

MAGUIRE PRODUCTS INC.

Weigh Scale Blender®
12-12 or 4088 Standard

MAGUIRE

WEIGH SCALE BLENDER®
with the 12-12 or 4088 Standard Controller

Using "FOUR" or "TWELVE" 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-600 Series, WSB-900 Series, WSB-1200 Series, WSB-1800 Series, WSB-2400 Series and WSB-3000 Series equipped with the 12-12 Controller or 4088 Standard Controller operating with the 4-Software or 12-Software configuration.

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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.

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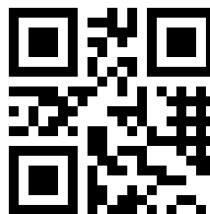
Manufacturer's Contact Information

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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
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Declaration Number:

SECTION 1 – BLENDER STARTUP



Getting Started – Important!

Safety Notifications and Safety Hazards	Page: 8	HAZARDS exist on this unit. Read Safety Notifications and Safety Hazards.
Blender Part Identification	Page: 11	Identifying key parts of the blender and what they do.
Controller Parts Identification	Page: 11	Identifying the key parts of the blender controller.
Setup and Installation	Page: 12	Assembly, setup and installation instructions.
Wiring Considerations	Page: 17	How to minimize electrical interference.
Check Out Procedure	Page: 20	Step by step procedure to verify correct assembly.
Model Selection	Page: 18	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.
WSB Operating Mode 4 and 12 Software Explained	Page: 19	Blend Mode of Operating and Software Selection Understanding the difference between 4 and 12 software and which is right for your process.
Settings Mode	Page: 49	Settings Mode as percent-of-natural or percent-of-total. 4088 Standard ONLY (Not available in 12-12). Sets the blend mode as: Additive are dispensed as a % of Natural or Materials are a % of Total Batch. See *08.
Load Cell Calibration	Page: 24	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.
Enable / Disable Material Type Outputs	Page: 31	To "Enable" a component, the TYPE must be selected as: REGRIND, NATURAL, or ADDITIVE. Each TYPE is controlled differently by the MATH routines. The controller must know the material TYPE to know how to dispense the setting. This is IMPORTANT. Be SURE you UNDERSTAND this section before operating the blender.
Material Flow Rate Calibration	Page: 35	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: 36	How to start the blender and save / restore the configuration.
Lockout/Tagout, Cleaning, Maintenance.	Page: 97	How to Lockout/Tagout, Clean and Maintain your blender.

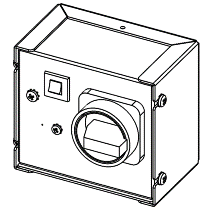


Safety Notifications



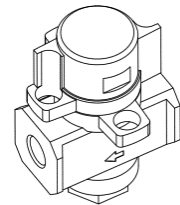
Electrical Lockout/Tagout Points

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 97.



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 97.



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 124 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

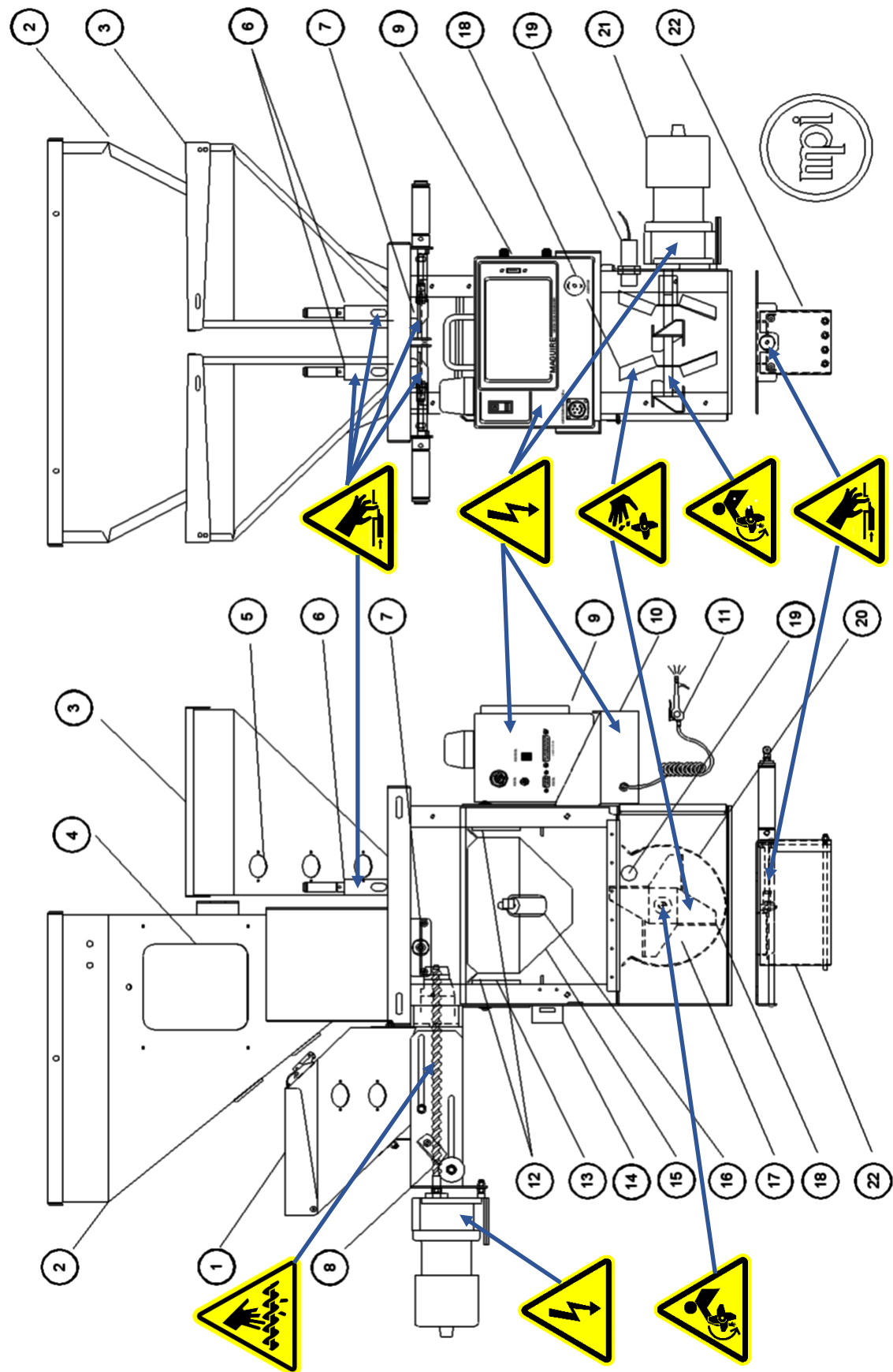
Auger Feeders contain a rotating shaft. **ALWAYS** keep fingers clear of rotating shaft and auger. **NEVER** use your fingers to clear an obstruction. **NEVER** touch a rotating shaft or auger.



HAZARD - FALLING OBJECTS

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

Blender Parts Identification



Blender Parts Identification

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.

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: 129.

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.

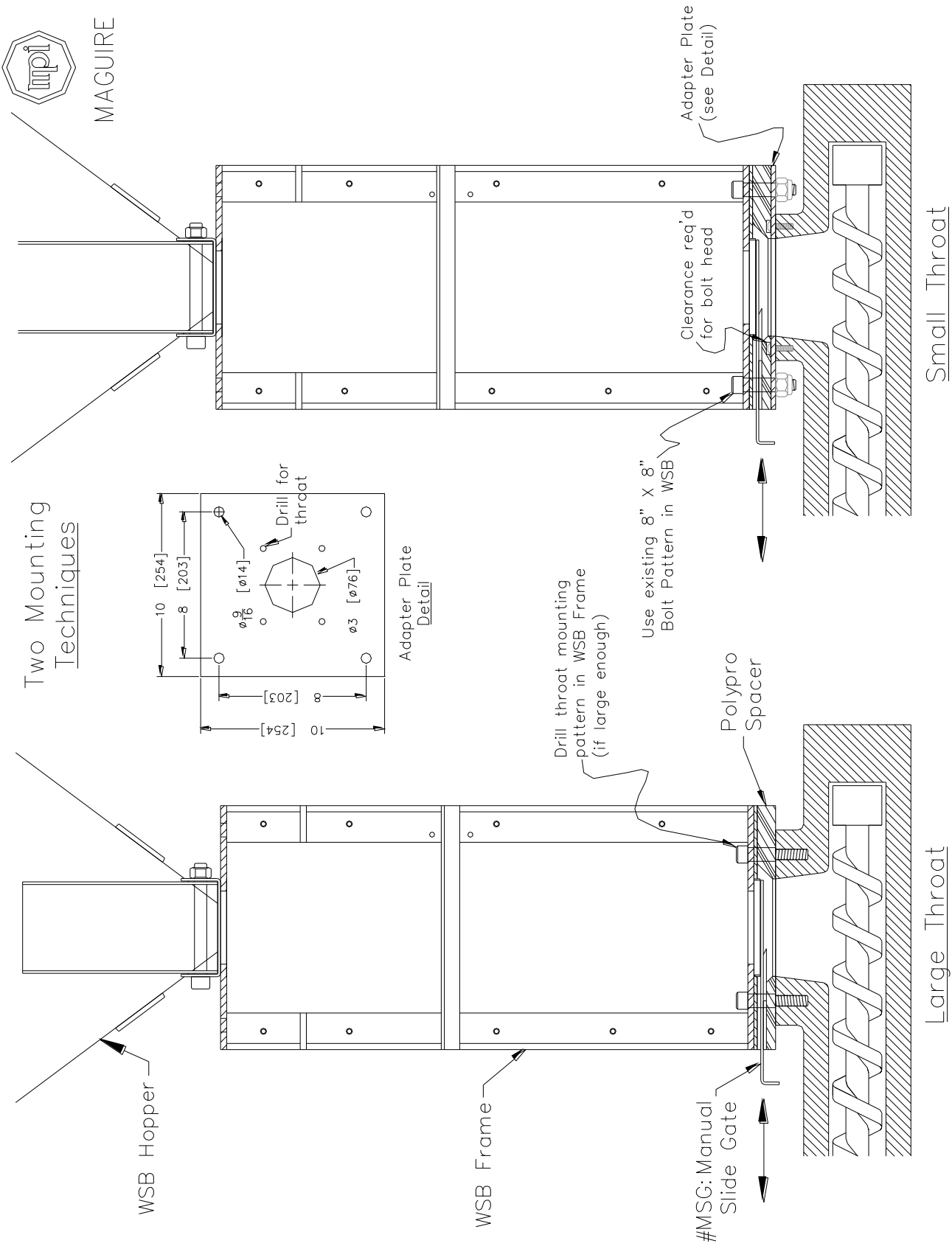
The RIGHT diagram shows only the 10 x 10 steel slide-gate plate drilled for your bolt pattern and bolted to your press. The FRAME is then bolted to it using the existing 8 x 8 inch bolt pattern holes and bolts provided. With this method, bolt head clearance holes are required in the poly-pro slide gate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



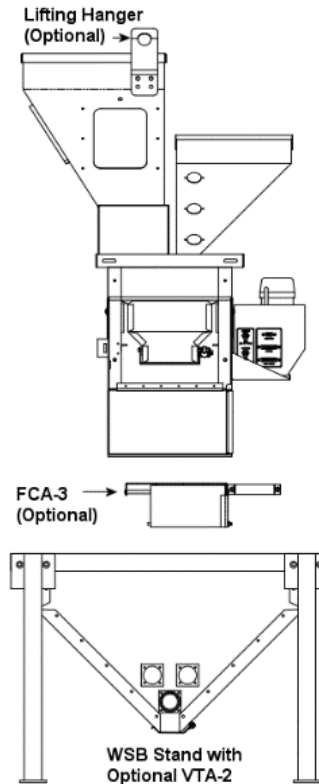
1B. Stand Mounted:

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
100/200/400/600	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		
1800	110/1/60 (Controller)	4.0	400/3/50+N+PE	2.5
	480/3/60 (Mix)	1.0		
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.

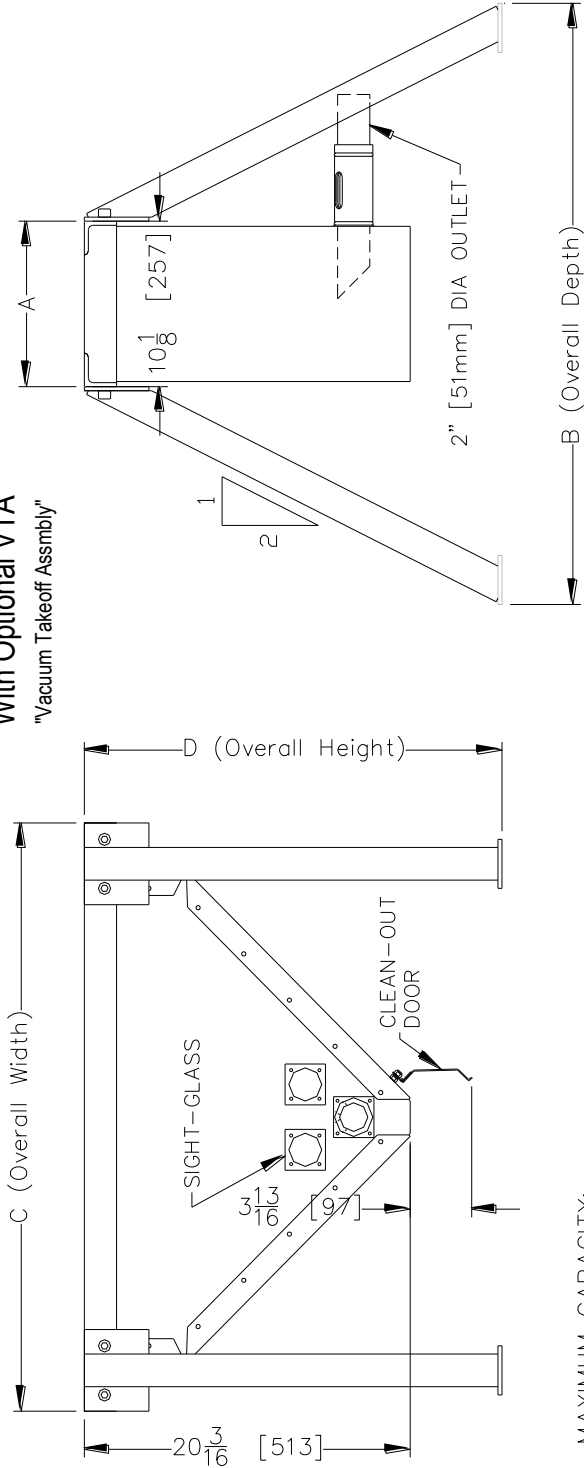
8. Upon completion of setup, an on-site safety inspection should be conducted to assess for any additional safety hazards, before allowing the equipment to be handing off to the machine operators.

WSB STANDS

With Optional VTA

"Vacuum Takeoff Assmly"

MAGUIRE



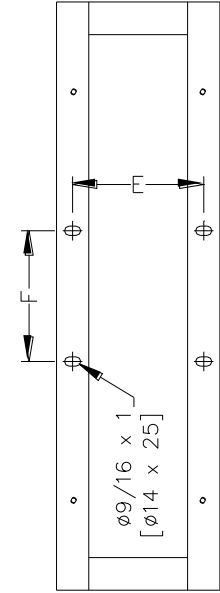
MAXIMUM CAPACITY:
100/200/400: 2.2 cu. ft. [62 L]
900/1800: 3.6 cu. ft. [101 L]
PRACTICAL CAPACITY:
100/200/400: 1.4 cu. ft. [40 L]
900/1800: 2.3 cu. ft. [65 L]

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

STAND DIMENSIONS

DIMS IN [] ARE mm.

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, static discharges and electromagnetic fields, all of which are very common in plastics factories. To MINIMIZE these things, consider the following.

- The power supply should be a reliable, steady 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 next to any heavy power lines. An unshielded power supply in a raceway next to 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. Remote touchscreens will have a single cable running back to the blender. 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 Printer and communication cables.

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 on the screen when the controller is powered on.

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 must be changed to match the blender. There are 9 main model categories, each with at least one sub model. The exact model of the blender can be found on the red serial tag attached to the blender frame. When changing the model of the blender controller to match the blender, use the exact model number as listed on the red serial tag. If the model is unknown or the tag is missing, please contact Maguire Products Inc.

Blender Model Categories	Batch Weight	Weigh Bin Dimensions (DxWxH, OD)		Load Cell Rating
	grams	mm	Inches	
Micro Blender (all models)	400	127x127x118	5" x 5" x 4.625"	1 @ 3Kg
140 (all models)	1000	138x242x170	5.437" x 9.5" x 6.687"	1 @ 3Kg
200 (all models)	2000	242x242x178	9.5" x 9.5" x 7"	2 @ 3 Kg
400 (all models)	4000	242x242x254	9.5" x 9.5" x 10"	2 @ 10 Kg
600 (all models)	6000	292x292x305	11.5" x 11.5" x 11.5"	2 @ 10 Kg
900 (all models)	9000	394x394x302	15.5" x 15.5" x 11.875"	2 @ 10 Kg
1200 (all models)	12000	394x394x378	15.5" x 15.5" x 14.875"	2 @ 20 Kg
1800 (all models)	18000	394x394x429	15.5" x 15.5" x 16.875"	2 @ 20 Kg
2400 (all models)	24000	508x540x458	20" x 21.25" x 18"	2 @ 20 Kg
3000 (all models)	30000	537x537x753	21.125" x 21.125" x 29.625"	2 @ 20 Kg



Changing the model will reset the controller's blender configuration settings and parameters to the factory 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

(display will show current model).

Press



To scroll through all model sizes.

When the model you want is displayed, then press EXIT:

Press



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

WSB Operating Mode - Software Selection

12-12 controllers and 4088 Standard controllers are programmed to use one of two methods of blending, 4 Component (also known as 4-Software) or 12 Component (also known as 12-Software). The blending method is displayed on the screen when the controller is powered on. All Weigh Scale Blender controllers come from factory pre-configured to use 4 Component or 12 Component depending on the blender's configuration or by request by the customer. The configuration can be changed easily on the controller, and it is important to understand the difference between the two configurations.

4 Component Operating Mode

The 4 Component Operating Mode is a simplified configuration using up to four hoppers, Regrind (hopper 1), Natural (hopper 2), Color (hopper 3), Additive (hopper 4). The material types are hard coded to Regrind, Natural, Color and Additive and blend as follows: Regrind dispenses first as a percent of total mix. Natural dispenses next as the remainder of the batch weight minus the anticipated additive and/or color weight, and then Additive and Color dispense as a percent of the actual weight of the Natural. Settings are entered on the digital or mechanical thumbwheels. The Additive and Color 3 AMP receptacles on the controller are for feeders and operate with the color and additive components using their respective settings. See Configuring Settings on page 27 for more details and examples. Also see *69, *71 and *72.

12 Component Operating Mode

The 12 Component Operating Mode uses up to 12 hoppers or feeders. Each hopper or feeder can be assigned a material type of Regrind, Natural, Additive or turned OFF. In the 4088 Standard controller the **Blend Mode of Operation** (*08 on page 49, 12 Software only) can be set to either **Percent of Total** where all component settings must add up to 99.9% or 100.0%, or **Percent of Natural**, where Regrinds are a percent of total, Naturals ratio to each other and Additives are a percent of the Naturals. Other rules may apply depending on the configuration. See 12 Component Examples of Configuring the Settings on pages 31 and 30 for more details and examples.

How to change the WSB Operating Mode

PRESS		Display will say ENTER PASSWORD
PRESS	    	Display will say WSB OPERATING MODE on the top line and the current mode on the bottom line.
PRESS		Press * to toggle between 4 Component and 12 Component.
PRESS		Press EXIT to save. The controller will perform a Clear All and reboot, loading the default parameters for the WSB Operating Mode the current model.

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).

400/900/1200/1800/2400/3000 series models (10K load cells) display weights in FULL grams, NO decimal point (xxxxx).

Start with NO MATERIAL in any hoppers.

Be sure an AIR SUPPLY is connected and supplies the correct PSI.

Place ALL switches DOWN position; POWER OFF (on front); and STOP and PAUSE down (on the side).

With power off 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, also check that it is closed.

Power ON the Controller	
Display should say:	MAGUIRE PRODUCTS INC SELF TEST or POWER ON RESET
Followed by a firmware self-check and status by checksum.	FIRMWARE OK Checksum = xxxxxxxx
Followed by the software configuration of the controller: 4 COMPONENT or 12 COMPONENT	WEIGH-SCALE BLENDER 4 COMPONENT Or WEIGH-SCALE BLENDER 12 COMPONENT
Followed by the firmware version (example shown).	WEIGH-SCALE BLENDER U1209A
Followed by the current model. (MODEL 220 shown as example). Be sure the model number that was displayed matches your blender model number. If not, see Changing the Model Selection on page 18.	WEIGH-SCALE BLENDER MODEL 220
Followed by the actual weight of material in the bin (top line). This number should be close to zero, +/- 20g. The display will also show the mode of the controller and the current state of the controller. AT THIS POINT, TOUCH WEIGH BIN VERY LIGHTLY. Display should update the weight every second reflecting the light pressure that you are exerting on the bin.	0.0 g MODE=BLEND WAITING

Testing Devices

4 Component Operating Mode:

OPERATE DISPENSE DEVICES		
PRESS		Display will say ENTER PASSWORD
PRESS		Enters the PROGRAM mode. 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.
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.

12 Component Operating Mode:

OPERATE DISPENSE DEVICES		
PRESS		Display will say ENTER PASSWORD
PRESS	    	Enters the PROGRAM mode. Display will show PROGRAM in the lower right.
PRESS		Display will say OPERATE DEVICES
PRESS		Device number 1 will operate. Display will show COMPONENT 1: ON Press "1" repeatedly to observe operation.
PRESS		Device number 2 will operate. Display will show COMPONENT 2: ON Press "2" repeatedly to observe operation.
REPEAT THIS SEQUENCE		For each dispense valve on your WEIGH SCALE BLENDER. Up to 12 outputs are possible numbered 1 through to 9, A, B, and C. Only those connected to devices will operate. NOTE which component NUMBER is assigned to each hopper. Hoppers are labeled with the component number.
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 power on:

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

Verify model number:

The model number will show on the display when the controller is powered on. Verify this model number matches the model number on the red metal tag on the blender frame. If the model number is not correct for you unit, see Model Selection on page 18.

