

BESSER



EasyBlend Batching System

Operation Manual

Easy Blend Batching System
Operation Manual

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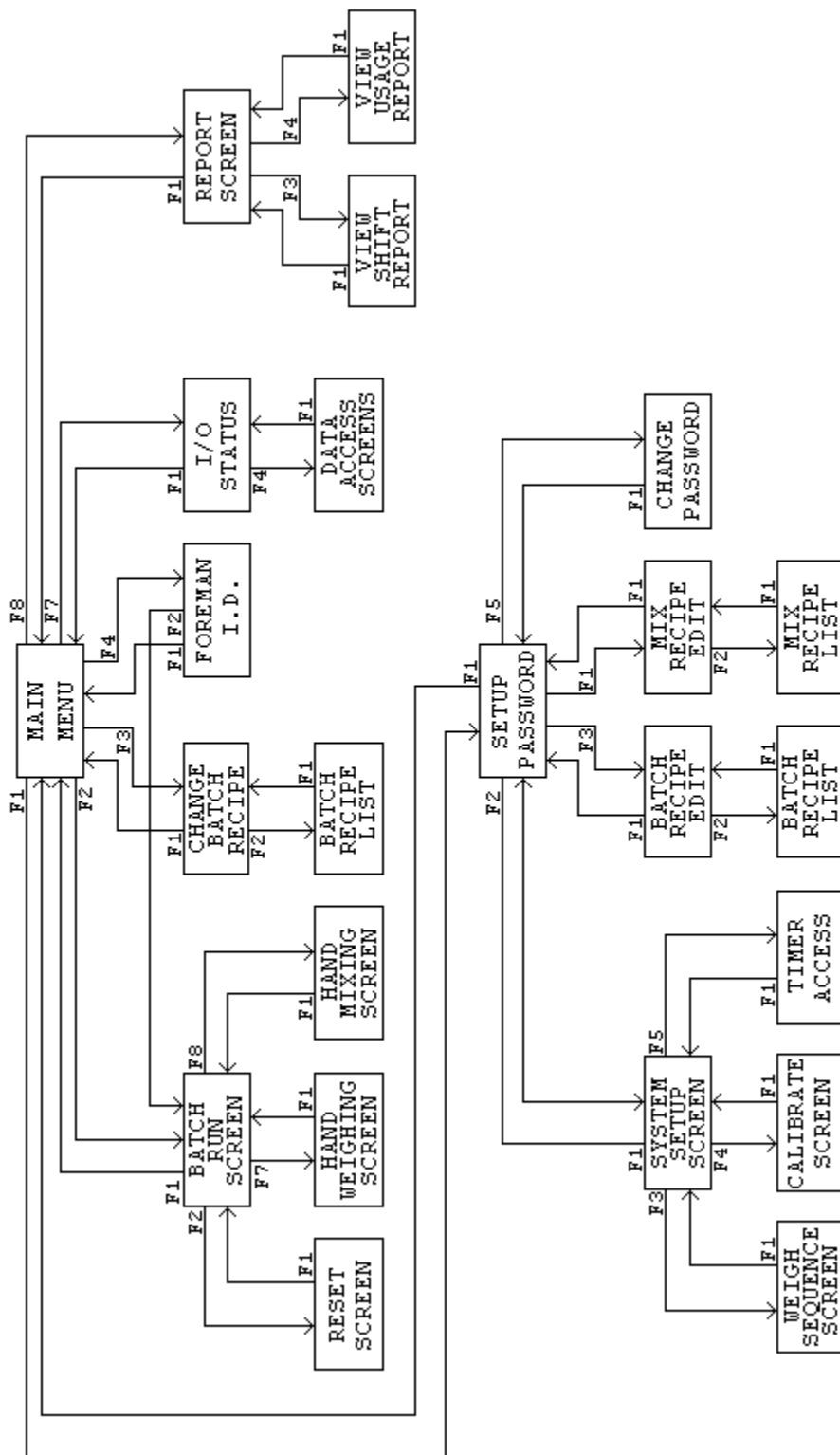
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Screen Map

BATCHING SYSTEM SCREEN MAP

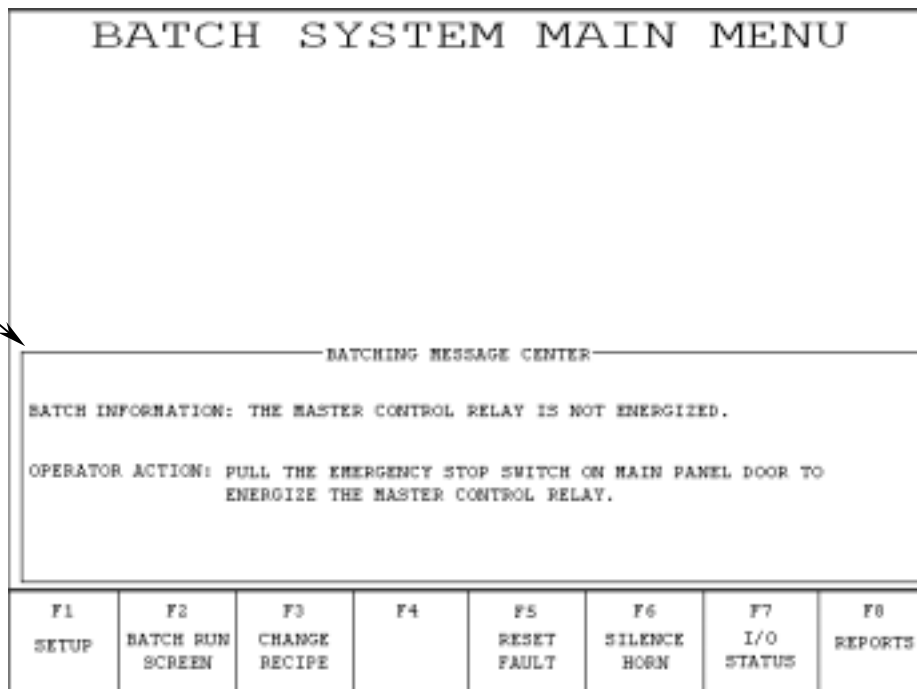


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Screen Explanations:

1) MAIN MENU

The Operator Message Center instructs the operator on how to get an automatic batch started and alerts the operator of any active alarms.



Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	SETUP	Go to Setup Password screen
F2	1	BATCH RUN SCREEN	Go to Batch Run Screen
F3	1	CHANGE BATCH RECIPE	Go to Change Batch Recipe screen
F5	1	RESET FAULT	Push this button to reset a fault. The fault must be reset before changing to another screen.
F6	1	SILENCE HORN	When an alarm is active use this button to silence the horn.
F7	1	I/O STATUS	Go to the I/O Status screen
F8	1	REPORTS	Go to the Reports screen

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2) SETUP PASSWORD SCREEN

This screen allows the operator access to the three main setup areas of the batching system. Each area requires a separate password to access.

F1 MAIN MENU	F2 SYSTEM SETUP	F3 BATCH RECIPE EDIT	F4 MIX RECIPE EDIT	F5 CHANGE PASSWORD	F6	F7	F8
<div style="text-align: center;"> <p>SETUP PASSWORD PROTECTION</p> <p>ENTER PASSWORD</p> <p>SYSTEM SETUP: <input style="width: 60px;" type="password" value="#####"/></p> <p>BATCH RECIPE EDIT: <input style="width: 60px;" type="password" value="#####"/></p> <p>MIX RECIPE EDIT: <input style="width: 60px;" type="password" value="#####"/></p> <p style="margin-top: 20px;">**ALL PASSWORDS MUST BE CORRECT IN ORDER TO ENTER THE CHANGE PASSWORD SCREEN</p> </div>							

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	MAIN MENU	Go back to Main Menu
F2	1	SYSTEM SETUP	Go to System Setup screen if the password is entered correctly
F3	1	BATCH RECIPE EDIT	Go to Batch Recipe Edit screen if the password is entered correctly
F4	1	MIX RECIPE EDIT	Go to Mix Recipe Edit screen if the password is entered correctly
F5	1	CHANGE PASSWORD	Go to Change Password screen if all three passwords are entered correctly

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3) SYSTEM SETUP SCREEN 1

Page 1 of the System Setup screen allows the operator to enter the moisture content of each aggregate, and also set percentage of freefall to add to next batch, range for freefall bias change and the over and under weight alarm limits.

