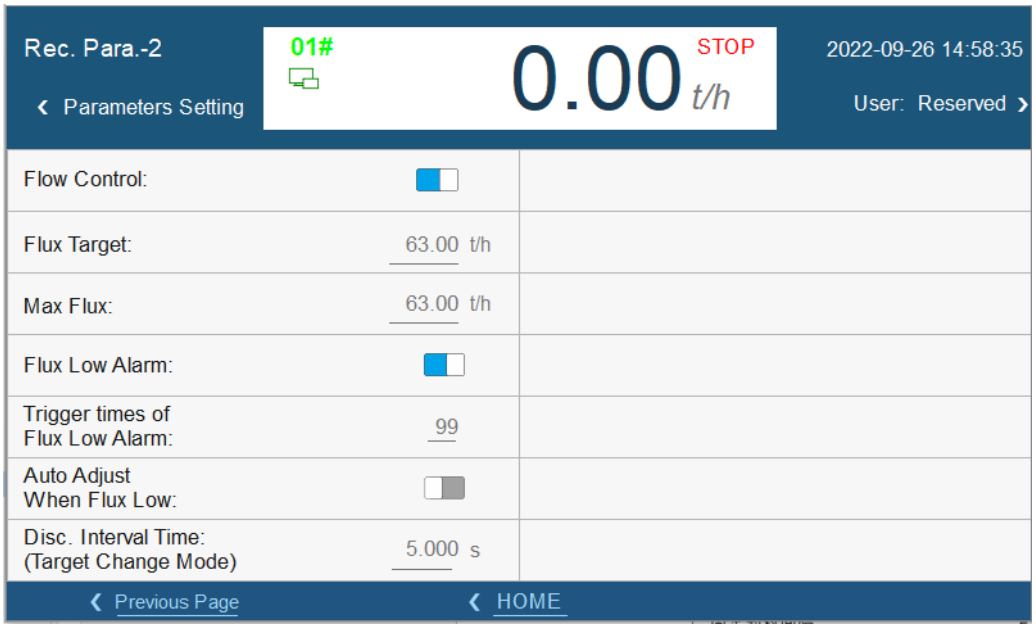
（41）Clear Current Cumulative: Can clear the current cumulative.

（42）Clear Total Accumulator and collection and Delivery accumulator: You can clear total accumulator and collection and delivery accumulator

（43）Clear Collection and Delivery Accumulator: The collection and delivery accumulator can be cleared

6.6Recipe parameter interface description

Recipe Parameters 1 Figure



Recipe Parameter 2 figure

Description of Parameters:

（1）Target value: Weight to be quantified.

（2）Quick add advance: in the quantification process, if the weight value ≥ the target value - quick add advance, then close the quick add.

（3）Add advance: in the quantitative process, if the weighing value is ≥ the target value -

add advance, then close the add.

（4）Drop value: in the quantitative process, if the weighing value is greater than or equal to the target value - drop value, the slow addition will be closed.

（5）Unloading mode: time controlled unloading or zero zone delay unloading can be selected.

（6）Discharge delay time: the discharge signal is output after the delay time.

（7）Zero zone value: in the quantitative process, if the weighing value is less than or equal to zero zone value, the unloading delay timer will be started.

（8）Formula No. : The number of the current formula.

（9）Fast opening: the opening of the feeding door when the material is fast adding.

（10）Medium opening: the opening of the feeding door when the material is added.

（11）Slow opening: the opening of the feeding door when the material is slowly added.

（12）Formula independent opening: if this switch is open, the independent opening of this formula is used, otherwise the opening under the opening table.

（13）Set time: the time to determine the weight after the completion of feeding.

（14）Delay T1 before feeding: at the beginning of the quantitative process, after the delay T1 time, the feeding process begins;

（15）Flow control: the default is on, and the mode is rice mixing.

（16）Target Flow: Sets the current target flow.

（17）Maximum traffic: The maximum amount of traffic the device can receive while it is running.

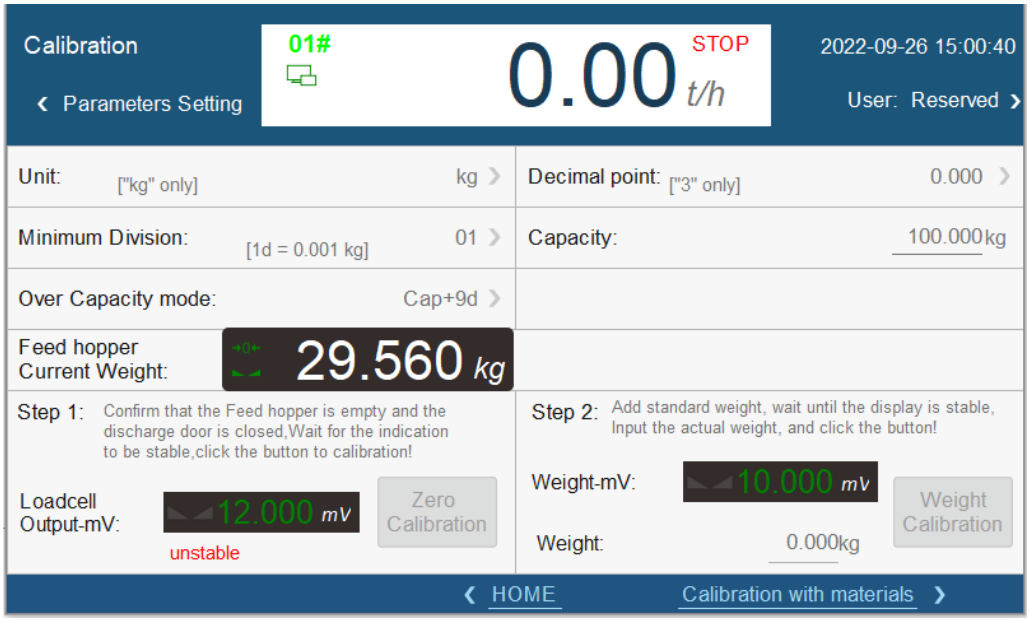
（18）Insufficient flow alarm switch: displays alarm information when insufficient flow occurs.

（19）Insufficient flow alarm statistics: the number of alarms caused by insufficient flow.

（20）Automatic adjustment after insufficient flow: automatic adjustment after opening.

（21）Fixed discharge interval: 2 ~ 10S optional

6.7Calibration scale interface description



Parameters that

（1）Unit: Fixed in kg

（2）Minimum fractions: 1 2 5 10 20 50 Optional.

（3）Over range display: There are three options, namely, the device displays a weight overflow when the current weight is greater than: maximum range + 9D, maximum range x 120%, and maximum range x 150%.

（4）Number of decimal points: fixed at 0.000, that is, three decimal places.

（5）Maximum range: Maximum range of the device (it is recommended not to set more than 20.00kg).

（6）Real-time weight of bucket: Real-time display of the weight of the material into the bucket.

6.8Weight calibration scale step

1. Zero point calibration: empty the hopper and close the unloading door.When the weight is stable, click "zero calibration". During the calibration process, the weight display area above will show the calibration result, and it will show stability after successful calibration.

2. Gain calibration: Add a weight to the weighing mechanism. After the weight is stable, click the weight input box of the weight.After successful calibration, the weight displayed in

the weight display area is the weight of the input weight.Otherwise, the gain calibration fails. Try again.

6.9Material calibration steps

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

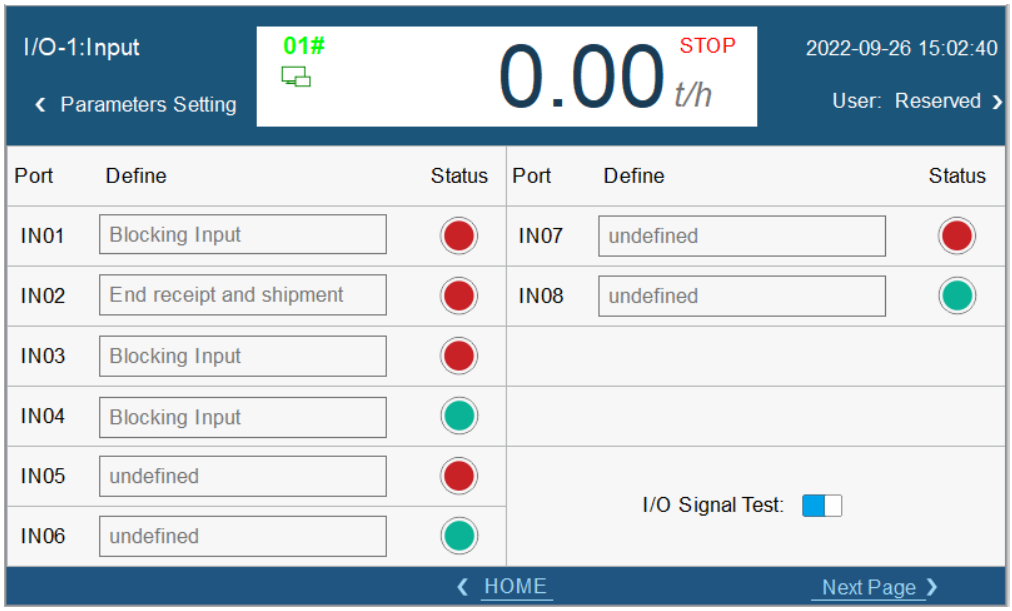
2, gain calibration:

A, use "automatic feeding" (automatically run a scale according to the current formula target value) or "manual feeding" (click once to open quick feeding, click again to close quick feeding), stop feeding and wait for the weight to stabilize, click "record weight" to save the current display value.

