

MAGUIRE PRODUCTS INC.

Weigh Scale Blender®

MAGUIRE

WEIGH SCALE BLENDER®

12-12 Controller
4088 Standard Controller

with "FOUR" COMPONENT SOFTWARE

INSTALLATION • OPERATION • MAINTENANCE



Use this space to record information about your Maguire Weigh Scale Blenders:

[illegible]

Notes:

Maguire Weigh Scale Blender

This document is the Original Instructions manual of the Maguire Weigh Scale Blender models WSB-MB, WSB-100 Series, WSB-200 Series, WSB-400 Series, WSB-900 Series, WSB-1800 Series, WSB-2400 Series and WSB-3000 Series equipped with the 12-12 Controller or 4088 Standard Controller.

The information contained within this manual including any translations thereof, is the property of Maguire Products Inc. and may not be reproduced, or transmitted in any form or by any means without the express written consent of Maguire Products Inc.

To every person concerned with use and maintenance of the Maguire WSB it is recommended to read thoroughly these operating instructions. Maguire Products Inc. accepts no responsibility or liability for damage or malfunction of the equipment arising from non-observance of these operating instructions. Any modifications or amendments to the equipment, without prior consent of the manufacturer, may invalidate CE compliance of the equipment.

To avoid errors and to ensure trouble-free operation, it is essential that these operating instructions are read and understood by all personnel who are to use the equipment.

Should you have problems or difficulties with the equipment, please contact Maguire Products Inc. or your local Maguire distributor.

Copyright © 2025 Maguire Products Inc.

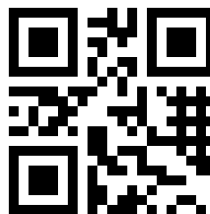
Manufacturer's Contact Information

Maguire Products Inc.
11 Crozerville Road
Aston, PA. 19014

Phone: 610.459.4300
Fax: 610.459.2700

Website: <http://www.maguire.com>

Email: info@maguire.com



Maguire Weigh Scale Blender 4 Software Operation & Maintenance Manual

Introduction

EC Declaration of Conformity _____	6
Getting Started – Read this page! _____	7
Safety Notifications and Safety Hazards _____	8
Blender Parts Key _____	10
12-12 Controller Parts Key _____	12
4088 Standard Controller Parts Key _____	14

Setup and Installation

Assembly and Installation Instruction _____	16
Wiring Considerations _____	21
Selecting the Correct Model _____	22
Check Out Procedure and Diagnostics _____	23

Configuration and Operation

Loadcell Zero and Full Weight Calibration _____	26
Material Flow Rate Calibration _____	28
Micro Pulse Instructions _____	29
Instructions for Normal Operation _____	30
Special Features – TAG, Recipe Database, FAST, Batch _____	31
WSB Controller Description of Controls and Outputs _____	33
Controller Keypad – Summary Description _____	44
Controller Keypad –Description of Functions _____	45
Star Functions – What they relate to _____	51
Star Functions _____	51
Parameters – What they relate to _____	60
Parameters Introduction _____	59
General Parameters _____	61
Changing Parameter Settings _____	84
Saving parameter Settings in User Backup _____	85
Communications _____	86

Printed Outputs

Monitoring System Accuracy	87
*54 Diagnostics Report	87
Parameter Printout	87
Interpreting the Cycle Printout	88
Troubleshooting with the Cycle Printout	89
Load Cell Calibration - Printout Verification	91
Special Tests - Printout Verification	92
Material Usage Printout	92

Blender Troubleshooting and Maintenance

Troubleshooting - What To Do	94
Typical Problems	95
Alarms – Cause and Solution	97
Mix Problems	101
Increasing Throughput	102
Normal Operating Sequence	102
Verifying Load Cell Function	104
Backup, Restore, Factory Reset	104
Clear Routine	105
Clear All	106
Updating Controller Firmware	107
LOTO, Cleaning, Maintenance	108
Maintenance and Preventative Maintenance	110
17 pin Amphenol Connector Pin Assignments	112
Technical Drawings, Electrical Diagrams, Pneumatic Diagrams	115
Dimensions and Weight by Model	145
Decommissioning and Disposal	146
Disclaimers	146
Accuracy of this Manual	146
Warranty	147
Technical Support and Contact Information	148

EC Declaration of Conformity



UK/EC DECLARATION OF CONFORMITY

Original

**Manufacturer Business Name & Full Address**

Maguire Products Inc
11 Crozerville Rd,
Aston,
PA
19014,
USA

Authorised Representative (if applicable)

Hold Tech Files Ltd.,
Dun Iseal, Newtown,
Gaulsmill, Ferrybank,
Waterford,
X91F638,
Republic of Ireland

Person Authorised To Compile the Technical File Name and Address

Hold Tech Files Ltd.

Machine Details

Name:

Electrical Info:

Serial Number:

Model:

I declare that the machinery fulfils all the relevant provisions of these Regulations: Supply of Machinery (Safety) Regulations 2008 as amended; Electromagnetic Compatibility Regulations 2016 as amended, and these Directives: Machinery Directive 2006/42/EC, Electromagnetic Compatibility Directive, 2014/30/EU.

Standards Used

EN4414 (2010); EN11201 (2010); EN12100 (2010); EN13849-1 (2015); EN13850 (2015); EN13857 (2008); EN14119 (2013); EN14120 (2015); EN60204-1 (AC:2010) and EN61310-1 (2008)

Place of Declaration

Maguire Products Inc
11 Crozerville Rd,
Aston,
PA
19014,
USA

Date of Declaration**Person Empowered to Draw Up Declaration**

Mr Steve Maguire

Signature

Position

President



Produced using Compliance Risk Software
www.compliancerisksoftware.co.uk

Declaration Number:



Getting Started – Important!

Blender Part Identification	Page: 10	Identifying key parts of the blender and what they do.
Controller Parts Identification	Page: 10	Identifying the key parts of the blender controller.
Setup and Installation	Page: 16	Assembly, setup and installation instructions.
Wiring Considerations	Page: 21	How to minimize electrical interference.
Check Out Procedure	Page: 23	Step by step procedure to verify correct assembly.
Model Selection	Page: 22	How to verify and change your model selection. All new blender controllers are pre-configured with the model from factory. New, spare or swapped controllers may require a model change.
Load Cell Calibration	Page: 26	Load Cells of new blenders are calibrated at the factory. However shipping or rough handling can create load cell problems. If weight readings are not correct, you MUST recalibrate the load cells.
Material Flow Rate Calibration	Page: 28	A flow rate calibration is not necessary because the blender will learn the flow rate over time however if you change equipment or material you may want to re-calibrate the material flow rate.
Normal Operation & Saving the Configuration	Page: 30	How to start the blender and save / restore the configuration.
Lockout/Tagout, Cleaning, Maintenance.	Page: 108	How to Lockout/Tagout, Clean and Maintain your blender.

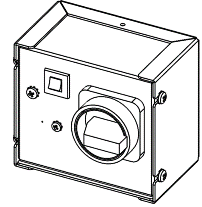


Safety Notifications



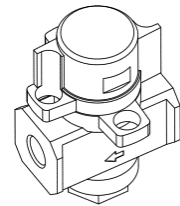
Electrical Lockout/Tagout Points

Disconnect electric before opening or servicing. If the weigh scale blender is equipped with an electrical LOTO box, use the lockout tagout switch to perform the power lockout/tagout. On 110v blenders, use a Plug lockout. Read: LOTO, Cleaning, Maintenance on page 108.



Pneumatic Lockout/Tagout Points

Disconnect compressed air supply before opening or servicing. If the weigh scale blender is equipped with a manually operated pneumatic valve actuator, use this lockout/tagout valve to perform a pneumatic lockout/tagout. Read: LOTO, Cleaning, Maintenance on page 108.



Eye Protection

Always wear safety glasses when using this equipment.



Maximum continuous noise level

The highest continuous Noise levels recorded for this equipment was measured at 71.4 db.



Safety Interlock Switch

The weigh bin / mix chamber access door may be equipped with a Safety Interlock Switch that prevents the mix motor from running and the slide valves from opening. DO NOT disable or bypass this Safety Interlock Switch. Refer to the motor safety circuits on page 140 for how the safety interlock switch is wired into the weigh scale blender.



Hopper Finger Guards

Finger Guards are fitted into each Material Hopper compartment. DO NOT reach through these Guards. DO NOT use fingers to clear an obstruction below these guards. DO NOT remove these Guards.



HAZARD - AUTOMATIC STARTUP

WARNING - Blender may start automatically without warning.



Safety Hazards

See Blender Parts Key for Safety Hazard Locations



HAZARD - ROTATING MIX BLADE

Mix Blades are driven with substantial torque. Never place your hand in the Mix Chamber while the blades are rotating. **SERIOUS INJURY WILL RESULT.** Always disconnect blender power using proper lockout/tagout procedures before servicing. Never defeat the Mix Chamber safety interlock switch.



HAZARD - SHARP MIX BLADES

Over time, Mix Blades may become **RAZOR SHARP**. **ALWAYS** be careful when **TOUCHING** or **CLEANING** these blades. Check for Sharp Edges frequently. Replace Blades if a Hazard exists.



HAZARD - SLIDE VALVES

Slide valves in hoppers **SLAM CLOSED** without warning. **ALWAYS** keep fingers clear of slide gate openings. **NEVER** use your fingers to clear an obstruction. **NEVER** use your fingers to move a sticking slide gate.



HAZARD - ELECTRICAL

Only qualified electrical technicians should make electrical connections. Disconnect and lockout power supply before servicing WXB Blender.



HAZARD - ROTATING SHAFT

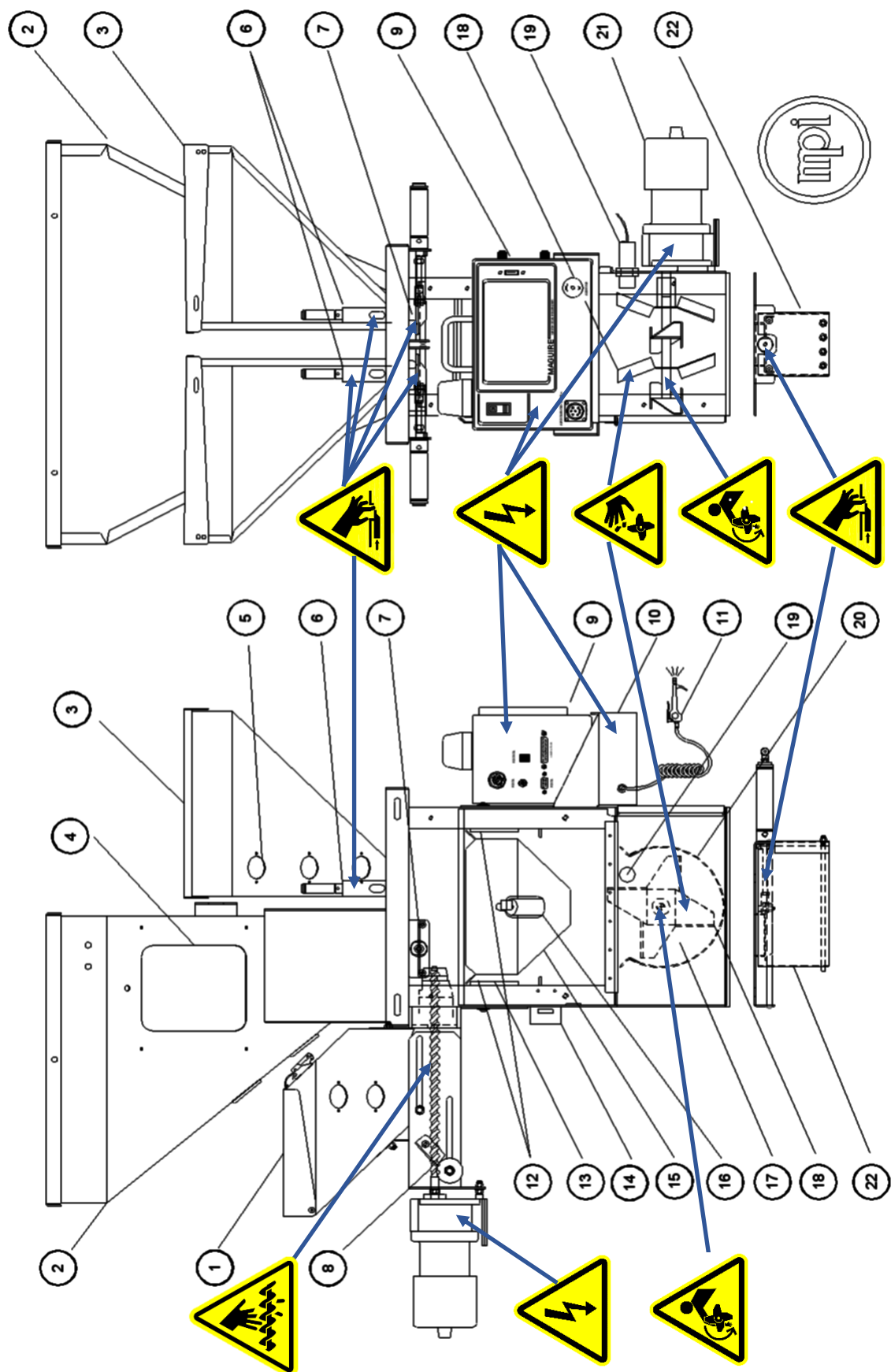
Auger Feeders contain a rotating shaft. **ALWAYS** keep fingers clear of rotating shaft and auger. **NEVER** use your fingers to clear an obstruction. **NEVER** touch a rotating shaft or auger.



HAZARD - FALLING OBJECTS

Do Not open hopper access door if material level is above hopper cleanout door.

Blender Parts Identification

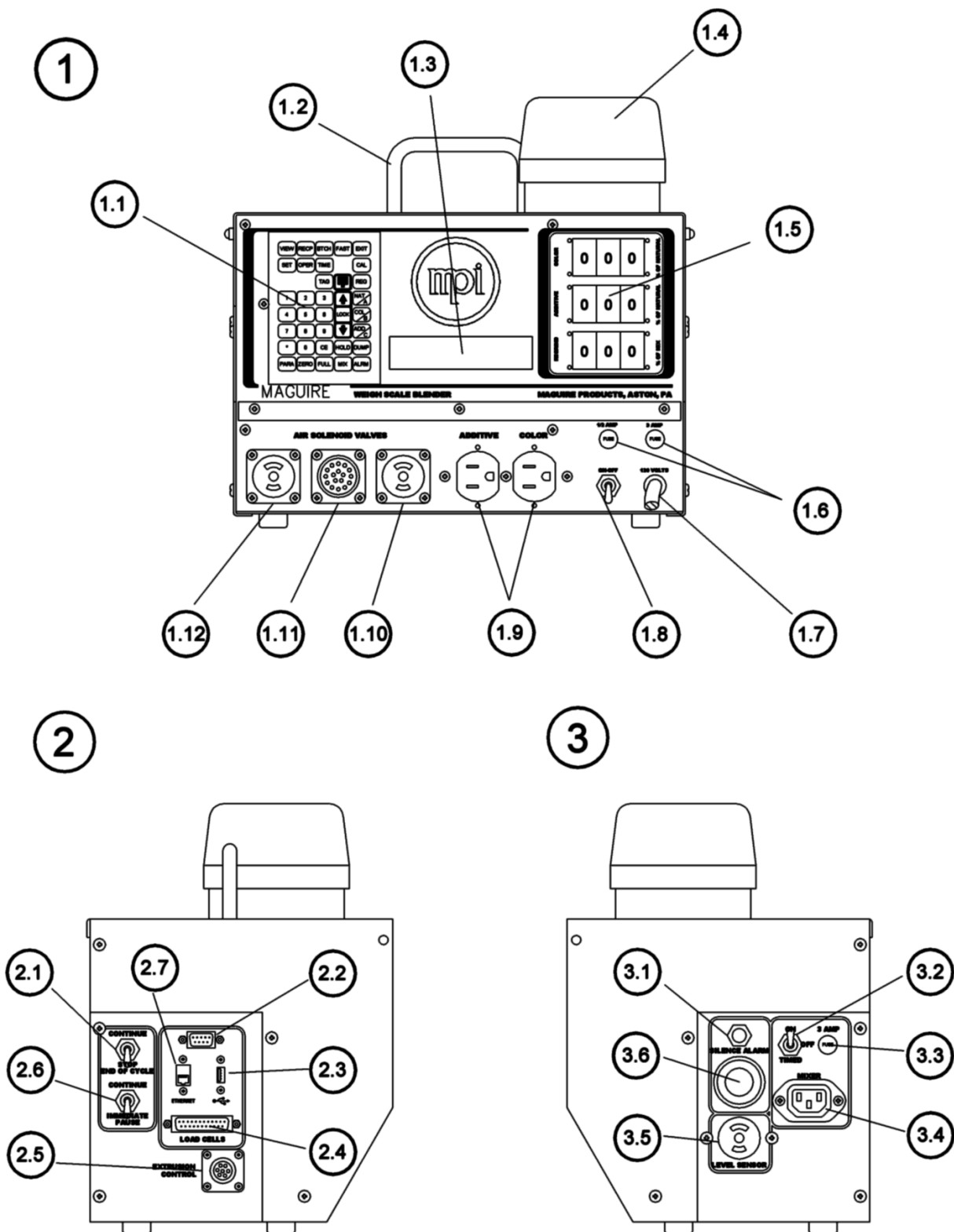


Blender Parts Key

1. **Auger Feeder** – Screw Feeder for feeding in small percentage materials such as Colors and Additives
2. **Fixed Material Hopper** – Material Hopper for main materials to be dosed by the slide gates
3. **Removable Hopper** – Removable Material hopper for small percentage materials such as Colors and Additives
4. **Hopper Access Door** – Door to access inside of hopper for quick cleaning and materials changes
5. **Sight Glass** – Means to view current material level inside the hopper
6. **Vertical Valve** – Dispense Device mounted inside removable hopper for small percentages up to 10%
7. **Slide Gate** – Dispense Device mounted below fixed hoppers to dispense large percentages
8. **Auger Screw** – Dispense Device mounted inside removable hopper for small percentages up to 10%
9. **Controller** – Central Controller for all settings on the blender
10. **Air Assembly & Solenoids** – Pneumatic assembly for activating pneumatic parts automatically and manually
11. **Cleaning Airline** – Airline for quick and easy cleaning of blender during materials changes
12. **Load Cells** – Load Cells monitor continuously the weight in the Weigh Bin
13. **Load Cell Bracket** – Load Cell Bracket for mounting Weigh Bin onto the Load Cells
14. **Safety Interlock** – Pneumatic and Electrical Safety interlock – stops blender operating if door is opened
15. **Weigh Bin** – Weigh Bin holds materials as materials are dispensed during a batch and weighed
16. **Dump Valve** – Pneumatic Valve and Flap to release materials from Weigh Bin when a batch is complete
17. **Mix Chamber** – Area where materials are blended together after being weighed
18. **Mix Blades** – Removable Mix Blades to fold the materials together to achieve an effective blend
19. **Level Sensor** – Sensor to monitor material level in the Mix Chamber, pauses blender when covered and mix chamber is full, once uncovered signals Controller to begin a new batch of material.
20. **Mix Chamber Insert** – Stainless Steel removable insert to assist in quick materials cleaning and changes
21. **Mix Motor – Electric Motor to drive Mix Blades** – Note on WSB MB and WSB 100 Series blenders this motor is a pneumatic Mix Motor
22. **Flow Control Valve** – (Optional) – Additional pneumatic slide gate with finger guards to be used when blender is not mounted directly on the throat of a machine but instead a stand or surge hopper. The Flow Control Valve ensures material remains inside the Mix Chamber long enough to be mixed efficiently. Automatically controlled by the blender Controller.

12-12 Controller Parts Identification

The 12-12 controller can be identified by a black metal enclosure.



Controller Parts Key

1. Front Panel

- 1.1 Keypad
- 1.2 Service Handle
- 1.3 Main Display
- 1.4 Alarm Beacon
- 1.5 Materials Thumbwheels
- 1.6 Fuses
- 1.7 Power Cord
- 1.8 On / Off Switch
- 1.9 Outputs for additional Feeders
(**NOTE – Feeder Outputs** – These 2 outputs are not available on WSB MB and WSB 100 Series Blenders.)
- 1.10 Options - High Sensor Mount or Remote Alarm Output
- 1.11 Air Solenoid Connection
- 1.12 Optional – Low Sensor Mount

2. Left Side Panel

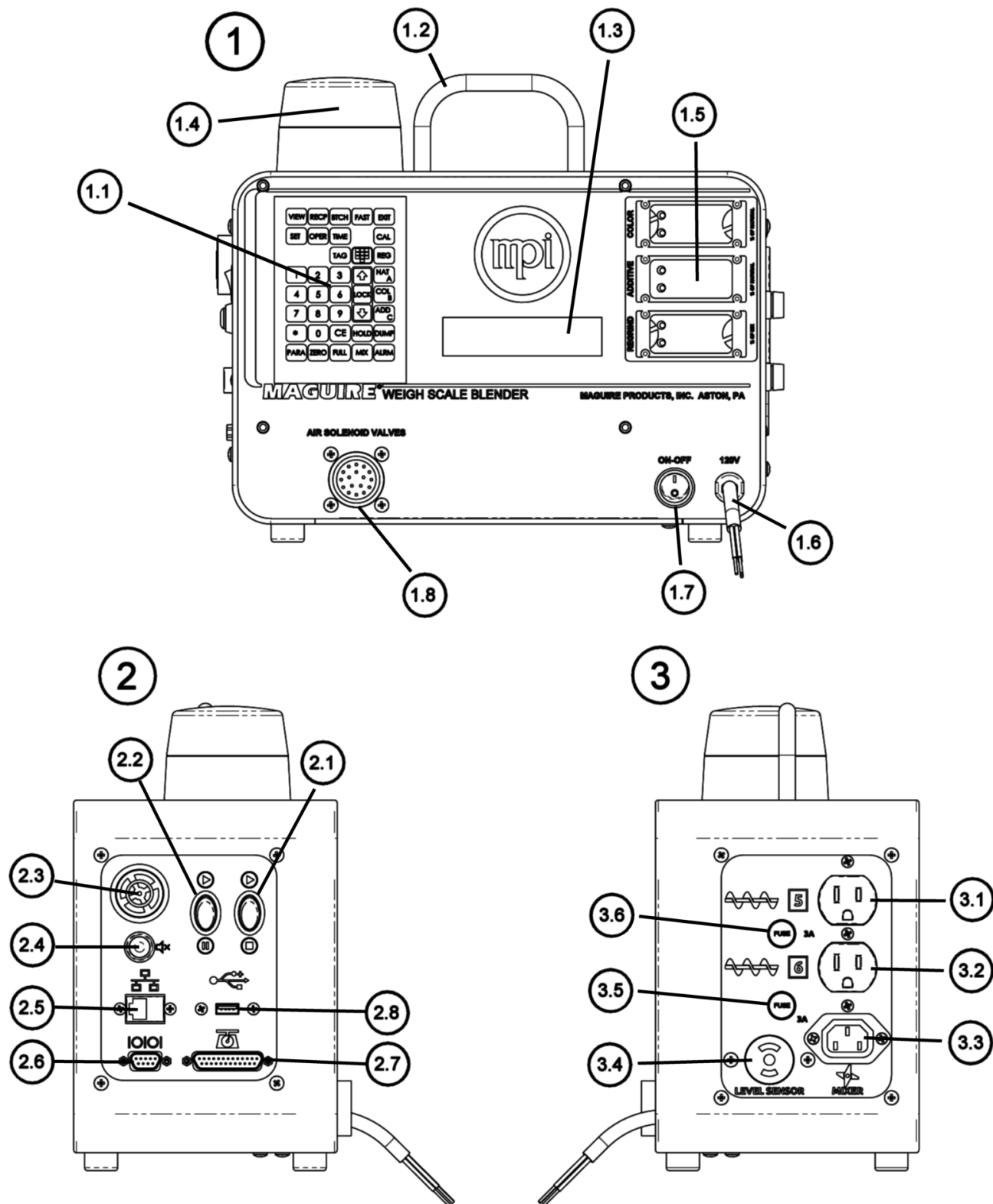
- 2.1 Stop End of Cycle / Continue Switch
- 2.2 Computer Serial Connection
- 2.3 USB Port for Flash Drive (software updates, reports to text files)
- 2.4 Load Cell Port Input
- 2.5 Optional – Extrusion Control 2 Way Interface
- 2.6 Immediate Pause / Continue Switch
- 2.7 Ethernet Port (RJ-45)

3. Right Side Panel

- 3.1 Silence Alarm Press Down Button
- 3.2 Electrical Mix Motor Operation Switch – Timed (Default), On or Off
- 3.3 Electrical Mixer Output Fuse
- 3.4 Electrical Mix Motor Power Plug
(**NOTE – Mixing Controls** – These 3 features not available on WSB MB and WSB 100 Series Blenders – fitted instead with Pneumatic Mixers.)
- 3.5 Mix Chamber Level Sensor Input
- 3.6 Audible Alarm Loudspeaker

4088 Standard Controller Parts Identification

The 4088 Standard controller can be identified by a silver metal enclosure.



12-12 Controller Parts Identification

1. Front Panel

- 1.1 Keypad
- 1.2 Service Handle
- 1.3 Main Display
- 1.4 Alarm Beacon
- 1.5 Digital Material Thumbwheels Digital
- 1.6 Power Cord
- 1.7 On / Off Switch
- 1.8 Air Solenoid Connection

2. Left Side Panel

- 2.1 Stop End of Cycle / Continue Switch
- 2.2 Immediate Pause / Continue Switch
- 2.3 Audible Alarm Loudspeaker
- 2.4 Silence Alarm Press Down Button
- 2.5 Ethernet Port (RJ-45)
- 2.6 RS-232, RS-485 port
- 2.7 Load cell communication port
- 2.8 USB Port for Flash Drive (software updates, reports to text files)

3. Right Side Panel

- 3.1 and 3.2 Outputs for additional Feeders (NOTE – Feeder Outputs – These 2 outputs are not available on WSB MB and WSB 100 Series Blenders.)
- 3.3 Electrical Mix Motor Power Plug
(NOTE – **Mixing Controls** – These 3 features not available on WSB MB and WSB 100 Series Blenders – fitted instead with Pneumatic Mixers.)
- 3.4 Mix Chamber Level Sensor Input
- 3.5 Electrical Mixer Output Fuse
- 3.6 Fuse for feeder outputs

Setup and Installation

Operating Conditions

Operating Temperature Range: 5°C - 90°C (41°F - 194°F)

Maximum Allowable Humidity: 80% @ 50°C (122°F)

Maximum Altitude: 2500m (8200 ft.)

Blender Assembly and Installation Instructions

Lifting Requirements



CAUTION: LOAD CELLS ARE EASILY DAMAGED. Always handle the blender with care. To avoid shock damage to load cells avoid hard impact with floor or equipment. Warranty coverage does not cover damaged load cells due to mishandling.

CAUTION: Weigh Scale Blenders can be top-heavy. Always lift using attach points mounted to the top of the frame of the blender. Do not lift from the hoppers or hopper extensions. Never use the air cylinders as lifting points or handles as damage to air cylinders may occur. Eyebolts can be temporarily installed on the top of the blender frame as a lifting point. Model 3000 blenders must be lifted from eyebolts installed on the top of the feeder frame. Install at least two eyebolts on opposite sides of the blender frame. When installing eyebolts, if an unused bolt hole is not available, a hopper bolt can be temporarily removed and replaced with a ½" eyebolt for lifting purposes. Optional Lifting Hangers are available from Maguire Products to allow lifting the blender with a strap or chain. Weight and dimensions of each model is listed on page: 145.

Mounting the Blender



The machine and all supporting equipment must be securely anchored in position prior to operational use.

1A. Machine Mounted:

For WSB MB, 100, 200, and 400 series models:

Two ways to do this are suggested ON THE NEXT PAGE:

The LEFT diagram shows the FRAME and SLIDE GATE both drilled with the proper bolt pattern for your machine and THROUGH BOLTED to your press.

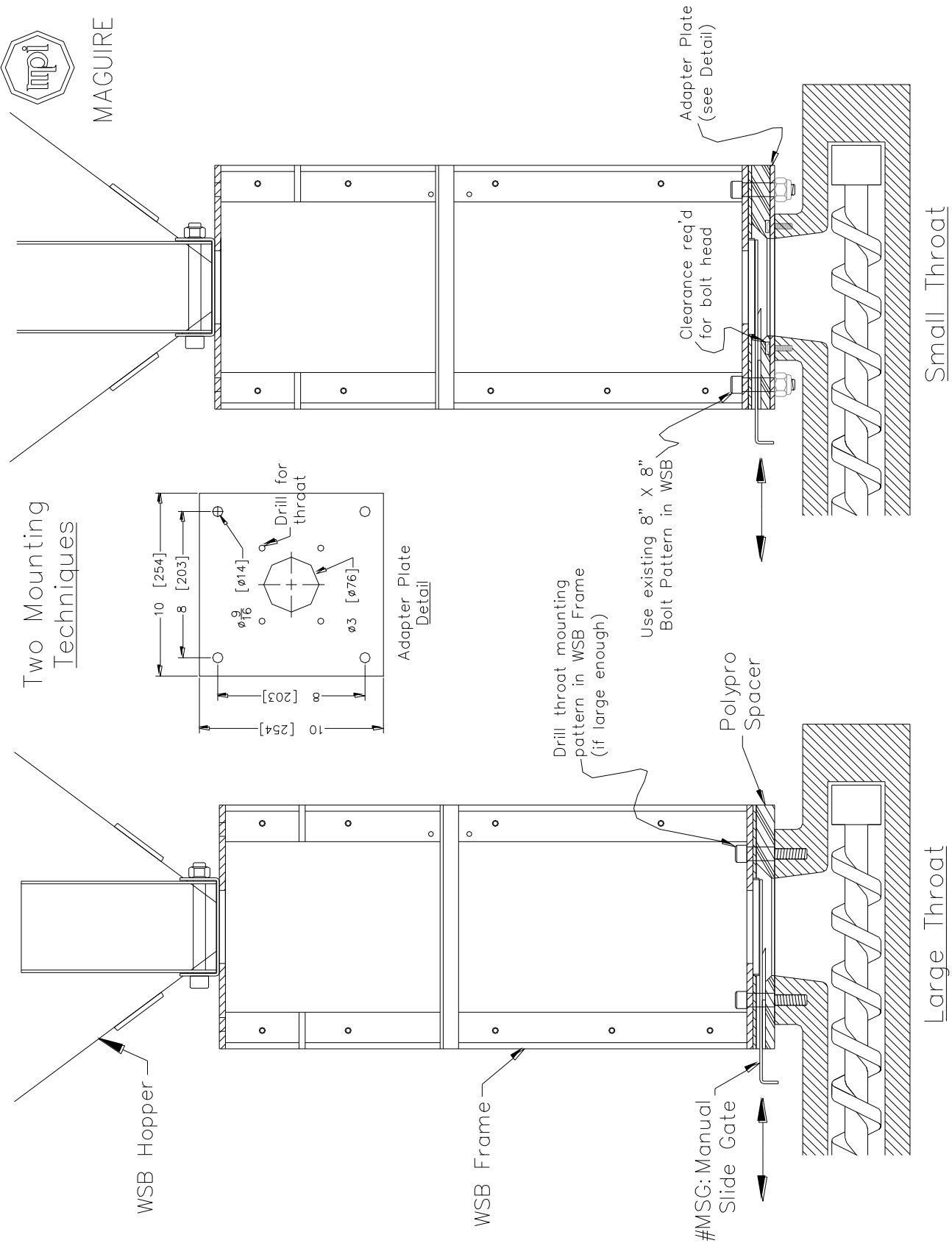
The RIGHT diagram shows only the 10 x 10 steel slide-gate plate drilled for your bolt pattern and bolted to your press. The FRAME is then bolted to it using the existing 8 x 8 inch bolt pattern holes and bolts provided. With this method, bolt head clearance holes are required in the poly-pro slide gate plate. This mounting works well on smaller machines.

For WSB 900 and 1800 series models:

An additional machine mount adaptor plate may be required. If you have ANY DOUBT about the STABILITY of the unit when bolted directly to your machine throat, please call us for advice.



NOTE: When choosing proper orientation, be sure to retain access to the controller and weigh chamber, clearance for hinged doors, and access to removable feeder hoppers.



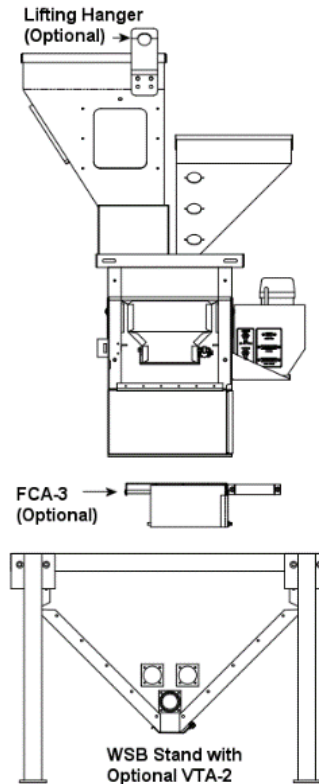
1B. Stand Mounted:

If you are mounting the blender on a stand, your unit will bolt directly to the stand.

An air operated FLOW CONTROL ASSEMBLY (FCA) is provided for dispensing into a container.

The purpose of the FCA is to allow time for mixing to occur after each dispense. This flow valve keeps the mix chamber full to just below the sensor.

The FCA assembly bolts directly to the bottom of the Weigh Scale Blender frame.



2. **Slide the WEIGH BIN into position.** It rests behind the clear-hinged access window. On models 100, 200, and 400 install weigh bin with the air cylinder to the left. On models 900, 1800, 2400 and 3000 install weigh bin with the air cylinder towards you. On Micro Blenders, install the weigh bin with the load cell hanger to the left. If bin is already in place, remove any shipping materials, packing tape or string.
3. **Hang the Color and Additive Feeders: (Optional)**
 - a. Lift side latches and fully extend slide assembly. Remove the hopper. Leave slide extended.
 - b. Tilting the entire slide assembly, motor end up, insert one corner of hanger cross bar behind frame corner post.
 - c. Rotate assembly into place so both ends of cross bar are behind corner posts.
 - d. Lower into place, bottom edge resting on frame and cross bar properly positioned behind corner posts.
 - e. Re-install hopper. Slide motor forward until latches engage.
4. **Place the controller on the support tray and plug in all cords:**
 - a. Air solenoid 17 pin plug into the matching receptacle.
 - b. Auger feeder drive motors into duplex receptacle.
 - c. Mixer motor into right side of controller.
 - d. Sensor cord plug into front side of controller.
 - e. Load Cell plug into port on left side of controller.

5. Plug the CONTROLLER into the receptacle located under the controller tray.



IMPORTANT: Do NOT plug the controller into a separate power source. The controller ground path **MUST** be the same as the blender frame ground path. If your system has the controller located in a remote location, **MAKE CERTAIN** that the power to the controller comes from the receptacle mounted on the Blender frame.

6. Power Requirements:

WSB Model	Voltage (60 hz)	FLA	Voltage (50 hz)	FLA
MB	110/1/60	2.0	230/1/50	1.0
100/200/400	110/1/60	5.0	230/1/50	2.5
900/1200	110/1/60 (Controller)	4.0	400/3/50+N+PE	2.5
	240/3/60 (Mix)	2.0		
	110/1/60 (Controller)	4.0		
	480/3/60 (Mix)	1.0		
1800	110/1/60 (Controller)	4.0	400/3/50+N+PE	2.5
	240/3/60 (Mix)	4.0		
	110/1/60 (Controller)	4.0		
	480/3/60 (Mix)	2.0		
2400/3000	110/1/60 (Controller)	4.0	400/3/50+N+PE	4.0
	240/3/60 (Mix)	3.2		
	110/1/60 (Controller)	4.0		
	480/3/60 (Mix)	1.6		

Secure voltage supply cable per the requirements of EN 60204-1, Clause 13.4.2.

7. Connect Compressed Air to the unit. About 5.5 bar (80 psi) is recommended for most models. 4.1 bar (60 psi) is recommended for: Micro Blender, 140R, 240R and 440R). Do not supply with lubricated air. Air provided to the blender should be clean and dry. The coalescing filter is a final attempt to dry the air to protect the valves from moisture contamination.

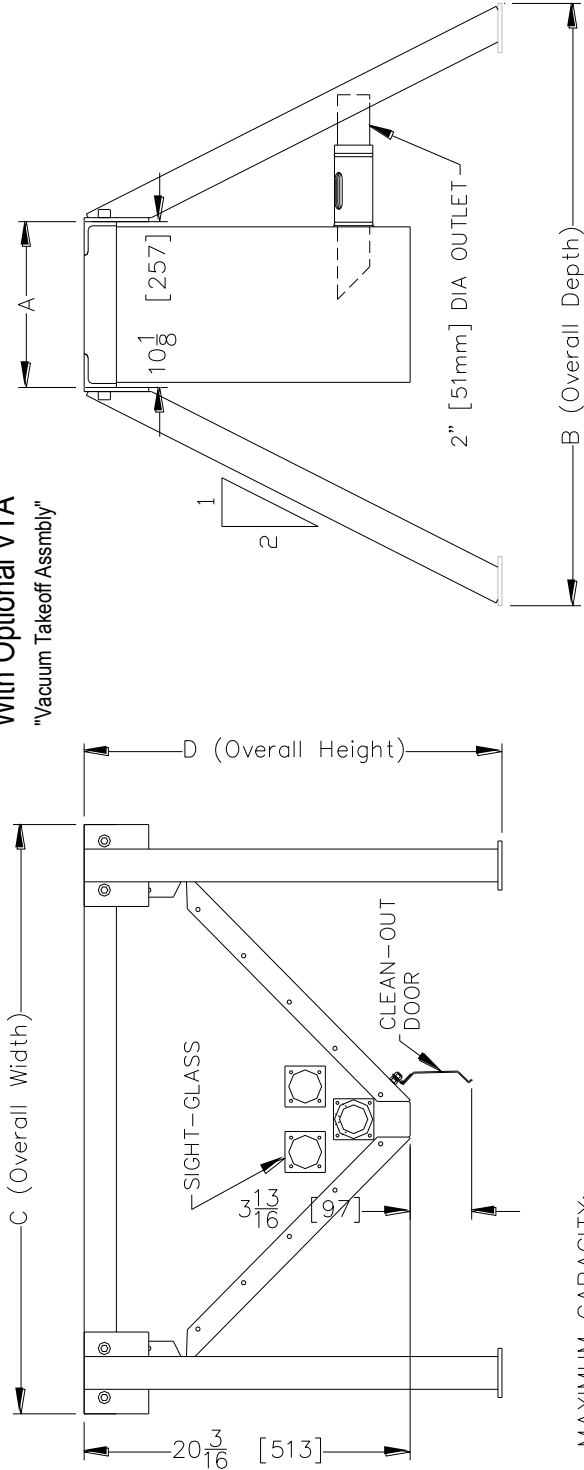


NOTE: Micro Blenders should be set to 4.1 bar (60 psi). The Vertical Valves used in removable hoppers on Micro Blenders are more accurate at the lower 4.1 bar (60 psi) pressure setting.

8. Upon completion of setup, an on-site safety inspection should be conducted to assess for any additional safety hazards, before allowing the equipment to be handing off to the machine operators.

MAGUIRE

WSB STANDS
With Optional VTA
"Vacuum Takeoff Assmbly"



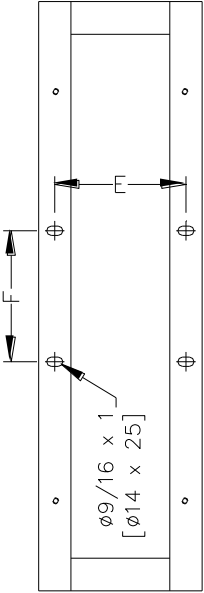
NOTE:
WSB 100/200/400 VTA Stand shown to scale.

MAXIMUM CAPACITY:
100/200/400: 2.2 cu. ft. [62 L]
900/1800: 3.6 cu. ft. [101 L]
PRACTICAL CAPACITY:
100/200/400: 1.4 cu. ft. [40 L]
900/1800: 2.3 cu. ft. [65 L]

DIMS IN [] ARE mm.

STAND DIMENSIONS

WSB 100/200/400	A	B	C	D	E	F
VTA	10-1/8 [257]	37-1/4 [946]	36 [914]	25-7/8 [657]	8-1/8 [206]	8 [203]
Barrel	10-1/8 [257]	51-1/4 [1302]	36 [914]	39-7/8 [1012]	8-1/8 [206]	8 [203]
Gaylord	10-1/8 [257]	63-1/4 [1607]	56 [1422]	51-7/8 [1318]	8-1/8 [206]	8 [203]
WSB 900/1800						
VTA	16-1/8 [410]	43-1/4 [1099]	36 [914]	25-7/8 [657]	14-1/8 [359]	15 [381]
Barrel	16-1/8 [410]	57-1/4 [1454]	36 [914]	39-7/8 [1012]	14-1/8 [359]	15 [381]
Gaylord	16-1/8 [410]	69-1/4 [1759]	56 [1422]	51-7/8 [1318]	14-1/8 [359]	15 [381]



Wiring Considerations

The wiring of your blender is very important to its proper operation. Electronics are very susceptible to voltage spikes and static charges, both of which are very common in plastics factories. To MINIMIZE these things, consider the following.

- The power supply should be solid; a strong supply, not limited by a "just adequate" control transformer. A source of voltage that comes from a large transformer that supplies a large portion of the plant is better than a small power supply transformer that is intended to supply only this device. Power supplies, even though they may be "isolation" transformers, will still pass all voltage spikes right through. Their small size limits their ability to dampen RF (Radio Frequency) noise that is often induced into the system from outside sources. This proves worse than connection to larger central transformers.
- Avoid running the power supply line along side any heavy power lines. An unshielded power supply in a raceway along side other heavy power lines will pick up induced RF noise and transfer it into the WSB steel enclosure causing computer trouble.
- Long extension cords should be avoided. They also reduce the ability to provide a dampening effect on spikes and static. The further the equipment is from a substantial power source, the more susceptible it is to spikes.
- The CONTROLLER and the WSB frame MUST share the same GROUND PATH. This is why you MUST plug the controller into the OUTLET that is provided ON THE FRAME.
- REMOTE SYSTEMS. If you have your controller mounted in a remote location, you will have a number of power and signal cords running between the frame and the controller. BE SURE that the LOW VOLTAGE lines are NOT BUNDLED to the HIGH VOLTAGE lines and keep them away from other nearby electrical lines.

LOW VOLTAGE lines are: Load Cell cable, Level Sensor cord, Air Solenoid cable, and communication cable.

HIGH VOLTAGE lines are: Mixer motor cable, Feeder motors, and MAIN POWER line.

Keep these sets of cables SEPARATED.

- VACUUM LOADER CONVEYING LINES. Keep them away from all electrical lines, particularly the Load Cell lines. Conveying plastic produces extreme static sources. A power supply line, even in conduit, that runs next to a vacuum line, can introduce extreme static pulses into the processor. Keep conveying lines SEPARATED from electrical supply lines.
- We use many internal tooth "STAR" washers in assembling the WSB to ensure good ground between painted parts. Do not remove them.

Model Selection

Controllers are programmed to control all sizes of Weigh Scale Blenders. The MODEL number that your unit is set for will be displayed across the status bar of the controller's Home Screen.

All Weigh Scale Blender controllers come from factory pre-configured for the model blender they are attached to. If a new blender controller is installed on a blender of a different model, the controller model should be changed to match the blender. There are 8 main model categories, each with at least one sub model. The model of the blender can be found on the red serial tag attached to the blender frame. The possible models are:

Blender Model	Batch Weight (Grams)	Weigh Bin Dimensions (DxWxH)		Load Cell Rating
		mm	Inches	
MB / MB1 / MB2	400	127x127x127	5" x 5" x 5"	1 @ 3Kg
140 / 140R / 140MP	1000	254x153x153	6" x 10" x 6"	1 @ 3Kg
220 / 240 / 240R / 260	2000	254x254x178	10" x 10" x 7"	2 @ 3 Kg
420 / 440 / 440R / 460	4000	254x254x254	10" x 10" x 10"	2 @ 10 Kg
940 / 950 / 960	9000	407x407x305	16" x 16" x 12"	2 @ 10 Kg
1840 / 1860	18000	407x407x432	16" x 16" x 17"	2 @ 20 Kg
2400	24000	560x508x458	22" x 20" x 18"	2 @ 20 Kg
3000	30000	407x407x432	20" x 22" x 30"	2 @ 20 Kg

"R" Models have 2 removable hoppers



WARNING: Changing Model will set all parameters and settings to factory defaults. Changing the model will reset the controller's blender configuration settings and parameters to the defaults for the selected model. System configuration and preferences will be retained through a model change.

Change the model of the blender controller:

Press



Display will say: **ENTER PASSWORD**

Press



Display will say:

SELECT WSB MODEL xxx
MODEL xxx

(displays current model).

Press



To scroll through all model sizes.
When the model you want is displayed, then:

Press



Controller will reset and restart as the system you have selected.

Check Out Procedure

As you go through this procedure, if what should happen, doesn't happen, see next section, Diagnostics, for what to check.



NOTE

MB/100/200 series models (3K load cells), display all weights in 1/10 grams (xxxx.x).

400/900/1800 series models (10K load cells) display weights in FULL grams, NO decimal point (xxxxx). On this page we show all weights with NO decimal point.

Start with NO MATERIAL in any hoppers.

Be sure an AIR SUPPLY is connected.

Place ALL switches DOWN; POWER (on front); STOP and PAUSE (on left).

PROCEDURE:

WHAT SHOULD HAPPEN:

1. POWER UP CONTROLLER

PLUG IN CONTROLLER

Nothing should happen.

Air pressure should be holding ALL valves CLOSED.

This means all air cylinders are extended. If any slide gate or flap is open, air lines are reversed.

If a FLOW CONTROL VALVE is installed, check it.

TURN POWER ON

Display should say: **MAGUIRE PRODUCTS INC SELF TEST**

Followed by: **FIRMWARE OK Checksum = xxxxxxxx**

Followed by: **4 COMPONENT**

Followed by the software version **V=xxxxxT**

Followed by model number **MODEL 220** or the model you have:

(WMB, 140, 140R, 220, 240, 240R, 420, 440, 440R, 940, 1840, WSB 3000).

Followed by the actual weight of material in the bin. This number should be zero, plus or minus several grams (20) to (-20). The display will also show the mode the controller is in and the current state of the controller. Note: WAITING indicates the sensor is covered or the stop/End of Cycle switch is down.