Move the cursor with the \rightarrow arrow keys to select an aggregate moisture percentage to change. Type to number on the keypad, and press the \rightarrow key to confirm the change.

The over and under weight alarm limits determine how far off the actual weight has to be from the preset in order for the alarm to go off.

The percentage of freefall determines how much of the free fall bias will be added or subtracted from the current bias for the next batch.

The range for freefall bias change determines how large off a change in the free fall bias will be used to calculate the percentage to add or subtract.

The material start weight limit determines the maximum weight the hopper can be to weigh the next batch.

SYSTEM SETUP SCREEN PAGE 1

AGGREGATE MOISTURE PERCENTAGE

AGGREGATE1 %

AGGREGATE2 %

AGGREGATE3 %

AGGREGATE4 %

AGGREGATE5 %

AGGREGATE6 %

PERCENTAGE OF FREEFALL TO ADD TO NEXT BATCH %

RANGE FOR FREEFALL BIAS CHANGE AGGREGATE CEMENT

OVER AND UNDER WEIGHT ALARM LIMITS AGGREGATE CEMENT

MATERIAL START WEIGHT LIMIT AGGREGATE CEMENT

F1	F2	F3	F4	F5	F6	F7	F8
SETUP	CHANGE % OF FREEFALL	CHANGE AGGREGATE FF RANGE	CHANGE CEMENT FF RANGE	CHANGE AGGREGATE ALARM LIM	CHANGE CEMENT ALARM LIM	CHANGE AGGREGATE WGT LIM	CHANGE CEMENT WGT LIM

F9 = NEXT PAGE

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	PREV PAGE	Go back to Page 1 of the System Setup screen
F2	1	CHANGE % OF FREEFALL	Press this button to enter the percentage of fall bias that will be added to or subtracted from the next batch.
F3	1	CHANGE AGGREGATE FF RANGE	Press this button to enter a value for the largest amount the aggregate free fall bias can be adjusted by.
F4	1	CHANGE CEMENT FF RANGE	Press this button to enter a value for the largest amount the cement free fall bias can be adjusted by.
F5	1	CHANGE AGGREGATE ALARM LIM	Press this button to enter the maximum difference between the actual and target cement that is allowed before an alarm is generated.
F6	1	CHANGE CEMENT ALARM LIM	Press this button to enter the maximum difference between the actual and target aggregate that is allowed before an alarm is generated.
F7	1	CHANGE AGG START MAX	Push this button to change the maximum amount of weight that the aggregate weigh hopper can have in it to start weighing the next batch.
F8	1	CHANGE CEM START MAX	Push this button to change the maximum amount of weight that the cement weigh hopper can have in it to start weighing the next batch.

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4) SYSTEM SETUP SCREEN 2

Page 2 of the System Setup screen allows the operator to change the name of each material to match the materials that are in each bin and dispenser.

SYSTEM SETUP SCREEN								PAGE 2
ENTER MATERIAL NAMES								
AGG1	<input type="text" value="AGGREGATE1"/>	CEM1	<input type="text" value="CEMENT1"/>	ADMIX1	<input type="text" value="ADMIX1"/>	COLOR1	<input type="text" value="COLOR1"/>	
AGG2	<input type="text" value="AGGREGATE2"/>	CEM2	<input type="text" value="CEMENT2"/>	ADMIX2	<input type="text" value="ADMIX2"/>	COLOR2	<input type="text" value="COLOR1"/>	
AGG3	<input type="text" value="AGGREGATE3"/>	CEM3	<input type="text" value="CEMENT3"/>	ADMIX3	<input type="text" value="ADMIX3"/>			
AGG4	<input type="text" value="AGGREGATE4"/>	CEM4	<input type="text" value="CEMENT4"/>	ADMIX4	<input type="text" value="ADMIX4"/>			
AGG5	<input type="text" value="AGGREGATE5"/>							
AGG6	<input type="text" value="AGGREGATE6"/>							
F1	F2	F3	F4	F5	F6	F7	F8	
PREV PAGE		WEIGH SEQUENCE SCREEN	CALIBRATE LOAD CELLS	TIMER ACCESS		ENABLE AUTO CLUTCH	ENABLE ALARMS	

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	PREV PAGE	Go to Page 1 of the System Setup screen
F3	1	WEIGH SEQUENCE SCREEN	Go to Weigh Sequence screen
F4	1	CALIBRATE LOAD CELLS	Go to Calibrate Load Cell screen
F5	1	TIMER ACCESS	Go to Timer Access screen
F7	1	ENABLE AUTO CLUTCH	Push to enable auto clutch. This will allow the clutch to automatically disengage if batch has been waiting in mixer the preset amount of time.
	2	DISABLE AUTO CLUTCH	Push to turn off the auto clutch option
F8	1	ENABLE ALARMS	Push to enable system alarms.
	2	DISABLE ALARMS	Push to turn off system alarms

Changing Material Names

To change material names use the \leftarrow arrow key to move the cursor to the name that you want to change. Push the $\text{\textcircled{8}}$ key. A blue box containing the alphabet, and numbers will appear. When the scratchpad is active you must use the keys specified on the bottom of the window. When you are done entering the name push the $\text{\textcircled{8}}$ key again.

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5) WEIGH SEQUENCE SCREEN

This screen allows the operator to set the order in which the aggregates and cements are weighed.

WEIGH SEQUENCE SCREEN

1st	Agg1: Agg1		1st	Cem1: Cem1
2nd	Agg2: Agg2		2nd	Cem2: Cem2
3rd	Agg3: Agg3		3rd	Cem3: Cem3
4th	Agg4: Agg4		4th	Cem4: Cem4
5th	Agg5: Agg5			
6th	Agg6: Agg6			

F1	F2	F3	F4	F5	F6	F7	F8
SYSTEM SETUP							

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	SYSTEM SETUP	Go back to Page 1 of the System Setup screen

Changing the Weigh Sequence

To change the weigh sequence of aggregate or cement, use the τv arrow keys to move the cursor between the steps of the weigh sequence. Use the $\pi\theta$ arrow keys to change the material that will be weighed on that step. The number of steps will be determined by the number of aggregates and cements used at plant.

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6) CALIBRATE LOAD CELLS

This screen allows the operator to calibrate the weight signal to an actual weight in the weigh hoppers or a separate scale read out.

CALIBRATE LOAD CELLS							
				AGGREGATE	CEMENT		
LIVE ANALOG VALUE				4000	4000	ANALOG RANGE: 4-20mA 4000-20000	
LIVE SCALED VALUE				0 LBS	0 LBS	0-20mA 0-20000	
ANALOG VALUE @ ZERO				4000	4000		
ANALOG VALUE @ KNOWN WEIGHT				7200	12000		
ENTER KNOWN WEIGHT				2000	LBS	500	LBS
PRESS F3 OR F4 WHEN ZERO HAS BEEN ESTABLISHED FOR THE AGGREGATE OR CEMENT.							
PRESS F5 OR F6 WHEN A KNOWN WEIGHT HAS BEEN ESTABLISHED AND ENTERED FOR THE AGGREGATE OR CEMENT.							
F1 SYSTEM SETUP	F2	F3 SET ZERO FOR AGG	F4 SET ZERO FOR CEM	F5 SET WEIGHT FOR AGG	F6 SET WEIGHT FOR CEM	F7	F8

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	SYSTEM SETUP	Go back to Page 1 of the System Setup screen
F3	1	SET ZERO FOR AGG	Press this button when the aggregate weigh hopper is empty in order to establish zero.
F4	1	SET ZERO FOR CEM	Press this button when the cement weigh hopper is empty in order to establish zero.
F5	1	SET WEIGHT FOR AGG	Press this button when the known weight in the aggregate weigh hopper matches the value entered on the screen.
F6	1	SET WEIGHT FOR CEM	Press this button when the known weight in the cement weigh hopper matches the value entered on the screen.