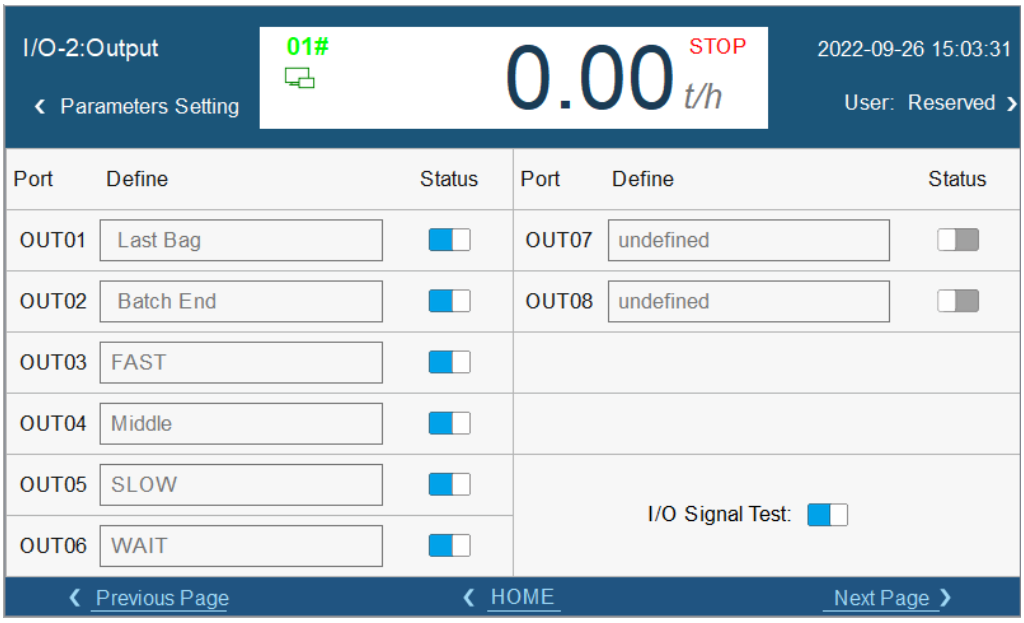
B, will be prepared in advance of the bag or container as the discharge port, click "manual discharge", the material in the hopper into the bag or container, the material in the bag or container weigh (pay attention to remove the weight of the bag or container).

C. Click the "Balance Weight" input box, enter the material weight obtained by the balance and click "Material Calibration" for calibration. Wait for the calibration to be successful, if not, try Step C again.After successful weight calibration is complete, exit the menu.

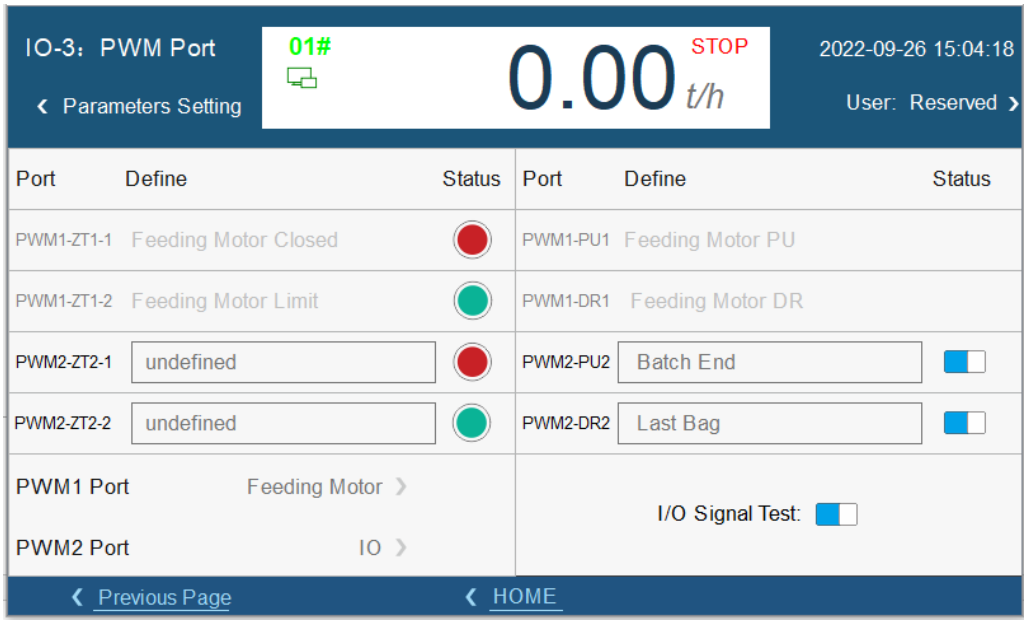
6.10 Switch weight interface description



Switch Quantity 1 Figure



Switching quantity 2 figure



Switching quantity 3 Figure

（1）Input port (IN01, IN02, IN03, IN04, IN05, IN06, IN07, IN08) where IN3 is set as emergency stop, IN4 is defined as servo alarm input, other customers can customize:

（2）The input port (PWM1-ZT1_1, PWM1-ZT1_2, PWM2-ZT2_1, PWM2-ZT2_2) is fixed for the motor photoelectric signal in place;

（3）Output port (OUT01, OUT02, OUT03, OUT04, OUT5, OUT6, OUT7, OUT8), where OUT5 is set as discharge, other customers can customize:

（4）Output port (DR1, DR2, PU1, PU2) is the direction signal and pulse signal of the motor.

（5）Switch quantity test: After opening, you can test whether the signal of the corresponding switch quantity is normal

Input end definition:

The port number	The initial value	Custom list
IN1	**1**	**I00: Undefined** **I01: start** **I02: stop** **I03: stop**
IN2	**2**	

IN3	**5**	**I04: feeding stepper motor origin (close the door in place level)** **I05: Feeding allowed**
IN4	**6**	**I06: Discharging allowed** **I07: Clearing alarm** **I08: keep**
IN5	**0**	**I09: Open/close discharging door [original manual discharging function, switch discharging output state]**
IN6	**0**	**I10: manual discharging** **I11: Manual slow loading** **I12: Add manually**
IN7	**0**	**I13: Manual quick add [press quick add to open the door]** **I14: Manual cleaning [open the door according to the maximum opening]**
IN8	**0**	**I15: Start/stop (double edge: effective edge, start;**Invalid edge, stop) **I16: Start/emergency stop (double edge)**
ZT1_1	**4**	**I17: Manual discharge (double edge)** **I18: Manual slow loading (double edge)** **I19: Manual add (double edge)**
ZT1_2	**24**	**I20: Manual Quick Add (double edge)** **I21: Manual cleaning (double edge)** **I22: reset**
ZT2_1	**0**	**I23: emergency stop [level](effective, then do not allow start, do not allow manual feeding, do not allow manual unloading)**
ZT2_2	**0**	**I24: feeding stepper motor opening limit point.** **I25: origin of discharging stepper motor.**

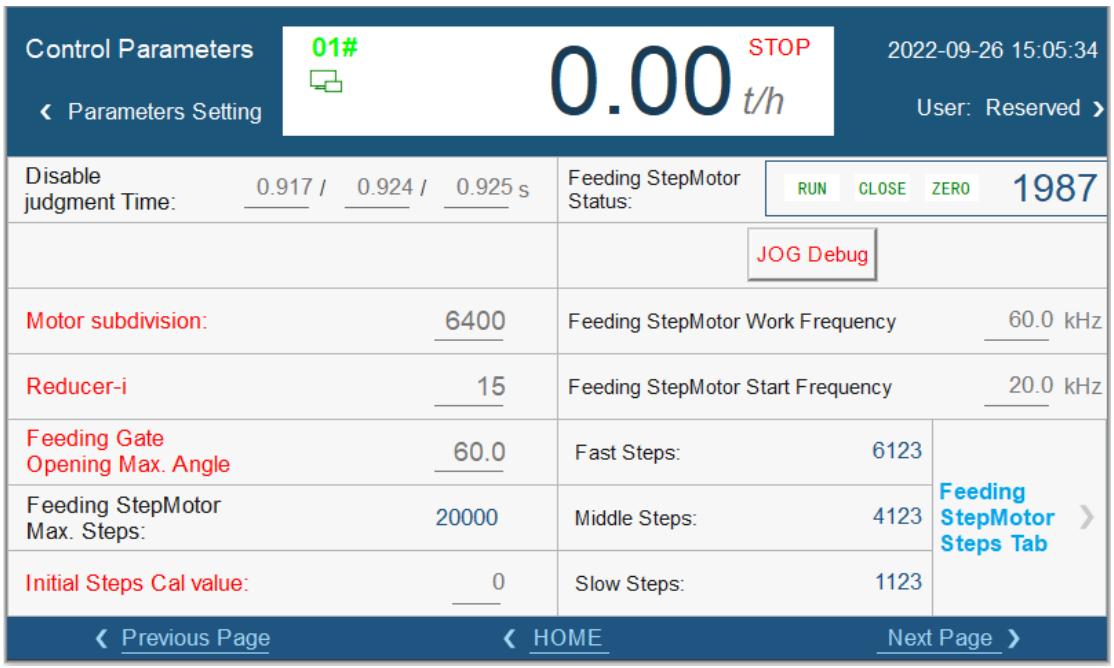
		I26: opening limit point of discharging stepper motor. **I27: jam** **I28: End of collection and delivery** **I29: Manual discharge** **I30: servo motor alarm**

Output side definition:

The port number	The initial value	Custom list
OUT1	**1**	**O00: Undefined** **Run O01:** **O02: refueling request** **O03: Direction of feeding stepper motor [PW signal is set to feeding PWM]** **O04: quick to add** **I add O05:** **O06: slow** **O07: fixed value** **O08: Unloading L** **O09: over/under** **O10: alarm** **11: clip bag** **O12: Preset number of bags completed** **O13: one packaging completed (output 1s after unloading)** **O14: stop** **O15: Unloading stepper motor direction** **O16: Discharge motor running/forward** **O17: Reversal of discharging motor**
OUT2	**4**	
OUT3	**5**	
OUT4	**6**	
OUT5	**7**	
OUT6	**8**	
OUT7	**0**	
OUT8	**0**	
DR1	**0**	
PU1	**0**	
DR2	**3**	
PU2	**8**	

		O18: Feeding PWM[only available for OUT7/OUT8] **O19: Discharging PWM[only available for OUT7/OUT8]** **O20: Last scale** **O21: End of receipt and delivery** **O22: servo motor alarm** **O23: Set value complete**
PWM1 function	**1**	**1: Universal switching quantity** **2: feeding motor control** **3: discharge motor control**
PWM2 function	**0**	

6.11 Control parameters interface description



Parameters that

（1）Fast, medium and slow add forbidden time: At the beginning of quantification, in order to avoid overshooting, the weight is not judged at this time, fast add, add and slow add are always effective

（2）Maximum opening of feeding motor (pulse number) : To protect the motor, the maximum opening of the motor is allowed after the motor is started.