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. See Load Cell Zero and Full Weight Calibration on page 24.

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. Contact Maguire Products, Inc. for assistance.

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 60 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 calibration 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.

ZERO 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
600 Series (620,640,640R,660)	6000 grams	06000	Whole grams
900 Series (940,950,960)	9000 grams	09000	Whole grams
1200 Series (1240,1250,1260)	12000 grams	12000	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.

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. Air flow should be adjusted for quiet operation, but assuring full valve movement per on/off cycle.

Micro-Pulse Valve Airflow Adjustment

On horizontal Slide Gate Micro Pulse valves, two adjustment screws are located at the end and base of the air cylinder. On vertical Micro Pulse valves, the adjustment screw is located externally on the hopper. All valves should be set to approximately 2 complete turns open from fully closed for initial adjustment. Additional adjustment should be made the by sound of the cylinder as it opens and closes. If the valve sounds slow, open the valve in small increments. If the valve is slamming open and closed hard, adjust the valve closed in small increments.

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.

To perform a material rate calibration on a Micro Pulse Valve, see Material Flow Rate Calibration on page 35.

Increased Micro Pulse Accuracy

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.

Configuring Settings

The following section explains the definitions of material types and explains how to set the settings / percentages on both the **4 Component** and the **12 Component** Operating Modes. For a brief explanation of 4 and 12 Component Operating Mode, see page 19.

Material Types Explained

Material **TYPES** are **REGRIND**, **NATURAL**, **ADDITIVE** and **COLOR** (Color, used only in 4 Component Operating Mode, operates the same as ADDITIVE and is labeled as COLOR in 4 Component Operating Mode only).

The Weigh Scale blender handles each material type differently and the settings have different meanings for each material type. To enter settings correctly, you must understand how different materials are handled based on their type.

REGRIND - PERCENT OF MIX

Components designated REGRIND will be added as a PERCENT of the ENTIRE MIX of material. For example, If component 1 is designated as REGRIND and is set for 20.0 percent, then for every 100 pounds of blend, 20 pounds will be this component. A recipe composed of all regrind types will dispense as percent of total and must add up to 99.9 or 100 percent. Additive and Color is not dispensed for the regrind portion of the batch (regrind is considered pre-mixed or recycled material).

NATURAL - Major component of the batch. Multiple Naturals ratio or other Naturals. A SINGLE component designated NATURAL will dispense as the remainder of the batch weight minus the anticipated additive and/or color weights. When a single NATURAL is used, the setting has to only be non-zero and 001 through 999 will dispense the full amount (does not apply for Settings Mode "Percent of Mix", see *08 on page 49).

MULTIPLE components designated NATURAL will be added in the proportion that you specify them to each other. Their actual percentage of the mix will depend on how much Regrind is specified and how much Additive is specified. For example, if components 2 and 3 are both designated NATURAL and are set for 10 and 40 respectively, then the RATIO of component 2 to component 3 will always be 10 to 40 or 1 to 4 (1 part to 4 parts).

If no Regrind or Additives are specified, the mix will be:

Component 2, NATURAL, SET= 10, 20.0 percent of mix,
Component 3, NATURAL, SET= 40, 80.0 percent of mix.
The RATIO of 1 to 4 is maintained.

If component 1 is specified as REGRIND at 20 percent, the mix is then

Component 1, REGRIND, SET= 20, 20 percent of mix,
Component 2, NATURAL, SET= 10, 16.0 percent of mix,
Component 3, NATURAL, SET= 40, 64.0 percent of mix.
Components 2 and 3 are still held at a 1 to 4 ratio.

ADDITIVE & COLOR - PERCENT OF NATURAL or ALL NATURALS

Components designated ADDITIVE and COLOR will be added as a percentage of NATURAL or all the NATURALS added together. For example: If component 5 is an ADDITIVE at 5 percent, then the above example now looks like this:

Component 1, REGRIND, SET= 20, 20 percent,
Component 2, NATURAL, SET= 10, 15.2 percent,
Component 3, NATURAL, SET= 40, 61.0 percent,
Component 4, ADDITIVE, SET= 05.0, 3.8 percent.

The REGRIND is still 20 percent of the MIX.

The NATURALS are still at a RATIO of 1 to 4, although they have been reduced to make room for the Additive.

The ADDITIVE is 5 percent of the NATURALS added together (5% of 76.2).

Operating Modes Explained

4 Component Operating Mode

4 Component Operating Mode is a simplified “Percent of Natural” mode consisting of up to 4 components set permanently to REGRIND, NATURAL, COLOR and ADDITIVE. 4 Component Blenders are labeled on the hoppers with these material types. Operation of a 4 Component blender is simplified for easy of use and easy configuration. Settings for the REGRIND, COLOR and ADDITIVE are set on the blue digital setting displays (or earlier model mechanical thumbwheels). The NATURAL setting is automatically set to 100. To begin operation of a 4 Component blender, follow these steps. NOTE: when settings are sent by communication, the digital setting displays or mechanical thumbwheels are disabled and settings at the controller are accessible only through SET key while in program mode.

1. Fill HOPPERS: REGRIND, NATURAL, COLOR, ADDITIVE in hoppers as labeled.
2. On Controller, turn POWER ON, set STOP, and PAUSE switches UP. Switch MIXER motor DOWN to run for a timed period each cycle.
3. Set THUMBWHEEL switches for percentage of materials desired:
REGRIND enter as a percentage of the entire mix (percent of total)
COLOR as a percentage of the Natural (setting is in 10ths, xx.x%)
ADDITIVE as a percentage of the NATURAL (setting is in 10ths, xx.x%)

The blender 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.

Also see: *69 - Regrind as 2nd Natural, *71 - Color percent of blend, *72 - Additive percent of blend.

12 Component Operating Mode

12 Component Operating Mode can control up to TWELVE (12) components; 1 through 9 and A, B, and C. You must "TURN ON" the COMPONENT outputs that you are going to use. Components that are TURNED OFF are not part of ANY routines. A component becomes TURNED ON when it is set to a MATERIAL TYPE. Most new blenders are pre-configured with the components enabled. Selecting the model enables the default components typical of that model.

Enable Components and Set Material Types

Press		Display will say: ENTER PASSWORD
Press	    	Display will say: PROGRAM
Press		Display will say: INSTRUCTION []
Press	 	Display will say: MATERIAL TYPES Comp 1: OFF The "1" is the component (device) number. This is component 1. It will control Hopper 1.
Press		Press CE repeatedly to make selection. MATERIAL TYPES Comp 1: OFF Comp 1: REGRIND Comp 1: NATURAL Comp 1: ADDITIVE Comp 1: OFF
When the selection you want is displayed, move on to NEXT component by doing the following:		
Press		Display will say: Comp 2: OFF
REPEAT sequence for ALL components you use.		
The  key will navigate through all components.		
The  key will change the TYPE for a component.		
Components NOT CONNECTED, or NEVER USED, set to OFF.		
When complete:		
Press		Display will say: PROGRAM
Press		Display will say: WAITING
After EXIT, if display says NEED NATURAL then you have specified an ADDITIVE without specifying a NATURAL. At least one Natural is required when using Percent-of-Natural mode.		



FOUR dispense valve systems use components 1 through 4. TWO dispense valve systems use 1 and 2. SIX dispense valve systems use 1 through 4, then 7 and 8. Panel front OUTLETS are always components 5 and 6. Additional outlets are generally components 7 and 8.

12 Component Operating Mode - Entering Material Settings

Material Settings Keypad Sequence:

Press:  Display will say

COMPONENT SETTINGS
... See below ...

Example shown. Material Types will vary per application

Comp 1 (REG) : **xx.x** (Regrind)

Comp 2 (NAT) : **xxx** (Natural)

Comp 3 (ADD) : **xx.x** (Additive)

Comp 1,2,3,4,5,6,7,8,9,A,B,C are the Components

REG (Regrind), NAT (Natural), ADD (additive) are the Types.

XX.X or XXX is Setting.

Enter a 3-digit setting:

Regrind settings = PERCENTAGE of the ENTIRE MIX

Natural settings = RATIO to OTHER NATURAL SETTINGS

Additive settings = PERCENTAGE of ALL the NATURALS

Press:  for the NEXT setting.
Repeat this sequence for all components.

Press:  when finished.

When entering settings, remember:

Feeder OUTLETS are always components 5 and 6. On the 12-12 controller, left is 5 and right is 6. On the 4088 Standard, top is 5 and bottom is 6.

Any component set to zero will not dispense.

12 Component - Assigning Material Settings to Thumbwheels

This is an optional Feature – it is not necessary for normal operation.

You may assign a component to one of the three thumbwheel switches.

You might do this for components that you wish to change settings frequently. This is ENTIRELY OPTIONAL.

Press:  Display will say: Comp 1 (REG) : **xx.x**

Press: A  Display will say: Comp 1 (REG) : **xx.x** (TW 1) (Thumbwheel 1)

or B  Display will say: Comp 1 (REG) : **xx.x** (TW 2) (Thumbwheel 2)

or C  Display will say: Comp 1 (REG) : **xx.x** (TW 3) (Thumbwheel 3)

(TW 1) = TOP switches,
(TW 2) = MIDDLE switches,
(TW 3) = BOTTOM switches.

To RETURN component to KEYPAD entry of the setting:

Press:  Display will return to: Comp 1 (REG) : **xx.x**

Press:  when finished.

Examples of Configuring the Settings

The following examples explain two blending methods, **Percent of Natural** and **Percent of Mix**. Both the 4 Component Operating Mode and the 12 Component Operating Mode will blend the Percent of Natural blending method. Only the 12 Component Operating Mode can run the Percent of Mix blending method. All examples use the 1000-gram model WSB 100 Series.

Percent of Natural Examples

Each Percent of Natural example uses this formula:

Regrind = $R_s * \text{Full weight}$
Natural = $(\text{Full weight} - R_a) / (100 + A_s)$
Additive = $\text{Natural} * A_s$

R_s = Regrind setting
 R_a = Regrind actual
 A_s = Sum of additive settings

4 Component Operating Mode – Percent of Natural Examples

Example 1		Percent of Natural - <u>4 Component Operating Mode</u> or <u>12 Component Operating Mode</u>	
Materials:	30% 70% 3%	Regrind (Regrind is recycled and therefore already colored) Natural (Color only needs to be added to the Natural Material) Color	
Settings:	Regrind Natural Color	R N A	30.0 100 (100 is the default setting in 4 Software) 3.0
Calculation:	- Total = 1000 grams - Regrind: $30\% * 1000.0 = 300.0$ ($R_s * \text{Full weight}$) - Natural: $(1000.0 - 300.0) / (100\% + 3\%) = 700.0 / 1.03 = 679.6$ ($\text{Full weight} - R_a) / (100 + A_s)$) - Additive: $679.6 * 3\% = 20.3$ ($\text{Natural} * A_s$)		
Result:	1 Regrind 2 Natural 3 Color Batch Total	300.0g 679.6g 20.3g 1000g	30.0 parts 67.9 parts 2.0 parts 100 parts

Example 2		Percent of Natural - <u>4 Component Operating Mode</u> or <u>12 Component Operating Mode</u>	
Materials:	30% 70% 3% 2.5%	Regrind (Regrind is recycled and therefore already colored) Natural (Color and Additive only needs to be added to the Natural Material) Color Additive	
Settings:	Regrind Natural Color Additive	R N A A	30.0 100 in 12 software or communication 3.0 2.5
Calculation:	- Total = 1000 grams - Regrind: $30\% * 1000.0 = 300.0$ ($R_s * \text{Full weight}$) - Natural: $(1000.0 - 300.0) / (100\% + 5.5\%) = 700.0 / 1.055 = 663.5$ ($\text{Full weight} - R_a) / (100 + A_s)$) - Color: $663.5 * 3.0\% = 19.905$ ($\text{Natural} * A_s$) - Additive: $663.5 * 2.5\% = 16.587$ ($\text{Natural} * A_s$)		
Result:	1 Regrind 2 Natural 3 Color 4 Additive Batch Total	300.0g 663.5g 19.9g 16.5g 1000g	30.0 parts 66.35 parts 1.99 parts 1.66 parts 100 parts

12 Component Operating Mode – Percent of Natural Examples

Example 3: Percent of Natural - 4 Component Operating Mode using *69 or 12 Component Operating Mode

Materials:	30%	Natural (a single natural in 12 Component Mode set to 100)
	70%	Natural
	3%	Color
Application:	2 nd Natural (or un-colored regrind) is used without any Color and therefore both naturals require color.	
Settings:	Natural	N 30 (Naturals are a ratio to each other, in this example 30 parts to 70 parts ratio)
	Natural	N 70
	Color	A 3
Calculation:	- Total = 1000 grams - Hopper 1 Natural at 30% (Ratio to hopper 2 natural 30% 70%, 291.3 grams) - Hopper 2 Natural at 70% (Ratio to hopper 1 natural 30% 70%, 679.6 grams) Naturals: $(1000.0 - 0) / (100\% + 3\%) = 1000.0 / 1.03 = 970.8$ (Full weight - Ra) / (100 + As) Additive: $970.8 * 3\% = 29.1$ (Naturals * As) - The blender is doing this calculation automatically for you	
Result:	1 Natural	291.2g 29.1 parts
	2 Natural	679.6g 68.0 parts
	3 Color	29.1g 2.9 parts
	Batch Total	1000g 100 parts

Example 4: Percent of Natural - 12 Component Operating Mode Only for this example

Materials:	20.0%	Regrind
	50	Natural
	30	Natural
	4.0%	Color
	6.0%	Additive
Application:	Regrind is recycled next to the machine and therefore already has Color and Additive. Color and Additive only needs to be added to the 2 Natural materials.	
Settings:	Regrind	R 20.0
	Natural	N 50 (Ratio to hopper 3 natural 50 parts 30 parts, 454.5 grams)
	Natural	N 30 (Ratio to hopper 2 natural 50parts 30parts, 272.7 grams)
	Color	A 4.0
	Additive	A 6.0
Calculation:	- Total = 1000 grams Regrind: $20\% * 1000.0 = 200.0$ (Rs * Full weight) Naturals: $(1000.0 - 200.0) / (100\% + 10\%) = 800 / 1.10 = 727.2$ (Full weight - Ra) / (100 + As) Additive: $727.2 * 4\% = 29.0$ (Natural * As) Additive: $727.2 * 6\% = 43.6$ (Natural * As)	
Result:	1 Regrind	200.0g 20.0 parts
	2 Natural	454.5g 45.4 parts
	3 Natural	272.7g 27.2 parts
	4 Color	29.0g 2.9 parts
	5 Additive	43.6g 4.3 parts
	Batch Total	1000g 100 parts

Percent of Total Examples

The following examples use settings methods that blend the components as a percent of a total of 100%. There are three methods that blend as a total of 100%, Settings Mode “Percent of Mix”, All Material Types set to Natural, and All Material Types set to Regrind.

Settings Mode: Percent of Mix (4088 Standard Controller only) - In “Percent of Mix” material types can be any type and the settings must add up to 99.9% or 100%. To enable Percent of Mix in the 4088 Standard controllers see page 49 for more information.

Example 5: Settings Mode: Percent of Mix - 12 Component Operating Mode Only, 4088 Standard Controller Only

Application: An exact percentage of the total mix is entered. The total of all components adds up to 100%.

Materials:	20%	Regrind	Settings and Types Entered:	Regrind	R	20.0
	35.5%	Natural		Natural	N	35.5
	34.5%	Natural		Natural	N	34.5
	5.2%	Additive		Additive	A	5.2
	4.8%	Additive		Additive	A	4.8

Calculation: The blender is calculating the settings in grams as a percent of total using the target batch weight.

Result:	Regrind	200.0g	200 parts
	Natural	355.0g	355 parts
	Natural	345.0g	345 parts
	Additive	52.0g	52 parts
	Additive	48.0g	48 parts
	Batch Total	1000g	1000 parts

All Material Types NATURAL – Percent of Total or RATIO of Weights Example

When all material types are type natural, settings can be entered as a RATIO OF PARTS TO PARTS or a PERCENT OF TOTAL. **NOTE:** In this mode, the total of all settings does **NOT** have to add up to 100%.

Example 6: All Natural Types - 12 Component Operating Mode Only, 4088 Standard Controller or 12-12 Controller

Application: An exact percentage of the total mix or a RATIO of parts to parts is entered.

						Valid Settings		
Materials:	20%	Natural	Settings and Types Entered:	Natural	N	200	020	002
	30.0%	Natural		Natural	N	300	030	003
	50.0%	Natural		Natural	N	500	050	005

Calculation: The blender is calculating the settings in grams as a ratio of parts to parts using the target batch weight.

Result:	Natural	200.0g	200 parts
	Natural	300.0g	300 parts
	Natural	500.0g	500 parts
	Batch Total	1000g	1000 parts

All Material Types REGRIND

When all material types are type REGRIND, settings can be entered as a PERCENT OF TOTAL. NOTE: In this mode, the total of all settings MUST add up to 99.9% or 100.0%. This mode is valid in 12-12 Controllers and 4088 Standard Controllers in 12 Component Operating Mode. This mode is the only valid mode to achieve % of total in the 12-12 Controller. The 12-12 Controller does not have the Blend Mode "Percent of Mix". If the settings entered do not add up to 99.9 or 100.0 an error message will appear SUM OF COMP > 100% or SUM OF COMP < 100%.

Example 6: All Regrind Types - 12 Component Operating Mode Only

Application: An exact percentage of the total mix is entered. The total of all components must add up to 100%.

Materials:	25%	Regrind	Settings and Types Entered:	Regrind	R	25
	65%	Regrind		Regrind	R	65
	4%	Regrind		Regrind	R	4
	6%	Regrind		Regrind	R	6

Calculation: The blender is calculating the settings in grams as a percent of total of the target batch weight.

Result:	1 Regrind	250.0g	25.0 parts
	2 Regrind	650.0g	65.0 parts
	3 Regrind	60g	6.0 parts
	4 Regrind	40g	4.0 parts
	Batch Total	1000g	100 parts

Example 7: All Regrind Types - 12 Component Operating Mode Only. Valid in 4088 Standard and 12-12 Controllers.

Application: An exact percentage of the total mix is entered. The total of all components must add up to 100%.

Materials:	33.3%	Regrind	Settings and Types Entered:	Regrind	R	33.3
	33.3%	Regrind		Regrind	R	33.3
	33.3%	Regrind		Regrind	R	33.3

Calculation: The blender is calculating the settings in grams as a percent of total of the target batch weight.

Result:	1 Regrind	333.0g	33.3 parts
	2 Regrind	333.0g	33.3 parts
	3 Regrind	333.0g	33.3 parts
	Batch Total	999g	99.9 parts

Material Flow Rate Calibration

If material is changed or hardware is changed (example: 1/2" auger changed to a 1" auger) and material meters at a much lower or higher rate than expected, the software may take 10 to 20 cycles to fully adjust. During this time cycles will take longer. The software will SELF ADJUST the flow rate or a Material Flow Rate Calibration can be done to set the flow rate immediately.

To perform a **Material Flow 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 Flow Rate Calibration

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 Auger Feeder 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 

Component #5 will calibrate itself.

Repeat this two key calibration routine for EACH material that you wish to calibrate. Only components that have a TYPE selected (not "OFF") will operate.

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.

Normal Operation and Saving the Configuration

1. Fill HOPPERS.
2. Turn POWER ON. Verify correct settings.
3. On Controller, set STOP and PAUSE switches UP. Turn MIXER motor switch DOWN to run for a timed period. Unit will now operate automatically to maintain a level of material high enough to cover the level sensor. Use the STOP or PAUSE switches to stop the blender. Turn power off only on final shutdown. 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 MODE
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

When the sensor is uncovered, the cycle begins. The target weight of a complete batch is determined by the model.

REGRINDS are dispensed first, in their order of size, largest dispense first. After all the Regrind dispenses, the space remaining in the weigh bin is determined.

NATURALS are dispensed second, in their order of size, each at the correct ratio to the others. These dispenses are calculated to fill the bin leaving just enough space for the Additive dispenses. After all Natural dispense are complete the exact weight of all of the NATURALS is determined and, based on this actual dispense weight, the Additive dispenses are now calculated.

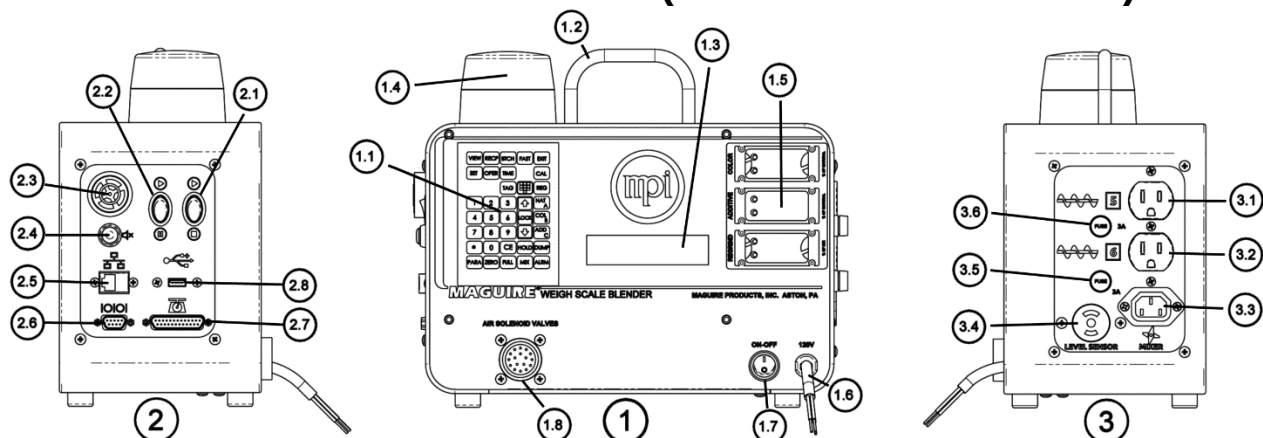
ADDITIVES are dispensed last. These dispenses are calculated as a percentage of all the NATURAL components only.

If any dispense fails to reach the requested weight, the process does NOT CONTINUE. The ALARM Strobe light flashes, the Beeper sounds, and the system continues to retry the dispense until the problem is remedied.

The total batch is then dropped into the mixing chamber for blending before entering the throat of the process machine.