Steps for Calibrating Load Cells

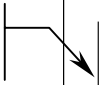
- Aggregate and cement weigh hoppers need to be completely empty. Once that has been verified, "SET ZERO" for aggregate and cement.
- Next a known weight needs to be hung on, or placed in weigh hoppers. Enter the known weight on the screen in the box marked "KNOWN WEIGHT" and push "SET WEIGHT". The weight will then be displayed as "LIVE SCALED VALUE".
- After scale has been calibrated weight should be removed to verify zero, and replaced to verify live scaled value.

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7) TIMER ACCESS SCREEN

This screen allows the operator to adjust selected timers. The timers on the list may change depending on the system configuration. There is also a second page when necessary.

Use the $\pi\theta$ arrow keys to choose the timer preset to change.



TIMER ACCESS				PAGE 1
TIMER	PRESET	CURRENT	DESCRIPTION	
0	0010	0000	AGGREGATE AT TARGET DELAY	
1	0010	0000	CEMENT AT TARGET DELAY	
2	0005	0000	AUTO DELAY	
3	0005	0000	CLOSE AGG WEIGH HOPPER GATE DELAY	
4	0030	0000	AGG BELT STOP DELAY	
5	0005	0000	CLOSE CEMENT WEIGH HOPPER GATE DELAY	
6	0030	0000	CLOSE MIXER DOOR DELAY	
7	0010	0000	RUN MUD BELT DELAY	
8	0020	0000	STOP MUD BELT DELAY	
9	0030	0000	GATE AND BELT ALARM DELAY	
10	0010	0000	METERING BELT OFF DELAY	
11	0060	0000	DISENGAGE CLUTCH DELAY	

F1
SYSTEM
SETUP

F2
NEXT
PAGE

F3

F4
CHANGE
PRESET

F5

F6

F7

F8

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	SYSTEM SETUP	Go back to Page 1 of the System Setup screen
F2	1	NEXT PAGE	Go to the next Timer Access screen
F4	1	CHANGE PRESET	Press to change the currently selected timer preset.

Explanation of Typical Adjustable Timers

- Aggregate and cement at target delay is the amount of settling time that is required before weighing the next material.
- Auto delay is the time that elapses between the selector switch being turned to auto and the system starting automatically.
- Close agg and cement weigh hopper gate delay is the time that the gate will stay open after the total weight has dropped below the max start weight for agg or cement.
- Agg belt stop delay is the amount of time required to clear the belt of material once the scale is below the max start weight.
- Close mixer door delay is the time that the door will stay open after the mud holding hopper low signal has been activated or the total time for the mixer to clear the mud from the mixer depending on the system's configuration.
- Gate and belt alarm delay is the time that the batching waits to active an alarm when an alarm situation arises.

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8) BATCH RECIPE EDIT

This screen allows the operator with the appropriate password to edit batch recipes.

Use the \uparrow \downarrow arrow keys to move the cursor to each value to be entered.

BATCH RECIPE EDIT

CURRENTLY EDITING RECIPE NUMBER: 1

RECIPE NAME	AGGREGATE1	AGGREGATE2	AGGREGATE3	AGGREGATE4
BATCH 1	500	500	500	500
	LBS	LBS	LBS	LBS
AGGREGATE5	AGGREGATE6	CEMENT1	CEMENT2	CEMENT3
500	500	500	500	500
		LBS	LBS	LBS
ADMIX1	ADMIX2	ADMIX3	ADMIX4	COLOR1
20	20	20	20	20
		OZS	OZS	OZS

ENTER RECIPE NUMBER TO EDIT: 1

F1	F2	F3	F4	F5	F6	F7	F8
SETUP	RECIPE LIST	ENTER RECIPE#	STORE RECIPE				

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	SETUP	Go back to Setup Password screen
F2	1	RECIPE LIST	Go to Recipe List screen
F3	1	ENTER RECIPE#	Press this button to enter the recipe number you want to edit.
F4	1	STORE RECIPE	Press this button once the recipe name and values have been entered to store the currently selected recipe number.

Editing a Batch Recipe

To edit a batch recipe push F3 and enter the number of the recipe to load. Use the \uparrow \downarrow arrow key to move the cursor to the recipe name or material amount that you want to change. If you want to change the recipe name move the cursor to the recipe name box and push the $\text{\textcircled{8}}$ key. A blue box containing the alphabet, and numbers will appear. When the scratchpad is active you must use the keys specified on the bottom of the window. When you are done entering the name push the $\text{\textcircled{8}}$ key again. If you do not know the number of the recipe that you want to edit, refer to the recipe list. The recipe list can be accessed using F2 on the EDIT BATCH RECIPE screen. To change a material amount move the cursor to the corresponding entry field and enter the amount desired using 0 – 9 on the keypad. Push $\text{\textcircled{8}}$ key once amount has been entered.

** Be sure to push “STORE” (F4) when finished or recipe will not be saved. **

If you edit the recipe that you are currently running you must re-enter the recipe to run. This means after you make changes to and then store the recipe, you must go to the CHANGE RECIPE screen and re-enter the recipe number to run for the changes that were made to take effect.

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9) BATCH RECIPE LIST

This screen shows a list of the batch recipe names and provides a way of entering the recipe number to edit. There are two other screens for the rest of the recipes.

BATCH RECIPE NAME LIST			Page 1
RECIPE NAME	RECIPE NAME	RECIPE NAME	
1 RECIPE1	16 RECIPE16	31 RECIPE31	
2 RECIPE2	17 RECIPE17	32 RECIPE32	
3 RECIPE3	18 RECIPE18	33 RECIPE33	
4 RECIPE4	19 RECIPE19	34 RECIPE34	
5 RECIPE5	20 RECIPE20	35 RECIPE35	
6 RECIPE6	21 RECIPE21	36 RECIPE16	
7 RECIPE7	22 RECIPE22	37 RECIPE36	
8 RECIPE8	23 RECIPE23	38 RECIPE38	
9 RECIPE9	24 RECIPE24	39 RECIPE39	
10 RECIPE10	25 RECIPE25	40 RECIPE40	
11 RECIPE11	26 RECIPE26	41 RECIPE41	
12 RECIPE12	27 RECIPE27	42 RECIPE42	
13 RECIPE13	28 RECIPE28	43 RECIPE43	
14 RECIPE14	29 RECIPE29	44 RECIPE44	
15 RECIPE15	30 RECIPE30	45 RECIPE45	
ENTER RECIPE NUMBER TO EDIT: <input style="width: 50px;" type="text" value="22"/>			
F1 CHANGE BATCH RECIPE	F2 NEXT PAGE	F3 ENTER RECIPE#	F4 F5 F6 F7 F8

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	BATCH RECIPE EDIT	Return to the Batch Recipe Edit screen
	2	CHANGE BATCH RECIPE	Return to the Change Batch Recipe screen
F2	1	NEXT PAGE	Go to page 2 of the Recipe List
F3	1	ENTER RECIPE#	Press this button to change the recipe number to edit. This will also automatically change the screen to either the Edit Batch Recipe or Change Batch Recipe screen.

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10) MIX RECIPE EDIT

This screen allows a mix recipe to be edited. A mix recipe determines in which order the materials are entered into the mixer and how long each material is mixed before the next material is entered.

Use the $\tau \nu$ arrow keys to move between each step and use the $\pi \theta$ arrow keys to select a material for each step. Be sure to use an "END SEQUENCE" for the last step if all seven steps are not used.

