

EURO SIZER ES4



Operator Manual



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CHARACTERISTICS

System of selection to weight for calibrated us to cups, rolls and carts.

The weight is in relief through cells of load opportunely filtered and elaborate in a resident program in the CPU. The program (Accounting) he is directed to furnish a chart of liquidation and it furnishes therefore a bead with the Total ones / Caliber in weight and in percentage. As it regards the clearing, up to 4 exits can be defined for every caliber and these can work in mixed or single wrapping for number or hang.

The whole dynamics of the car is managed through an Optical Encoder that it synchronizes the operations of reading and clearing.

Hardware

Entries:	Analogical	4	Cells of load 350 Ohms
	Digital	1	Optical Encoder 1000 imp/tr (10 cups)
		1	Sensor NPN 10-30 Vcc
		1	contact n.o. (End Champion)
Exits:	Analogical	2	0-10Vs Inverter Sorter and Feeding
	Digital	2	Relay contacts n.o. (Block feeding during Tara)
CPU:	DAC	10	bit resolution + / - 1 gram
	Speed	10	cups / sec.
	Type tara		Tara / Line and Tara / Cup selectable.
	AutoPhase		Through the sensor of Beginning Chain. (Optional)
	Adjustable point of open Solenoid		globally for all the magnets.

Software ES4

Programs: Unique file for all the types of products.
Functions of Edit: Change, New program, Copy, Cancellation and Press.

Beads: I file container the results of the workmanships.
Functions of Edit: Change, New stamps, Copy, Cancellation and Press.
In the beads the are recorded "Gives" inserted during the workmanship :
Number of the conferment, code and manufacturing name, a line of Notes.
The Edit allows the insertion of a Total Game and two types of discards of which one already weighed and therefore inclusive in the calibers and one from the bench of selection and therefore in sum.

Workmanship: The curtain that allows to change the programs of Workmanship to Modify Weights and Exits of the Program of Workmanship directly entering the window of Edit of the program.
To take back and to continue a suspended workmanship.
To compile the Data during the workmanship.
To reset, to Adjourn, to Visualize and to Stamp the Total ones.
To close a game with recording e/o stamps.
To manage the Control Costs.
To manage an Exit of Control Quality.

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Service: Curtain that contains the control functions and set-up of the car.

Assistance With all the control functions and regulation.

Dynamic Calibration Alignment of the Cells.

Memorized Control of the read values.

Magnet test Verifies some operation Solenoid.

Control Encoder operation Encoder.

I check Cups Control and location defective Cups.

Oscilloscope Graphics of control of the phase.

I check Cells it Verifies some analogical part.

Reset CPU Restarts some CPU.

Chart Sets Verification carpet Cups (Value to Empty).

Control Remote Telephone Assistance (if trained)

Installation works her of Set-Up of the car.

Calibratrice I parameters of configuration.

It programs The flags of management, press and memorization.

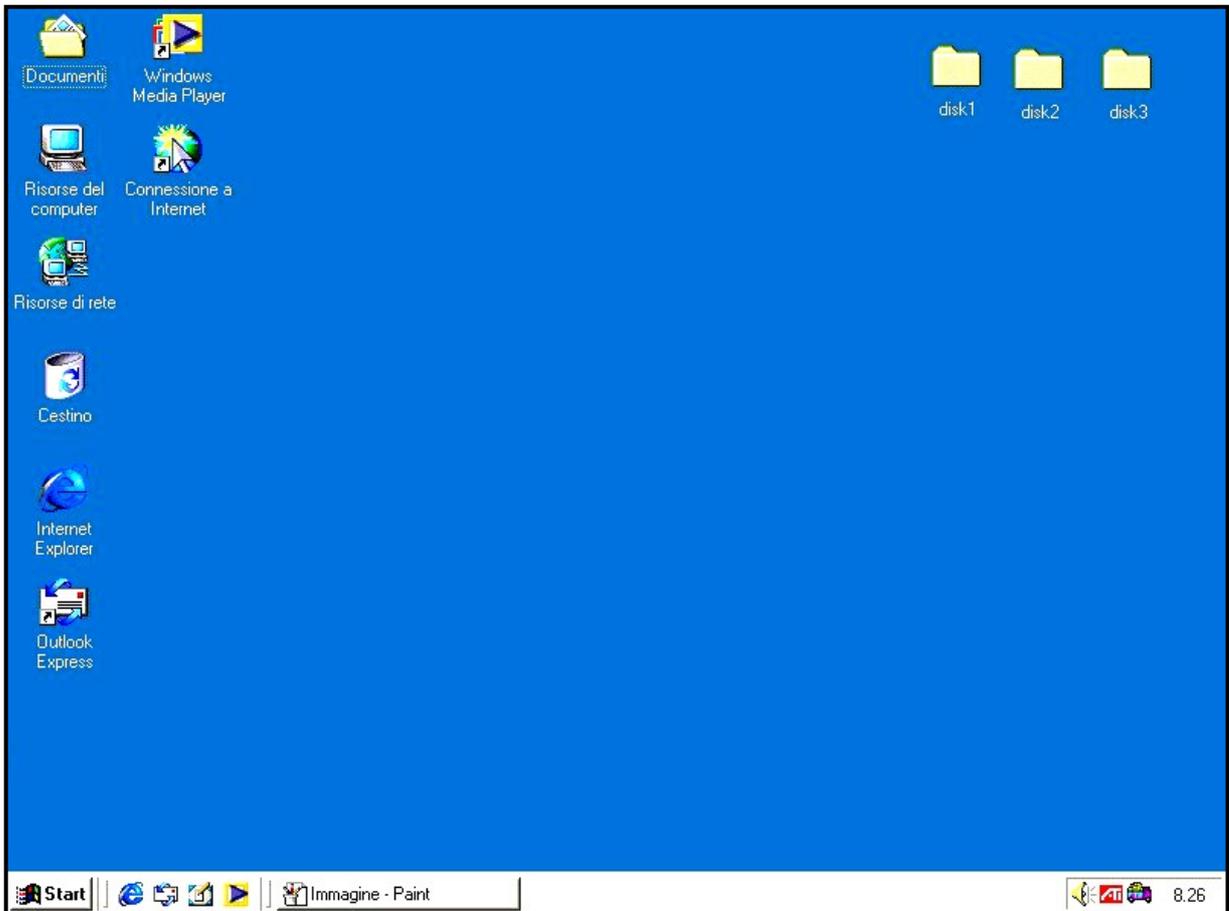
Firm The registry one of the firm that appears in press.

You cost The number and the cost of the personnel.

It saves on Floppy Copy on diskette the parameters of configuration

It restores from Floppy it Restores from diskette the parameters.

INSTALLATION



The packet can be installed on a P.C. any in the standard endowment with keyboard, mouse and printer Ink-jet.

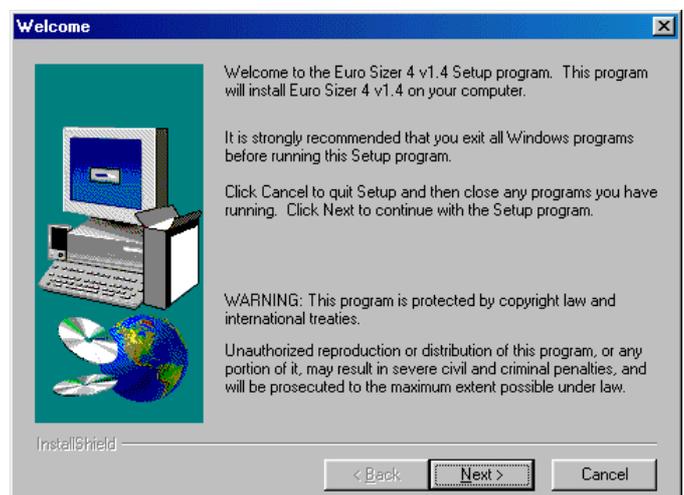
The anticipated operating system is Windows-98, Windows-me and Windows XP.

The installation can happen both from Floppy Disk 3" ½ 1,44Mb that from CD-ROM..

FROM CD-ROM

To insert the CD, to close again the counter and to attend the automatic throwing of the Set-Up.

To confirm all the indications that the program suggests and at the end to confirm the reboot of the computer.