	0.0 g
MODE=BLEND	WAITING

AT THIS POINT

Be sure the model number that was displayed matches your blender model number. If this is not the case see two sections ahead, **SELECTING CORRECT MODEL**.

TOUCH WEIGH BIN VERY LIGHTLY

Display should update the weight every second reflecting the light pressure that you are exerting on the bin.

2. OPERATE DISPENSE DEVICES

PRESS

*

Display will say **ENTER PASSWORD**

PRESS

2 2 2 2 2

Enters the PROGRAM mode. 2's will not be displayed as you enter them. Display will show **PROGRAM** in the lower right.

PRESS		Display will say OPERATE DEVICES
PRESS		Regrind Slide Gate will operate. Display will say REGRIND: ON Press "REG" repeatedly to observe operation.
PRESS		Natural Slide Gate will operate. Display will say NATURAL: ON Press "NAT" repeatedly to observe operation.
REPEAT THIS SEQUENCE	 	Repeat process with COL & ADD for each dispense valve on your WEIGH SCALE BLENDER. Only those connected to devices will operate.

3. OPERATE OTHER DEVICES

PRESS		The weigh bin air solenoid will operate. Display will show DUMP: ON The weigh bin dump valve will open. Press, "DUMP" repeatedly to observe operation.
PRESS		This key controls the mix motor outlet on the side of the controller. The mixer motor will run. Display will show MIXER: ON Mix blade turns clockwise facing the motor shaft or 270° on Pneumatic Mix Motors. Mixer switch must be down; timed position.
PRESS		The Flow Control Valve will operate. Display will show HOLD: ON (Under the mix chamber - this device is optional)
PRESS		The Strobe light and Beeper will operate. Display will show ALARM: ON
PRESS		Press twice, to return to normal mode. Verify normal mode by observing that the display shows WAITING in lower right.

Check Out Procedure Diagnostics

If display fails to come on at all:

Check for power at outlet.
Check the 1/2 amp panel front fuse.

If third display says TWELVE COMPONENT, then:

this is NOT the correct manual for this software. Obtain and use a 12 software manual.

Possible model numbers are:

WMB, 140, 140R, 220, 240, 240R, 420, 440, 440R, 940, 1840, WSB 3000
If model number is not correct for you unit:
see the next page, SELECTING CORRECT MODEL.

If display shows randomly drifting numbers:

check to see load cells are plugged in.

If display shows about (- 1250.0) or (-4500):

check that the weigh bin is in place properly.

If display is steady but not near zero:

An over stressed load cell will display a permanently high or low reading. Recalibrate load cells; next section.

If there is no response from the display when the bin is touched:

check for damaged wires to load cells.
check that load cell plug screws are secure.

If response is not sensitive or does not return to its start point:

check for interference around weigh bin.

If pressing * does not display ENTER PASSWORD:

you are not in the normal power-up mode or the keypad doesn't work. Normal mode is indicated by the ABSENCE of MANUAL or PROGRAM at the lower right of the display.

If display says INVALID after entering the password number:

you pressed the wrong keys or the password number has been changed and it is no longer 22222. Call us for help.

If an air solenoid does not operate:

check the 1/2 amp fuse.
check solenoid cable connected properly and fully seated.
check mix chamber door closed, safety interlock engaged.

If a slide or dump valve does not open:

check the air supply and regulator adjustment:
(minimum 20 psi, 80 psi (5.5 bar) recommended).
check for proper air line connection to cylinder.

If an auger feeder motor does not run:

check the 3 amp fuse.
check that the motor is plugged into the proper outlet.
check for faulty motor by plugging it into a known source of 110 volt A.C. power (240 volt outside U.S.).

Load Cell Zero and Full Weight Calibration

The WSB has a set of load cells for weighing the weigh bin. The load cells must be calibrated periodically with zero and full weight calibrations for proper operation and accurate weight reporting. The zero calibration routine should be performed routinely to tare the load cells back to zero or near zero when necessary. The Full weight calibration should be performed periodically to set the calibration slope. Full Weight Recalibration of the load cells is recommended every 6 months especially if totals are collected from the blender. The following instructions outline how to calibrate the weigh bin load cells, identified as the load cell assembly that weighs the removable weigh bin.

Before performing a Zero Weight Calibration or a Zero/Full Weight Calibration, verify the following:

**If you are calibrating a WSD, *47 must first be disabled to perform a calibration.
After the calibration is complete, *47 can be re-enabled.**

BE SURE the weigh bin is EMPTY.
BE SURE the load cell cable is plugged into the side of the controller.
BE SURE the weigh bin is resting on the load cells freely and does not make contact with anything around it.
BE SURE the air line to the weigh bin's dump valve is connected as it would be during normal operation.
BE SURE The load cells and bin are not jammed in any way. To test for this, see that a light touch on the bin causes the display to change. When the pressure is removed the display must return to exactly where it was, plus or minus 1 gram. If this does not happen, bin is not entirely free to move. Check EVERYTHING around the bin.

Weigh Bin Load Cell Zero, Zero and Full Weight Calibration

Press		Display will say: ENTER PASSWORD
Press		Display will say: PROGRAM
Press		Display will say: CALIBRATION MODE DISABLED
Press		Display will say: CALIBRATION MODE WSB LOAD-CELLS
Press		Display will say: MODE=BLEND PROGRAM

Verify that the Weigh Bin is empty.

Press		Display will say: WSB CELL ZERO -- WAIT -- Followed by: PROGRAM
-------	--	--

If a FULL WEIGHT calibration is to be performed next, continue to FULL WEIGH CALIBRATION on the next page. Otherwise, if only the ZERO calibration is to be performed at this time, exit calibration mode.

Press		Display will say: CALIBRATION MODE DISABLED
Press		Display will say: CALIBRATION MODE DISABLED
Press		Display will say: MODE=BLEND WAITING

FULL WEIGHT CALIBRATION

The full weight calibration must be performed immediately after a zero calibration. While still in program mode, place the calibration weight into the weigh bin. Use the chart below for the calibration weight required for your model WSB blender.

Model	Calibration Weight	Enter this value (use your exact value)	
Micro Blender (MB,MB1,MB2)	400.0 grams	04000	Tenths of grams
100 Series (140,140R,140MP,160)	1000.0 grams	10000	Tenths of grams
200 Series (220,240,240R,260)	2000.0 grams	20000	Tenths of grams
400 Series (420,440,440R,460)	4000 grams	04000	Whole grams
900 Series (940,950,960)	9000 grams	09000	Whole grams
1800 Series (1840,1850,1860)	18000 grams	18000	Whole grams
2400 Series (2400)	24000 grams	24000	Whole grams
3000 Series (2400)	30000 grams	30000	Whole grams

Press



Display will say: **WSB CELL FULL**

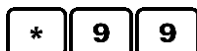
ENTER WEIGHT: _ _ _ _ _ (5 digits)

Enter the gram value of your calibration weight at this time.

The display will then say: **PROGRAM (calibrated weight value)**

Full Weight Calibration is complete. Press * 99 and then * twice to DISABLE Calibration Mode.

Press



Display will say: **CALIBRATION MODE DISABLED**

Press



Display will say: **CALIBRATION MODE DISABLED**

Press



Display will say: **MODE=BLEND WAITING**

Display will show the new calibrated weight value. Remove the weight from Weigh Bin. The display should go back to displaying 0.0 g. Actual displayed weights may be +/- a few grams.

After a FULL weight calibration, if the display says BAD CELL, the controller is receiving a raw weight reading from the load cells outside of the expected range. Verify the weigh bin is free to move and that the gram weigh entered is correct. Verify the correct model is selected. BAD CELL may also indicate the load cells are bad.

Material Flow Rate Calibration

Software is set to expect STANDARD hardware. If a device meters at a much lower feed rate than expected, the software will take 10 to 20 cycles to fully adjust. During this time cycles will take longer.

An example of this is a system using a 1/2" auger instead of 1".

If you don't mind letting the system SELF ADJUST, or your hardware is STANDARD, then:

To perform a **RATE CALIBRATION**:

Have the HOPPER LOADED with enough material to run for several cycles without running out.

Have the "STOP END OF CYCLE" and "PAUSE" switches DOWN.

Material Calibration Keypad Sequence:

Press  Display will say: **ENTER PASSWORD**

Press      Display will say: **PROGRAM**

If you are calibrating an auger feeder, operate it briefly to ensure it is fully primed. To do so:

Press  Display will say: **OPERATE DEVICES**

Press  or  Run until Dispense Device is dispensing

Press  This will empty the Weigh Bin

Now you can CALIBRATE the material. To do so:

Press  Display will say: **RATE CALIBRATION**
Component: _

Press  Color will calibrate itself.

For each material, press CAL followed by the proper component key. Each time a dispense will occur, followed by weighing, followed by a dump to empty the weigh bin.

Press  Display will say: **WAITING**

YOU ARE NOW READY FOR ACCURATE PRODUCTION BLENDING.

Micro Pulse Instructions

MICRO PULSE

Micro Pulse valves are available on models:

WSB MB	with optional VERTICAL VALVE MICRO PULSE valves.
WSB 122 / WSB 140m2	with optional SLIDE GATE MICRO PULSE valves.
WSB 131 / WSB 140m1	with optional SLIDE GATE MICRO PULSE valves.
WSB 140Rm1 / WSB 140Rm2	with optional VERTICAL VALVE MICRO PULSE valves.
WSB 240Rm1 / WSB 240Rm2	with optional VERTICAL VALVE MICRO PULSE valves.
WSB 440Rm1 / WSB 440Rm2	with optional VERTICAL VALVE MICRO PULSE valves.

These models may use our "MICRO PULSE" metering system for Color and Additive components.

PULSED OUTPUT parameters control the on/off timing, or pulsing, of the valves. The controlling parameters are the "_PO" component parameters.

When set to 00000, normal slide gate operation occurs. When set to a value, such as 00101, power will pulse ON then OFF, at 1/10 second time intervals each way. This ON/OFF cycling will repeat for the entire dispense time.

When using a MICRO PULSE valve, you must set the related _PO parameter to 00101.

If overall blender throughput is too low, you may increase the metering rate of each Micro Pulse device by adjusting the cylinder airflow control valves for higher flow rate. This causes more rapid movement of the cylinder, ejecting more pellets per pulse. The drawback is noisy operation.

We recommend air flow be adjusted for quiet operation, but assuring full valve movement per on/off cycle. We have already done this. No further adjustment should be necessary.

The approximate correct airflow adjustments are:

- At nose of cylinder, 1.5 full turns out from full closed.
- At rear of cylinder, 2.5 full turns out from full closed.
- MICRO BLENDER slant valves, adjust by sound.

On fixed hoppers with horizontal micro pulse valves, CLEAN OUT of the hopper can be accomplished by opening the "clean out" port provided under the valve. Turn to one side to allow material to drain.

MICRO PULSE - ACCURACY

All MICRO PULSE valves are more accurate if the associated PT parameter is set to 00090. Read PT parameter in the PARAMETER section. Use *83 function, Progressive Metering, for improved accuracy so long as the additional time necessary for Progressive Metering exists. Read about more about *83 in the Star Functions section.

Normal Operation and Saving the Configuration

1. Fill HOPPERS: REGRIND, NATURAL, COLOR, ADDITIVE in hoppers as labeled. If auger feeders are used COLOR is the RIGHT side feeder and ADDITIVE is the LEFT side feeder.
2. Set THUMBWHEEL switches for percentage of materials desired:
 - REGRIND** enter as a percentage of the entire mix – no decimal place (xx%)
 - COLOR** as a percentage of the Natural (xx.x%)
 - ADDITIVE** as a percentage of the NATURAL (xx.x%)
3. On Controller, turn POWER ON, set STOP, and PAUSE switches UP. Switch MIXER motor DOWN to run for a timed period each cycle.

Unit will now operate automatically to maintain a level of material high enough to cover the sensor.

Use the STOP or PAUSE switches to stop the dispensing of material. Turn POWER off only on final shutdown. Battery-backed RAM ensures all information is retained even with power turned off.

The KEYPAD is only for:

1. MANUAL TESTING.
2. ALTERATION of INTERNAL PARAMETERS

After several days of proper operation:

Save all parameter information to the User Backup Settings for future retrieval just in case software problems develop later.

To SAVE all parameter information to the User Backup Settings:

Save Parameters Keypad Sequence:

Press		Display will say: ENTER PASSWORD
Press	    	Display will say: PROGRAM
Press		Display will say: INSTRUCTION [_]
Press	 	Display will say: SAVE USER SETTINGS
Wait:	when done, Display will say: PROGRAM	
Press		Display will say: WAITING

If software related problems develop later, RETRIEVE this correct copy of the parameters from the User Backup Settings. This clears corrupted data from RAM and corrects most software problems.

To Retrieve:

Retrieve Parameters (CLEAR) from User Backup Settings - Keypad Sequence:

Switch		Power Off to the Controller
Hold		Hold the "CE" Key down
Switch		Power on to the Controller
Release		The "CE" Key
Display will say *** CLEAR ***		
If you do not see CLEAR on the display, do it again.		

Normal Operating Sequence - Each Cycle

As the sensor is uncovered, the cycle begins. The target weight of a complete batch is 18000, 9000, 4000, 2000, 1000, or 400 grams.

REGRIND, if requested, will dispense first. After the Regrind dispense the space remaining in the weigh bin is calculated.

NATURAL will dispense second. This dispense is calculated to fill the bin leaving just enough space for the Color and Additive dispenses. After the Natural dispense is complete the exact weight of this dispense is calculated and, based on this actual dispense weight, the Color and Additive dispenses are now calculated.

COLOR and ADDITIVE are now dispensed one at a time as requested. These dispenses are a percentage of the Natural component only.

If the Natural, Color, or Additive components fail to reach the requested weight, the process does NOT CONTINUE. The ALARM Strobe light flashes and the system holds until the problem is remedied.

As each component is being dispensed and weighed, the corresponding component is displayed:

DISPENSING: REG (1), NAT (2), COL (3), or ADD (4). The total updated bin weight is displayed about 3 seconds AFTER each dispense.

Each dispense weight is checked and recorded. Rate recalibration takes place every cycle to ensure continuous process accuracy. The total batch is dropped into the mixing chamber and blended before entering the throat of the process machine.

Special Features – TAG, Recipe Database, FAST, Batch

To use one of these SPECIAL FEATURES, read about it first. The KEYSTROKE sequence required is given at the end of this section.

Function: Key: Description:

TAG		To TAG all material usage data with Work Order or Employee numbers for better tracking of material used, read: KEYPAD, TAG key, and set 2nd digit in the FLG parameter to 1.
RECIPES		To store RECIPES using the RECIPE storage feature, read: KEYPAD, RECIPE key, and set 3rd digit in the FLG parameter to 1.
FAST		To increase throughput, using the FAST key, read: KEYPAD, FAST key, and set 4th digit in the FLG parameter to 1.
BATCH		To blend a preset BATCH amount of material and then stop, read: KEYPAD, BATCH key, and set 5th digit in the FLG parameter to 1.

BATCH, RECIPE, FAST, and TAG keys REQUIRE that you read: PARAMETERS, FLG parameter.

SETTINGS	To use a lower percentage than 00.1 percent, read: PARAMETERS, _XT parameter.
MIXING	To change the MIXER RUN TIME , read: PARAMETERS, MIX Parameter.
SETTINGS	To place UPPER LIMITS on settings, read: PARAMETERS, _SE Parameter.
PASSWORDS	To LOCK OUT others from changing the settings, read: PARAMETERS, (*78) - Changing the Password.
ACCURACY	To VERIFY ACCURACY of the entire system, read: PRINTER OUTPUT and TROUBLESHOOTING sections.
DATA	To TRACK MATERIAL USAGE , read: KEYPAD, VIEW DATA, and PARAMETERS, PRT Parameter.

READ the rest of the manual at your leisure to learn more about how your WEIGH SCALE BLENDER works and what else the blender can do.

KEYSTROKE SEQUENCE for these or other SPECIAL FEATURES

Making Changes to Parameters - Keypad Sequence:

Switch the **STOP END OF CYCLE** switch **DOWN**:

Turn **POWER ON**. Wait 5 seconds, until display says **WAITING**

Press



Display will say: **ENTER PASSWORD**

Press



Display will say: **PROGRAM**
This is the Program Mode

To alter a PARAMETER:

Press



Press repeatedly until the parameter you want is displayed.
If you accidentally pass it, use the * key to back up. With the proper parameter displayed, enter the NEW number. Enter 5 digits; use leading zeros if necessary. For correct entries, follow specific directions given in the PARAMETER section.

Press



Display will say: **PROGRAM**

Press



Display will say: **SAVE USER SETTINGS**
This saves the changes made

Press



Display will say: **WAITING** when settings are complete.

Making Changes to * Functions - Keypad Sequence:

Press



Display will say: **ENTER PASSWORD**

Press



Display will say: **PROGRAM**
This is the **PROGRAM MODE**

Press



Display will say: **INSTRUCTION [_ _]**

Press

XX (2-digit code)

Enter the 2-digit code. For correct entries, follow specific directions given in the KEYPAD section, STAR FUNCTIONS.

Press



Display will say: **PROGRAM**

Press



Display will say: **SAVE USER SETTINGS**
This saves the changes made

Press



Display will say: **WAITING** when settings are complete.



NOTE

Toggle forward through the component parameters by continuing to press the SET key.
Press the VIEW key to move backwards through the component parameters.

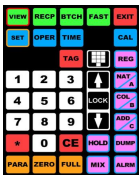
WSB Controller – Description of Controls and Outputs

There are two version of this controller, the 12-12 (identified by the black enclosure) and the 4088 Standard (Silver enclosure).

4088 Standard Controller (Silver enclosure)

Front Panel

- KEYPAD
- DISPLAY
- DIGITAL THUMBWHEELS
- AIR SOLENOID OUTPUTS
- POWER SWITCH
- STROBE LIGHT
- BEEPER ALARMS



KEYPAD

See next section for Keypad functions.



DISPLAY 40 Character Vacuum Fluorescent Display (VFD)

Displays the accumulated total bin weight, in grams, after each dispense. Other information displayed here includes material usage totals, internal parameters, component types and settings and various information prompts to assist the operator.

#####

Numbers displayed are the total weight of material, in grams, in the bin at any time. The weight in the bin is updated only after an individual dispense is complete. During the dispense the displayed weight does not change.

PROGRAM

In the lower Right position of the display indicates unit is in PROGRAM mode.

MANUAL

Indicates unit is in MANUAL mode.

Comp R (REG) [TW-1]

Comp R (REG) 20.0

REG - Regrind

NAT – Natural

COL – Color

ADD - Additive

*** INVALID ***

Indicates: Component 1, REGRIND, and Thumbwheel setting applies (or) SETTING of 20 percent. Also (NAT) indicates NATURAL, (ADD) indicates ADDITIVE, (COL) indicates COLOR

Indicates a material component being dispensed.

Indicates:

1. You pressed an incorrect key - or
2. You pressed a key for a function that is not active – or
3. 3. You are not in the right mode for this key to operate.

ENTER PASSWORD

Password is displayed when you press the * key from the normal mode. Enter:

11111 - for MANUAL mode

22222 - for PROGRAM mode - or

Enter your password number (if password was changed).

INSTRUCTION [_ _]

This is displayed when you press the * key from the PROGRAM mode. Enter a 2-digit instruction number for special tasks.

DISPENSING:

This is displayed while material is being dispensed. The display will also show the accumulated total in grams per batch (upper right), the material Type (REG=REGRIND, NAT=NATURAL, ADD=ADDITIVE, COL=COLOR), and the component (hopper) number (far lower right). See example below:

	1880.2 g
DISPENSING:	ADD (4)

COMPONENT SETTINGS, OPERATE DEVICES, TIMED DISPENSE, and RATE

CALIBRATION are displayed when the respective keys are pressed from the manual or program modes. These displays are followed by pressing a device key; 1 through 9, A, B, C, DUMP, ALARM, MIX, or HOLD. The word FLASHING on the display means that retries are occurring because the first dispense was not enough. Other error conditions also cause flashing. **FIRMWARE and Checksum** messages indicate the condition of controllers program and memory. See KEYPAD, *25, for explanation.

**DIGITAL THUMBWHEEL SWITCHES****COLOR thumbwheel switch (00.0 to 99.9)**

This setting represents the PERCENT of the NATURAL PORTION that is to be COLOR. For example, if your COLOR to NATURAL mix ratio is 1:25 then "04.0" is the proper setting. (1 pound of color to 25 pounds of natural is $1/25 = 4\%$)

ADDITIVE thumbwheel switch (00.0 to 99.9)

This setting represents the PERCENT of the NATURAL PORTION that is to be ADDITIVE. For example, if your ADDITIVE to NATURAL mix ratio is 1:100 then "01.0" is the proper setting ($1/100 = 1\%$).

REGRIND thumbwheel switch (00.0 to 99.9)

This setting represents the PERCENT of the ENTIRE MIX that is to be REGRIND. A lower limit of 5% (05) has been entered into the software. This limit may be altered using the keypad (see parameters, RLO). A setting of "99.9" causes the system to run 100 percent regrind. With this setting, no attempt is made to meter natural, color, or additive unless the regrind dispense fills less than 1/2 of the weigh bin.

Digital thumbwheels update when the settings are sent by MLAN or Modbus TCP.

LOCKOUT - To lock out access to the digital thumbwheels, see the _SE parameter.

Digital Thumbwheel Brightness Adjustment – To change the brightness of the digital thumbwheels, on power up, press and hold the Additive's down button. The displays will read the current firmware of the thumbwheels and then display **brt** (bright) and a value from 1-226 (default is 100). Press the Additive UP or DOWN to adjust the brightness. Press the UP button of the Regrind to exit and save.

**ALL AIR SOLENOID outputs**

There is a single 17 pin Amphenol plug located on the front of the control panel. This provides output of all 24 volt signals to drive the air solenoids. These power sources are transistor driven and are protected by the 1/2 amp panel fuse. See the wiring diagram section for the correct wiring to each pin.

**POWER ON switch**

Controls all power to the controller and all outputs. When power is switched off, battery backed-up RAM preserves all internal totals and parameters. All other functions are reset for normal start-up when power is restored.

Controller – Left Side

- **STOP END OF CYCLE / CONTINUE switch**
- **IMMEDIATE PAUSE / CONTINUE switch**
- **RS-232, RS-485 Port**
- **ETHERNET RJ-45 Port**
- **USB Port**
- **LOAD CELLS Port**
- **Alarm Beeper, Silence Alarm Button**



STOP END OF CYCLE / CONTINUE switch

This is the switch that you should use to STOP the system. This switch is wired in series with the level sensor. Turning it off breaks the signal to the computer the same as covering the level sensor with material. This stops the process at the end of a full cycle.



IMMEDIATE PAUSE / CONTINUE switch

Causes a computer-controlled immediate pause during a cycle. Dispenses will stop in mid-dispense if necessary. When switched back to CONTINUE, the process continues without any error in amounts dispensed.

A cycle can be aborted during an Immediate Pause by pressing the DUMP button.



RS-232, RS-485 Communication Port

Serial has been the standard method of communications until the introduction of the 12–12 Controller, when onboard Ethernet became available. For customers who have been using Serial for their communications, this option is still implemented as before making the controller backward compatible with earlier Maguire Weigh Scale Blender communication serial networks. The SERIAL port is a DB9 (9 pin) male port that communicates the MLAN protocol over RS-232 and RS-485. The serial port is also used to convert MLAN protocol over serial to other industrial protocols using a third party gateway.



ETHERNET PORT (RJ-45)

The Ethernet port allows for communication to the controller over Ethernet. Communication through this port is TCP/IP utilizing the MLAN Protocol or Modbus. The G2 Software, using the MLAN Protocol, can communicate with the controller over Ethernet using this Ethernet port.

For information on configuring the Ethernet interface, see Communications.



SILENCE ALARM

This button stops the STROBE and BEEPER ALARMS, but does not remedy the cause of the alarm. The continuation of the cycle to its proper completion will also stop the alarm. When in the BATCH mode, this button also serves to start the next batch.



USB PRINTER PORT

This is a USB port. A USB printer or USB Drive plugged in here allows several types of information to be ported directly to a USB printer or USB Drive giving the benefit of a permanent printed or digital record. They are:

1. The totals of the material usage data.
Press VIEW and * keys or use the PRT parameter to AUTOMATICALLY and periodically print these totals.
2. A listing of the internal parameter table.
Press *77 in the PROGRAM mode.
3. A printout of information after each cycle including actual dispensed weights and percentages for every cycle.
Press *54 in the PROGRAM mode, use * to set printer flag ON.
4. A printout of information after the TIME or CALIBRATE routines.
*54 flag must be on to allow this.
5. Print Display – This is useful for obtaining printed verification of load cell accuracy ISO and other international quality program rules.
Press *88 before and after placing a KNOWN CERTIFIED WEIGHT into the weight bin to print the Date, Time, Machine number and displayed weight.
6. USB Recipe Command – Using *34, this command allows a recipe to be stored on a USB drive and / or used as the primary recipe run by the controller. For more information, see *34 on page 52.

The USB port can also be used to update the controller's software. For information about updating the controller software see Updating Controller Software and the Star function *93.



NOTE

Notes about printing to a USB drive

When saving printout information to a USB drive, the USB drive must contain a folder named **maguire** and within the folder, a file labeled **PRINTER.TXT** must be present. It is this file, **PRINTER.TXT** that printout functions appended to. Also note that every time a print occurs to the file on the USB drive, the data is appended to the end of the file PRINTER.TXT and does not overwrite existing data within the file.



LOAD CELL input port

On systems with two load cells the leads are joined by a common connector that is plugged into this port.

Controller - Right Side

- **SILENCE ALARM**
- **MIXER MOTOR ON/OFF/TIMED SWITCH**
- **MIXER MOTOR FUSE**
- **MIXER MOTOR OUTLET**
- **LEVEL SENSOR INPUT**



FEEDER POWER OUTPUTS (receptacles on panel front)

Each outlet puts out 120 volts (240 outside USA) through internal plug-in solid-state relays rated and fused at 3 amps. These relay outputs are designed to drive motors or other devices requiring power up to 3 amps each. The LEFT outlet is for component number 5, and the RIGHT outlet is for component number 6. Do Not use these outlets to power other devices.



Fuse for Feeders - 3 amp

Fuses power to the circuit board power supply, which includes all solenoid outputs and solid-state relay outputs.



MIXER MOTOR OUTLET

This outlet is energized continuously when the MIXER SWITCH is ON (up). In the TIMED position, it stays energized for a time period following the dump of the weigh bin. You may adjust this time in the parameter table (MIX 03015). This time should be just long enough to provide adequate mixing. Mixing for a longer period may contribute to a static problem. Also, excessive mixing sometimes causes separation of pellets of different size and weight.



MIXER MOTOR FUSE - 3 amp

Located above the Mixer Motor outlet, this fuse is rated at 3 amps and protects the mixer motor circuit separately from all other fuses. On 100, 200, and 400 series models, this fuse protects the mix motor directly. On 900 and 1800 series models, this circuit operates a 25 amp solid-state relay in a separate box. The mix motor is protected by a "motor starter" switch with a "heater". This switch must be on for the motor to operate.



LEVEL SENSOR input

The high level sensor in the mixing chamber plugs into this outlet and signals the controller to start a dispense cycle when it is uncovered. The sensor must be uncovered for at least 2 seconds before a cycle will start (see DLY 00488 Parameter). Once a dispense cycle is started, covering the sensor does not stop it. Operation continues until the cycle is complete.

INTERNAL FUSES

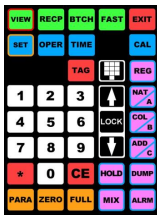
An in-line fuse is provided internally to protect the main 120-volt power cord supply (10) amps. If this fuses blow, an internal short circuit is indicated and we don't recommend that you try to fix it. Remember, this unit carries a five-year warranty; just send it back.

The MIX MOTOR timed power source and the AUGER FEEDER OUTLETS are driven by internal solid-state plug-in relays. These relays are located on the circuit board mounted on the inside back surface of the controller enclosure. A small 5-amp glass fuse is located to the right of each relay. A spare fuse is also located on the board if replacement is necessary.

12-12 Controller (black enclosure)

Front Panel

- KEYPAD
- DISPLAY
- THUMBWHEELS
- AIR SOLENOID OUTPUTS
- FEEDER POWER OUTPUTS
- PANEL FUSES
- POWER SWITCH
- STROBE LIGHT
- BEEPER ALARMS



KEYPAD

See next section for Keypad functions.



DISPLAY 40 Character Vacuum Fluorescent Display (VFD)

Displays the accumulated total bin weight, in grams, after each dispense. Other information displayed here includes material usage totals, internal parameters, component types and settings and various information prompts to assist the operator.

#####

Numbers displayed are the total weight of material, in grams, in the bin at any time. The weight in the bin is updated only after an individual dispense is complete. During the dispense the displayed weight does not change.

PROGRAM

In the lower Right position of the display indicates unit is in PROGRAM mode.

MANUAL

Indicates unit is in MANUAL mode.

Comp 1 (REG) 20.0

Indicates: Component 1, REGRIND, and SETTING of 20 percent. Also (NAT) indicates NATURAL, (ADD) indicates ADDITIVE, (COL) indicates COLOR

*** INVALID ***

Indicates:

4. You pressed an incorrect key - or
5. You pressed a key for a function that is not active – or
6. 3. You are not in the right mode for this key to operate.

ENTER PASSWORD

Password is displayed when you press the "*" key from the normal mode. Enter:
11111 - for MANUAL mode
22222 - for PROGRAM mode - or
Enter your own password number if you have established one.

INSTRUCTION [_ _]

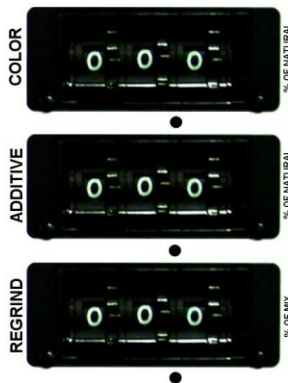
This is displayed when you press the * key from the PROGRAM mode. Enter a 2-digit instruction number for special tasks.

DISPENSING:

This is displayed while material is being dispensed. The display will also show the accumulated total in grams per batch (upper right), the material Type (REG=REGRIND, B, C, DUMP, ALARM, MIX, or HOLD. The word FLASHING on the display means that retries are occurring because the first dispense was not enough. Other error conditions also cause flashing. **FIRMWARE and Checksum** messages indicate the condition of controllers program and memory. See KEYPAD, *25, for explanation.

	1880.2 g
DISPENSING:	ADD (4)

COMPONENT SETTINGS, OPERATE DEVICES, TIMED DISPENSE, and RATE CALIBRATION are displayed when the respective keys are pressed from the manual or program modes. These displays are followed by pressing a device key; 1 through 9, A, B, C, DUMP, ALARM, MIX, or HOLD. The word FLASHING on the display means that retries are occurring because the first dispense was not enough. Other error conditions also cause flashing. **FIRMWARE and Checksum** messages indicate the condition of controllers program and memory. See KEYPAD, *25, for explanation.

**THUMBWHEEL SWITCHES (mechanical, pre 1st quarter 2012)****COLOR thumbwheel switch (00.0 to 99.9)**

This setting represents the PERCENT of the NATURAL PORTION that is to be COLOR. For example, if your COLOR to NATURAL mix ratio is 1:25 then "04.0" is the proper setting. (1 pound of color to 25 pounds of natural is 1/25 = 4%)

ADDITIVE thumbwheel switch (00.0 to 99.9)

This setting represents the PERCENT of the NATURAL PORTION that is to be ADDITIVE. For example, if your ADDITIVE to NATURAL mix ratio is 1:100 then "01.0" is the proper setting (1/100 = 1%).

REGRIND thumbwheel switch (00.0 to 99.9)

This setting represents the PERCENT of the ENTIRE MIX that is to be REGRIND. A lower limit of 5% (05) has been entered into the software. This limit may be altered using the keypad (see parameters, RLO). A setting of "99.9" causes the system to run 100 percent regrind. With this setting, no attempt is made to meter natural, color, or additive unless the regrind dispense fills less than 1/2 of the weigh bin.

**NOTE**

Mechanical thumbwheel switches - When settings are sent to the controller using the Set Settings MLAN command (such as when using the G2 Software), the thumbwheels are disabled and the settings are set using the internally stored settings.

**DIGITAL THUMBWHEEL SWITCHES (Standard first quarter of 2012)**

Digital thumbwheels operate the same as the mechanical thumbwheels however the digital thumbwheel displays will reflect the current setting of each component (color additive, regrind) even if the setting is updated via MLAN communications. Changing the digital thumbwheel display will update the internally stored setting of that component. To lock out the digital thumbwheels, see the _SE parameter.

Digital Thumbwheel Brightness Adjustment – To change the brightness of the digital thumbwheels, on power up, press and hold the Additive's down button. The displays will read the current firmware of the thumbwheels and then display **brt** (bright) and a value from 1-226 (default is 100). Press the Additive UP or DOWN to adjust the brightness. Press the UP button of the Regrind to exit and save.



ALL AIR SOLENOID outputs

There is a single 17 pin Amphenol plug located on the front of the control panel. This provides output of all 24 volt signals to drive the air solenoids. These power sources are transistor driven and are protected by the 1/2 amp panel fuse. See the wiring diagram section for the correct wiring to each pin.



COLOR and ADDITIVE power outlets (certain models only)

Each outlet puts out 120 volts (220 volts outside U.S.A.) through internal plug-in solid state relays rated at 5 amps and fused at 3 amps. These relay outputs are designed to drive motors or other devices requiring power up to 3 amps each.

The COLOR outlet is driven based on the COLOR setting. The ADDITIVE outlet follows the ADDITIVE setting. COLOR dispense occurs first but has no effect on the ADDITIVE dispense. The amount of each dispense is calculated based on the NATURAL dispense that precedes them.



Do Not use these outlets to power other devices such as Ethernet to Serial converters.



PANEL FUSE for processor - 1/2 amp

Fuses power to the circuit board power supply, which includes all solenoid outputs and solid-state relay outputs.



PANEL FUSE for duplex receptacle - 3 amp

Fuses the common power wire of the duplex receptacle (the color and additive outputs). Since these outlets are only turned on one at a time, each is protected to the full 3 amp rating of the fuse.



POWER ON switch

Controls all power to the controller and all outputs. When power is switched off, battery backed-up RAM preserves all internal totals and parameters. All other functions are reset for normal start-up when power is restored.



**Strobe Light
Beeper Alarm**

STROBE LIGHT and BEEPER ALARMS

The Strobe light flashes and the Beeper sounds when a component fails to meter properly. Alarms begin after a number of retries have occurred, this number determined by the parameter table (see Parameters, _AL). These alarms can also indicate an out-of-range TARE weight. This range is set by the TL and TH parameters; above 100 or below -50 grams.

Controller – Left Side

- **STOP END OF CYCLE / CONTINUE switch**
- **IMMEDIATE PAUSE / CONTINUE switch**
- **COMPUTER SERIAL input / output**
- **ETHERNET RJ-45 Port**
- **USB PRINTER Port**
- **LOAD CELLS Port**
- **EXTRUSION CONTROL Port**



STOP END OF CYCLE / CONTINUE switch

This is the switch that you should use to STOP the system. This switch is wired in series with the level sensor. Turning it off breaks the signal to the computer the same as covering the level sensor with material. This stops the process at the end of a full cycle.



IMMEDIATE PAUSE / CONTINUE switch

Causes a computer-controlled immediate pause during a cycle. Dispenses will stop in mid-dispense if necessary. When switched back to CONTINUE, the process continues without any error in amounts dispensed.

A cycle can be aborted during an Immediate Pause by pressing the DUMP button (requires software version P0909A/N or later).



COMPUTER SERIAL input / output

Serial has been the standard method of communications until the introduction of the 12-12 Controller, when onboard Ethernet became available. For customers who have been using Serial for their communications, this option is still implemented as before making the 12-12 Controller backward compatible with earlier Maguire Weigh Scale Blender communication serial networks.

The SERIAL port is a DB9 (9 pin) male port that communicates the MLAN protocol over RS-232 and RS-485. The serial port is also used to convert MLAN protocol over serial to other industrial protocols using a third party gateway.



ETHERNET PORT (RJ-45)

The Ethernet port allows for communication to the controller over Ethernet. Communication through this port is TCP/IP utilizing the MLAN Protocol or Modbus. The G2 Software, using the MLAN Protocol, can communicate with the controller over Ethernet using this Ethernet port.

For information on configuring the Ethernet interface, see Communications.



USB PRINTER PORT

This is a USB port. A USB printer or USB Drive plugged in here allows several types of information to be ported directly to a USB printer or USB Drive giving the benefit of a permanent printed or digital record. They are:

1. The totals of the material usage data.
Press VIEW and * keys or use the PRT parameter to AUTOMATICALLY and periodically print these totals.
2. A listing of the internal parameter table.
Press *77 in the PROGRAM mode.
3. A printout of information after each cycle including actual dispensed weights and percentages for every cycle.
Press *54 in the PROGRAM mode, use * to set printer flag ON.
4. A printout of information after the TIME or CALIBRATE routines.
*54 flag must be on to allow this.
5. Print Display – This is useful for obtaining printed verification of load cell accuracy ISO and other international quality program rules.
Press *88 before and after placing a KNOWN CERTIFIED WEIGHT into the weight bin to print the Date, Time, Machine number and displayed weight.
6. USB Recipe Command – Using *34, this command allows a recipe to be stored on a USB drive and / or used as the primary recipe run by the controller. For more information, see *34 on page 52.

The USB port can also be used to update the controller's software. For information about updating the controller software see Updating Controller Software and the Star function *93.



NOTE

Notes about printing to a USB drive

When saving printout information to a USB drive, the USB drive must contain a folder named **maguire** and within the folder, a file labeled **PRINTER.TXT** must be present. It is this file, **PRINTER.TXT** that printout functions appended to. Also note that every time a print occurs to the file on the USB drive, the data is appended to the end of the file PRINTER.TXT and does not overwrite existing data within the file.



LOAD CELL input port

On systems with two load cells the leads are joined by a common connector that is plugged into this port.



EXTRUSION CONTROL 2 Way Interface (optional)

For Extrusion Control Systems

Controller - Right Side

- SILENCE ALARM
- MIXER MOTOR ON/OFF/TIMED SWITCH
- MIXER MOTOR FUSE
- MIXER MOTOR OUTLET
- LEVEL SENSOR INPUT



SILENCE ALARM

This button stops the STROBE and BEEPER ALARMS, but does not remedy the cause of the alarm.

The continuation of the cycle to its proper completion will also stop the alarm. When in the BATCH mode, this button also serves to start the next batch.



ALARM SPEAKER



MIXER MOTOR ON/OFF/TIMED SWITCH (optional)

The Mixer ON/OFF/TIMED switch is provided as an additional safety so that you may switch the mixer off when you wish to clean out the mix chamber. In the UP position (ON), the mixer runs continuously. In the middle position (OFF) the mixer is off. In the down position, the mixer will run for a timed period following the dump of the weigh bin. The TIMED position is generally the correct choice.



MIXER MOTOR FUSE - 3 amp

Located above the Mixer Motor outlet, this fuse is rated at 3 amps and protects the mixer motor circuit separately from all other fuses. On 100, 200, and 400 series models, this fuse protects the mix motor directly. On 900 and 1800 series models, this circuit operates a 25 amp solid-state relay in a separate box. The mix motor is protected by a "motor starter" switch with a "heater". This switch must be on for the motor to operate.



MIXER MOTOR OUTLET

This outlet is energized continuously when the MIXER SWITCH is ON (up). In the TIMED position, it stays energized for a time period following the dump of the weigh bin. You may adjust this time in the parameter table (MIX 03015). This time should be just long enough to provide adequate mixing. Mixing for a longer period may contribute to a static problem. Also, excessive mixing sometimes causes separation of pellets of different size and weight.



LEVEL SENSOR input

The high level sensor in the mixing chamber plugs into this outlet and signals the controller to start a dispense cycle when it is uncovered. The sensor must be uncovered for at least 2 seconds before a cycle will start (see DLY 00488 Parameter). Once a dispense cycle is started, covering the sensor does not stop it. Operation continues until the cycle is complete.

INTERNAL FUSES

An in-line fuse is provided internally to protect the main 120-volt power cord supply (10) amps. If this fuses blow, an internal short circuit is indicated and we don't recommend that you try to fix it. Remember, this unit carries a five-year warranty; just send it back.

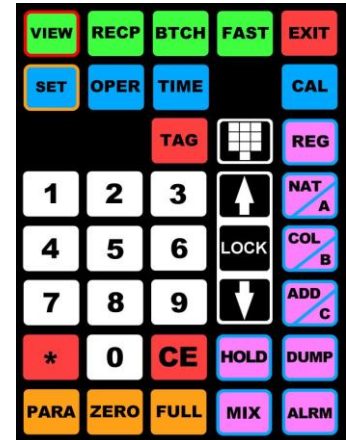
The MIX MOTOR timed power source and the AUGER FEEDER OUTLETS are driven by internal solid-state plug-in relays. These relays are located on the circuit board mounted on the inside back surface of the controller enclosure. A small 5-amp glass fuse is located to the right of each relay. A spare fuse is also located on the board if replacement is necessary.

Controller Keypad – Summary Description

Detailed explanations are given on the pages that follow.

AUTOMATIC OPERATION MODE: (normal operation on power up)

VIEW	View Data: date, time, cycles, and each component weight. Press VIEW, * to print data.
RECP	Enter and retrieve stored RECIPES.
BTCH	View BATCH data: Target Weight, Current Portion, and Accumulated Total, and Batch Count. CE = clear displayed field.
FAST	Run rapid FAST cycles after a normal weighed cycle.
TAG	Tag Work Order and Operator numbers to all reports.
EXIT	Press to EXIT all sequences from ALL MODES.
SET	Press to review or change settings.
CE	Press to display "raw signal" weight readout for 3 seconds.



MANUAL OR PROGRAM MODE: Press: *; then (11111) or your own 5 digit password.

OPER	Operate all devices manually; open and close valves.
TIME	Operate devices for a selected time period.
CAL	Operate devices to learn rate.

Above keys use 1 through 9, A, B, C, DUMP, MIX, HOLD, ALARM.

ZERO	Zero the tare weight with the bin empty.
FULL	Using known weights, enter gram weight to calibrate load cells.
*00	Clear DATA fields.
*99	Set flag to enable weight calibration of load cells.

PROGRAM MODE ONLY: Press: *; then (22222) or your own password.

SET	Enter settings if access in Automatic mode has been locked out.
PARA	View or change system parameters.

Press PARA for next in list, "*" for previous, SET for next table, VIEW for previous table.

STAR FUNCTIONS: Press * and two numbers for the following functions:

*02	Extrusion and Yield Control.	*69	Regrind as second natural.
*03	Four digit (xx.xx) settings.	*71	Color percent of blend.
*04	Simulate FOUR software.	*72	Additive percent of blend.
*05	Inhibit table clearing.	*74	Stop, alarm MAX wt exceeded.
*11	DATE - TIME, real-time clock.	*75	Alarm on weight drop.
*12	Move table from ROM to RAM.	*77	Print parameters.
*18	Language Selection	*78	Change program mode PASSWORD.
*22	LIW Model Selection	*82	Precision Ratioing.
*23	Move from RAM to EEPROM.	*83	Progressive Metering
*25	ROM OK flag, "CE" to clear.	*86	Backdoor Password
*32	Move from EEPROM to RAM.	*87	VOLUMETRIC operation.
*44	End cycle - bin full.	*88	Print display readout.
*45	Change MANUAL mode password.	*89	Select pounds, kilos.
*47	Totalizer flag.	*93	Update WSB software from USB drive
*48	Dispense range xx.x to xxx.	*95	Select COM port Baud Rate
*52	Double dump weigh bin.	*97	USBC Driver version display, update, verify
*54	Print cycle information.	*98	Display raw weight number.
*57	Alternate Liquid Color	*99	Enables Weight Calibration of the Load Cells
*66	WSB I.D. number (1-255).	*00	Clear All Data Fields.
*67	Modbus Enable / Disable		

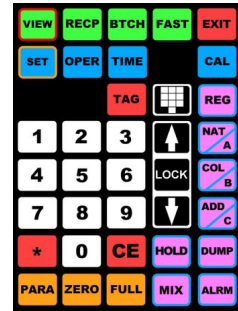
Controller Keypad – Description of Functions

Three (3) operation Modes are available; **AUTOMATIC, MANUAL, PROGRAM.**

KEYPAD - AUTOMATIC OPERATION MODE

This is the **NORMAL** operating mode. When power is turned on, the unit is in this mode. Automatic dispensing occurs **ONLY** in this mode. The **AUTOMATIC** mode is indicated by the **ABSENCE** of the letter "P" or "M" at the left end of the display.

Only the **VIEW, RECIPE, BATCH, FAST, TAG, CE, EXIT** and **SET** keys are available in this mode. These keys operate only **BETWEEN** cycles or when the **PAUSE** switch is on. To stop between cycles, use the "STOP END OF CYCLE" switch.



VIEW DATA - Press to display the **CURRENT** Date and Time, **LAST CLEARED** date and time, and stored material usage data. Total **CYCLES** and Material totals are available: (in Pounds, Kilos, Grams, or Ounces)

Number of CYCLES that have occurred:	(CYCLES : #####)
Weight of REGRIND that has been dispensed:	(Comp R: #####)
Weight of NATURAL :	(Comp N: #####)
Weight of COLOR :	(Comp C: #####)
Weight of ADDITIVE :	(Comp A: #####)
Total weight of ALL materials:	(Total: #####)

Each successive press of the **VIEW** key displays the next total. The last displayed line will say (00=CLEAR) for 5 seconds. During this time, you may press 0,0 to clear the data. **NOTE: Do not clear totals if you are using the G2 software to collect totals.** Waiting 5 seconds or pressing any other key will exit the sequence. When the sequence is exited, normal automatic operation resumes. These totals may be displayed as pounds, grams, kilograms, or ounces by a selection procedure explained later (*89).

Press the **VIEW** key once followed by the "*" key to cause all information to be sent to the printer (if available). To then clear the data, press 00 within 5 seconds. Press any other key or, wait 5 seconds, to continue the process without clearing the totals.



RECIPE - This key allows you to **GET, LOAD, and SAVE** RECIPES. To **SAVE** a recipe you must be in the **PROGRAM** mode. Recipes are thumbwheel switch settings. 99 recipes may be stored, 00 to 99.

This key is **NOT FUNCTIONAL** unless the third digit in the "FLG" parameter is set to 1 (FLG xx1xx). To do this, see the **MAINTENANCE** section, **PARAMETER TABLE, "FLG"**.