WSB Controller – Description of Controls and Outputs

4088 Standard Controller (silver metal enclosure)



2. Left Side Panel

- 2.1 Stop End of Cycle / Continue Switch
- 2.2 Immediate Pause / Continue Switch
- 2.3 Alarm Audio Beeper
- 2.4 Extrusion Control (Optional)
- 2.5 Ethernet Port (MLAN, Modbus TCP)
- 2.6 RS-232, RS-485 MLAN
- 2.7 Load Cell Port Input
- 2.8 USB Port for Flash Drive

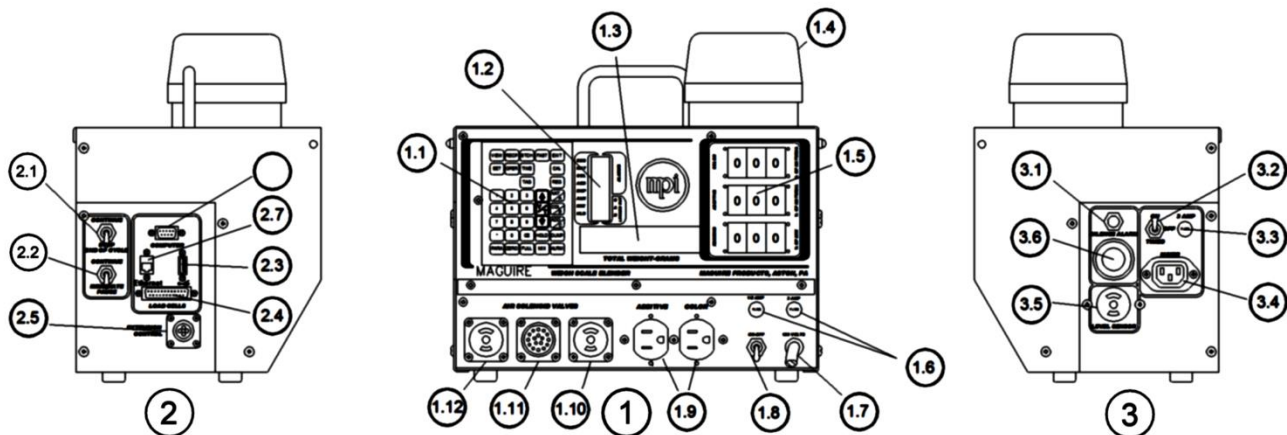
1. Front Panel

- 1.1 Keypad
- 1.2 Service Handle
- 1.3 Main Display
- 1.4 Alarm Strobe Light
- 1.5 Materials Thumbwheels Digital
- 1.6 110V or 240V Power Input
- 1.7 Controller Power On / Off Switch
- 1.8 Air Solenoids Electrical Connection

3. Right Side Panel

- 3.1 Outputs for additional Feeder
- 3.2 Outputs for additional Feeder
- Feeder outputs not available for WSB-MB, WSB 100*
- 3.3 Mix Motor Power Plug
- not used for WSB-MB, WSB-100 (pneumatic)*
- 3.4 Mix Chamber Level Sensor Input
- 3.5 Electrical Mixer Output Fuse
- 3.6 Fuse for feeder outputs

12-12 Controller (black metal enclosure)



2. Left Side Panel

- 2.1 Stop End of Cycle / Continue Switch
- 2.2 RS-232, RS-485 MLAN
- 2.3 USB Port for Flash Drive
- 2.4 Load Cell Port Input
- 2.5 Extrusion Control (Optional)
- 2.6 Immediate Pause / Continue Switch
- 2.7 Ethernet Port (MLAN, Modbus TCP)

1. Front Panel

- 1.1 Keypad
- 1.2 Service Handle
- 1.3 Main Display
- 1.4 Alarm Strobe Light
- 1.5 Materials Thumbwheels Digital
- 1.6 LEFT: Controller ½ amp Fuse
- RIGHT: Feeder receptacles 3 amp
- 1.7 110V or 240V Power Input
- 1.8 Controller Power On / Off Switch
- 1.9 Outputs for additional Feeder
- Feeder outputs not available for WSB-MB, WSB 100*
- 1.10 Optional High Sensor Mount or Remote Alarm Output
- 1.11 Air Solenoids Electrical Connection
- 1.12 Optional Low Sensor Mount

3. Right Side Panel

- 3.1 Silence Alarm Button
- 3.2 Electrical Mix Motor Operation Switch
- Timed (Default), On or Off
- 3.3 Electrical Mixer Output Fuse
- 3.4 Mix Motor Power Plug
- not used for WSB-MB, WSB-100 (pneumatic)*
- 3.5 Mix Chamber Level Sensor Input
- 3.6 Alarm Audio Beeper



Keypad

For more information, see Controller Keypad Description on page 43.



Controller Display

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:

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 [_ _]

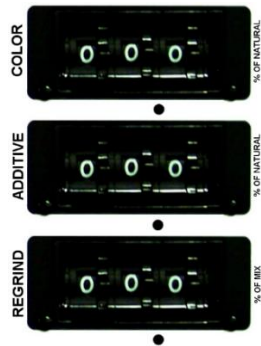
This is displayed when you press the * key from the PROGRAM mode. Enter a 2-digit instruction number for special tasks.

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 controller's program and memory. See KEYPAD, *, 25, for explanation.



Digital or Mechanical (Thumbwheel) Setting Switches

The three sets of digital display switches have no effect unless the controller is in 4-Software (defaults to Re grind, Additive and Color to the labeled thumbwheels) or in 12-Software, thumbwheels are assigned to a particular output device. Entry of all SETTINGS is done by using the KEYPAD. However, if you prefer, you may assign up to three components to the Thumbwheel switches and then use these switches to set and alter their settings. Since only three switch sets are available, only 3 components can be controlled in this manner. All others must use the keypad. See Assigning Thumbwheels on page 30 for more information on how to do this.



NOTE

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

When settings are sent to a digital thumbwheel equipped controller using the Set Settings MLAN command, the assigned thumbwheels are updated along with the internally stored settings.

Digital Thumbwheel Switches and Mechanical Thumbwheel Switches

Digital thumbwheels operate the same as the mechanical thumbwheels however the digital thumbwheel displays will reflect the current setting of assigned components even if the setting is updated via MLAN communications. Changing the digital thumbwheel display will update the internally stored setting of that component. To display but lock out the assigned digital thumbwheels, see the `_SE` parameter.

Air Solenoid Outputs

17 pin Amphenol plug located on the front of the control panel. 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.

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

RS-232 and RS-485 port used for direct MLAN protocol communication or MLAN conversion to other industrial protocols using a third-party gateways.



Ethernet Port (RJ-45) for MLAN over TCP/IP, Modbus TCP

The Ethernet port allows for communication to the controller over Ethernet. Communication through this port is TCP/IP utilizing the MLAN Protocol or Modbus TCP. 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 51.

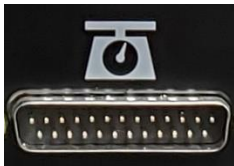
The USB port can also be used to update the controller's software. For information about updating the controller software see Updating Controller Software and the Star function * 93.



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.



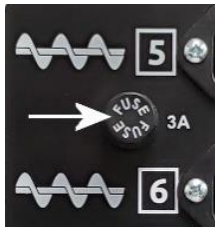
Load Cell Input Port

Load Cell Connector port.



Feeder Power Outlets (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 Feeder Outlets - 3 amp

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

4088 Touchscreen 3-amp fuse location right side panel.
12-12 3-amp fuse location front panel.



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.



12-12 Controller Panel Fuse - 1/2 amp

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



12-12 Controller 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.



Strobe Light and Beeper Alarm

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.

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.

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.



EXTRUSION CONTROL 2 Way Interface (optional)

For Extrusion Control Systems



Mixer Motor ON/OFF/TIMED Switch (optional)

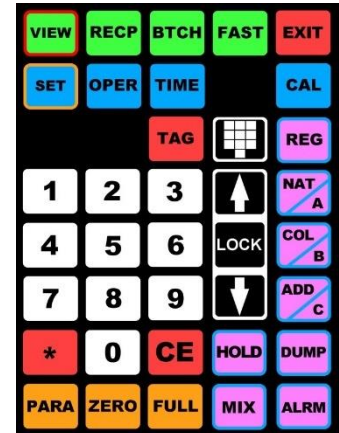
The Mixer ON/OFF/TIMED switch is provided as an additional safety so that you may switch the mixer off when you wish to clean out the mix chamber. In the UP position (ON), the mixer runs continuously. In the middle position (OFF) the mixer is off. In the down position, the mixer will run for a timed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

Controller Keypad 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.
RCP	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 (diagnostics only).



MANUAL 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: Press: *; then (22222) or your own 5-digit password.

Program Mode is a password protected administration section of the controller used for accessing star functions, parameters and other system configuration settings and routines.



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: #####)
TOTAL weight of each component: (only active components are displayed)	(Comp x: #####)
Total weight of ALL materials:	(Total: #####)

Each 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. 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 in 4-software or settings using the SET key in 12-software. 50 recipes may be stored, numbered 00 to 50.

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:

(RCP --), (1R= xx), (2N= xx.x), etc., (CE=CLEAR)

Press CE to CLEAR CURRENT RECIPE and return settings to those previously set. Then press RCP to look at another recipe. Display = (GET --).

If no RECIPE is currently in use, display says (GET --).
Enter 2 digits to retrieve one of 99 recipes.
Display will flash through this recipe data:

(RCP 01), (1R= xx), (2N= xx.x), etc., (* = LOAD)

Press * to LOAD this recipe into memory.

Routine will exit automatically.

Press RCP or EXIT to return to the display (GET --).

Press RCP or EXIT again to exit.

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 volumetric (not gravimetric) cycles to follow a normal calibrated and weighed cycle. In a FAST cycle all components are dispensed without weighing and dispense in less time than weighed cycles.

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

Press SET to step forward through all the settings. Press * key to backward in the list. NEW settings may be entered directly. Press SET for next table of component parameters and VIEW for previous table.

REGRIND and ADDITIVE settings are expressed as percentages, up to 99.9 percent. NATURAL is any number you wish (usually weight). It is used to establish RATIOS with all other NATURAL entries. When only one material is designated as a NATURAL, the value of it's setting has no meaning, except that it must be set to some value to operate.

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.

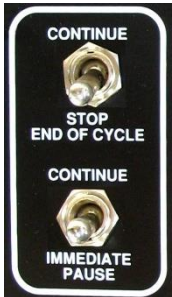


EXIT - This key is operational in ALL MODES.
Use the EXIT key to exit any and all keypad sequences.



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 SET, OPER, TIME, and CAL operate in this mode coupled with all device keys; 1 through 9, A, B, C, 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 16 keys: 1 through 9, A, B, C, 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 12 component keys. 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 online 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 12 component keys. 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 (DO AGAIN), press any key to cause the process to repeat itself. If the display then says (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 by communications or printout, a Zero Weight and Full Weight calibration should be done periodically, approx. every 4-6 months, to assure accurate data in your totals reports.

See page 24 for Zero and Full Weight Calibration instructions.

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 Calibration

See page 24 for Zero and Full Weight Calibration instructions.

During the calibration routine (see page 24 for Zero and Full Weight Calibration) the Zero weight must be entered before the Full Weight to calibrate. The FULL key will not function until the Zero weight has been entered.

FULL WT. and ZERO WT. have been set at the factory. A drift of several grams from these settings is normal and should not affect the weighing process because each cycle is tared before weighing. Recalibration should be considered only if zero is +/- 20 grams or if the full weight is off by more than 50 grams (using a known weight in the weigh bin). These +/- errors do not prevent proper proportions from being dispensed or accurate weights from being measured and recorded.

Star Functions

* 00	Clear All Data Fields.	* 63	MLAN TCP Server Port (9999 default)
* 02	Extrusion and Yield Control.	* 64	Modbus TCP Server Port (502 default)
* 03	3-digit (xx.x) or 4-digit (xx.xx) settings.	* 65	Set IP Address, Network Mask, Default Gateway
* 05	Inhibits clear totals 00 from VIEW key	* 66	WSB I.D. number (1-255).
* 06	Inhibit CE Clear on Power Up	* 67	Modbus Enable / Disable.
* 08	Blend Mode: % Total or % Natural.	* 69	Regrind as 2 nd Natural. (4-Software only)
* 11	Date and Time adjustment.	* 71	Color percent of blend. (4-Software only)
* 12	Move table from ROM to RAM.	* 72	Additive percent of blend.
* 14	Set Material Types (12-software only)	* 74	Stop, alarm MAX wt exceeded.
* 15	Set Clear-All row of keys	* 75	Alarm on weight drop.
* 16	Set Dispense Order (4088 12-software only)	* 77	Print parameters.
* 18	Language Selection	* 78	Change program mode PASSWORD.
* 22	LIW Model Selection	* 79	Leak Detection
* 23	Move from RAM to EEPROM.	* 82	Precision Ratioing.
* 25	Firmware checksum.	* 83	Progressive Metering
* 32	Move from EEPROM to RAM.	* 86	Backdoor Password
* 34	USB Recipe Command	* 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.	* 94	Update WSB Net software from USB drive
* 52	Double dump weigh bin.	* 95	Select COM port Baud Rate
* 54	Print cycle information.	* 96	Format flash memory. (4088 Standard only)
* 57	Alternate Liquid Color	* 97	USBC Driver version display, update, verify
* 60	View IP address	* 98	Display raw weight number.
* 61	View Serial Number	* 99	Enables Weight Calibration of the Load Cells
* 62	View MAC Address		

* 0 0

CLEAR ALL TOTALS DATA (Manual and Program Mode)

Press (*,0,0) to CLEAR ALL TOTALS DATA fields. These are the material usage totals of all components 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. NOTE: Totals retrieved by MLAN and Modbus TCP communications will also clear.

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.

* 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



INPUT FORMAT – 3-Digit (x.xx) or 4-Digit (xx.xx) Entry of Settings (Available in 12-Software only)

Press (*,0,3) to change between 3-digit (xx.x) or 4-digit (xx.xx) entry of settings. This does not make the blender more accurate. It does allow easier setup for customers that have a mixture of setting requirements that is x.xx entry requirements as well as the standard xx.x requirements. Normally the XT parameter would be manually adjusted to allow the decimal shift. If this four-digit entry option is turned on, then all entries are in the format xx.xx. The software uses only the first three digits unless the first digit is a zero, in which case the last three digits are selected and the related XT parameter is set to 00010. See XT parameter for more information. Display will say (INPUT FORMAT 3 Digit (XX.X) or 4 Digit (XX.XX)). Use * key to toggle.



CLEAR DATA PROMPT - Prevent Totals being Cleared

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

Customers using communications MLAN or Modbus TCP for retrieval of material usage information may wish to restrict an operators ability to clear the material usage data at the controller. This option restricts the ability to clear totals data to program mode only. Press * to toggle between **CLEAR DATA PROMPT ENABLED** and **CLEAR DATA PROMPT DISABLED**.



Settings Mode – Percent of Total or Percent of Natural (4088 Standard Controller, 12-Software Only)

Press (*,0,8) to set the Blend Mode of Operation (Settings Mode) to **Percent of Natural** or **Percent of Total**. Press * to toggle between **Percent of NAT (Natural)** and **Percent of Mix (Total Batch)**. Under the mode Percent of Natural, regrind components are a percent of the total and additives are a percent of the natural. Under the mode Percent of Mix, all components must add up to 99.9 or 100.0%.



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 computer.

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

(Previously: Move table from ROM to RAM - reloads 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.



NOTE: The battery used for backup is a lithium battery that is part of an I.C. chip on the board. It has an expected 10-year life and is not easily accessible for replacement. Should it fail, we suggest that it be replaced at our factory.



Set Material Types for each Hopper (12-Software Only)

Press (*,1,4) to set components to one of four options.

The display will look like this:

MATERIAL TYPES:

Comp 1: OFF

This is the component number and the TYPE it is set to: **REGRIND, NATURAL, ADDITIVE, or OFF.**

Press the CE key repeatedly to toggle between the four options: **REGRIND, NATURAL, ADDITIVE, OFF.**

When proper selection is displayed, move on to NEXT component by pressing the * key.

REPEAT the * CE sequence for ALL components you use.

The * key will walk you through all components, 1 through 9, then A, B, C (A=10, B=11, C=12).

The CE key will change the TYPE for a component.

Components NOT CONNECTED, or NEVER USED, set to OFF.

EXIT will exit the sequence at any time.

After EXIT, if display says **NEED NATURAL** then you have specified an ADDITIVE without specifying a NATURAL. This is an unacceptable condition.



NOTE

FOUR dispense valve systems use components 1 to 4.

TWO dispense valve systems use 1 and 2.

SIX dispense valve systems use 1 to 4, then 7 and 8.

Panel front OUTLETS are always components 5 and 6.



Dispense Order - 4088 Standard in 12-Software Mode Only Requires Percent of Mix (see *08)

Press (*,1,6) to set the dispense order of the components. Controller must be in Percent of Mix (*08) to set a Dispense Order. Press * to toggle Dispense Order modes: Highest to Lowest, Lowest to Highest, Custom. For Custom enter 1-9 for hopper (or feeders) 1 through 9 and A  for component 10, B  for component 11, and C  for component 12. Up to 12 components may be entered. Press CE to clear all entries. Once set, components will dispense in the specified order.



Select Language

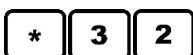
Press (*,1,8) to select the language the controller's display will use. Language options are: English, Francais, Italiano, Deutch, Cesky, Espanol, Polski, Anglescko.



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 CE key on Power Up) 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.

* 2 5

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.

* 3 4

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
T	T = 12 software, W = 4 Software
S1:1:100:000:00004:	Column 1: S1 through SC = components 1 through 12
S2:2:500:000:00004:	
S3:2:500:000:00004:	Column 2: 1 = Re grind, 2 = Natural, 3 = Additive (additive is the same as color)
S4:3:030:000:00004:	
S5:3:030:000:00004:	Column 3: Setting value. Implied decimal in 10ths for regrind and additive.
S6:0:000:000:00004:	
S7:0:000:000:00004:	Column 4: XT Parameter (See XT Parameter on page 71)
S8:0:000:000:00004:	
S9:0:000:000:00004:	Column 5: Alarm parameter (See AT parameter alarm on page 70)
SA:0:000:000:00004:	
SB:0:000:000:00004:	E = End of file
SC:0:000:000:00004:	
E	

* 4 4

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.

* 4 5

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.

* 4 7

WST Totalizer - 4-Software Mode 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)
Press EXIT to exit out of program mode.

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.

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

*** 4 7**

WSD Weigh Scale Dispenser – 12-Software Only

Weigh Scale Dispenser Mode

Press (*,4,7) to turn ENABLE / DISABLE Dispense Station.

The display will say (DISPENSE STATION DISABLED).

Press * to toggle flag to **DISPENSE STATION ENABLED 99.9** or

Press * to toggle flag to **DISPENSE STATION ENABLED 999** or

Press * to toggle flag to **DISPENSE STATION ENABLED 9.99**

The three weight range options alter the range of requested dispense weights. 00.1 to 99.9 is standard. 001 to 999 is optional using this function. Dispense systems are generally used for rotational molding.

12-12 Controllers Only: FUL Parameter Adjustment

Press EXIT to save and exit out of program mode.

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

*** 5 2**

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.

*** 5 4**

Write Cycle-by-Cycle Diagnostic Report to USB

Press (*,5,4) to enable writing of reports containing cycle data to a USB flash drive. Cycle data will write after each full dispense cycle. When **ENABLED** and 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 10**. When display says **COL 10**, the color setting applies to output 10 only, the standard COLOR output. When display says **COL 10 → 11**, this means that output 10 is the starting output, and when no weight is detected after a dispense, the output switches to output 11. The "11" is determined by the parameter (LIQ 11011). You can change the secondary output by changing the parameter. If enabling *57 and component 10 is not set as an additive, the display will briefly show: *** LIQ ERROR ***. If output 11 is also empty, the output switches back to 10. See parameter (LIQ 11011) for more information.

*** 6 0**

COMMUNICATIONS – View Ethernet IP Address, Subnet and Gateway

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

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

*** 6 5**

COMMUNICATIONS – Set IP Address, Subnet and Gateway

Press (*,6,5) to configure Ethernet IP Address Settings. Under Static IP, you may assign a static IP Address, Subnet and Gateway. Press the **CE** key to toggle between DHCP and static IP Address. Enter the IP address, network mask, and default gateway. When finished, press exit. **MLAN commands use TCP port 9999 (G2, OPC, MLAN), Modbus TCP uses port 502.**

*** 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. Valid ID numbers are 001 to 255 (000 reserved for broadcast).

*** 6 7**

MODBUS COMMUNICATIONS – Enable / Disable

Press (*,6,7) to enable or disable Modbus communications. Press * to toggle between **ENABLED** and **DISABLED**. Press Exit when complete. **Modbus commands use TCP port 502.** Modbus registers are available upon request or may be downloaded from our website.

*** 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) (4 Software Mode 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 will say **COLOR AS A % OF NAT (default)**. Press the **CE** key to toggle to **COLOR AS A % OF MIX**.

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

*** 7 2**

ADD & COL AS % MIX - Additive Percent of Mix (4 Software Mode only)

Press (*,7,2) to change the Additive settings to be interpreted as percent of the entire MIX instead of percent of the Natural. The display will say **ADD & COL AS % MIX ENABLED or DISABLED**. Press * to toggle flag between **ENABLED** and **DISABLED**. This option has been added for customers with unique requirements. Leave this flag OFF, (APM- OFF), unless you have specific instructions to do otherwise.

CAUTION: With this flag set, additive settings combined must NOT exceed 100 percent. From a practical standpoint, they should not exceed 10 percent combined.



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**.
Press EXIT when done.



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**. Press EXIT when done.



Parameter Printout to USB

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.



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.



Precision Ratioing - Additives

With Precision Ratioing, natural dispenses occur after the selected additive dispense or the selected 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 COMPONENT 1-12 (additives)**. Only one Additive component 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.

Press EXIT when done to save new settings.



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 (for diagnostic mode, simulated mode or emergency 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.



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:	12/31/2021
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 difference between the two weight printouts should equal the KNOWN CERTIFIED

WEIGHT.

* 8 9

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.

* 9 3

Update Controller Software From 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 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.

* 9 4

**Update Controller NET Software From USB Drive
(WSB 12-12 controllers only, not present in 4088 Standard)**

Press (*,9,4) to initiate a NET specific software 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.

* 9 5

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

* 9 7

**USBC Driver Version
(WSB 12-12 controllers only, not present in 4088 Standard)**

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.

* 9 8

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.

* 9 9

Enables the Zero and Full Weight Calibration of the Load Cells

NOTE: *47 must be disabled to perform a zero or full weight calibration
See Loadcell Zero and Full Weight Calibration on page 24. Available in Manual Mode and Program Mode.