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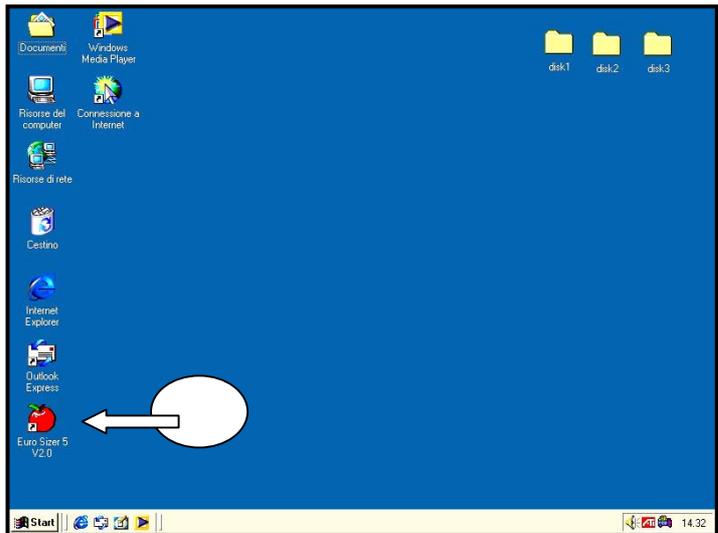
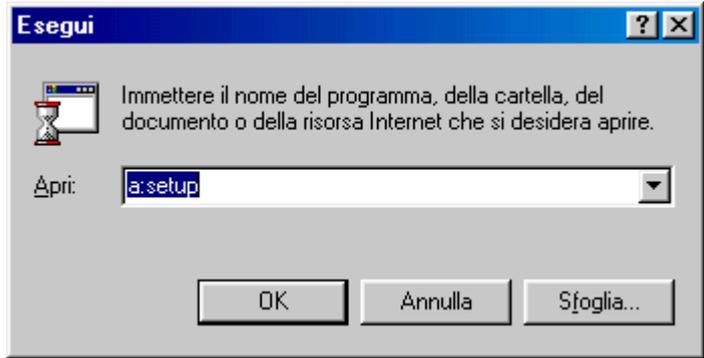
FROM FLOPPY

The version on diskette doesn't contain the automatic throwing.

Then to select Start (you Perform and in the window to digitize: a:setup. Cliccare on "OK" and to follow the various phases confirming the suggested formulations.

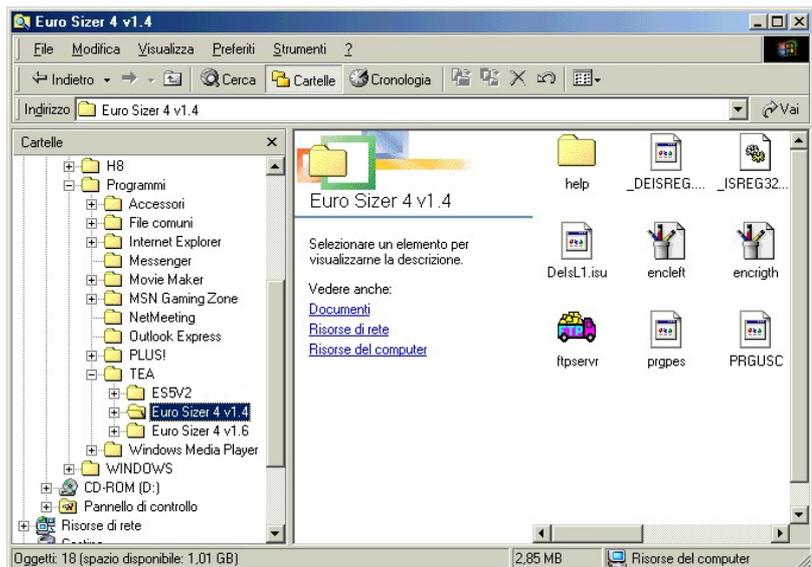
To change the diskette when she is required.

After the reboot of the computer, in the window of Windows the icon of the red apple appears as in figure.



It owes us to remember that this software serves as before installation or in the case of substitution of the computer. Following the Set-Up the car is not certainly shaped, therefore in case of substitution of the Computer it will be had then to use the lifesaving diskette of the Installation (discussed more ahead in this same manual).

From the figure beside he can be observed that the software is installed on the hard disk "C: " in the following ramifications: "Programs" "TEA" "Euro Sizer 4 v 1.4."



UNINSTALL & UPDATING

In case of updating, (Reinstall of an already existing software), it is necessary that first the File server of Transfer is closed Files that can have been activated for the Telephone assistance.

The FTP-file server, if opened, it is visible in low to the right in the window of Windows among the resident programs and it has an icon raffigurante a pickup truck (as from figure).

A click on the icon to make to appear the relative window and a click on "Close" to disarm the program.

Uninstall

To select in the Control panel, "Installation Applications." The list of the programs appears on which to select :

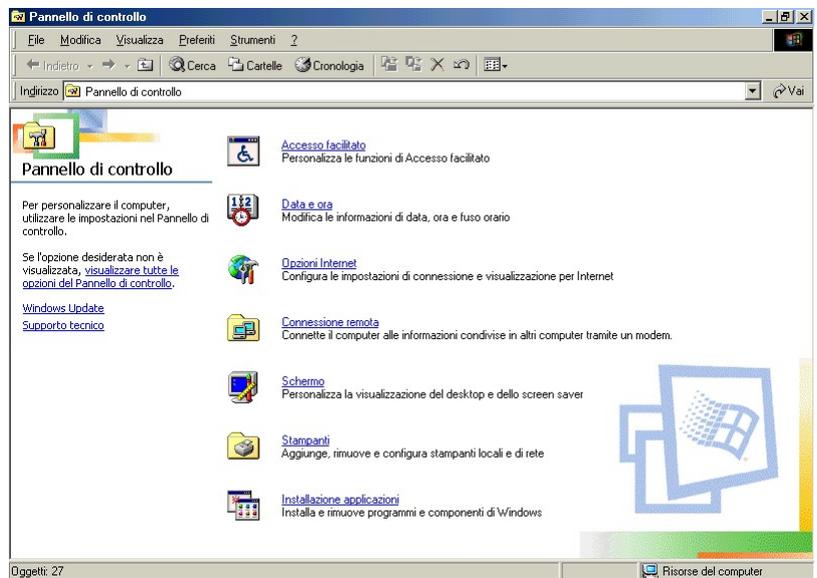
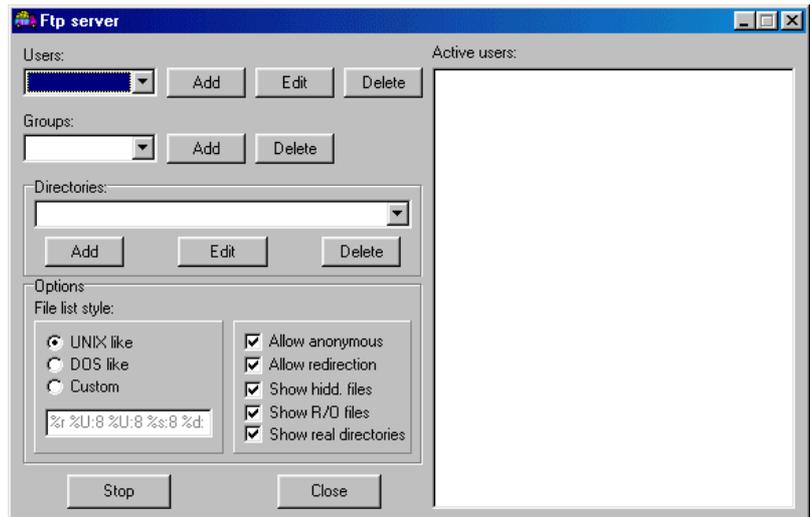
"Euro Sizer 4 v1.4s."

The Program Uninstall, will provide to remove automatically all the relative files..

It owes however us to remember, before this operation, to save and to stamp all the data related to the configuration of the car.

In case of updating, they are had to follow the contained indications in a file:

"LEGGIMI.TXT" that it will point out of time in time the operations to perform.e.



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KEYBOARD AND MOUSE

The Italian keyboards are standardized by now at least as it regards the position of the principal groups of keys. The new models extend to incorporate new keys and special functions of Windows that however they don't concern us.