MIX RECIPE EDIT

CURRENTLY EDITING RECIPE NUMBER: 10

RECIPE NAME:

MIX DELAY FOR EACH
STEP IN SECONDS
(0-999 sec)

STEP 1:	Add Aggregate	1
STEP 2:	Prewet	1
STEP 3:	Add Admix/Color1	15
STEP 4:	Add Cement	1
STEP 5:	Add Admix/Color2	20
STEP 6:	Add Final Water	10
STEP 7:	Add Admix/Color3	30

****IF ALL OF THE STEPS ARE NOT USED
(1-7), PLACE AN "END SEQUENCE" AS
THE FINAL STEP. THIS WILL SIGNAL
THE END OF THE CURRENT SEQUENCE.****

ENTER RECIPE NUMBER TO EDIT:

F1	F2	F3	F4	F5	F6	F7	F8
SETUP	RECIPE LIST	ENTER RECIPE#	STORE RECIPE				

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	SETUP	Go back to Setup Password screen
F2	1	RECIPE LIST	Go to Recipe List screen
F3	1	ENTER RECIPE#	Press this button to enter the recipe number you want to edit.
F4	1	STORE RECIPE	Press this button once the recipe name and values have been entered to store the currently selected recipe number.

Editing a Mix Recipe

To edit a mix recipe push F3 and enter the number of the recipe to load. Use the $\tau \nu$ arrow keys to move the cursor to the recipe name, mix step, or mix delay that you want to change. If you want to change the recipe name move the cursor to the recipe name box and push the 8 key. A blue box containing the alphabet, and numbers will appear. When the scratchpad is active you must use the keys specified on the bottom of the window. When you are done entering the name push the 8 key again. If you do not know the number of the recipe that you want to edit, refer to the recipe list. The recipe list can be accessed using F2 on the EDIT MIX RECIPE screen. To change a mix step use the $\tau \nu$ arrow keys to move the cursor to the corresponding entry field and use the $\pi \theta$ arrow keys to change the material added on that step. Once the mix steps are set to add desired materials use the $\tau \nu$ arrow keys to enter mix delay time after each step used.

** If all seven steps are not used place an "END SEQUENCE" after the final step used. **

** Be sure to push "STORE" (F4) when finished or recipe will not be saved. **

** If you edit the recipe that you are currently running you must re-enter the recipe to run. This means after you make changes to and then store the recipe, you must go to the CHANGE RECIPE screen and re-enter the recipe number to run for the changes that were made to take effect.**

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11) MIX RECIPE LIST

This screen shows a list of the mix recipe names and provides a way of entering the recipe number to edit.

MIX RECIPE LIST							
RECIPE NAME	RECIPE NAME	RECIPE NAME	RECIPE NAME	RECIPE NAME	RECIPE NAME	RECIPE NAME	RECIPE NAME
1	MIX1	17	MIX17	33	MIX33		
2	MIX2	18	MIX18	34	MIX34		
3	MIX3	19	MIX19	35	MIX35		
4	MIX4	20	MIX20	36	MIX36		
5	MIX5	21	MIX21	37	MIX37		
6	MIX6	22	MIX22	38	MIX38		
7	MIX7	23	MIX23	39	MIX39		
8	MIX8	24	MIX24	40	MIX40		
9	MIX9	25	MIX25	41	MIX41		
10	MIX10	26	MIX26	42	MIX42		
11	MIX11	27	MIX27	43	MIX43		
12	MIX12	28	MIX28	44	MIX44		
13	MIX13	29	MIX29	45	MIX45		
14	MIX14	30	MIX30	46	MIX46		
15	MIX15	31	MIX31	47	MIX47		
16	MIX16	32	MIX32	48	MIX48		
ENTER RECIPE NUMBER TO EDIT: <input style="width: 50px;" type="text" value="10"/>							
F1 MIX RECIPE EDIT	F2	F3 ENTER RECIPE#	F4	F5	F6	F7	F8

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	MIX RECIPE EDIT	Go back to Mix Recipe Edit screen
F3	1	ENTER RECIPE#	Push this button and enter the number of the recipe you want to edit

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12) CHANGE PASSWORD

The Change Password screen allows the operator to change any of the three passwords and also the passwords can be disabled or enabled from this screen.

CHANGE PASSWORD SCREEN							
ENTER PASSWORD							
		SYSTEM SETUP:		#####			
		BATCH RECIPE EDIT:		#####			
		MIX RECIPE EDIT:		#####			
F1	F2	F3	F4	F5	F6	F7	F8
SETUP SCREEN		DISABLE PASSWORDS					

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	SETUP SCREEN	Go back to Setup Password screen
F3	1	DISABLE PASSWORDS	Currently passwords are enabled if this button is pressed the passwords will be disabled.
	2	ENABLE PASSWORDS	Currently passwords are disabled if this button is pressed the passwords will be enabled.

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13) BATCH RUN SCREEN

This screen allows the Batching System to be monitored as well as providing a means to reach all the screens necessary to setup and run the system.

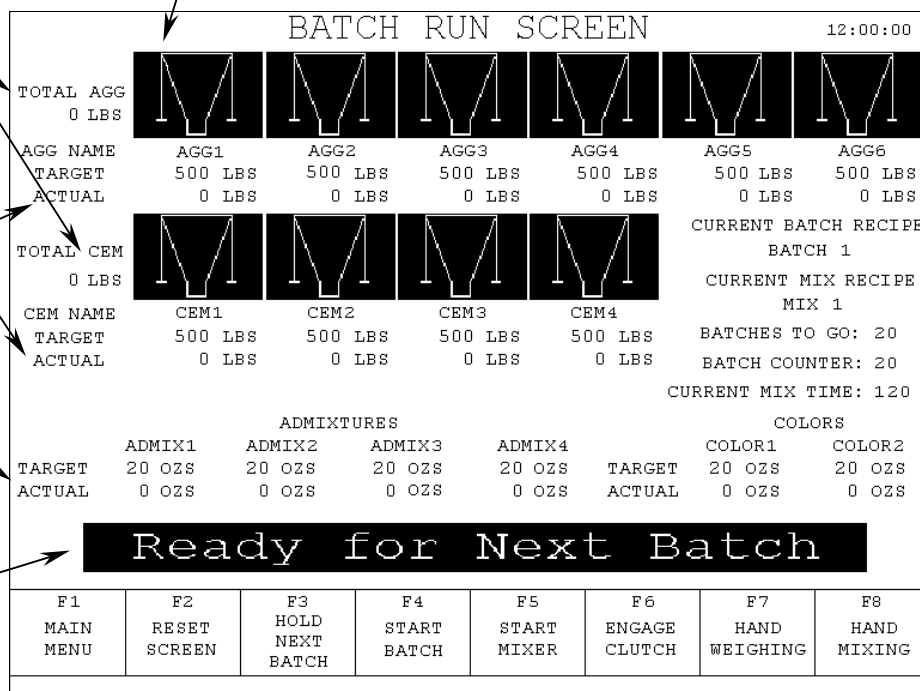
The material bin graphics indicate the status of the bins they are:
green if target is not zero and material not currently weighing,
blue if materials' the target is zero,
flashing yellow if the material is currently weighing
flashing red if the materials gate or belt is open or running and not in auto

Shows the actual weight of the material in the agg & cem weigh hopper at all times.

Target is the amount of material that is to be weighed for each batch
Actual shows the amount of material weighed during the last batch

The target and actual for the admixtures and colors are used only if the batch panel weighs or measures them. A target value is required for the inventory report data.

Mix status indicator



Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	MAIN MENU	Go to Setup Password screen
F2	1	RESET SCREEN	Go to Reset screen
F3	1	HOLD NEXT BATCH	Push this button to hold the next batch in the weigh hoppers
	2	MIX NEXT BATCH	Push this button to release the held into the mixer.
F4	1	START BATCH	The batch is not currently running, if pressed and the auto light is on, the batch will start
	2	STOP BATCH	The batch is currently running, if pressed the batch will stop if the aggregate and cement are done weighing
	3	LAST BATCH	Flashes when Stop batch has been pressed and the agg and/or the cem is not done weighing, or has not been dumped into mixer.
F5	1	START MIXER	The mixer is not running, if pressed the mixer will start if the hand or auto light is on
	2	STOP MIXER	The mixer is running, if pressed the mixer will stop and the clutch will disengage
F6	1	ENGAGE CLUTCH	The clutch is not engaged, if pressed and the mixer is on the clutch will engage
	2	DISENGAGE CLUTCH	The clutch is engaged, if pressed the clutch will disengage
F7	1	HAND WEIGHING	Go to the Hand Controls for Weighing screen if the hand-off-auto selector switch is in the hand position.
F8	1	HAND MIXING	Go to the Hand Controls for Mixing screen if the hand-off-auto selector switch is in the hand position.