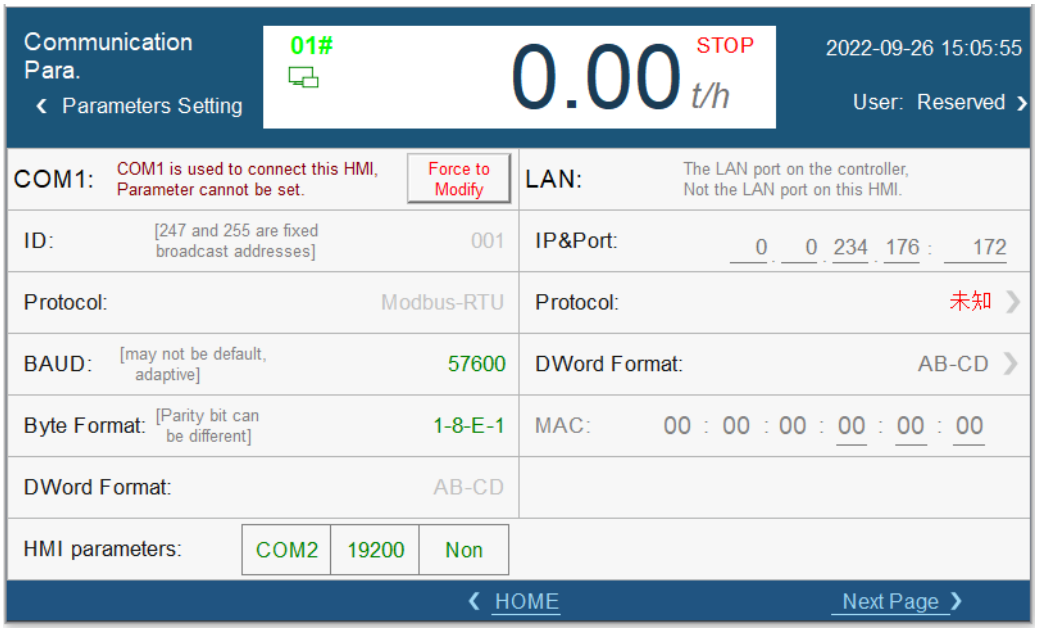
（3）The state of the feeding motor: stop, open, the origin and the opening of four states

can be seen.

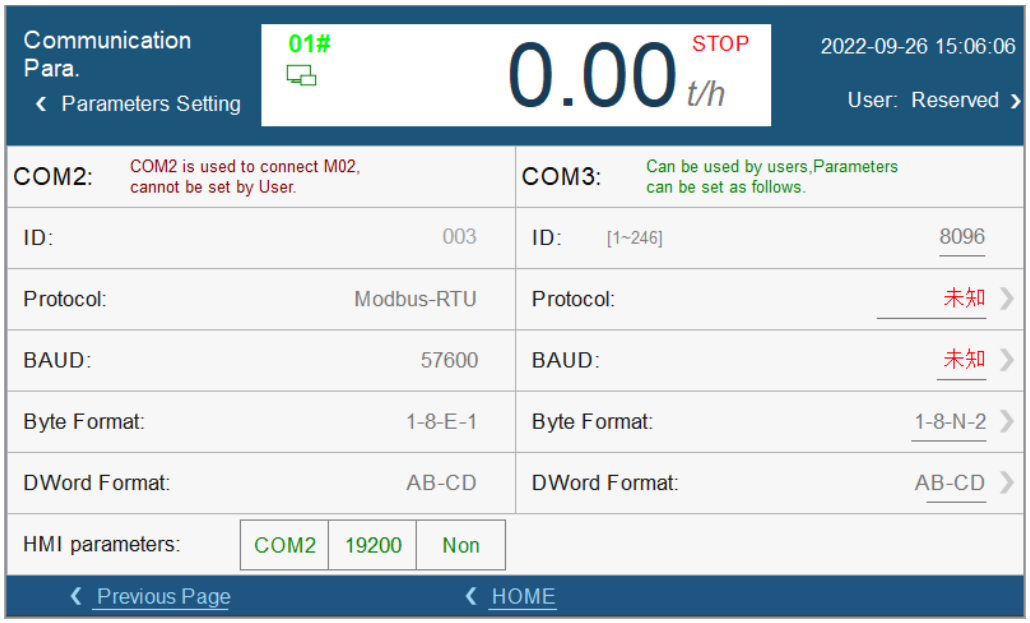
（4）Feeding motor working frequency: feeding motor when the frequency of normal work.

（5）Feeding motor start frequency: feeding motor start frequency.

6.12 Communication parameter interface description



Communication parameter 1 Figure



Communication parameter 2 figure

Parameter description:

（1）Address number: Slave number.That is, the serial port communication ID number

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

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

（4）Byte format: data format.Initial value.1-8-e-1 (8-bit data bits - parity - 1-bit stop bits;)

（5）Two-word register order: Modbus high-low word. The order of high and low words first is ABCD, and the order of low and high words first is CDAB.

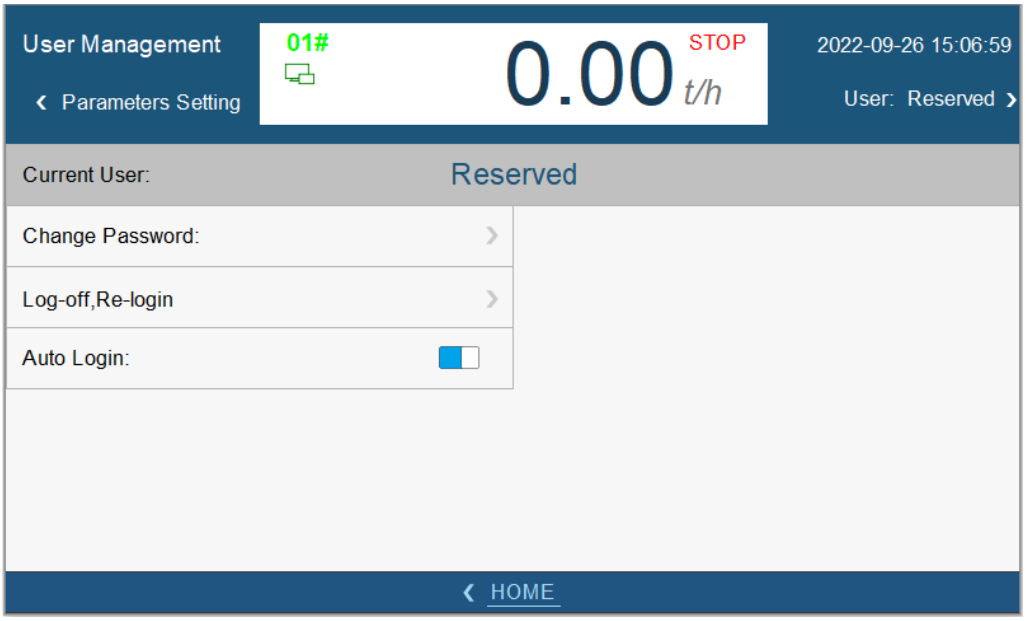
（6）HMI Current Communication parameters: Displays the current communication parameters of the touch screen.

（7）IP and Port: indicates the IP address.

（8）MAC: MAC address.

* Description: Serial port one has been used for HMI connection and serial port two has been used for M02 meter connection.Serial port three and network port can be used by customers for external communication.

6.13 User management interface Description



Parameter description:

Displays the user currently logged in and can change password and set automatic login.

There are four user levels in this system, from high to low: Reserved user (used by the manufacturer), engineer, administrator, and operator.

The cancellation

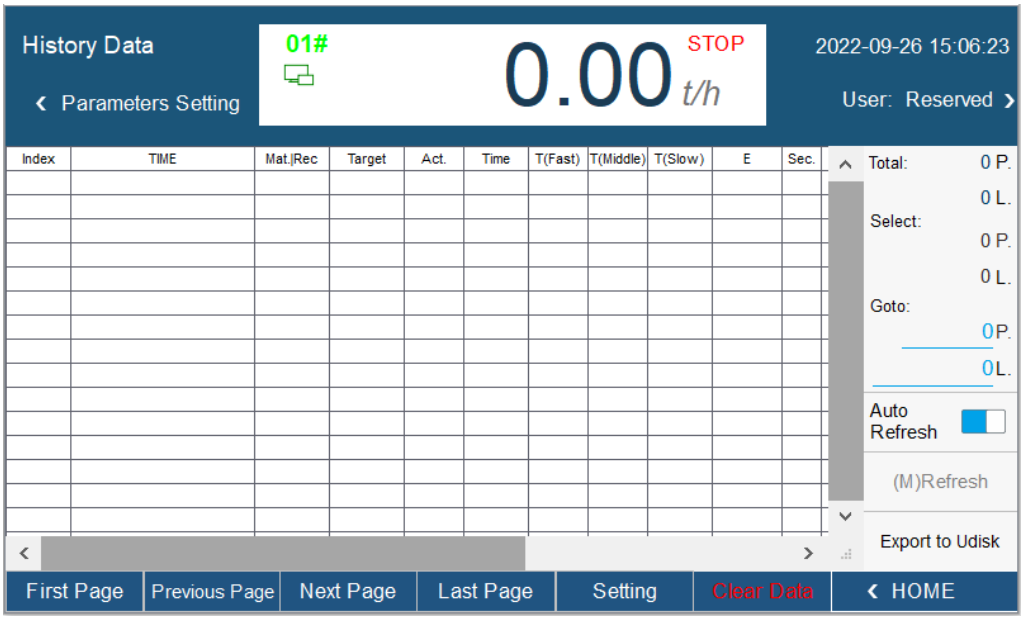
After a user logs in, if you want to log out or switch users, click Log Out→

To switch users, log out of the user management interface and enter the corresponding user number and password on the login interface to access the corresponding user

Change the password

Path: Parameter Settings User Management Change Password Click the password entry box to follow the prompts→→→→