As it is to imagine effortless, the selection of the functions and the aim are largely submitted to the mouse leaving only to the keyboard the insertion of the alphanumeric data.

We quickly refresh in so far the position of the most important keys.



THE MONITOR

We now see a panning of the present information on the screen and of their use.

	Calibro	Peso	Uscite	Totale	Percentuale
1	Ind.	020-057	01 00 00 00	10.3 Kg	5.11 %
2	49	057-062	02 00 00 00	6.4 Kg	3.18 %
3	46	062-067	03 00 00 00	10.7 Kg	5.31 %
4	42	067-073	04 00 00 00	18.0 Kg	8.94 %
5	39	073-079	05 00 00 00	15.9 Kg	7.89 %
6	36	079-086	06 00 00 00	31.9 Kg	15.84 %
7	33	086-095	07 00 00 00	20.1 Kg	9.98 %
8	30	095-105	08 00 00 00	20.1 Kg	9.98 %
9	27	105-115	09 00 00 00	11.8 Kg	5.86 %
10	25	115-125	10 00 00 00	10.4 Kg	5.16 %
11	23	125-140	11 00 00 00	6.4 Kg	3.18 %
12	20+	140-999	12 00 00 00	39.4 Kg	19.56 %
Lavorato				201.4 Kg	100.00 %
Scarto Banchi				0.0 Kg	0.00 %
Scarto Selezione				0.0 Kg	0.00 %
TOTALE				201.4 Kg	

numero tazza 044

Lavorazione precedente n: 2

15 - Kiwi 3Kg 00.0 tz/s 4 - Lavorazione

The window of the program, divides the screen in three bands :

- Aloft A bar "Pulsating" on which the curtains of grouping of the functions go down. In practice, the various executable procedures were being divided in four mastergroups in each of which they are inclusive determine operations. In the next chapter will be described in detail.
- To the Center Contain the parameters of job (Program) and the results. In low there can be also the information related to the control you cost and of the possible recalled workmanship. On the right best man the number cup; this increases with the movement of the car but it doesn't have a rigid control for which it doesn't increase to every cup. Under to this best man also the writing "Block Feeding" during it Sets her/it Initial to point out that the consent of the relay is not present and that fruit doesn't have to pass in this phase.
- In Low it rules her of status of the system. It is separated in the 4 zones:
 - 1 - It programs The number and the name of the program in progress. He is automatically loaded after it "Initial Tara" or from the curtain of "Workmanship."
 - 2 - Speed In cups / second for every line.
 - 3 - Communications Here every activity of transmission is signalled from and for the CPU.
 - 4 - Status CPU La operational condition of the equipment. From the lighting to the Workmanship, the CPU has to cross the suitable sequence:
 - 0 CPU Off Out Equipment
 - 0 Turned on Equipment Turned on not shaped.
 - 1 Stand-By Pronta and shaped (waiting for to depart).
 - 2 Attended Encoder Has noticed the impulses and he is synchronizing herself.
 - 3 Initial Tara Reading to empty of all the cups to be used as Tara.
 - 4 Workmanship Plots ready.

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THIS LINE THAT POSSIBLE ANOMALIES OF OPERATION CAN BE DEDUCED BEING LOOKING.
We quote some examples of it :

If the state plots it doesn't go to " 1 Stand-By", the CPU is out or the cable or the drivers of communication are spoiled. (this last case is enough common as a result of power drains in presence of storms).

If the state plots it goes in " 4 Workmanship" and then inexplicably it returns to 2 or to 3 of "it Sets Initial", it means that the CPU him reset's. There can be of the troubles or of the slow clamps; to consult the Technical Manual and the Builder.

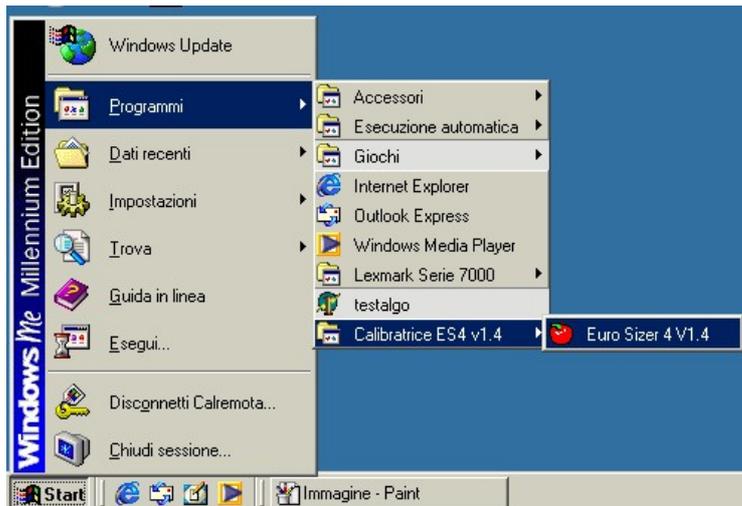
If the state plots he remains in " 1 Stand-By" and the Speed signals 10,0 Cup/sec or more, the Encoder is not operational. To consult the Technical Manual and the Builder.

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THE THROWING AND THE EXIT

There are two ways to enter the program..

One is through the icon on the Desktop pointed out to the right in figure. You aims with the mouse on the icon and with the button of left two rapid clicks.



The other method uses the button of "Start" in low to the left to open the curtain of Windows, he aims to "Programs" and him clicca an only time on "Euro Sizer 4 V1.4s."

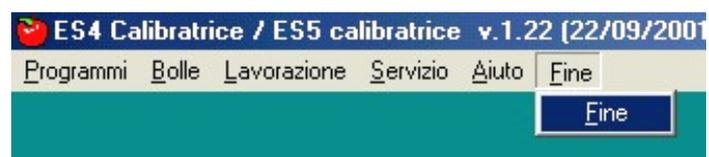
Once launched, the program can be suspended, minimizing to the right aloft it with the special button, to perform other programs.



It becomes us account that the program is active looking at the button in low (as in figure) and a click will be enough on the button to restore the screen.

Also for the exit there are two possibilities.

One is the button with her "X" aloft to the right, and the other one is the button "End" on the bar of the buttons.



We recommend the use of the button "End" in how much it guarantees the correct closing of the FILES and the rescue of the temporary data.

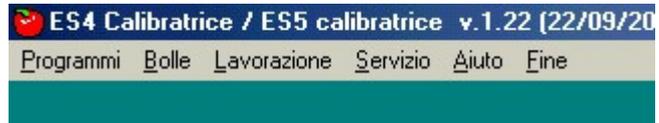
If to evening a workmanship is suspended without closing her, going out with this key, the next day we will find again all the data. The "X" instead it is aloft to the right a button of Windows and the procedure it is not guaranteed.

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THE PROGRAM

Naturally he is supposed that the consumer knows the techniques of use of the mouse and the keyboard, for which we won't detain there on the elaborate management of the keys. To such intention the purchase of one of the so many books of rapid learning recommends him in sale in all the bookstores.

The software of management of the system, is synthesized in 6 pulsating to be opened through mouse on the second line of the screen.



Each of these recalls a curtain that gathers the relative procedures.

PROGRAMS

IT IS A FILE THAT CONTAINS ALL THE PARAMETERS OF WORKMANSHIP: THE WEIGHTS OF THE CALIBERS, THE ASSIGNED EXITS AND THE TYPE OF CLEARING.



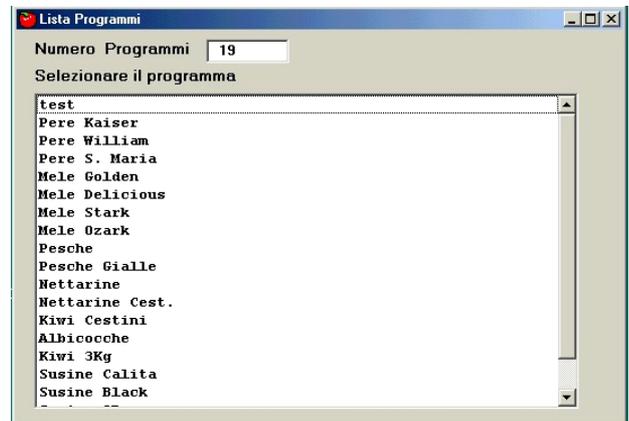
This way it is possible to realize a program for every type of fruit and more programs for the same type but with different clearings.