Assuming a proper **FLG** parameter is set: In normal Automatic mode: Press **RCP** key. If a **RECIPE** is currently in use then display will flash through the current stored data:

RECIPE # ##
Comp 1 (REG): ##.#, Comp 2 (NAT): 100, Comp 3 (ADD): ##.#, Comp 4 (COL): ##.#, (CE=CLEAR)

Press **CE** to **CLEAR** CURRENT **RECIPE** and return settings to those previously set. Then press **RCP** to look at another recipe. Display will say **RECIPE FILE GET # _ _**

Enter 2 digits to retrieve one of 99 recipes.
Display will flash through this recipe data:
Comp 1 (REG): ##.#, Comp 2 (NAT): 100, Comp 3 (ADD): ##.#, Comp 4 (COL): ##.#, Press * to Load

Press "*" to **LOAD** this recipe into memory.
Routine will exit automatically.
Press **RCP** to review recipe.
Press **EXIT** twice to exit out of program mode.

To **SAVE** a **RECIPE** you must be in the **PROGRAM** mode. If you press **RCP** key again after display of (GET --), display says (SAVE --). Enter 2 digits, display will say (SAVING). The current settings are saved into memory under the recipe number you have entered. Routine will **EXIT** automatically.

To delete a recipe from the database you must be in the **PROGRAM** mode. Press the **RCP** key to show the current recipe. Press the **CE** button to clear the current recipe. Then press **RCP** key again. Display will show **GET --**. Enter the recipe number you want to delete. Display will show this recipe followed by: *=Load **DUMP=Delete**. Press the **DUMP** key to delete this recipe from the database.

EXIT will exit at any time. To clear a recipe, set all component settings to zero and save these settings into the recipe location.



BATCH - This key allows you to blend a PRE-SELECTED WEIGHT of material, and then STOP running and sound the ALARM. The process may also be programmed to sound the alarm but continue running.

This key is NOT FUNCTIONAL unless the last digit in the "FLG" parameter is set to 1 or 2. (xxxx1 or xxxx2). To do this, see the MAINTENANCE section, PARAMETER TABLE, "FLG".

The ALARM SILENCE button on the side of the controller is the ONLY way to CONTINUE OPERATION after a BATCH amount has been run.

Assuming a proper "FLG" parameter is set:

Press the BTCH key once to view the desired BATCH WEIGHT.

Display will say: **BATCH INFORMATION Weight: #**

BATCH WEIGHT is the amount you wish to dispense before stopping and/or sounding the alarm.

Press again to view the CURRENT PORTION, of the batch, that has been dispensed.

Display will say: **Portion: #**

CURRENT PORTION shows how much of the Batch Weight you have blended so far.

Press again to view the ACCUMULATED TOTAL weight of all batches dispensed.

Display will say: **Total: #**

ACCUMULATED TOTAL is the sum weight of all batches that have been blended. This number will continue to grow until it is manually cleared to zero, or it exceeds its maximum possible value.

Press again to view the total BATCH COUNT.

Display will say: **Count: #**

BATCH COUNT is the total number of batches that have run.

This number will continue to grow until it is manually cleared to zero, or it exceeds its maximum possible value.

Press again to return to normal operation.

When any of the above totals are being displayed, you may press the CE key to RESET that number to zero. While all four totals can be cleared to zero manually, only the BATCH WEIGHT number can be entered manually.

When the BATCH WEIGHT is being displayed, you may enter a NEW batch weight using the keypad. You must enter a 5-digit number with leading zeros, if necessary. Maximum number that can be entered is "59999".

The unit of weight that will be used is either POUNDS or KILOGRAMS as determined by the *89 option, explained later.

While in operation, when the total is reached, the system will alarm and stop blending if the FLG parameter is set to 00001. The system will alarm but CONTINUE running if the FLG parameter is set to 00002. Use the ALARM SILENCE button (on the side of the controller) to silence the alarm. Pressing the BTCH key to view the information will also silence the alarm.

If the system is programmed to STOP at the end of a batch, the ALARM SILENCE button MUST be pressed to start blending the next batch. The First press of the ALARM SILENCE button will silence the alarm. The Second press will start the next batch.



NOTE

NOTE: Fractional cycles are not blended. Total weight may be in over the target by as much as one cycle weight.

The EXIT key will exit the BTCH sequence at any point but will NOT cause the system to start a new batch.

If an additional 120-volt output is desired for an alarm, substitute a 4 or 7 for the 00001. 4 turns on the Additive outlet, 7 turns on component 7 output.

If you have a printer connected, totals will print automatically. (See VIEW, * for details).



FAST CYCLES - This key will allow you to exceed the normal blending rate of your unit. Once your system has learned proper flow rates of each material, the timing of each component dispense is very consistent cycle to cycle. The FAST key allows one or more FAST REPEAT cycles to follow a normal calibrated cycle. In a FAST REPEAT cycle all components are dispensed simultaneously, without any weights being taken. Errors in dispense amounts will not be detected. These are, in fact, volumetric dispenses, not gravimetric. These dispenses take much less time. Throughput is easily doubled in this manner.

This key is NOT FUNCTIONAL unless the 4th digit of the "FLG" parameter is set to 1 (xxx1x). To do this, see the SOFTWARE MAINTENANCE section, PARAMETER TABLE, "FLG".

The shorter mixing time may be a problem. So the number of FAST REPEAT cycles is kept as low as possible. Up to 4 repeats may occur.

Press the FAST key then the * key to toggle the **FAST CYCLES** flag **ENABLED** or **DISABLED**. When set to (FAST OFF) the FAST mode will not operate. When set to ENABLED every normal calibrated dispense will be followed by up to 4 FAST repeat dispenses.

This series of 4 dispenses is terminated as soon as the sensor is covered, which indicates the blender has "caught up". The next cycle will then be a weighed cycle, followed by the required series of fast cycles to catch up again.

Press * to toggle between ENABLED and DISABLED.
Press EXIT, to exit.

When the FAST mode is in operation, the display will flash "FAST" intermittently.



SETTING

NOTE: With 4 Software controllers that have mechanical thumbwheels (not digital), use of the SET key to set the settings will disable the thumbwheels.

Press once and the current setting of component 1 is displayed. Display will say: COMPONENT SETTINGS Comp X (REG): xx.x. X is hopper, followed by either REG, (REGRIND); NAT, (NATURAL); ADD, (ADDITIVE); COL (COLOR). xx.x is the current setting.

Press SET to step forward through all the settings. Press * key to backup in the list. NEW settings may be entered directly. **Settings set here will override thumbwheels.**

REGRIND and ADDITIVE and COLOR settings are expressed as percents, up to 99.9 percent. NATURAL makes up the rest of the batch.

If you wish to restrict the entry of settings to the PROGRAM mode only, (password required), you may do so by altering the _SE parameter for each component that you wish to "lock out". See MAINTENANCE SECTION, PARAMETERS, _SE parameter.



TAG - This key allows two pieces of information to be "tagged" onto all data that is either printed or retrieved through the computer communications ports. The items are WORK ORDER number and OPERATOR number.

This key is NOT FUNCTIONAL unless the 2nd digit of the "FLG" parameter is set to 1 (x1xxx). To do this, see the SOFTWARE MAINTENANCE section, PARAMETER TABLE, "FLG".

Press once to display the current Work Order number: **Work Order: xxxxxx**. Press again to display the current Operator number: **Operator Number: xxx**. Press again for the Recipe number: **Recipe: xxxxx**. You may enter or change the Work Order or Operator number, when each is displayed to tag all information with these numbers. The Recipe number is used only for the Recipe Auto Download feature of the G2 software or the earlier MLAN software. For information on Auto-download see the **Recipe Auto Download** function in the G2 Software Manual.

Work Order and Operator numbers are for your TRACKING of information ONLY. They have NO EFFECT on the operation of the Weigh Scale Blender.

- **WORK ORDER** number (6 digits) allows you to tag all information with an internal accounting number such as a job or purchase order number.
- **OPERATOR** number (3 digits) allows you to track who is operating the equipment.
- **RECIPE** number allows you to request a recipe stored in the G2 Software using a recipe number between 100 and 65536. The Recipe Tag number is not for loading internally stored recipes. See the RECIPE key for loading internally stored recipe numbers. If a recipe has been entered using

our G2 or MLAN software, then a 3-digit or 5-digit number will be displayed in this field. If a new recipe number is entered and the TAG or EXIT key is pressed, the controller will display: **Waiting for Recipe...** At this time, the controller is requesting a recipe from the G2 Software using the MLAN protocol. A matching recipe number found in the G2 Recipe database will then be sent to the controller, enabling or disabling components and setting settings. G2 will then begin tracking material usage for that recipe. If the G2 Software does not have a matching recipe number, the controller will alarm briefly and then revert back to it's previous loaded recipe. A successfully loaded recipe number will be displayed and "tagged" to all printouts and retrievals. EXIT will exit the sequence at any point. Exit will also abort a pending Recipe Auto Download.

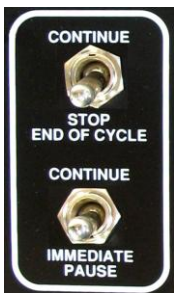


EXIT - This key is operational in ALL MODES.
Use the EXIT key to exit any and all keypad sequences.



CE - Press "CE" at any time to display raw data readout of the load cells for five seconds. This is helpful in diagnosing possible load cell problems and is explained in detail in the MAINTENANCE section. "CE" is used frequently in connection with other keys, to clear or scan through selections.

KEYPAD - MANUAL MODE



In this mode, you may operate individual functions manually for test purposes. No totals are saved and automatic operation does not take place. The low level sensor has no control or effect over manual operation requests.

The Row of keys marked OPER, TIME and CAL operate in this mode coupled with all device keys; REG, NAT, COL, ADD, DUMP, MIX, HOLD, and ALRM.

You can enter this mode only when the controller is between cycles. The sensor must be covered or the STOP switch must be in the "STOP –END OF CYCLE" position. When in this mode, no automatic dispensing occurs.

To enter this mode, press "*", then enter the correct password number. The password supplied with the unit is "11111." You may change this to any other 5 digit number, if you wish, as explained later (*45). When in the MANUAL mode, the letter "M" shows at the left end of display.

The following manual functions are available in the MANUAL mode:



OPERATE - Press once followed by one of 8 keys: REG, NAT, COL, ADD, DUMP, ALRM, MIX, or HOLD. The selected output operates until the key is pressed again or another output is selected. Only 1 output will be active at a time. EXIT will exit the sequence and close all outputs.



TIMED - Press once followed by one of 4 component keys (REG, NAT, COL, ADD). A time in interrupts is requested; (TIME ---). Three digits must be entered specifying a dispense time up to 999 interrupts (about 4 seconds maximum.) CE will cancel entry before last digit is entered. Following a full 3-digit time entry, the specified output is activated for the time requested. After the dispense is weighed, the dump valve automatically operates to empty the weigh bin. If a printer is on line and the Print flag is ON, then output information will be printed. EXIT will exit the sequence.



CALIBRATE - (RATE) Press once followed by one of the 4 component keys (REG, NAT, COL, ADD). A dispense will occur for 1 second. If the amount dispensed is less than 50 grams, a second dispense will occur for 2 seconds. If a 2-second dispense is not enough for an accurate calibration, the blender will dispense for 10 seconds. Using the resulting weight and time, the processor calculates a proper beginning point dump rate for the start of production blending. After each dispense is weighed, the weigh bin dump valve automatically operates to empty the weigh bin. If a USB drive is plugged in and the Print flag is ON (see *54), then output information will be written to USB. EXIT will exit the sequence.

If the display says (FAILED DO AGAIN), press any key to cause the process to repeat itself. If the display then says (FAILED NO GOOD), the dispense weight was below 2 grams, not enough for a valid calibration.

During initial operation, after each power up, the blender calibrates itself completely automatically, regardless of how far off the initial flow rate may be. This may take several cycles. During normal operation, calibration correction occurs continuously.

Since this unit adjusts flow rates automatically, manual Rate Calibration is not necessary for proper operation.



Zero Weight Calibration



If you are collecting totals from the blender with software, a Zero Weight and Full Weight calibration should be done periodically, approx. every 6 months, to assure accurate data in your totals reports.

For this key to function, you must first set the weight calibration flag ON.

Press *99 to observe flag status. Press * to toggle flag ON or OFF. With flag set ON, press EXIT. Power-off always resets this flag to OFF.

Press the ZERO key once to set the displayed gram weight of the empty bin to zero. BE SURE the load cells are plugged into the controller. Be sure the bin is properly in place and EMPTY when this key is pressed.

Since the bin, even when empty, weighs about 1300 grams; it is necessary on initial setup of equipment to instruct the controller of the exact tare weight of the empty bin.

Slight drift in the tare or zero weight during day-to-day operation is normal. All weight calculations automatically compensate for this drift. However, when the bin is empty, if the weight displayed is more than 50 grams above or below zero, then you may wish to reset the electronics to display zero when the bin is empty.

If, when the bin is empty, the weight displayed is greater than 100, or less than -50, (Parameters TH and TL), the dispense cycle will not begin. Instead, the dump valve will repeatedly try to dump any material it thinks is in the bin or will sound the alarm if weight is below -50. If the load cell calibrations have drifted this far, it is absolutely necessary to reset empty bin weight to zero. These minimum and maximum tare weights are set by the TL and TH parameters. See PARAMETERS, TL and TH for more info.

Allow system to be on for at least 5 minutes to allow for warm up of certain components before setting ZERO or FULL weights.

Generally, when zero weight shifts, the full weight reading shifts the same amount. For this reason, resetting the ZERO WT automatically shifts the FULL WT readout by the same amount. Resetting the ZERO weight usually is all that is necessary to also calibrate the FULL weight.



Full Weight - ZERO WT. must be entered before FULL WT. to achieve proper calibration. The FULL WT. key will not function until you have set ZERO WT. as described above.

If you wish to reset the controller for proper full-weight scale display, use any known weight as close to full bin weight as possible. Do not exceed 9999 grams. Place this weight in the bin and press the FULL WT. key. The display will show five dashes (FUL-----). Now enter the actual weight in grams of the item you are weighing.

AGAIN, both FULL WT. and ZERO WT. have been set at the factory. A drift of several grams from these settings is normal and should not be of any concern. Recalibration should be considered only if ZERO is more than 20 grams off or FULL WT. is more than 50 grams off. These errors do not prevent proper proportions from being dispensed. ZERO error is always "tared" for proper weighing of each component. FULL scale error will only cause accumulated totals to be off by the degree of this error. The primary function of the WEIGH SCALE BLENDER is to dispense materials in the proper ratios. Because all components are weighed by the same load cells, the accuracy of these ratios is not affected by zero or full scale errors.

STAR FUNCTIONS available in the MANUAL mode:



Press (*,0,0) to CLEAR ALL DATA fields. These are the material usage totals that are viewed with the VIEW key. If you are tracking material usage, you should record these numbers periodically but clearing these totals is entirely optional and not necessary.

After VIEWING the data or printing of data using the VIEW,* key sequence, a display of (00=CLEAR) will appear for 5 seconds. During this 5 seconds you may reset all data fields to zero by pressing 00. Pressing any other key or waiting 5 seconds will exit this sequence without clearing data.



Press (*,9,9) to set flag to enable Weight Calibration of the Load Cells. In later model controllers you can specify WSB CAL or LIW CAL. Power On will always set this flag to OFF. This flag must be ON before the load cell weight calibration keys, ZERO and FULL WT, will function. With ON flag displayed, press EXIT.

KEYPAD - PROGRAM MODE

In this mode, you may perform ALL of the functions available in MANUAL mode, plus additional functions that alter the logic with which the controller operates. The PARA key operates in this mode. STAR FUNCTIONS are available by pressing the "*" key and two numbers.

Just as with the MANUAL mode, you can enter this mode only when the controller is between cycles. The sensor must be covered or the STOP switch must be in the "STOP - END OF CYCLE" position. In the MANUAL mode, no automatic dispensing will occur.

To enter this mode, press "*", then enter the correct password number. The correct password supplied with the unit is "22222". To change this to another 5-digit number of your choice, see (*78). When in the PROGRAM mode, the letter "P" shows at the left end of the display.

The following PROGRAM functions are available in the PROGRAM mode.



PARAMETERS - Press the PARA key to display the table of operating parameters that reside in memory. There are 13 separate groups of parameters. The first group is the GENERAL group and contains 49 GENERAL parameters. The other 12 groups are the COMPONENT groups and contain 14 COMPONENT parameters each.

A FULL EXPLANATION of each PARAMETER can be found in the next section: EXPLANATION of PARAMETERS.

The PARAMETER LIST looks like this:

General	Component: 1 through 9, and A, B, and C				
FLG	1TY	2TY	3TY		CTY
MIX	1CS	2CS	3CS	and so on up to:	CCS
FCV	1AL	2AL	3AL		CAL
DTI	1XT	2XT	3XT		CXT
KDF	1SE	2SE	3SE		CSE
WDF	1WT	2WT	3WT		CWT
BER	1TI	2TI	3TI		CTI
ROC	1MI	2MI	3MI		CMI
ROV	1NC	2NC	3NC		CNC
RHL	1RP	2RP	3RP		CRP
FUL	1RD	2RD	3RD		CRD
MAX	1LA	2LA	3LA		CLA
TH	1PT	2PT	3PT		CPT
TI					
PRT					
...and so on down to:					
TRC					

Press: PARA to ENTER the list at the TOP LEFT (FLG).
 Press: PARA to move DOWN a list.
 Press: * to move UP
 Press: SET to move RIGHT (1st time, goes to 1TY)
 Press: VIEW to move LEFT
 Press: EXIT when finished.

In the COMPONENT lists:

The TOP parameter (TYPE) is ALWAYS accessible. The others are NOT accessible unless TYPE is set.

The First press of the PARA key will enter the GENERAL list at the top. Then the first press of the SET key will move to top of the first component list. Press the PARA key to move down in any list. While in one COMPONENT list, press the SET key to jump to the same relative position in the next list. This allows rapid scanning of like parameters in all component groups. To change a displayed parameter, enter a new number in place of the old one. CE will cancel a number entry before the last digit is entered. The purpose of each parameter is explained elsewhere in this manual. In any component list, if TYPE is set to "OFF"; (_TY= OFF); other parameters in that list are not accessible. EXIT will exit the sequence at any time.

Star Functions

Star functions are password protected access codes to setup certain functions of the blender controller. To access a star function, enter program mode by pressing *, then enter the program mode password (default password is 22222), and then press * followed by the two-digit star function.

*02	Extrusion and Yield Control	*45	Change MANUAL mode password	*77	Print parameters
*04	Simulate FOUR software	*47	Enables/disables Dispenser Mode	*78	Change program mode password
*05	Inhibit totals data clearing	*52	Double dump weigh bin	*79	Valve Leak Detection
*06	Inhibit CE restore on power up	*54	Print cycle information	*82	Precision Ratioing
*07	Not in use (deprecated)	*57	Alternate Liquid Color	*83	Progressing Metering
*10	Not in use (deprecated)	*60	Display IP, Subnet, Gateway	*86	Backdoor Password
*11	Select Date Format	*61	Display Serial Number	*87	VOLUMETRIC operation
*12	Restore ROM defaults	*62	Display MAC Address	*88	Print display readout
*14	Set types: REG, NAT, ADD, OFF	*63	Set MLAN TCP Port (4088 Std only)	*89	Select pounds, kilos
*15	Clear All row	*64	Set Modbus TCP Port (4088 Std only)	*93	Update Controller Firmware
*18	Select Language	*65	Set IP, Subnet, Gateway	*94	Update Controller NET Firmware
*23	Save User Settings	*66	Set WSB ID number (1-255)	*95	Select COM Port Baud Rate
*25	Check Firmware	*67	Enable/Disable Modbus TCP	*96	Format SPIFI (4088), Flash-card (12-12)
*32	Restore User Settings	*69	Regrind as 2 nd Natural (4-Soft only)	*97	Update USB Driver (12-12)
*33	Ext. Control (deprecated)	*71	Color as % of Mix (4-Soft only)	*98	Display Raw Counts
*34	USB Recipe Command	*72	Color and additive as % of Mix	*99	Calibration Mode Enable/Disable
*44	End cycle - bin full	*74	Stop, Alarm MAX Weight Exceeded	*00	Clear Totals and Cycle Count
		*75	Alarm on weight drop		

Use the "*" key to select readout or toggle flags ON or OFF

Star Functions are only available in PROGRAM mode.

* 0 2

EXTRUDER MODE - Extrusion and Yield Control, and Rate display.

Press (*,0,2) to turn on Extrusion or Yield control.

The default display is **DISABLED**.

Press * to toggle this flag to **RATE DISPLAY**, **EXTRUSION CONTROL**, or **YIELD CONTROL**.

If you are using our EXTRUSION or YIELD control software to control your extruder, refer to our EXTRUSION CONTROL instruction booklet for complete information.

If you simply want to view throughput continuously on the blender display, set this option to **RATE DISPLAY**. This will alter the display only. In all other respects, the blender will operate normally.

YLD-X – Extruder Control

YLD-T – Takeoff

YLD-D – Dual

* 0 5

CLEAR DATA PROMPT - Prevent manual reset of totals and cycle count

Press (*,0,5) to inhibit the (00=CLEAR) display at the end of the VIEW  sequence.

Applications using communication to retrieve material usage totals may wish to restrict an operator's ability to clear the material usage data at the controller. This option disables the prompt to clear this data at the end of the VIEW  sequence. Press * to toggle between **CLEAR DATA PROMPT ENABLED** and **CLEAR DATA PROMPT DISABLED**. When finished, press **Exit** to save changes, then press **Exit** again to exit out of Programming Mode.

* 0 6

CE Key on Power Up - Restore User Settings – Enable/Disable

Press (*,0,6) to enable or disable the use of the CE key on power up to restore saved user settings.

Press * to toggle between **CLEAR DATA PROMPT ENABLED** and **CLEAR DATA PROMPT DISABLED**.

See *23 and *32 for more information.

* 1 1

SELECT DATE FORMAT - Sets System Date and Time

Press (*,1,1) to set the date format and to enter the correct date and time into the real-time clock. Correct date and time is helpful if you are retrieving information using a printer or are collecting data by communications.

The first display will indicate USA or EUROPE date format.
Use the CE key to toggle from one to the other.

USA will cause all dates to be displayed MONTH/DAY/YEAR.
EUROPE will cause all dates to display DAY/MONTH/YEAR.

Press ***** to enter the current date and time. The correct date and time for Easter Standard Time were entered at the factory. You will want to correct this for your time zone. Enter the date and time using the keypad numbers. The date and time fields will advance as numbers are entered. Use the **CE** key to step through all the fields without change. After entering the minutes, the controller will exit to program mode and save the changes to date and time. Press **Exit** again to exit out of Program Mode.



Restore Factory Default Settings

Press (*****,**1**,**2**) to restore the Blender's hard-coded factory default settings.

Pressing *****,**1**,**2** restores Factory Default Settings into "User Settings" and "User Backup Settings" (retains certain important information). Display will show: **RSTR. ROM DEFAULTS**. It will not prompt for confirmation. Resets immediately after ***12** is pressed. Accessible in Program Mode Only.



Select Language

Press (*****,**1**,**8**) to select the language the controller's display will use. Language options are: English, Francais, Italiano, Deutch, Czech, Hungarian. English6 and English7 are placeholders for additional languages.



Save User Settings

Press (*****,**2**,**3**) to copy the current "User Settings" into "User Backup Settings". The display will show **SAVE USER SETTINGS**. For an explanation of the memory areas in the Blender software as well as the use of the **Clear** and **Clear All** Routines see the Backup, Restore, Factory Reset section.

Once saved, this information is then available for retrieval using the CLEAR routine (press and hold CE key during power on) or by using the ***32** function described next. When finished, press **Exit** to save changes, then press **Exit** again to exit out of Programming Mode. Accessible in Program Mode only.



Restore Saved User Settings

Press (*****,**3**,**2**) to copy the "User Backup Settings" into "User Settings". Display will say **RESTORE USER SETTINGS**. For an explanation of the memory areas in the Blender software as well as the use of the **Clear** and **Clear All** Routines see the Backup, Restore, Factory Reset section.

This is useful for retrieving correct information that you may have stored earlier in the "User Backup Settings". Also, if you have been making changes to **User Settings** and now wish to restore all settings to what they were at power up, this is the function to use. When finished, press **Exit** to save changes, then press **Exit** again to exit out of Programming Mode. Accessible in Program Mode Only.



DISPLAY Firmware Status and Checksum

Press (*****,**2**,**5**) to display the Firmware status and checksum. (Previously: Check the ROM-CHECK Flag). Displays the firmware status and checksum. When finished, press **Exit**, and then press **Exit** again to exit out of Program Mode.



USB Recipe Command

Press (*****,**3**,**4**) to enable or disable the USB Recipe Command. Use the ***** key to toggle USB Recipe Command enable or disable. Enabling the USB Recipe Command enables the following options:

The Recipe key (RECP) allows the user to save the current recipe to USB (press RECP once), press ***** to save. Note: The Recipe key (RECP) is only enabled in Program Mode.

The Recipe key (RECP) allows the user to view the current recipe file stored on the USB key (press RECP twice), press ***** to view.

With the USB Recipe Command enabled, the blender will look for a USB drive plugged into the USB port on the controller that contains a file named "RECP_CMD.TXT" located within a folder named "maguire". If that file exists and is formatted correctly, the controller will run the recipe stored on the USB drive. If the USB drive does not exist, the RECP_CMD.TXT files does not exist or the RECP_CMD.TXT is not

formatted correctly, the controller will stop and alarm.

Example USB Recipe	Description
W	W = 4 Software, T = 12 software
S1:1:200:000:00000:	Column 1: S1 through S4 = components 1 through 4
S2:2:100:000:00004:	Column 2: 1 = Regrind, 2 = Natural, 3 = Additive (additive is the same as color)
S3:3:050:000:00004:	Column 3: Setting value. Implied decimal in 10ths for regrind and additive.
S4:3:030:000:00004:	Column 4: XT Parameter (See XT Parameter on page 69)
E	Column 5: Alarm parameter (See AL parameter alarm on page 66)
	E = End of file



END CYCLE WITH: BIN EMPTY, BIN FULL This flag for SPECIAL APPLICATIONS ONLY.

Press (*,4,4) to tell the controller to end a cycle when the weigh bin is FULL. Use the * key to toggle between **BIN EMPTY** or **BIN FULL**.

Normal operation is to end the cycle BIN EMPTY. The BIN FULL option is only for special installations where the sensor has been relocated BELOW the mix chamber and the instructions to do otherwise. When finished, press **Exit** to save changes, then press **Exit** again to exit out of Programming Mode.



SET MANUAL MODE PASSWORD

Press (*,4,5, followed by a 5 digit number) to change the PASSWORD number for entering the MANUAL mode. The system is supplied with the number "11111" as the password number. If you wish to restrict use of this mode to only yourself, you may make up your own number and enter it here. When finished, press **Exit** to save changes, then press **Exit** again to exit out of Programming Mode.



This flag is for WST (totalizer) models only.

When set, the display will continuously display the total amount of material that has passed through the unit since the total fields were last cleared. When the unit is functioning as a totalizer, this is the information that is most meaningful.

Press (*,4,7) to turn the totalizer functions on.
The display will say (TOTALIZER DISABLED).
Press * to toggle flag to (TOTALIZER ENABLED)

To RESET TOTALS to zero:

1. Stop operation by switching to "STOP END OF CYCLE".
2. Move the pause switch to "IMMEDIATE PAUSE".
3. Press the "ALARM SILENCE" button. This will clear the totals.

When finished, press **Exit** to save changes, then press **Exit** again to exit out of Programming Mode.

CALIBRATION: To perform a Zero and Full Weight Calibration, disable *47. When calibration routine is finished, Enabled *47 to return to Totalizer Mode.



EXTRA BIN DUMP (Weigh Bin Double Dump)

Press (*,5,2) to cause the weigh bin dump valve to operate two times. We call this a "double dump". If you have problems with material hanging up in the weigh pan, this may help shake it loose.
Use the * key to toggle between **ENABLED** and **DISABLED**
Press EXIT when done.



PRINTED REPORTS - Cycle-by-Cycle Printout

Press (*,5,4) to enable writing of Printed Reports containing cycle data to a USB flash drive. Cycle data will write after each full dispense cycle. With this feature **ENABLED**, a folder named maguire present on the flash drive and the flash drive plugged into the controller's USB port, four lines of information about the dispense cycle that just occurred will be sent to a file named PRINTER.TXT. Press * to toggle between **ENABLED** and **DISABLED**. This information includes dispense weight and percentage of each component, the internal rate numbers used by the computer to determine dispense time, and the actual dispense time of each component. This is excellent information troubleshooting and to track the accuracy of each dispense cycle and the accuracy of the entire system over an extended period of time. See: Printed Outputs for a more detailed explanation.

* 5 7

Alternate Color (For Liquid Color PIAD system)

For LIQUID COLOR applications only. This function usually operates in conjunction with an additional two air solenoids mounted on the blender frame.

Press (*,5,7) to allow automatic switch over to a full drum when the current drum of color runs out. When function is off, display will say **LIQ OFF**. Press * to toggle to **COL 04**. When display says **COL 04**, the color setting applies to output 04 only, the standard COLOR output. When display says **COL 04 → 07**, this means that output 04 is the starting output, and when no weight is detected after a dispense, the controller will alarm, then the output switches to output 07. The "07" is determined by the parameter (LIQ 10007). You can change the secondary output by changing the parameter.

If output 07 is also empty, the output switches back to 04. See parameter (LIQ 10007) for more information.

When finished, press **Exit** to save changes, then press **Exit** again to exit out of Programming Mode.

* 6 0

WSB COMMUNICATIONS – View the Blender's Ethernet IP Address, Subnet and Gateway

Note: this star function is available in controller software versions ending in /N

Press (*,6,0) to view the WSB's Ethernet IP Address, Subnet and Gateway. If the WSB is configured to obtain an IP automatically (DHCP) through *65, then the IP, Subnet will be whatever was assigned to the controller by a DHCP Server on your network. If the IP address was configured manually, this will be whatever was entered using *65. Press the * key to toggle through IP, Subnet and Gateway. Press EXIT when done.

* 6 2

WSB COMMUNICATIONS – View the Blender's Ethernet MAC Address

Note: If *62 displays INVALID, please contact Maguire Products Inc.

Press (*,6,2) to view the WSB's Ethernet MAC Address. View Only.

* 6 4

Modbus TCP Server Port Selection – 4088 Standard Only

Press (*,6,4) to view or change the Modbus TCP Server port. Default is port 502.

* 6 5

WSB COMMUNICATIONS – Set the Blender TCP/IP Settings

Note: If *65 displays INVALID, please contact Maguire Products Inc.

Press (*,6,5) to configure the IP Address, Network Mask and Default Gateway.

Press the CE key to switch between DHCP and Static IP. For DHCP, See *62 for the MAC Address.

To enter the Static IP, Network Mask and Default Gateway, use the numeric keypad. When complete, press exit to save. Press exit again to exit out of programming mode. **MLAN use TCP port 9999.**

* 6 6

WSB COMMUNICATIONS – Sets the Blender ID number

Press (*,6,6) to enter an identification number for this particular weigh scale blender. This I.D. number will appear on all printed reports. If you have more than one unit, this helps to identify reports. If you are using a computer to automatically gather data, then each controller must have a unique address. Valid numbers are 000 to 255. When connected to a computer, do not use the number 000 for identification. When finished, press **Exit** to save changes, then press **Exit** again to exit out of Programming Mode.

* 6 7

Modbus TCP Server – Enable / Disable

Press (*,6,7) to enable/disable the Modbus TCP Server. Press * to toggle between **ENABLED** and **DISABLED**. When complete, press exit to save. Press exit again to exit out of programming mode. **Modbus TCP uses TCP port 502. See *64 Modbus port reassignment (4088 Standard only).**

* 6 9

Regrind Hopper as Second Natural (4 Software Mode only)

Press (*,6,9) to set flag to treat the "REGRIND" dispense in 4 Software as a SECOND NATURAL material.

With the flag **DISABLED**, Natural is calculated to fill the space remaining in the weigh bin after a Regrind dispense has occurred. In other words, when a reduced amount of Regrind is dispensed, additional Natural is dispensed. Color and Additive dispenses are calculated as a percentage of this Natural dispense ONLY.

With the flag **ENABLED**, Natural is calculated to maintain the proper RATIO between the two components (Natural and Regrind). Color and Additive dispenses are calculated to add to BOTH components at the requested ratios.

"Regrind", in the normal sense, is not added. Instead, this component is treated as another "Natural" material. If the ratio of the two naturals is not 50/50, place the HIGHER volume component in the "regrind" side. Set the "regrind" thumbwheel for the percentage that the "regrind" side is of the combined mix. For example; Naturals A and B are to be used at a 20/80 mix ratio; B is the greater at 80 percent. Put component B in the regrind side and set the regrind switch for 80 percent.

NOTE: The Regrind alarm parameter (RAL) is automatically set to a number that forces retries and stops the system when this component runs out. See PARAMETERS, RAL-00004.

Use the * key to toggle flag ENABLED or DISABLED. Press EXIT when desired flag status is displayed.

NOTE: Do not use these features in combination with *82.

* 7 1

COLOR AS Percent of Mix (% of total) - This flag for SPECIAL APPLICATIONS ONLY

Press (*,7,1) to change the Color setting to be interpreted as percent of the entire MIX instead of percent of the Natural (NAT). The display: COLOR AS A % OF NAT (default). Press CE key to toggle to COLOR AS A % OF MIX. **CAUTION:** With flags set, Color and Additive settings combined must NOT exceed 100 percent. When finished, press **Exit** to save changes, then press **Exit** again to exit out of Programming Mode.

* 7 2

ADDITIVE AS Percent of Mix or Regrind - This flag for SPECIAL APPLICATIONS ONLY

Press (*,7,2) to change the Additive setting to be interpreted as percent of the entire MIX or Regrind instead of percent of the Natural (NAT).

The display will say **ADDITIVE AS A % OF NAT (default)**. Press the CE key to toggle to **ADDITIVE AS A % OF MIX**. Press the CE key again to toggle to **ADDITIVE AS A % OF REGRIND (REG)**.

CAUTION: With flags set, Color and Additive settings combined must NOT exceed 100 percent.

When finished, press **Exit** to save changes, then press **Exit** again to exit out of Programming Mode.

* 7 4

MAX Weight Alarm

Press (*,7,4) to set a flag that will cause the system to stop and the Alarm to activate when MAX weight is exceeded. This might occur if a valve sticks open or slightly open. Normally the system recovers automatically from such events with only the one batch blended incorrectly. Set the flag only if you want the system to stop and alarm. Press * key to toggle between **ENABLED** and **DISABLED**. When finished, press **Exit** to save changes, then press **Exit** again to exit out of Programming Mode.

* 7 5

WEIGHT LOSS ALARM - Weight Reading Alarm

Press (*,7,5) to set a flag to ALARM if the weigh bin weight drops more than 20 grams during a cycle. This serves to detect and report a weigh bin problem, such as material leaking from the bottom of the bin. Press * key to toggle between **ENABLED** and **DISABLED**. When finished, press **Exit** to save changes, then press **Exit** again to exit out of Programming Mode.

* 7 7

Parameter Printout

Press (*,7,7) to write a copy of all internal parameters to a plain text file on a USB flash drive. A folder named maguire must be present on the USB flash drive and the flash drive must be plugged into the USB port of the controller. Up to 13 lists will print, a General list and 12 component lists. Only components that are turned "on" will print. Four columns will print, RAM; ROM; 200 and 900 series tables; and EEPROM. Identifying headings print above each column.

* 7 8

Change Program Mode Password

Press (*,7,8, followed by a 5 digit number) to change the PASSWORD number for entering the PROGRAM mode. The system is supplied with the number "22222" as the password number. If you wish to restrict use of this mode to only yourself, you may make up your own number and enter it here. If you forget your password number, call us. We can help.

* 7 9

Valve Leak Detection

Press (*,7,9) to enable or disable Valve Leak Detection. When enabled leaks in the hopper valves are detected by monitoring the weight in the weigh bin for an unexpected gain in weight after the completed dispense of a valve. Requires at least a 20-gram change in weight before flagging the alarm.

* 8 2

Precision Ratioing - Color or Additive

With Precision Ratioing, natural dispenses occur after the selected color or additive dispense or the selected color or additive is introduced in between the natural component. With *82 enabled, natural is calculated to assure the most exact percentage ratio for the smaller selected precision component. Because the Natural dispenses are larger, this method allows for more exact ratio of the one selected

precision component. To enable Precision Ratio press (*,8,2).

Pressing the CE key will toggle between: **PRECISION RATIOING DISABLED, PRECISION RATIOING COLOR, PRECISION RATIOING ADDITIVE**. Only one component (Color or Additive) can be selected for Precision Ratio. With Precision Ratioing enabled on a specific component, press the * key to change the **LAYERING** options then press **CE** to toggle to change the **LAYERING** option. Layering options are **LAYERING** (default) or **STANDARD**. **LAYERING** will dispense ½ of the NATURAL first then the ADDITIVE, and then the 2nd half of the NATURAL. This option is designed for application such as liquid color creating better dispersion and a lesser chance of the liquid color adhering to the weigh bin while still offering more precise ratioing of the selected additive. **STANDARD** Layering will dispense the specified additive BEFORE the Naturals, instead of after. When finished, press **Exit** to save changes, then press **Exit** again to exit out of Programming Mode.



Progressive Metering

Press (*,8,3) to select "Progressive Metering" option. Progressive Metering allows for more accurate dispenses of selected components. However, cycle time will be extended by a few additional seconds.

In normal operation blenders target a dispense of the full requested amount in one try. This almost always works, and generally will fall within acceptable upper and lower error limits. Making the dispense in one try allows for high throughput rates while still achieving a level of accuracy acceptable for most processors. When the accuracy of one particular component is critical, or the process depends on maintaining a tighter tolerance of this component, customers may lengthen the blend cycle time slightly to achieve this higher level of accuracy.

The *83 function is used to turn on the progressive metering function for a selected component. This sets parameters which will cause the dispense to occur in several progressively smaller dispenses. This results in a more accurate dispense.

The first dispense targets only 85 percent (the default percentage) of the full required amount. After careful weighing, each successive dispense targets 50 percent of the remaining shortage. This continues until the amount reaches, or is within 1 percent of, the target. In this manner the software "sneaks up" on the target, providing the maximum achievable accuracy possible.

When a component is selected and turned ON, the corresponding PT and RP parameters are set to PT 00085 and RP 00001.

The keypad sequence:

Press *,8,3. Display will say <instruction 83> COMP: 1T.

Use the "*" key to walk through all the components.

Use the "CE" key to toggle a component ON or OFF.

When ON, Display will say **COMP: # T: 85**

You may change the 85 by entering a different number. Too low a setting will just add time. Too high will cause occasional overshooting. When finished, press **Exit** to save changes, then press **Exit** again to exit out of Programming Mode.



Backdoor Password

Press (*,8,6) to select a new "Back Door" password for your controller. Display will say **BACKDOOR PASSWORD Select (0-9): 00000**. Enter 00000 through 00009 to select one of ten backdoor passwords. Backdoor passwords are not published, and you must contact Maguire Products for the actual number.

Blenders are pre-programmed with two default passwords; (22222) is the default password for the PROGRAM mode, and (11111) is the default password for the MANUAL mode. You can alter these passwords to any 5-digit number. Also see *78.



Volumetric Mode

Press (*,8,7) to set flag for operation in a VOLUMETRIC mode. Use the * key to toggle the flag ENABLED or DISABLED. Press EXIT when done. When power is turned off this flag is always reset to OFF. With this flag ENABLED (VOLUMETRIC mode), the load cells are completely ignored. Error correction and rate recalibration does not take place. The unit functions like a volumetric feeder without checking or correcting for errors. Since load cell readings are ignored, this flag allows operation even if the load cells become damaged. Dispense times will be based entirely on the WT and TI parameters. When finished, press **Exit** to save changes, then press **Exit** again to exit out of Programming Mode.



Printout Display

Press (*,8,8) to force a printout of the display on the controller front. DATE, TIME, Machine number, and displayed weight will print:

Date: 11/09/2006
 Time: 17:22:01
 Machine number: 001
 Display Readout: 2000.0 g

This is useful for obtaining printed verification of load cell accuracy ISO and other international quality program rules.

The recommended procedure is:

1. Place the unit into the Program mode.
2. Press *88 for printout of empty bin TARE weight.
3. Place a KNOWN CERTIFIED WEIGHT into the weight bin.
4. Press *88 again for printout with the weight added.
5. The different between the two weight printouts should equal the KNOWN CERTIFIED WEIGHT.



Select Weight Unit

Press (*,8,9) to select the desired weight unit (GRAMS, KILOGRAMS, OUNCES, POUNDS) for readout of data. For the U.S.A. systems are supplied with POUND readout selected. KILOGRAMS are preferred for nearly all countries outside the U.S.A. GRAM or OUNCE readouts are appropriate only for very short runs or short demonstrations. Use the * key to toggle through the four possible selections. Press EXIT when the weight unit you want is displayed, then press **Exit** again to exit out of Programming Mode.



Update Controller Firmware via USB Drive

Press (*,9,3) to initiate a software update from the USB Drive. Pressing *,9,3 will cause the controller to search the USB drive for a folder named **maguire** and 3 files within the folder **maguire** named: **UPDATER3.BIN**, **912WFxxxxx.crc**, and **912WFxxxxx.s28**. If more than one .s28 file exists in the maguire folder, the controller will prompt you to select the version. Press the * key to toggle between versions. Press the CE key to select the version you want to upload. The controller will then verify the file. If verification is successful, the controller will upload the new firmware. DO NOT turn off the controller during this process. Wait until you see **Update Complete!** Then turn off the controller and turn it back on again. The update should take only a few minutes. Updated software is available from Maguire Products free of charge and can be obtained by calling our office or visiting us on the web www.maguire.com.



Update Controller NET Firmware via USB Drive

Press (*,9,4) to initiate a NET specific firmware update from the USB Drive. Pressing *,9,4 will cause the controller to search the USB drive for a folder named **maguire** and 2 files within the folder **maguire** named: **UPDATER.BIN** and **NETxxxxx.BIN**. If more than one .BIN file exists in the maguire folder, the controller will prompt you to select the version. Press the * key to toggle between versions. Press the CE key to select the version you want to upload. The controller will then verify the file. If verification is successful the controller will upload the new software. DO NOT turn off the controller during this process. Wait until you see **Update Complete!** Then turn off the controller and turn it back on again. The update should take only a few minutes. Updated software is available from Maguire Products free of charge and can be obtained by calling our office or visiting us on the web www.maguire.com.



SELECT COMM. SPEED (Set Baud Rate)

Press (*,9,5) to set the baud rate of the COM port. Options are 1200 baud or 2400 baud. Note: The default baud rate is 1200. If the baud rate is set to 2400, the G2-SA (if in use will also have to be set to 2400 baud by installing a jumper pin on an internal board. If you wish to do this, contact Maguire Products and request the document regarding the G2-SA baud rate. Document is also available online: www.maguire.com



USBC Driver Version (12-12 Controllers Only)

Press (*,9,7) to display the USBC Driver version. Press * to update the driver from the Flash drive. Press CE to verify the USB driver.



Display Load Cell Raw Signal (counts)

Press (*,9,8) to set flag for RAW-SIGNAL readout in place of gram readout of scale weight. Power-On will always set this flag to OFF. Use the * key to toggle flag ENABLE or DISABLE.

Press EXIT when done. A raw signal readout is useful to demonstrate the extreme sensitivity of the load cells. The raw signal readout bypasses the calibration math routine. Load cell function can be monitored without concern for any improper weight calibration that may have been done. Second line is an Output Event Monitor.

*** 9 9**

Enable Weight Calibration of the Load Cells

Press (*,9,9) to set flag to enable Weight Calibration of the Load Cells. In later model controllers you can specify WSB CAL or LIW CAL. Power On will always set this flag to OFF. This flag must be ON before the load cell weight calibration keys, ZERO and FULL WT, will function. With ON flag displayed, press EXIT.

*** 0 0**

CLEAR ALL DATA

Press (*,0,0) to CLEAR ALL DATA fields. These are the material usage totals that are viewed with the VIEW key. If you are tracking material usage, you should record these numbers periodically but clearing these totals is entirely optional and not necessary.

After VIEWING the data or printing of data using the VIEW,* key sequence, a display of (00=CLEAR) will appear for 5 seconds. During this 5 seconds you may reset all data fields to zero by pressing 00. Pressing any other key or waiting 5 seconds will exit this sequence without clearing data.

Parameters Introduction

All WEIGH SCALE BLENDER controllers operate according to certain internal PARAMETERS. Because customer requirements vary widely, we have made over 160 parameters accessible for change through the keypad. There is one GENERAL group and twelve COMPONENT groups.

BRIEF explanations are given first.

FULL information is given in the section that follows.



Parameters values shown here are initial ROM values of a model 940. Initial values for other models are listed at the end of this section.

Parameters are five digits, with leading zeros added.

TIMES	TIMES are expressed as seconds, minutes, or interrupts. (244 interrupts = 1 second).
WEIGHTS	are always expressed as GRAMS. 100 and 200 models use tenths of grams: (xxxx.x). (00010 = 1 gram) 400/900/1800/3000 models; full grams: (xxxxx). (00010 = 10 grams)
PERCENTS	are expressed in tenths for settings (0xxx.x), and full percents for other percentage references (00xxx).

Navigating Parameters

In the COMPONENT lists:

The TOP parameter (TYPE) is ALWAYS accessible.

The others are NOT accessible unless TYPE is set onto a setting.

The First press of the PARA key will enter the GENERAL list at the top. Then the first press of the SET key will move to top of the first component list. Press the PARA key to move down in any list.

While in one COMPONENT list, press the SET key to jump to the same relative position in the next list. This allows rapid scanning of like parameters in all component groups.