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Bin indicator colors

- **BLUE:** The material is not used in the recipe that is currently running.
- **GREEN:** The material is used in the recipe that is currently running, and is idle.
- **YELLOW:** The material is being weighed, but it is on hold.
- **YELLOW FLASHING:** The material is being weighed and the gate is open or the screw is running.
- **RED FLASHING:** The gate is open, or the screw is running when the material is not being weighed.

Starting a Batch

To start a batch there are some conditions that have to be met. The first thing to do is to put the HAND OFF AUTO selector switch on the door in auto. Verify that BATCHES TO GO is greater than zero, and that the aggregate and cement scales are both their max start weight. Push the HOLD/RESTART WEIGH CYCLE pushbutton on the door to take the weigh cycle off of hold. Make sure that the batch and mix recipe's that are running are the ones that you want to use. Push "START BATCH" (F4) to start batching. The indicator should change to "STOP BATCH" in red. Just push F4 again when you want to stop batching or change a batch recipe.

To enter the number of batches to run, go the CHANGE RECIPE screen and push "ENTER NUMBER OF BATCHES" (F4). Type in the number that you want to run or type 99 and continuous batching will occur until "STOP BATCH" (F4) is pressed on the BATCH RUN screen.

To change the max start weight go to SYSTEM SETUP screen 1 and enter a new aggregate start weigh by pushing "CHANGE AGGREGATE WGHT LIM" (F7). Change cement start weight by pushing "CHANGE CEMENT WGHT LIM" (F8).

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14) RESET SCREEN

The Reset Screen is a tool for altering the state of the system. The operator can reset the mix and weigh cycles and set and reset the material done weighing bits. The operator can also adjust the material freefall values on this screen.

RESET SCREEN							
AGG NAME	AGG1	AGG2	AGG3	AGG4	AGG5	AGG6	
TARGET	500 LBS	500 LBS	500 LBS	500 LBS	500 LBS	500 LBS	
CURRENT FREEFALL	40.00	40.00	40.00	40.00	40.00	40.00	
ENTER NEW FREEFALL	<input type="text" value="40.00"/> LBS	<input type="text" value="40.00"/> LBS	<input type="text" value="40.00"/> LBS	<input type="text" value="40.00"/> LBS	<input type="text" value="40.00"/> LBS	<input type="text" value="40.00"/> LBS	
CEM NAME	CEM1	CEM2	CEM3	CEM4			
TARGET	500 LBS	500 LBS	500 LBS	500 LBS			
CURRENT FREEFALL	10.00	10.00	10.00	10.00			
ENTER NEW FREEFALL	<input type="text" value="10.00"/> LBS	<input type="text" value="10.00"/> LBS	<input type="text" value="10.00"/> LBS	<input type="text" value="10.00"/> LBS			
F1	F2	F3	F4	F5	F6	F7	F8
BATCH RUN SCREEN		RESET MIX CYCLE		SET AGG DONE WEIGHING	SET CEM DONE WEIGHING		
F9	F10	F11	F12	F13	F14	F15	F16
		RESET WEIGH CYCLE		RESET AGG DONE WEIGHING	RESET CEM DONE WEIGHING		

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	BATCH RUN SCREEN	Go back to Batch Run screen
F3	1	RESET MIX CYCLE	Press this when the mix cycle is on hold to set the mix cycle to step one.
F5	1	SET AGG DONE WEIGHING	Push this button to tell the system that all the aggregate is weighed up.
F6	1	SET CEM DONE WEIGHING	Push this button to tell the system that all the cement is weighed up.
F11	1	RESET WEIGH CYCLE	Press this when the weigh cycle is on hold to reset the weigh cycle.
F13	1	RESET AGG DONE WEIGHING	Push this button to tell the system that there is no aggregate weighed up.
F14	1	RESET CEM DONE WEIGHING	Push this button to tell the system that there is no cement weighed up.

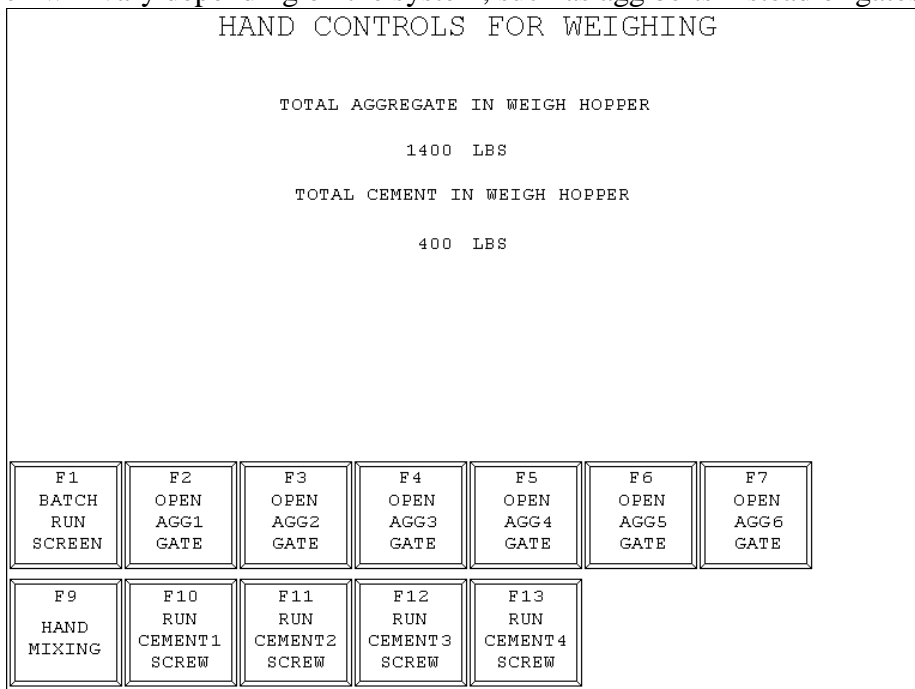
Adjusting Freefall

To change a material's use the \uparrow \downarrow arrow keys to move the cursor to freefall that you want to change. Once the cursor is in position, use 0 – 9 on the keypad to enter a new freefall value, and then push 8 key.

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15) HAND CONTROLS FOR WEIGHING

The Hand Weighing screen provides a means for the operator to manually operate all of the weighing functions of the system. This screen will vary depending on the system, such as agg belts instead of gates.

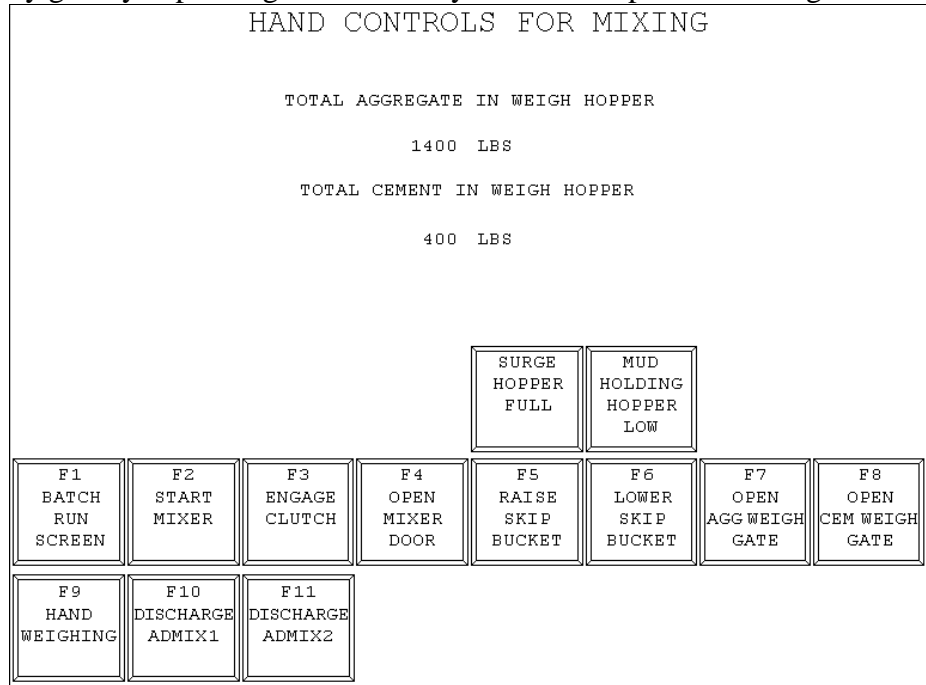


Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	BATCH RUN SCREEN	Go back to Batch Run screen
F2-F7	1	OPEN AGG GATE	When one of these buttons is pressed the appropriate aggregate gate will open or belt will run and when it is released the gate will close or the belt will stop.
F9	1	HAND MIXING	Go to the Hand Controls for Mixing
F10-F13	1	RUN CEMENT SCREW	When one of these buttons is pressed the appropriate cement screw will run and when it is released the screw will stop. If there is also a cement gate it will open at the same time that the cement screw runs.

