

INTRODUCTION

This document includes all information's about the order 11-8801 batching system. The followings are the features of this system.

- The system will be running continuously until the STOP button is pressed.
- The batching sequence is always the same, feeding fast feed output #1 then dribble feed output #2.
- There is an auto preact compensation, if set at on, it will adjust the target weight preact automatically.
- There is a list of timer to adjust.
 1. Feed delay after discharge.
 2. Zero zone to enable the WI-130 for a new sequence.
 3. Preact value.

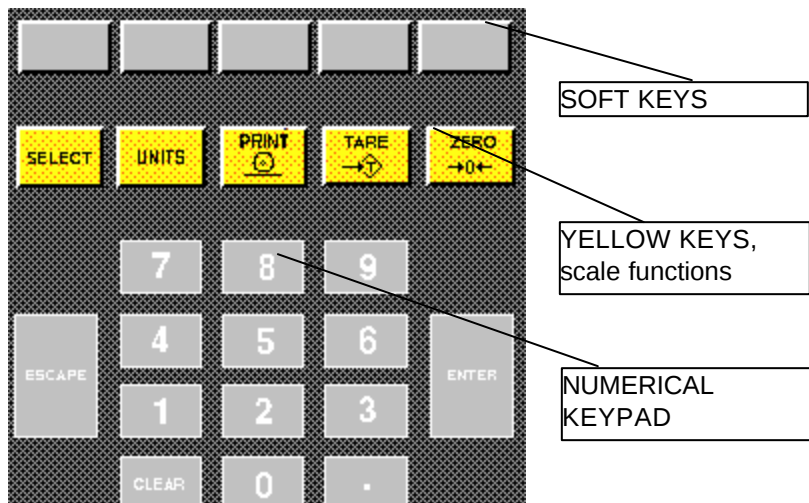
SYSTEM HARDWARE

1. WI-130 with 2 output modules
 - 1 fast speed feeder.
 - 1 dribble feeder.

I/O INFORMATION'S

I/O #	IN/OUT	Description
1-	Output	Feeder #1 (fast feed)
2-	Output	Feeder #2 (dribble feed)

WI-130 KEYPAD



Pic. 1

- **SOFT KEYS** Special functions identified on the display.
- **YELLOW KEYS** Normal scale functions.
- **NUMERICAL KEYS** Data entry keypad for numerical values.

MAIN MENU

This is the main menu of the instrument, this menu comes up at first when power is applied.



Pic. 2

START

This is the option to start batching. See **WEIGHING OPERATION**.

CONF

This menu brings up another menu where the system's parameters are entered, system's timers, preact and auto compensation. See **CONFIGURATION MENU**.

SYSTEM CONFIGURATION MENU

This is where all the system's values are entered.



Pic. 3

TIMER

1. **DELAY FEED HOP:** This is the delay before another sequence is initiated after the zero zone is met.
2. **ZERO ZONE :** This is the zero zone for the scale, it will be used by the WI-130 to initiate a new sequence. This zero zone means that the scale is empty.
3. **PREACT VALUE.** This is the preact for the feeders. The system will adjust it if the auto preact is used. Otherwise enter a value if known.

PREACT

This is where the automatic compensation ratio is set. There are choices of 0, 25%, 50%, 75%, 90%. If set at 0%, no auto compensation will be done. Only the values entered in the TIMER option will be used. **A good basic value is 75%, if the feeders are not very constant and the batches vary a lot, use a smaller value.**



Pic. 4

These are the options that you have, It shows you what it is set for then make your choice. Select the same one if no changes are needed. If the feeders are not very constant, selecting an auto preact too high will make the system unstable. 75 % is a good start.

EXIT

To return to the main menu.

WEIGHING OPERATION

From the main menu, press START to start batching.



Pic. 5

The first question is the target value, then the dribble. The dribble is the amount of ingredient to be feed at slow speed.

The system will now start batching. The START button will become a STOP button. The sequence will be repeated until the STOP button is pressed. **THE SEQUENCE WILL STOP FULL ONLY. IT WILL NOT STOP BETWEEN TWO SPEED OR DURING A FEED OPERATION.**

This is the sequence with some print screen of the WI-130.

Press the start button.



Pic. 6

Enter here the target for each batch wanted.



Pic. 7

Enter the dribble value.



Pic. 8

Now the sequence is running. The START button is now a STOP button. The sequence will start over again and again until the STOP button is pressed.



Pic. 9

Now the scale is feeding. The bar graph shows the state of the sequence. The bar will go across the display and finish feeding when the bar is full.



Pic. 10

After the scale is full, it will prompt WAITING FOR DISCHARGE to the operator.



Pic. 11

When the STOP button is pressed, the STOP button become only with dashes. This mean that the sequence will end after the next dump.



Pic. 12

The system will stop and return to the main menu after the dump is done.

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