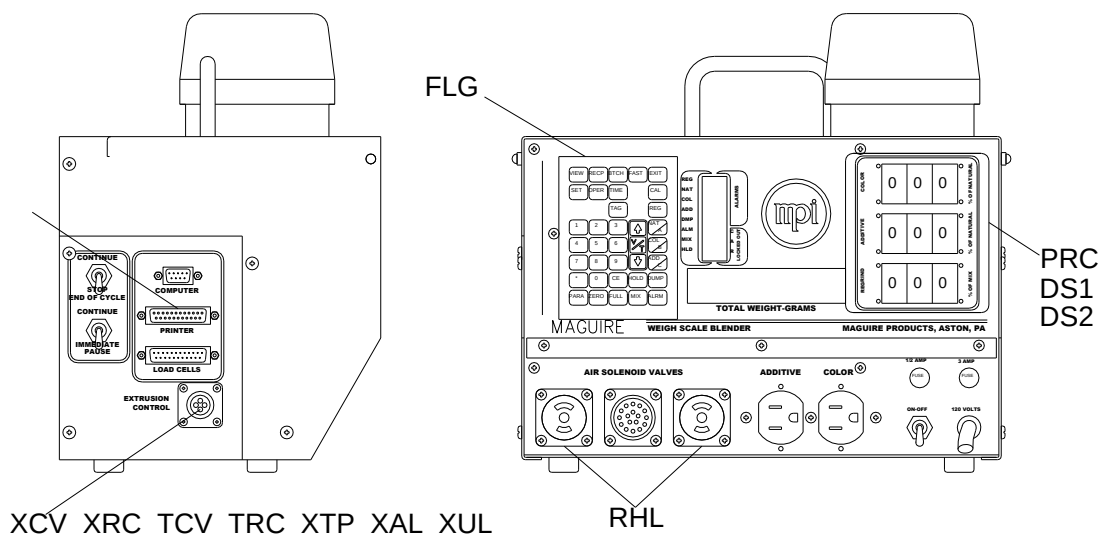
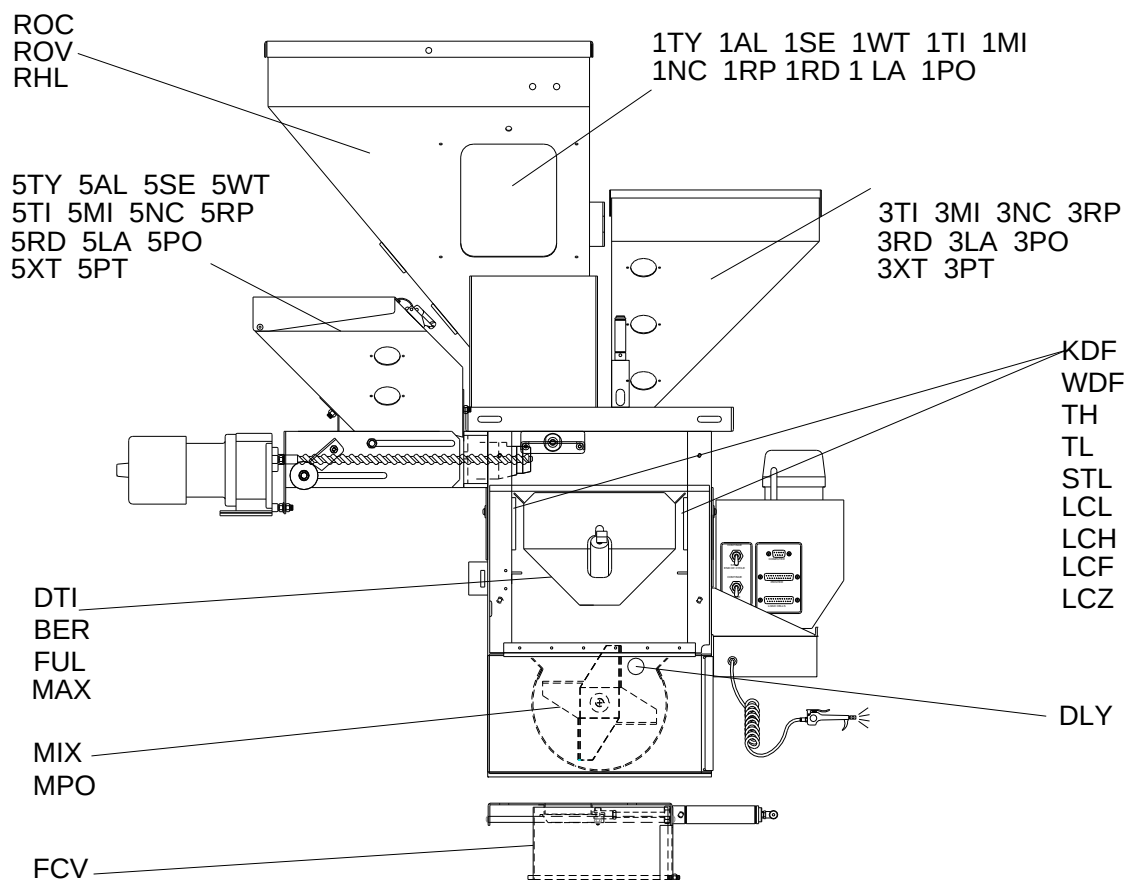
To change a displayed parameter enter a new number in place of the old one. CE will cancel a number entry before the last digit is entered. The purpose of each parameter is explained elsewhere in this manual.

In any component list, if TYPE is set to "OFF"; (_TY= OFF); other parameters in that list are not accessible. EXIT will exit the sequence at any time.

Navigating Parameters Quickly - Keypad Sequence:

Press		To ENTER the list at the TOP LEFT (FLG)
Press		To move DOWN a list
Press		To move UP
Press		To move RIGHT (1st time, goes to 1TY)
Press		To move LEFT
Press		When finished EXIT will take you out of Parameters

Parameters - What they relate to:



Parameters Overview

(20 parameters) (900 series settings shown as example settings)

FLG 00000	FLG is a SET of flags for enabling or disabling the keys: TAG, RECIPE, FAST and BATCH. These four keys will NOT WORK and their associated functions are not available, unless this parameter is set properly. When all digits are set to 0 (FLG 00000), all four functions are OFF. The second digit set to 1 (FLG 01000), will turn the TAG key on. Added information on reports. The third digit set to 1 (FLG 00100), will turn the RECIPE key on. Internally stored recipes (0-99). The fourth digit set to 1 (FLG 00010), will turn the FAST key on. Higher output mode. The fifth digit set to 1 (FLG 00001), will turn the BATCH key on. Dispense Target weight and stop.
RPO 00000 NPO 00000 CPO 00000 APO 00000	Pulsed Output, timing of ON/OFF pulses. (Reg = RPO, Nat = NPO, Col = CPO, Add = APO) Set only for Micro Pulse equipped slide gates.
MPO 00010	Pulsed output to the mixer motor
RAL 00000 NAL 00004 CAL 00004 AAL 00004	Last digit = number of retries before ALARM. 00001 to 00009 = sound alarm, hold process. 00011 to 00019 = sound alarm, continue process. 00000 = no alarm, no retries. These parameters set ALARM functions. When material runs out, or does not dispense fully, these flags instruct the controller what to do. Default settings shown are for Natural, Color, and Additive to alarm, but not Regrind.
MIX 00015	MIXER MOTOR TIME This parameter times how long the MIX motor runs.
JOG 03030	MIXER MOTOR JOGGING, COUNTS and TIME JOG indicates the number of times the blade will jog after initial mixing is ended, plus the time interval between these jogs.
FCV 00006	FLOW CONTROL DELAY - TIME the Flow Control valve delays before opening (Seconds). This parameter holds each batch in the mix chamber for a time to assure mixing. This is only for units equipped with the optional flow control valve under the mix chamber.
FCA 00002	FLOW CONTROL ALARM – If enabled, an uncovered sensor triggers the Flow Control to close for the next batch. If the sensor is not covered in x cycles (2 by default) the FCA alarm is sounded and the process stopped. FCA parameter is for enabling or disabling the Flow Control Alarm.
DTI 00006	WEIGH BIN DUMP TIME at end of cycle. (Seconds) This parameter times how long the weigh bin dump valve opens to empty. No change is required.
KDF 00010 WDF 10010	STABLE WEIGHT - Maximum variation in GRAMS between two consecutive weight STABLE WEIGHT TARE - Readings for reading to be accepted. (x or x.x) KDF controls sensitivity of weight readings during calibration of load cells. No change is required. WDF controls the sensitivity of weight readings during normal operation. If excessive vibration interferes with weight readings you may have to increase this number.
BER 01000	BAIL-OUT THRESHOLD - Excess GRAM weight before dispense is aborted. This parameter controls sensitivity of the emergency "bailout" routine that prevents overfilling of the weigh bin. No change is required.
CXT 00000 AXT 00000	Move decimal left on color and additive settings. These parameters allow entry of less than (00.1) percent for COLOR or ADDITIVE. When set to "00010" settings are read as X.XX percent. When set to "00100" settings are read as .XXX percent.
ROC 00000	REGRIND OVERCOLOR - ROC, ROV, and RHL help control regrind usage. ROC indicates the PERCENT of REGRIND that will be treated as natural when COLOR and ADDITIVE dispenses are calculated. This adds some color or additive to the regrind.

ROV 00000	REGRIND OVERRIDE - ROV is for closed loop fully automatic reprocessing of regrind scrap. This parameter will detect when more regrind is being produced than consumed, and override the current setting to use a higher amount. This helps prevent material backing up in your grinder.
PRN 00000	Percent of Regrind to be Treated as Natural 1st digit: 0 = adds, 1 = subtracts ... additive to or from the regrind. 2nd digit: Regrind component. 3rd digit: 0 = all additives. Entering a number specifies that additive component only. Last 2 digits: Percent of Regrind. 99 = 100. Example: 01030 - 0=add, 1=Regrind in 1, 0=all additives, 30% of regrind as natural. 3rd digit should use 1-9, A, B, C for component numbers.
RAC 000000	Regrind Auto Control This is a Six-digit parameter. 1st digit is the regrind component 2nd and 3rd digits are the cycle count Last 3 digits are the % to increase current setting by. Example: 110100 - Regrind #1, 10 cycles increase setting by 100%. Current setting 25%, increases to 50%.
RLC 00000	Regrind Level Control – works with RHL 1st digit is the regrind component Last digit the % to increase current setting when sensor covered and uncovered. Example: 10005 - Regrind #1 increase 5% each cycle based on RHL setting.
RHL 00000	REGRIND LEVELS – HI/LOW - RHL has effect only if level sensors are added to your unit to detect material level in the regrind hopper. These level sensors can alter regrind percent usage.
FUL 20000 MAX 30000	FULL BIN WEIGHT - determined by weigh bin size. Maximum BIN WEIGHT - weight the software will target (grams). FUL is the target weight that is blended each cycle. Change only for extremely fluffy or very heavy material. MAX prevents overflowing of the weigh bin. It is reset automatically if the FUL parameter is changed.
TH 01000 TL 00500	VALID TARE WEIGHT HIGH - The highest acceptable TARE weights for Blend cycle to start. VALID TARE WEIGHT LOW - The lowest acceptable TARE weights for Blend cycle to start. TL prevents starting with the weigh bin out of place. No change is required. TH prevents starting with a full weigh bin. Change TH only if clumps of material hang up in the weigh bin.
PRT 00000	REPORT INTERVAL - MINUTE interval between automatic print of TOTALS. This parameter will cause your system to PRINT MATERIAL TOTALS automatically. A printer must be connected.
RSE 01000 CSE 01000 ASE 01000 RLO 00050	Upper SETTING limits for thumbwheels (0xxx.x). Settings greater than limit are held to limit. "01000" = 100%. Lower SETTING limit for REGRIND (0xxx.x).
_SE RLO	parameters SET UPPER LIMITS to the thumbwheels. For color and additive, lower settings may help ensure expensive material is not wasted. First digit locks or unlocks the setting thumbwheels. sets a LOW limit of 5 percent to the REGRIND setting.
DLY 00488	CYCLE START DELAY - Delay before cycle start. (Interrupts) This parameter is the time that the sensor must be uncovered before a cycle will begin.
LT1 00000 LT2 00000	Loader #1 time. (seconds) Loader #2 time. These are timers for loaders. Since loader outputs are not yet available, leave them set to zero.
RPT 00000 NPT 00000 CPT 00000 APT 00000	Percent of target to reduce first try dispense. These can increase the accuracy of slow dispense devices ONLY, like augers, and micro pulse valves.
RWT 26000 RTI 00976 NWT 26000 NTI 00976 CWT 10240	WT/TI = the rate that will be used for calculating the next dispense time. WT = the Weight portion of the dispense rate, calculated such that WT/TI equals the average of the last two actual dispense rates.

CTI 31232 AWT 10240 ATI 31232	TI = the TIME portion of the dispense rate. (interrupts) These change AUTOMATICALLY during normal operation. They are Weight and Time portions of the flow rate calibration.
RMI 00001 NMI 00001 CMI 00001 AMI 00001	Minimum valid dump rate GRAMS/sec. (full or tenth grams) Error correction is bypassed when dispense rate is lower. On power up, these are always set to 1. After several consistent cycles, they are reset to 80 percent of actual flow rate. These prevent excessive swings in flow rate calculations if material is running out.
RNC 00050 NNC 00050 CNC 00010 ANC 00010	Allowable GRAM error within which NO correction is made. This is the acceptable error range for each component to prevent hunting. They adjust automatically over an extended time period to match the flow characteristics of each material.
RRP 00010 NRP 00010 CRP 00010 ARP 00010 RRD 00500 NRD 00500 CRD 00050 ARD 00050	PERCENT shortage error that will force a retry. GRAM weight shortage error that will force a retry. Both RP and RD limits must be met before system will advance to the next component. Retries occur until both conditions are met.
RLA 00020 NLA 00020 CLA 00012 ALA 00012	Lag TIME before dumping ACTUALLY starts. (mechanical response time, interrupts) These parameters state the lag time between when a device is signaled and when it actually begins to operate. Change ONLY if you change to non-standard equipment.
PRC 00010	MAX. PERCENTAGE CHANGE - Maximum allowable PERCENT rate change per cycle. This prevents excessive swings in flow rates by the software. Do not change.
STL 00122	DISPENSE SETTLE TIME before a weight reading is taken. The time (interrupts) allowed for material to SETTLE in the weigh bin before a weight is taken. Lengthen only to slow the next cycle start, thereby lowering the pile of material in the mix chamber, and, in some cases, improving mixing.
LCL 00027 LCH 00039 LCF 00079 LCZ 00583	LOAD CELL limits, low slope, high slope, frequency, zero. DO NOT CHANGE except for different weight load cells. The above 4 parameters relate to the characteristics of the LOAD CELLS on your blender. DO NOT CHANGE THEM.
SCR 00000 BCR 00000	Special Customer Request function to be activated. For BAR CODE input equipped blenders. The following parameters are all related to EXTRUSION CONTROL only.
XTP 05050	Extrusion Control - TRIP POINT for a Rate adjustment. As batch timing errors accumulate, this number determines how large the accumulated error must be to force an adjustment.
XCV 00000 XRC 00004	Extrusion Control - Extruder speed Control Voltage. Extrusion Control - Extruder speed Rate of Change.

These two parameters control the voltage output to the extruder speed control, and its rate of change.

TCV 00000
TRC 00004

Extrusion Control - Takeoff speed control voltage.
Extrusion Control - Takeoff speed Rate of Change.

These two parameters control the voltage output to the downstream takeoff speed control, and its rate of change.

XAL 00005

Extrusion Control - Single Adjustment Limit, percent.

XUL 00200

Single rate adjustments are limited to this percentage change.
Extrusion Control - Upper Adjustment Limit, volts

Adjustments beyond this voltage change will sound the alarm.

MCT 00000

Monitor Cycle Time

Alarms if normal cycle timing exceeds previous cycle time by a specified amount. Used to detect mechanical failures.

LIQ 00000

For LIQUID COLOR applications using dual pumps.

Allows automatic switching when current container runs out.

CPL 00000

Yield Control - Counts per unit Length.

Matches your down stream takeoff speed encoder to the software.

PTD 00020

Yield Control - Pulse Train Delta

Allows slight errors in encoder pulse train pulse rate

G2F 00000

Alarm status for G2 communications (offline alarm)

XMO 00000

Maximum Extruder Output

LTP 00005

Loss in Weight Trip Point in percent of Batch

LLF 10000

Loss in Weight Low Level Fill

HLF 40000

Loss in Weight High Level Fill (LLF and HLF are set by *22, LIW Model selection)

SBO 00000

Sensor Blow Off for the purpose of clearing dust and particles from the face of the sensor.

MDI 00000

MLAN Delay Interval (Time in milliseconds)

Parameters – Full Explanations

FLG **Change this to enable the RECIPE, BATCH, FAST, and TAG keys**

FLG is a SET of flags for enabling or disabling the TAG, RECIPE, FAST and BATCH keys. These four keys will NOT WORK and their associated functions are not available, unless this parameter is set properly.

When all digits are set to 0 (FLG 00000), all four functions are OFF.

The second digit set to 1 (FLG 01000), will turn the TAG key on.

The third digit set to 1 (FLG 00100), will turn the RECIPE key on.

The forth digit set to 1 (FLG 00010), will turn the FAST key on.

The fifth digit set to 1 (FLG 00001), will turn the BATCH key on.

The TAG key is useful for entering information that you wish to be "tagged" to all printouts and computer retrievals. Work Order and Operator numbers may be entered and displayed. Any computer loaded recipe number may also be displayed.

The RECIPE key is useful for storing thumbwheel switch settings under a single numbered recipe. Up to 50 may be stored. To enable the RECIPE key, place a 1 in the 3rd position of the parameter.

The FAST key allows the unit to operate in a faster, higher output, mode. Output may be doubled in this way. To enable the FAST key, place a 1 in the 4th position of the parameter.

The BATCH key allows you to signal that you have processed a certain amount of material, or for filling a barrel or gaylord to the top without the need for a level sensor to stop the process. To enable the BATCH key, place a 1 or 2 in the 5th (last) position of the parameter.

Set to one (00001), the unit dispenses until the preset batch amount is reached and then stops and alarms. Set to two (00002), the unit alarms but continues running when the preset amount is reached. See KEYPAD section, for full explanations of these 4 keys.

_PO **For Micro Pulse devices only**

RPO _PO sets the ON and OFF time of the specified device during the time period that the
NPO device is operated. This results in a "pulsed" output. This is used in combination with a
CPO "micro pulse" equipped slide gate. Set to 00000 for normal operation. Set to 00101 for
APO pulsed operation. The first three digits (001xx) controls ON time in tenths of seconds. The
last two digits (xxx01) controls OFF time. Larger numbers produce slower dispense rates
without any increase in accuracy. Smaller numbers may not allow enough time for the
slide to shift fully.

Pulsed Output may also assist in dispensing regrind and some powders when these materials tend to bridge. A parameter of 00501 will produce a 1/2 second open time (5/10 seconds), a long enough time to allow a significant dispense, followed by a 1/10 second close time, just enough to close the gate fully. The rapid gate movement may help in keeping material flowing.

MPO **For Micro Blender air driven reciprocating mixer.**

MPO sets the timing, in tenths of seconds the clockwise and counterclockwise timing of the mix blade. MPO 00010 is 1 second for each direction.

_AL _AL Alarm FLAGS

RAL
NAL
CAL
AAL

When material runs out, or for some other reason material does not dispense fully, these flags will instruct the controller what to do.

The last digit is number of retries before the action.

The next to last digit is the action:

00000 = NO ALARM, NO RETRIES

00001 to 09 = ALARM, Continue retries.

00011 to 19 = ALARM, Stop retries, Continue process.

00021 to 29 = ALARM, Stop retries, Stop process.

00031 to 39 = NO ALARM, Stop retries, Continue process.

00000 = no alarm, no pause in process, no retries. This is the normal alarm configuration for the Regrind dispense.

00001 to 00009 = sound alarm after specified number of retries and continue retries until successful. The process will not continue until the fault condition is corrected. The last digit determines the number of retries before sounding the alarm. This is appropriate for all important components; natural, color, and additive, and sometimes regrind.

00011 to 00019 = sound alarm after specified number of retries but then stop the retries and continue with the remainder of the cycle. The alarm will continue until the fault condition is corrected or until the next cycle begins. The last digit determines the number of retries before sounding the alarm. This would be appropriate if you wish to make several attempts at a dispense, such as regrind, but you wish the process to continue even without the component.

00021 to 00029 = same as 1 to 9, Stop Process, Sound Alarm, but NO more retries. Just sound alarm and wait. Press the RESET button to clear alarm and start the retries again. Appropriate ONLY if you absolutely want operator intervention to occur when material runs low. In other words you do not want any automatic loading or other correction to allow the process to continue.

00031 to 00039 = DO NOT sound alarm. After specified number of retries stop the retries and continue with the remainder of the cycle. The last digit determines the number of retries before continuing with the process. This would be appropriate if you wish to make several attempts at a dispense, such as regrind, but you wish the process to continue without any alarm indication.

Over Dispense Alarm – Grams or Percent - The first three digits of the _AL parameter (xxx00) may be used to STOP and ALARM the blender if an over dispense occurs by a specified number of grams or percent. To specify grams above target to cause an alarm, enter 001 through 499 in the first three digits. To enable percent, entering 5 in the first digit (6-9 invalid in first digit). When percent is enabled, the 2nd and 3rd digits are the percent of weight (01 – 99) above the target to cause an alarm.

Over Dispense grams example: 4AL 06004 will cause the system to STOP and ALARM if the fourth component dispense is 60 grams over target. If target is 300 grams: $300 + 60 = 360$ grams or 60 grams over the target of 300 grams, which will stop and alarm with error: ***ERROR*** Comp 4 Wt Exceeded

Over dispense percent example: 4AL 52004 will cause the system to STOP and ALARM if the fourth component dispense is 20% over target. If target is 300 grams: $300 \times .20 = 60$

grams over target which will stop and alarm with error *****ERROR***** Comp 4 Wt Exceeded.

Reset alarm - Use PAUSE (or POWER OFF) to reset the alarm condition. If a USB drive is connected and *54 enabled, a standard cycle printout will occur.

MIX **Change this to run the mixer for a longer timed period**

MIX indicates the TIME that the mixer will run after the weigh bin dump valve opens. The number is the mix time in seconds. Adequate mixing can be accomplished in a short time. Additional mixing may cause separation and may create a static problem with the material.

The default value is (00015), allowing an initial mix time of 15 seconds. A maximum setting of 29999 is possible, for a mix time of over 8 hours. Setting the mix time to 99 (MIX 00099) will cause the mixer to run 360 seconds (6 minutes).

JOG **JOG indicates the number of times the blade will jog after initial mixing is ended, plus the time interval between these jogs.**

After mix TIME is complete, the mix blade is jogged about 1 turn every 1/2 minute. These jogs serve to level the pile of material in the mix chamber, insuring that the sensor does not remain covered for too long. The first 3 digits (030xx) of the parameter indicate how many jogs will occur. The last two digits (xxx30) indicate the frequency (or interval) in seconds.

The default setting of (03030) produces a jog every 1/2 minute for up to 30 jogs. You may lengthen or shorten these numbers as required. A setting of (29999) produces a jog time of over 8 hours at 99 second intervals. Setting the first three digits to 000 causes the controller to jog forever (no timeout).

FCV **Delays opening and closing of the flow control valve**

FCV controls three different items:

- 1) Digit 1 can reverse the output logic of the computer.
- 2) Digits 2 and 3 set the time delay before closing.
- 3) Digits 4 and 5 set the time delay before opening.

The most important and primary use of FCV is to set the TIME, in seconds, that the flow control valve delays before opening (4th and 5th digits (FCV 000xx). If your unit is equipped with a Flow Control Valve, under the mix chamber, it is programmed to open whenever the sensor is covered. It will close again immediately when the sensor is uncovered. This assures that material has time to mix before dropping into a bin below. When a batch is dropped into the mix chamber the sensor is covered. To prevent unmixed material from dropping immediately out the bottom, the mix valve is delayed for a time to allow mixing to occur first. This parameter controls the time that the Mix Chamber Valve remains closed after a batch has been dropped.

The primary function of the valve is to assure mixing. As such it seems best to keep as high a level as possible in the mix chamber. However, if the chamber gets too full (over the blades), mixing is not as good. To allow the chamber to empty to a lower level after the sensor is uncovered, we can also DELAY the CLOSING of the flow control valve. This is done by using the 2nd and 3rd digits (FCV 0xx00) to specify a delay time. (FCV 00206) delays closing by 2 seconds.

If the first digit is set to a 1 (FCV 10006), the signal output to the air solenoid is reversed. Normally, the computer puts out a voltage to open the valve. With this flag set the computer puts out a voltage to close the valve. For this reverse logic to work correctly, you must reverse the air lines to the flow control valve air cylinder.

Normal power-off position for the valve is closed. Some customers prefer the valve open when all power is off. This option allows this reversed "power off" position. With power on, no difference is apparent.

FCA FLOW CONTROL ALARM

FCA parameter is for enabling or disabling the Flow Control Alarm. Entering a 1 in the first digit enables alarm. If enabled, uncovering of the sensor triggers the Flow Control to close for the next batch. If the Sensor is not covered in 2 cycles, the FCV timing is started (last digit of parameter FCA10002), the alarm is sounded and the process stopped. Pressing the silence alarm button once will silence the alarm. Pressing it a second time will reset the alarm. Default is FCA disabled - FCA00002

DTI Probably no need to ever change this

DTI is the maximum TIME allowed for the weighing bin to dump at the end of the cycle. The software will close the bin earlier if it detects no weight change occurring. This time determines the maximum time that is allowed for the bin to empty. We set this maximum time limit according to the model and batch size.

KDF WDF Typically No change required - Change only if you have an extreme vibration problem

KDF and WDF are the maximum acceptable variation in GRAMS between two consecutive weight readings. One weight reading requires 1 second of time. Two readings are always taken and they must be within KDF grams of each other to be accepted as valid. Readings are taken continuously until two consecutive readings meet the criteria. This prevents a single accidental bump of the scale from causing a grossly inaccurate reading. WDF also allows the first digit to determine how long a reading is taken. A 1 in the first position indicates ½ second per reading. 2 means 1 second, 3 means 1.5 seconds, up to 5 which is 2.5 seconds. The higher this number the slower the blend rate, but the more reliable the readings.

KDF is used for load cell calibration weights, WDF for starting tare weight and component dispense weights.

BER Change only if severe vibration causes problems

BER is the BAILOUT ERROR weight. Dispenses are controlled by very accurate timing. However, as a precaution, the weigh bin is constantly monitored during each dispense. If bin weight is found to exceed target weight during the dispense, then a BAILOUT occurs. This ends the dispense immediately just as if the end of the dispense time period had been reached. This in no way effects the accuracy of the remainder of the cycle. The dispense is checked and retries will occur if required.

A bailout does not occur unless target weight is exceeded by the weight given in the BAILOUT ERROR parameter. This is primarily to prevent vibration from causing a false bailout during very small dispenses. We set this parameter to a default of 00200 (20 grams or 200 grams). If vibration is causing false bailouts, then you may want to set a higher value in this parameter.

If the BER parameter has a 1 in the last position, (BER 00201), then a printout will occur of all cycle data anytime a bailout occurs for any single component. This is helpful if you want to be aware of occurrences where dispenses significantly exceed target. This will be the same information that you see when the PRINT flag is on (*54). A printer must be

connected.

CXT Moves the decimal to the left on color and additive settings.
AXT Change if you want less than 00.1 percent

_XT, is a number that will alter the meanings of the thumbwheel switches for COLOR (CXT) or ADDITIVE (AXT). This number, when set, will be divided into the thumbwheel setting; thereby reducing it's value. The only valid entries are 10 and 100. When set to "00010" the decimal point is moved left one place and the setting is read as X.XX percent. When set to "00100" the decimal point is moved left two places and the setting is read as .XXX percent. This allows closer control where requested dispense is less than 1 percent. When set to "00000", this parameter has no effect.

ROC Allows for adding some ADDITIVE to one of the REGRIND portions (12-12 only)

ROC indicates the PERCENT of one REGRIND that will be treated as natural when ADDITIVE dispenses are calculated. If you feel it is necessary to ADD (or subtract) color or additive to your regrind, this parameter will automatically see that this is accomplished.

The first digit is 0 to add, 1 to subtract. The second digit is the REGRIND component number you will be making this adjustment for. The last 3 digits indicate the percent of this Regrind component to add to, or subtract from, the Naturals when computing Additive dispenses.

EXAMPLE: ROC set to (ROC 01020).

The first 0 means add. The 1 is component 1.

The 20 means take 20 % of component 1 (a Regrind) and ADJUST the total of all NATURAL dispenses upward by this amount. Whatever amount of component 1, Regrind, is added, 20 percent of this amount will be added to the Natural amounts before a color calculation is made.

Regrind dispense = 600 grams, Natural portions = 1400 grams.

At 4 percent, if ROC=00000, Color would be 56 grams.

If ROC=01020; increase Natural by 20 % of 600, (120 grams).

Color is now 4 % of 1520 grams (1400+120), or 61 grams.

In some cases, the addition of pre-colored regrind tends to produce overall better coloring because of an initial more uniform dispersion of pigment. In this case you may want to add LESS color to the Natural portions when Regrind is present. Placing a 1 in the first digit of the ROC parameter (ROC 10000), will cause a portion of this Regrind component to be SUBTRACTED from the Natural portions, instead of added.

EXAMPLE: ROC set to (ROC 11020).

The first 1 means subtract. The second 1 selects component 1.

This means take 20 % of component 1, a Regrind, and reduce the NATURAL portions by this amount. Whatever amount of component 1 is added, 20 percent of this amount will be subtracted from the Natural amounts before a color calculation is made.

Component 1 dispense = 600 grams, Natural portions = 1400 grams.

At 4 percent, if ROC=00000, Color would be 56 grams.

If ROC=11020; reduce Naturals by 20 % of 600, (120 grams).

Color is now 4 % of 1280 grams (1400-120), or 51 grams.

ROV Regrind Control (12-12 Controllers Only)

ROV is a parameter that will allow your unit to AUTOMATICALLY change to a higher REGRIND USAGE in the event that the amount of regrind being produced exceeds the usage rate.

NO LEVEL SENSORS are required for this parameter to work.

The first two digits of the parameter number represent a CYCLE COUNT, the last three digits represent a PERCENT. When EITHER number equals zero, the parameter has no effect.

If your system dispenses the full requested amount of regrind for the number of consecutive cycles specified by the CYCLE count, it automatically jumps by the PERCENTAGE indicated by the last 3 digits.

This parameter is useful if your process is one where a runner is molded, ground up, and loaded back into the regrind hopper immediately and continuously every cycle.

For example: Say your runner represents 20 percent of your shot weight. You set your controller to 25 percent regrind. Under normal conditions your system adds back the 20 percent of scrap that is produced each cycle, only occasionally dispensing up to the maximum 25 percent that the setting calls for. Since supply is limited to 20 percent, you never dispense a full 25 percent more than once or twice in a row.

Now say you start producing all bad parts and the entire shot is being feed into the grinder as scrap. Dispenses will now be a full 25 percent every cycle. The regrind hopper will also begin to fill.

With this parameter set to (ROV 10100) (10 cycles and increase setting by 100 percent), after 10 cycles have occurred at the full 25 percent, the unit will automatically start using regrind at 50 percent.

This prevents your hopper from becoming full. This is critical in fully automated systems that are evacuating the chamber of a grinder continuously and rely on space in the regrind hopper to keep the grinder discharge clear.

As soon as one cycle occurs that does not dispense the new full amount, the system takes this to indicate that the regrind hopper is now empty, and the controls revert back to normal.

PRN Percent of Regrind to be Treated as Natural (4088 Standard only)

1st digit: 0 = adds, 1 = subtracts ... additive to or from the regrind.

2nd digit: Regrind component.

3rd digit: Entering a number specifies that additive component only. 0=all additives.

Last 2 digits: Percent of Regrind. 99 = 100.

Example: 01030 - 0=add, 1=Regrind in 1, 0=all additives, 30% of regrind as natural.

3rd digit should use 1-9, A, B, C for component numbers.

RAC Regrind Auto Control (4088 Standard only)

This is a Six-digit parameter.

1st digit is the regrind component

2nd and 3rd digits are the cycle count

Last 3 digits are the % to increase current setting by.

Example: 110100 - Regrind #1, 10 cycles increase setting by 100%. Current setting 25%, increases to 50%.

RLC Regrind Level Control – works with RHL (4088 Standard only)

1st digit is the regrind component

Last digit the % to increase current setting when sensor covered and uncovered.

Example: 10005 - Regrind #1 increase 5% each cycle based on RHL setting.

RHL Regrind High / Low Level Sensors

LEVEL SENSORS are required for this parameter to work

Use only if you have regrind level sensors fitted

RHL instructs the controller to change the regrind setting of one selected regrind component if optional level sensors in the regrind hopper indicate high or low conditions. The component to be changed is determined by the first digit of the ROV parameter above.

If set to all zeros (RHL 00000), then this parameter is ignored.

ROV alters the way RHL is interpreted.

If the last digit of ROV = 0, (ROV x0000), then RHL numbers indicate NEW settings that are to be run when regrind level is high or low.

If the last digit of ROV = 1 to 9 (ROV x0001) to (ROV x0009), then RHL indicates upper and lower regrind usage limits only, and regrind usage will be adjusted slowly, to these limits, based on the ROV number.

IF ROV equals zero (ROV 10000):

In this (and all) examples, ROV is selecting component 1 as the controlled component. (ROV 10000)

If RHL is set to any value, the first 3 digits of the parameter indicate a new Regrind setting to use when the material level is ABOVE the HIGH level sensor; (sensor is covered). The last 2 digits indicate a new setting to use if material level is BELOW the LOW sensor; (both High and Low sensors are uncovered).

In other words, RHL allows the selection of a percentage that is HIGHER than normal, and a percentage that is LOWER than normal. NORMAL is what you put on the bottom thumbwheel switch.

Sensors are assumed to be covered when NO signal is returned. If a sensor is unplugged from the controller, it is read as "covered".

If you only have ONE SENSOR, it must be used as a HIGH level sensor. The absence of a sensor is read as a covered sensor; so the absence of the high sensor would signal the system to run at the high setting all the time. This would not be acceptable. The absence of the LOW sensor simply prevents the system from ever thinking it is very low. This is acceptable.

With a high level sensor only, the system switches between the NORMAL thumbwheel setting and the HIGH setting indicated by the first 3 digits of the parameter. The last 2 digits have no effect, since a LOW condition is never detected.

Sensors that we supply are wired correctly for this logic. If a "Bindicator" or similar device is used, with a micro-switch dry contact closure signal, then wire to the normally CLOSED contact so that the signal OPENS when regrind covers the bindicator paddle.

The circuit board "pin outs" for each sensor are positive, ground, and signal. If you are wiring using a dry contact closure, only the positive and signal lines are used. When the contact is open, the signal is pulled to ground internally through a resistor.

Example: RHL is set to 90 and 10 percent (RHL 09010).
ROV last digit is set to zero, (ROV 10000).
The "Regrind" thumbwheel switch is set to 25 percent (025).

The Software logic is as follows:

If material level is high, above the high sensor,
the HIGH sensor is COVERED, (returns NO signal);
Regrind runs at the HIGH setting; 90 percent.

If material level is in the middle, between sensors,
the High sensor is NOT covered, (returns a signal),
the LOW sensor IS covered, (returns NO signal),
Regrind runs at the THUMBWHEEL SETTING; 25 percent.

If material level is low, below the low sensor,
BOTH sensors are NOT covered, (both return a signal),
Regrind runs at the LOW setting; 10 percent.

IF ROV equals 1 to 9 (ROV 10001 to ROV 10009):

All the same rules given above apply, except that the thumbwheel switch regrind setting does not jump in one step to a new setting, but, instead, moves slowly to the new setting which acts as a limit. The usage adjustment is made each cycle by the amount specified by the ROV parameter.

Example: RHL is set to 10 and 90 percent (RHL 09010).
ROV last digit is set to 3 (ROV 10003).
The "Regrind" thumbwheel switch is set to 25 percent (025).

The Software logic is as follows:

If material level rises, goes above the high sensor, the HIGH sensor is COVERED, Regrind usage will increase 3 percent each cycle up to a high limit of 90 percent.

If material level is in the middle, between sensors, the HIGH sensor is NOT covered, the LOW sensor IS covered, Regrind usage will change 3 percent each cycle, moving back toward the THUMBWHEEL SETTING of 25 percent.

If material level drops below the low sensor, BOTH sensors are NOT covered, Regrind usage will decrease 3 percent each cycle down to a low limit of 10 percent.

PAR Percent of Additive to add to Regrind (4088 Standard only)

1st digit is the Regrind component.

2nd digit is the Additive component (3 or 4 for component number 3=additive, 4=color).

Last 3 digits are percent in tenths (##.#).

Example 15050: Regrind 1, Additive 5, 5%

FUL Change only for extremely fluffy or heavy material

FUL is the full batch weight in GRAMS set at the factory to 1000, 2000, 4000, 9000, or 18000 grams, depending on model. The criteria for this number is to not exceed the

volume capacity of the weigh bin and to not exceed the load cell capacity. On a 9000 gram system, load cells are rated for 10,000 grams each. Total load capacity is 20,000 grams. The weigh bin, when empty, weighs about 2400 grams, leaving a net capacity of 17,600 grams for weighing material. However, a dispense over 13,000 grams probably would exceed the volume capacity of the bin. We have set the full batch weight to 9000 grams which we considered a conservative full batch weight. Higher batch weights will increase maximum throughput rates.

If your Regrind is very fluffy and you use a lot of it, you may find 9000 grams to be too much volume for the bin. Select a lower total batch weight such as 7000 to ensure that the bin never overflows or fills completely to the dump valve.

DISPENSE STATION CONFIGURATION.

When this controller is used on a dispensing system (Model WSD; not a Weigh Scale Blender) where you may wish to frequently change the dispense weight of each batch, this parameter acts as a flag to allow that mode of operation. When FUL is set to 00001, the controller will read the top thumbwheel switches as the full batch weight, in pounds from 00.1 to 99.9, and will target that weight for the batch. When set to 00002 it will read the switch as kilograms (00.1 to 99.9). **See "MAX", next, for more information.**

MAX Set automatically if FUL parameter is changed

MAX is the maximum gram weight, which the software will allow as a target for dispensing. The initial Full weight target is set by the FUL parameter. As dispenses progress, an over dispense of one component may cause a new target to be calculated for future dispenses in order to maintain proper requested ratios. A recalculated target is not allowed to exceed the value held in the MAX parameter.

If you change the FUL parameter, the MAX parameter will automatically be set to a value 50 percent higher than the FUL setting.

DISPENSE STATION CONFIGURATION.

This controller can be configured to operate as a dispense station (model WSD). This is generally done when exact weights of material or blend are required to place into a process, such as rotational molding. In this configuration, the thumbwheel switches tell the controller how much weight to dispense in pounds (or kilos). The FUL parameter is set to 00001 or 00002 for direct reading of the top thumbwheel switch; or optionally, for recipe reading of the second thumbwheel switch.

When dispense weight you request exceeds the amount specified in the MAX parameter, the unit will automatically make multiple dispenses that will add up to the requested amount.

TH Change only if material sticks in the weigh bin

TL

TH and TL are acceptable error limits for TARE WEIGHT.

Before a dispense cycle begins, the software checks to see that the weigh bin is in place and that it is not already full of material. To do this it looks at the starting TARE weight.

If Tare weight is below the value of TL, (50 grams), the software assumes that the bin is either missing or hung up on something. In this case the ALARM sounds.

If Tare weight is above the value of TH (100 grams), the software assumes material is in the bin. In this case the ALARM sounds and the weight bin dump flap operates to empty the weigh bin.

If you are processing a material that tends to hang up in the corners of the bin, then you may wish to widen the range of acceptable starting tare weight. Since tare weight is always subtracted from dispense weights, these errors do not affect accuracy.

PRT **Change to get AUTOMATIC printing of material totals**
Change to get AUTOMATIC printing of material totals
 PRT, when set to any number other than zero, will cause the processor to output all current material usage totals, at regular time intervals, to the USB port to a file named PRINTER.TXT. The number you enter will dictate the time interval in MINUTES. All timing starts from MIDNIGHT. For example, an entry of 00120 will cause totals to print at 2 AM, 4 AM, 6 AM, etc. Printing always waits until a cycle has just ended. A setting of 10000 is a special case. This will cause a printout after every cycle. A printer must be connected. If one is not, the routine will abort, and blending will continue.

RSE **_SE is the upper SETTING limits for the thumbwheel switches**

CSE
ASE This allows a reasonable cap to be set for each component so that an operator cannot accidentally set the controls to an excessively high setting. For color and additive, these limits will ensure that expensive material is not wasted. Thumbwheel settings that are greater than the limit is held to the limit.

EXAMPLE: If the highest color usage in your plant is 6%, you may enter this upper limit in the parameter table. Since settings are stored as 1/10s of percent (##.#), the parameter would be: CSE 00060

Color thumbwheel settings above 060 will be held to 6 percent.

The operator may still prevent running this component by entering a setting of all ZEROS (00.0). This will override any setting entered by the keypad. If you do not want this override option, enter a 1 as the first digit in the SE parameter. (_SE 1xxxx).

Digital Thumbwheel Lockout – On digital thumbwheel controllers, entering a 1 in the first digit of the _SE parameter will prevent the corresponding thumbwheel setting from being changed using the thumbwheel buttons. This will also require the operator to enter program mode to change the settings.

RLO **RLO is the lower limit for SETTING the regrind thumbwheel switches.**

Settings lower than this number will be held to the low limit. Air operated dump valves are not intended to dispense exceedingly small quantities. We have set RLO at the factory to 5 percent (00050) allowing a minimum dispense of 5% or about 100 grams.

DLY **Consider changing if mixing is a problem**

DLY is the TIME the mix chamber level sensor must be uncovered before a cycle begins. The sensor must be uncovered without interruption for the full specified DELAY time. To prevent false starts from material movement caused by the mix blade, a minimum of 2 seconds (00488) is recommended.

Sometimes throughput is slow enough that each new batch buries the mix blade for a while. When this happens the material on top does not mix well. To reduce this, you can delay the start of a new batch by increasing the DLY parameter. The new batch is delayed and mix chamber level has time to fall before the next batch is added.

LT1 **Loader Timeout #1, Loader Timeout #2**

LT2 LT1 and LT2 (set ONLY if your controller is modified to control a loader)

The LT1 and LT2 parameters are normally set to all zeros, indicating that this feature is not present on your system.

If you have additional outputs on your WSB controller for driving a loading system, then this parameter should be set to some number indicating how many seconds you will attempt to load before sounding the ALARM. A sensor input to the controller tells the loader to load. When the sensor is covered the loader stops. If the sensor is not covered within the specified number of seconds, the strobe light and the beeper are activated and the display flashes (LOADER 1) or (LOADER 2), depending on which one has the problem. The LT1 and LT2 parameters specify this delay time before alarm. All circuit boards have provision for connecting level sensor inputs for 2 loaders. When this loader option is being used, uncovering level sensor 1 will cause pin G (7) of the eight pin Amphenol plug to be energized. This can be used, through a relay, to drive a loader.

RPT **_PT (for augers and micro pulse devices only)****NPT**
CPT
APT

The _PT parameters will cause the first try dispense to be a percentage of the full target weight. For example, with color set to (CPT 00090), the first try will be 90 percent of the full target amount. Retries then occur, but each will target only 50 percent of the remaining requirement. A series of progressively shorter retries should be expected, until the retry parameters are satisfied (RP and RD). The _PT parameter is most effective for slow dispense devices, like augers. When setting _PT, also set the _RP parameter to 00001. This forces retries up to within 1 percent of target, instead of 10, improving accuracy.

RWT **_WT and _TI (adjusted automatically after each cycle)****RTI****NWT**
NTI

The _WT, and _TI parameters are related to the flow rate or dispense rate of each material. These can be changed manually or set AUTOMATICALLY by using the RATE CALIBRATION routine described in the KEYPAD section of the manual. These numbers are automatically corrected as necessary after each cycle.

CWT
CTI

_WT and _TI are WEIGHT and TIME numbers that, taken together, represent the actual flow rate for the specified material (WT/TI).

AWT
ATI

This rate is used to calculate an exact time period to dump the required quantity of material.

Both numbers are adjusted by the computer logic after each cycle as a means of continuously calibrating the dispense times.

This rate correction takes place continuously and the battery-backed RAM maintains the correct rate even when power is turned off.

If, for some reason, you were to set these numbers manually, (for example, if the load cells are damaged and you want to adjust the VOLUMETRIC flow rate), an example of a proper setting would be as follows: For a 1" auger feeder with a 60 RPM motor; this unit dispenses 8 grams per revolution which is 8 grams per second. Since the _WT gram number indicates tenths of grams (model 2xx) and the _TI number indicates interrupts (at 244 per second) then the proper numbers would be:

_WT 00080 and TI 00244.

The computer automatically bumps both numbers up in value by doubling them both until at least one number exceeds 16,000. The ratio (rate) is still the same but error correction

routines work better with higher numbers.

RMI **_MI (set AUTOMATICALLY each time power is turned on.)**

NMI

CMi

AMi

_MI numbers are set to one half the amount of material, in grams or 10ths of grams (model dependent), that can feed in one second based on normal valid dispense rates. A valid rate is considered the normal dispense rate that occurs under normal conditions with equipment functioning properly. When a rate lower than half this actually occurs, it is assumed that an equipment malfunction or loss of material has occurred. Under these circumstances, normal rate correction routines are bypassed.

EXAMPLE: For a 1" auger feeder with a 60 RPM motor drive, the normal metering rate is about 8 grams per revolution or 8 grams per second. Since the _MI number is expressed as tenths of grams, (model 2xx), half of this is expressed as (_MI 00040).

It is safe to use a _MI number that is too low but NOT safe to use a number too high. Error correction routines will not work when this number is too high.

This number is reset to 00001 every time power is turned on. After the system detects 10 good dispenses, (no retries, no bailouts), then the MI parameter is AUTOMATICALLY set to 50 percent of current flow rate. The RATE CALIBRATION routine will also set this parameter. Periodically, during production, if dispenses have occurred in a very uniform manner for an extended period of time, the MI parameter is reset based on these dispenses.

RNC **_NC (changes itself AUTOMATICALLY over time)**

NNC

CNC

ANC

_NC is the allowable GRAM error within which NO flow rate corrections are made by the software. Gram weight errors that are equal to, or less than, this number will be accepted, and no error corrections will take place. Since no equipment is perfect, we must accept that a certain range of error is normal. To make corrections within this range only adds an additional error due to hunting and broadens the error range. This parameter controls and prevents this. This parameter is adjusted automatically by the software according to the actual conditions of the metering.

This number has been set based on our experience with the dispense devices. If, over time, the computer finds that the number is too large or too small, it will automatically adjust it to match the actual conditions that exist with your equipment. These adjustments occur in small increments once every 20 cycles. A change is made only if needed. Checking this number from time to time will indicate the normal error range that is occurring with each dispense device.

If you manually set this number to a very high value, you will effectively eliminate all error correction attempts for the component. Gradually, over several months, the software will adjust this number back down. If you wish to defeat a component's error correction routines permanently, you may set NC to (_NC 29999). The software recognizes this number as special and will not change it. This high setting eliminates error correction attempts for this component. The component is still weighed, and retries still occur if short, but the timing of each dispense is based only on previously learned rates and never adjusted from new experience. A very small dispense in a high vibration environment may actually be more consistently accurate if no adjusting occurs.