Parameters Introduction

All Weigh Scale Blender operation is controlled by a set of model specific parameters. In most cases the default parameters for a specific model are the ideal starting point for most configurations and parameters can be reset to factory default.

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 milliseconds, seconds, minutes, or interrupts. (244 interrupts = 1 second).
WEIGHTS	Grams or 10ths of 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 percentages for other percentage references (00xxx).

Navigating Parameters:

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

Parameter List - Explanations

General Parameters

(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 forth 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.
MIX 00015	MIX - Mix Time (Seconds) Time mixer motor runs after the weigh bin dumps.

JOG 03030	JOG - Mixer operation after MIX time (count/seconds) After MIX time, JOG will operate mixer 1 turn every xx seconds for a total count of xxx times. First 3 digits 030xx is the total count. Last two digits xxx30 is the interval in seconds.
FCV 00006	FCV – Flow Control Valve – Delays opening and closing of the flow control valve Digit 1 = When power is off: 0=CLOSED (default), 1 = OPEN (must reverse air lines) Digits 2 and 3 = time delay in seconds before closing. Digits 4 and 5 = time delay in seconds before opening. 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.
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 your 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.
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.
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.
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	LOAD CELL limits, low slope, high slope, frequency, zero. DO NOT CHANGE except for different weight load cells.

LCZ 00583	The above 4 parameters relate to the characteristics of the LOAD CELLS on your blender. DO NOT CHANGE THEM.
DS1 00000	Thumbwheel switch override setting. The above 3 parameters allow external computer inputs to alter the thumbwheel switch settings. They are used on computer controlled dispense systems, using MLAN software.
DS2 00000	
DS3 00000	
XCV 00000	Extrusion control voltage output value Rate of change of above value Takeoff control voltage output value Rate of change of above value Trip point to force a correction Percentage adjustment limit Voltage adjustment limit The above 7 parameters all relate to Extrusion Control Systems.
XRC 00040	
TCV 00000	
TRC 00040	
XTP 05020	
XAL 00005	
XUL 00200	
MPO 00000	For air drive reciprocating mix motor
SCR 00000	Special Customer Request
BCR 00000	Barcode Reader
CPL 00000	Yield Control - Counts Per Linear unit of measure
PTD 00020	Pulse Train Delta
MCT 00000	Monitor Cycle Time
LIQ 11011	Liquid Additive - Pump in a Drum (components 10, 11 ... one minute retries then switch 10 to 11)
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 Loss in Weight High Level Fill (LLF and HLF are set by *22, LIW Model selection)
HLF 40000	
SBO 00000	Sensor Blow Off for the purpose of clearing dust and particles from the face of the sensor. Lowest Dump Rate of Regrind (Grams/Second) Loader Timeout #1 (Time in seconds) Loader Timeout #2 (Time in seconds) MLAN Delay Interval (Time in milliseconds)
RLO 00050	
LT1 00000	
LT2 00000	
MDI 00000	

Component Parameters - 12 Groups of 15 parameters each

The first digit is the component number. Component 1 is shown here. There are 11 more just like it. The underscore (_) at the beginning of a parameter represents the component number, 1 through 9, or "A" for component 10, "B" for component 11 and "C" for component 12.

1TY = OFF	DESIGNATES MATERIAL TYPE for this component. Material types are: REG, NAT, ADD, or OFF=NOT USED. (0=OFF, 1=REG, 2=NAT, 3=ADD) These MUST be set using the *14 function before the system will operate. See: "TURNING ON OUTPUTS" to complete this.
1CS 00000	Thumbwheel assignment or current setting entry. This parameter reflects the current setting or thumbwheel assignment for this component. No entry is required here.
1AL 00000	Last digit = number of retries before ALARM. 00001 to 00009 = sound alarm, hold process. 00011 to 00019 = sound alarm, continue process. 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 Re grind.
1XT 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.
1SE 01000	Upper SETTING limits for thumbwheels (0xxx.x). Settings greater than limit are held to limit. (01000) = 100% These parameters can SET UPPER LIMITS to the thumbwheels. For color and additive, lower settings may help ensure expensive material is not wasted.
1WT 24000 1TI 01952	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. 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.
1MI 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.
1NC 00001	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.
1PT 00000	Reduce the target of the first try dispense.
1RP 00010	PERCENT shortage error that will force a retry.
1RD 00300	GRAM weight shortage error that will force a retry. Retries occur until both conditions are met.
1LA 00020	Lag TIME before dispense 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.
1PO 00000	Pulse rate of "MICRO PULSE" valves.
1SL 00000	SETTING LOWER LIMIT – Set a lower limit on the setting (4088 Standard Only)

Parameter List – Full Explanations

GENERAL PARAMETERS

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

FLG is a SET of flags for turning on the RECIPE, BATCH, FAST and TAG 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 fourth 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.

MIX **Mixer Control – Mix Time (Seconds)**

TIME mixer motor runs after weigh bin dumps.

Default: 00015. Maximum setting of 29999 (mix time over 8 hours).

99 (MIX 00099) = 360 seconds (6 minutes).

JOG **Mixer operation after MIX time (count/seconds)**

After MIX time, JOG will operate mixer 1 turn, every xx seconds for a total count of xxx times to level the pile of material in the mix chamber, insuring that the sensor does not remain covered for too long. First 3 digits (030xx) is the total count. Last two digits (xxx30) is the interval in seconds. Default 03030 produces a jog every 1/2 minute for up to 30 jogs. 000 causes the controller to jog forever (no timeout).

FCV **Flow Control Valve - Delays opening and closing of the flow control valve**

Digit 1 = When Power Off: 0 = CLOSED (default), 1 = OPEN, (must reverse air lines).

Digits 2 and 3 = time delay in seconds before closing.

Digits 4 and 5 = time delay in seconds before opening.

FCA Flow Control Alarm (Enable/Disable)

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 - 00002

DTI DTI - Weigh Bin Dump Time (seconds)

Maximum TIME allowed to determine an empty weigh reading.
Set according to the model and batch size.

KDF Vibration Control**WDF KDF Calibration Weight Reading Difference (1/10th gram)****WDF WDF Operation Weight Reading Difference (1/10th gram)**

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 BER - BAIL-OUT THRESHOLD - Excess GRAM weight before dispense is aborted.**Change only if severe vibration causes problems**

BER is the BAILOUT ERROR weight. During a material dispense the weight of the weigh bin is monitored constantly. If bin weight is found to exceed target weight during the dispense by the amount specified in the BER parameter, then a BAILOUT occurs. This ends the dispense of the current material being dispensed immediately. To prevent a false bailout the dispense weight is checked and retries will occur if dispense is short of target weight. The remaining material dispenses within the cycle dispense at their normal target weight.

Parameter default is 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 USB 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 exceed target by the amount specified in the BER parameter.

ROC Allows for adding some ADDITIVE to one of the REGRIND portions

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 to adjust.

The last 3 digits are 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 Re grind) and ADJUST the total of all NATURAL dispenses upward by this amount. Whatever amount of component 1, Re grind, is added, 20 percent of this amount will be added to the Natural amounts before a color calculation is made.

ROV **Regrind Control (12-12 Controllers Only)**

ROV and RHL parameters work together. Their combined purpose is to allow the adjustment of one Re grind component up or down based on input from one or two lever sensors.

LEVEL SENSORS are required for this parameter to work.

Both ROV and RHL must be set for these parameters to have any effect.



NOTE

The component being controlled is ALWAYS automatically assigned to the bottom set of thumbwheel switches.

The first digit of the ROV parameter indicates which component is controlled by the adjustment routine. Only components 1 through 9 may be controlled.

The last digit determines the adjustment rate. Zero in the last position means make the full adjustment immediately. Any value from 1 to 9 indicates the percentage adjustment that will be made each cycle when the level sensor condition changes. See RHL below for examples.

RHL **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 Re grind 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.

FUL Full Batch Target Weight (Grams)

Change only for extremely light or heavy material

Default values are based on average material volume. Light weight material may exceed weigh bin volume and may require lowering FUL value. Lowering FUL decreases throughput.

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 Maximum Gram Weight Per Batch

If FUL parameter is changed, MAX is reset to a value 150 percent of FUL.

An over dispense of one component may cause a new, higher target batch weight. A recalculated target weight will not exceed MAX.

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 – Tare Weight High Limit

TL – Tare Weight Low Limit

TH and TL are acceptable upper and lower 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 (model specific), the ALARM sounds. If Tare weight is above the value of TH (model specific), The ALARM sounds and the weight bin dump flap operates in an attempt to empty the weigh bin. If you are processing a material that has a tendency to stick to the weigh bin, you can increase the TH value to widen the range of acceptable starting tare weight. Since tare weight is always subtracted from dispense weights, these errors do not effect accuracy.

PRT AUTOMATIC printout of material usage totals to USB (minutes)

Timing starts at 12:00 am. Example 00120 = 2:00 AM, 4:00 AM, 6:00 AM, etc.

10000 = printout after every cycle. 0=disabled

DLY Cycle Start Delay - (milliseconds)

Time in milliseconds that the sensor must be uncovered before cycle start. Minimum of 02000 (ms) is recommended. With low throughput, increasing DLY may allow better mixing if needed.

PRC Maximum allowable percent rate change per cycle. If a large dispense error occurs, flow rate corrections do not exceed this percent number. Prevents large changes in timing of dispenses and provides for stable dispense rates under difficult conditions.

STL **Dispense Settle Time - (milliseconds)**
Time for dispensed material to SETTLE before weighing.

LCL **Load Cell Limits – DO NOT CHANGE**
LCH Automatically set by model number.

LCF
LCZ

DS1 **Function in Dispenser mode only.**
DS2 Override top, middle and bottom thumbwheel switch settings.

DS3 When the system is operating as a dispense system, (FUL 00001), the dispense weight is retrieved from the top thumbwheel switch or from the recipe file if the middle thumbwheel is set to a recipe number.

If either DS1, DS2 or DS3 is set to any value greater than zero:
Substitute DS1 for the TOP switch settings,
Substitute DS2 for the MIDDLE switch settings, and
Substitute DS3 for the BOTTOM switch settings

These three parameters allow MLAN to download the dispense weight amount or recipe number. They also allow entry of a "locked in" amount or recipe.

If BOTH DS1, DS2 and DS3 are set to 00000, then nothing changes.



NOTE

The middle thumbwheel switch setting for a recipe will override the top switch setting. When loading a weight into DS1, load 00000 into DS2 to be sure DS1 will control.

SCR **Special Custom Routines**

SCR = 0: Disabled

SCR = 1: Not used

SCR = 2: Mixer motor failure alarm enabled, stops process until alarm is silenced

SCR = 3: Mixer motor cycle alarm, stops process and cycle must be aborted

SCR = 4: Volumetric mode saved across power toggles

XCV **Extrusion Control Voltage**
XRC (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.

XTP

Extrusion Control Trip Point

(For Extrusion Control Systems only)

The LAST THREE digits of the XTP parameter specify the TRIP POINT when software makes 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.

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.

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).

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.

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 01011, which directs that component 10 is the normal output, and 11 is the component to switch to. Outputs 10 and 11 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 00506, which is to say that the "additive" outlet (output 6) is designated as the back up output for COLOR (which is output 5). Other arrangements are possible.

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.

G2F G2 Totals Collection Alarm

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 it's 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.

RLO Lowest Dump Rate of Regrind (Grams/Second)

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 very small quantities. We have set RLO at the factory to 5 percent (00050) allowing a minimum dispense of 5% or about 100 grams.

LT1 Loader Timeout #1, Loader Timeout #2

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.

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.

COMPONENT PARAMETERS

The underscore (_) represents the component number, 1 through 9, and "A" for component 10, "B" for component 11 and "C" for component 12.

_TY Material Type – Also see Configuring Settings on page 27.

OFF = Disabled

REG = Regrind

NAT = Natural

ADD = Additive

_CS Set AUTOMATICALLY when you enter settings

_CS parameter stores the current setting that has been entered through the keypad "SET" function or communications for this component.

This parameter can also be used to assign this component to one of the three digital or mechanical thumbwheel setting switches. When the _CS parameter set to 10000, 20000, or 30000, the component will follow the TOP, MIDDLE, or BOTTOM thumbwheel switches respectively. The SET routine also assigns thumbwheels.

_AL Standard Alarm - Sets alarm functions

When material runs out, or material does not dispense fully, these parameters specify the alarm action. Sets the alarm action per component, when material runs out.

The last digit is number of retries before 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. Press Silence Alarm button to restart retries.

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

First 3 digits (000xx) used to STOP and ALARM on an over dispense in grams or percent.

Grams: 001 – 499.

Percent: 501 – 599 (1% to 99%).

_XT Sets decimal place in the component setting

00000 = XX.X (Default)

00010 = X.XX

00100 = .XXX

_SE Setting Upper Limit - Use to lock out high settings or limit access

_SE is the upper SETTING limits for this component allowing for a maximum to be set for each component. Settings that are greater than the limit are held to the limit. Component Setting Lock Out - When a 1 is entered as the first digit of this parameter, (_SE 1xxxx), setting entries can only be made from the program mode. If a Digital Setting Display is assigned to a component and that component is locked out using a 1 in the first digit of the _SE parameter, the component setting will display on the thumbwheel but cannot be changed at the thumbwheel display unless the operator logs into program mode.

_WT Weight/Time for Material Flow Rate

_WT, and _TI parameters are related to the flow rate of each material. Set by the Flow Rate Calibration routine (page 35) and adjusted automatically as necessary after each cycle.

_MI Minimum Rate (10ths of grams)

_MI sets to 80 percent of the amount of material, in grams, that can feed in one second based on normal valid dispense rates. Power-on resets _MI to 00001. After 10 cycles have occurred without retries, the controller will learn and set the corrected number. _MI is also set automatically by the Flow Rate Calibration routine.

When the _AL parameter is set to 0, the MI parameter is left unchanged.

_NC Limit Adjustment (10ths of grams)

Allowable GRAM error within which no flow rate corrections are made. Dispense to dispense gram weight variations that are equal to, or less than, this number will be accepted, and flow rate changes will be made.

_PT Percent First Dispense - For augers and micro pulse devices only

The _PT parameters will cause the first dispense to be a percentage of the full target weight. Subsequent retries target 50 percent of the remaining dispense target. 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 will cause retries up to within 1% of target, improving accuracy. Example: Set _PT to 00090 the first dispense will target 90% of the full target.

_RP Allowable Percent Shortage (percent)

_RD Allowable Weight Shortage (1/10ths grams)

_RD is set automatically by the flow rate calibration routine

These two parameters determine the dispense shortage that is accepted. And are used together to cause a dispense "retry". A "retry" is an additional dispense that is calculated to add the amount of material that is short from the first dispense. 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.

_LA Lag Time (ms)

Time before material dispense actually starts. Offsets the mechanical lag to the controller's signal to start. Lag time is automatically added to all dispense times.

_PO Pulsed Output - For Micro Pulse devices only (1/10ths second)

Sets the ON and OFF time of a pulsed output device during operation. Used in combination with a "micro pulse" equipped slide gate.

00101 = pulsed operation enabled

00000 = pulsed operation disabled

First three digits (001xx) ON time (1/10ths of a second)

Last two digits (xxx01) OFF time (1/10ths of a second)

Pulsed Output may also assist in dispensing regrind and some powders when these materials tend to bridge. 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.

_SL SL – SETTING LOWER LIMIT – Set a minimal setting limit (4088 Standard Only)

When enabled, the minimal setting will be held to the lower limit in the component's SL parameter. Enabled is a value ranging from 00001 - 00999 or 00001 - 09999 in 4-digit mode. Uses the component's decimal place for the decimal location. 00000 disables lower limit.

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**:

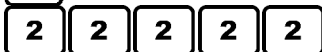
Turn **POWER ON**. Wait 5 seconds, until display says **WAITING**

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**

Saving Parameters in the User Backup Settings

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

If an unexpected problem occurs, a "CLEAR" will clear all data from memory and replace it with information stored in 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

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 53.

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 53. To set the MLAN ID number see *66 on page 53. 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. This example uses the data from a 12-12 controller.

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

```

-----
**1 R20.0**  **2 N  100**  **3 A 04.0**  **4 A 00.0**  -----
* 11/10/21 *  *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**  **3 A 04.0**  **4 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. Setting and material type is shown for each.

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

The **CYCLE** heading:

```

* 11/10/21 *  *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 (milliseconds in 4088 Standard controllers, and Interrupts (244/second) in 12-12 controllers); 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 if 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 obtaining acceptable weight readings. Increase the WDF parameter to 2 or 3 grams, (WDF 00003) or (WDF 00030), or more if necessary.

Load Cell Calibration - Printout Verification

To print a Load Cell Calibration Printout, insert a flash drive into the controller's USB port (the flash drive requires a folder named "maguire" to be present). Enter Program Mode (*22222) then press * 8 8. The following document will print to the flash drive.

MAGUIRE WSB WEIGH DOCUMENTATION

MACHINE ID: 7
DATE: 03/18/21
TIME: 17:10:08
DISPLAY READOUT: 4000

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 difference between the two weight printouts should equal the KNOWN CERTIFIED WEIGHT.

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		
COMP 1	R 05.0	2.4	4.8	1.5	5.0	
COMP 2	N 100	47.4	100.0	28.6	100.0	
COMP 5	N 00.5	.4	.99	.2	.99	
COMP 6	N 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 10 or more cycles of Cycle-by-Cycle printout and then email 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 gauge 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 24.
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 loosing 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 series units use an air drive for the mix blade, instead of an electric motor.

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. Turn "FAST" on. This causes rapid volumetric "timed" dispenses to occur up to 4 times after each normal gravimetric dispense.
5. 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.

Load Cell Raw Signal Readout

Press "CE" key to check this RAW number for several seconds.

Load cells put out a very small voltage that varies slightly as the load cell is deflected. This voltage is converted, on the circuit board, to a pulse train and these pulses are counted for 1 full second to determine a weight load. The software can handle a range of counts from 0 to approximately 249,850.

A properly operating set of 3 K cells will range from about 55,000 to 120,000; a span of about 65,000 from empty weight (weigh bin in place), to a full bin weight of 2000 grams. (10 K load cells range about 90,000 from empty to a full 9000 grams). The system will work correctly as long as the empty bin weight readout is between 1 and 149,248. 149,248 is the highest number that the software will accept for zero weight calibration (see parameters, LCZ). If the number is over this when you press the ZERO weight key, the display will say (ZERO LOW).

This RAW COUNT number is converted to the proper gram readout, by the software, based on load cell calibration information.

The RAW COUNT numbers are more useful in diagnosing load cell problems because they bypass the calibration math and, therefore, bypass any calibration errors that might have occurred.

Press "CE" key to display this RAW number for several seconds.

To observe this number continuously, use the ***98** function in the PROGRAM mode.

Press		Display will say: ENTER PASSWORD
Press	    	Display will say: PROGRAM
Press		Display will say: INSTRUCTION [_]
Press	 	Display will say: DISPLAY RAW COUNTS DISABLED
Press		Display will say: DISPLAY RAW COUNTS ENABLED
Press		Display will say: PROGRAM
Press		Display will say: CT= xxxxxxxx

A floating, drifting number usually indicates the load cells are not plugged in.

A readout of 0 indicates an open circuit, a damaged wire or cell.

A full-scale readout of 249,850 indicates a damaged wire or cell.

A set of 3 K load cells will put out about 33 more counts for every gram of weight that is added. A test of sensitivity is to add a small weight to the bin. The RAW WEIGHT count should increase by about 33 counts for each gram added. (10 counts per gram for 10K load cells.)

If you call us for help in solving a load cell problem, it is helpful if you can tell us what the RAW COUNT number is with the bin empty, and with a known weight in it. Pressing the CE key at any time will display the RAW COUNT number for the current weight.

To OPERATE with DAMAGED load cells in a VOLUMETRIC mode, see KEYPAD, ***87**, Volumetric mode.

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



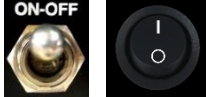
Power Off to the Controller. The power switch is in the lower-right on the front of the controller.

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 POWER ON RESET or RESET, ***** 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	OFF	Power Off to the Controller
Hold		Hold these keys down simultaneously
Switch	ON	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]

[illegible]

Updating: xxx/726

[illegible]

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.

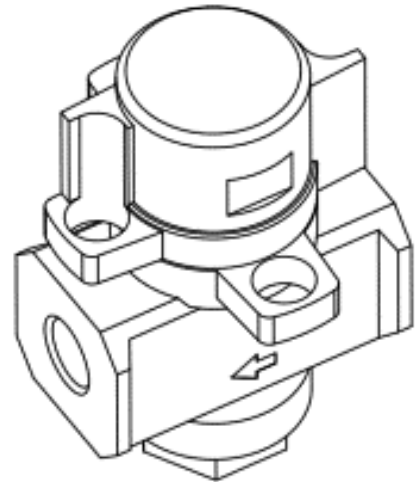
LOTO, Cleaning, Maintenance

Pneumatic and Electrical LOTO

The blender should be pneumatically and electrically locked out prior to any Cleaning/Maintenance/Repair of the blender.

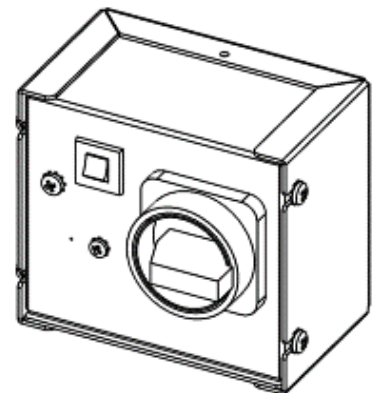
Pneumatic Lockout/Tagout Points

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. In the event that 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 locked on the blender prior to any Cleaning/Maintenance/Repair of the blender. See Pneumatic and Electrical LOTO on page 97.
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 not 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

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 Adjustment

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 very small regular screwdriver to adjust it.
2. Turn the adjustment screw clockwise until the LED turns ON.
3. Turn the adjustment screw counter-clockwise 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 as a result of material dust or static.



Sensor position on 200 and 400 series models only:

The sensor should protrude into the mix chamber about 1/4 inch past the inside surface of the stainless mounting plate. If it does not protrude far enough, it will sense the mounting plate itself. If it protrudes too far, it will sense the mix blade.

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 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. 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 24.

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.