6.14 Description of the historical data interface



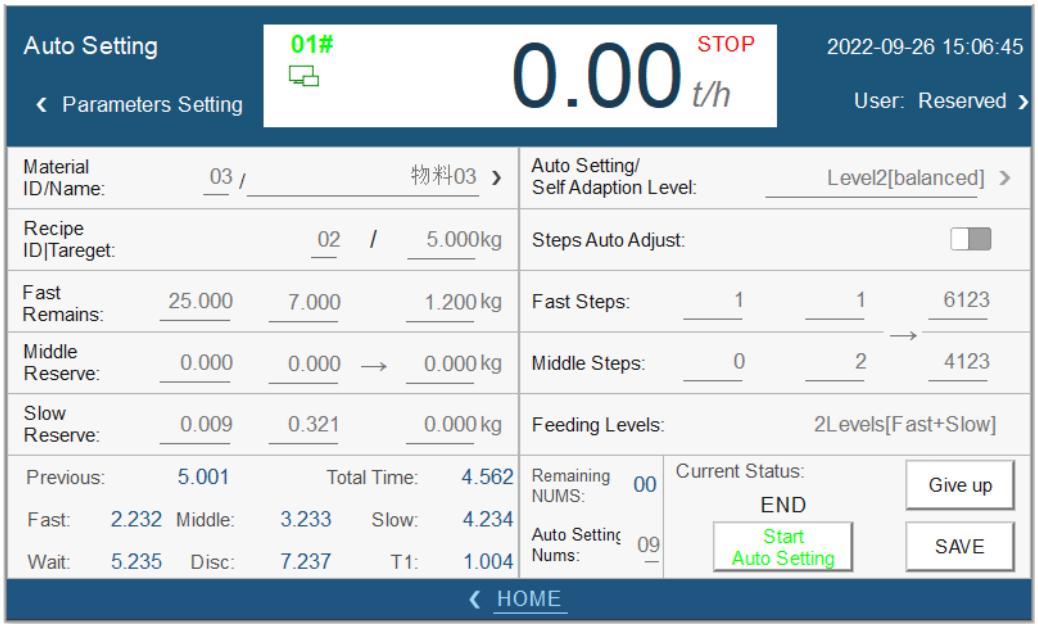
Parameter description:

（1）Auto Refresh/Manual Refresh: How to refresh the data.

（2）Usb disk export: Historical data can be exported.

（3）Clear data: Clear historical data.

6.15 Automatic scale adjustment interface description



Parameter description:

（1）Material Number/Name: Material number and material name can be set;

（2）Recipe number/Target value: set recipe number and target value;

（3）Adaptive & automatic scale adjustment level: a total of four levels, level 0 for the fastest, the higher the speed is slower;

（4）Opening automatic adjustment: the opening of the feeding door automatic adjustment function switch;

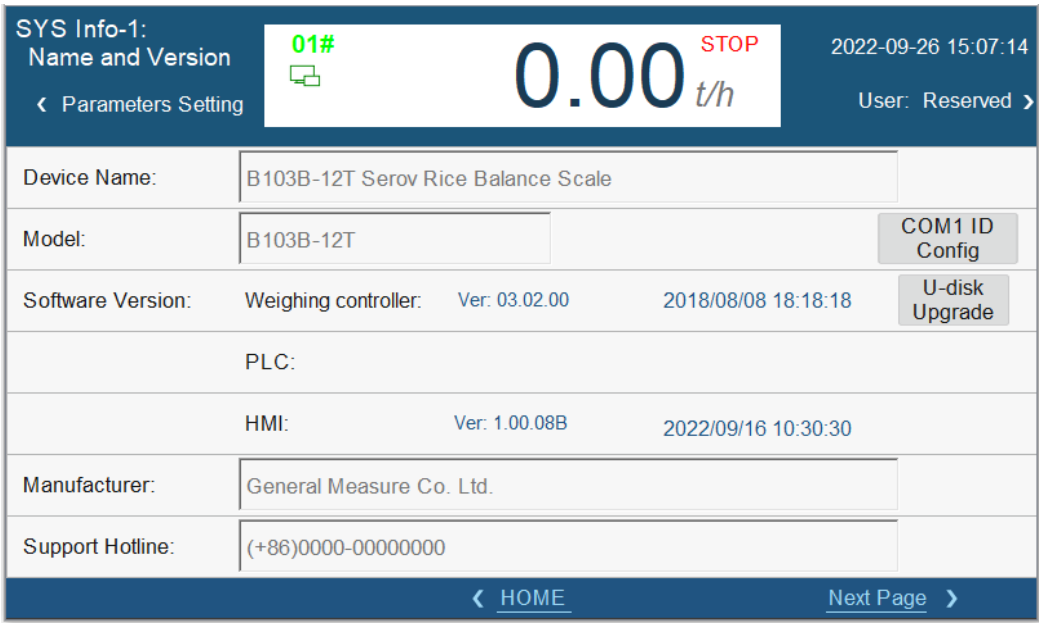
（5）Feeding level: two or three levels of feeding, the system according to the target value automatically set;

Automatic scale adjustment steps and instructions

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

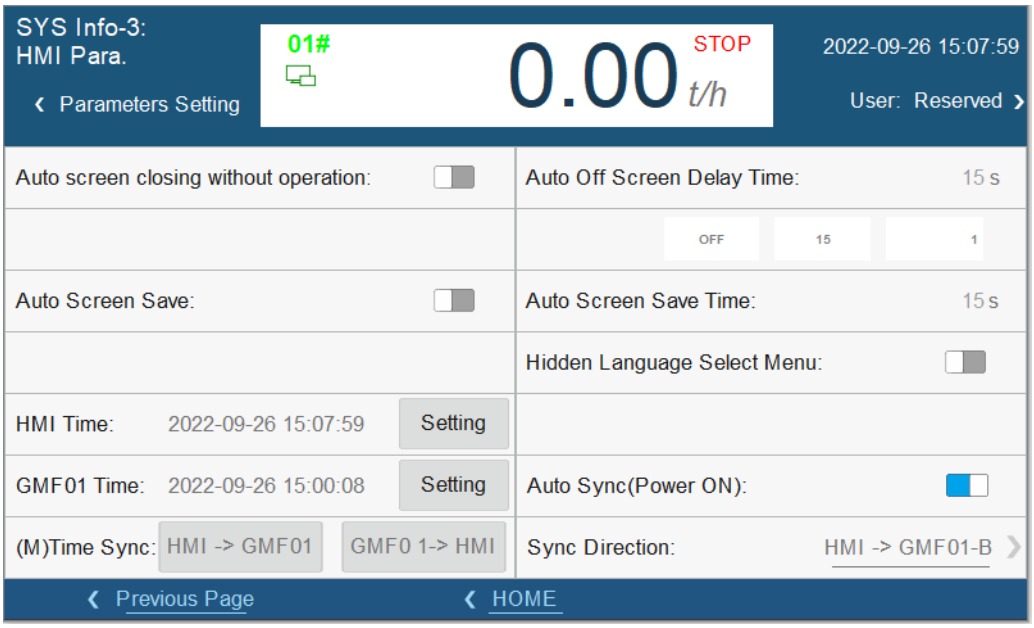
automatically adjustable scale, After the number of adjusting scales arrives, the equipment will stop automatically. At the same time, the user can choose to save or give up according to the adjustment value of the automatic adjusting scale, save the adjustment value of the automatic adjusting scale to the current formula, and give up that is, still use the value before the automatic adjusting scale.If the balance is completed, does not meet the requirements of the user, the customer can start the automatic balance again, the equipment will be adjusted and corrected again on the basis of the last time the balance is completed.The user can also manually modify the lead-time and opening parameters.

6.16 System information interface description



System Information 1 Figure

System Info 2 figure



System Info 3 Figure

Parameter Description:

System Information 1 Shows the device information diagram.You can see the device's name, model, software version, manufacturer, technical support phone number and more.

System information 2 shows the factory Settings restoration diagram.Engineers and reserve users can reset all parameters.The details are as follows:

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

Working Parameter Reset - Resets the basic system parameters to their default Settings.

Calibration parameter reset -- reset the system calibration scale related parameters to the default Settings.

Formula parameter reset -- Reset system formula parameters to default Settings.

Peripheral Parameter Reset - Resets system peripheral parameters to default Settings.

Adaptive parameter reset - Resets system adaptive parameters to their default Settings.

Communication parameter Reset -- Resets the system communication parameters to their default Settings.

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

System Info 3 shows the touch screen Settings diagram.The engineer can set the parameters of the touch screen.

Usb disk upgrade system:

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

7. The Modbus address table

In [Communication Parameters], if Modbus-RTU mode is selected for serial communication, and the communication parameters are consistent with those of the host computer, ModBUS-RTU protocol is used for communication.

The PLC address	**Function**	**meaning**	**instructions**	
The following are read-only registers (function code 0x03)				
Meter status Parameters				
40001	**00000**	The current weight	4 bytes, signed number	
40002	**00001**			
40003	**00002**	Meter Status 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
			. 6:	zero
			07:	Minus sign
			. 08:	Millivolts are stable
			. 09 ~. 15:	keep
40004	**00003**	Meter Status 2	**00.**	run
			.01	Before loading

			. 02	Quickly add
			.03	To add
			. 04	Slowly add
			.05	Constant value
			. 6	Super poor
			07.	Owe less
			. 08	Call the police
			The 09	Waiting for the clip bag
			10.	Clip bag
			11.	discharge
			12.	Charging to allow
			13.	Discharge allow
			14.	jam
			15.	keep
40005	**00004**	Meter Status 3	**00:**	keep
			.01	keep
			. 02	One wrap done (1S duration)
			.03	Collection and delivery completed
			. 04	The consignor
			.05	The final balance
			. 6	Lack of material (1: lack of material, 0: no shortage)
			07.	Lower limit of discharge hopper (1: weight lower than discharge

				Bit, 0: weight higher than the feeding level)
			. 08	Hopper upper limit (1: weight higher than feeding Bit, 0: weight below feeding level)
			The 09	Medium limit of hopper (1: weight on top and bottom Between bits, 0: weight is not in the upper and lower material A)
			10.	Outlet hopper zero (1: zero, 0: non-zero)
			11.	Hopper stability (1: stable, 0: unstable)
			12.	Blocking material (1: blocking material, 0: not blocking)
			, 13 ~ 15:	keep
40006	**00005**	Alarm Queue 1	**00.**	No alarm
			.01	Batch to complete
			. 02	Clear out of range (2S)
			.03	Unstable when clearing (2S)
			. 04	Cannot start with a target value of 0 (2s)
			.05	Over and under time out
			. 6	keep
			07.	No zero clearing operation in operation (2S)
			. 08	Over/under alarm
			The 09	keep