RRP **_RP and _RD (probably no need to ever change this)**

NRP

_RD is reset AUTOMATICALLY shortly after POWER ON

CRP These two parameters determine the dispense shortage error that is acceptable for
ARP each component.

RRD RP is the shortage expressed as a PERCENT of the target dispense weight and RD is
NRD the shortage expressed in GRAMS. These parameters are used together, either one will
 force a "retry".

CRD A "retry" is an additional dispense that is calculated to add the amount of material that is
ARD short. This comes into play only when the amount dispensed is less than expected.

Retries will occur until the difference between the required amount and the metered amount is equal to, or less than, the RP percent difference AND the RD weight difference.

These numbers dictate just how close to perfect the dispense has to be before going on. If the dispense overshoots the target, then the process continues. These parameters only control the degree of weight SHORTAGE that is acceptable.

The RP parameter is important when SMALL DISPENSE requests for color or additive are made. Large PERCENT errors are more likely to occur when very small dispenses are requested.

The RD parameter is important when LARGE DISPENSE requests for color or additive are made. Large GRAM weight errors are more likely to occur when very large dispense percentages are being requested.

Depending on the accuracy of the metering device, a certain amount of hunting is to be expected from one dispense to the next. Allowing the software to stop trying when it gets sufficiently close to the target results in more perfect average dispenses. The mix chamber and the barrel of your process machine average out the small errors that occur from cycle to cycle.

If no shortage is ever to be allowed, setting RP to 00000 will prevent any shortage from occurring. This will, however, cause an overall average error on the plus side.

NOTE: Remember that EITHER ONE of the these two parameters will cause retries to occur. BOTH parameter conditions must be met before the process will continue, with one exception: If the ALARM parameter (AL) is set to 00000, indicated that you do not want any retries to occur, then these two RETRY parameters will have no effect. The first dispense will always be accepted and no retries will be made.

The RD parameter is adjusted automatically by the software after every power on, after the blender has been operating smoothly, without retries, for 10 cycles. If you wish to change RD and have it stay changed, then enter a 1 as the first digit in the parameter: (RD 10020). The 1 signals the software to NOT make any automatic adjustments to this parameter.

RLA LA (change if you change metering device)

NLA LA is the lag TIME before dumping actually starts. This lag time is the time it takes for the
CLA dispense system to mechanically respond to the controller's signal to start. Lag time is
ALA automatically added to all dispense times.

Changing the means by which a device is operated such as using a different diameter air cylinder, or a different drive system for an auger feeder may require a change in this parameter.

These parameters represent the number of interrupts (time) that pass before the feeder or dispense system actually begins to dispense. There are 244 interrupts per second. To determine these times, use the TIME dispense function in the Manual mode (KEYPAD instructions).

Following the instructions given in the KEYPAD portion of the manual (TIME key), start with a dispense time of 1 (001). Try successively higher time numbers until some movement is noted in the mechanical device and a minimum amount of material IS dispensed on each try. This is the MINIMUM lag time number; the lowest number that DOES cause some movement and DOES result in a minimum dispense. Add 5 to this time period and use this number as the lag time. Lag times that are too short can cause problems. That is why the MINIMUM lag time determined above should be increased by 5 as a safety factor. Use minimum plus 5.

These numbers are preset at the factory for the equipment we have supplied. When a dispense of only a few grams or a fraction of a gram is required, the _LA number is very important. A lag time number that is too small will result in no dispense at all because of inadequate time for the device to operate. A lag time number that is too big may result in over dispenses when very small amounts are called for. Since too small a number may stall the process, always add 2 to the minimum as a safety. As a further safety, the software automatically doubles the lag time number if a dispense occurs without any weight being detected.

Typical LAG TIMES are: (minimum plus five)
12 - for an AC motor being powered through a relay.
20 - for a 1" air cylinder sliding a dispense valve.
127 - for a MAGUIRE automatic speed controller.

PRC No change required

PRC is the maximum allowable PERCENT rate change per cycle. If a large dispense error occurs, flow rate corrections do not exceed this percent number. This prevents large swings in timing of dispenses and provides for stable dispense rates under difficult conditions. For example, when dispense quantities are very small (one or two grams), overfeeding by several grams is a distinct possibility. This type of error represents a very large percentage error to the controller.

However, a large correction would not be appropriate but, instead, would cause a "hunting" of dispense time that would result in further large errors. This parameter prevents this.

STL No change required

STL is the TIME period allowed to pass after a dispense has occurred, but before a weight reading is taken. This settle time allows falling pellets to reach the bin and also prevents their impact with the bin from adding to the weight reading.

LCL DO NOT CHANGE THESE

LCH
LCF
LCZ

These four parameters are set to match the characteristics of the type of load cells used in your system. DO NOT ALTER THEM. LCL and LCH are the acceptable LOW and HIGH limits of load cell output expressed as raw signal counts per gram of weight. LCF is the lowest acceptable FULL scale load cell output expressed as raw signal counts per second. LCZ is the highest acceptable ZERO scale output. LCF and LCZ values are multiplied by 256 before being used by the software.

XTP Extrusion Control Trip Point (For Extrusion Control Systems only)

The LAST THREE digits of the XTP parameter specify the TRIP POINT when software will make an adjustment to the throughput rate number, which will then cause a change in extruder speed. Speed is held steady until there is significant indication that the throughput rate is incorrect. The software analyzes each batch watching for any meaningful deviation from current controlling rate. These last three digits of this parameter specify the accumulated error, indicated as a percent of full batch weight, required to trip a change. For example, when set to 30 on a 200 series blender, this would indicate a 600 gram total error must accumulate before adjustment, 30 percent of the full batch weight of 2000 grams.

The FIRST TWO digits indicate how many cycles must run without a rate adjustment before the operator is permitted to switch from voltage (manual) control to Throughput (automatic) control. This is a factor during startup only. Larger numbers assure a very accurate rate has been learned. This is preferred if you like the way your extruder is running and do not want any further adjustment unless a real problem is detected. On the other hand, if you know that you want output to be a predetermined value, like 1000 pounds per hour, then switching sooner is better. In this way the operator can enter the rate he desires sooner, and the blender can immediately make any required adjustments required to target in on this rate. Too large a number causes delayed response, too small causes hunting. Larger is safer since you do not want "false" adjustments to occur.

This parameter starts at XTP 50030, 30 percent of full batch weight accumulated error and 5 cycles required without adjustment before your operator can switch to the Throughput mode. A "T" is displayed when the 5 cycle requirement is reached.

XCV Extrusion Control Voltage (For Extrusion Control Systems only)

XCV - "Extruder speed Control Voltage" is used in conjunction with our extrusion control software. This number can range from 0 to 1000 (XCV 00000) to XCV 01000), and determines the voltage output on pin S of the Amphenol connector. Pin R is the neutral or zero reference for this voltage output. The voltage ranges from 0 to 10 volts. 01000 = 10.00 volts. This parameter can be set manually, however it is intended to be controlled by the extrusion control logic or by MLAN communications in conjunction with our extrusion control software. Whenever the software control logic makes a change to this voltage, up or down, the controller display will say (RAMPING) during the time the voltage is being adjusted.

XRC - "Extruder speed Rate of Change", determines the ramp up or ramp down rate of the XCV parameter, above. It can range from 0 to 10 (XRC 00000) to (XRC 00040). Default setting is 00040.

When XCV changes, it does so gradually, making small incremental changes every 10 interrupts, or about 24 incremental changes per second. The XRC parameter determines the maximum value of each incremental change. For example, if XRC is set to 1 then the XCV number will increment by 1 count (0.01 volt) every 10 interrupts, for a rate change of 24 counts (0.24 volt) per second, which will produce a full range change from 0 to 10 volts over about 41 seconds.

TCV TRC **Takeoff Control Voltage** (For Extrusion Control Systems only)

These parameters control a second 0 to 10 volt voltage output on for controlling Takeoff control speed. They operate the same as the XCV and XRC covered above except they move in the opposite direction, higher to reduce weight per foot, lower to increase weight per foot.

XAL **Extrusion Control Adjustment Limit**

XAL limits the degree of change that the software can make in one adjustment cycle. Default setting is 00005, 5 percent. Operator entered rate changes are not limited.

XUL **Extrusion Control - Upper Adjustment Limit**

XUL sets an upper limit to how far the software can adjust the extruder speed (control voltage). If this limit is exceeded, then the adjustment is NOT made, and the ALARM is turned on. Pressing the V/T key switches the control to Voltage Mode. When pressed again, the unit returns to Throughput Mode, and a new Limit is set. Further adjustments may now occur to the new limit.

Default is 00200, 2 volts. The idea is that once control is established, adjustments upward of more than 2 volts indicate conditions that should be attended to, a clogged screen pack for example. You may wish to reduce this number so that operators are warned well in advance of such conditions.

MCT **Monitor Cycle Time – For Throat Mount Applications Only**

This parameter acts as the ultimate fail-safe precaution. When used, it monitors sequential cycle times, and alarms if a cycle time exceeds the previous cycle time by an amount that is not consistent with proper operation. This provides a means to detect mechanical failures such as a sticking valve or weigh bin gate. When set to 00000, this parameter is not active. When set to MCT 02060, an alarm will occur when either a cycle time is double (02xxx) the previous time, or exceeds it by 60 (xx060) seconds. At power-on this alarm is always set off and disabled. Once smooth running is established, the alarm is enabled. Smooth operation is established using the same logic that Extrusion Control uses. If the alarm is activated, the display will say (TIME OUT). Press the alarm silence button to reset the alarm. A new cycle will also reset the alarm. If another alarm is currently active (material not dispensing for example) then this Monitor alarm is ignored or reset.

LIQ **For LIQUID COLOR applications using dual pumps / drums.**

Liquid Color users generally want the current container of color to run completely out before switching to a new container. Switching early requires the transfer of the unused portion to the next container. This feature allows a standby container to be in place and ready, and instructs the blender to switch to the backup container as soon as the first container runs out, as detected by the lack of weight after a dispense. The default setting is LIQ 10007, which directs that component 04 is the normal output, and 07 is the component to switch to. Outputs 04 and 07 must first be prewired to an outlet that is added to the side plate of the controller. Two additional air solenoids are also added to drive liquid pumps that require air for operation.

When conventional pumps are used, two pumps must be present, each connected to a drum of color. Both would have to be plugged into the two outlets on the duplex receptacle on the front of the controller. The parameter would be set to LIQ 00304, which is to say that

the "additive" outlet (output 3) is designated as the back up output for COLOR (which is output 4).

Other arrangements are possible, but require some wiring.

CPL Yield Control - Counts Per Linear unit of measure

Customers using Yield Control require a pulse generator, or shaft encoder, mounted on downstream takeoff equipment to signal the line speed to the blender. In operation the software displays GRAMS per unit length, which may be per foot, per yard, per meter, or whatever. For whichever unit length you select, enter the pulses per unit length in this parameter. In America, a typical shaft encoder delivers 600 or 1200 pulses per foot. Set the parameter to 600 or 1200. Everywhere else you are most likely concerned with meters. The proper setting for this parameter is then the number of pulses per METER that the encoder generates.

PTD Yield Control - Pulse Train Delta, trip point

This allows some error in the pulse train rate. For example, if the pulses are being generated at a rate of 6030 per minute, which is 100.5 per second, and we count pulses every second, then we will count 100 for one second, 101 for the next, then 100, then 101 and so on. This "error" could cause adjustments to occur when no adjustment is warranted. The PTD parameter specifies how many over or under pulses have to accumulate before adjustment occurs. In the above example, if 6030 per minute was what we wanted, but counts came in at 101 per second, then an error of 30 would accumulate in 1 minute. The PTD parameter set to 00030 would cause a correction to occur at this level of error. The default value of this parameter is 00060 (20).

G2F The G2F parameter is used in conjunction with the G2 Software or the Get Totals command. The Get Totals MLAN command can be sent with either a command code of 16 or 17. If Get Totals used command code 16, an internal flag in the controller is set indicating the totals have been collected for this cycle. If the G2F Parameter is on, the blender will stop running cycles and alarm because the flag had not been set, indicating the totals had not been collected for the previous cycle. At that time the "Get Status" MLAN protocol command will return an alarm status of 26.

XMO Maximum Extruder Output

For Extrusion Control, this parameter stores the extruder throughput rate that can be expected when control voltage is set to its maximum output of 10 volts. On start up, before the unit has time to learn the correct voltage/throughput relationship, this parameter is used as a starting point. Having this value allows the customer to switch to Throughput mode right away; no need to wait several cycles. XMO is adjusted and corrected frequently by the software to match your process. The only time it is zero is on the very first start up of the system. XMO is the rate in pounds per hour, or kilos per hour.

LTP Loss In Weight Trip Point

For Extrusion Control, Yield Control, when a Loss In Weight station is part of the system, an adjustment "trip point" must be specified. This is the total accumulated error that is required to cause an adjustment to the learned rate. This is the equivalent to the XTP parameter, which is explained earlier. The last 3 digits are a percentage in tenths (xx.x) of the total batch that is being monitored. If the system is filling the Loss In Weight bin to a total weight of 10,00 grams, for example, and allowing it to drop to 4000 grams, for example, before refilling, then the batch is 6000 grams. If LTP is set to 00010, then this is 1 percent of 6000, or 60 gram trip point. See XTP for more explanation of trip point.

LLF Loss In Weight Low Level Fill

Value in grams that will cause the fill valve on the Loss In Weight system to open and begin to fill. This parameter is set automatically by the *22 LIW Model Selection.

HLF Loss In Weight High Level Fill

Value in grams that will cause the fill valve on the Loss In Weight system to close and stop the fill process. This parameter is set automatically by the *22 LIW Model Selection.

SBO Sensor Blow Off

If SBO is set to a value, the Weigh Scale Blender will pulse the FCV valve by a specified pulse length and specified delay in between pulses for the purpose of clearing dust and particles from the face of the sensor.

1st digit: pulse width in 1/10th of seconds

2nd digit: Not used

3rd digit: Number of pulses in multiples of 10

Last 2 digits: Pulse delay in seconds.

Recommended SBO parameter setting is 10230, which would pulse a 1/10th second for a maximum of 20 times every 30 seconds.

MDI MLAN Delay Interval (milliseconds) (4088 Standard only)

This parameter controls the delay between when an MLAN TCP/IP packet is received and the time the MLAN TCP/IP response packet is sent. This parameter is displayed and stored in milliseconds. Defaults to 0.

PARAMETER DEFAULT SETTINGS - FOUR SOFTWARE

Here is a complete list of the "default" entries for all parameters as they are provided in the original program, and as they will appear after a CLEAR ALL or a model change. The Model 220 list is the ORIGINAL BASE list.

The General list:

	Micro	140	140R	220	240	240R	420	440	440R	940	1840	2400	3000
FLG	0	0	0	0	0	0	0	0	0	0	0	0	0
MIX	15	15	15	15	15	15	15	15	15	30	99	99	99
JOG	3030	3030	3030	3030	3030	3030	3030	3030	3030	3030	3030	3045	3030
FCV	5	5	6	5	5	5	5	5	5	5	5	5	5
FCA	00002	00002	00002	00002	00002	00002	00002	00002	00002	00002	00002	00004	00002
DTI	6	6	6	6	6	6	10	10	10	6	8	8	8
KDF	10	10	10	10	10	10	2	2	2	2	4	4	4
WDF	10010	10010	10010	10010	10010	10010	10002	10002	10002	10002	10004	10020	10020
BER	1000	1000	1000	1000	1000	1000	200	200	200	200	200	200	200
ROC	0	0	0	0	0	0	0	0	0	0	0	0	0
ROV	0	0	0	0	0	0	0	0	0	0	0	0	0
RHL	0	0	0	0	0	0	0	0	0	0	0	0	0
FUL	4000	10000	10000	20000	20000	20000	4000	4000	4000	9000	18000	24000	30000
MAX	6000	15000	15000	30000	30000	30000	6000	6000	6000	13500	27000	36000	45000
TH	1000	1000	1000	1000	1000	1000	200	200	200	1000	1000	1000	1000
TL	500	500	500	500	500	500	100	100	100	500	500	500	500
PRT	0	0	0	0	0	0	0	0	0	0	0	0	0
DLY	732	244	488	488	488	488	488	488	488	488	488	488	488
PRC	10	10	10	10	10	10	10	10	10	10	10	10	10
STL	122	122	122	122	122	122	122	122	122	122	122	488	488
LCL	27	27	27	27	27	27	80	80	80	80	40	10	10
LCH	39	39	39	39	39	39	120	120	120	120	60	30	30
LCF	79	79	79	79	79	79	79	79	79	79	79	79	79
LCZ	583	583	583	583	583	583	583	583	583	583	583	583	583
DS1	0	0	0	0	0	0	0	0	0	0	0	0	0
DS2	0	0	0	0	0	0	0	0	0	0	0	0	0
XCV	0	0	0	0	0	0	0	0	0	0	0	0	0
XRC	40	40	40	40	40	40	40	40	40	40	40	40	40
TCV	0	0	0	0	0	0	0	0	0	0	0	0	0
TRC	40	40	40	40	40	40	40	40	40	40	40	40	40
XTP	5020	5050	5020	5050	5050	5050	5050	5050	5050	5050	5050	5050	5050
MPO	10	10	10	0	0	0	0	0	0	0	0	0	0
SCR	0	0	0	0	0	0	0	0	0	0	0	0	0
XAL	5	5	5	5	5	5	5	5	5	5	5	5	5
XUL	200	200	200	200	200	200	200	200	200	200	200	200	200
BCR	0	0	0	0	0	0	0	0	0	0	0	0	0
CPL	0	0	0	0	0	0	0	0	0	0	0	0	0
PTD	60	60	60	60	60	60	60	60	60	60	60	60	60
MCT	0	0	0	0	0	0	0	0	0	0	0	0	0
DS3	0	0	0	0	0	0	0	0	0	0	0	0	0
LIQ	11011	11011	11011	11011	11011	11011	11011	11011	11011	11011	11011	10007	11011
G2F	0	0	0	0	0	0	0	0	0	0	0	0	0
XMO	0	0	0	0	0	0	0	0	0	0	0	0	0
LTP	5	10	5	10	10	10	10	10	10	10	10	10	5
LLF	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000
HLF	10000	10000	10000	10000	10000	10000	10000	10000	10000	10000	10000	12000	10000
RLO	50	50	50	50	50	50	50	50	50	50	50	50	50
LT1	0	0	0	0	0	0	0	0	0	0	0	0	0
LT2	0	0	0	0	0	0	0	0	0	0	0	0	0
SBO	0	0	0	0	0	0	0	0	0	0	0	0	0
ROA	0	0	0	0	0	0	0	0	0	0	0	0	0

Changing Parameter Settings

To change a **PARAMETER**, the sequence of keystrokes is as follows:

Making Changes to Parameters - Keypad Sequence:

Switch the **STOP END OF CYCLE** switch **DOWN**:

Turn **POWER ON**. Wait 5 seconds, until display says **WAITING**

Press



Display will say: **ENTER PASSWORD**

Press



Display will say: **PROGRAM**
This is the **PROGRAM MODE**

To alter a **PARAMETER**:

Press



Press repeatedly until the parameter you want is displayed.
If you accidentally pass it, use the * key to back up.
With the proper parameter displayed, enter the **NEW** number.
Enter 5 digits; use leading zeros if necessary.
For correct entries, follow specific directions given in the **PARAMETER** section.

Press



Display will say: **PROGRAM**

Press



Display will say: **SAVE USER SETTINGS**
This saves the changes made

Press



Display will say: **PROGRAM** when settings are complete.

Additional information can be found in the **KEYPAD** section.

Saving Parameters in the User Backup Settings

If the changes you have made are PERMANENT, SAVE them in the "User Backup Settings".

Sometimes during normal operation, electrical noise or RF (Radio Frequency) noise will corrupt the processor memory. It may be necessary to do a CLEAR to fix this problem.

A "CLEAR" will clear all data from memory and replace it with information stored in the "User Backup Settings".

So it is a good idea to have an exact copy of User Settings stored in the "User Backup Settings" for just such an emergency.

To copy and SAVE all system parameter information into the "User Backup Settings", the sequence of keystrokes is as follows:

Save Parameters Keypad Sequence:		
Press		Display will say: ENTER PASSWORD
Press	    	Display will say: PROGRAM
Press		Display will say: INSTRUCTION [__]
Press	 	Display will say: SAVE USER SETTINGS
Wait:	when done, Display will say: PROGRAM	
Press		Display will say: WAITING

With this done, all correct Parameters may be restored from EEPROM to RAM at any time by doing a CLEAR.

If software related problems should develop later, RETRIEVE this correct copy of the parameters from the EEPROM. This clears corrupted data from RAM and corrects most software problems.

To Retrieve:

Retrieve Parameters (CLEAR) from User Backup Settings - Keypad Sequence:		
Switch		Power Off to the Controller
Hold		Hold the "CE" Key down
Switch		Power on to the Controller
Release		The "CE" Key
Display will say:	*** CLEAR ***	
If you do not see CLEAR on the display, do it again.		

Communications

The WSB 4088 Standard and WSB 1212 controllers communicates data and commands over two protocols, Modbus TCP and MLAN TCP.

Modbus TCP – Modbus TCP is the primary communication protocol for PLC communication to the Maguire Blenders. Modbus TCP must be enabled at the controller and uses the IP Address to communicate over port 502. For more information on Modbus TCP, see the Maguire Modbus register mapping document. To enable Modbus see *67 on page 54.

MLAN Protocol (Maguire Local Area Network) – MLAN is a protocol consisting of commands that allows two-way communications to the Maguire Weigh Scale Blenders. All Maguire Weigh Scale Blenders dated back to 1992 contain the essential MLAN commands for basic control and data collection while newer Maguire controllers contain additional commands for enhanced control and data collection. The MLAN Protocol was initially intended to provide information for individuals who are writing software for PLCs and needed to communicate with the Maguire Weigh Scale Blender. This legacy protocol is the method used by our G2 Software as well as the OPC (Kepware, Dimension Software and Software Toolbox). The Protocol is available for free and is explained in detail in our MLAN Protocol Manual. MLAN communications use the ID number and IP address to communicate over port 9999. Configuration of the ID number and IP address must be setup in the controller. To set the IP address see *65 on page 54. To set the MLAN ID number see *66 on page 54. See the MLAN Protocol Manual for more information on the MLAN commands. MLAN communications over Ethernet (includes G2, OPC and direct MLAN) use port 9999 to communicate. The 4088 Standard and 1212 controllers also communicate the MLAN protocol over RS-232 and RS-485 for backward compatibility on older MLAN communication networks.

For more information on communication options visit: www.maguire.com



IMPORTANT: If your older 1212 controller (pre-2007 model) has a blue display but the star function *65 responds with "INVALID" then please contact Maguire Products for a main board upgrade.

SECTION 3 - PRINTED OUTPUTS

Monitoring System Accuracy

*54 Diagnostic Cycle Report

The *54 diagnostic cycle report is used to analyze individual cycles and the blender’s overall performance. When the diagnostic cycle report is enabled, the WSB will automatically write cycle diagnostic information after every cycle to a file named PRINTER.TXT located within a folder named “maguire” on a USB flash drive inserted into the USB port on the controller.



NOTE

When saving printout information to a USB drive, the USB drive must contain a folder named maguire (you must first create this folder on a computer). The blender controller will then create the file PRINTER.TXT and write data to that file. If a PRINTER.TXT file already exists, the blender controller will append to that file every time a new print output occurs and will not overwrite existing data within the file.

Turning on *54 Cycle by Cycle Printing - Keypad Sequence:

Press		Display will say: ENTER PASSWORD
Press		Display will say: PROGRAM
Press		Display will say: INSTRUCTION [__]
Press		Display will say: PRINTED REPORTS DISABLED
Press		Display will say: PRINTED REPORTS ENABLED
Press		Display will say: PROGRAM
Press		Display will say: WAITING

*77 - Parameter Printout

When troubleshooting, the Parameter Printout (*77) can also be very useful. The Parameter Printout will write all of the current parameters values to a plain text file on the USB drive.

To Print the PARAMETER Table - Keypad Sequence:

Press		Display will say: ENTER PASSWORD
Press		Display will say: PROGRAM
Press		Display will say: INSTRUCTION [__]
Press		Display will say: PARAMETER REPORT Please Wait ...
Press		Display will say: WAITING

Interpreting the *54 Cycle Printout

10 or 20 cycles of data can tell a lot about the performance of your blender. The following will help you interpret the data.

A single cycle printout looks like this: (dashes ---- added for clarity of spacing)

```

-----
**1 R20.0**  **2 N 100**  **4 C 04.0**  **3 A 00.0**  -----
* 11/10/16 *  *16:17:53 *  RECIPE 0000  **ID# 051**  **WO 00000*  OPR000
FINAL: DISP,%    0.0  0.0  1908.3          77.6  4.06    0.0    .00  2000.1
RATE: GR/TIME  18224   976  19993   488   12973 31232   10240 31232    9.9
1ST DISP, TIME    0.0  0.0  1908.3  469    77.6  1826    0.0    .00    22

```

DEFINITION OF EACH LINE

The **TOP-OF-PAGE** heading:

```

-----
**1R 20.0**  **2 N 100**  **4 C 04.0**  **3 A 00.0**  -----

```

Prints as a heading to each page, or once every 10 cycles. This serves as a heading over four columns of material. Additional lines will print for additional components as necessary, printing only those components turned on. Thumbwheel setting and material type is shown for each. If a thumbwheel setting is changed, a new header line will print.

In this example, component 1 is a REGRIND; component 2, a NATURAL; 3 and 4 are set up as ADDITIVES.

The **CYCLE** heading:

```

* 11/10/16 *  *16:17:53*  RECIPE 0000  **ID# 051**  **WO 00000*  OPR000

```

DATE and TIME this blend cycle was completed. RECIPE, ID, Work Order, and Operator numbers have no bearing on blender operation but aid in identifying this particular blender, and what job was running.

DATA LINE 1:

```

FINAL: DISP,%    0.0  0.0  1908.3          77.6  4.06    0.0    .00  2000.1

```

For each material, each column shows the final dispensed weight of that material and its percentage of the blend.

In this example Natural dispensed 1908.3 grams. Color dispense is 77.6 grams, 4.06 percent of the natural dispense, slightly over the 4 percent requested.

The final number, 2000.1 is the total weight of the blend. It equals the sum of the component dispenses.

DATA LINE 2:

```

RATE: GR/TIME  18224   976  19993   488   12973 31232   10240 31232    9.9

```

These numbers show the RATE of dispense for each material. These are the numbers that the software used to calculate how long to open the slide gate or run an auger, in order to dispense the required amount. This is GRAMS per Interrupts; 1822.4 grams dispensed in 976 interrupts, which is 4 seconds.

The final number, 9.9 grams, is the TARE WEIGHT of the weigh bin displayed just before the cycle began.

DATA LINE 3:

```

1ST DISP, TIME    0.0  0.0  1908.3  469    77.6  1826    0.0    .00    22

```

This shows the first dispense in grams for each material and the timing of that dispense (in interrupts).

If the first dispense weight, (data line 3), matches the final dispense, (data line 1), then no "retries" occurred. In other words, the software accepted the first try. If they do not match, then the first try was short and one or more retries occurred. The second number is the dispense time that the software calculated to be a correct first try for the dispense.

The last number (22) is the CYCLE count, a convenient way to keep pages of data in order, like page numbers.

Optional "**BAILOUT**" line:

232

A 4th data line (not shown in the beginning example) will print if any single dispense goes past its target weight by a certain value, this value set by the BER parameter, normally 200 grams. The example line shown here would indicate component 3 overshoot the target weight after dispensing for only 232 interrupts.

Bailouts are designed to prevent overflows of material when initial software settings, at start up, are entirely inappropriate for the metering device. A larger than normal error correction will occur after a bailout. Bailouts errors at any time other than startup, usually indicate either very poor flowing material, or excessive vibration. When a bailout occurs the dispense stops immediately for a weight reading. Using this information, the cycle then continues normally.

Troubleshooting with the *54 Printout

TOTAL BATCH WEIGHT: (DATA line 1)

Check the TOTAL batch weight, (DATA line 3), to confirm the blender model. 2000 grams indicates 200 series model. 400, 1000, and 2000 gram totals indicate models that use 3 K load cells, which means output information is in 1/10's of grams. 4000, 9000, and 18000 gram totals indicate larger blenders that report information in full grams. Since some numbers in the printout do not include the decimal point, you will want to know if you are reading full grams or tenths of grams.

TARE WEIGHT: (DATA line 2)

In DATA line 2, tare weights should be consistently within a few grams of each other from cycle to cycle. Large variations in the tare weight numbers may indicate excessive vibration, some mechanical interference with the weigh bin, or a faulty circuit board. Tare weights above or below zero are not a problem as long as they are consistently similar from cycle to cycle. When problems are present, tare numbers may vary by up to 50 grams. Variations of 2 or 3 grams are not a problem.

RETRIES: (DATA line 3 and 1, FIRST and FINAL dispense)

When FIRST time dispense, (DATA line 3), does not equal FINAL dispense, (DATA line 1), one or more retries have occurred. Retries are evidence of a problem that will also cause percentage errors.

Retries may indicate possible problems; perhaps the hopper ran out of material, or the flow rate is so erratic that the first dispense was short for no good reason. Parameters _RT and _RP determine what shortage error is necessary to force a retry.

FLOW RATE NUMBERS: (DATA line 2)

Check the RATE numbers, (DATA line 2), to determine each dispense device.

In the example above:

In the component 1 column, 18224 and 976 translates to 1822.4 grams in 4 seconds (244 interrupts = 1 sec). This is 455.6 grams per second, typical for a regrind flowing through 3" round or 2"x3" dispense valves.

In the component 2 column, 19993 and 488 indicate 1999.3 grams in 2 seconds, or 999.6 grams per second flow rate. This is a heavy natural material, not polyethylene. Perhaps Lexan or a glass filled material.

In the component 3 column, 12973 and 31232 indicate 1297.3 grams per 31232 interrupts, or 128 seconds, for a flow rate of 9.99 grams per second. This is a 1" auger feeder, from which we would typically expect about 8 grams per second. More recent auger feeders use faster motors delivering about 16 grams per second.

In the component 4 column, 10240 and 31232 indicate a flow rate of 8 grams per second EXACTLY. Since it is exact, and since these two numbers are, in fact, the "default" settings from when the blender was first installed, we know that "component 4" has never been run on this blender, or at least not since the last "CLEAR ALL" was performed.

DATA line 3 dispense weight of 0.0 for component 4, and the TOP-OF-PAGE heading showing component 4 set to 00.0 percent also confirm that component 4 is not being run.

The following information will help you determine what devices are in place on a blender.

Material Dispense Device:

Approx. Grams

per Second:

½" Auger Feeders, Micro Pulse Valves	0.5 - 02
1" Auger Feeders	06 - 10
Vertical Valves	20 - 40
WSB 100 - Slide Gates	250 - 450
WSB 220, 420 - 3" Round Slide Gates	500 - 900
WSB 240, 260, 440, 460, 940, 960, 1840, 1860 - 2" x 3" Slide Gates	500 - 900
WSB 240, 260, 440, 460, 940, 960, 1840, 1860 - 3" x 6" Slide Gates	3000 - 5000

Regrinds are always lower than naturals. Bulk density will also cause wide variations in flow rates.

ERROR CORRECTIONS: RATE NUMBERS: (DATA line 2)

The RATE numbers are used by the software, each cycle, to calculate material dispense times. They are adjusted every cycle until flow rates stabilize. When a significant error is detected, the software adjusts the RATE numbers.

The GRAM number is adjusted first. The TIME number (interrupts) is changed only if the GRAM number goes below 16,000 or above 32,000 (approximately). In this event both GRAM and TIME numbers are doubled or halved to bring the GRAM number back to between 16,000 and 32,000.

This serves to keep all numbers as large as possible allowing for the most accurate math, but not so large as to overflow the registers.

Only the GRAM number changes from cycle to cycle, except under the conditions noted above.

Check the GRAM number for a series of consecutive cycles. If it remains unchanged, then the dispenses are accurate enough to not trigger error corrections. Another possibility is that the parameters (MI and NC) that determine when error corrections occur are somehow out of range preventing corrections that should be occurring.

The PRC parameter limits adjustments to 10 percent. Do not expect any single GRAM number change larger than 10 percent.

A gradual decrease in the GRAM number indicates a slowing rate, a hopper that is becoming empty for example. A jump in rate (increased GRAM number) occurs when the hopper is refilled.

If Errors are occurring, but the GRAM number is NOT adjusting, check the NC parameter and the MI parameter. These control whether or not error corrections occur. Both are set and adjusted automatically by the software. MI is set after each start up, after 10 cycles have run without retries. MI will be set to indicate 50 percent of normal dispense rate expressed as grams per second.

NC adjusts slowly over extended periods of running. NC indicates, in grams, the upper limit of the error in 60 percent of the dispenses. A high number usually indicates poor flowing material. Vibration or drifting load cells are other possibilities.

DISPENSE TIMING: (DATA line 3)

The second number is the number of interrupts calculated to dispense the material. If these times are consistent but the weight of the first dispense varies, then the material does not flow well, or consistently. Another possibility is excessive vibration or interference with the weigh bin.

Excess vibration, particularly on small dispenses, may cause incorrect weight readings even though the weight dispensed was, in fact, correct.

If the timing number is very small, 10, 20, 30 interrupts, perhaps this is asking too much from a slide valve. Very short times mean you want small amounts, but are using a high rate dispense valve to do the job. An auger, a vertical valve, a horizontal valve with a flow restrictor, or a smaller valve would help to improve accuracy and control.

If the timing number is below 5, you are operating in a range where it is difficult for the blender to perform well.

The LAG time parameter adds time to every dispense. This is to compensate for the time at the beginning of a dispense when the solenoid valve shifts and air pressure builds, before the valve starts to move. LAG times are always set slightly longer than the necessary minimum. If a calculated dispense time is very short, the Lag time that is added, while small, may interfere with accuracy, and cause an over dispense.

PERCENTAGE ERRORS: (DATA line 1)

When looking at errors of percentage of color or additive dispensed, look further.

1. First, look for indications of "retries". Retries are evidence of a problem that will also cause percentage errors.

When FIRST time dispense, (DATA line 3), does not equal FINAL dispense, (DATA line 1), one or more retries have occurred. This means the hopper ran out of material, or the flow rate is so erratic that the first dispense was short for no good reason. Parameters _RT and _RP determine what shortage error is necessary to force a retry.

Inconsistent loading resulting in large variations in hopper material level can cause retries.

Excessive vibration can also cause bad weight readings, which can cause unwarranted retries. If the BAILOUT line is printing occasionally, then vibration is most likely causing this. Increasing the BAILOUT parameter should fix this.

A LAG time set too high may cause retries to overshoot their mark resulting in over dispensing.

2. Second, look at ACTUAL weight dispensed (DATA line 1).

Color, for example, is a percentage of the natural. In the example above, Natural is 1908.3 grams, so color, at 4 percent of Natural, is targeted to be 76.3 grams. In fact, 77.6 were dispensed. The error is 1.3 grams, well within the expected accuracy of a 1" auger feeder.

The actual GRAM error of a dispense is more meaningful than the percentage error. Mechanical devices are not perfect. The most we can expect from them is to operate within a reasonable range of accuracy. This range is better defined by an error expressed in grams, rather than percentage.

3. Third, look at the dispense TIME (DATA line 3).

Very short times (10, 20, 30 interrupts) indicate dispense devices not well matched to the task. Accuracy on a percentage basis, cycle to cycle, will suffer. This may very well be acceptable as long as overall usage percentages are still accurate.

BAILOUT: (line 4)

If bailouts occur, vibration is usually the cause and these bailouts may be causing other problems. Raise the value of the BAL parameter to 200 or 300 grams to reduce or eliminate unnecessary bailouts.

Vibration may also cause throughput rates to suffer due to the added time requiring to obtain acceptable weight readings. Increase the WDF parameter to 2 or 3 grams, (WDF 00003) or (WDF 00030), or more if necessary.

Parameter Settings Printout

Press (*,7,7) to print a copy of all internal parameters. A USB flash drive must be connected and ready. Up to 13 lists will print, a General list and 12 component lists. Only components that are turned "on" will print. Four columns will print, RAM; ROM; 200 and 900 series tables; and EEPROM. Identifying headings print above each column.

Load Cell Calibration - Printout Verification

Press (*,8,8) in Program mode to force a printout of the display on the controller front. DATE, TIME, Machine number, and display will print:

Date:	11/09/93
Time:	17:22:01
Machine number:	002
Display Readout:	P 500.0

This is useful for obtaining printed verification of load cell accuracy for ISO and other international quality program rules.

The recommended procedure is:

1. Place the unit into the Program mode.
2. Press *88 for printout of empty bin TARE weight.
3. Place a KNOWN CERTIFIED WEIGHT into the weight bin.
4. Press *88 again for printout with the weight added.
5. The different between the two weight printouts should equal the KNOWN CERTIFIED WEIGHT.

Special Tests - Printout Verification

Using the *54 flag the following tests can be made:

If you are running these special tests in the MANUAL or PROGRAM mode, a printout will automatically occur after each test provided the PRINT flag (*54) is turned on.

Special tests that produce printouts are TIME or CALIBRATE.

TIME (See KEYPAD, TIME; and PARAMETERS, _LA, for more information)

The TIME function is to determine lag times of different metering devices. It also allows testing of device repeatability. The single line printout looks like this:

TIME	COMP	1	123	2749
key:		component number		
			dispense time (in interrupts; 244 = 1 sec.)	
			weight dispensed	

CALIBRATE (See KEYPAD, CALIBRATE for more information)

The CALIBRATE function allows the controller to rapidly learn the flow rate of the device. It automatically sets the WEIGHT and TIME parameters that determine metering rate, and the MINIMUM RATE parameter. For more information see PARAMETERS, _RA, _TI, and _MI. The single line printout looks like this:

CALIBRATE	COMP	1	732	8795	15	3465
key:		component number				
			dispense time			
			weight dispensed			
			lag time used			
			min rate			

Material Usage Printout

Pressing the VIEW key followed by the * key will cause all material usage totals to be printed. The (*54) flag need not be on. These totals are since the last time printed, and since the last time cleared.

Setting the PRT parameter to a time interval number may periodically, and automatically, print this same information. (See PARAMETER, PRT)

The printout looks like this:

	DATE	TIME			
CURRENT	11/10/01	16:20:23			
LAST	11/10/01	16:10:23			
PRINTED					
LAST	09/10/01	09:00:04			
CLEARED					
	TOTALS:	GRAND	PCT	CURRENT	PCT
CYCLES		11		7	
REG	05.0	2.4	4.8	1.5	5.0
NAT	100	47.4	100.0	28.6	100.0
COL	00.5	.4	.99	.2	.99
ADD	00.5	.4	.94	.2	.91
TOTAL		50.8		30.7	
WEIGH SCALE ID# 120					
TOTALS ARE IN POUNDS					
POUNDS PER HOUR 365.3					

The Totals may be in POUNDS or KILOS depending on your selection of weight unit. See: PROGRAM mode, (*89).

A line is printed for each active component. Each line shows component number, type, setting, grand and current totals.

The GRAND totals will continue to grow until they are intentionally cleared. This is done by the *00 routine, or pressing 00 within 5 seconds after printing these totals.

The CURRENT totals are since the last time totals were printed. The date and times are given for LAST CLEARED and for LAST PRINTED.

The percentages given for "R" types (REGRIND) are percentages of the total mix. Percentages given for "A" types (ADDITIVES) are percentages of all the "N" types added together. Percentages given for "N" types (NATURALS) are each component's percentage of all the "N" types added together.

The POUNDS PER HOUR is calculated using the total material dispensed from the CURRENT column, and the time difference between the CURRENT time and the LAST PRINTED time.

SECTION 4: TROUBLESHOOTING

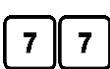
TROUBLESHOOTING - What To Do

This section is for troubleshooting problems. To locate and correct problems, use the following steps as a guide:

1. Start by reading the WIRING CONSIDERATIONS section. Even if the system worked well for a time, dry weather or increased plant electrical noise can cause new problems.
2. Then follow the CHECKOUT procedure in the front of this manual. If anything does not work right, read the diagnostics section that follows it.
3. Read the section on NORMAL OPERATING SEQUENCE to be sure you understand what it is supposed to be doing. If you are still unsure as to how the software logic works, call us.
4. Read the list of TYPICAL PROBLEMS that follows on the next page.
5. Read the section on VERIFYING LOAD CELL function to be sure that the load cells are operating correctly.
6. For difficult problems we can provide the most help if we have a printout of the PARAMETER table (KEYPAD, *77) and 10 or more cycles of cycle-by-cycle printouts (KEYPAD, *54). (See below for printouts)
7. Try rebooting the controller (turn power off/on).
8. Try a CLEAR. Turn power off. Hold the "CE" key down and turn power ON. Display will say (CLEAR).
9. As a last resort, try a factory reset (Clear All). Turn off controller power. Hold down keys VIEW, BATCH and EXIT and turn on controller. The display should show POWER ON RESET.

Warning: A Clear All will reset parameters, settings and totals to factory defaults. Hopper types will need to be reset (see *14) and settings will need to be entered after a Clear All.

To Print the PARAMETER Table - Keypad Sequence:

Press		Display will say: ENTER PASSWORD
Press		Display will say: PROGRAM
Press		Display will say: INSTRUCTION [__]
Press		Display will say: PARAMETER REPORT Please Wait ...
Press		Display will say: PROGRAM

To Print the CYCLE BY CYCLE information during Operation - Keypad Sequence:

Press		Display will say: INSTRUCTION [__]
Press		Display will say: PRINTED REPORTS DISABLED
Press		Display will say: PRINTED REPORTS ENABLED
Press		Display will say: PROGRAM
Press		Display will say: WAITING

Now run the blender normally until you have collated 2 pages of Cycle-by-Cycle printout and then fax this with the PARAMETER Report directly to your local Maguire reseller with a short cover note explaining your process, how the blender is located, if any changes have been made recently and what problems you are experiencing now.

Typical Problems

These problems are based on phone calls that we have received from Weigh Scale Blender users.

1. **The display does not read close to zero when power is turned on, bin empty (plus or minus 10 grams).**
 - The load cells are not plugged in.
 - The weigh bin is not resting properly and freely in its platform or the platform is not resting properly on the bolts that protrude from the load cell enclosures.
 - The controller was never calibrated for these load cells or you just did a CLEAR ALL. In this case it will most likely be off by several hundred grams. See LOAD CELL CALIBRATION.
 - The load cells are damaged. See CHECKING THE LOAD CELLS
2. **The Controller "RESETS" itself for no reason. This indicates electrical noise or voltage spikes disrupting the processor.**
 - See WIRING CONSIDERATIONS, ASSEMBLY section.
3. **The ALARM is flashing and the display shows a weight above 100 or below -50 grams. If above 100, the Weigh bin dump valve keeps opening and closing every 6 or 7 seconds.**
 - There is material in the weigh bin that will not dump out.
 - The dump flap may be stuck.
 - The load cells are hung up or obstructed.
 - The load cells are out of calibration.
 - Incorrect grounding is causing wide load cell readouts.
4. **The VERY FIRST DISPENSE does NOT take place. After a few seconds the ALARM begins to flash. The display says (N x.x) and is flashing.**
 - The air supply is not connected or the pressure is set too low.
 - The Natural solenoid is not connected properly.
 - The 1/2 amp panel front fuse is blown.
 - The NATURAL slide gate is jammed. The cylinder mount may be bent.
5. **The NATURAL dispense valve continues to dump repeatedly even though the weigh bin has filled to overflowing. The weight reading is still below 2000.0 grams.**
 - The weigh bin is not free to move.
 - The load cells are jammed.
 - The load cells are damaged. See CHECKING THE LOAD CELLS
6. **The system operates but always needs MANY RETRIES to complete a dispense and never seems to "learn" the proper dispense rate.**
 - Vibration is causing frequent "bailouts" causing large swings in rate adjustment. Increase the BER parameter.
7. **The THUMBWHEEL SWITCHES do not seem to be controlling output.**
 - Someone has LOCKED IN a setting using the keypad. See KEYPAD, PROGRAM MODE, SETTING.

- The _SE parameter is LIMITING the thumbwheel switch setting. See KEYPAD, PROGRAM MODE, and PARAMETERS, _SE.
- 8. Occasionally, the system gets STUCK doing retries of a component but the retry time is so short that nothing gets dispensed.**
- The LAG TIME parameter is set for too short a time. See KEYPAD, TIME, and PARAMETER, _LA.
 - A valve is sticking closed. Check for free operation when air pressure is removed.
- 9. The system USED TO WORK but now it does unexplainable things.**
- Static or a voltage surge has altered RAM memory. Do a CLEAR or CLEAR ALL. See "CLEAR" RESTART or "CLEAR ALL" RESTART. Then do a LOAD CELL CALIBRATION, and RATE CALIBRATION for ALL materials.
- 10. The Display reads 3100.0 even with the bin empty. This is the upper limit load cell readout.**
- The Load Cells are not plugged in and the circuitry has drifted to the top limit.
 - The Load Cells have been overloaded way beyond their limit and are now permanently deflected.
- 11. Dispenses from a slide gate are not as consistent as they should be.**
- The slide gate is sticking slightly. With the hopper empty, move the slide manually to see that it moves freely. Press up or down on the air cylinder to adjust for proper alignment.
 - The material does not flow very well. A bridge breaker adaptor may be required.
- 12. Load Cell weight readings are not holding steady. They vary as much as 100 grams from second to second.**
- This is static and improper grounding. See WIRING CONSIDERATIONS
 - If readings drift slowly in one direction, requiring frequent recalibration, a component on the circuit board is most likely faulty. Call us.
 - If TARE weights are not steady, something may be physically interfering with free movement of the cells.
- 13. At the end of each cycle the MIX MOTOR runs for a fraction of a second only.**
- The MIX MOTOR pulls a heavy amp load on start up. If the power supply is not adequate (like when using an extension cord), the voltage will drop so low that the computer will reset and the mix motor signal will shut off. The display will show this by restarting as if power was just turned on. Provide a better supply of power; remove extension cord or use larger gage wire.

Alarms - Cause and Solution

Typically, problems are indicated by an alarm condition on the Blender controller's display with an audible alarm and a flashing strobe light. The following alarm troubleshooting chart will describe the alarm condition and possible causes and solutions.