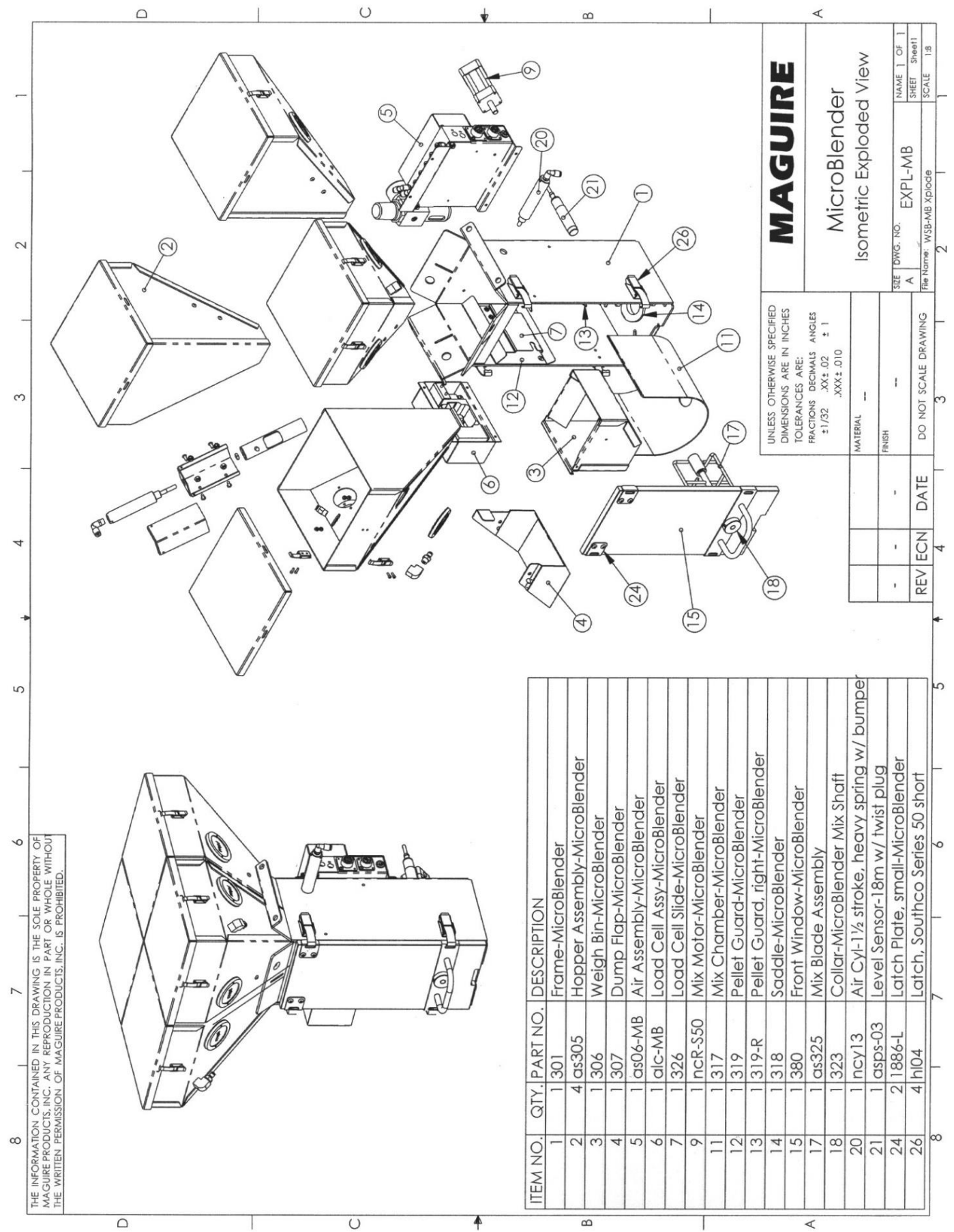
17 pin Amphenol connector

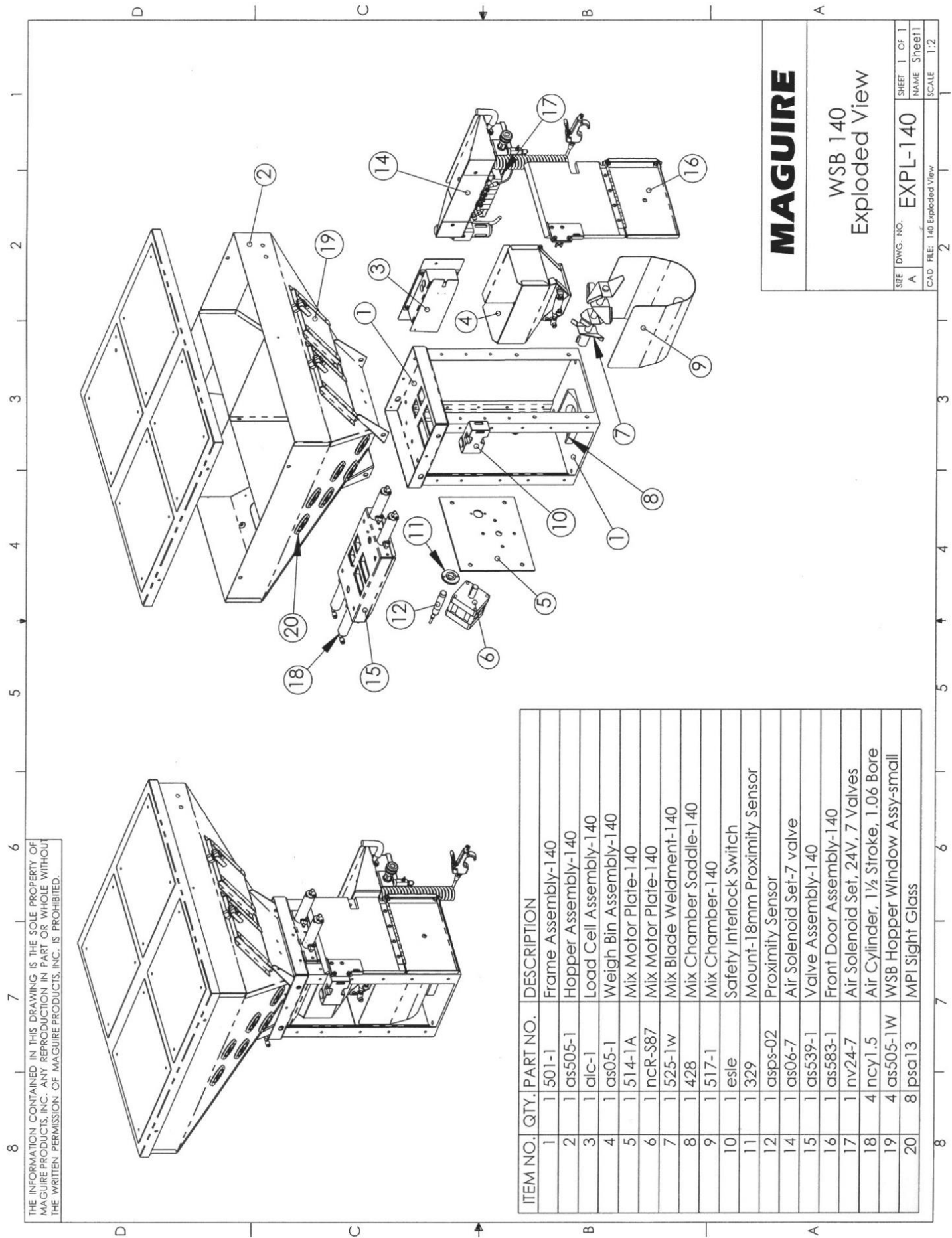
This pin goes to the outside world through this connector: 17 pin Amphenol connector	to drive this external device:	wire color
pin A	weigh bin dump air solenoid	brown
pin B	component 1 air solenoid	orange
pin C	component 2 air solenoid	blue
pin D	component 3 air solenoid	gray
pin E	component 4 air solenoid	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	

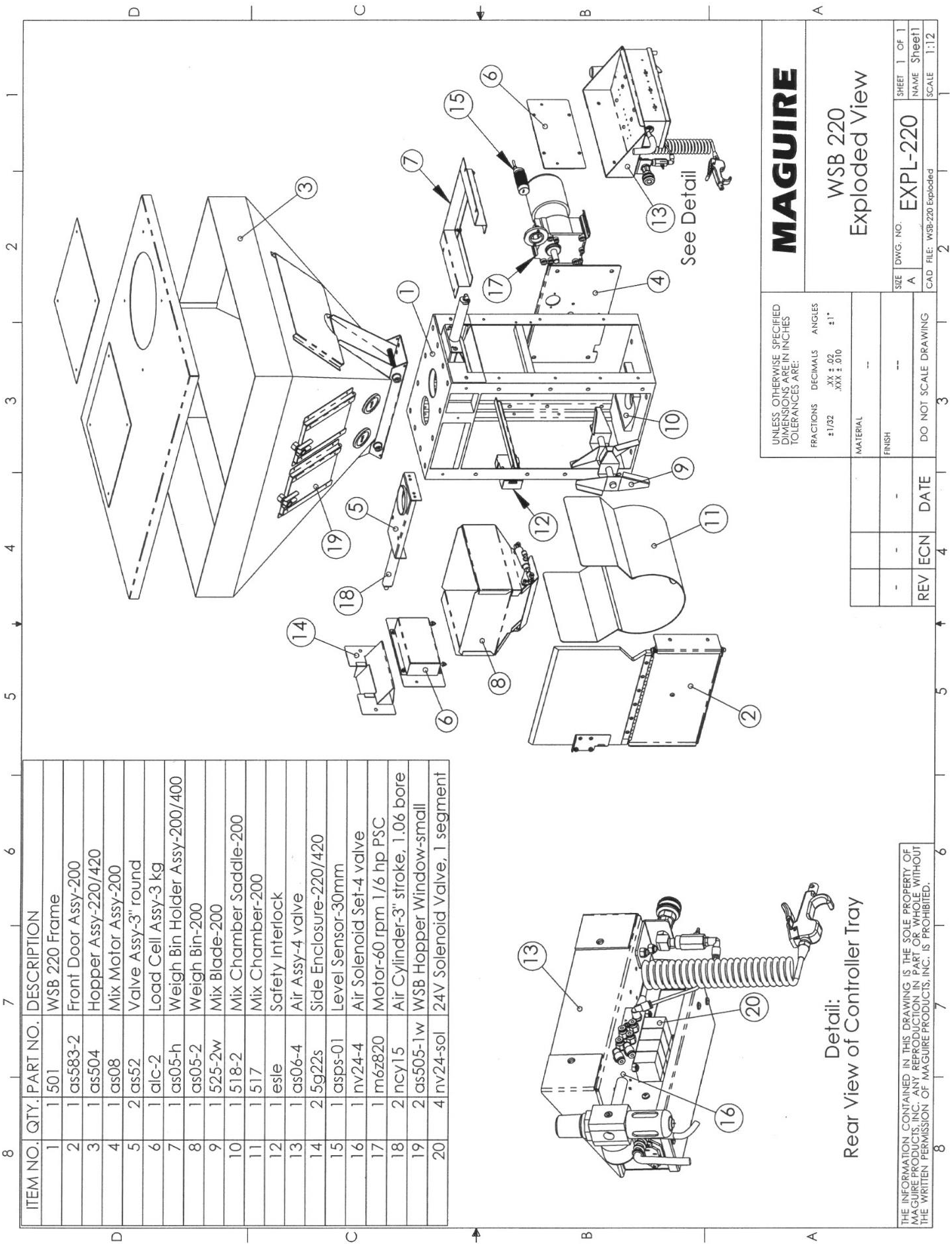
External SS relays are optional.

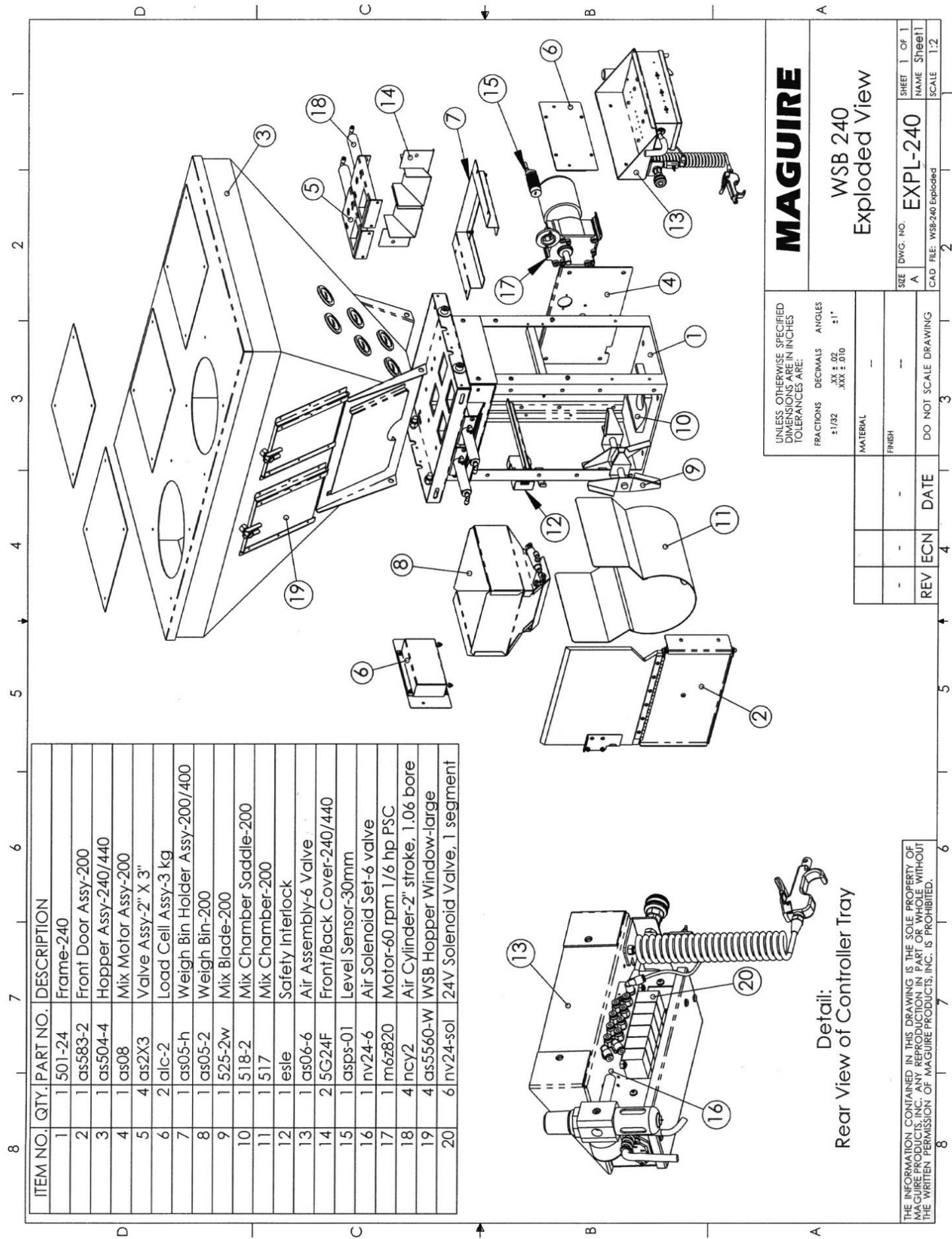
External SS relays and air solenoids may be exchanged.