In every moment, also during the workmanship, it is possible to enter to one of the procedures of EDIT of the programs; both in that currently in progress (what later he will be rebroadcasted) that in others.

CHANGE

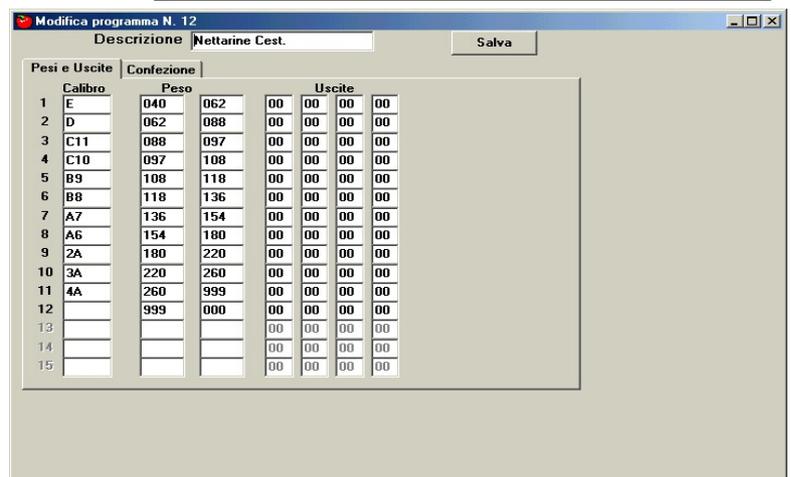
The selection of the program, happens always from a window on which the list appears.

Through mouse click on the desired program (in this case "NETTARINE CEST.").



To notice on the right the vertical bar that can be used for making to flow the programs.

The window of EDIT of the program introduces two briefcases described as "Weights and Exits" and "Wrapping.". In analogy to our old equipments, the program he is organized as a chart. In horizontal 12 lines where every line represents a caliber, and in vertical different groups of columns.



He is established that to the 1° caliber corresponds the smallest range

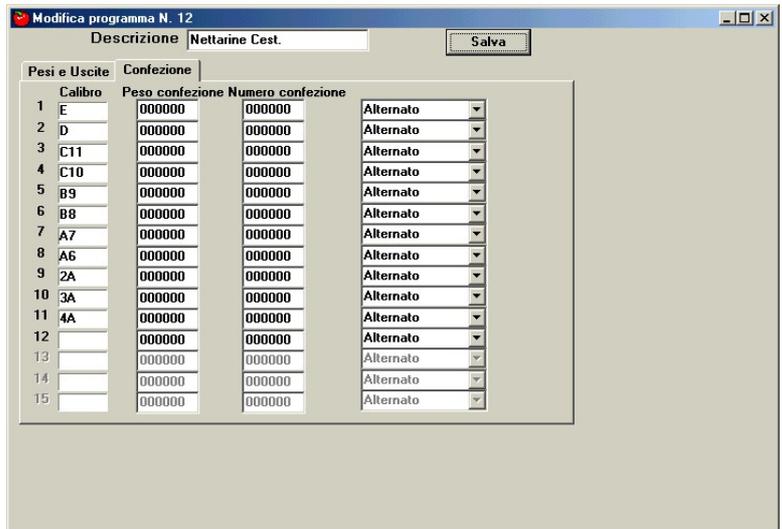
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of weight and the calibers is prepared, going down, in increasing order.

In vertical sense we have different columns that have functions specifications.

Description max 15 chars.

IT IS THE NAME THAT IS GIVEN TO THE PROGRAM AND THAT IT SERVES TO THE OPERATOR TO REMEMBER THE TYPE OF JOB THAT PERFORMS. You remembers that in the list two programs of NETTARINE appear, what we have selected remembers that this is specific for the "Baskets" as she is deduced by the column "Calibers."



You calibrate max 5 chars.

Also this column doesn't have effects on the workmanship. It serves to describe the range of weight and it contains both numbers and letters: Es. (B, Á., etc) (65-70, 70-75, etc.) or (B8, A7, etc) in this last case the number is reported to the number pieces for basket.

Hung max 3 numbers

They are 2 connected columns among them. To the left the column of the least weight of the caliber, to the right that of the ceiling of the caliber. The software automatically repairs the two columns every time that a weight is modified. We have inserted some programs taken by different cars; therefore it will be opportune to always verify the correspondence before beginning a workmanship in how much it would be able a correction to be necessary of the values.

Some considerations on the change of the Weights:

- **Change.** The change of the least value of a caliber will also modify the maximum one some preceding caliber; the change of the maximum value of a caliber will also modify the least value of the following caliber. This double possibility can originate some confusion, therefore we always advise to get used to use an only column (you see chapter "Workmanship").
- **Zero resetting Calibrates.** There is only a way.

To put to 0 (Zero) the maximum one of the 3° Caliber is wrong. All the fruits after 88gr will go to the exit n. 3.

It puts on the max of the third equal caliber to the least one.. All the fruits within 88-108gr will go to the Exit n. 4.

Necessity to temporarily remove a caliber, can present while they works baskets and it quickly it is necessary to change even to frying pans on another exit.

1	E	040	062	01	00
2	D	062	088	02	00
3	C11	088	0	03	00
4	C10	0	108	04	00
5	B9	108	118	05	00
6	B8	118	136	06	00

1	E	040	062	01	00
2	D	062	088	02	00
3	C11	088	088	03	00
4	C10	088	108	04	00
5	B9	108	118	05	00
6	B8	118	136	06	00

- **The least one of the Primo I calibrate.** She must be held inferior of the smallest fruit that will pass in car. Normally 10 - 20 grs. If held to 30gr and they are worked very small plums (20-25gr), after some I draft the system it will lose it Tara and he doesn't work better. If held to 0 (zero), later it TARA initial, there will be no more updatings on the values of it sets some cups.

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You go out max 2 numbers

There are four possible exits for every caliber. There are no limits in their use. A same exit can be assigned to more calibers and without ties of sequence.

The mechanical exit can be used on a caliber as Gone out only 00 if everybody and four the boxes of that caliber are to 00. The same purpose is simply reached inserting as number of exit a superior number (es. if a system has 12 Exits + the mechanics), inserting the exit 13 or 14, etc a range of weight can be sent after all.

You recommends to always digitize both the figures not to create possible problem or losses of characters in transmission.

These 4 columns are also connected to the operation of the window of "Wrapping."

Wrapping

This window brings other three columns that determine the modus operands of the clearing.

The first column brings the weight of the wrapping gram-me, the second the number pieces in the wrapping and the third one the way of operating..

3	C11	000000	000000	Alternato
4	C10	000000	000000	Alternato
5	B9	000000	000000	Peso
6	B8	000000	000000	Numero
7	A7	000000	000000	Alternato
8	A6	000000	000000	Alternato

Naturally these data matter only in the case that in the preceding window two are assigned or more exits to the caliber.

Besides the packing to weight or to number is bound to the caliber, therefore if one of the assigned exits is also active on other calibers, the system it loses precision.

Finally the system is hardly applicable to small wrappings in how much the exit of the last pieces of the wrapping normally asks for very elevated times.

NEW

This procedure introduces a window with all the values to 0. He must be used for preparing very different programs from those existing or however for products that has not been worked yet.

COPY

This procedure introduces the window of selection of the program where it is had to choose the program to copy. Then it enters the function of "Change."

IT IS USEFUL TO QUICKLY PREPARE A SIMILAR PROGRAM TO ANOTHER WITHOUT OWING TO TOTALLY EDIT HIM.

IT CANCELS

To remove obsolete, wrong or old programs. We recommend to always perform this operation and only before the beginning of a season.

In the file of the Beads, the number of the program is recorded.

PRESS

It allows the reproduction on paper of the parameters of a program. The printer is managed by Windows and it is therefore to these that it owes us to report in case of problems.