			10.	keep
			11.	Discharge fault
			12.	Discharging timeout
			13.	Feeding motor runs out of time
			14.	Discharge motor running out of time
			15.	Unable to operate at emergency stop (2S)
			16.	Failed to clear zero (clear zero before running refill)
			17.	Charging a timeout
			18.	Fixed value stability timeout (stable value method)
			19.	Receipt and delivery completed
			20.	Run-time target traffic set less than the target value
			21.	Do you need to clear the accumulated receipt and delivery of the last time when starting the switch is turned on, the accumulated receipt and delivery of the last time is not cleared when starting
			22.	Insufficient flow alarm
			23.	In the police
			24.	Plugging material alarm
			25.	Servo motor alarm
			99.	Software authentication failed
40007	**00006**	Alarm Queue 2	Same alarm queue 1. When there are multiple alarms at the same time, press Happen	
40008	**00007**	Alarm queue 3		

			Queue up front and back. Up to three alarms are displayed at the same time.
40009	**00008**	The default package number	Initial value: 0, range: 0 to 99999
40010	**00009**		
40011	**00010**	Number of preset packets remaining	Initial value: 0, range: 0 to 99999
40012	**00011**		
40013	**00012**	Current gross weight value	The difference from 40001 is that this register is not held by a fixed weight Switch control, when the switch is turned on, even during unloading, also Return the actual weight
40014	**00013**		
40015	**00014**	Total number of packages received and delivered	
40016	**00015**		
40017	**00016**	Accumulated weight received and shipped (accumulated weight)	
40018	**00017**		
40019	**00018**	Total cumulative number of packs (current recipe Total number of accumulations)	
40020	**00019**		
40021	**00020**	Total cumulative weight (current recipe 4 places higher in cumulative weight)	
40022	**00021**		
40023	**00022**	Number of current recipe accumulative packs (when Previous recipe cumulative	
40024	**00023**		

		weight is lower by 9 A)	
40025	**00024**	Current recipe cumulative weight (no Use)	
40026	**00025**		
40027	**00026**	Total cumulative number of packets in the system (No Clear) (Current task remaining Weight)	
40028	**00027**		
40029	**00028**	System total cumulative weight (No Clear) (current weight of the discharge hopper The amount)	
40030	**00029**		
40031	**00030**	Years (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**	Hour (readable and writable)	Scope: 0 ~ 23
40036	**00035**	Points (readable and writable)	Scope: 0 ~ 59
40037	**00036**	Seconds (readable and writable)	Scope: 0 ~ 59

40038	**00037**	System elapsed time	The timer starts when the system is powered on, and the unit is S. It can be used to monitor faults such as restarts.
40039	**00038**		
40040 **...** **40050**	**00039** **...** **00049**	The reserved	
40051	**00050**	Top pack recipe number	The recipe number and target value when the "upper pack result weight" is produced, Manual discharge, also do a result save, but the formula number is equal to 0
40052	**00051**	Upper package target value	
40053	**00052**		
40054	**00053**	Top packet result weight	Weight units are system units and are updated at the end of unloading
40055	**00054**		
40056	**00055**	The actual packing time of the upper package (includes waiting time)	Updated at the end of unloading, in milliseconds
40057	**00056**		
40058	**00057**	Upper wrap theory packing time (Does not include waiting time)	
40059	**00058**		
40060	**00059**	Delay before feeding (includes 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 Discharge start)	
40069	**00068**		
40070	**00069**	Wait for the clip bag (discharging allowed) time	
40071	**00070**		
40072	**00071**	Discharging time	
40073	**00072**		
40074	**00073**	Actual packing speed	Updated at the end of unloading, in: BPH
40075	**00074**		
40076	**00075**	Theoretical packing speed	
40077	**00076**		
40078	**00077**	deviation	Signed double word, non-combined pattern: Upper packet result - upper packet target value. Combined mode: first time, fixed to 0, second time: Combined total result - Set target value
40079	**00078**		
40080	**00079**	Number of speed sampling packets Nspeed (Readable and writable)	Initial value: 6, range: 6 to 12
40081	**00080**	Current traffic (does not need to be displayed)	Decimal 8 digit year month day such as: 20160111 (2016/01/11)
40082	**00081**		
40083	**00082**	Flow unit	
40084	**00083**	Flow decimal point	
40085	**00082**		

40086	**00083**	Current opening of outlet hopper	The number of pulses corresponding to the current opening of the hopper door
40087	**00082**	Package head current average flow	Average current flow rate of the scale
40088	**00083**		
40089	**00082**	Current instantaneous discharge of hopper	
40090	**00083**		
40091	**00082**	Feeding level weight (readable readable Write)	The opening corresponding to the first opening of the outlet hopper after the start
40092	**00091**		
40093	**00092**	Feeding level weight (readable readable Write)	
40094	**00093**		
40095	**00094**	Initial opening of outlet hopper	
40096	**00095**		
40097	**00096**	Out hopper forbidden time	
40098	**00097**	Task run time accumulated	
40099	**00098**		
40100	**00099**	The reserved	
The following content is readable and writable (Write a single register function code 0x06, write multiple registers function code 0x10, read function code 0x03)			
Calibration parameters			
40101	**00100**	The zero calibration	Write 1 to calibrate zero and read to return zero
40102	**00101**		
40103	**00102**		Range: 0 to 999999, in grams

<table>
<tr><td>40104</td><td>00103</td><td>Have weight gain calibration
(Input weight)</td><td colspan="2"></td></tr>
<tr><td>40105</td><td>00104</td><td rowspan="2">Material gain calibration (r
Record the current AD code</td><td colspan="2" rowspan="2">Enter 1 to record the gain AD code and read back 0</td></tr>
<tr><td>40106</td><td>00105</td></tr>
<tr><td>40107</td><td>00106</td><td rowspan="2">Material gain calibration
(input weight)</td><td colspan="2" rowspan="2">Range: 0 to 999999, in grams</td></tr>
<tr><td>40108</td><td>00107</td></tr>
<tr><td>40109</td><td>00108</td><td rowspan="2">Absolute millivolts (read only)</td><td colspan="2" rowspan="2">Default 3 decimal places, in millivolts
A value of 12345 represents 12.345</td></tr>
<tr><td>40110</td><td>00109</td></tr>
<tr><td>40111</td><td>00110</td><td rowspan="2">Gain millivolts (read only)</td><td colspan="2" rowspan="2">Default 3 decimal places, in millivolts
A value of 12345 represents 12.345</td></tr>
<tr><td>40112</td><td>00111</td></tr>
<tr><td rowspan="9">40113</td><td rowspan="9">00112</td><td rowspan="9">Calibration result information (read only)</td><td>The results</td><td>instructions</td></tr>
<tr><td>0</td><td>There is no information</td></tr>
<tr><td>1</td><td>Calibration is successful</td></tr>
<tr><td>2</td><td>The current sensor voltage is unstable</td></tr>
<tr><td>3</td><td>The input weight is not reasonable</td></tr>
<tr><td>4</td><td>The current sensor has too much voltage</td></tr>
<tr><td>5</td><td>The current sensor voltage is too low</td></tr>
<tr><td>6</td><td>Too high calibration resolution</td></tr>
<tr><td colspan="2">The alarm message will be automatically eliminated after 2 seconds.Before elimination, no
Allow to operate calibration again</td></tr>
</table>

40114 **...** **40200**	**00113** **...** **00199**	The reserved	
The basic parameters			
40201	**00200**	unit	Initial value: 1,0: g;**1 kg;2: t;3: b**
40202	**00201**	The decimal point	Initial value: 3, range: 0 to 4
40203	**00202**	Dividing the value	Initial value: 1, range: 1, 2, 5, 10, 20, 50
40204	**00203**	Maximum range	When the equipment model is AF-5K, initial value: 10000 When the device model is AF-10K, initial value: 20,000 Range: 1 to 999999, unit: g
40205	**00204**		
40206	**00205**	OFL indicates type	Initial values: 0, **0:[maximum range + 9D] indicates OFL;** **1:[maximum range *120%] to display OFL;** **2:[maximum range *150%] to display OFL**
40207	**00206**	Scale range mode	Initial values: 0, 0, 5 k;**1:25K;2:50K;3:10K;4: the reserved**
40208	**00207**	Automatic zero clearance interval	Initial value: 80, range: 0 to 9999, in milliseconds
40209	**00208**	Start additional zeroing times	Initial value: 2, range: 0 to 9
40210	**00209**	Additional zero clearing time	Initial value: 1000, range: 0 to 9999, in milliseconds
40211	**00210**	How to handle zeroing failure	Initial values: 0, **0: alarm only, for 1S, this time give up the zero, the next time;** **1: only alarm, for 1S, this time to give up clearing, the next time to clear, even**

			Continue three times can not clear, return to stop state!Continue to report to the police **2: Alarm, but keep waiting for stability, once stable, eliminate the alarm,** Automatically continue to run; **3: alarm, immediately return to stop state.**
40212	**00211**	Reset the scope	Initial value: 10, range: 0 to 99, unit: %
40213	**00212**	Sentenced to stabilizing range	Initial value: 5, range: 0 to 99, unit: D
40214	**00213**	Sentenced to stabilizing time	Initial value: 300, range: 100 to 9999, in milliseconds
40215	**00214**	Zero tracking range	Initial value: 3, range: 0 to 9, unit: D
40216	**00215**	Zero tracking time	Initial value: 2000, range: 0 to 9999, in milliseconds
40217	**00216**	Stop AD filter progression	Initial value: 9, range: 0 to 9
40218	**00217**	Feed AD filter progression	Initial value: 2, range: 0~9
40219	**00218**	Fixed value AD filter series	Initial value: 5, range: 0~9
40220	**00219**	Discharge AD filter level	Initial value: 2, range: 0~9
40221	**00220**	Power on the automatic zero clearing switch	Initial value: 0, range: 0~1
40222	**00221**	Manual discharge accumulator switch	Initial value: 0, range: 0~1

40223	**00222**	Fixed weight hold switch	Initial value: 1, range: 0~1
40224	**00223**	Unloading mechanism mode	Initial value: 0,0: pneumatic, 1: ordinary motor one-way, **2: common motor two-way, 3: one-way stepper motor**
40225	**00224**	Unloading working mode	**0: timing mode, discharging signal output continuous discharging time (formula** Set in parameter) is off. Discharge is abnormal after the end of unloading Judge; **1: Judge zero zone mode, signal output, until the weight is below zero zone** Value, and then start unloading delay time, time to close the unloading Material signal. After entering the unloading delay, there is no need to judge the weight.
40226	**00225**	Discharge delay	Initial value: 200, range: 0 to 9999, in milliseconds
40227	**00226**	Discharge timeout	Initial value: 2000, range: 0 to 20000, unit: millisecond
40228	**00227**	Loose bag model	0: automatic bag loosening after unloading. 1: manual bag loosening is required after unloading bag
40229	**00228**	Feeding allows discriminant mode	0: only start feeding judgment, feeding process is no longer judged;1: charging Judge all the way through.