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16) HAND CONTROLS FOR MIXING

The Hand Mixing screen provides a means for the operator to manually operate all of the mixing functions of the system. This screen will vary greatly depending on the conveyor and/or skip loader configurations.



Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	BATCH RUN SCREEN	Go back to Batch Run screen
F2	1	START MIXER	The mixer is not running, press the button to start the mixer.
	2	MIXER RUNNING PUSH F2 TO STOP	The mixer is running, press the button to stop the mixer.
F3	1	ENGAGE CLUTCH	The clutch is disengaged, press the button to engage the clutch.
	2	CLUTCH ENGAGED F3 TO DISENGAGE	The clutch is engaged, press the button to disengage the clutch.
F4	1	OPEN MIXER DOOR	The mixer door is closed, press the button to open the door.
	2	MIXER DOOR OPEN PUSH F4 TO CLOSE	The mixer door is open, press the button to close the door.
F5	1	RAISE SKIP BUCKET	The skip bucket is not in the up position, press the button to raise the skip.
	2	SKIP BUCKET UP	The skip bucket is in the up position, nothing will happen if the button is pressed.
F6	1	LOWER SKIP BUCKET	The skip bucket is not in the down position, press the button to lower the skip.
	2	SKIP BUCKET DOWN	The skip bucket is in the down position, nothing will happen if the button is pressed.
F7	1	OPEN AGG WEIGH GATE	Press this button to open the aggregate weigh hopper gate, release the button to close the gate.
F8	1	OPEN CEM WEIGH GATE	Press this button to open the cement weigh hopper gate, release the button to close the gate.
F9	1	HAND WEIGHING	Go to the Hand Controls for Mixing
F10-F11	1	DISCHARGE ADMIX	When one of these buttons is pressed the appropriate admix is discharged and when it is released the admix will stop discharging.

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17) CHANGE RECIPE

The Change Recipe screen allows the operator to select different batch and mix recipes to run. Also the batch counter is cleared from this screen.

CHANGE RECIPE							
CURRENTLY RUNNING BATCH RECIPE NUMBER: 10							
RECIPE NAME: RECIPE10							
AGGREGATES		CEMENTS			ADDMIXES		
AGG1	500 LBS	CEM1	500 LBS	ADDMIX1	20 OZS		
AGG2	500 LBS	CEM2	500 LBS	ADDMIX2	20 OZS		
AGG3	500 LBS	CEM3	500 LBS	ADDMIX3	20 OZS		
AGG4	500 LBS	CEM4	500 LBS	ADDMIX4	20 OZS		
AGG5	500 LBS				COLORS		
AGG6	500 LBS				MIX RECIPE # 1	COLOR1	20 OZS
					MIX RECIPE NAME MIX 1	COLOR2	20 OZS
ENTER BATCH RECIPE NUMBER TO RUN:				<input type="text" value="10"/>			
NUMBER OF BATCHES TO RUN:				<input type="text" value="15"/>			
ENTER MIX RECIPE NUMBER TO RUN:				<input type="text" value="1"/>			
							BATCH COUNT: 20
F1	F2	F3	F4	F5	F6	F7	F8
BATCH RUN SCREEN	RECIPE LIST	ENTER BATCH RECIPE#	ENTER# OF BATCHES	ENTER MIX RECIPE#	MIX RECIPE LIST	CLEAR BATCH COUNT	

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	BATCH RUN SCREEN	Go back to the Batch Run screen
F2	1	RECIPE LIST	Go to page 1 of the Batch Recipe List
F3	1	ENTER BATCH RECIPE#	Press to change the batch recipe currently running. The recipe can only be changed if the batch is not running or the weigh cycle is on hold and the aggregate and cement are done weighing.
F4	1	ENTER# OF BATCHES	Enter the number of batches that you want to run before stopping. If 99 is entered batching will continue until "Stop Batch" is pressed.
F5	1	ENTER MIX RECIPE#	Press to change the mix recipe currently running. The recipe can only be changed if the mixer is "Ready for Next Batch".
F6	1	MIX RECIPE LIST	Go to page that displays the Mix Recipe List
F7	1	CLEAR BATCH COUNT	Press to clear the batch count.

Changing a Batch Recipe

To change a batch recipe there are some conditions that have to be met. The first thing to do is push "STOP BATCH"(F4) on the Batch Run Screen. Once the aggregate and cement are done weighing, you can go to the Change Recipe screen, and ENTER BATCH RECIPE # (F3). If you don't want to stop batch, then you can also put the weigh cycle on hold before the aggregate and cement start weighing, and then change the recipe. If you do not know the recipe number, refer to the batch recipe list (F2) and look for batch recipe name and/or number that you want to run.

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Changing a Mix Recipe

To change a mix recipe the mixer has to be Ready For Next Batch. (This is what the mix status indicator on the Batch Run Screen must say to change the mix recipe) If the mixer is empty, the door is closed, and the mix status indicator does not say Ready For Next Batch, go to the Reset Screen and push “RESET MIX CYCLE” (F3) Once Ready For Next Batch is obtained go to the Change Recipe screen and ENTER MIX RECIPE # (F5). If you do not know the recipe number, refer to the mix recipe list (F6) and look for mix recipe name and/or number that you want to run.

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18) I/O STATUS

The I/O Status screens displays the status of the inputs and outputs of the PLC. The number of screens required to display this information will vary depending on the system.

INPUT/OUTPUT STATUS				PAGE 1			
ADDRESS	STATUS	DESCRIPTION		ADDRESS	STATUS	DESCRIPTION	
I: 6/00	OFF	HAND		I: 7/00	OFF	AGG BELT RUNNING	
I: 6/01	ON	AUTO		I: 7/01	OFF	CEM WEIGH HOPPER OPEN	
I: 6/02	OFF	AGG1 GATE OPEN		I: 7/02	ON	CEM WEIGH HOPPER CLOSED	
I: 6/03	ON	AGG1 GATE CLOSED		I: 7/03	OFF	CEMENT SCREW RUNNING	
I: 6/04	OFF	AGG2 GATE OPEN		I: 7/04	ON	MIXER RUNNING	
I: 6/05	ON	AGG2 GATE CLOSED		I: 7/05	OFF	MIXER DOOR OPEN	
I: 6/06	OFF	AGG3 GATE OPEN		I: 7/06	ON	MIXER DOOR CLOSED	
I: 6/07	ON	AGG3 GATE CLOSED		I: 7/07	ON	MUD HOLDING HOPPER LOW	
I: 6/08	OFF	AGG4 GATE OPEN		I: 7/08	OFF	MUD BELT RUNNING	
I: 6/09	ON	AGG4 GATE CLOSED		I: 7/09	OFF	SURGE HOPPER HI	
I: 6/10	OFF	CEMENT GATE OPEN		I: 7/10	ON	SURGE HOPPER LO	
I: 6/11	ON	CEMENT GATE CLOSED		I: 7/11	ON	PREWET COMPLETE	
I: 6/12	OFF	SPARE		I: 7/12	ON	FINAL WET COMPLETE	
I: 6/13	OFF	SPARE		I: 7/13	OFF	PREWET IN PROGRESS	
I: 6/14	OFF	AGG WEIGH HOPPER OPEN		I: 7/14	OFF	FINAL WET IN PROGRESS	
I: 6/15	ON	AGG WEIGH HOPPER CLOSED		I: 7/15	ON	MCR ENERGIZED	

F1	F2	F3	F4	F5	F6	F7	F8
MAIN MENU	NEXT PAGE		DIAGNOSTIC SCREENS				

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	MAIN MENU	Go back to the Main Menu
F2	1	NEXT PAGE	Go to page 2 of the I/O Status
F4	1	DIAGNOSTIC SCREENS	Go to the first of the Diagnostic Screens which is the Data Table Display-Status File screen.