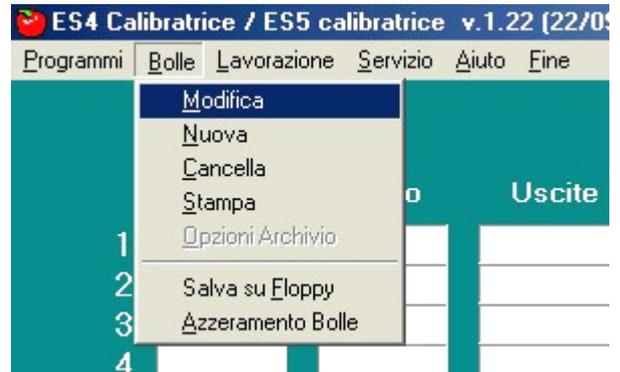
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BEADS

Also this curtain manages a file.
What records all the data of the workmanship.

When a workmanship is closed with the buttons "Workmanship" ("End Workmanship", the division calibrates, the n. program and the "Data" prepared, they are recorded in a record and appended to this file.

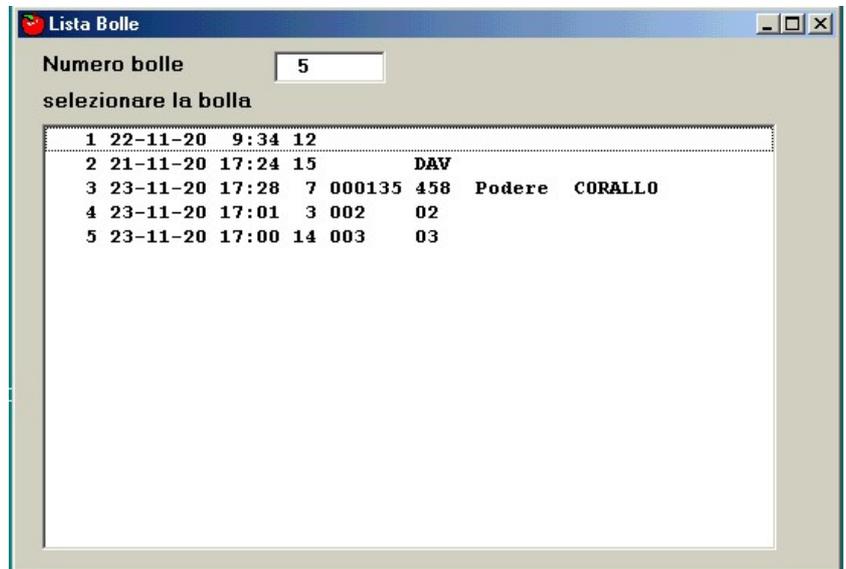
Naturally also in this case they are possible the normal operations of EDIT, but they have been assistant other two functions to save the file on floppy and to reset it to beginning season.



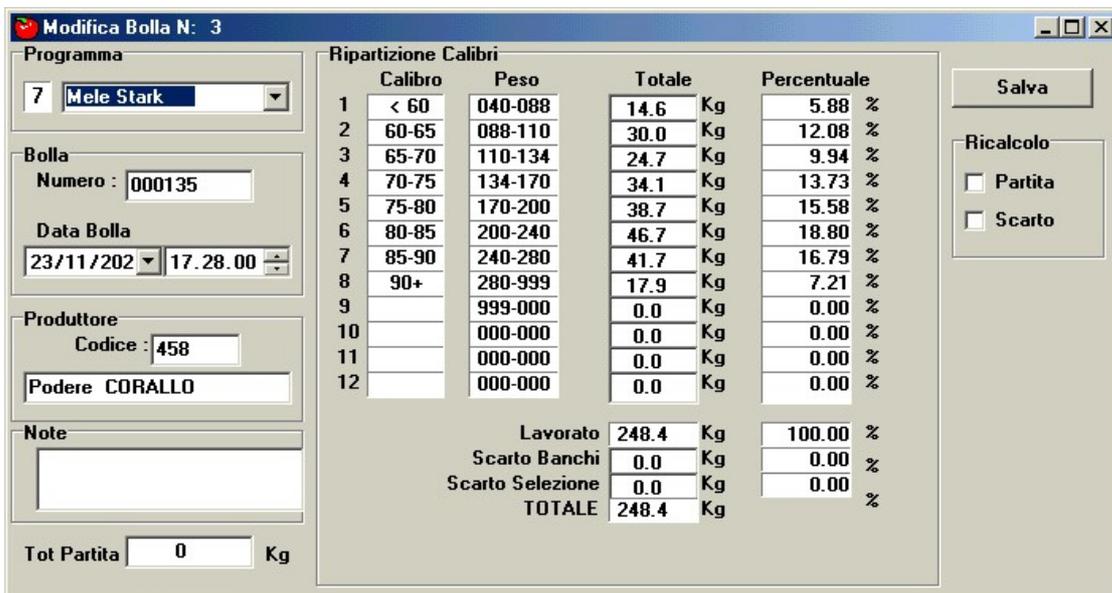
CHANGE

Also in this case, the selection of the bead happens on a window where every bead introduces in a line the most important data connected to the performed workmanship.

This way we can see the sequential number of the recording (n. record), gives and now of "End Workmanship", the number of the used program, the N. stamps withdrawal, Code and Description of the Producer. (these last 3 from the window "Data").



For our example we will select with a click the bead number 3.



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As he can be observed, of this workmanship everything can be corrected. We recommend nevertheless to drag with the mouse the value to make to become him blue so that when it is begun to digitize the old values are cancelled and replaced.

- The program with one to standard weights (what have however the same number of calibers).
- Number and date bead dates her introduces in small the monthly calendar for which it results very easy every change. The number stamps it is of 6 number.
- The Producer The code and the description of the producer. The manufacturing code is of 4 characters and the description it is of 20 characters.
- Notes A line of comment of 30 characters.
- Total Stock This box can be used in combination with the relative box of trace the division to bring him you calibrate and the total ones to the real conferred quantity. The computer will repair the total ones in base to the percentages. You will use this option on the occasion of samplings or in the case that a part of the workmanship is lost because of black-out on computer and CPU. Max 8 number.
- Division Also Calibrates these they can be modified. He can be noticed that to every change, the screen refresh the up-to-date data also in the percentages. You remembers that if these values are modified and it save him in exit, the original division will be lost and replaced with the acquisition values. The limit of these values is 2.000.000.
- You discard there are two types of discard that can automatically be in relief with special balances (optional) or subsequently inserted to keyboard after manual weighting. The first one "Discard Benches" it is considered coming from the benches of packing and therefore already weighed. It will go to deduct the division you calibrate in base to the percentages so that the total general rests unchanged. The second "Discard Selection", it is considered performed in proximity of the bins-upseter and therefore not weighed. This will go instead to add him to the division increasing the total general.
- Recalculate this section contains the boxes that cause the updating of the division you calibrate. The original data are always however preserved in the file. Besides the function he doesn't activate if the relative field is to zero. When the function of ricalcolo is active, the whole column of the division calibrates it is in yellow.

Note: The call of a bead whose fields of Total Work and/or Discards is already compiled, active automatically the Flags of the recalculate and it is necessary to disarm them to see the original values.

If in the division you calibrate the substances they don't appear, it needs to activate the flag in "Service" , "Installation" , "Program."

WORKMANSHIP

Before beginning the discussion on this curtain, it is had to notice that if the CPU is out or not connected (is system 0) this writing will also stay shaded and the curtain won't be available..

This button opens a curtain with all the tied up procedures to the workmanship.

These procedures can alter in way to take root the clearing, for which it needs to know its purpose. To every way it is always necessary a combination of keys or confirmations to activate her, for which these operations can hardly depart casually.



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Program

This button opens the window of selection of the programs. With the mouse he aims the program to the desired program and with a click he is loaded.



The window the message of transmission disappears and appears pointed out in figure. After some instant from the end of the transfer to the left the number of the program is adjourned.

In practice there will be always a program (because he is loaded at the end of Tara) and this function serves to change him.

It modifies W / E

This button allows to directly access the window of EDIT of the program (already discussed) to allow the rapids change of the weights and the exits on the program of workmanship.

The same operation can also be performed by the curtain of Change Programs.

The changes are always permanent in the sense that they are recorded on the program and therefore the change of the weight of the calibers must always checked, not to be herself with the time to jump whole calibers.

It takes back Bead

IT IS THE PROCEDURE THAT ALLOWS TO RECALL AND TO CONTINUE A WORKMANSHIP PREVIOUSLY SUSPENDED.