40230	**00229**	Discharge allows discriminant mode	0: judge only when starting unloading, no longer judge during unloading;1: discharge Judge all the way through.
40231	**00230**	Over range feeding protection	Initial value: 1, **0: close;** **1: open. When open, count from the calibration zero (plus clear zero** If the weight is greater than or equal to the specification *1.2, it will be judged OFL, whether or not it exceeds the maximum range. Prevent clearing will be larger After the weight is cleared to 0, the weight is shown to be smaller, but the actual weight has been At the same time, adjust the adjustable value of the zero clearing range from 99% The whole of 20%
40232 **...** **40240**	**00231** **...** **00239**	The reserved	
40241	**00240**	Collection and delivery mode	Initial value: 1, range: 0 to 2 0: ordinary packing scale. Address 40009 is the number of batches. 1: Delivery mode of flow scale. Address 40009 is the total amount received and

			delivered. Receipt mode, the total amount of receipt and delivery is meaningless. 2: flow scale delivery mode. Address 40009 is the total amount of receipt and delivery.
40242	**00241**	Length of traffic sampling window	Initial value: 3, range: 1~6, calculate the traffic with the set packet number data.
40243	**00242**	Fixed value method	Initial value: 0, range: 0~ 1,0: time value;1: stable value
40244	**00243**	Set the value to determine the timeout	Initial value: 0, range: 0 to 999, unit: 100ms The maximum time allowed to wait for stability when the stable value is determined is exceeded If the time is not stable, it will be processed according to the "fixed value judgment timeout processing method". Does not work.
40245	**00244**	Fixed value decision timeout handling method	Initial value: 0, range: 0~3, 0: The meter will consider the current weight as the stabilized weight and continue below Step, and alarm [fixed value timeout], for 1S. 1: The meter will consider the current weight as the weight after stabilization, continue below Step and alarm for 1S. After three consecutive times, return to stop shape

			State, continuous alarm [continuous fixed value timeout]. 2: alarm, but continue to wait for stability, once stable, eliminate the alarm, automatic relay Continue to run. 3: Alarm and return to stop state immediately.
40246	**00245**	Switch recipe/collect and ship mode is No Clear the collection and delivery accumulations and shipments The total	Initial value: 0, range: 0 to 1, 0: Do not clear 1: clear
40247	**00246**	You need to manually clear the last post when starting Service collection and delivery accumulation	Initial value: 0. The value ranges from 0 to 1. 0: This parameter is not required remove
40248	**00247**	Flow control mode selection	Initial value: 0, range: 0~1, 0: time control, 1: target value conversion
40249	**00248**	Automatically adjust target weight switch	Initial value: 0, range: 0~1, 0: no adjustment, 1: self-adjustment
40250	**00249**	Self-adjust target weight sampling window length	Initial value: 10, range: 10~50, After the adjustment switch is opened, proceed to the next time according to the length of the window

			Standard weight adjustment
40251	**00252**	Start/stop no-load test	Initial value: 0, range: 0~1, write 1: enter the no-load test;write 0: Exit the no-load test
40252	**00253**	No load test detects input	Initial value: 0, range: 0~ 1,0: no load test does not need to detect feeding allowed or unloading allowed;1: need to detect feeding allow and discharge allow
40253	**00254**	Delay before feeding for no-load test	MS is the unit, when entering the no-load test state, do not judge the weight, straight Then carry out each step according to this delay, and output corresponding output.
40254	**00255**	No load test fast add time	
40255	**00254**	Add time to the no-load test	
40256	**00255**	No load test slow add time	
40257	**00256**	No load test set time	
40258	**00257**	No load test unloading time	
40259 ... 40300	**00258 ... 00299**	The reserved	
User preferences			
40301	**00300**	Material no.	Initial value: 1, range: 0 to 10
40302	**00301**	The formula,	Initial value: 1, range: 0 to 20
40303	**00302**	The target	Initial value: 0, range: 0 to 999999, unit: gram
40304	**00303**		
40305	**00304**	Add the advance quickly	Initial value: 0, range: 0~ maximum range, unit: gram
40306	**00305**		

40307	**00306**	Canada ahead of the curve	Initial value: 0, range: 0~ maximum range, unit: gram
40308	**00307**		
40309	**00308**	Slow plus 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, range: 0 to 99999, in milliseconds
40314	**00313**		
40315	**00314**	Delay before feeding	Initial value: 0, range: 0~99999, unit: milliseconds
40316	**00315**		
40317	**00316**	Set hold time	Initial value: 900, range: 0 to 99999, in milliseconds
40318	**00317**		
40319 ... 40326	**00318 ... 00325**	The reserved	
40327	**00326**	Combination Mode (read only)	Initial value: 1, Read only. 1 or 2:1 non-combined mode.2 Combined mode
40328	**00327**	Refill progression (read only)	Initial value: Automatically determined based on the target value Feeding series,2: two levels of feeding;**3: three level feeding. Controller will** Automatically choose whether to feed two or three stages according to the range Material.[2 level, fast + slow add, add advance and middle add no Meaning][Level 3, fast plus + plus + slow plus, but add or add fast The lead is 0 or the opening is set to 0 and still does not go fast plus or medium

			Add]
40329	**00328**	Separate configuration opening	Initial value: 0, range: 0~1
40330	**00329**	This recipe is quick to add degrees	Initial value: 8000, range: 0~ maximum opening
40331	**00330**	Add extra degrees to this recipe	Initial value: 5000, range: 1 to maximum opening
40332	**00331**	This recipe is slow to open	Initial value: 1800, range: 2 to maximum opening
40333 ... 40340	**00332 ... 00339**	The reserved	
40341	**00340**	Target flow function switch	Initial value: 1, range: 0~1. This function is enabled by default in meter scale mode
40342	**00341**	Target traffic value	Initial value: 0, range: 0 to 999999, unit: P1H (per hour).This parameter cannot be set beyond" "Maximum traffic limit".
40343	**00342**		
40344	**00343**	Maximum traffic limit	Initial value: 12, range: 0 to 999999, maximum flow the device can achieve.Used to limit the target flow The setting cannot exceed this value.(The default is 12T/H.)
40345	**00344**		
40346	**00345**	Insufficient flow alarm function switch	Initial value: 0, range: 0~1, the actual discharging interval time continuously exceeds the calculated discharging interval time times more than "insufficient flow alarm statistics", then alarm
40347	**00346**	Insufficient traffic alarm statistics times	Initial value: 10, range: 0~99, several consecutive feeding interval Time out, and the number of times reached the value set by F5.4, instrument output flow insufficient alarm
40348	**00347**	Automatic adjustment function switch	Initial value: 0, range: 0~1, the switch is turned on, if there is a timeout in the unloading interval, the instrument will adjust

		after insufficient flow (discharge interval timeout)	automatically, shorten the unloading interval time after, until the timeout time offset.
40349	**00348**	Packet interval	Initial value: 2500, range: 2000 to 10000, unit: ms; Fixed interval time between each packet
40350	**00349**		
40351	**00350**	Current task work order number (readable Can write)	Initial value: 0, range: 0 to 999999999
40352	**00351**		
40353	**00352**	Hopper push rod working frequency (Readable and writable)	Initial value: 10000, range: 2500 to 25000 Frequency of electric push rod during operation
40354	**00353**		
40355	**00354**	PID scaling coefficient P	
40356	**00355**	PID coefficient k.	
40357	**00356**	PID coefficient D	
40358	**00357**	Lack of material stop switch	
40359	**00358**	Hopper push rod start frequency (Readable and writable)	Initial value: 10000, range: 10000~25000 Frequency at which the electric push rod starts
40360	**00359**		
40361 **...** **40400**	**00360** **...** **00399**	The reserved	
Switching quantity parameters			
40401	**00400**	Start/end switch volume test	Write 1 Start switch volume test;Write 0 to end the switch measurement

			try	
40402	**00401**	Input switch quantity test (read only)	From low to high each bit represents an input state	
40403	**00402**	Output switch quantity test	From low to high, each bit represents an output state	
40404	**00403**	IN1	The initial	instructions
			1	Enter the definition list: **I00: No definition** **I01: start** **I02: stop** **I03: stop** **I04: feeding stepper motor origin (close the door to** Bit, level) **I05: Feed allowed** **I06: Discharging allowed** **I07: Clearing alarm** **I08: keep** **I09: Open/close discharge door [original manual discharge** Function, switch the discharging output state] **I10: Manual discharging** **I11: Manual slow loading** **I12: Add manually** **I13: Manual quick add [press the quick add opening to open** The door]
40405	**00404**	IN2	**2**	
40406	**00405**	IN3	**5**	
40407	**00406**	IN4	**6**	
40408	**00407**	(1-ZT1)	**4**	
40409	**00408**	(1-ZT2)	**23**	
40410	**00409**	(2-ZT1)		
40411	**00410**	(2-ZT2)		
40412	**00411**	IN5		
40413	**00412**	IN6		
40414	**00413**	IN7		
40415	**00414**	IN8		

				I14: Manual cleaning [open at maximum opening The door] **I15: Start/Stop (Double edge: effective edge,** Start;Invalid edge, stop) **I16: Start/emergency stop (double edge)** **I17: Manual discharge (double edge)** **I18: Manual slow loading (double edge)** **I19: Manual add (double edge)** **I20: Manual Quick Add (double edge)** **I21: Manual cleaning (double edge)** **I22: reset** **I23: Emergency stop [level](valid, then not** Start allowed, manual refilling not allowed, not allowed Manual unloading is allowed) **I24: feeding stepper motor opening limit point.** **I25: origin of discharging stepper motor.** **I26: opening limit point of discharging stepper motor.** **I27: jam** **I28: End of collection and delivery** **I29: Manual discharge** **I30: servo motor alarm**
40416	**00415**	OUT1		Output definition list:

40417	**00416**	OUT2		**O00: None defined** **Run O01:** **O02: refueling request** **O03: feeding stepper motor direction [has PW** Signal is set to feed PWM] **O04: quick to add** **I add O05:** **O06: slow** **O07: fixed value** **O08: Unloading L** **O09: over/under** **O10: alarm** **11: clip bag** **O12: Preset number of bags completed** **O13: One packaging completed (unloading finished** Rear output 1s minutes) **O14: stop** **O15: Unloading stepper motor direction** **O16: Discharge motor running/forward** **O17: Reversal of discharging motor** **O18: Feeding PWM[only available for OUT7/OUT8]** **O19: Discharging PWM[only available for OUT7/OUT8]** **O20: Last scale** **O21: End of receipt and delivery** **O22: servo motor alarm**
40418	**00417**	OUT3		
40419	**00418**	OUT4		
40420	**00419**	OUT5		
40421	**00420**	OUT6		
40422	**00421**	[DR1]		
40423	**00422**	[DR2]		
40424	**00423**	[PWM1]		
40425	**00424**	[PWM2]		

			O23: Set value complete
40426	**00425**	PWM1 function	0 ~ 2
40427	**00426**	PWM2 function	0 ~ 2
40428	**00427**	Start the	Writing: 1. Read: 1 Running status.0: stopped state.
40429	**00428**	scram	Writing: 1. Read: 1 Stop state.0: Running state.
40430	**00429**	stop	Writing: 1. Read: 1 Stop signal has been entered (this time It will stop after the wrapping process is finished). 0: The stop signal is not entered.
40431	**00430**	reset	Writing: 1. Read: 1 Weight is 0.0: Weight is not 0.
40432	**00431**	Remove alarm	Writing: 1. Read: 1 No alarm.0: Alarm reported.
40433	**00432**	Choose the formula	Writing: 1. Read: 0.
40434	**00433**	Loose bag	Writing: 1. Read: 1 has clipped the bag.0: Bag not clipped.
40435	**00434**	Open/close the discharge door	Write: 1: Switch discharge door status: valid -> Invalid, invalid -> valid Read: 1: Unloading is valid.0: Unloading none Effect.
40436	**00435**	Slowly add manually	Writing: 1. Read: 1 Slow plus effective.0: Slow plus does not work.
40437	**00436**	Manually add	Writing: 1. Read: 1 Add valid.0: Add invalid.

40438	**00437**	Quickly add manually	Writing: 1. Read: 1 Quick add valid.0: Quick plus does not work.
40439	**00438**	Manual cleaning (storage hopper cleaning)	Write: 1: Switch the clearing state Read: 1 Clear material is valid.0: Clearing is not effective. Clear material effective: quick add effective, discharge has Effect.Clear material invalid: fast add ineffective, discharge Is invalid.The quick loading and discharging states are not consistent, Take the feeding state as the judgment standard.
40440	**00439**	Manual Max Open Quick Add	Writing: 1. Read: 1 Quick add valid.0: Quick plus does not work.
40441	**00440**	Automatic feeding once (stop after setting the value)	Writing: 1. Read: 1 Being refilled automatically.0: not automatic Charging.
40442	**00441**	Emergency stop	Write: 0/1: Exit/enter Emergency stop lock Set the state. Read: 1 has made an emergency stop.0: not urgent Stop.
40443	**00442**	Manually unload once	Writing: 1. Read: 1 Unloading.0: Unloading is not working.
40444	**00443**	Allowed to add	Read/Write 1: Allow plus works.Read/write 0: enable Add is invalid.
40445	**00444**	Allow unloading	Read/Write 1: Allow unloading to work.Read/write 0: enable Discharge is invalid.

40446	**00445**	End of collection and delivery	Go to I28: to end the function of receiving and sending the same volume switch
40447	**00446**	Discharge hopper manually	Write: 1 Take the discharge door of the hopper upside down. Read: 1 Discharge door open, 0 closed
40448	**00447**	The whole balance discharging	Write: 1. Metering bucket discharge door, discharge hopper discharge door to take reverse. Used for empty Two buckets of memory material in this scale. Read: 1 manual discharge open, 0 closed
40449	**00448**	Clear out hopper	Write: 1. The discharge hopper performs zero clearing. Make sure that the outlet hopper material has been cleared Empty. Please note that the zero clearing operation will not be saved by power failure. Power on again, Will display non-zero.
40450	**00449**	Outlet hopper marked zero	Write: 1. The discharge hopper is calibrated to zero. Please make sure that the hopper material is already Empty.
40451 ... 40460	**00450 ... 00459**	The reserved	
40461	**00460**	OUT7	With the OUT1 - OUT6
40462	**00461**	OUT8	
40463 ... 40500	**00462 ... 00499**	The reserved	
.Communication parameters			
40501	**00500**	Serial Port 1 Slave number (read only)	Initial value, 1, range: 1 to 99
40502	**00501**	Serial Port 1 Communication	Initial values, 0,0: modbus-rtu, 1: Modbus-ASCII, 2: serial printer

		protocol (only Read)	
40503	**00502**	Serial Port 1 Baud rate (read only)	Initial values, 3, 0:9600, 1:19200, 2:38400, **3:57600, 4:115,200**
40504	**00503**	Serial Port 1 Data Format (only Read)	Initial values, 1, 0:18N2, 1:18E1, 2:18O1, 3: **18N1**
40505	**00504**	Serial port 1Modbus double word mail Memory sequence (read only)	Initial values, 0,0: ABCD, 1: CDAB
40506	**00505**	Serial Port 2 Slave number	Initial value, 1, range: 1 to 99
40507	**00506**	Serial Port 2 Communication protocol	Initial value, 0,0: modbus-rtu, 1: Modbus-ASCII, 2: serial printer
40508	**00507**	Serial port 2 Baud rate	Initial values, 3, 0:9600, 1:19200, 2: **38400, 3:57,600, 4:115,200**
40509	**00508**	Serial port 2 Data format	Initial values, 1, 0:18N2, 1:18E1, 2: **18O1, 3:18N1**
40510	**00509**	2 high modbus serial port Low word order	Initial values, 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, 2: serial printer
40513	**00512**	Serial port 3 Baud rate	Initial values, 3, 0:9600, 1:19200, 2: **38400, 3:57,600, 4:115,200**

40514	**00513**	Serial port 3 Data format	Initial values, 1, 0:18N2, 1:18E1, 2: **18O1, 3:18N1**
40515	**00514**	Serial port 3Modbus highland 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 Port Communication Protocol	
40522	**00521**	Network port high and low byte order	
40523	**00522**	MAC1	0~0xFF
40524	**00523**	MAC2	0~0xFF
40525	**00524**	MAC3	0~0xFF
40526	**00525**	MAC4	0~0xFF
40527	**00526**	MAC5	0~0xFF
40528	**00527**	MAC6	0~0xFF
40529 ... 40600	**00528 ... 00599**	The reserved	
System parameters			

40701	**00700**	Device model (ASCII code Characters) (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 converting decimal value to**
40712	**00711**		**123456, the value is 12.34.56. The range is 0 to 999999**
40713	**00712**	Compiled date: Year (read only)	**2000 ~ 2099**
40714	**00713**	Compiled date: Month (read only)	**1 ~ 12**
40715	**00714**	Compile Date: Day (read only)	**1 to 31**
40716	**00715**	Compile Date: Hour (read only)	**0 ~ 23**
40717	**00716**	Compile Date: minutes (read only)	**0 ~ 59**
40718	**00717**	Compile date: seconds (read only)	**0 ~ 59**
40719	**00718**	Parameters of the reset	Write: **0 Reset all (production used, contains all below additionally also** There are statistics clear, cumulative clear, putter-related parameters)

			(Superuser) **(Super User) 1 Reset all (customers) including all below** **2 Reset the basic parameters** **3 Reset the calibration parameters** **4 Reset user parameters** **5 Reset peripheral parameters** **6 Reset the adaptive parameters** **7 Reset the communication parameters** **8 Reset switch quantity Custom parameters** **9 Reset adaptive statistics** Read: 0
40720	**00719**	keep	
40721	**00720**	Turn USB on/off	**1: Turn USB on, 0: turn USB off**
40722	**00721**	USB device connected (only Read)	**0: USB device is connected, 1: USB device is not connected**
40723	**00722**	USB mass storage device Connected (read only)	**0: USB mass storage device is connected** **1: USB mass storage device is not connected**
40724	**00723**	Export data	**Write:** 10: All parameters 11: Calibration parameters 12: basic parameters 13: User parameters 14: IO custom 15: communication parameters 16: peripheral parameters 17: adaptive parameter 18: Putting parameters 19: Advanced hidden parameters 50: All Statistics (Super user)

			51: All statistics (non-super users) 52: Cumulative statistics 53: Packaging Record statistics (Superuser) 54: Packaging Record Statistics (non-superuser) 55: Parameter modification statistics Read: 0
40725	**00724**	Data export result information	0: No information 1: Export successfully 2: Export failed (Message lasts 2 seconds and then automatically cancels)
40726	**00725**	Data import	Write: 10: All parameters 11: Calibration parameters 12: basic parameters 13: User parameters 14: IO custom 15: communication parameters 16: peripheral parameters 17: adaptive parameter 18: Putting parameters 19: Advanced hidden parameters Read: 0
40727	**00726**	Data import result information	0: no information 1: imported successfully 2: Import failed 3: Import file does not exist (Message lasts 2 seconds and then automatically cancels)
40728 **...** **40750**	**00727** **...** **00749**	The reserved	