Alarm Display:

Troubleshooting:

COMPONENT ALARM ALARM CODE:01-12 (alarm code denotes hopper / component number)	Problem: Hopper / component out of material. This alarm is triggered by the AL parameter. Solution: Determine reason for material shortage.
BATCH COMPLETE ALARM CODE:13	Alert Alarm: Batch is complete (Batch Mode). The Batch Mode Alarm is enabled under Setup/Blender Configuration/Specialized Alarms/Batch Complete Alarm (ON/OFF)
MAXIMUM WEIGHT ALARM (former: BAILOUT ALARM) ALARM CODE:14	Problem: Maximum Weight Exceeded - Cycle Aborted As the cycle dispensed material into the weigh bin, the calculated weight was projected to exceed the maximum allowable weight in the weigh bin (MAX parameter) and cycle was aborted. The Maximum Weight Alarm is enabled under Setup/Blender. Configuration/Specialized Alarms/Maximum Weight Exceeded Alarm (ON/OFF). Also See: MAX parameter. Solution: This alarm is typically caused by an unexpected increase in material flow, such as valve getting stuck open or a sudden flow increase due to a material blockage opening up. Typically a random Maximum Weight Exceeded Alarm will be corrected by automatic flow rate adjustments however if they are repeating often, this may indicate a problem with a dispense valve.
COMPONENT BAILOUT No alarm, no alarm code	Problem: Component Bailout - Aborted Dispense As the cycle dispensed a specific material into the weigh bin, the weight of that component exceed the target by the amount specified in the BER parameter and the material dispense was abruptly stopped. See: BER parameter. Solution: Bailouts occur because the target weight exceeds the Bailout Weight Limit (BER) parameter. Component bailouts are typically caused by vibration. Increasing the value of the BER parameter (from 200 to 300 grams) may reduce or eliminate unnecessary bailouts.

ZERO TARE ALARM (former: DUMP ALARM) ALARM CODE:15	Problem: Load Cells outside of acceptable Calibration. Weigh bin empty weigh above tare high upper limit (TH parameter) or below tare lower limit (TL parameter). If above TH (upper limit) weigh bin dump valve opens and closes repeatedly. Possible causes: There is material in the weigh bin that will not dump out. The dump flap may be stuck. The load cells are hung up or obstructed. The load cells are out of calibration. Solution: Clear material jam, check dump valve for free movement, Check that weigh bin and load cells are free from contact with door and back of enclosure, verify weigh bin is installed correctly. If weigh bin is empty and weight reading on-screen is above TH parameter or below TL parameter then recalibration load cells. See Load Cell Zero and Full Weight Calibration on page 26.
OVER WEIGHT ALARM ALARM CODE:20	Problem: Over Dispense triggered by Alarm Parameter First three digits of the component specific AL parameter (<u>00000</u>) are used to STOP and ALARM the blender if an over dispense occurs by a specified number of grams or percent. Grams: enter 001 to 499 in the first three digits. Percent: enter the number “5” in the first digit. When percent is enabled, the 2nd and 3rd digits are the percent (01 – 99). In the first digit of the _AL parameter, 6 – 9 are invalid digits. Solution: Determine cause of over dispense.
WAIT FOR RECIPE ALARM ALARM CODE:21	Problem: Recipe Request option did not receive a recipe within the 2-minute timeout period. When enabled the Recipe Request option uses the Recipe Number Tag to request a recipe over communications. If the recipe number is changed to a value between 100 - 65535, the 2-minute Recipe Request timer starts and monitors for a change in the recipe. If a recipe is not received within the timeout period, this alarm sounds. Solution: Check Recipe number, check status of communications.
WEIGHT DROP ALARM ALARM CODE:22	Problem: Weigh Bin losing weight during a cycle. This alarm is triggered by a loss of more than 20, 40, or 80 grams (model dependent) during a dispense cycle. This serves to detect and report a weigh bin problem, such as material leaking from the bottom of the bin. See WDD parameter, Weight Differential Detect. Solution: Examine weigh bin for issues with material retention such as weigh bin flap closure problems, material jam, angel hair causing leak, low air pressure, damage to weigh bin or obstruction to weigh bin closing.

MCT PARAMETER ALARM ALARM CODE:23	Problem: Cycle time exceeds previous cycle time by value set in MCT parameter. The MCT parameter when used, monitors sequential cycle times and alarms if a cycle time exceeds the previous cycle time by an amount that is not consistent with proper operation. See: MCT parameter. Solution: Check material source. MCT parameter alarm may indicate a problem with material loading, blending issues or delays in completing a cycle such as vibration.
ALTERNATE COLOR ALARM ALARM CODE:24	Alert Alarm: Alternate Liquid Color, Component Switch. The Alternate Liquid Color option allows automatic switch over from Liquid Color component 10 to liquid color component 11 when component 10 runs out (switch over continues from 11 to 10 and so on). This alarm is triggered by a switch over of the component configured to switch over liquid color. For more details see Alternate Liquid Color under Operating Options and also the LIQ parameter. Solution: Replace Liquid Color component that has run out.
MIX MOTOR FAILURE ALARM ALARM CODE:25	Problem: Mix Motor Failure Detected. When enabled under Specialized Alarms and used with the Mix Motor Failure Kit (KIT-075T), this alarm will sound when the mix motor fails to move during intended operation. Solution: Check operation of Mix Motor. Check for material jam in mix chamber, check for mix blade obstructions. Clear mix chamber and Mix Motor operation using Manual Operations. Check thermal overload fuse on larger blender (model 900 and higher) or Mix Motor Fuse on Controller.
G2F PARAMETER ALARM ALARM CODE:26	Problem: Totals have not been collected by communications for previous cycle. The G2F parameter is used in conjunction with the Get Totals command. The Get Totals MLAN command can be sent with either a command code of 16 or 17. If Get Totals used command code 16, an internal flag in the controller is set indicating the totals have been collected for this cycle. If the G2F Parameter is on, the blender will stop running cycles and alarm because the flag had not been set, indicating the totals had not been collected for the previous cycle. At that time the "Get Status" MLAN protocol command will return an alarm status of 26. Solution: Check communication status to this blender.
USB RECIPE ALARM ALARM CODE:30	Problem: USB Recipe Command is enabled but Recipe not found on USB drive. When enabled, the USB Recipe Command causes the controller to look for the recipe file located on the USB drive before dispensing the next cycle. If the USB recipe file is not found on the flash drive, this alarm will occur. Solution: Check for the USB drive, check for the recipe file on the USB drive.

REGRIND LESS THAN 100% ALARM CODE:31	Problem: All Regrind Recipe or Percent of Total Recipe settings add up to less than 100%. When Blend Mode of Operation is set to “% of Total Batch” or all component types are set to REGRIND, the settings must add up to 100% (within the range of 99.0% to 100.0%). When the total of all settings is less than 99.0%, this alarm occurs. Solution: Check the current settings.
REGRIND GREATER THAN 100% ALARM CODE:32	Problem: All Regrind Recipe or Percent of Total Recipe settings add up to more than 100%. When Blend Mode of Operation is set to “% of Total Batch” or all component types are set to REGRIND, the settings must add up to 100% (within the range of 99.0% to 100.0%). When the total of all settings is more than 99.0%, this alarm occurs. Solution: Check the current settings.
FLOW CONTROL ALARM ALARM CODE:33	Problem: Flow Control Valve Not closing. When the FLOW CONTROL ALARM is enabled (Mix Chamber Setup), an uncovered level sensor triggers the Flow Control to close for the next batch. If the sensor is not covered in x cycles (2 by default) the FCA alarm is sounded and the process stopped. Solution: Check Flow Control Valve. Check Mix Chamber level and increase cycle count if necessary.
COMPONENT VALVE LEAK DETECTION ALARM CODE:34	Problem: Weigh Bin gaining weight during a cycle. This alarm is triggered by a gain of more than 20, 40, or 80 grams (model dependent) during a dispense cycle, between material dispenses. This serves to detect and report a component valve problem, such as material leaking from a slide gate or valve. See WDD parameter, Weight Differential Detect. Solution: Examine component valves for issues with material retention such as slide gate closure problems, material jam, angel hair causing leak, low air pressure, damage to slide gates or rails or obstruction to slide gate closing.
REMOTE RECIPE LOAD FAILURE ALARM ALARM CODE:35	Problem: The recipe TAG in Modbus was set to a recipe number from 1 to 99 but the recipe does not exist in the internal recipe database. When a recipe number in the range from 1 to 99 is sent to Modbus register 40107, the controller checks for the existence of a recipe with that number in the internal recipe database. If the recipe number exists and the controller is idle, the new recipe is loaded and register 40107 returns the new recipe number. If the recipe number does not exist, an alarm is generated on-screen and Modbus register 40012 returns alarm code 35 = Remote Recipe Load Failure. Solution: Check the internal database and verify that the recipe number exists in the database.

Mix Problems

Customers with mix problems have several options available.

Decrease the batch size by lowering the FUL parameter value. This does two things. First, it causes the components to be dispensed in smaller, more frequent batches, which places more and smaller layers of material into the mix chamber. Second, it lowers the level of material in the mix chamber immediately after a dispense. It is critical to proper mixing that the mix blades reach up through the top of the material in the mix chamber during mix time. Dispensing a large batch may bury these blades, particularly when the process is not running at full blender capacity. A smaller batch size, while reducing throughput rate, will help prevent the mix blades being covered during mix time.

Be sure level sensor is mounted in its lowest position, and increase sensitivity as much as possible. Both serve to keep a batch from being dispensed so early as to cover the mix blades.

On units without flow control valves (FCA), increase the DLY parameter to as number as high as 50 percent of the time between cycles. DLY is the time delay (in interrupts) from the sensor being uncovered until we begin the batch. Increasing DLY allows the mix chamber to empty somewhat before the next batch drops. The maximum possible value for DLY is 29999 or 122 seconds.

You may increase the mix time at the end of each batch by changing the last two digits of the MIX parameter. If throughput is very high it may be better to run the mixer continuously. However, added mix time sometimes causes separation after an initial mixing. Different bulk densities and static electricity both aggravate this potential for separation from excessive mixing.

If a blender is mounted on a stand over a surge hopper, there should be a FCA, automatic flow control valve, fitted to the bottom of the blender. This valve must be plumbed so that it is closed when the level sensor is uncovered. When the sensor is covered the valve opens to release material. The purpose of this valve is to ensure mixing. The FCV parameter delays the opening of this valve for 6 seconds. You can increase this delay time if you feel additional mixing is required before release.

On model WSB-940, be sure the weigh bin has two baffles installed. These ensure horizontal layering (as opposed to side by side layering) of materials prior to dropping into the mix chamber.

Bulk density and pellet shape differences, specifically smooth virgin pellets mixed with square higher density color pellets, can separate when dropped onto a sloping pile, as exists in a hopper, Gaylord, or surge bin. The light round pellets flow like water to the edges, while the heavier square color pellets stay put. This is difficult to correct. It is best not to drop these kinds of blends into large containers.

Vacuum conveying can also separate materials of different bulk densities. Maintain high air velocity to minimize this.

Models WSB-MB, 100 series, and some 200 series units use an air drive for the mix blade, instead of an electric motor. Air drives have these advantages:

- Improved mixing due to back and forth motion of the blades.

- No EMF (Electro Magnetic Force) feedback to the processor from electrical demands of the motor resulting, the results in less processor problems.

- Less electronic parts on the board, parts that are vulnerable to failure from in-plant voltage spikes, from storms and power failures, parts that can represent a percentage of failures over the lifetime of the blender.

- Inherent safety for plant personnel due to the more controlled, more limited torque of an air drive compared to an electric motor drive. A correctly sized electric motor can deliver 10 times the normal design and operating torque when stalled. In spite of interlocks, this presents a potential safety hazard.

If you are having mix problems with air drives, be sure the blades moves a full 270 degrees (3/4 turn) with each sweep. If they do not, try the following:

- Increase the air pressure. If the gauge pressure drops more than 5 pounds during operation of the blades, the air supply line is too small.

- Lower the pile in the mix chamber to reduce torque requirements on the mix blade. This is explained above.

- Increase the MPO parameter from 122 (1/2 second) to 183 (3/4 second) or 244 (1 full second). This allows more time for a full mix blade sweep to occur. You may also want to increase mix time from 10 seconds to 15 or 20 seconds so that, in spite of slower mix blade speed, the same amount of mixing occurs.

Increasing Throughput

A correctly sized blender should have throughput that always exceeds your process requirements. If, for some reason, your blender is not keeping up, here are a few ways to increase throughput.

1. If your blender is equipped with a flow control slide gate, under the blender, this will reduce throughput up to 25 percent. To counter this, set the "END FULL" flag on using the *44 function explained earlier. In the END FULL mode, blending begins even while the sensor is still covered due to flow control valve operation.
2. If your process consumes a large batch of material all at once (such as during injection and screw return time), and material reserve is not adequate, you may "run out" of material for a few seconds while the Weigh Scale blender is making a new batch. The *44, "END FULL" function will also correct this. Here, when the sensor is uncovered, a completed batch is immediately available to help refill the mix chamber, providing a larger reserve to the process.
3. Increase the FUL parameter. This sets the batch size. Larger batches increase throughput. Depending on the bulk density of your material, you may be able to increase batch size by 20 to 40 percent.
4. Reduce the DTI parameter. This is the number of seconds the weigh bin opens to empty each batch. Shorter DTI times will shorten the overall cycle time and increase throughput.
5. Turn "FAST" on. This causes rapid volumetric "timed" dispenses to occur up to 4 times after each normal gravimetric dispense.
6. Do not confuse "reserve" with "throughput". If your blender has a temporary problem which results in your process running out of material before you have time to remedy the problem, your "reserve" is inadequate. Add a surge hopper, or material level alarms on individual hoppers to prevent these types of problems.

Normal Operating Sequence

This section tells you how the system is supposed to work. If your system is not operating correctly, this description may help you spot exactly where the system is failing, providing a clue to the problem.

Turn POWER ON:

The current program version date (V=xxxxxT) is displayed for 1 second, followed by the check sum number (CKS xxxx), followed by a ROM check (ROM OK), followed by a display of (0). The weight in the weight bin is now displayed. It should be 0 plus or minus several grams. During the first few minutes of operation, the displayed weight readings may drift slightly as the circuitry warms up.

BEGIN operation:

The unit will begin to operate if both switches on the left side are UP in the CONTINUE position and the SENSOR in the mix chamber is UNCOVERED. The sensor must be plugged into the right side of the controller. If it is not, this has the same effect as the sensor being covered; the unit will not run.

If the WEIGH BIN DUMP Flap opens and closes repeatedly:

If initial empty bin TARE weight is 100 grams or more, the weigh bin dump valve will operate in an attempt to empty the bin and bring the starting weight closer to zero. If the bin is empty but the weight reading is greater than 100 grams then something is wrong. See TESTING the LOAD CELLS and LOAD CELL CALIBRATION.

If the ALARM flashes:

If the initial TARE weight is below -50 grams the Alarm will flash and the unit will not operate. Go to TESTING of LOAD CELLS and LOAD CELL CALIBRATION.

The DISPENSE sequence begins:

If initial tare weight is within limits, between -50 and +100, the sequence will begin.

DISPLAY during dispenses:

During all dispenses, the component number and Type letter (R,N,A) will be displayed indicating

which component is being dispensed. The INITIAL display is the tare weight of the bin. This will not change during the first dispense. After each dispense, the new total weight of the material in the bin is updated and displayed.

REGRINDS first:

If REGRIND is part of the blend, REGRIND dispenses will occur first in order of size, from the largest to the smallest. The letter "R" will appear in the display. After these dispenses an exact weight is taken to determine the space remaining in the weigh bin for the remaining dispenses. The total bin weight will appear in the display 2 seconds AFTER each dispense has ended.

NATURALS second:

The NATURAL dispenses occur next in the sequence. They will be dispensed in order of size, largest to smallest. The letter "N" will appear in the display. The exact weight of all NATURAL dispensed is now determined for calculating the ADDITIVE dispenses.

ADDITIVES third:

The ADDITIVE dispenses occur last in the sequence. Each dispense must meet requirements set by internal parameters or RETRIES will occur and the sequence will not continue.

MATERIAL RUNS OUT:

If any material runs out or is not enough to meet criteria set by parameters then the process will NOT CONTINUE past this component. RETRIES of this dispense will occur indefinitely until the full dispense occurs or power is turned off. The display will FLASH. The ALARM will sound after 4 retries. This number of retries before alarm is based on the ALARM (_AL) parameters. REGRIND may, or may not, be set to cause an alarm when it runs out. See PARAMETERS, _AL, for how to set the ALARM parameters.

If ALARM flashes:

More than four retries of any single component will cause the strobe light ALARM to begin flashing. The component that is causing the alarm will continue to retry the dispense. The display will blink and the first digit in the display will signify which component is causing the problem. To continue with the dispense sequence, you must satisfy the requirements of the dispense or turn power off.

WEIGH BIN dump:

After all dispenses the weigh bin is emptied by the final dump of the weigh bin into the mixing chamber. The dump valve remains open for four seconds. (DTI parameter)

SENSOR covered:

While the sensor is covered, the dump valve remains open to ensure the weigh bin empties completely. Dispensing stops. The dump valve will remain open for as long as the sensor is covered. This will be until the next cycle begins.

FLOW CONTROL Valve: (optional)

The Flow Control Valve under the mix chamber will stay closed for 6 seconds (FCV parameter) immediately following a dispense into the mix chamber. The rest of the time it opens when the sensor is covered, and closes when the sensor has been uncovered for at least two full seconds (based on DLY parameter).

VERIFYING LOAD CELL FUNCTION

Most Problems are related to LOAD CELL function.

There are several ways to VERIFY that the load cells are functioning properly. The slightest touch on the weigh bin should result in a change in the readout. If this is not the case, something is wrong. When the light touch is removed, the display should return to its starting point. If this does not happen, something is interfering with free movement of the cell or the bin. Make a careful inspection of EVERYTHING around the load cells, the hanger bolts, the weigh bin tray and the weigh bin. NOTHING should interfere with free movement.



NOTE

It is normal for load cell readout to drift several grams over time and with different temperatures. Since all the component dispenses are weighed by a single set of load cells, this drift will affect all components equally and, therefore, the ratio of the components will remain accurate. Empty weight is always TARED so each dispense is accurately measured.

The following observations will verify proper load cell operation:

When the bin is empty, between cycles, the display should read near zero. An error of several grams is not important since this empty weight reading is "tared" from all dispense readings. The "empty weight" readings should be consistently within 1 or 2 grams of each other. The addition of several pellets to the weigh bin should result in a change in the readout. 1 gram is about 40 pellets.

Most load cell problems are caused by interference to the movement of the load cell. The load cell must be free to respond to the weight of a single pellet as well as free to move far enough to record a full 20,000 gram weight deflection. (10,000 grams per cell - 10K cells). If weight readout is very erratic check for damage to the load cell wires. Check for a pinched wire in the connector.

An over stressed load cell will read high. The top limit is (3100.0) for a 200 series or (31000) for a 400 or 900 series. A load cell that was forced or pried upward too far will read (0.0).

We supply and replace load cells in matched sets and we always include the mounting enclosures. You may remove the back plate from the enclosure for visual inspection. It is not safe to remove the load cell itself from the enclosure. To do so may stress the cell itself.

To OPERATE with DAMAGED load cells in a VOLUMETRIC mode, see KEYPAD, *87, Volumetric mode.

To RECALIBRATE the LOAD CELLS, see the HARDWARE MAINTENANCE section.

If you suspect load cell damage or failure, see: LOAD CELL RAW SIGNAL READOUT.

Backup, Restore, Factory Reset

Locations of stored Blender settings and their purpose

There are 3 memory areas where Blender settings are stored:

1. **User Settings** - The current settings in use. When you make parameter changes and/or enable features, the changes (if any) are recorded into the user-settings when you exit PROGRAM mode. When changes are made to User Settings, the changes are stored in EEPROM memory so that they are not lost when the Blender is powered off.
2. **User Backup Settings** – The area in memory where User Settings are backed up into when the ***23** function is used. If User Setting were never backed up using ***23** then Factory default settings reside in this memory location. "User Backup Settings" can be restored into "User Settings" using the ***32** function.
3. **Factory Default Settings** - The area in memory that holds the Blender's factory default settings. The Factory Default Settings are hard-coded default settings for each model. Factory Default Setting can be restored using the ***12** function or by doing a CLEAR ALL.

For information on using ***12**, ***23** and ***32**, see **Star Functions**.

Clear Routine

The **"CLEAR"** routine will copy **"User Backup Settings"** into **"User Settings"**. If **"User Backup Settings"** were not intentionally saved earlier (using ***23**), then the CLEAR routine is essentially restoring Factory Default Settings. The Clear routine is the same as using the ***32** function. All rate calibration numbers that the unit has "learned" at the time of the ***23** will be restored back into RAM.

To execute a "CLEAR", hold down the "CE" key while turning POWER ON. HOLD the CE key until you see RESET on the display, then release the "CE" key. When done correctly, the display will say :

***** CLEAR *****

Retrieve Parameters (CLEAR) from EEPROM - Keypad Sequence:

Switch  Power Off to the Controller

Hold  Hold the "CE" Key down

Switch  Power on to the Controller

Hold the CE key until you see RESET, then

Release  The "CE" Key

Display will say (CLEAR)

If you do not see (CLEAR) on the display, do it again.

CLEAR does not clear EEPROM information but instead loads EEPROM into RAM. Load Cell weight calibration numbers are NOT lost. (To load EEPROM with correct RAM information, see KEYPAD, *23)

Clear All

The "**CLEAR ALL**" routine sets both current "**User Settings**" and "**User Backup Settings**" to the Blender's model-specific default settings (the hard-coded values contained within the software itself). However, a CLEAR ALL will preserve the most important user-defined settings, which are: model selection, stored recipes, passwords and language configuration.

There are only TWO times when you want to do a CLEAR ALL.

1. When new software has been installed. Information may reside in memory locations that do not match the new program. CLEAR ALL fixes this.
2. When all else fails. CLEAR ALL will sometimes fix problems that the simple CLEAR routine misses.

Restart with Default System Settings - the same as the CLEAR, above, but EEPROM information is also cleared.

Clear All - Keypad Sequence:

Switch		Power Off to the Controller
Hold		Hold these keys down simultaneously
Switch		Power on to the Controller

Hold the VIEW, BTCH, EXIT keys until you see RESET on the display, then

Release		Release the keys
---------	--	------------------

When done correctly, the display will say ***** CLEAR ALL *****

If you do not see ***** CLEAR ALL ***** on the display, do it again.

LOAD CELL calibration WILL be lost. You will have to follow the Load Cell calibration procedure given in this manual.

Since parameter table information is lost, you will want to reenter parameters that were previously modified. See BRIEF EXPLANATION of PARAMETERS for a quick review of which ones might have been changed.

Be certain that your unit displays the proper MODEL number when you turn on power. If not, see SELECTING CORRECT MODEL.

Updating Controller Firmware

Updating the firmware within the 12-12 Controller can be accomplished through 2 different methods.

Method 1: USB Drive Update

1. This method uses a standard USB drive. There are 3 files that are required to perform a software update to the 12-12 Controller. These files may be requested from Maguire Products and are labeled:

```
UPDATER.BIN
912WFxxx.crc
912WFxxx.s28
```

When you are provided with these three files, they should be copied to a USB drive and placed in a folder named: **Maguire**

2. Insert the USB drive into the USB port on the 12-12 controller. Note, the controller should be powered on but should not be running cycles.
3. Enter into program mode. Press *22222
4. Press *93. The display should say **Checking Device...**
5. If more than one firmware version is stored on the flash drive, Press * to toggle between firmware versions. If you only have a single copy of firmware stored on the flash drive the controller will default to displaying that version.

Select Version:
WFxxxxx

6. When the firmware to loaded is displayed, press the **CE** key to begin the firmware transfer.

Verifying: [WFxxxxx]

Updating: xxx/726



IMPORTANT!

Do not turn off controller or remove the flash drive while firmware is updating! Doing so may corrupt the controller's firmware.

- When **Update Complete!** is displayed, turn off the controller and turn on again. **Clear All** will display if a version update was applied. The firmware update to the controller is complete.

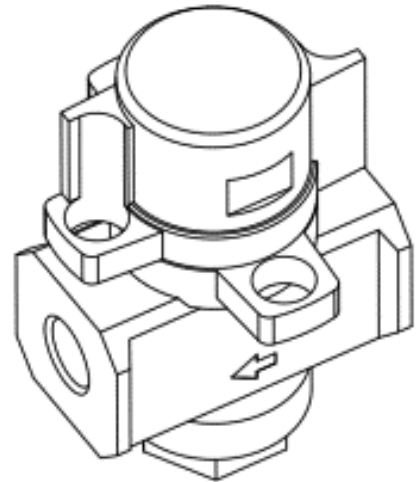
LOTO, Cleaning, Maintenance

Pneumatic and Electrical LOTO

The blender should be pneumatically and electrically locked out prior to any Cleaning/Maintenance/Repair of the blender.

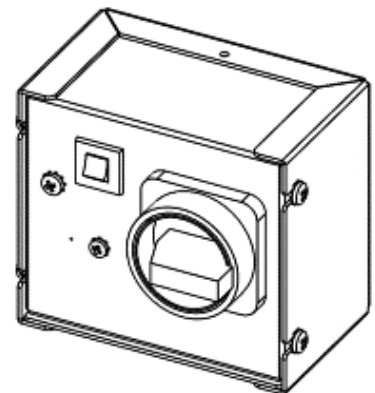
Pneumatic Lockout/Tagout Points

Disconnect compressed air supply before performing Cleaning/Maintenance/Repair. If the weigh scale blender is equipped with a manually operated pneumatic valve actuator, use this lockout/tagout valve to perform a pneumatic lockout/tagout. If the blender is connected directly to an air supply, it must be disconnected from the air supply. After full LOTO has been employed on the blender, there is a possibility that the pneumatic system may still contain stored or residual air pressure, therefore prior to any maintenance, repair or cleaning, Maintenance Engineers must manually dissipate any stored/residual energy from the Pneumatic system, via the Manual Operations screen using the Weigh Bin button.



Electrical Lockout/Tagout Points

Disconnect electric before performing any Cleaning/Maintenance/Repair. If the weigh scale blender is equipped with an electrical LOTO box, use the lockout tagout switch to perform the power lockout/tagout. On 110v blenders, unplug the 110v electric plug from the electric source and use a Plug Lockout to lockout the machine.



Cleaning Procedure with LOTO

1. Material Removal

Cleaning and maintenance procedures may require the evacuation of material from blender prior to LOTO. If material needs to be evacuated, use optional clean-out drain tubes and/or drain chutes to evacuate the material in conjunction with Manual Operations. Material is stored in the following locations: material hoppers including hopper extensions and feeder hoppers, weigh bin, and mix chamber including multi-stage mix chambers.

	Manual Operations – Manual Operations in the touchscreen controller provides manual operation of the valves, augers, weigh bin and mix motor/blades for manual cleanout and testing procedures. To access Manual Operations press: Setup, Blender Configuration, Manual Operations. The device is ON/Open when the button is green. The device is OFF/Closed when the button is red. When a device is disabled, the button is blue. Press the device button to turn ON, press again to turn OFF.
2. Lockout/Tagout	
	Perform a pneumatic and electrical lockout on the blender prior to any Cleaning/Maintenance/Repair of the blender. See Pneumatic and Electrical LOTO on page 108.
3. Open Front Access Door	
	To access the Weigh Bin and Mix Chamber, open the draw latches and open the front door. Some models have a two-stage front door for accessing the upper Weigh Bin area and a lower door to access the Mix Chamber. Inspect and clean the door, hinge and Safety Interlock Switch. Note: On the Micro Blender, the Mix Blade is attached to the Door and removes as one assembly.
4. Remove the Weigh Bin	
	Disconnect the Weigh Bin air line and lift the Weigh Bin off of the weigh bin hangers and out of the blender. Inspect and clean. Also see maintenance, next section.
5. Remove the Mix Blades and Mix Chamber	
	Micro Blender - Mix Blade is attached to the Door and removes as one assembly. 900, 1200, 1800 – Mix Blade and Mix Chamber removes as one unit. 2400, 3000 – Mix Blades are non-removeable. Inspect and Clean Mix Blades and Mix Chamber.
6. Clean Blender Interior	
	Using a vacuum and/or external supplied air nozzle, inspect and clean: slide gates (located above the load cells), weigh bin hangers, load cell assemblies, mix chamber, and access door and door hinges. Inspect all moving and non-moving parts for wear or damage. Clean and inspect slide gate rails for wear and free movement. Clean and inspect weigh bin hangers and load cell assemblies for damage or wear.
7. Reassembly	
	Re-install the Mix Chamber first (if removed), then reinstall the Mix Blades, followed by the Weigh Bin. When installing the Weigh Bin use caution to ensure the Weigh Bin is hanging properly on the Load Cell hangers and does come in contact with the sides of the blender or guards. Connect the Weigh Bin air line and ensure the air line does not interfere with the weigh bin. Close the access door and re-connect the draw latches.

Maintenance and Preventative Maintenance

Blender Maintenance Schedule

Check:	Frequency	Action Summary – See below for more information
Air Pressure	Weekly	Verify pressure is at recommended setting.
Coalescing Filter	Weekly	Verify air is clean, empty moisture trap.
Load Cells	3 months	Perform a Zero and Full Weight Calibration.
Valve operation	3 months	Inspect for wear and loose components.
Weigh Bin	3 months	Inspect for wear, loose components and weigh bin dump valve operation.
Mix Chamber	3 months	Inspect Blades.
Pneumatic Tubing	3 months	Inspect for kinks and leaks.
Sensor adjustment	3 months	Inspect and adjust if necessary.
Cleanout of valves	3 months	As needed, remove angle hair, debris, etc.
Solenoid Bank	3 months	Check using Manual Operations. Replace when necessary.
Slide Valves	3 months	Check using Manual Operations. Replace when necessary.
Air Cylinders	3 months	Check using Manual Operations. Replace when necessary.

Air Pressure Recommendations:

Approximately 5.5 bar (80 psi) is recommended for most models. 4.1 bar (60 psi) is recommended for: Micro Blender, 140R, 240R and 440R. The coalescing filter is a final attempt to dry the air to protect the valves and solenoids from moisture contamination. Check for correct air pressure, tight fittings, and no damaged or crimped air lines.



NOTE: Micro Blenders should be set to 4.1 bar (60 psi). The Vertical Valves used in removable hoppers on Micro Blenders are more accurate at the lower 4.1 bar (60 psi) pressure setting.



Do NOT use lubricated air. Lubricated air can cause air cylinders and air solenoids to stick, jam or malfunction. Air provided to the blender should be clean and dry.

Level Sensor Adjustments

Adjusting the mounting location:

- On models Micro Blender and 100 Series, the level sensor should protrude into the mix chamber about 1/4 inch past the inside Mix Chamber surface.
- On models 200 and 400 series, the sensor should mount flush to the sensor mount and the inside surface of the Mix Chamber.
- On blender model 900, 1800, 2400 and 3000 series, the sensor is mounted to an external sensor mounting bracket. Adjust the sensor distance from the sight glass within a few millimeters to touching the window.

Adjusting sensor sensitivity:

1. The adjustment screw is located at the rear of the sensor and is a ten-turn pot. You will need a small regular flathead screwdriver to adjust the sensor.
2. Turn the adjustment screw clockwise until the LED turns ON.
3. Turn the adjustment screw counterclockwise until the LED turns OFF.
4. Continue turning for one full revolution after the LED turns off.
5. When material is present in front of the sensor, the LED should turn on.
6. Additional adjustments may be necessary to adjust for material dust.

Weigh Bin Dump Valve	
	The weigh bin dump valve should be adjusted to close softly. A needle valve is installed on or behind the solenoid bank or located on the weigh bin air cylinder. Adjust for a soft close. Hard closure of the weigh bin dump valve over time can cause damage to the weigh bin. Check for wear at the hinge points. The Dump Flap should overlap the forward edge enough to prevent dribble when closed, even when closed against pellets. Space at the rear of the flap should allow for static charged build-up of pellets on the rear edge of the dump flap without interfering with the closing of the flap.
Weigh Bin Clearances – Free Movement of Weigh Bin	
	Carefully examine all the parts of the weigh bin and the bin hanging bracket to be sure that the weigh bin or weigh bin hanging bracket does not come in contact with windows or guards. Free space should exist on all sides of the weigh bin. A light press down of the weigh bin should show a change in the weight readout. Remove the touch and the display should return to exactly the weight reading, +/- 1 gram. If any interference with the weigh bin or weigh bin hanging bracket is detected, it must be corrected for accurate operation.
Slide Valves	
	Slide valves must open and close freely, quickly, and completely to maintain accuracy. Check using Manual Operations. If slide valves jam slightly or do not move freely, performance will be affected. Test movement during LOTO without air pressure. Check for wear on the slide valve guide rods. Check cylinder clevis adjustment for correct closing of the valve. A valve should close just enough to block the hole, but no further. Check that the clevis pin connecting the air cylinder for wear.
Mix Chamber	
	Inspect Mix Blades for damage or wear. Over time, blades can wear and become sharp. Replace damaged, worn or sharp mix blades.
Load Cell Zero and Full Weight Calibration	
	Loadcells should be routinely inspected and calibrated. For information on ZERO and FULL weight calibration, see Load Cell Zero and Full Weight Calibration on page 26.

17 pin Amphenol connector Pin assignments

This table describes the pin assignment to device of the 17 pin Amphenol connector with factory wire color assignment.



17 pin Amphenol connector

This pin goes to the outside world through this connector: 17 pin Amphenol connector	to drive this external device:	wire color
pin A	weigh bin dump air solenoid	brown
pin B	component 1 air solenoid	orange
pin C	component 2 air solenoid	blue
pin D	component 3 air solenoid	gray
pin E	component 4 air solenoid	purple
pin M	flow control air solenoid	yellow
pin F	component 7 air solenoid	red
comp. 5		
comp. 6		
strobe and beeper + opt. alarm relay output		
mix motor outlet, panel side		
pin G	comp. 8 - external SS relay	wt./red
pin H	comp. 9 - external SS relay	wt./yellow
pin J	comp. 10 - external SS relay	wt./green
pin K	comp. 11 - external SS relay	wt./blue
pin L	alarm	
pin N	common line, all outputs	white
pin P	comp. 12 - ext. relay (also air drive mixer)	
pin R	neutral to 10 volt signals (S,T)	
pin S	0-10 volt extruder control signal	
pin T	0-10 volt line speed control signal	

External SS relays are optional.

External SS relays and air solenoids may be exchanged.

MODEL WST - WEIGH SCALE TOTALIZER

THESE INSTRUCTIONS FOR "TOTALIZERS" ONLY

Maguire Weigh Scale Totalizers track the exact weight of material that passes through the unit.

They operate exactly like Weigh Scale Blenders except that typically only one component is dispensed. Because of this difference, Totalizers are mechanically much simpler than blenders. The differences are the single compartment material hopper and the elimination of the mixing chamber.

Totalizers use the same software as blenders. This manual is correct for the software provided in a Totalizer. However, since there is only one component, totalizers are very simple to operate. All thumbwheel switches should always be set to zero. In this way only Natural component is dispensed (from the Totalizers single hopper). Natural does not require a setting. With all other component settings on zero, Natural is dispensed as 100 percent of the "batch".

Remember: For TOTALIZERS, as you read this manual, ignore all reference to Regrind, Color, and Additive. You are concerned with the NATURAL component only. Also ignore references to the mix chamber.

Enabling Totalizer Display Function

Totalizers will leave the factory with *47 enabled. When *47 is set, the display will continuously display the total amount of material that has passed through the unit since the total fields were last cleared.

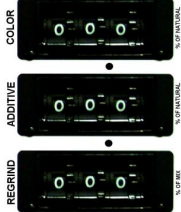
If *47 is not enabled, use this sequence of keystrokes to enable Totalizer Display Function:

Press		Display will say: ENTER PASSWORD
Press		Display will say: PROGRAM
Press		Display will say: TOTALIZER DISABLED
Press		Display will say: TOTALIZER ENABLED
Press		Display will say: PROGRAM
Press		Display will say: TOTALIZER

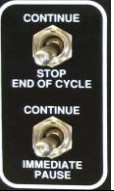


CALIBRATION: To perform a Zero and Full Weight Calibration, disable *47. When calibration routine is finished, Enabled *47 to return to Totalizer Mode.

Basic Totalizer Operation - Startup, Shutdown, Recording Totals

With Power OFF, toggle the PAUSE and STOP switches to the OFF position (down position).	 Power OFF	 Pause and Stop switches DOWN
Turn the WST controller's power ON.	 Power ON	
Leave all thumbwheel switches on zero. If any thumbwheel switch is not set to zero, do so now.	 Digital Thumbwheels	 Mechanical Thumbwheels

To start the Totalizer, toggle the PAUSE and STOP switches to ON (up position).	
---	--

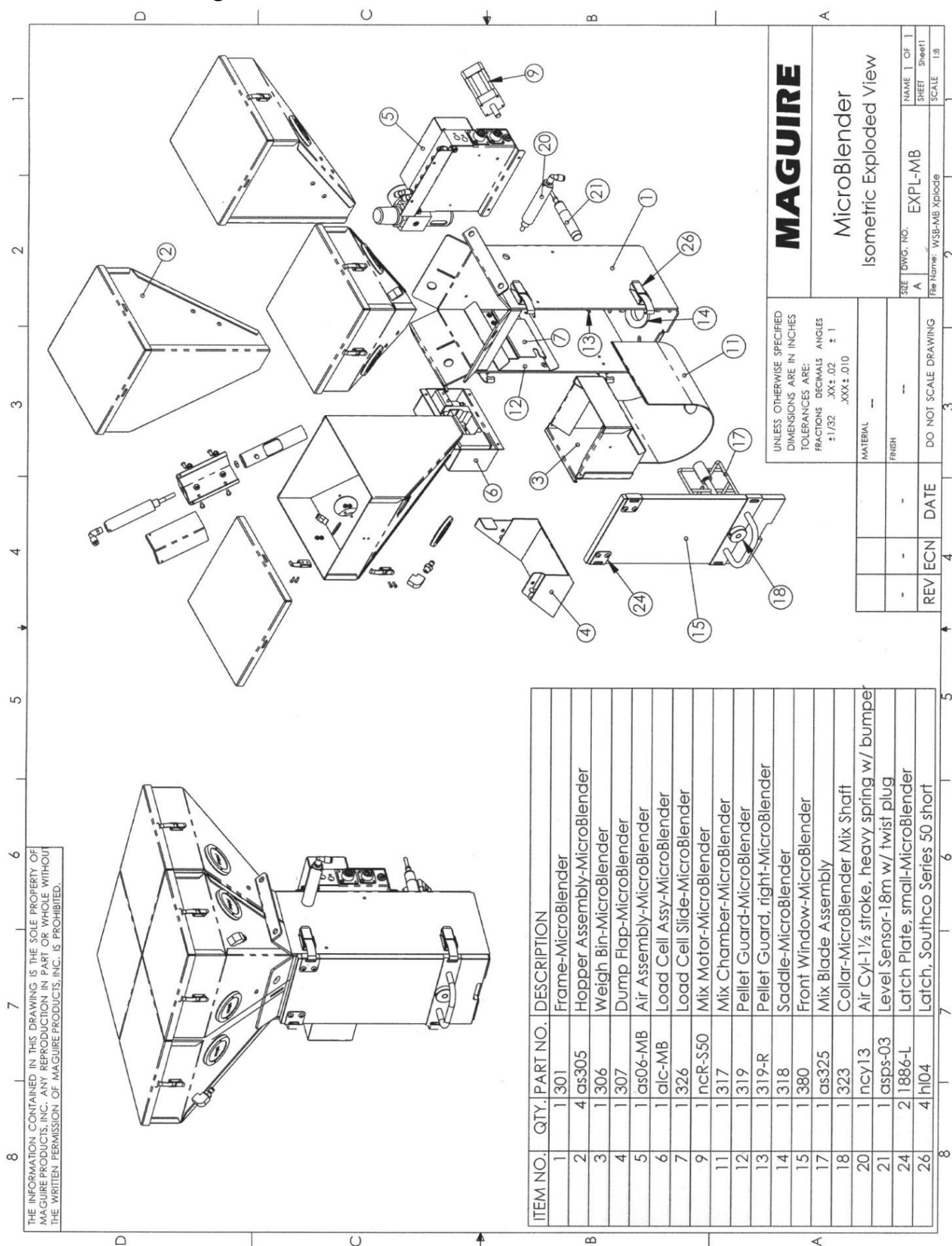
Shutdown To Stop the Totalizer toggle the PAUSE, and STOP switches down.	
--	---

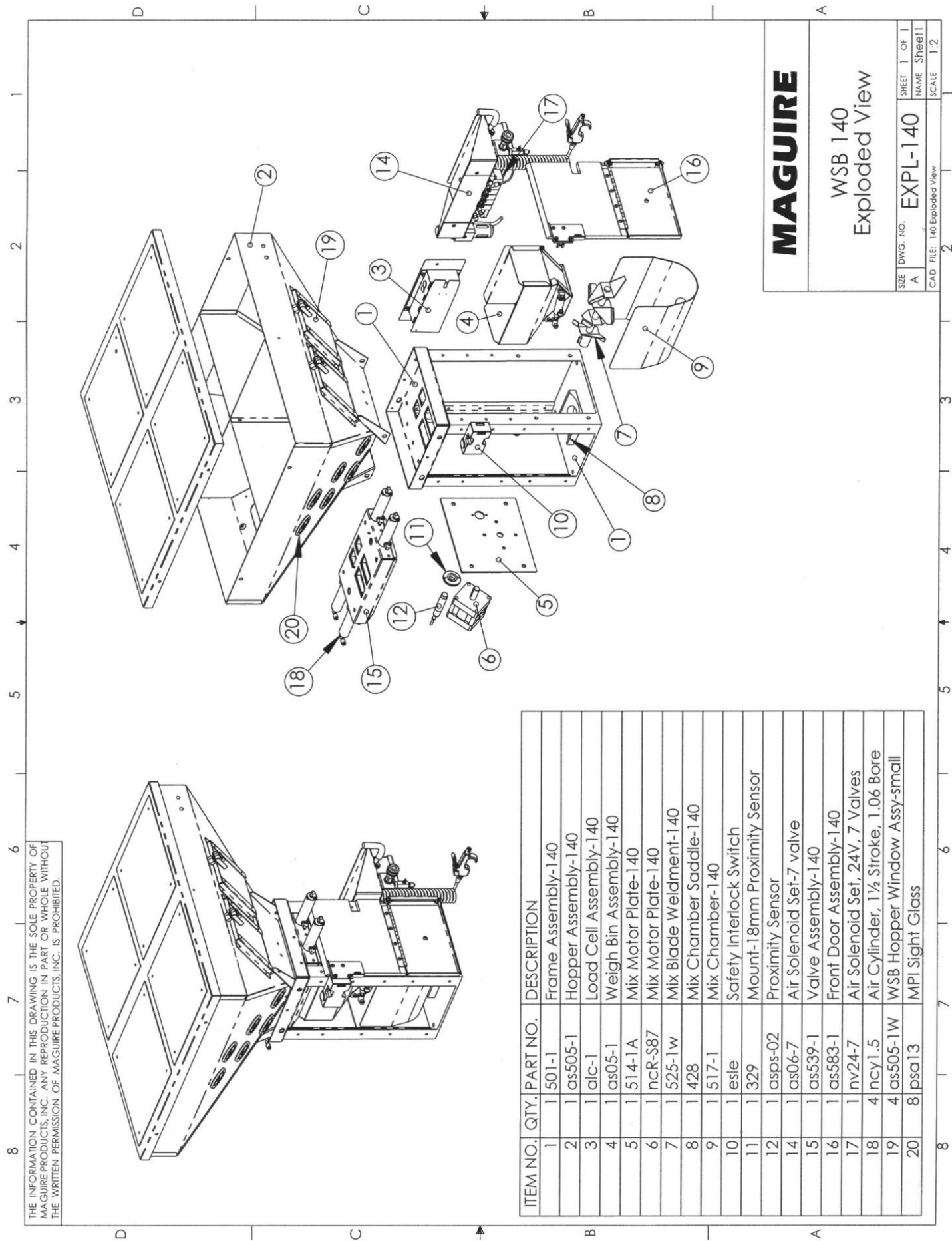
As material is dispensed and weighed, totals will accumulate on the controller display. You may retrieve these totals at any time by:

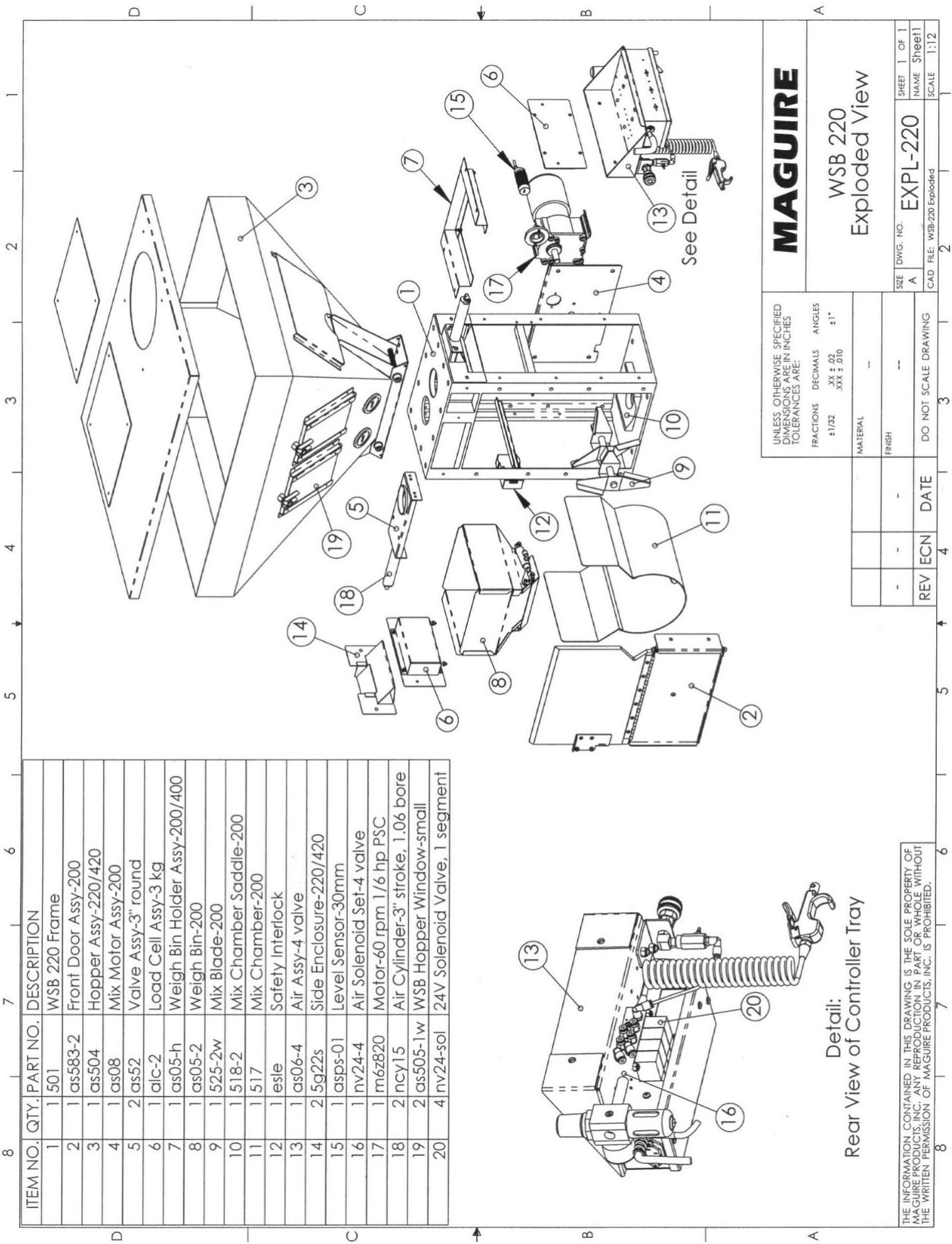
1. using the VIEW key for direct read out on the display,
2. using a USB flash drive for a printed record.
3. Use a USB thumb drive to record a digital printout to a USB drive.
4. using our MLAN Protocol or G2 Software to port all information to a computer,
5. set unit to continuously display the accumulated total (see next page to enable).