Technical Drawings

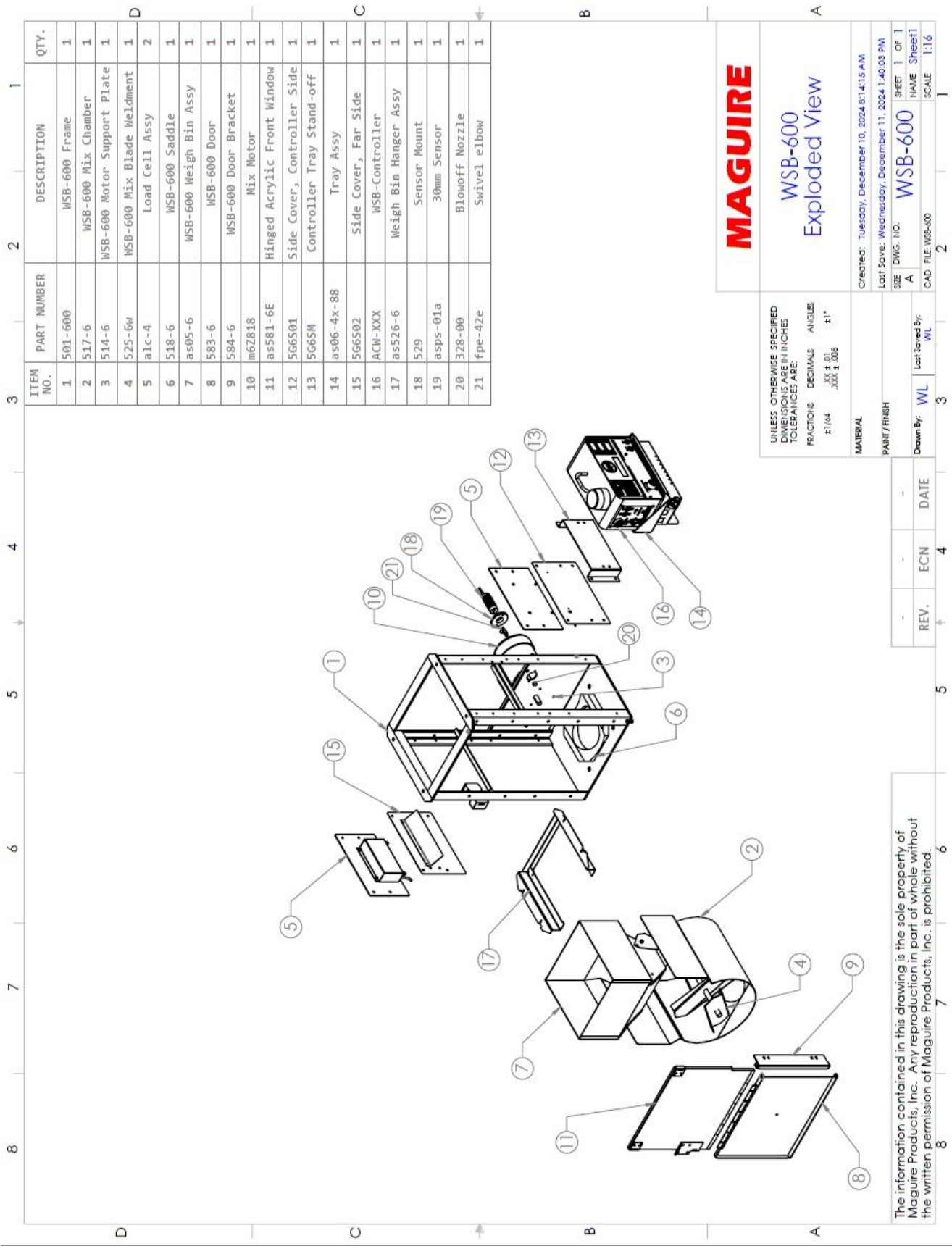


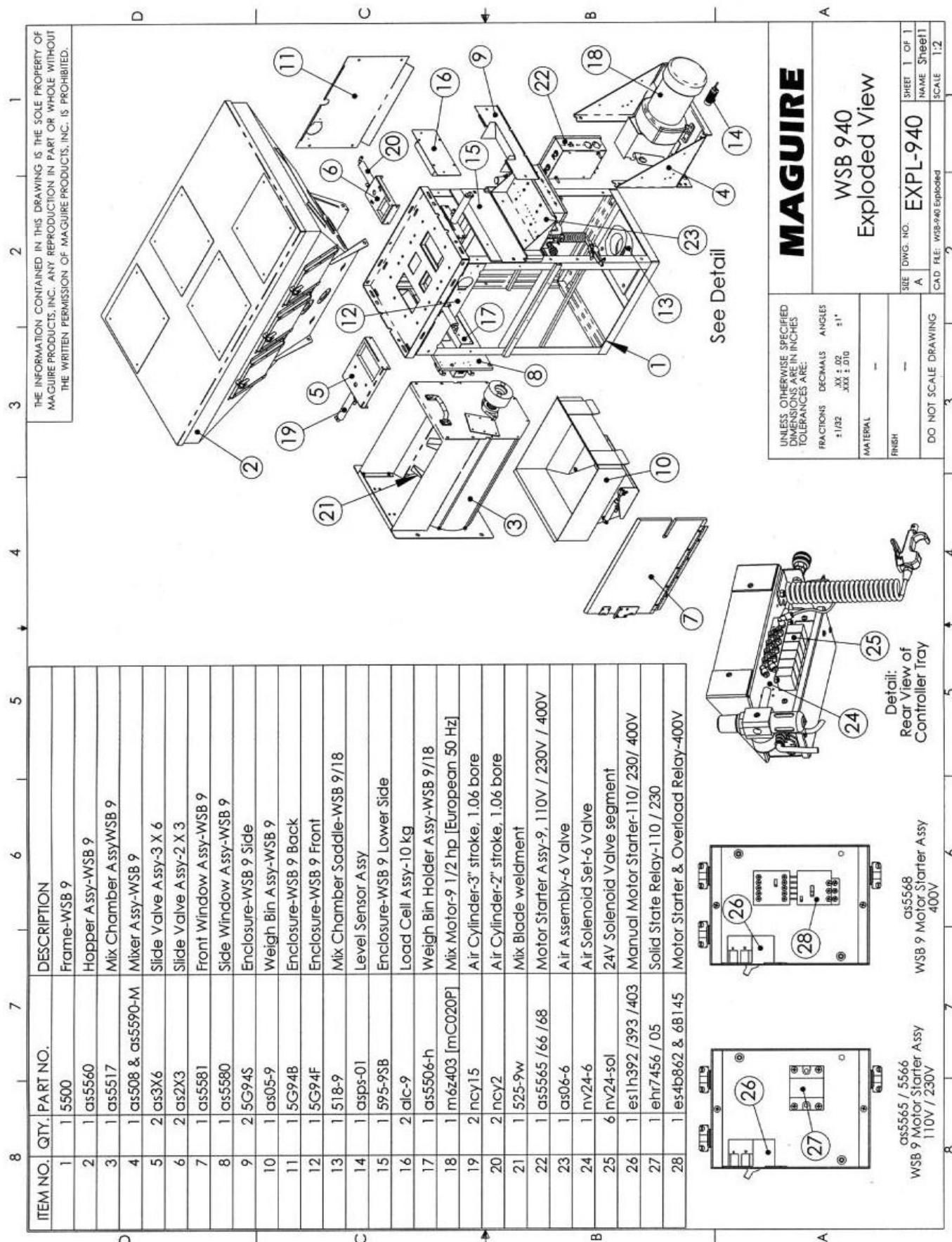




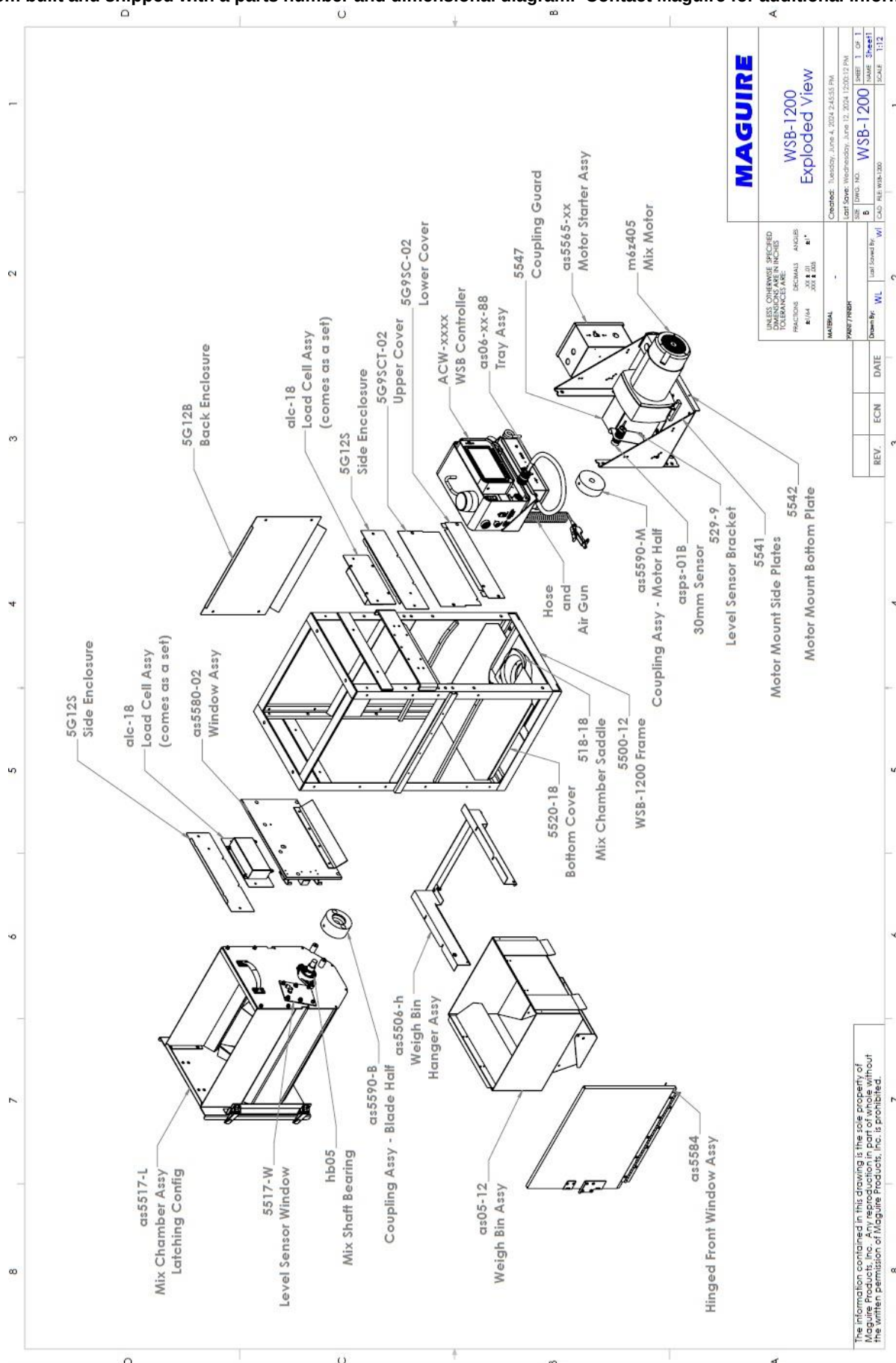


The WSB-600 exploded view parts diagram is shown as the base only. Hopper configurations for each WSB-600 are custom built and shipped with a parts number and dimensional diagram. Contact Maguire for additional information.

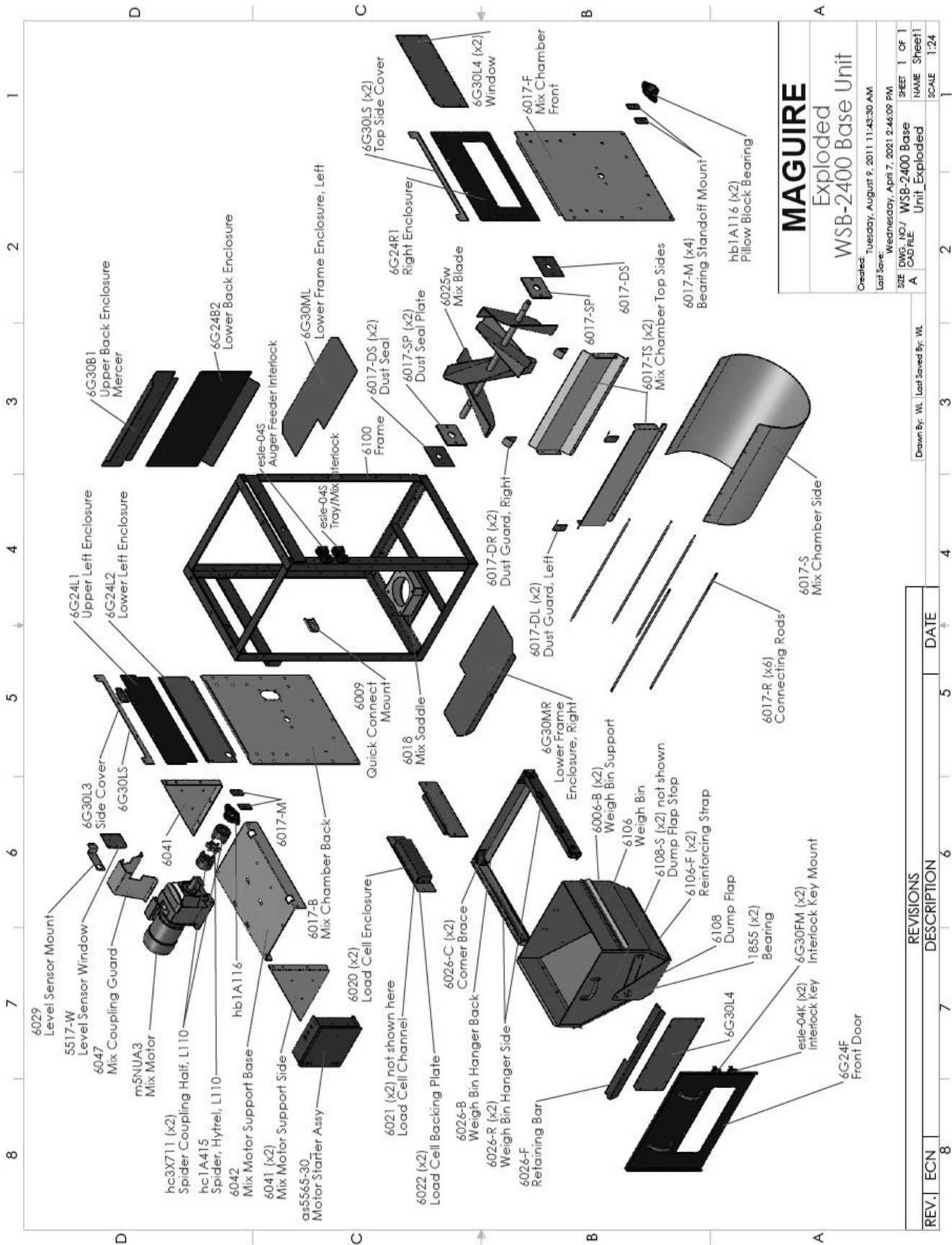




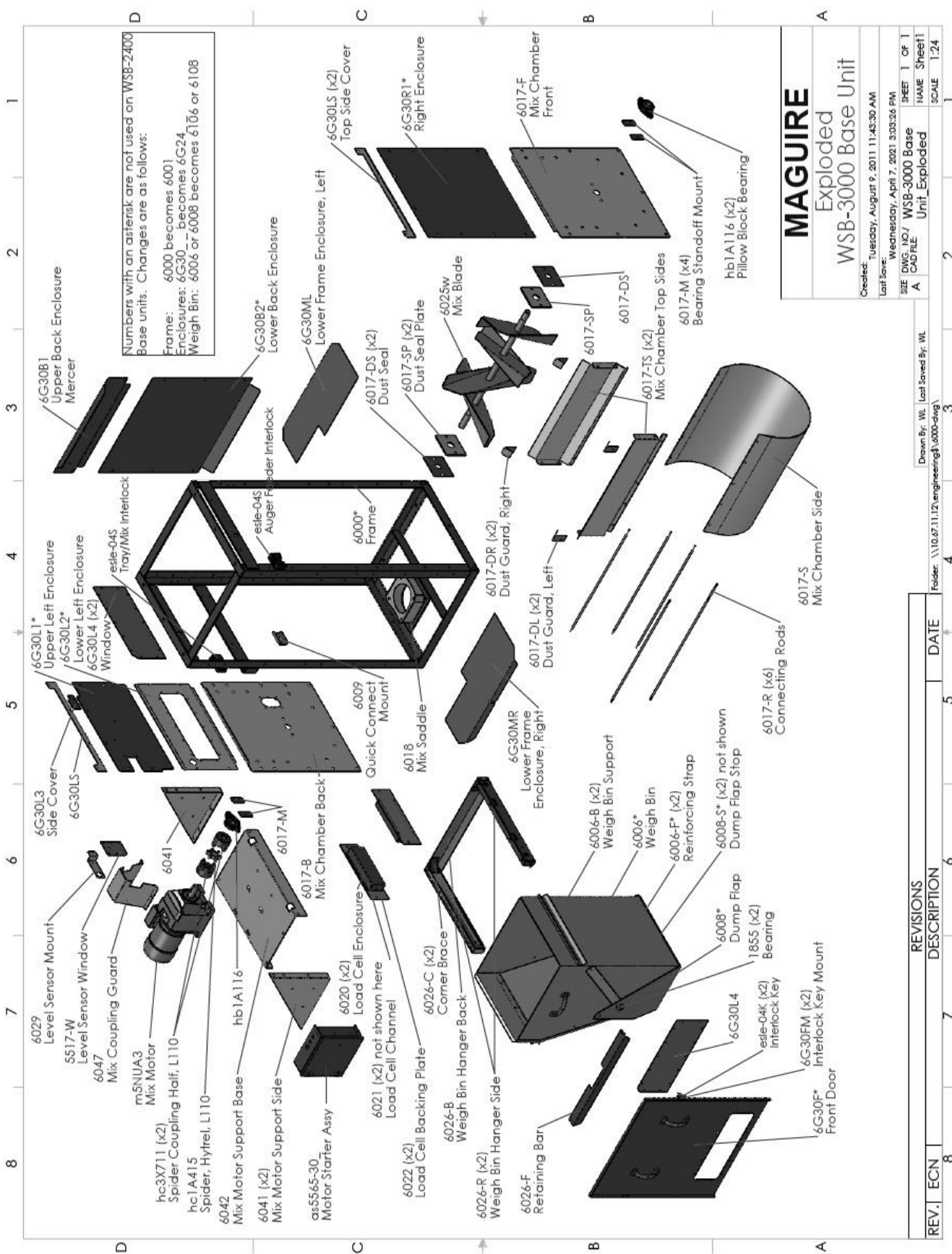
The WSB-1200 exploded view parts diagram is shown as the base only. Hopper configurations for each WSB-1200 are custom built and shipped with a parts number and dimensional diagram. Contact Maguire for additional information.

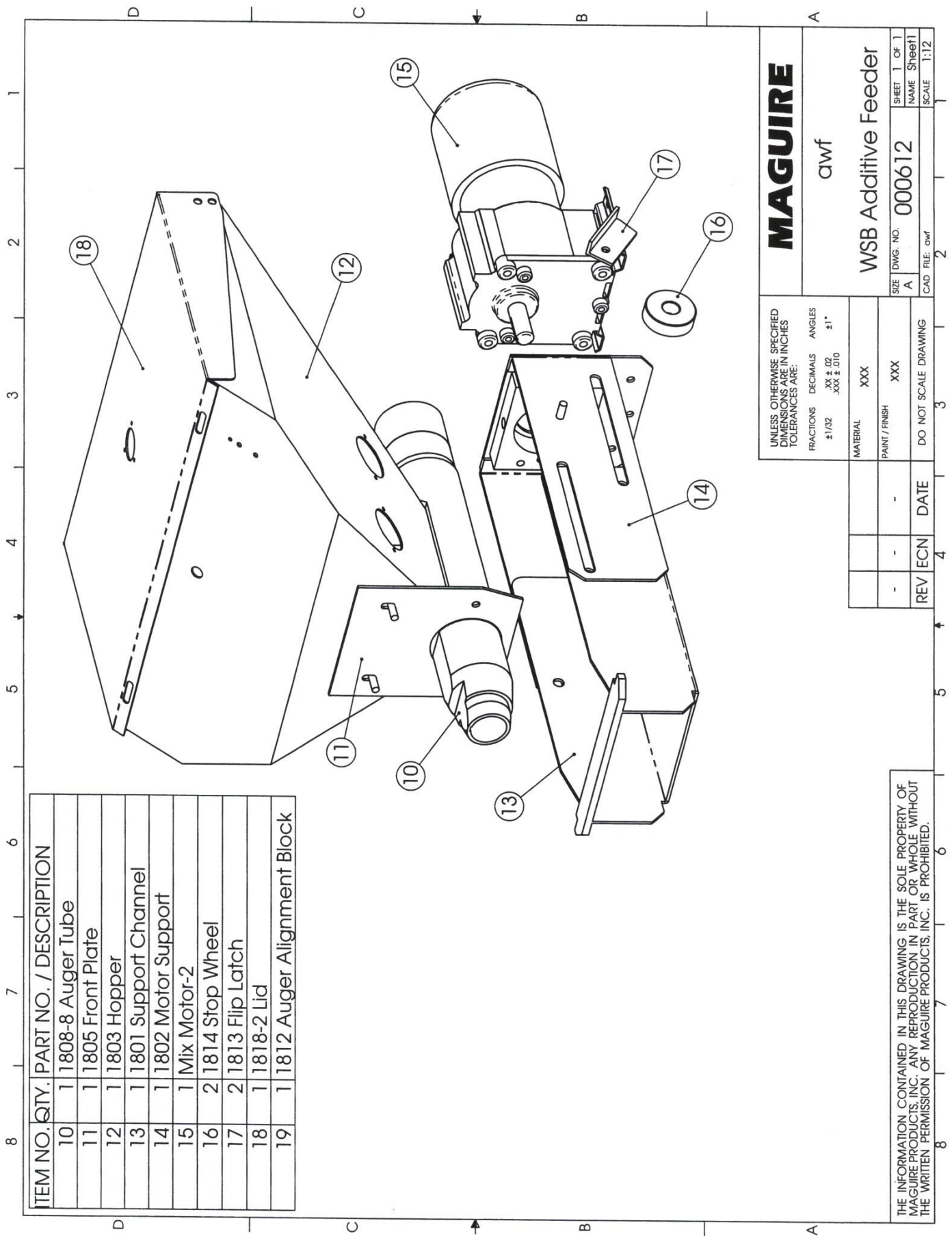


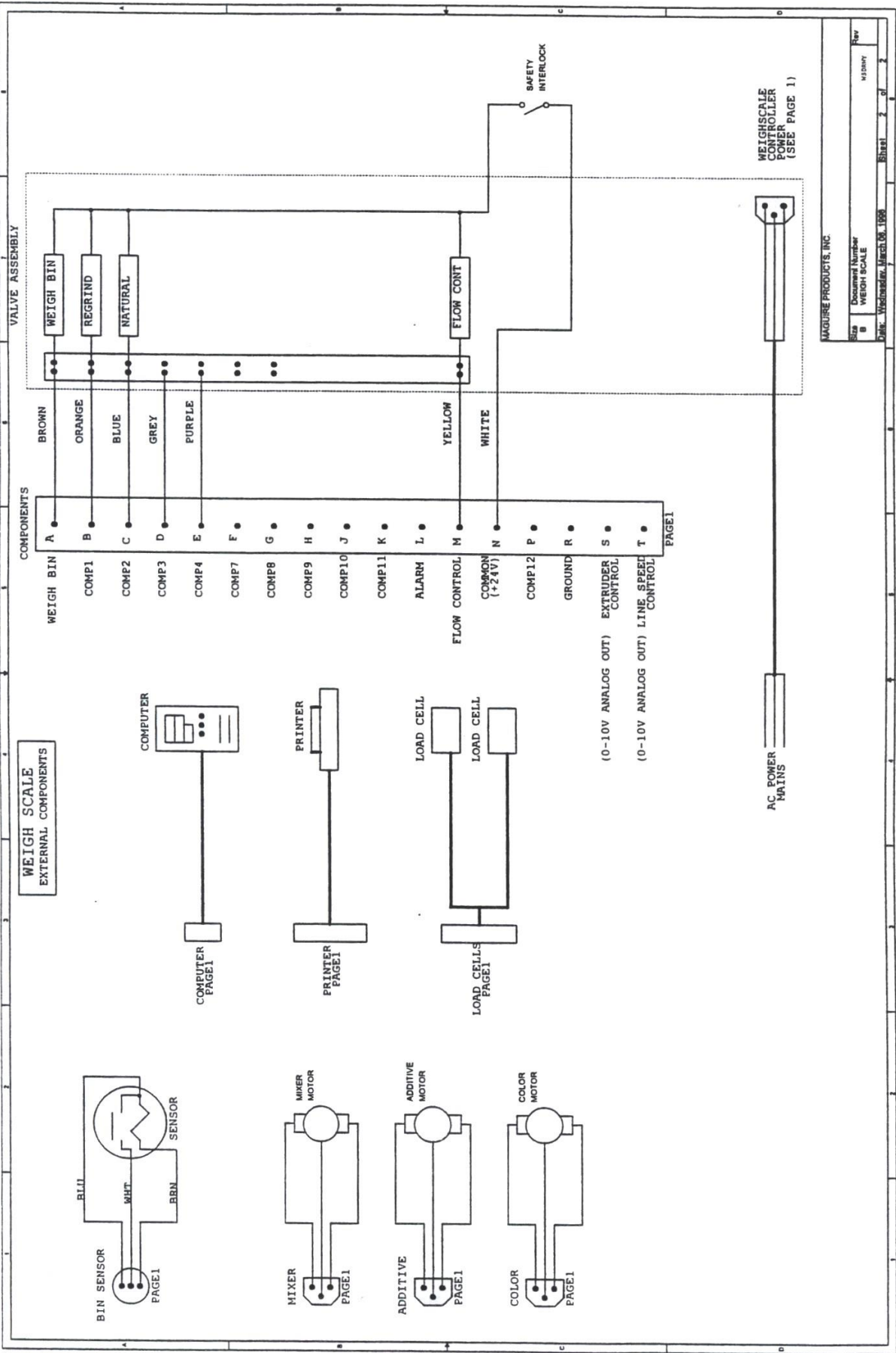
The WSB-2400 exploded view parts diagram is shown as the base only. Hopper configurations for each WSB-2400 are custom built and shipped with a parts number and dimensional diagram. Contact Maguire for additional information.



The WSB-3000 exploded view parts diagram is shown as the base only. Hopper configurations for each WSB-3000 are custom built and shipped with a parts number and dimensional diagram. Contact Maguire for additional information.