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19) DATA TABLE DISPLAY-STATUS

This screen displays the status file of the PLC and can be helpful in diagnosing certain problems when assisted by a service technician.

DATA TABLE DISPLAY															
STATUS WORD S2:00							WORD VALUE 00050								
BIT NUMBER															
15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0
0	0	0	0	0	0	0	0	0	0	1	1	0	0	1	0
F1 I/O STATUS	F2 SLC500 STATUS (S)	F3 CONTROL RELAY (B)	F4 TIMER PRESET (T.PRE)	F5 COUNTER PRESET (C.PRE)	F6 COUNTER ACCUM. (C.ACC)	F7 INTEGER VALUE (N)	F8 FLOAT VALUE (F)								
SLC-5/04 Error Code: 0 (0=NO FAULT)															

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	I/O STATUS	Go to the I/O Status screen
F2	1	SLC500 STATUS (S)	Press this button to change the status word that is currently being displayed.
F3	1	CONTROL RELAY (B)	Change to the Control Relay display screen
F4	1	TIMER PRESET (T.PRE)	Change to the Timer Preset display screen
F5	1	COUNTER PRESET (C.PRE)	Change to the Counter Preset display screen
F6	1	COUNTER ACCUM. (C.ACC)	Change to the Counter Accum display screen
F7	1	INTEGER VALUE (N)	Change to the Integer Value display screen
F8	1	FLOAT VALUE (F)	Change to the Float Value display screen

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20) DATA TABLE DISPLAY-BIT

This screen displays the bit (control relay) file of the PLC and can be helpful in diagnosing certain problems when assisted by a service technician.

DATA TABLE DISPLAY															
BIT ADDRESS B3/050							BIT VALUE 0								
BIT NUMBER															
15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0
F1 I/O STATUS	F2 SLC500 STATUS (S)	F3 CONTROL RELAY (B)	F4 TIMER PRESET (T.PRE)	F5 COUNTER PRESET (C.PRE)	F6 COUNTER ACCUM. (C.ACC)	F7 INTEGER VALUE (N)	F8 FLOAT VALUE (F)								

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	I/O STATUS	Go to the I/O Status screen
F2	1	SLC500 STATUS (S)	Change to the SLC500 Status display screen
F3	1	CONTROL RELAY (B)	Press this button to change the bit number that is currently being displayed.
F4	1	TIMER PRESET (T.PRE)	Change to the Timer Preset display screen
F5	1	COUNTER PRESET (C.PRE)	Change to the Counter Preset display screen
F6	1	COUNTER ACCUM. (C.ACC)	Change to the Counter Accum display screen
F7	1	INTEGER VALUE (N)	Change to the Integer Value display screen
F8	1	FLOAT VALUE (F)	Change to the Float Value display screen

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21) DATA TABLE DISPLAY-TIMER PRESET

This screen displays the timer preset file of the PLC and can be helpful in diagnosing certain problems when assisted by a service technician.

DATA TABLE DISPLAY															
TIMER PRESET T4:00								PRESET VALUE 0050							
BIT NUMBER															
15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0
0	0	0	0	0	0	0	0	0	0	1	1	0	0	1	0
F1 I/O STATUS	F2 SLC500 STATUS (S)	F3 CONTROL RELAY (B)	F4 TIMER PRESET (T.PRE)	F5 COUNTER PRESET (C.PRE)	F6 COUNTER ACCUM. (C.ACC)	F7 INTEGER VALUE (N)	F8 FLOAT VALUE (F)								

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	I/O STATUS	Go to the I/O Status screen
F2	1	SLC500 STATUS (S)	Change to the SLC500 Status display screen
F3	1	CONTROL RELAY (B)	Change to the Control Relay display screen
F4	1	TIMER PRESET (T.PRE)	Press this button to change the timer preset that is currently being displayed.
F5	1	COUNTER PRESET (C.PRE)	Change to the Counter Preset display screen
F6	1	COUNTER ACCUM. (C.ACC)	Change to the Counter Accum display screen
F7	1	INTEGER VALUE (N)	Change to the Integer Value display screen
F8	1	FLOAT VALUE (F)	Change to the Float Value display screen

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22) DATA TABLE DISPLAY-COUNTER PRESET

This screen displays the counter preset file of the PLC and can be helpful in diagnosing certain problems when assisted by a service technician.

DATA TABLE DISPLAY															
COUNTER PRESET C5:00							PRESET VALUE 0050								
BIT NUMBER															
15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0
0	0	0	0	0	0	0	0	0	0	1	1	0	0	1	0
F1 I/O STATUS	F2 SLC500 STATUS (S)	F3 CONTROL RELAY (B)	F4 TIMER PRESET (T.PRE)	F5 COUNTER PRESET (C.PRE)	F6 COUNTER ACCUM. (C.ACC)	F7 INTEGER VALUE (N)	F8 FLOAT VALUE (F)								

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	I/O STATUS	Go to the I/O Status screen
F2	1	SLC500 STATUS (S)	Change to the SLC500 Status display screen
F3	1	CONTROL RELAY (B)	Change to the Control Relay display screen
F4	1	TIMER PRESET (T.PRE)	Change to the Timer Preset display screen
F5	1	COUNTER PRESET (C.PRE)	Press this button to change the counter preset that is currently being displayed.
F6	1	COUNTER ACCUM. (C.ACC)	Change to the Counter Accum display screen
F7	1	INTEGER VALUE (N)	Change to the Integer Value display screen
F8	1	FLOAT VALUE (F)	Change to the Float Value display screen

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23) DATA TABLE DISPLAY-COUNTER ACCUM

This screen displays the counter accum file of the PLC and can be helpful in diagnosing certain problems when assisted by a service technician.

DATA TABLE DISPLAY															
COUNTER ACCUM. C5:00							INNER VALUE 0050								
BIT NUMBER															
15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0
0	0	0	0	0	0	0	0	0	0	1	1	0	0	1	0
F1	F2	F3	F4	F5	F6	F7	F8								
I/O STATUS	SLC500 STATUS (S)	CONTROL RELAY (B)	TIMER PRESET (T.PRE)	COUNTER PRESET (C.PRE)	COUNTER ACCUM. (C.ACC)	INTEGER VALUE (N)	FLOAT VALUE (F)								

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	I/O STATUS	Go to the I/O Status screen
F2	1	SLC500 STATUS (S)	Change to the SLC500 Status display screen
F3	1	CONTROL RELAY (B)	Change to the Control Relay display screen
F4	1	TIMER PRESET (T.PRE)	Change to the Timer Preset display screen
F5	1	COUNTER PRESET (C.PRE)	Change to the Counter Preset display screen
F6	1	COUNTER ACCUM. (C.ACC)	Press this button to change the counter accum that is currently being displayed.
F7	1	INTEGER VALUE (N)	Change to the Integer Value display screen
F8	1	FLOAT VALUE (F)	Change to the Float Value display screen

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24) DATA TABLE DISPLAY-INTEGER

This screen displays an integer file of the PLC and can be helpful in diagnosing certain problems when assisted by a service technician.