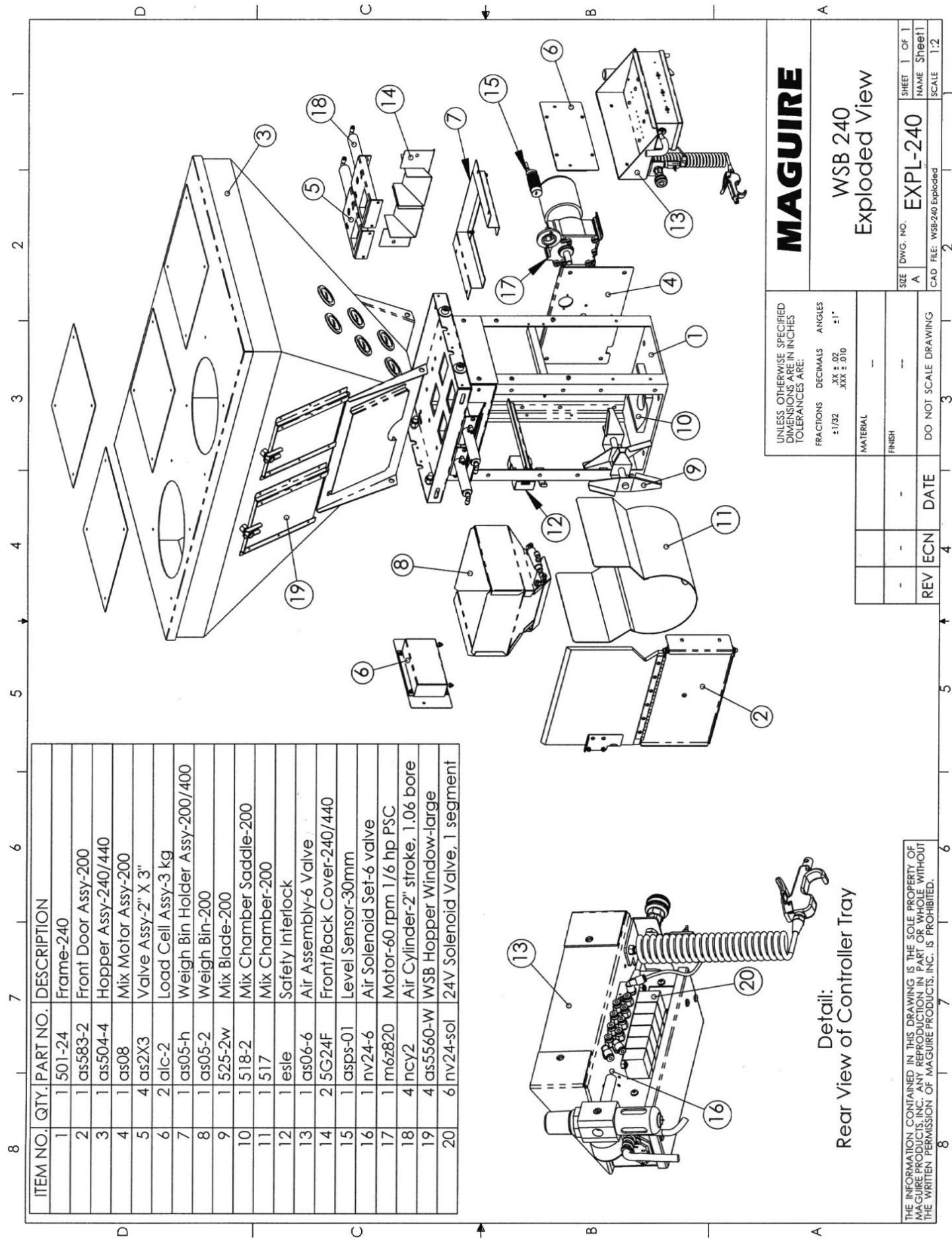
To reset the displayed totals and recorded totals to zero: First, stop operation by switching to "STOP END OF CYCLE". Next, switch to "IMMEDIATE PAUSE". Last, press "ALARM SILENCE" to clear the totals.		
---	---	---

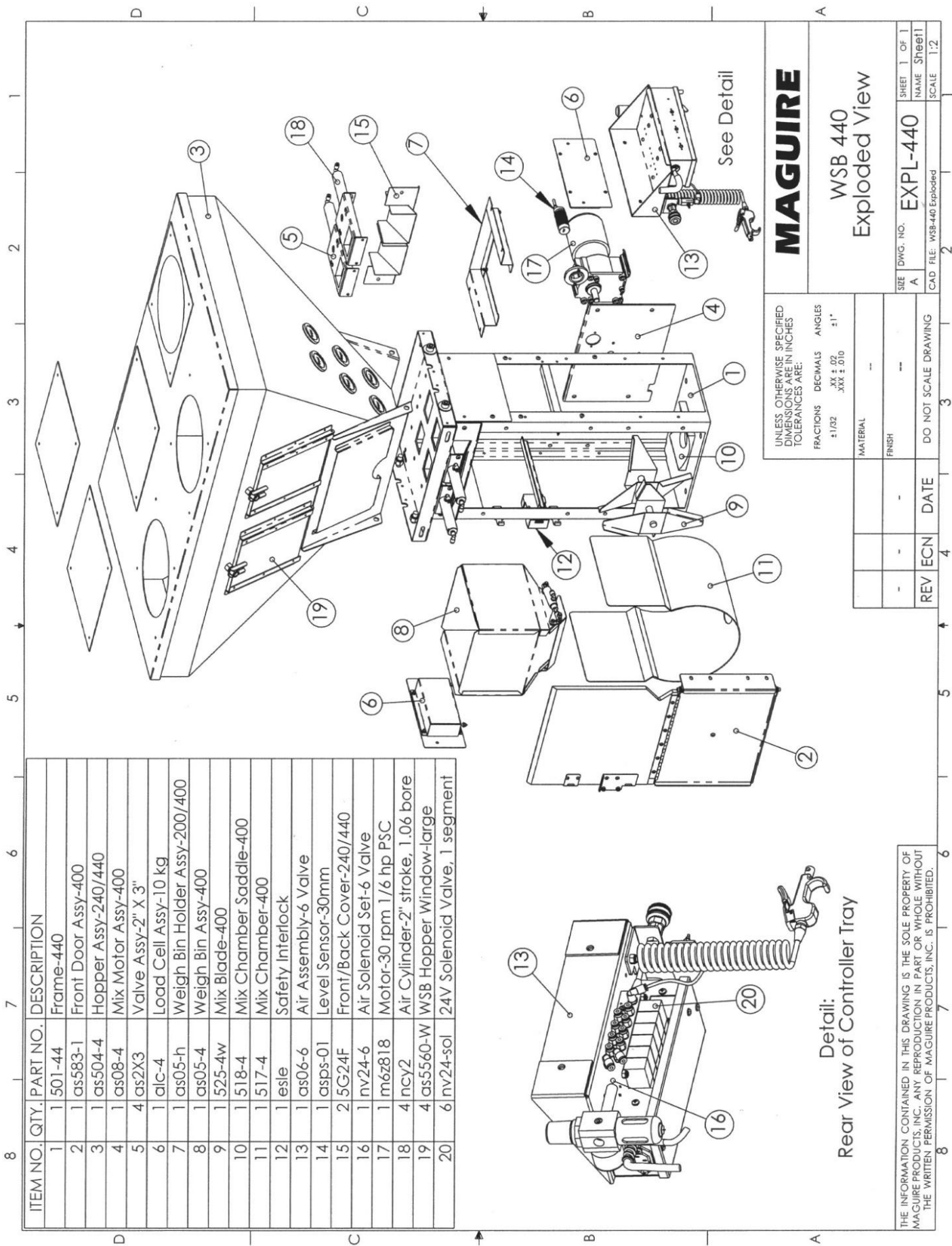
Technical Drawings





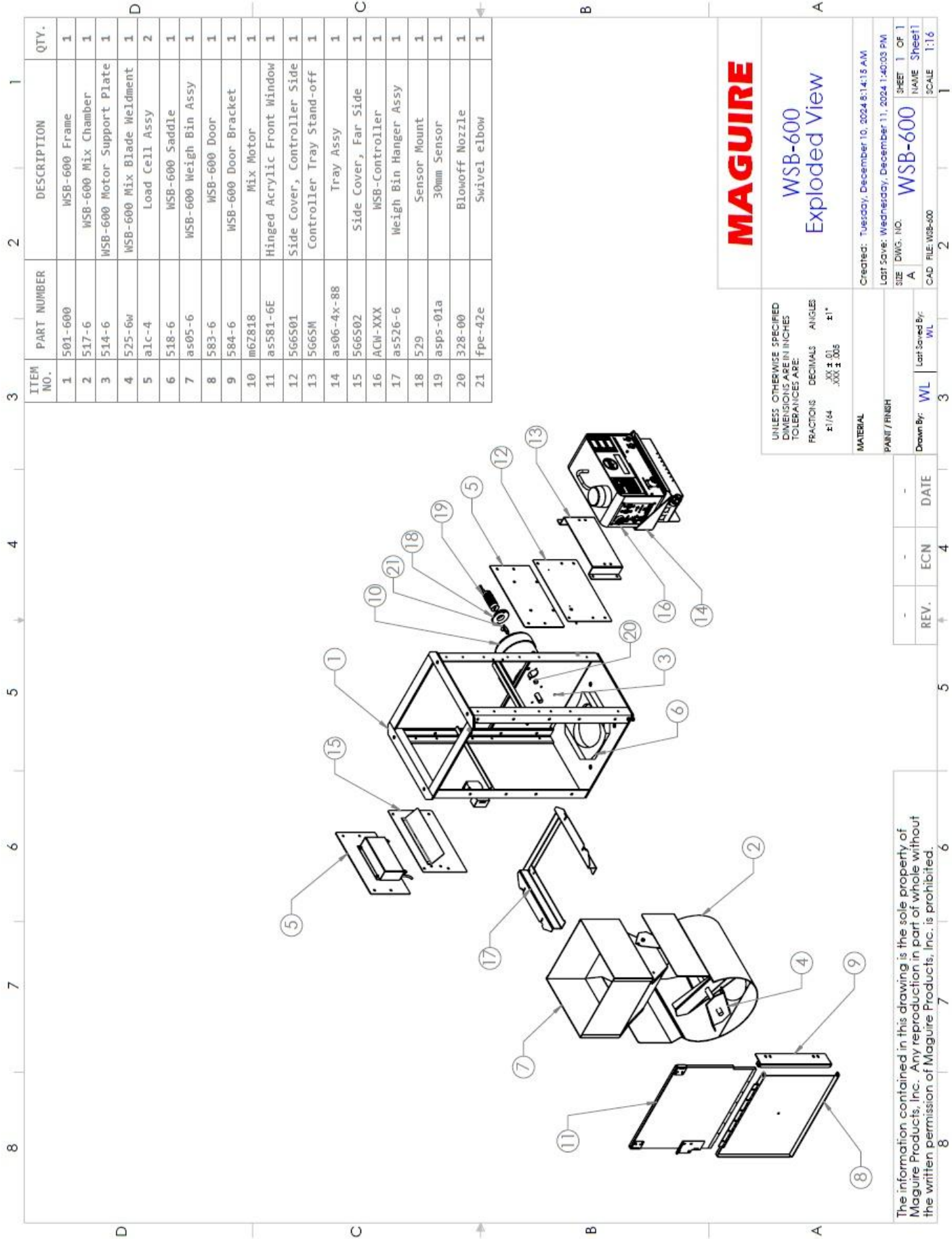






The WSB-600 exploded view parts diagram is shown as the base only. Hopper configurations for each WSB-600 are custom built and shipped with a parts number and dimensional diagram. Contact Maguire for additional

information.



THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MAGUIRE PRODUCTS, INC. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF MAGUIRE PRODUCTS, INC. IS PROHIBITED.

MAGUIRE
WSB 940
Exploded View

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
FRACTIONS DECIMALS ANGLES
± 1/32 ± .02 ± 1°
.XXX ± .010

DO NOT SCALE DRAWING

SEE DETAIL

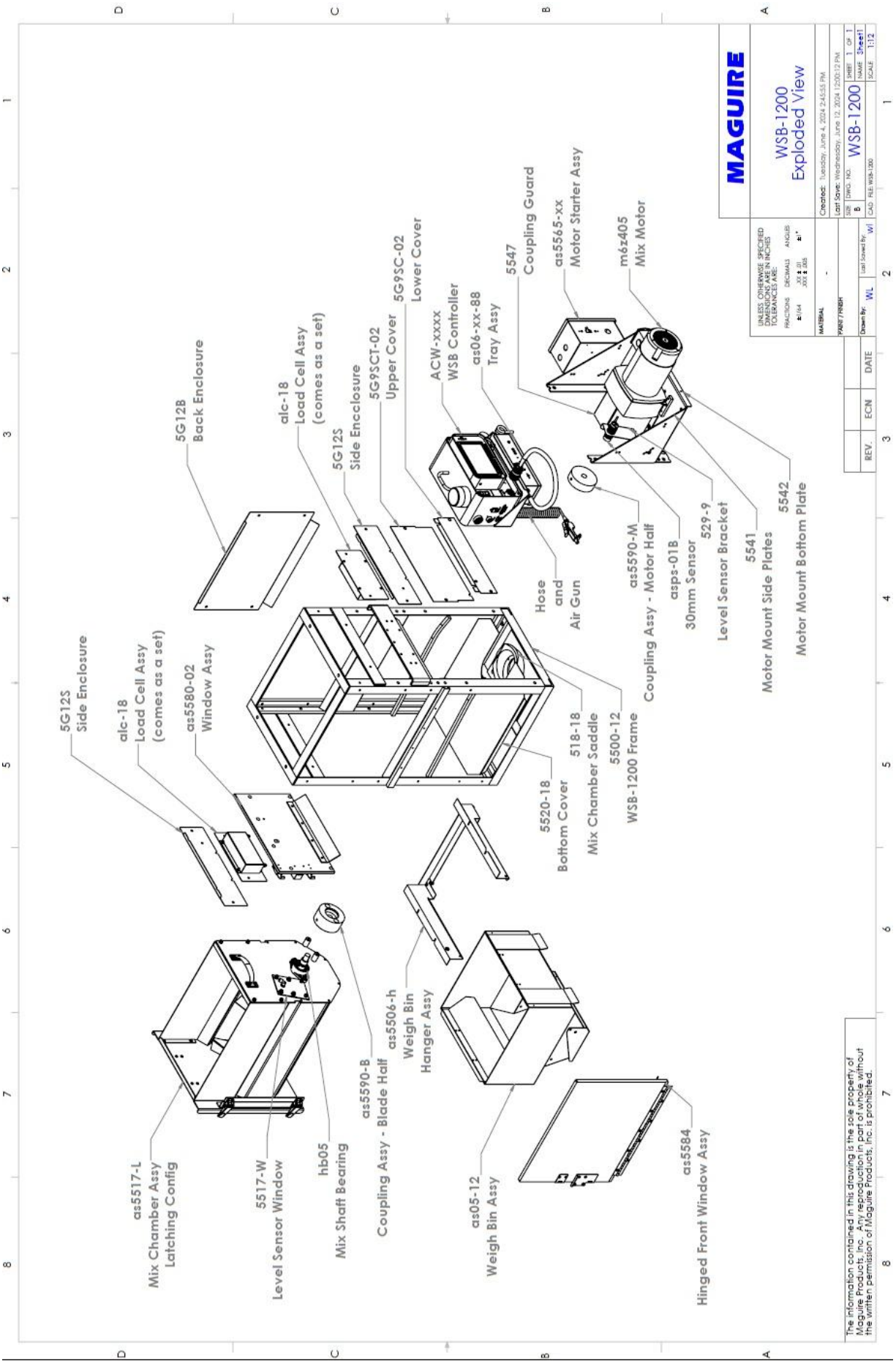
Detail:
Rear View of
Controller Tray

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	5500	Frame-WSB 9
2	1	as5560	Hopper Assy-WSB 9
3	1	as5517	Mix Chamber AssyWSB 9
4	1	as508 & as5590-M	Mixer Assy-WSB 9
5	2	as3X6	Slide Valve Assy-3 X 6
6	2	as2X3	Slide Valve Assy-2 X 3
7	1	as5581	Front Window Assy-WSB 9
8	1	as5580	Side Window Assy-WSB 9
9	2	5G94S	Enclosure-WSB 9 Side
10	1	as05-9	Weigh Bin Assy-WSB 9
11	1	5G94B	Enclosure-WSB 9 Back
12	1	5G94F	Enclosure-WSB 9 Front
13	1	518-9	Mix Chamber Saddle-WSB 9/18
14	1	asps-01	Level Sensor Assy
15	1	595-9SB	Enclosure-WSB 9 Lower Side
16	2	alc-9	Load Cell Assy-10 kg
17	1	as5506-h	Weigh Bin Holder Assy-WSB 9/18
18	1	m6z403 [mC020P]	Mix Motor-9 1/2 hp [European 50 Hz]
19	2	ncyl15	Air Cylinder-3" stroke, 1.06 bore
20	2	ncyl2	Air Cylinder-2" stroke, 1.06 bore
21	1	525-9w	Mix Blade weldment
22	1	as5565 / 66 / 68	Motor Starter Assy-9, 110V / 230V / 400V
23	1	as06-6	Air Assembly-6 Valve
24	1	nv24-6	Air Solenoid Set-6 Valve
25	6	nv24-sol	24V Solenoid Valve segment
26	1	es1h392 / 393 / 403	Manual Motor Starter-110 / 230 / 400V
27	1	eh7456 / 05	Solid State Relay-110 / 230
28	1	es4b862 & 68145	Motor Starter & Overload Relay-400V

as5565 / 5566
WSB 9 Motor Starter Assy
110V / 230V

as5568
WSB 9 Motor Starter Assy
400V

The WSB-1200 exploded view parts diagram is shown as the base only. Hopper configurations for each WSB-1200 are custom built and shipped with a parts number and dimensional diagram. Contact Maguire for additional information.



THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF MAGUIRE PRODUCTS, INC. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF MAGUIRE PRODUCTS, INC. IS PROHIBITED.

1 2 3 4 5 6 7 8

D C B A

See Detail 23

MAGUIRE

WSB 1840

Exploded View

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:

FRACTIONS	DECIMALS	ANGLES
1/32	.XX ± .02	± 1°
	.XXX ± .010	

MATERIAL

FINISH

DO NOT SCALE DRAWING

SIZE DWG. NO. EXP-1840 SHEET 1 OF 1

CAD FILE: WSB-1840 Exploded-US NAME SHEET1

SCALE 1:2

Detail:
Rear View of
Controller Tray

25

26

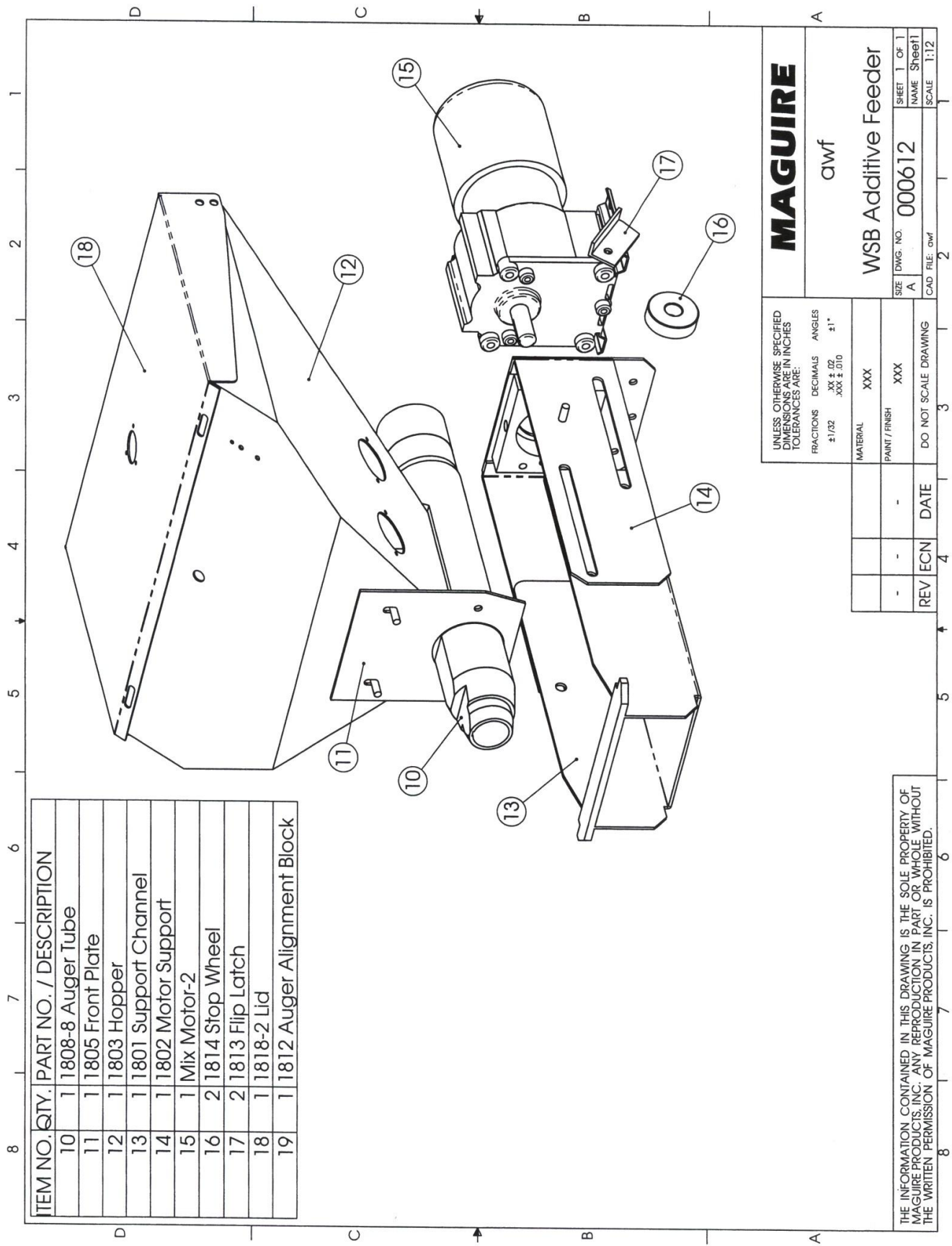
27

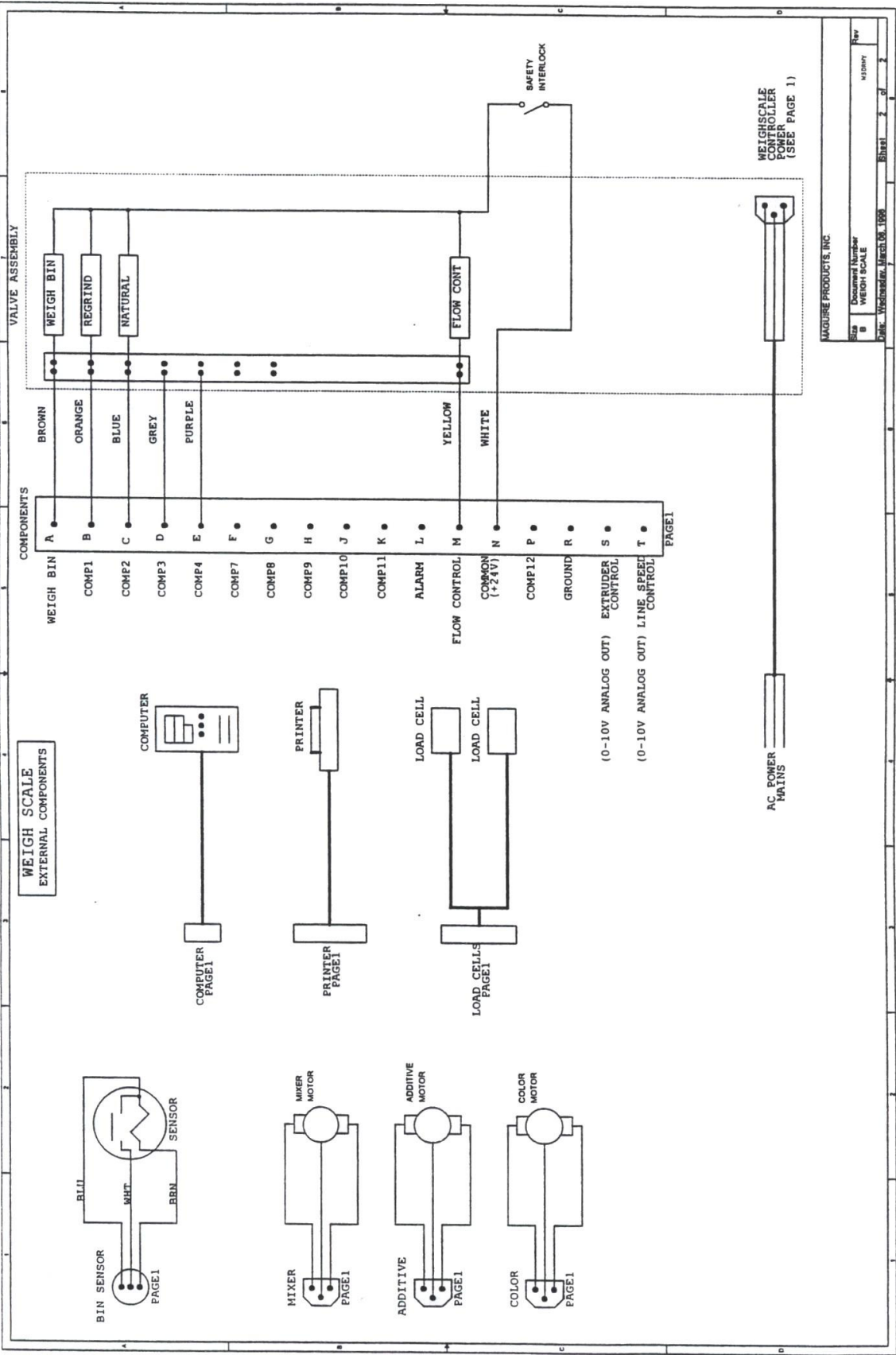
28

as5565 / 5566
WSB 9 Motor Starter Assy
110V / 230V

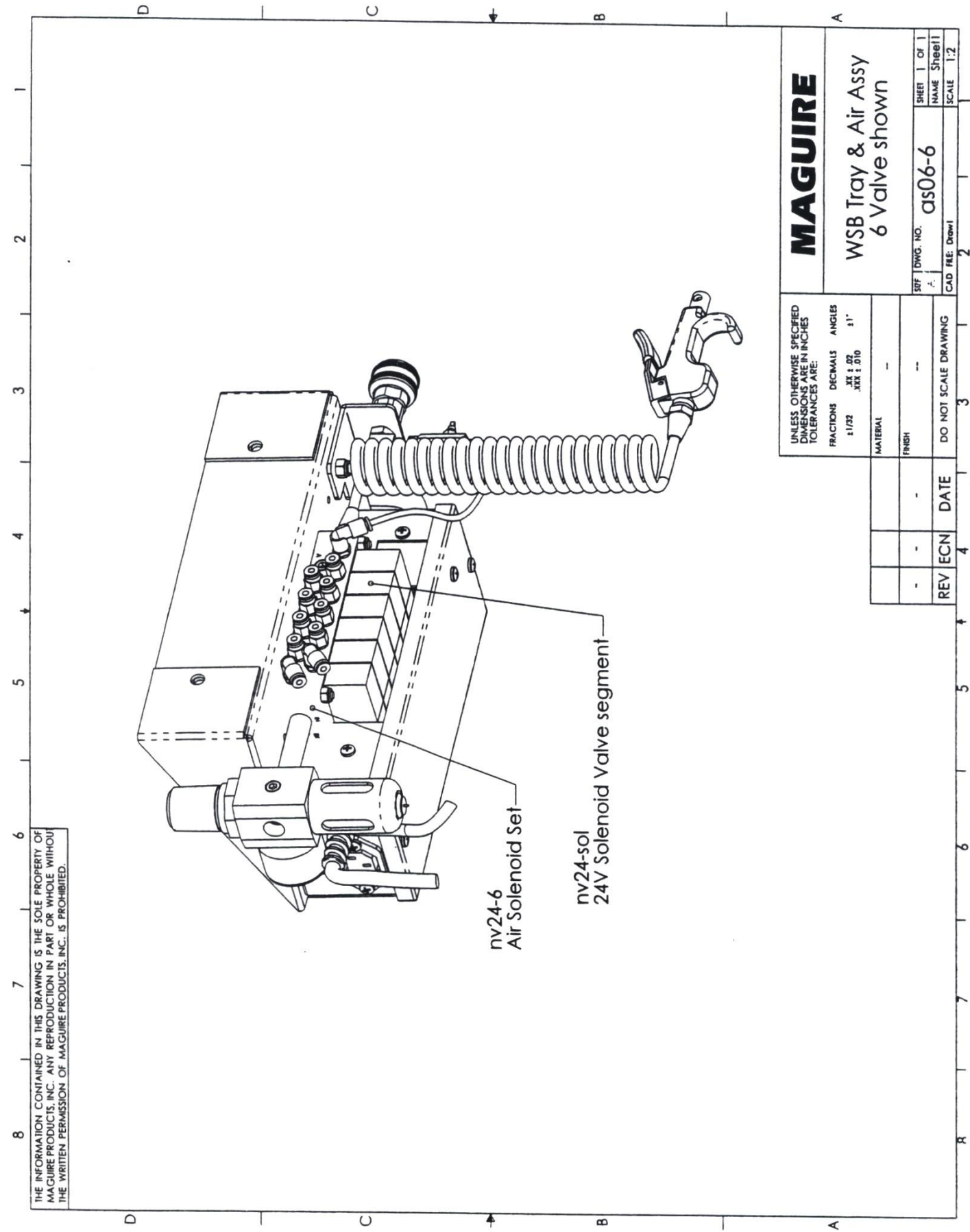
as5568
WSB 9 Motor Starter Assy
400V

ITEM #	QTY	PART #	DESCRIPTION
1	1	5500-18	Frame-WSB 18
2	1	as5561	Hopper Assy-WSB 18
3	1	as5518 / 19	Mix Chamber Assy-WSB 18 Lower/Upper
4	2	as508-18	Mixer Assy-WSB 18
5	2	as3X6	Slide Valve Assy-3 X 6
6	2	as2X3	Slide Valve Assy-2 X 3
7	1	as5584	Front Window Assy-WSB 18
8	1	as5581	Side Window Assy-WSB 18
9	2	5G184S	Enclosure-WSB 18 Side
10	1	as05-18	Weigh Bin Assy-WSB 18
11	1	5G184B	Enclosure-WSB 18 Back
12	1	5G184F	Enclosure- WSB 18 Front
13	1	518-9	Mix Chamber Saddle-WSB 9/18
14	1	asps-01	Level Sensor Assy
15	1	595-9SB	Enclosure-WSB 9/18 Lower Side
16	2	alc-18	Load Cell Assy-20 kg
17	1	as5506-h	Weigh Bin Holder Assy-WSB 9/18
18a	1	m6z405	Mix Motor- 3-Phase 220/440
18b	1	m8y979	Mix Motor- 230V Single Phase
18c	1	mC020P	Mix Motor- Euro 50 Hz 230/402
19	2	ncv15	Air Cylinder-3" stroke, 1.06 bore
20	2	ncv2	Air Cylinder-2" stroke, 1.06 bore
21	1	525-9w	Mix Blade weldment
22	1	as5565 / 66 / 68	Motor Starter Assy-9, 110V/230V/400V
23	1	as06-6	Air Assembly-6 Valve
24	1	nv24-6	Air Solenoid Set-6 Valve
25	6	nv24-sol	24V Solenoid Valve segment
26	1	es1h392 / 393 / 403	Manual Motor Starter-110/230/400V
27	1	eh7456 / 05	Solid State Relay-110/230
28	1	es4b862 & 68145	Motor Starter & Overload Relay-400V



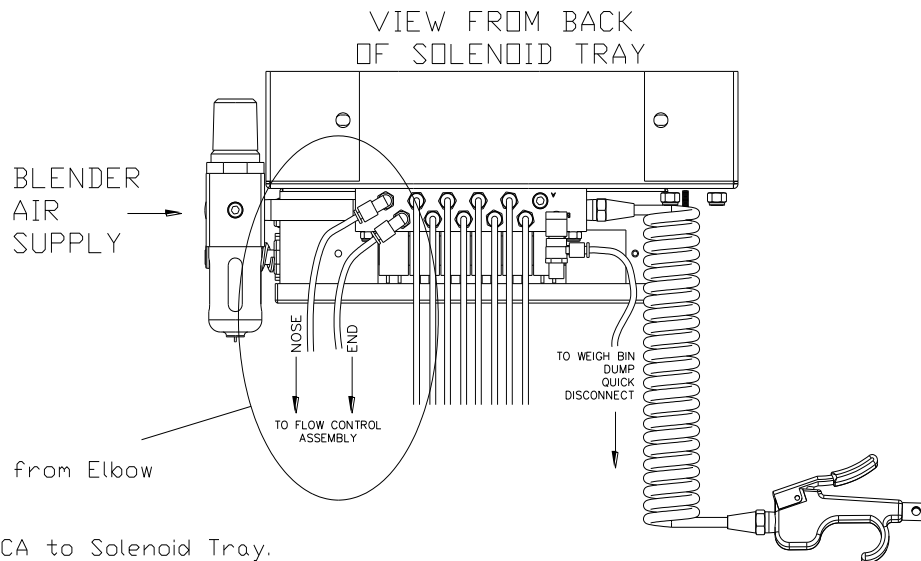
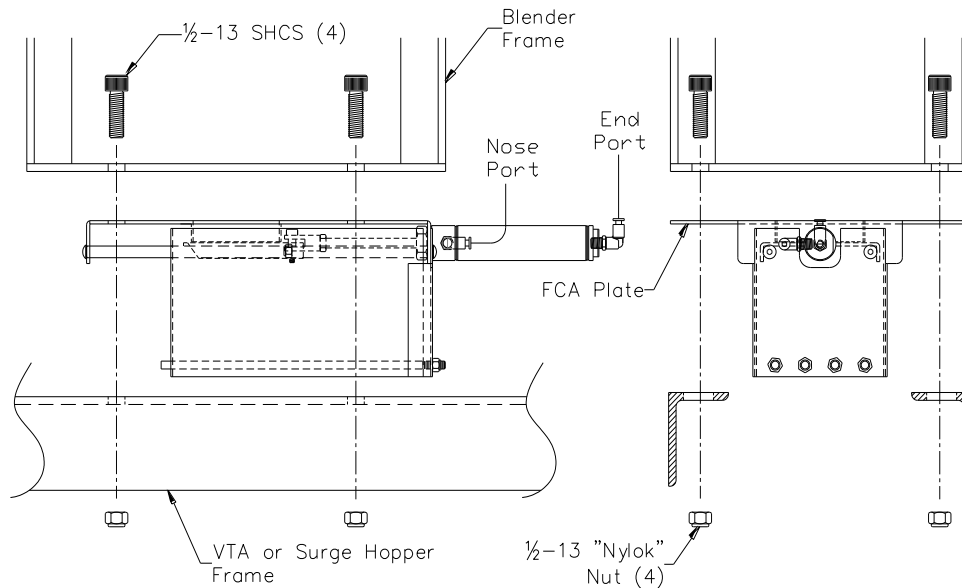


Air Solenoid Tray Pre-2017



Air Solenoid Tray Pre-2017

FCA INSTALLATION DIAGRAM



Remove Orange Plugs from Elbow Fittings.

Plumb Airlines from FCA to Solenoid Tray.

To Check that FCA is Plumbed correctly:
With air supply connected, turn blender on and then off. When power is off, Valve should close. Normal power-off position for the FCA Valve is closed.

Controller is already set up to run FCA and does not need to be modified.



Maguire Products Inc.
Aston, PA 19014 USA
(610) 459-4300
FAX (610) 459-2700

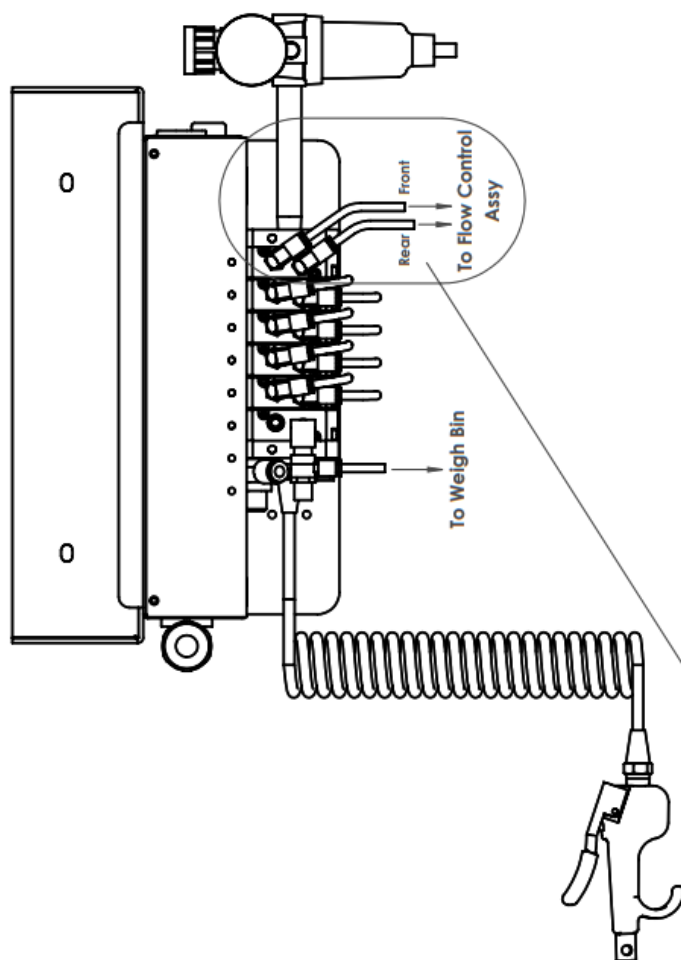
FCA INSTALLATION DIAGRAM

DRAWN BY:

DATE DRAWN:

4/23/04

Air Solenoid Tray post-2017



Remove Plugs from Elbow Fittings.

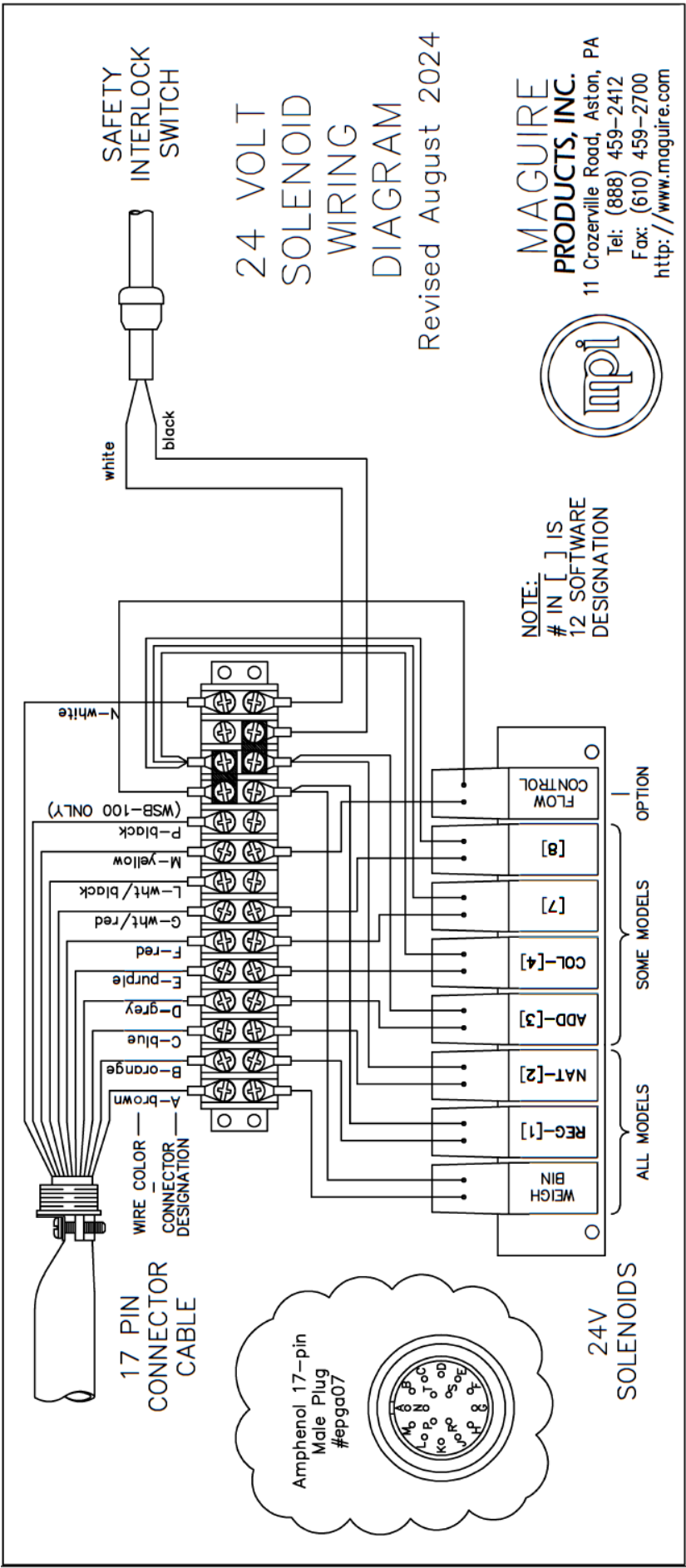
Plumb Airlines from FCA to Solenoid Tray.

To check that FCA is Plumbed correctly:
With air supply connected, turn blender on and then off. When power is off, valve should close. Normal power-off position for the FCA Valve is closed.

Controller is already set to run FCA and does not need to be modified.

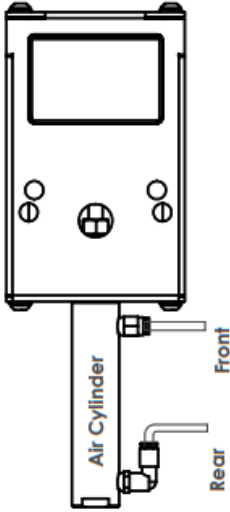
The information contained in this drawing is the sole property of Maguire Products, Inc. Any reproduction in part or whole without the written permission of Maguire Products, Inc. is prohibited.