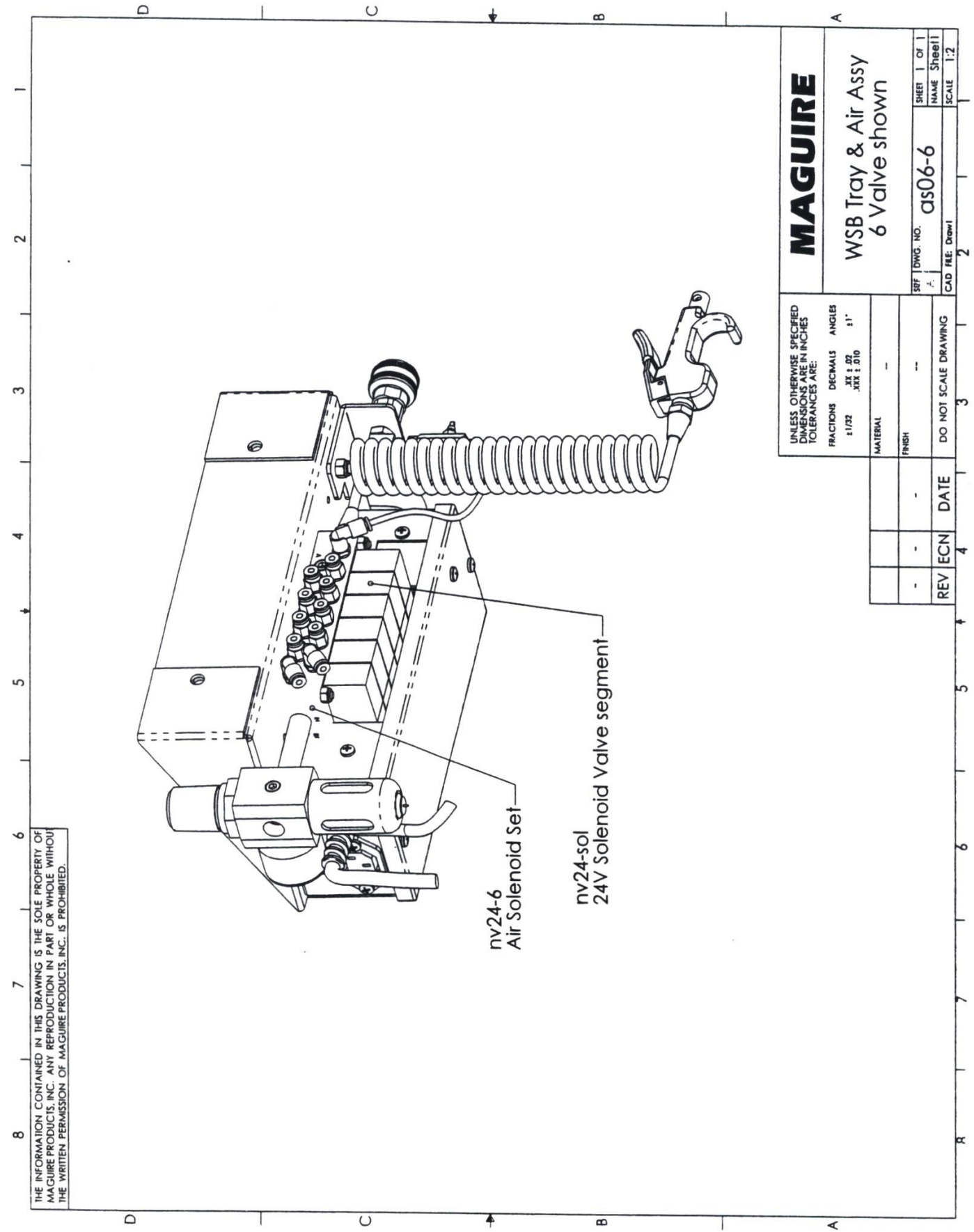




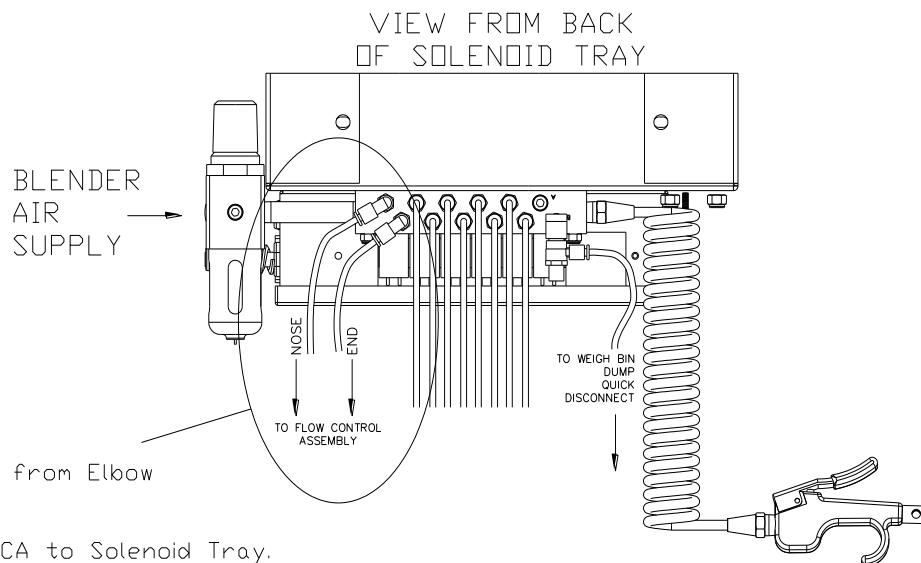
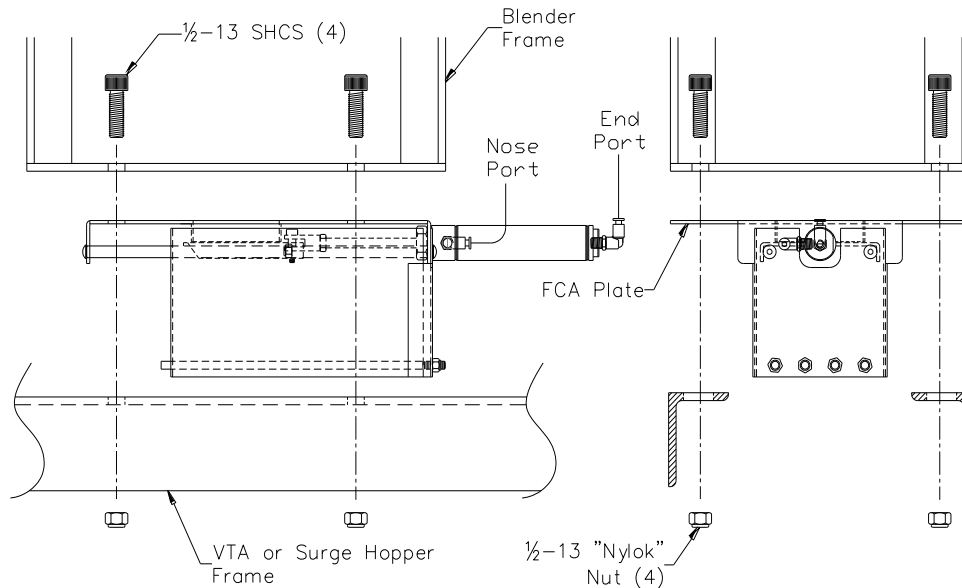
MAGUIRE PRODUCTS, INC.

Size	Document Number	Rev
B	WEIGH SCALE	1
Date: Wednesday, March 06, 1996		
Sheet	2	of 2

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.

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:

FRACTIONS	DECIMALS	ANGLES
±1/64	.XX ±.01	±1°
	.XXX ±.005	

MATERIAL

PART / FINISH

Drawn By:

Created: Tuesday, February 27, 2024 3:07:55 PM

Last Save: Wednesday, February 28, 2024 9:54:15 AM

SIZE DWG. NO.

CAD FILE: FCA Initial.dwg

SHEET 1 OF 1

NAME Sheet1

SCALE 1:4

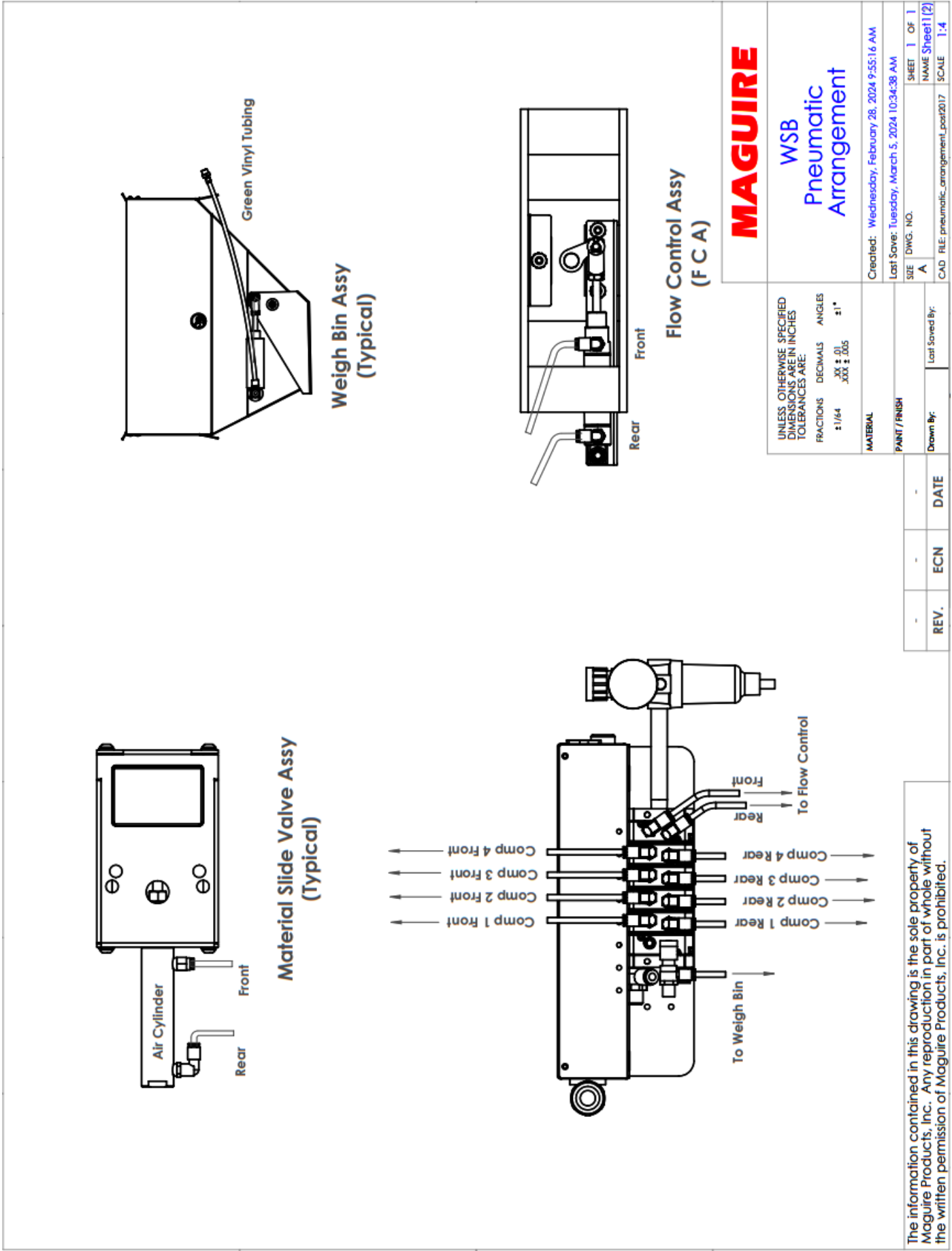
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ECN

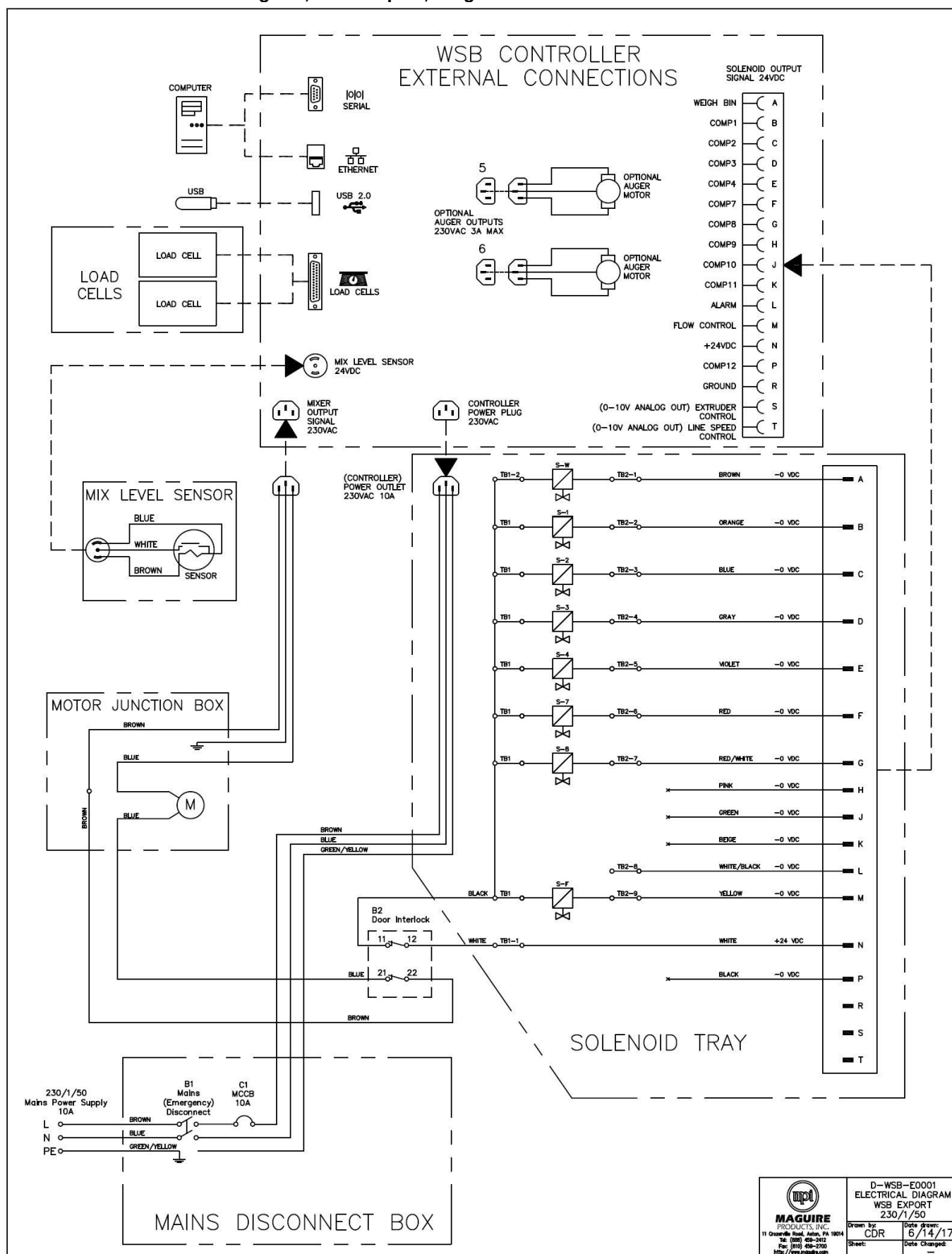
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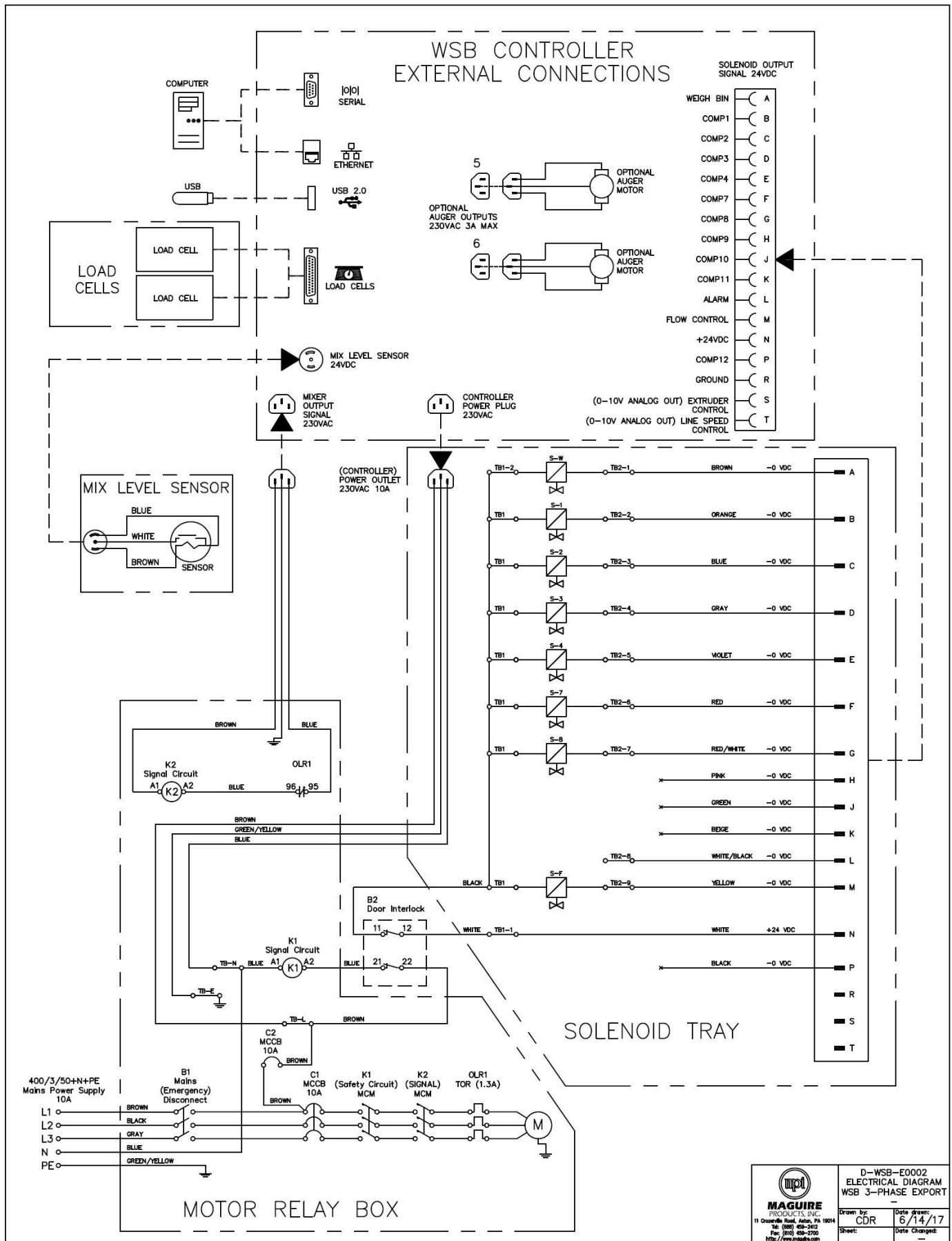
Air Solenoid Tray post-2017



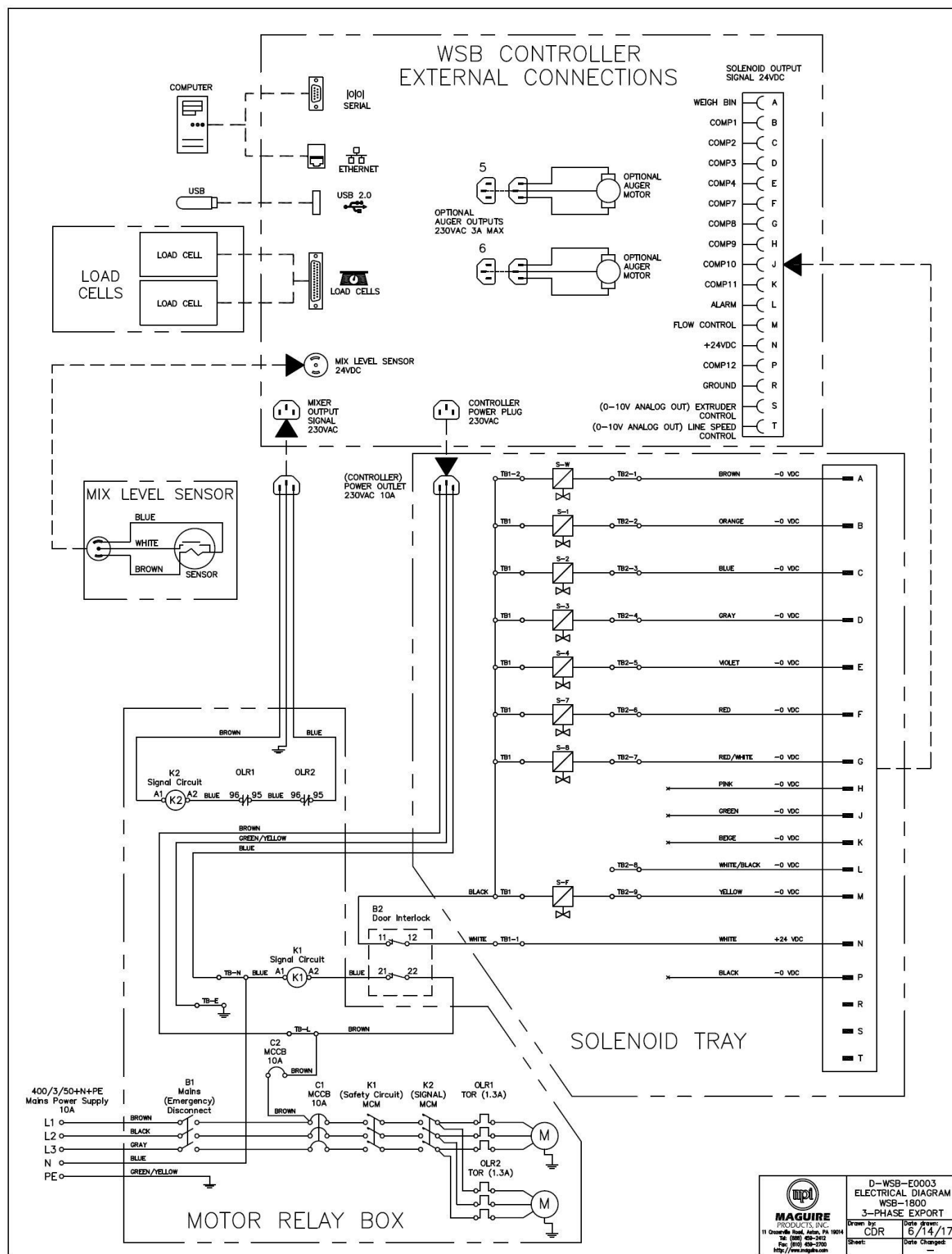
D-WSB-E0001 - Electrical Diagram, WSB Export, Single Phase



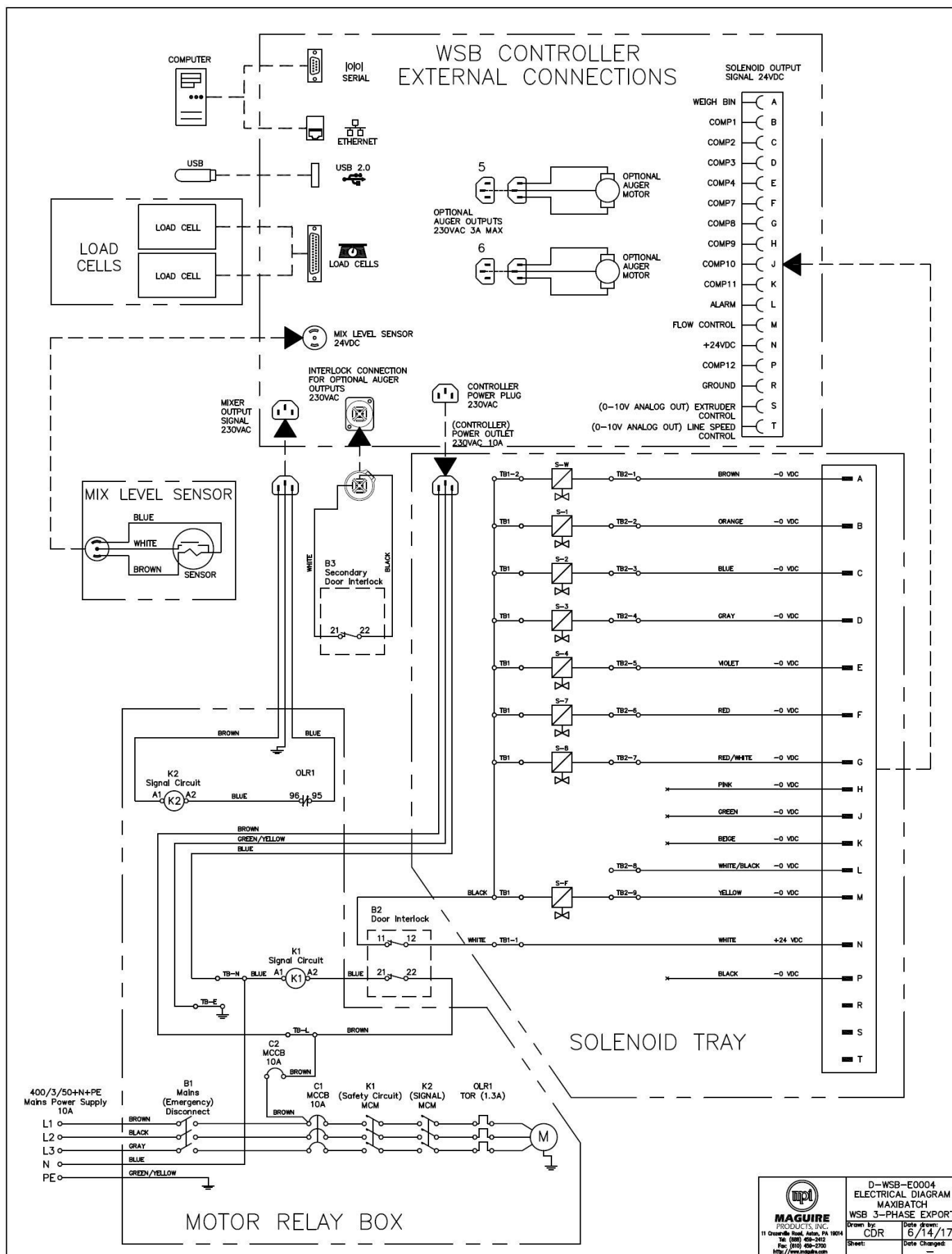
D-WSB-E0002 - Electrical Diagram, WSB Export, 3-Phase