It opens the window of selection it boils, that is chosen by to load. The following operations are performed :

- Loading programs
- Loading Total (Last of the bead)
- Loading "Data" from the Bead recalled.

It needs to specify that the total presents before this operation must be lost and therefore this procedure follows one "End Workmanship."

A possible message like that of figure, points out that the file of filing is disabled and therefore it is owed first to go in "Service", "Installation", "Program" and to reactivate the Flag of "File."



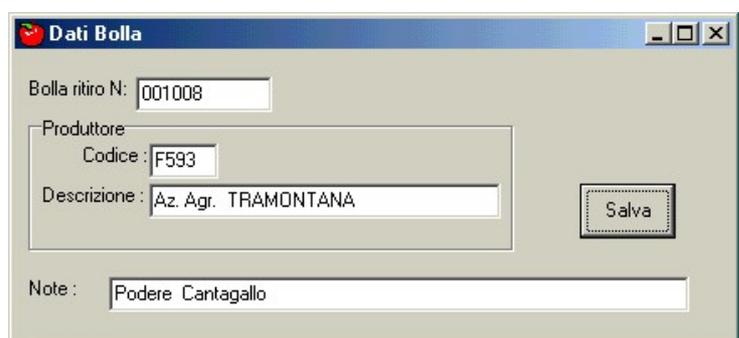
Zero resetting

You uses for resetting the total ones in case of tests or workmanships of which it doesn't serve to preserve the results.

Data

IT IS THE PROCEDURE THAT ALLOWS THE COMPILATION AND/OR IT MODIFIES SOME DATA RELATED TO THE WORKMANSHIP IN PROGRESS.

How much writing will be then here recorded in bead in the moment of the, "End Workmanship."



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He report us to the preceding chapter as it regards the type and the purpose of these information.

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Total

This button entirely provokes the refreshment of the total ones on the screen. It serves therefore to monitor the course of the workmanship.

Press

You uses for getting the press of a provisional bead. These beads differentiate him from those of file because they bring the heading > SAMPLING > rather than > Workmanship < and also for the "Recording n. : ---".

Also in this case if the column of the substances doesn't appear, to use the Flags in "Service" ,"Installation" ,"Program."

End WORK

IT IS THE BUTTON THAT IS USED AT THE END OF A GAME. It immediately provokes an updating of the total ones on the screen and to follow, the recording total and "Gives", the press and the zero resetting for beginning new game.

We remember that the press, the recording, the visualization total in Grams or Kilograms It can be set in the procedure of Installation already quoted.

Costs

Control costs it is activated in the relative window from the buttons "Service" "Installation" "Costs." The control him active automatically when in the column "N. People" there is at least a person. The refreshment of the cost to the Kg automatically happens to every application "Total."

This button restores the timer for the calculation of the time of workmanship. He must be used in the case of lock system caused by unexpected problems.

If he is firm for 5 minutes, or if he leaves the power on computer for a break of the personnel, to the departure the cost will be very increased and this button restores it.

Control

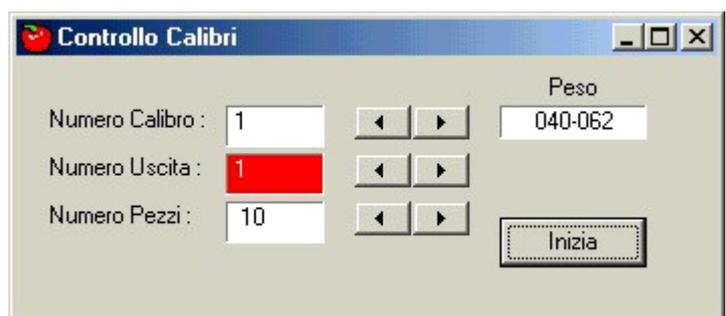
The packet offers the possibility to facilitate the operations of control quality of workmanship.

In the window beside it is had to select, :

N. Caliber. With the arrows the caliber is selected and to the right the weight can be checked.

N. Exit. The exit where to send the material. Normally a free exit or one who contains a very different caliber.

I number Pieces. Standards are predisposed 10 pieces but the operator can change the value in base to the type of wrapping or arbitrarily.



With the button "it Begins" he activates the function. From this moment, that caliber suspends the normal clearing and she is sent in the suitable exit (from all the lines) up to the attainment of the suitable calculation. Then it takes back the normal clearing. All this during the normal activity of the system.

EURO SIZER ES4

SERVICE

The button of "Service" she offers two curtains with different functions.

The first one contains functions of help and control that can also be used by the operator. The second contains functions of formulation (Set-UP) and it is generally reserved to the personnel of maintenance.



ASSISTANCE

The curtain of Assistance shows us some control functions that can be used for verifying the various parts of the system.

Of these solo 2 can be activated during the normal operation of the calibratrice without drawbacks: "Encoder" and "Chart Sets." And one must be uses to firm System: "Control Cells." If used under conditions of job and in movement, it doesn't break him nothing but the CPU can lose some fruit and then this procedure it recalls functions that are reliable only if you perform to firm System.



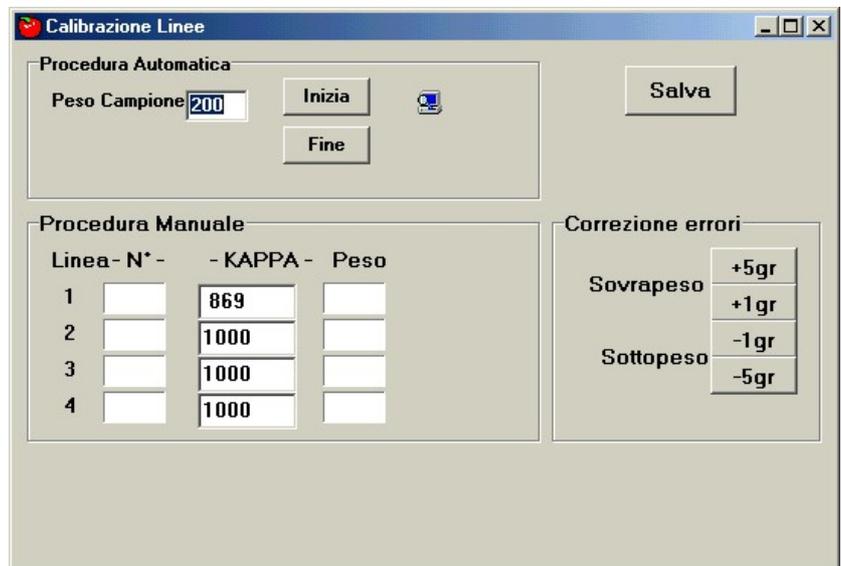
Calibration

The correction of the weight, among the value that the CPU reads and the true value, he performs with a formula in base 1000 that we will define with it initials it's "KAPPA."

In practice if the System reads 120 and the KAPPA is planned to 850, the following is performed calculation :

$$(120 * 850) / 1000 = 102$$

the weight is reduced to 102 grs



In all the equipments of this generation, the amplifiers are set on 20% superior values in more; this means that the value of the "KAPPA" it has to oscillate among 800 and 950.

They are two the possibilities to intervene on the Kappa: Automatic and Manual.

EURO SIZER ES4

Automatic to perform with the System in motion and in process with a weight of around 200 grs. It needs to know the value of the weight champion that is used and to digitize it in the relative box. You click on "it Begins" and they do him at least 10 passages on all the lines. Click on "End" and on "Save."

IT IS OPPORTUNE THAT BEFORE THIS OPERATION THE MECHANICAL PREPARATION OF THE GUIDES AND THE CONTROL OF THE EMPTY CUPS IS PERFORMED ELIMINATING POSSIBLE ERRORS FROM CUPS THAT DAMAGE VERY DIFFERENT VALUES. However the program isolates the passages that give inferior values to 150 grs but cups defective damage wrong surveys however that engrave then on the calculations.

RULE IS GOOD FOR THE ONE THAT PERFORMS THIS OPERATION TO CHECK FIRST THE VALUES OF THE KAPPA AND TO FIND LATER THE VALUES AND TO USE THE KEY "SAVE" ONLY IF THE VALUES REENTER IN THE SUITABLE SPECIFICATIONS.

This operation must not be performed every day, only long periods it is necessary after of lock System or, if is wanted to maintain always set, on established periods (for example every week or 15 days).