[illegible]



MAGUIRE PRODUCTS, INC.
11 Crozerville Road, Aston, PA
Tel: (888) 459-2412
Fax: (610) 459-2700
<http://www.maguire.com>

Air Solenoid Tray post-2017

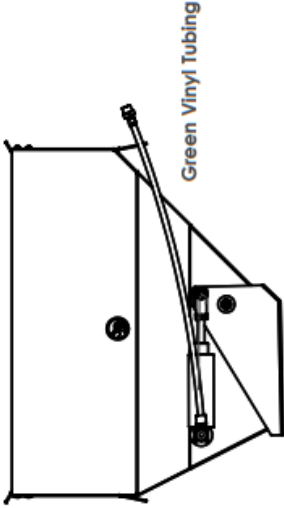


Air Cylinder

Rear

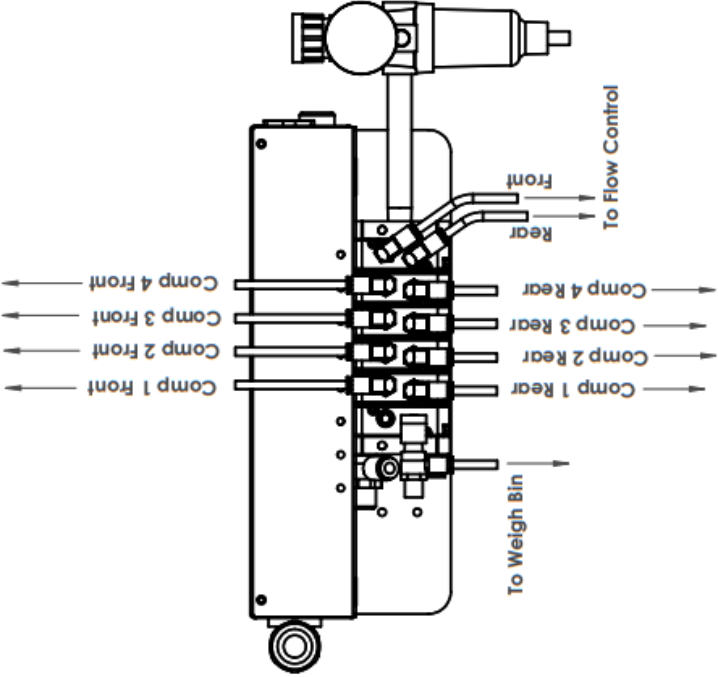
Front

Material Slide Valve Assy
(Typical)



Green Vinyl Tubing

Weigh Bin Assy
(Typical)



To Weigh Bin

Comp 1 Front

Comp 2 Front

Comp 3 Front

Comp 4 Front

Comp 1 Rear

Comp 2 Rear

Comp 3 Rear

Comp 4 Rear

To Flow Control Front

To Flow Control Rear

Flow Control Assy
(F C A)

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:

FRACTIONS	DECIMALS	ANGLES
±1/64	.XX ± .01	±1°
	.XXX ± .005	

MATERIAL

PAIN / FINISH

Drawn By:

Last Saved By:

Created: Wednesday, February 28, 2024 9:55:16 AM

Last Save: Tuesday, March 5, 2024 10:34:38 AM

SHEET 1 OF 1

NAME Sheet1(2)

SCALE 1:4

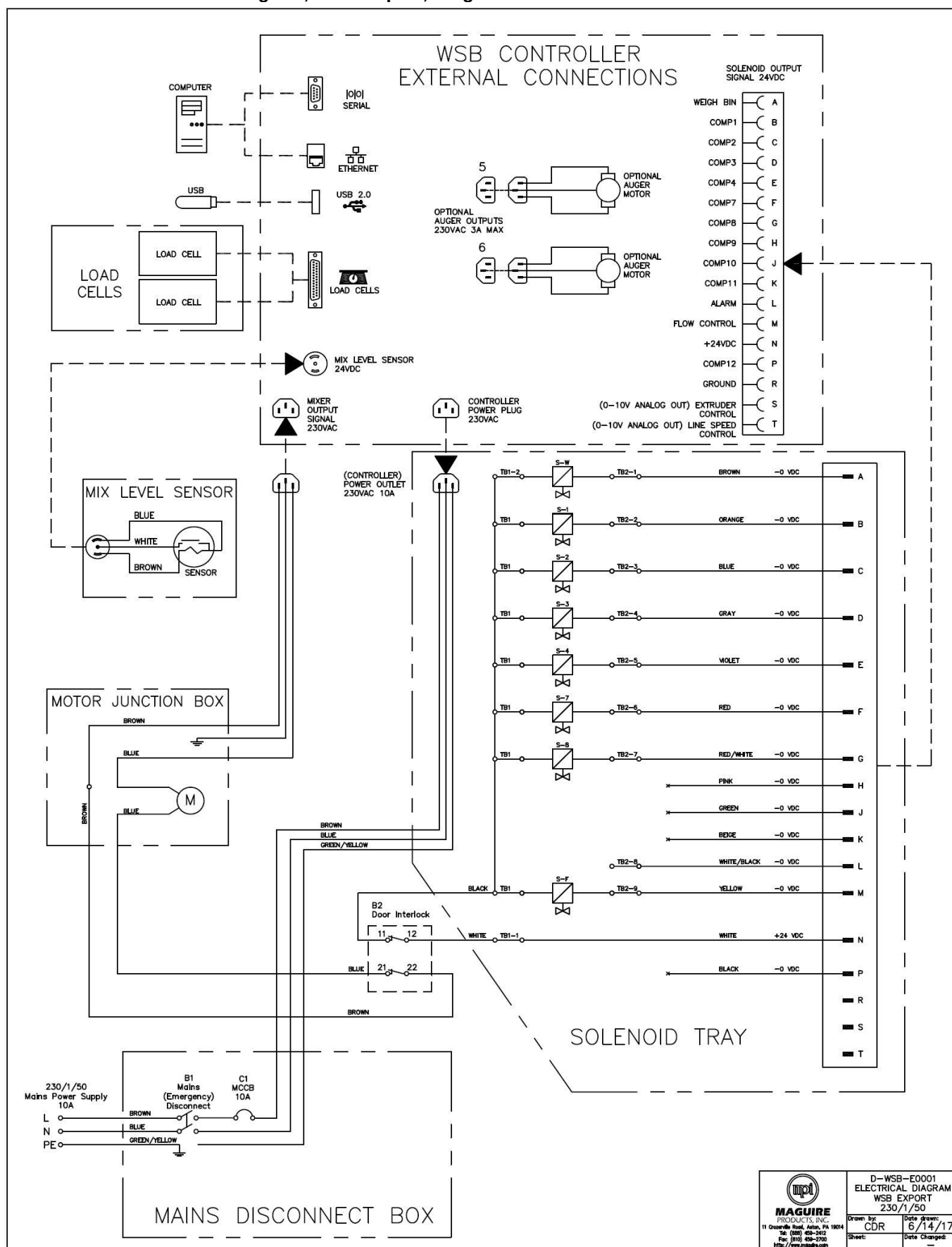
MAGUIRE

WSB
Pneumatic
Arrangement

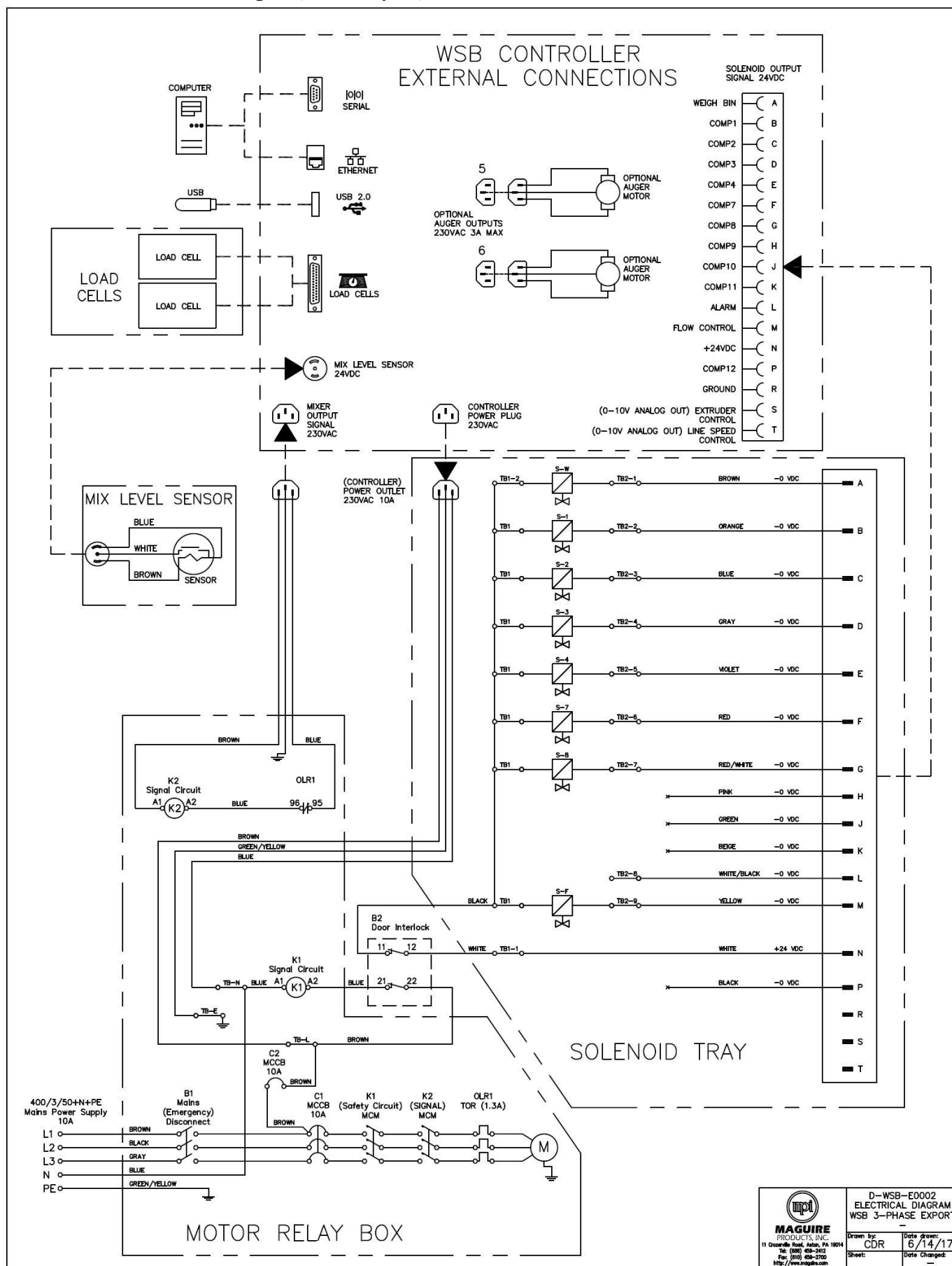
REV.	ECN	DATE
-	-	-

The information contained in this drawing is the sole property of Maguire Products, Inc. Any reproduction in part or whole without the written permission of Maguire Products, Inc. is prohibited.

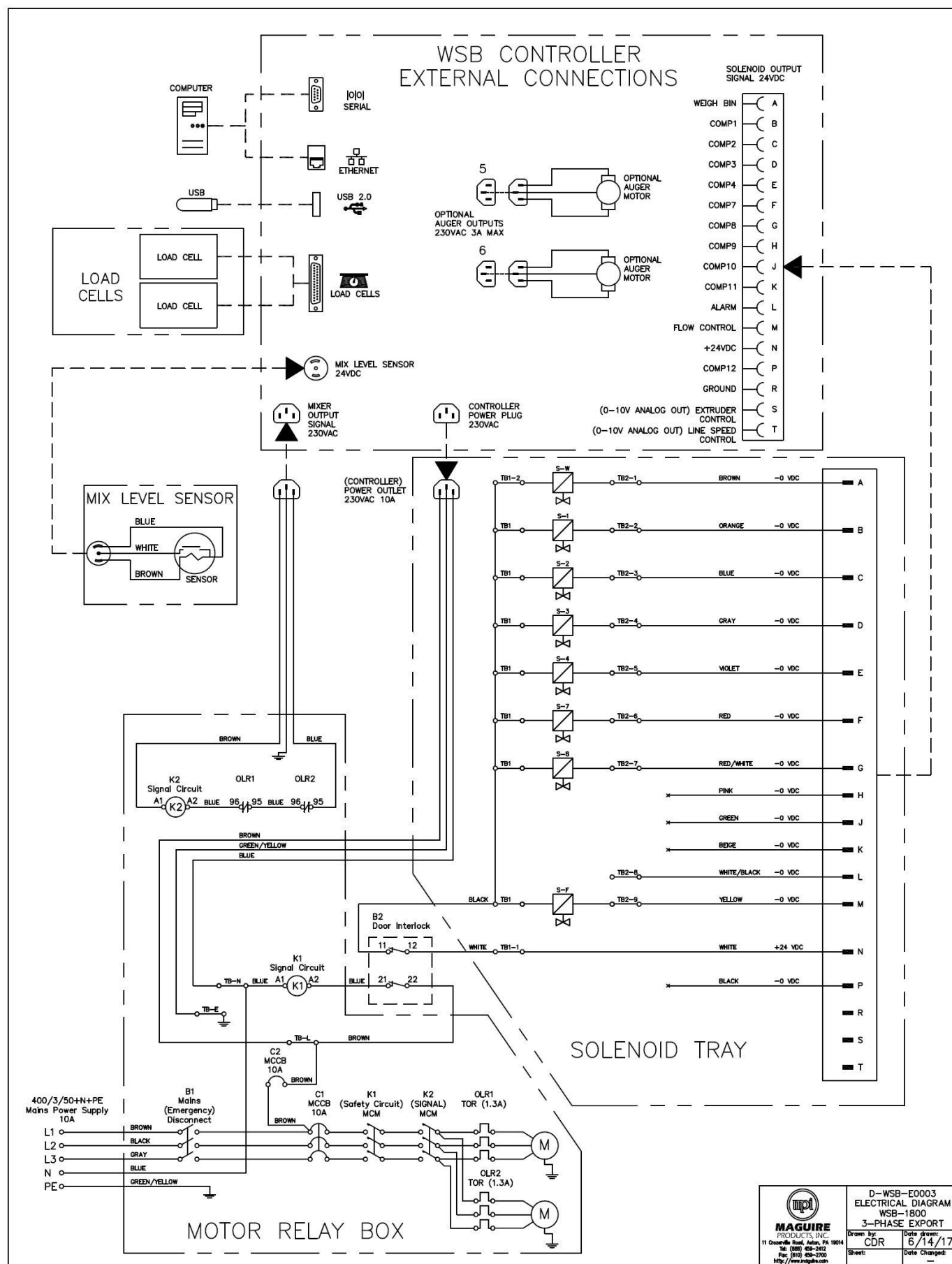
D-WSB-E0001 - Electrical Diagram, WSB Export, Single Phase



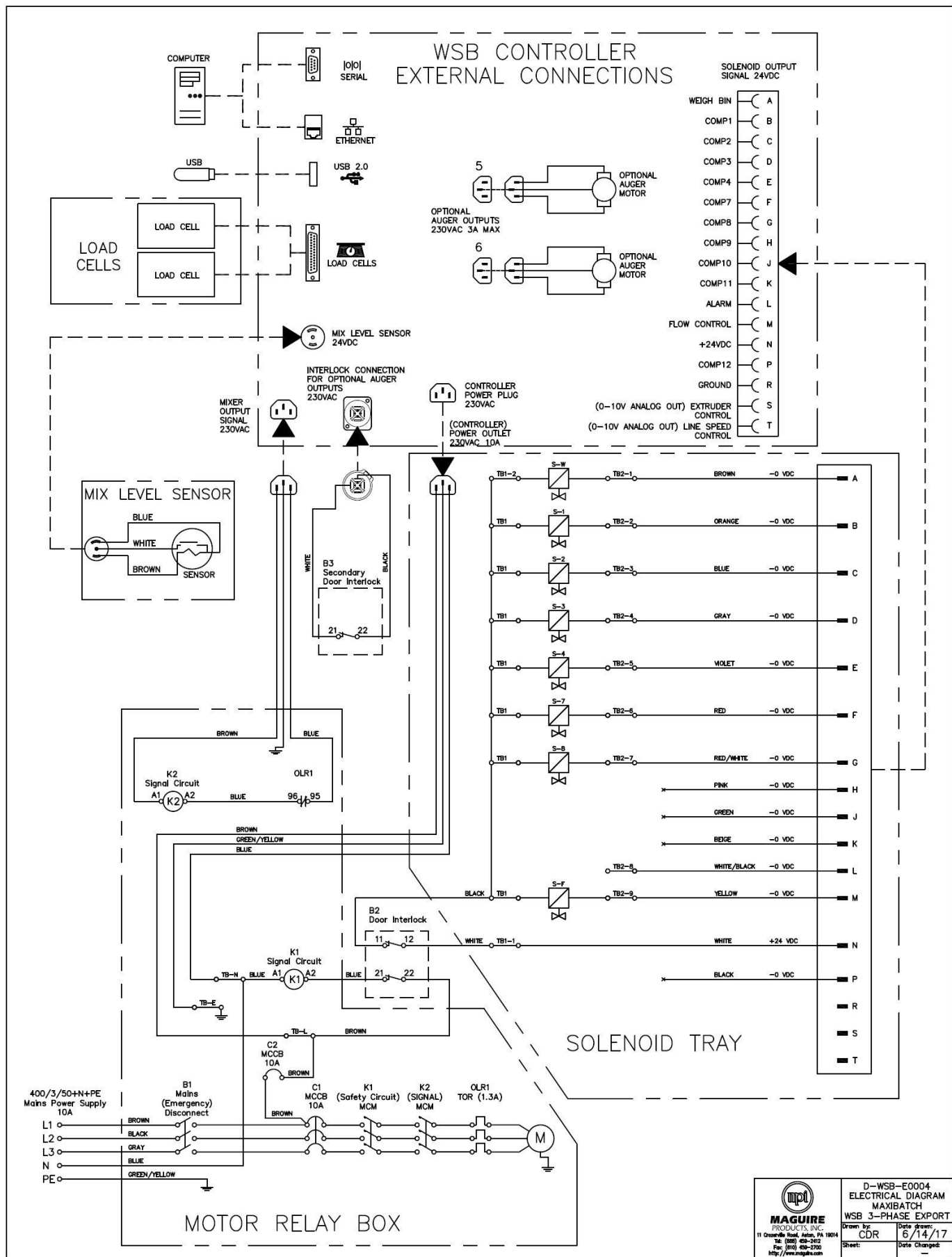
D-WSB-E0002 - Electrical Diagram, WSB Export, 3-Phase



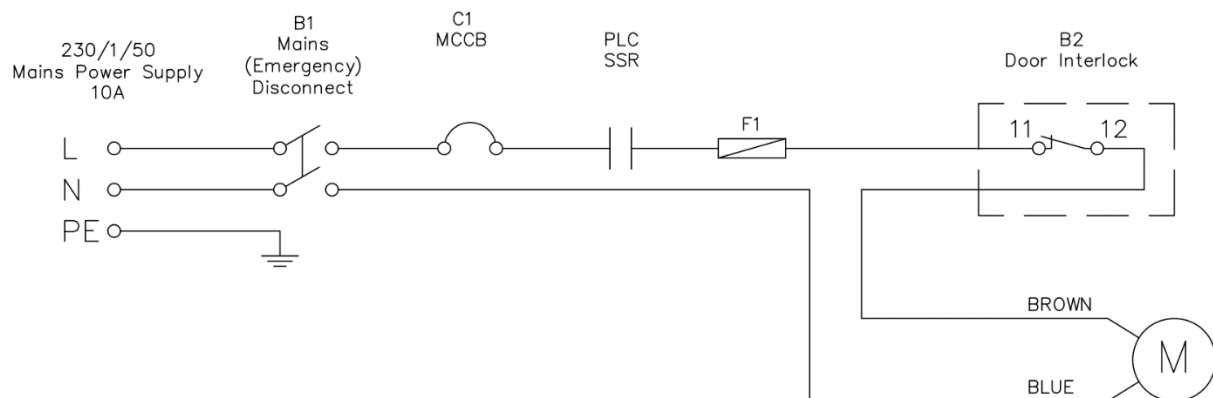
D-WSB-E0003 - Electrical Diagram, WSB Export, 1800 3-Phase



D-WSB-E0004 - Electrical Diagram, WSB Export, Maxibatch

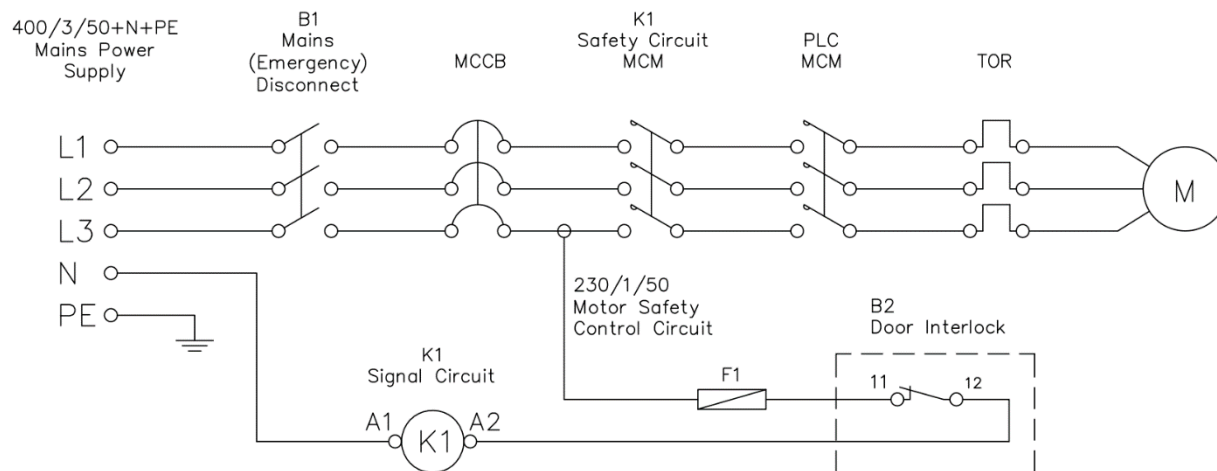


WSB Single Phase Motor Safety Circuit



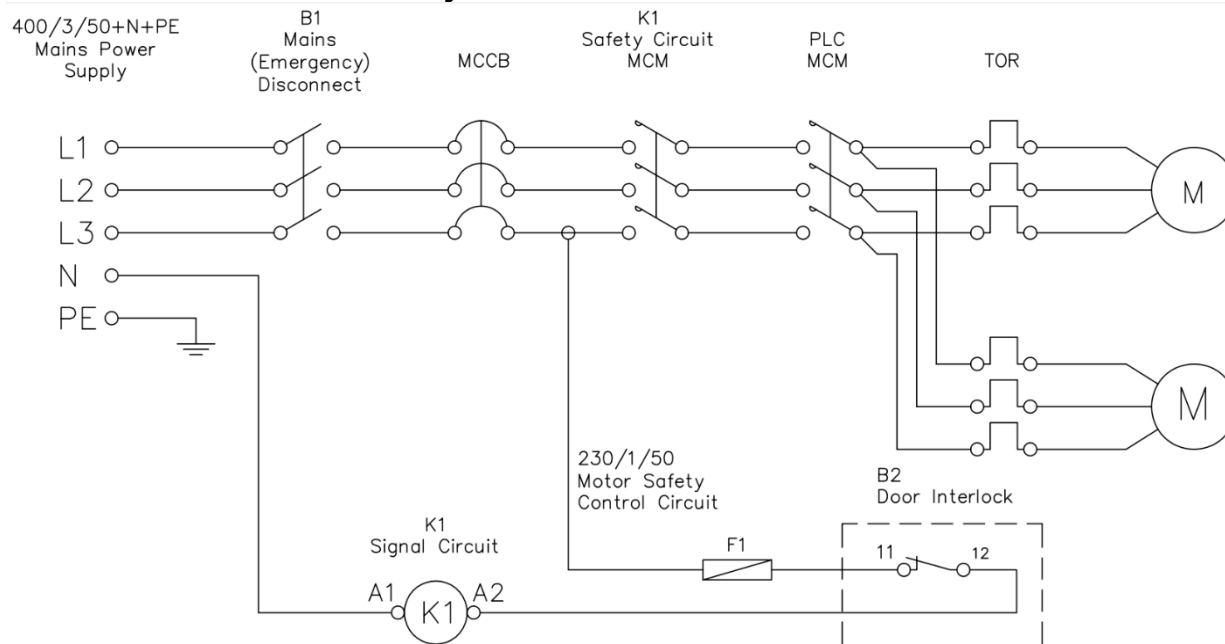
WSB Single Phase Motor Safety Circuit

WSB 3-Phase Motor Safety Circuit

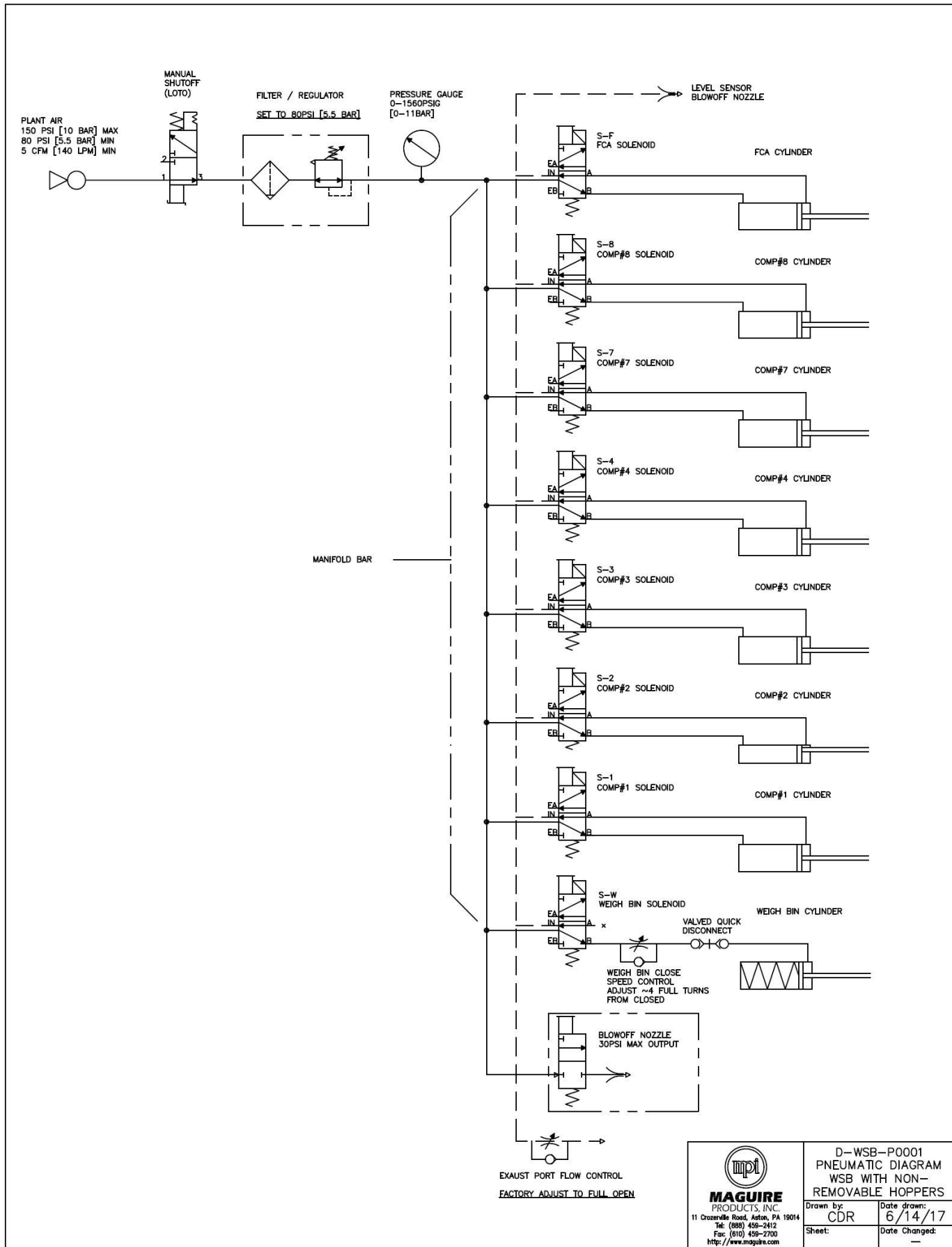


WSB 3-Phase Motor Safety Circuit

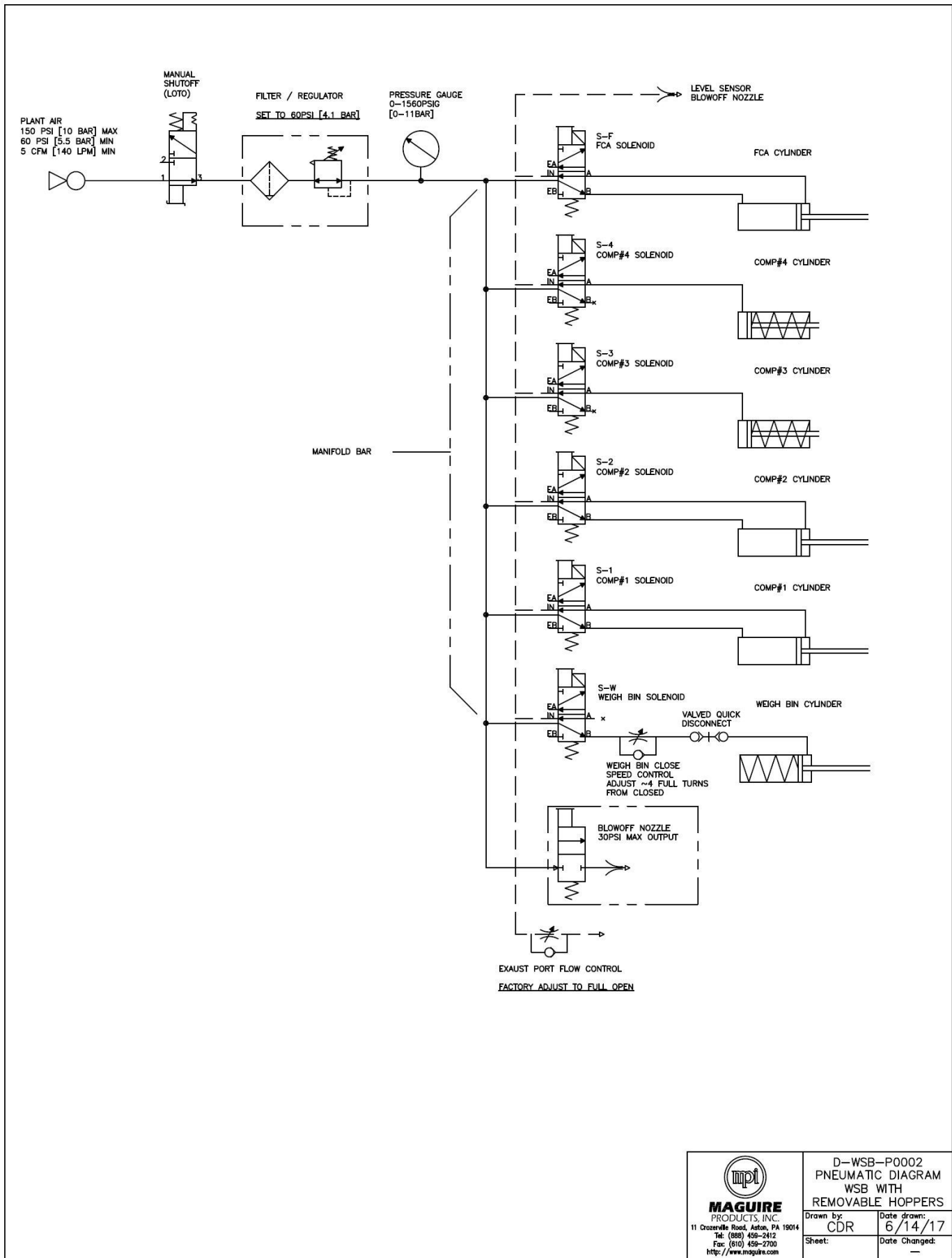
WSB-18 3-Phase Motor Safety Circuit



WSB-18 3-Phase Motor Safety Circuit

D-WSB-P0001 - Pneumatic Diagram, WSB, with Non-Removable Hoppers

D-WSB-P0002 - Pneumatic Diagram, WSB, with Removable Hoppers

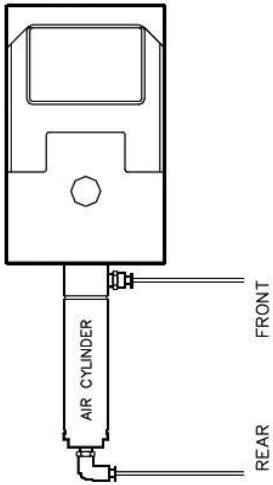


PNEUMATIC ARRANGEMENT

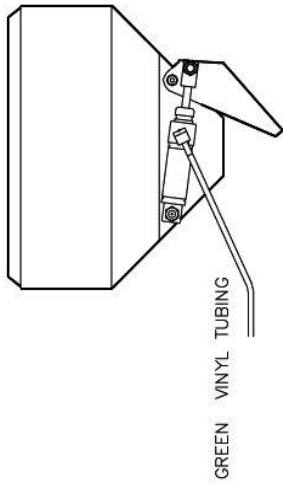
WSB Models with Electric Mixer



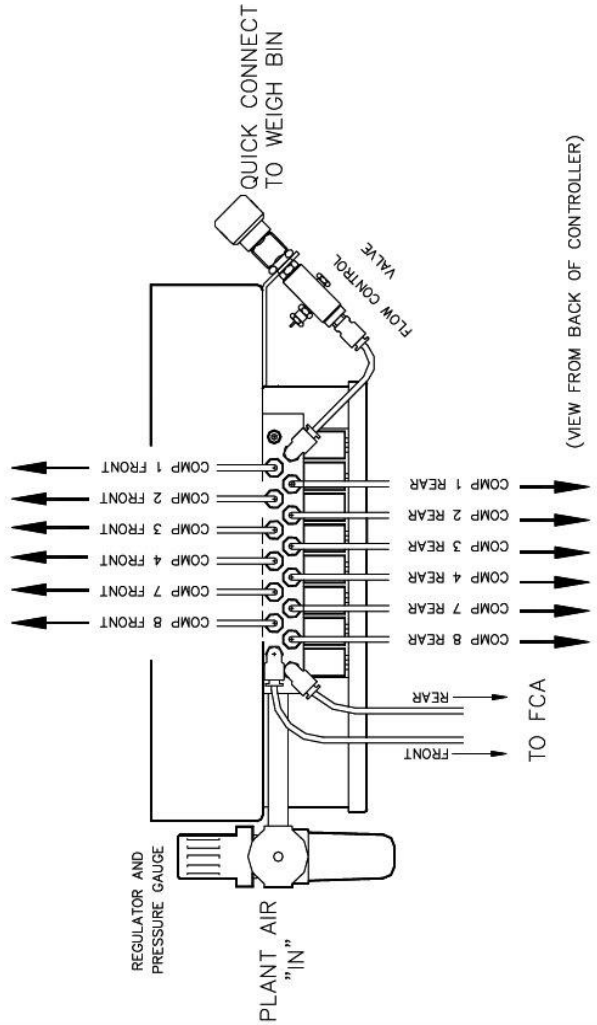
MAGUIRE PRODUCTS INC.
11 Crozerville Road
Aston, PA 19014 USA
610-459-4300
Fax 610-459-2700



MATERIAL SLIDE VALVE ASSY
(TYPICAL)

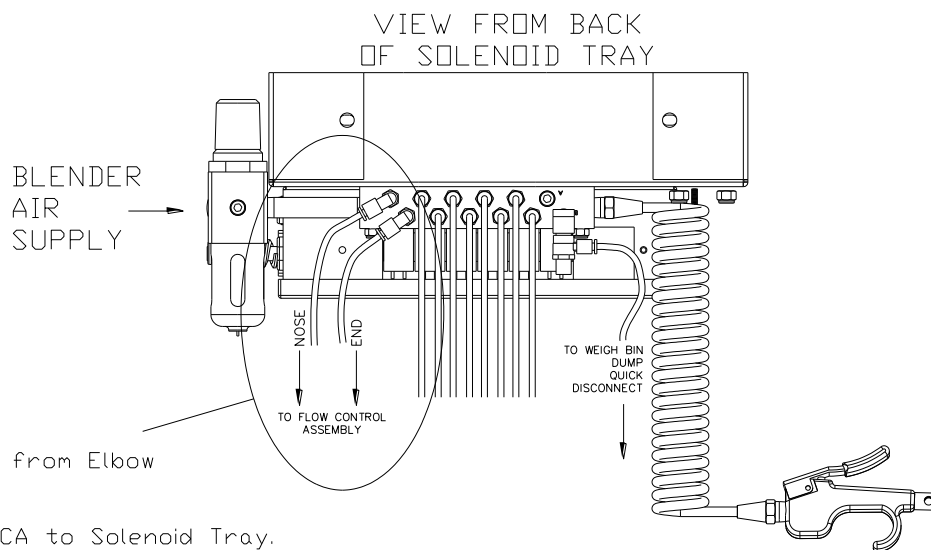
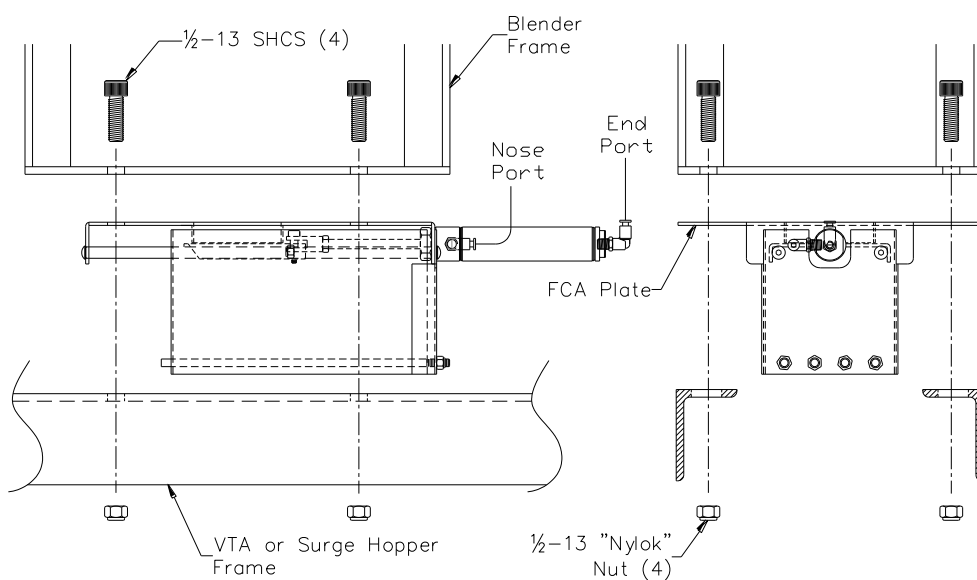


WEIGH BIN ASSY
(TYPICAL)



FLOW CONTROL ASSY
(F C A)

FCA INSTALLATION DIAGRAM



Remove Orange Plugs from Elbow Fittings.

Plumb Airlines from FCA to Solenoid Tray.

To Check that FCA is Plumbed correctly:
With air supply connected, turn blender on and then off. When power is off, Valve should close. Normal power-off position for the FCA Valve is closed.

Controller is already set up to run FCA and does not need to be modified.



Maguire Products Inc.
Aston, PA 19014 USA
(610) 459-4300
FAX (610) 459-2700

FCA INSTALLATION DIAGRAM

DRAWN BY:

DATE DRAWN:

4/23/04

WSB Model Dimensions and Weight

Note: Weights and dimensions can vary based on the accessories and hopper configuration. The following values are for example only of the specific models listed. For more specific information about your configuration, please contact Maguire Products Inc.

Model	Overall Dimensions (WxDxH)	Overall Weight
WSB-MB	16x16x23.5 (in), 410x410x600 (mm)	50 lb/23 kg
WSB-100	28.5x26.5x32(in), 730x670x820 (mm)	150 lb/68 kg
WSB-140	28.5x26.5x32(in), 730x670x820 (mm)	150 lb/68 kg
WSB-220	32.5x26.5x42 (in), 826x673x1067 (mm)	220lb/100/kg
WSB-221	32.5x26.5x42 (in), 826x673x1067 (mm)	260lb/118kg
WSB-222	32.5x26.5x42 (in), 826x673x1067 (mm)	300lb/136kg
WSB-240	32.5x26.5x42 (in), 826x673x1067 (mm)	230lb/105kg
WSB-241	32.5x26.5x42 (in), 826x673x1067 (mm)	270lb/123kg
WSB-242	41.5x28x46 (in), 1054.1x711.2x1168.4 (mm)	310lb/141kg
WSB-240R	41.5x28x46 (in), 1054.1x711.2x1168.4 (mm)	255lb/116kg
WSB-260	41.5x28x46 (in), 1054.1x711.2x1168.4 (mm)	260lb/120kg
WSB-420	32.5x26.5x48 (in), 826x673x1220 (mm)	275lb/125kg
WSB-421	32.5x26.5x48 (in), 826x673x1220 (mm)	315lb/143kg
WSB-422	32.5x26.5x48 (in), 826x673x1220 (mm)	355lb/161kg
WSB-440	32.5x26.5x48 (in), 826x673x1220 (mm)	310lb/141kg
WSB-441	32.5x26.5x48 (in), 826x673x1220 (mm)	350lb/159kg
WSB-442	41.5x28x51.5 (in),1054x711x1308 (mm)	390lb/177kg
WSB-444	41.5x28x51.5 (in),1054x711x1308 (mm)	470lb/214kg
WSB-440R	41.5x28x51.5 (in),1054x711x1308 (mm)	345lb/157kg
WSB-460	41.5x28x51.5 (in),1054x711x1308 (mm)	355lb/161kg
WSB-600	Overall dimensions and overall weight vary. See as-built diagram for each WSB-600.	
WSB-940	46.5x28.5x60 (in), 1181x724x1524 (mm)	420lb/191kg
WSB-941	46.5x28.5x60 (in), 1181x724x1524 (mm)	460lb/209kg
WSB-942	46.5x28.5x60 (in), 1181x724x1524 (mm)	500lb/227kg
WSB-944	46.5x28.5x60 (in), 1181x724x1524 (mm)	580lb/264kg
WSB-960	46.5x28.5x60 (in), 1181x724x1524 (mm)	430lb/195kg
WSB-1240	41x42x75 (in), 1042x1066x1905 (mm)	615lb/280kg
WSB-1260	62x42x78 (in), 1575x1067x1982 (mm)	615lb/280kg
WSB-1840	46.5x40.5x87 (in), 1181x1029x2210 (mm)	615lb/280kg
WSB-1841	46.5x40.5x87 (in), 1181x1029x2210 (mm)	655lb/298kg
WSB-1842	46.5x40.5x87 (in), 1181x1029x2210 (mm)	695lb/316kg
WSB-1860	46.5x40.5x87 (in), 1181x1029x2210 (mm)	625lb/284kg
WSB-1866	46.5x40.5x87 (in), 1181x1029x2210 (mm)	865lb/393kg
WSB-2420	42 x 42 x 87 (in), 1100 x 1100 x 2210 (mm)	825 lb/375 kg
WSB-2440	42 x 42 x 87 (in), 1100 x 1100 x 2210 (mm)	825 lb/375 kg
WSB-2443	60 x 80 x 87 (in), 1500 x 2100 x 2210 (mm)	1225 lb/560 kg
WSB-2445	80 x 85 x 87 (in), 2000 x 2150 x 2210 (mm)	1425 lb/650 kg
WSB-3020	50 x 50 x 90 (in), 1300 x 1300 x 2300 (mm)	900 lb/400 kg
WSB-3040	50 x 50 x 90 (in), 1300 x 1300 x 2300 (mm)	900 lb/400 kg
WSB-3043	60 x 80 x 90 (in), 1500 x 2100 x 2300 (mm)	1300 lb/600 kg
WSB-3045	80 x 85 x 90 (in), 2000 x 2150 x 2300 (mm)	1500 lb, 680 kg

Decommissioning and Disposal

Decommissioning the unit: Disconnect the unit from the power supply. Disconnect the compressed air supply. Cut all Electrical cables & Pneumatic Hoses to decommission the equipment. Disposal: Remove air hoses and inspection glasses and dispose of with plastic refuse. Remove electric motor dispose of with metal. Remainder of unit dispose of with metal. Controller: Remove battery and dispose of battery with hazardous waste. Remainder of controller dispose of with electronic waste. Re-cycle any hazardous materials/substances in accordance with the Local & National regulations of the End User e.g. Lithium batteries etc, specific attention should be paid to the European RoHS & WEEE Directives; remove any 'sharps' and dispose of in accordance with Local & National regulations.

Disclaimers

Production of Faulty Product

Processing conditions and materials vary widely from customer to customer and from product to product. It is IMPOSSIBLE for us to anticipate ALL processing conditions and requirements, or to be certain that our equipment will perform properly in all instances. You, the customer, must observe and verify the performance level of our equipment in your plant as part of your overall manufacturing process.

You must verify to your own satisfaction that this level of performance meets your requirements. We CAN NOT be responsible for losses due to product that is blended incorrectly, even when due to equipment malfunction or design incorrect for your requirements; and/or for any consequential losses due to our equipment not blending to your requirements.

We will only be responsible to correct, repair, replace, or accept return for full refund if our equipment fails to perform as designed, or we have inadvertently misrepresented our equipment for your application.

Accuracy of this Manual

We make every effort to keep this manual as correct and current as possible. However, technology and product changes occur more rapidly than the reprinting of this manual. Generally, modifications made to the design of the blender or to the operation of the software are not reflected in the manual for 3 to 6 months. We always reserve the right to make these changes without notice, and we do not guarantee the manual to be entirely accurate. If you question any information in this manual, or find errors, please let us know so that we may make the required corrections. We will gladly provide you with updated manuals.

Warranty – Exclusive 5-Year

MAGUIRE PRODUCTS offers THE MOST COMPREHENSIVE WARRANTY in the plastics equipment industry. We warrant each Weigh Scale Blender manufactured by us to be free from defects in material and workmanship under normal use and service; excluding only those items listed below as 'excluded items'; our obligation under this warranty being limited to making good at our factory any Weigh Scale Blender which shall within FIVE (5) YEARS after delivery to the original purchaser be RETURNED intact to us, transportation charges PREPAID, and which our examination shall disclose to our satisfaction to have been thus defective; this warranty being expressly in lieu of all other warranties expressed or implied

and of all other obligations or liabilities on our part, and MAGUIRE PRODUCTS neither assumes nor authorizes any other persons to assume for it any other liability in connection with the sale of its Weigh Scale Blenders.



This warranty shall not apply to any Weigh Scale Blender, which shall have been repaired or altered outside MAGUIRE PRODUCTS factory, unless such repair or alteration was, in our judgment, not responsible for the failure; nor which has been subject to misuse, negligence or accident, incorrect wiring by others, or installation or use not in accord with instructions furnished by Maguire Products.

Our liability under this warranty will extend ONLY to equipment that is returned to our factory in Aston, Pennsylvania, PREPAID.

Please note that we always strive to satisfy our customers in whatever manner is deemed most expedient to overcome any problems they may have in connection with our equipment.

EXCLUDED ITEMS:

LOAD CELLS on our WEIGH SCALE BLENDER are covered as long as they have not been damaged from improper handling. MB, 100, and 200 series units use load cells rated for 6.6 pounds (3KG) maximum load. Larger units use load cells rated for 22 pounds (10KG). DO NOT press on them manually. DO NOT disassemble them from their mounting enclosures. Do not DROP them. Do not drop the frame to which they are mounted. If the frame is dropped from a height of two feet, the load cells will most likely be damaged.

DISCLAIMER:

Processing conditions and materials vary widely from customer to customer and from product to product. Please be aware that it is IMPOSSIBLE for us to anticipate ALL processing conditions and requirements, or to be certain that our equipment will perform properly in all instances. You, the customer, must observe and verify the performance level of our equipment in your plant as part of your overall manufacturing process. You must verify to your own satisfaction that this level of performance meets your requirements. We CAN NOT be responsible for losses due to product that is blended incorrectly, even when due to equipment malfunction or design incorrect for your requirements; and/or for any consequential losses due to our equipment not blending to your requirements.

We will only be responsible to correct, repair, replace, or accept return for full refund if we have inadvertently misrepresented our equipment for your application.

Technical Support and Contact Information

Maguire Products Inc.

11 Crozerville Road

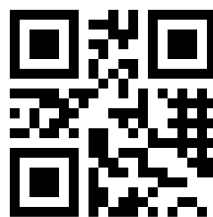
Aston, PA 19014

Tel: 610.459.4300

Fax: 610.459.2700

Email: info@maguire.com

Web: www.maguire.com



Maguire Europe

Tame Park

Tamworth

Staffordshire

B775DY

UK

Tel: + 44 1827 265 850

Fax: + 44 1827 265 855

Email: info@maguire-europe.com

Maguire Products Asia PTE LTD

Main Office

15 Changi North Street 1

#01-15, I-Lofts

Singapore 498765

Tel: 65 6848-7117

Fax: 65 6542-8577

E-mail: magasia@maguire-products.com.sg