DATA TABLE DISPLAY															
INTEGER WORD N7:00								WORD VALUE 00050							
BIT NUMBER															
15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0
0	0	0	0	0	0	0	0	0	0	1	1	0	0	1	0
F1	F2	F3	F4	F5	F6	F7	F8								
I/O STATUS	SLC500 STATUS (S)	CONTROL RELAY (B)	TIMER PRESET (T.PRE)	COUNTER PRESET (C.PRE)	COUNTER ACCUM. (C.ACC)	INTEGER WORD NUMBER	FLOAT VALUE (F)								
PRESS F9 TO CHANGE INTEGER FILE															

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	I/O STATUS	Go to the I/O Status screen
F2	1	SLC500 STATUS (S)	Change to the SLC500 Status display screen
F3	1	CONTROL RELAY (B)	Change to the Control Relay display screen
F4	1	TIMER PRESET (T.PRE)	Change to the Timer Preset display screen
F5	1	COUNTER PRESET (C.PRE)	Change to the Counter Preset display screen
F6	1	COUNTER ACCUM. (C.ACC)	Change to the Counter Accum display screen
F7	1	INTEGER WORD NUMBER	Press this button to change the integer word that is currently being displayed.
F8	1	FLOAT VALUE (F)	Change to the Float Value display screen
F9	1	CHANGE INTEGER FILE	Press this button to change the integer file that is currently being displayed.

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25) DATA TABLE DISPLAY-FLOAT

This screen displays a floating point file of the PLC and can be helpful in diagnosing certain problems when assisted by a service technician.

DATA TABLE DISPLAY															
FLOATING POINT WORD F8:00							WORD VALUE 000050								
BIT NUMBER															
15	14	13	12	11	10	9	8	7	6	5	4	3	2	1	0
0	0	0	0	0	0	0	0	0	0	1	1	0	0	1	0
F1 I/O STATUS	F2 SLC500 STATUS (S)	F3 CONTROL RELAY (B)	F4 TIMER PRESET (T.PRE)	F5 COUNTER PRESET (C.PRE)	F6 COUNTER ACCUM. (C.ACC)	F7 INTEGER VALUE (N)	F8 FLOATING POINT WORD#								
PRESS F9 TO CHANGE FLOATING POINT FILE															

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	I/O STATUS	Go to the I/O Status screen
F2	1	SLC500 STATUS (S)	Change to the SLC500 Status display screen
F3	1	CONTROL RELAY (B)	Change to the Control Relay display screen
F4	1	TIMER PRESET (T.PRE)	Change to the Timer Preset display screen
F5	1	COUNTER PRESET (C.PRE)	Change to the Counter Preset display screen
F6	1	COUNTER ACCUM. (C.ACC)	Change to the Counter Accum display screen
F7	1	INTEGER VALUE (N)	Change to the Integer Value display screen
F8	1	FLOATING POINT WORD#	Press this button to change the floating point word that is currently being displayed.
F9	1	CHANGE FLOATING POINT FILE	Press this button to change the floating point file that is currently being displayed.

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26) REPORT SCREEN

The Report screen allows the operator to clear material usage data, view the usage report.

REPORT SCREEN								23/11/2000 13:01:18
CLEAR MATERIAL DATA								
<div style="border: 1px solid black; padding: 5px;"> <p>▶ CLEAR AGG1 DATA</p> <p>CLEAR AGG2 DATA</p> <p>CLEAR AGG3 DATA</p> <p>CLEAR AGG4 DATA</p> <p>CLEAR AGG5 DATA</p> <p>CLEAR AGG6 DATA</p> <p>CLEAR CEM1 DATA</p> <p>CLEAR CEM2 DATA</p> <p>CLEAR CEM3 DATA</p> <p>CLEAR CEM4 DATA</p> <p>CLEAR ADMIX1 DATA</p> <p>CLEAR ADMIX2 DATA</p> <p>CLEAR ADMIX3 DATA</p> <p>CLEAR ADMIX4 DATA</p> <p>CLEAR COLOR1 DATA</p> <p>CLEAR COLOR2 DATA</p> </div>								
F1 MAIN MENU	F2	F3 VIEW USAGE REPORT	F4	F5 CLEAR AGG1 DATA	F6 CLEAR ALL DATA	F7	F8 RESET PRINT FAULT	

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	MAIN MENU	Go back to the Main Menu
F3	1	VIEW INVENTORY REPORT	Go to page 1 of the Inventory Report screen
F5	1	CLEAR AGG1 DATA	Press to clear the used, auto and target data for the material selected in the list box above. Also the since date for the selected material will be reset.
F6	1	CLEAR ALL DATA	Press to clear the used, auto and target data for all of the materials. Also the since date will be reset.
F8	1	RESET PRINT FAULT	Press this button to reset a print fault.

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27) VIEW USAGE REPORT

The Usage Report screen shows how much material has been added in manual and auto modes as well as the percentage of error between the auto and target for each material since a particular date.

MATERIAL USAGE REPORT							20/11/2000
							13:00:00
MATERIAL	MANUAL	AUTO	USED	TARGET	ERROR	SINCE	
AGG1	100	10000	10100	9990 LBS	00.02%	15-10-2000	
AGG2	100	10000	10100	9990 LBS	00.02%	15-10-2000	
AGG3	100	10000	10100	9990 LBS	00.02%	15-10-2000	
AGG4	100	10000	10100	9990 LBS	00.02%	15-10-2000	
AGG5	100	10000	10100	9990 LBS	00.02%	15-10-2000	
AGG6	100	10000	10100	9990 LBS	00.02%	15-10-2000	
CEM1	100	10000	10100	9990 LBS	00.02%	15-10-2000	
CEM2	100	10000	10100	9990 LBS	00.02%	15-10-2000	
CEM3	100	10000	10100	9990 LBS	00.02%	15-10-2000	
CEM4	100	10000	10100	9990 LBS	00.02%	15-10-2000	
ADMIX1	0	120	120	120 OZS	00.00%	15-10-2000	
ADMIX2	0	120	120	120 OZS	00.00%	15-10-2000	
ADMIX3	0	120	120	120 OZS	00.00%	15-10-2000	
ADMIX4	0	120	120	120 OZS	00.00%	15-10-2000	
COLOR1	0	120	120	120 OZS	00.00%	15-10-2000	
COLOR2	0	120	120	120 OZS	00.00%	15-10-2000	
F1 REPORT SCREEN	F2	F3	F4	F5	F6	F7 PRINT USAGE REPORT	F8

Function Key	State	Message	Indicator explanation and/or action when button is pressed
F1	1	REPORT SCREEN	Go back to the Report Screen
F7	1	PRINT USAGE REPORT	Push this button to print out the Usage Report
	2	PRINTING USAGE REPORT	Indicates that the Usage Report is being compiled. Indicator will change back to state 1 as soon as report starts printing.

Inventory Report Data:

- Manual – Shows the amount of each material that was removed from the material’s bin while in manual mode.
- Auto – This is the amount of material used while in auto mode.
- Used – This is the total amount of material used.
- Target – This is the amount of material that is supposed to be used.
- Error – The percentage of the difference of material that was used and the target amount.
- Since – The date that the collection of data for a particular material was reset.

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Spare Parts List

ELECTRICAL PANEL

(Standard components for 110 –120 volts)

Item	Part Number	Description	Quantity
1	113772FIA16	INPUT MODULE 16-POINT A.B. #1746-IA16	1
2	1746-OA16	OUTPUT MODULE 16-POINT A.B. #1746-OA16	1
3	114375	INCANDESCENT LAMP A.B. #800T-N169	5

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ELECTRICAL PANEL LAYOUT

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ELECTRICAL PANEL DOOR

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Glossary

Freefall Bias – The amount of material that is in the air as the material is falling into the weigh hopper. This amount is used for deciding when to actually stop adding the material to the weigh hopper. For instance if the target is 1000 and the freefall bias is 100 the gate, belt or screw will close or shut off at 900.

Target – The amount of material that is required according to the batch recipe.

Actual – The amount of material that actually was added during the last batch.

Batch Running – This is an internal bit in the PLC that determines when a batch is running. The batch is running once the start batch button is pressed and does not stop until the last batch stops. The hand-off-auto switch and the hold buttons do not affect the batch running bit. One way to tell if a batch is running is by going to the batch run screen and look at the message for F4, if it says “STOP BATCH” then the batch is running.