In case of errors on all the benches, she must be used if errors are found in only excess or in defect, but if there are both must not be used because the problem is mechanical.

To perform the Calibration in dynamics, gives best results in comparison to a static procedure (from firm) in how much it allows to also keep in mind of the movement and of the conditions of vibration and attrition that are different among the lines And it is really for the change of the dynamic conditions, sugar on the guides - vibration-etc., what they will start to appear some errors.

Manual Allows the direct correction of the KAPPA of one or more lines through keyboard. This system is used if it realizes us that a line is ache set of some gram. For example, after the Automatic procedure, the function will be used of "Memorized" to check through some passages. If an inferior tendency of 2 grams is noticed in the readings of the line 1, him click in the picture "Manual" in the value 869 and to keyboard 10 or 20 points it is added digit 889 and then "Save." You still repeats the function of "Memorized" to verify.

Correction This procedure has recently been introduced for facilitating the operator.

Errors In case of presence Errors, instead of repeating it "Calibration Automatic", this function can be used with effectiveness and rapidity.

We suppose to find some errors of overweight in all the calibers (around 5 grs in the big calibers). We will perform a click on "Overweight" (" + 5gr" and on "Save."

Can be noticed that all the values of "KAPPA" they are decreased. We will now repeat the cycle of control of all the calibers and when errors are found in both the senses, the car is calibrated.

NOTE: Don't use this function if they are contemporarily there errors both in overweight and in underweight. It worsens the situation.

Memorized

It serves for verifying the readings of the lines.

You uses with the system in movement and in process making some passages on a line. The number of cup is



	1	2	3	4
N. TAZZA	7	0	0	0
TARA	293	0	0	0
NETTO	119	0	0	0

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visualized, the value of it sets and the Clean in relief.

EURO SIZER ES4

Solenoid test

Also this function is separated in two procedures

Statics. System stopped.

With the buttons On and Down of side to the number, to select the exit and click on "Beginning." All the solenoid of that Exit will be activated and disarmed with a lilt of around 1 according to. This procedure is used for verifying the operation of the solenoid and the relative circuits. Don't use this function during the movement because can damage the mechanisms of expulsion.

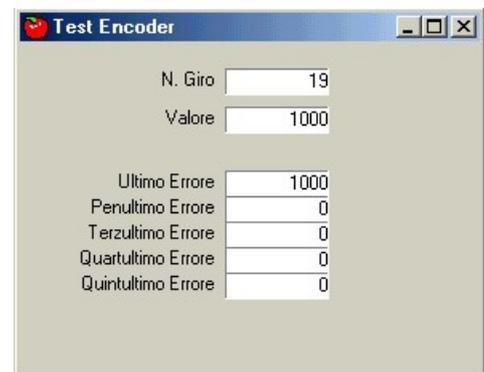


Dynamics. System in movement.

This procedure serves to check the correct operation of the solenoid. When is activated on an exit, can be verified that the cups are upset in alternate way (a cuff and one no). Defective Solenoid, are able not to take some cup or to take 2 of them followings. You see Technical Manual for further details.

Encoder test

The Encoder has to furnish 1.000 impulses every turn. Its correct operation can be noticed by this window. To every turn the reached calculation is checked and if different from the precedent is moved in the column of the errors. In so far, as in figure, under normal conditions, on this column it owes us to be only a value (the first turn after the lighting). In case of problems to still refer to the technical manual.



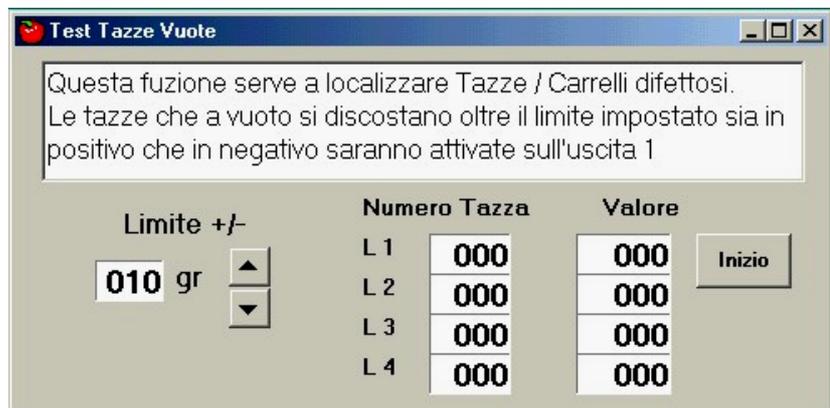
I check Cups

The same window is very explicit. The operator chooses the limit and then click on "Beginning."

The system has to be in movement and in process but empty.

To every in relief weight that overcomes the suitable

limit, the line is signalled, the number cup and the value on the relative window and is activated the solenoid of the Exit 1. With a chalk or a pen the cups can be marked. If to every turn system they are always the same cups to fall, must be changed, otherwise the problem is on the system of weighting.



EURO SIZER ES4

Oscilloscope

IT IS A TEST THAT USES SPECIALIZED TECHNICAL TOOLS. Must exclusively be used from personal specialized.

To refer to the technical manual.

I check Cells

To perform to system Stopped and with the cups above to the system of weighting



In case of problems on one or more lines, if there are doubtful on the weighting, it is with this function that the correct operation of the analogical section can be verified: cell of load, cables and amplifiers. The values that are read to empty and with a weight above, they have to be repetitive with a tolerance of some gram.

Besides to empty the value must be held within 150 250 grs. In the figure above, the value would go a lowered a little even if we specify that the system is functioning however.

Reset CPU

This button performs the reboot of the CPU (exactly as to extinguish and to relight) leaving again from the loading of the parameters of installation, control Encoder, and it Sets. Program and total currently in progress they stay in memory ready for the workmanship.

IT IS A FUNCTION AUTOMATICALLY RECALLED BY THE PROGRAM IN DETERMINED CONDITIONS: LIGHTING, INSTALLATION, ETC. Can be recalled by the operator in the cases of anomalous operation after having voided the calibratrice to adjourn it Initial TARA.

Table Tara

It opens a window that contains the values to empty of every single cup. If the system is very long, the apparition can delay some second.

In a system in order, these values will have maximum oscillations of around 7 Defective cups will have removals of 30 points or more and inferior values are due to cleaning, regulation you skate or vibrations.

1	0293	0000	0000	0000
2	0293	0000	0000	0000
3	0293	0000	0000	0000
4	0293	0000	0000	0000
5	0293	0000	0000	0000
6	0293	0000	0000	0000
7	0293	0000	0000	0000
8	0293	0000	0000	0000
9	0293	0000	0000	0000
10	0293	0000	0000	0000
11	0293	0000	0000	0000
12	0293	0000	0000	0000
13	0293	0000	0000	0000

Remote control

IT IS A RESERVED BUTTON. I don't activate.

EURO SIZER ES4

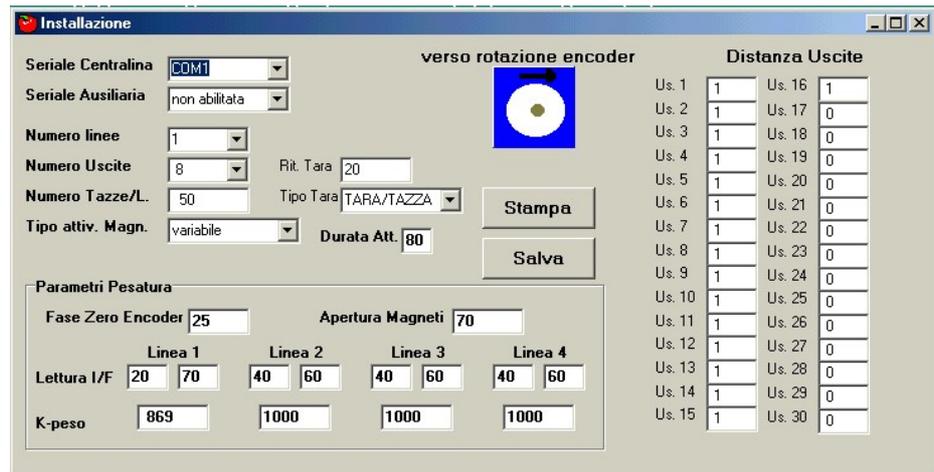
INSTALLATION

This button opens a curtain that contains the functions of formulation "SETUP" of the system and the lifesaving operations and restoration.