"Usb Flash Drive Update App" function parameters			
40751	**00750**	Enter/exit the Bootloader	Read: **0: Automatically enter the main program after waiting for 3 seconds delay** **1: the Bootloader has been entered** Write: **1: Go to Bootloader** **2: Exit the Bootloader and enter the main program**
40752	**00751**	USB device connected (only Read)	**0: USB device is connected** **1: USB device is not connected**
40753	**00752**	USB mass storage device has Connected (read only)	**0: USB mass storage device is connected** **1: USB mass storage device is not connected**
40754	**00753**	Upgrade file scan results (only Read)	**0: No upgrade file** **1: There is a control panel upgrade file**
40755	**00754**	Control panel program upgrade information (read-only)	**Zero: no** **1: The control panel is being upgraded** **2: The control panel upgrade failed** **3: The control board is upgraded successfully** **4: The control panel upgrade file does not match the instrument model** **5: There is an error in the control panel upgrade file** **6: The control panel upgrade file does not exist**
40756	**00755**	Reserved (read only)	
40757	**00756**	Control panel upgrade file version number	Read: Version number (6-digit decimal number) Write: 1 Upgrade this version of the program
40758	**00757**		

40759 ... 40800	**00758 ... 00799**	The reserved	
Adaptive relevant parameters			
40801	**00800**	Adaptive master switch	Initial value: 1, range: 0~1
40802	**00801**	Adaptive & automatic scale grading	Initial value: 1, range: 0~4
40803	**00802**	Positive error function switch	Initial value: 0, range: 0~1
40804 ... 40900	**00803 ... 00899**	The reserved	
Internal reservation parameters			
40901 ... 40916	**00900 ... 00915**	The reserved	
40917	**00916**	Add time to the embargo quickly	Initial value: 700, range: 0 to 9999, in milliseconds
40918 ... 40923	**00917 ... 00922**	The reserved	
40924	**00923**	Canada-china ban time	Initial value: 700, range: 0 to 9999, in milliseconds
40925	**00924**	Slow plus time off	Initial value: 700, range: 0 to 9999, in milliseconds
40926 ... 41100	**00925 ... 01099**	The reserved	
Target value data parameters			

[Only the target value of each formula under the current material number, do not support reading the target value of each formula number of different materials]			
41101	**01100**	Target value (Recipe 1)	Range: 0 to 999999, in grams, read only
41102	**01101**		
41103	**01102**	Target Value (Formula 2)	Range: 0 to 999999, in grams, read only
41104	**01103**		
41105	**01104**	Target Value (Formula 3)	Range: 0 to 999999, in grams, read only
41106	**01105**		
41107	**01106**	Target Value (Formula 4)	Range: 0 to 999999, in grams, read only
41108	**01107**		
41109	**01108**	Target Value (Formula 5)	Range: 0 to 999999, in grams, read only
41110	**01109**		
41111	**01110**	Target value (Recipe 6)	Range: 0 to 999999, in grams, read only
41112	**01111**		
41113	**01112**	Target value (Formula 7)	Range: 0 to 999999, in grams, read only
41114	**01113**		
41115	**01114**	Target value (Formula 8)	Range: 0 to 999999, in grams, read only
41116	**01115**		
41117	**01116**	Target value (Recipe 9)	Range: 0 to 999999, in grams, read only
41118	**01117**		
41119	**01118**	Target value (Recipe 10)	The value ranges from 0 to 999999 (unit: gram)
41120	**01119**		
41121 ... 41200	**01120 ... 01199**	The reserved	
Cumulative data parameters			

41201	**01200**	Clear the total cumulative data	Write 1 Clear the total cumulative data and all recipe cumulative data Write 2 only clears total cumulative data but not recipe cumulative data Write 3 clears the receipt and delivery accumulations and the total accumulations Write 4 clears the collection and shipment accumulations
41202	**01201**	Clear recipe accumulation data	Write person 0 to clear all recipe accumulations Write 1 to 20 to clear the corresponding recipe 1 to 20 cumulative data
41203	**01202**	Total cumulative times	A maximum of 9 decimal digits
41205	**01204**	Total cumulative times	Write person 0 to clear all recipe accumulations Write 1 to 20 to clear the corresponding recipe 1 to 20 cumulative data
41207	**01206**	Total cumulative weight (high 4 places)	Maximum 13-digit decimal number
41208 **...** **42000**	**01207** **...** **01999**	The reserved	
Automatically adjust scale parameters			
42001	**02000**	Automatically adjust scale status	Read: Automatic scale adjustment status :0/1: Stop/run.2. Automatic scale adjustment Done.[midrun abort set back to 0, not 2], read only
42002	**02001**	Maximum type of material	**10~40. Temporarily fixed to 10. Later adjustment. That is, the maximum support is guaranteed** Store 10 different materials, read only

42003	**02002**	=40301, current material type	read-only
42004	**02003**	=40302, current recipe number	read-only
42005	**02004**	=41050, current specification scales the most Large range points	read-only
42006	**02005**	=41096, current target value In the range point	read-only
42007	**02006**	Automatic scale adjustment times	Initial value: 6, range 3 to 10
42008	**02007**	How many	
42009	**02008**	Qualified times	
42010	**02009**	Automatic scale grading	Initial value: 1, range: 0~4, the smaller the grade, the better the speed First, the small casting time is about 0.2s longer for each level increase
42011	**02010**	Start/stop automatic scale adjustment	Read: Automatic scale adjustment status :0/1: Stop/run (complete status Ascribed to 0), write :1/0: start/shut down autoscale
42012	**02011**	Save the automatic scale adjustment results	Write 1: Save autoscale result to current current material number current Under recipe number, write 2: give up saving and restore debugging result to silent Value.
42013 ... 42020	**01207 ... 02019**	The reserved	

42021	**02020**	Material XSegY quick increase in advance The results of	X= material number,Y segment number, material number change, target value change [span Range section], then the value of this area may change automatically
42022	**02021**		
42023	**02022**	Material XSegY plus plus advance The results	
42024	**02023**		
42025	**02024**	Material XSegY slow add advance The results of	
42026	**02025**		
42027	**02026**	Material XSegY Quick opening knot fruit	
42028	**02027**	Material XSegY in the added opening knot fruit	
42029	**02028**	Material XSegY slow opening knot fruit	

8. Basic function instructions

8.1 Working principle and operation process

Working principle of rice distribution scale: rice distribution scale is divided into two parts, the upper part is divided into flow scale, servo motor fast feeding, used for accurate weighing, automatic adjustment of opening and advance for flow control and cumulative

weight record.The lower part is divided into weightlessness weighing, according to the current hopper weight real-time control of the feeding cylinder, to ensure the uniform outflow of material, will not produce the phenomenon of disconnection or large impulse.The upper and lower parts cooperate with each other, which can not only ensure the accuracy and flow control through the flow balance of the upper part, but also ensure the continuity of the material through the weight loss balance of the lower part.

Rice distribution scale operation process: set the target flow rate and the total amount of material, the equipment will automatically calculate and generate the corresponding target value and opening of each scale, start feeding, namely: Fast feeding, the system automatically calculates the amount of lead generated as a control cut-off point, the second step, after the end of feeding, into the value process, the value of time can be set, after the end of the value, the equipment through the switch output "feeding complete" signal;The third step, the device receives the external "allow unloading" effective switch signal, the device will drive the cylinder to open the unloading door of the metering bucket, when the weight of the material in the metering bucket is lower than the zero zone value set before, the device drives the cylinder to close the unloading door, complete a quantitative process;The fourth step, the material into the hopper after the electric push rod action, the discharge door opened to a certain opening so that the material outflow evenly;Before starting the next quantitative process, the equipment first carries out a period of delay before feeding, and then carries out the next feeding, discharging, and the material flows out evenly, so that the cycle repeats.

The working principle of the push rod: the stepping motor controls the expansion of the push rod, and then controls the size of the opening of the hopper.

The operation process of the push rod: 1. When starting, the push rod will not be opened directly at first, but wait for some materials in the hopper to start and open (to prevent the flow interruption and overshooting fluctuations when the material is less at the beginning). At this time, the opening degree is matched by the set target flow.2. When working normally, the hopper weighing controller will adjust the push rod in real time according to the weight in the hopper to control the weight of the hopper to maintain a relatively dynamic and stable state, so as to control the material flow in a relatively uniform outflow state.

8.2 Multi - scale linkage operation process

When this match meter scale factory has multiple water balance function, users only need to insert the linkage of the scale body navigation at the scene according to the cable requires the use of our design by the interconnection between multiple scales, multiple water balance can be realized, that is: as long as there is a bench scale start or stop, and the interconnection of other scales in lockstep start or stop.

8.3 Example for Parameter Setting

If the material is rice, the parameters of the rice distribution scale have been restored to factory Settings. If you want to run at a flow rate of 12T /h and control the total amount to 10T, you need to set the following parameters:

Working parameters:

1. Set the "automatic zero failure processing" to continue to be stable.

2. Set the "loading level weight of the hopper" to 13kg.

3. Set the "weight of discharging hopper level" to 6kg.

4. Set the "initial opening of hopper" to 40000.

5, set the "scale specification" to 12T.

Control parameters: Set the "initial opening calibration value" to 4000.

Main interface parameters: 1. Set "Target flow" to 12T /h.

2. Set "Target Value" to 10T.

After completing the above parameter Settings, start the rice distribution scale.

9. Common fault analysis and troubleshooting

Common faults in use, causes and handling methods.

The serial number	The fault phenomenon	why	To deal with
1	The device starts without blanking	1. There is no material in the storage bin 2. The closure door of the storage bin is not opened 3. Air source leakage 4. Air source pressure is too low or flat	1. Feed the storage bin 2. Open the closure door of the storage bin 3. Connect the air source 4. Increase the air pressure or turn on the air pressure switch
2	Plugging material	The discharging motor does not operate or the opening of the discharging hopper is inconsistent with the set target flow opening	The pushrod needs to be replaced if the power-off restart cannot be solved
4	Abnormal weight display	1.Faulty weight sensor 2.Not cleared before use 3.Equipment not calibrated 4.Incomplete unloading	1.Check the sensor and replace it if necessary 2.Stop reset 3.recalibrate 4.Increase the unloading time appropriately
5	Data cannot be exported	1.U disk is damaged 2.The USB flash drive interface of the electric control box is damaged	1.Replace the U disk 2.Check the interface

10. Maintenance, warranty

In order to ensure the weighing accuracy of the equipment, do not place the equipment in a cold and damp environment. According to the use situation, clean the dust generated by the material inside the equipment regularly. After daily use or maintenance, remember to close the electric control box door.

● Warranty principles

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

The equipment failure caused by the following circumstances is not covered by our warranty:

- Failure to operate according to the instructions
- Install without professional guidance
- Make structural changes to the equipment
- Damaging equipment without permission
- Programming and operation errors
- Natural damage to equipment