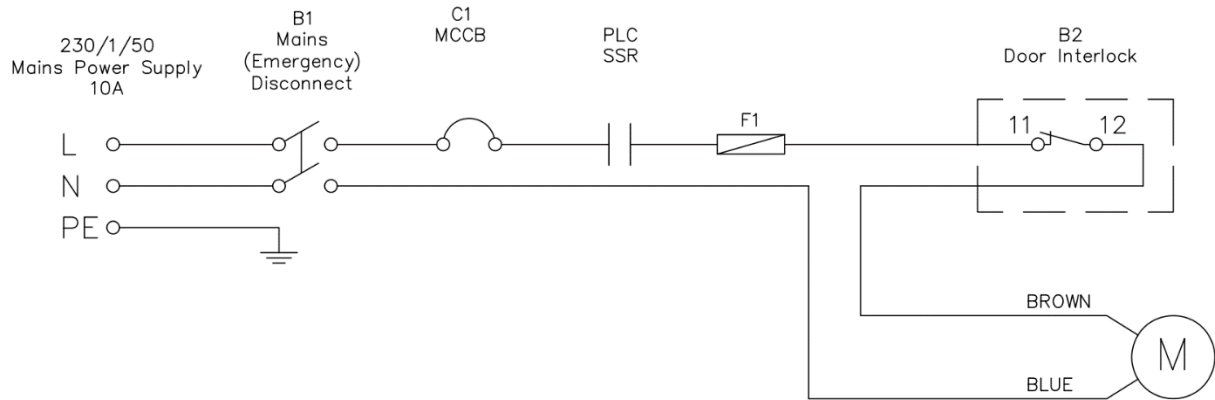
D-WSB-E0003 - Electrical Diagram, WSB Export, 1800 3-Phase



D-WSB-E0004 - Electrical Diagram, WSB Export, Maxibatch

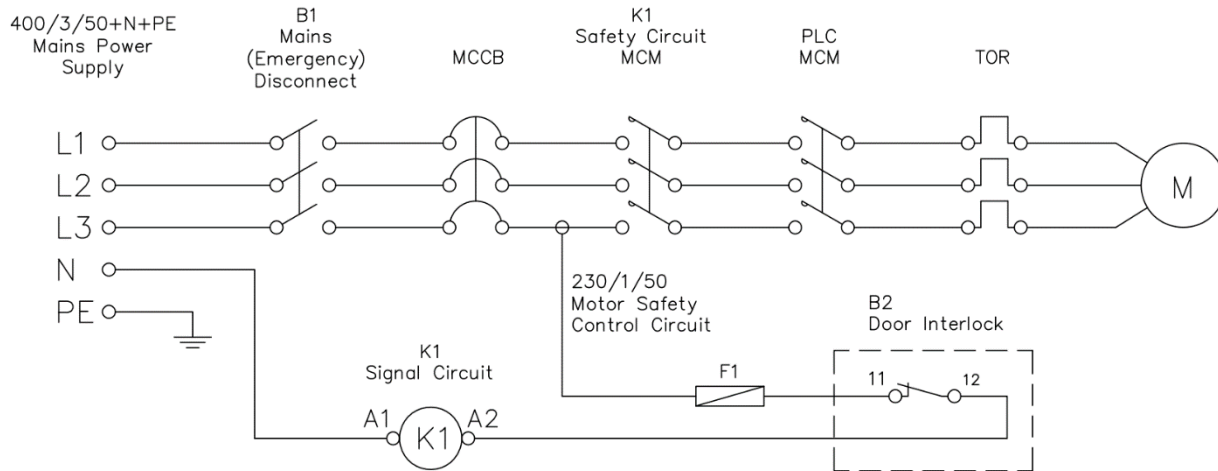


WSB Single Phase Motor Safety Circuit



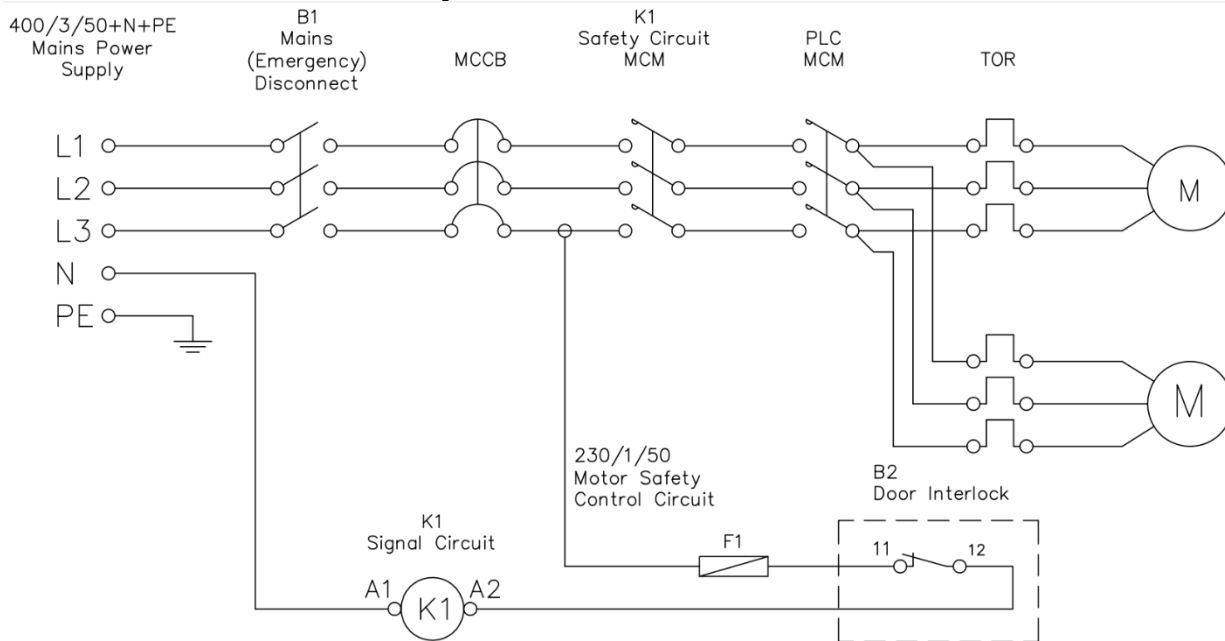
WSB Single Phase Motor Safety Circuit

WSB 3-Phase Motor Safety Circuit



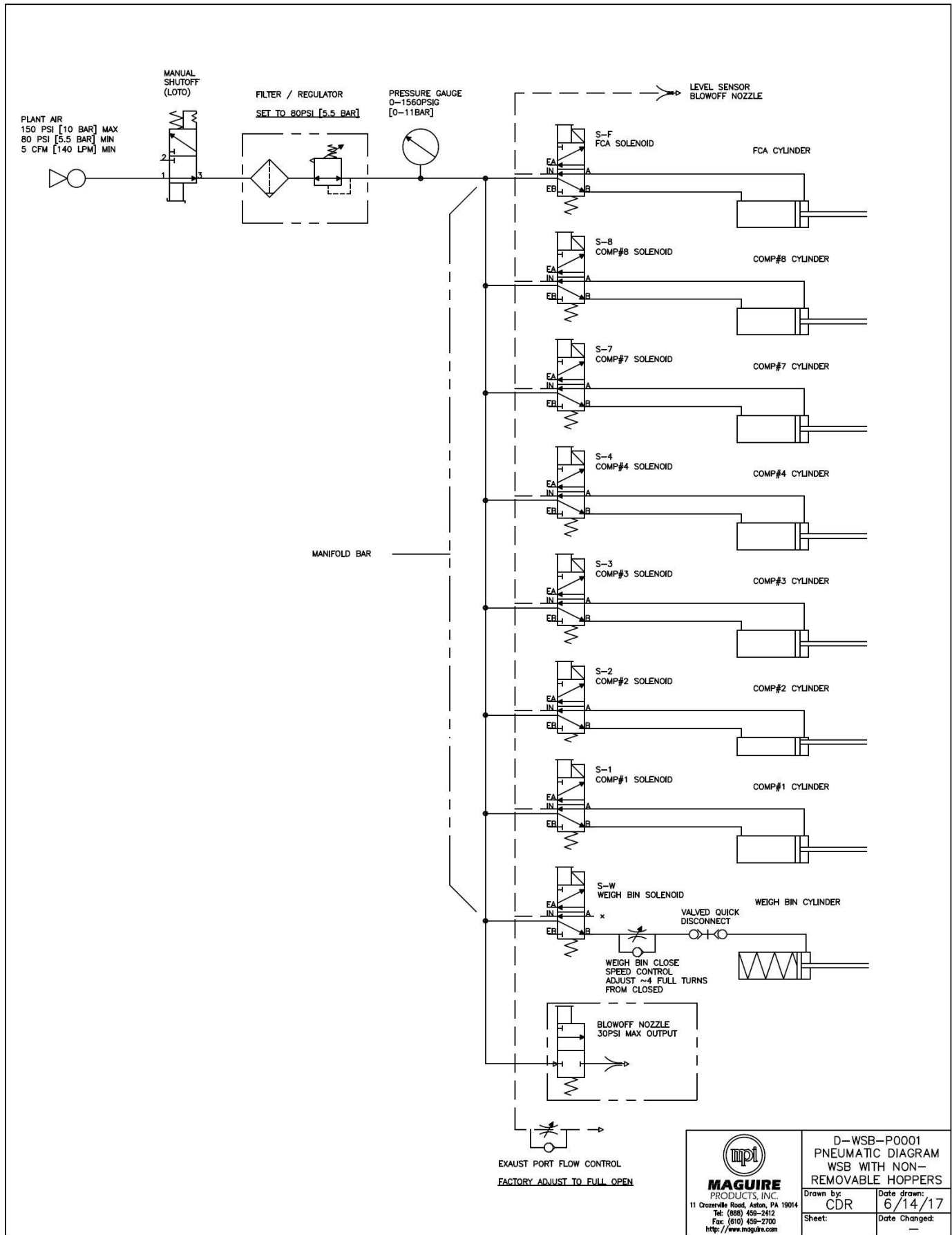
WSB 3-Phase Motor Safety Circuit

WSB-18 3-Phase Motor Safety Circuit

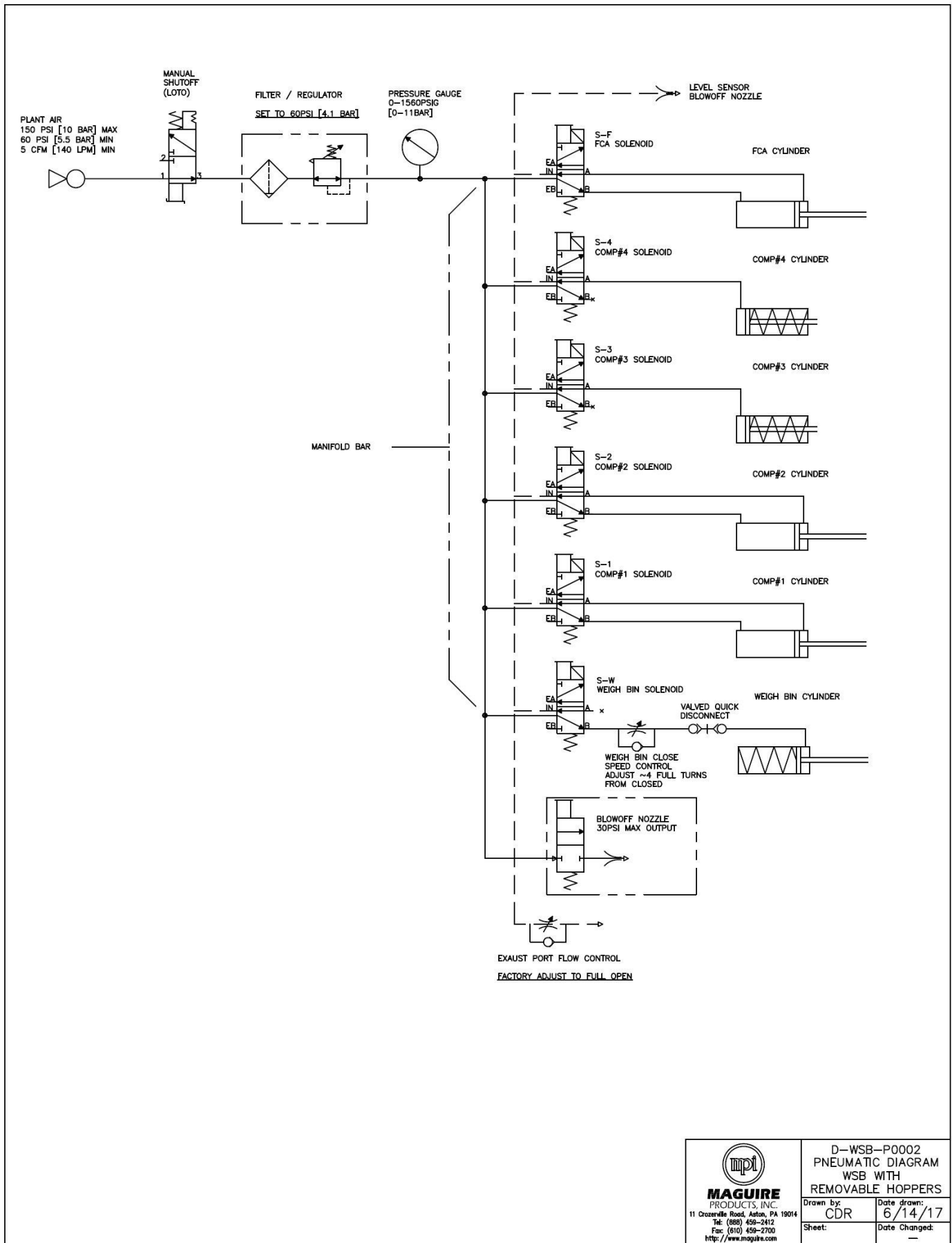


WSB-18 3-Phase Motor Safety Circuit

D-WSB-P0001 - Pneumatic Diagram, WSB, with Non-Removable Hoppers



D-WSB-P0002 - Pneumatic Diagram, WSB, with Removable Hoppers

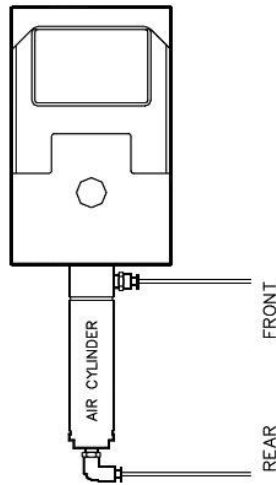


PNEUMATIC ARRANGEMENT

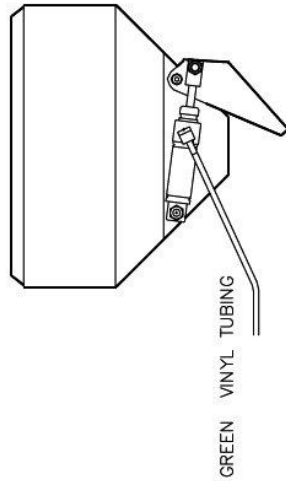
WSB Models with Electric Mixer



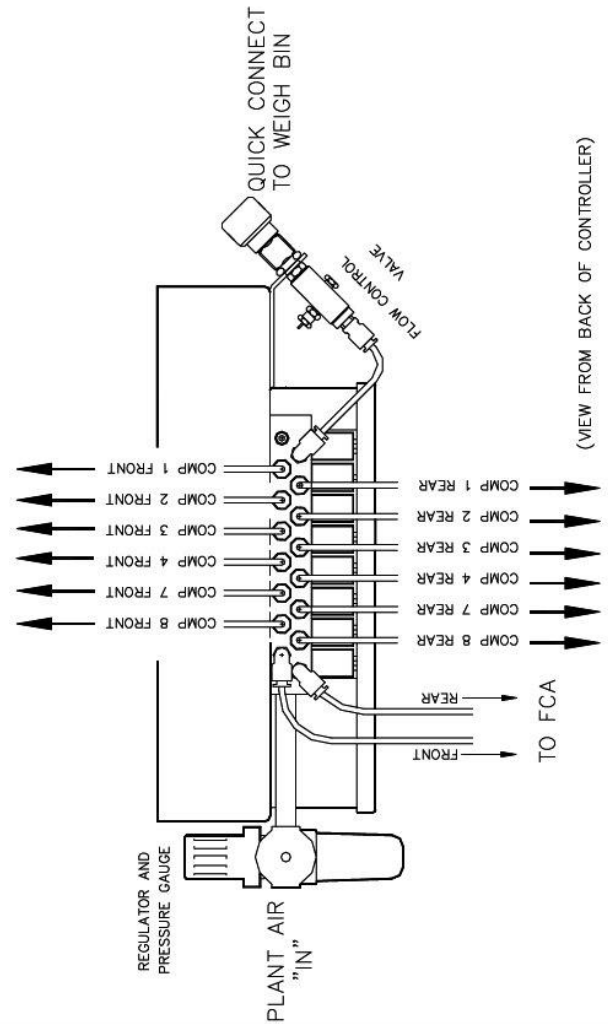
MAGUIRE PRODUCTS INC.
11 Crozerville Road
Aston, PA 19014 USA
610-459-4300
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MATERIAL SLIDE VALVE ASSY
(TYPICAL)

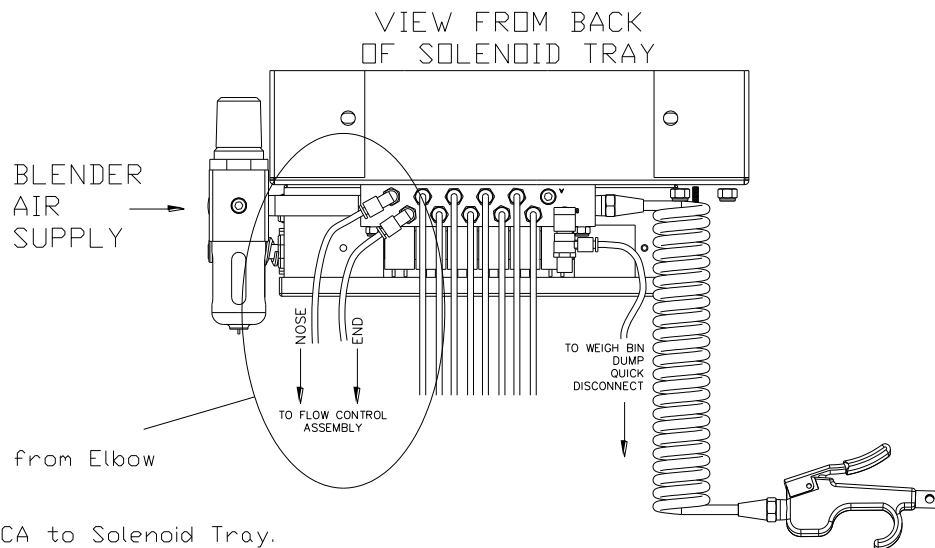
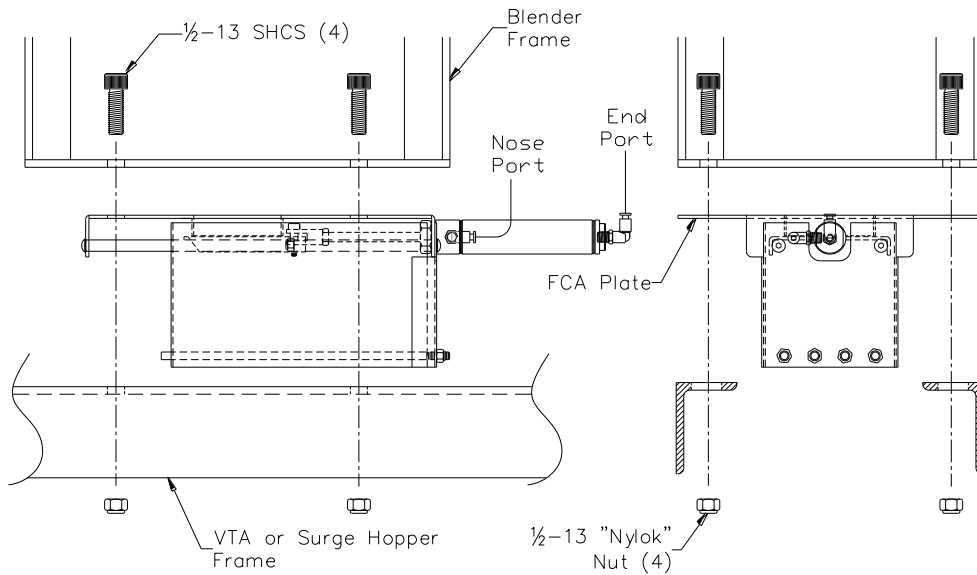


WEIGH BIN ASSY
(TYPICAL)



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.



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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	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

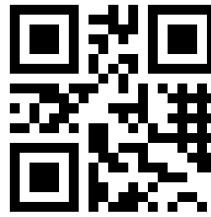
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