SORTER

This window contains all the data of SETUP of the calibratrice. And it is for this that enters you through it doubles confirmation and a code that of Default is " 0."



To refer to the Technical Manual for further details.

Program

This curtain brings the general Flags of management of the results.

- Filing. IT IS CONNECTED TO THE BUTTON "END WORKMANSHIP" OF THE CURTAIN OF WORKMANSHIP. It trains the recording of the data in the file. Must be disabled for maintenance or if it doesn't serve to preserve the data.
- It stamps Substances. It trains the column of the substances of the program in the printout of the press it boils.
- Transmission to the remote one. Reserved. It doesn't produce effects on the workmanship.
- It stamps Bead. Also this is connected to the button of "End Workmanship" and it trains the press.
- Total express train in: The Total ones are of default express in Kg. In the case the car is used for making Champions, the flag can be changed for having the results in Grams.



Firm

They are 4 lines of 20 cars. Every to describe the name of the Firm that appears on the report of press.



EURO SIZER ES4

Costs

Window of formulation of the control costs.

Control costs it is a service that is offered for verifying in real time the cost to the Kg of the worked product.

It doesn't keep in mind of the cost of the plant neither of other amortizable expenses. **IT IS A PURE COST OF MANPOWER WITH IMMEDIATE REFERENCE.**

	N. Persone		Costo Orario	
Categoria 1	1	022000	£	11.36 Euro
Categoria 2	2	017000	£	8.78 Euro
Categoria 3	10	015000	£	7.75 Euro
Costo orario complessivo	206000	£	106.390	Euro
Costo / Minuto	3433	£	1.773	Euro

Salva

It foresees the presence of three categories of personnel with diversified hourly rates.

You disarms if the column of the N. is reseted People. The operator can indifferently plan the rate both through the Liras (£) that through the European ones (€).

It saves on Floppy

It saves on the diskette the parameters of "SETUP" of the calibratrice and of the programs of job. **IT IS OPPORTUNE TO ALWAYS MAINTAIN ONE OR TWO FLOPPY WITH THE UP-TO-DATE DATA.** In case of problems you will have the CD-ROM to install or reinstall the packet, but they will be these data that allow you to plan the car.

The actual devices are cheap unfortunately from the point of view of the quality and reliability for which we advise to always hold at least two lifesaving diskettes and to replace the drive every year.

Restoration from Floppy

Is used, after the CD-ROM, for reset the configuration of the car in case of crash of the computer.

EURO SIZER ES4

HELP

IT IS A CURTAIN THAT CONTAINS
TWO BAWLS.

- **Help**
This button opens the program of the electronic manual.
IT IS IN PROGRESS OF PREPARATION.



- **Information**
This button opens the window that contains the version of the software.
It always needs to mark him these numbers before taking telephone contacts for the assistance.



MANUAL OF MAINTENANCE

In case of problems, before phoning for asking for assistance, it is necessary to perform some controls.

In almost all the cars is allowed every type of remixing and therefore he supposes that he first of all checks well the program.

We introduce therefore a list of defects and the possible causes that are worth for almost all the sorter.

- **ALL AFTER ALL**
 1. The CPU is out
 2. Comes broken Encoder
 3. The computer doesn't communicate with the CPU
 4. The CPU is not in process (Sensory or Encoder)
 5. The CPU doesn't communicate with the cards magnets
 6. It misses the feeding to the cards Magnets
 7. One or more cards magnets spoiled.
- **ALL AFTER ALL FROM A LINE**
 1. Cell of load or spoiled amplifier
 2. It files magnets it spoils
 3. One or more spoiled magnets.
- **WITH WAVE GOES AFTER ALL**
 1. If it is a system to cups can give him that there are short trees and the chain it climbs on the guides.
 2. The joint Encoder can be broken.
 3. A card Magnets him reset (Cables and clamps of feeding).
- **THEN GOES IT UNLOADS WELL AFTER ALL**
 1. One or more cards magnets don't work
 2. There can be some unhooked carrellinis.
- **IT GOES AFTER ALL IT IS UNLOADED MIXED**
 1. The car can be out phase (a tooth of the chain) or (comes broken Encoder).
 2. On C17 to also extinguish all the electric picture and to relight after one minute.
- **A BENCH WITH ERRORS**
 1. A magnet that doesn't close again in time and discharge 2 cups.
 2. If it is the first bench after the weight, you/he/she can contain double or fallen fruits on the weight.
- **Errors On All The Benches (Light or Heavy).**
 1. The car has the tendency to weigh Too much or too much little. Can be made up for lifting or lowering the
 2. Often however this problem meets when the 80% of the product center on the limit of the caliber or within 2 grs from it.
 3. The Value "KAPPA" of one or more lines has altered. To repeat the calibration after having checked the cups.
- **MIXED ERRORS ON ALL THE BENCHES**
 1. If after all function can be also the phase (chain or comes Encoder).
 2. It opens the cup before or that later. Following the change of the points of reading Encoder, the car can lose the footstep and to open a cup before or after that correct. It is necessary to enter the set-up of Installation and to repair the Gone out Distances.
 3. If the errors are enter 10-15 grs the car it is dirty and clean to be do.
 4. The Value "KAPPA" of one or more lines has altered. To repeat the calibration after having checked the cups.
- **ERRORS AFTER A FEW MINUTES**
 1. The system loses it's TARA. You works too much small stuff. On C17, C31, ES4, to lower the first value of the first caliber.
 2. The balances are dirty. After a short time it TARA gets up.

SEQUENCE CHECKS

When the system doesn't work and he doesn't succeed in understanding its cause, there are a series of tests to perform for verifying the various parts and the components of it.

1. THE CELLS OF LOAD

For a long time all of our line of sorter has a test "Control Cells." Must always be performed to stopped system and with the cups above the roller skate of the cells of load.

It serves for verifying the correct operation of the cell and the amplifiers with a weight that put goes and removed 2 or 3 times verifying the reliability of the values.

It also serves to check the stability of the value (a drift of 50-100 grs in one minute is symptom of some problem).

And finally to check the value to empty that must be held on 100-300 grs with the cart or the cup above the balance.

2. VALUES OF READING.

If the phase

IT IS OPPORTUNE FOR THIS, TO USE A PROGRAM THAT DEPARTS FROM 100 GRS TO ELIMINATE POSSIBLE CUPS OR DEFECTIVE CARTS.

You will use therefore a weight champion of around 200 grs and they will be made some passages on the various lines checking the read values.

In a new car the difference among the least one and the maximum in relief will be of 5 grs. Can be also acceptable + / - 10 grs.

Possible differences among the lines point out the necessity to perform the procedure of calibrazione to balance the cells between them.

In general, superior errors point out the necessity to clean the car or to regulate the roller skate of the cells (cups cars). Errors of 50 or more grams signal the loss of the phase of the chain instead. (In this case the intervention is necessary of a technician).

3. I CHECK EMPTY CUPS

In some equipments they exist some specific functions, in others the program of workmanship can be used lowering the least value of the first caliber to 10-15 grams and making to unload him in the first exits.

Making to turn to empty the car realizes how many folded up trees or defective carts are there.

4. I CHECK ELECTROMAGNETS.

On all the cars there is the possibility to check the operation of the Solenoid. Some make to fall two cups and they leave two of them, others alternate an only cup. A frequent defect of the Solenoid is that the rubber band back weakens him and in high speed the following cup falls before also the tongue returns in closing. This defect can also be originated from sugar or from dirt that they hold back the tongue.

The test underlines these problems in how much the sequence of opening and closing it will be irregular. Can also be verified during the workmanship in the case of an alone mixed Range of weight checking in every line the opening of the cups.

5. CALIBRATION

This function, present in all the recent cars, must be performed after having checked the cups and the balances. If the balance is dirty or if there are cups that mark, a very wrong calculation can be gotten that worsens the situation. The value "K" of a line, can change in the time of + / - 100 points. RULE IS GOOD THEREFORE TO CHECK BEFORE ALWAYS THE VALUE AND AFTER THE PROCEDURE. In case of very ample variations, to manually bring the "K" to the preceding value and to check the mechanics or the cups.

NOTES