



Weigh Hopper Operation & Programming Guide

Weigh Hopper Load Cell Re-assembly

Your weigh hopper has been sent to you dis-assembled to prevent load cell damage. Instructions for re-assembly are below.

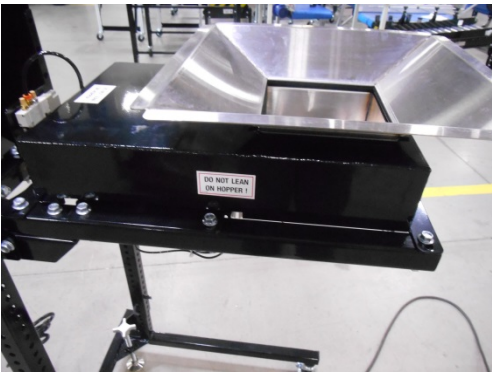


Fig 1

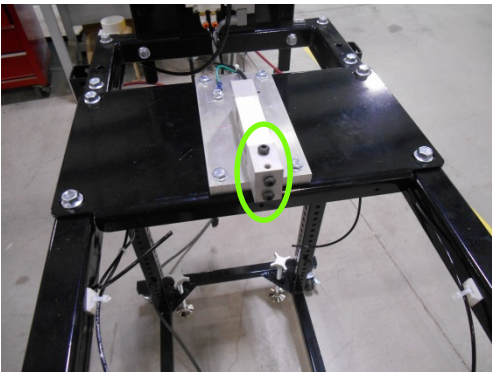


Fig 2

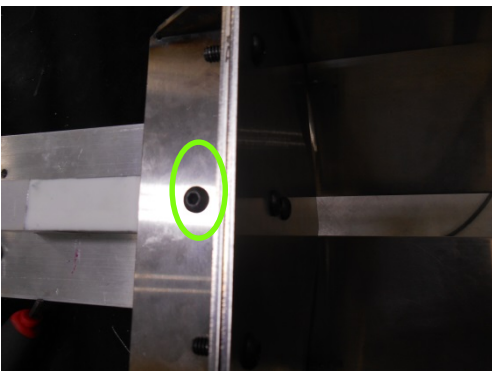


Fig 3

- Remove top cover from frame assembly. (Fig 1)
- Load cell will be revealed with three bolts for re-attachment of the weigh hopper. (Fig 2)
- Install all 3 bolts and tighten evenly. Use caution not to overtighten into the aluminum load cell. (Fig 3 & 4)

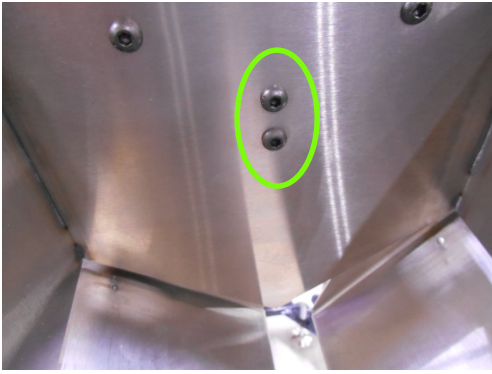


Fig 4



Fig 5

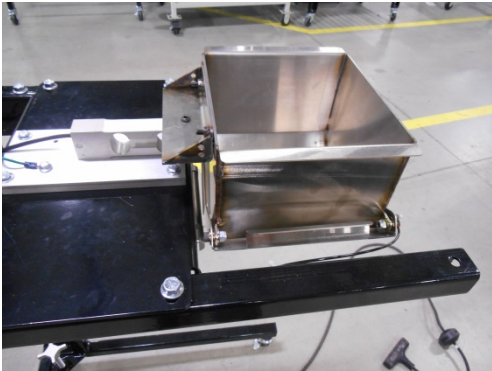


Fig 6

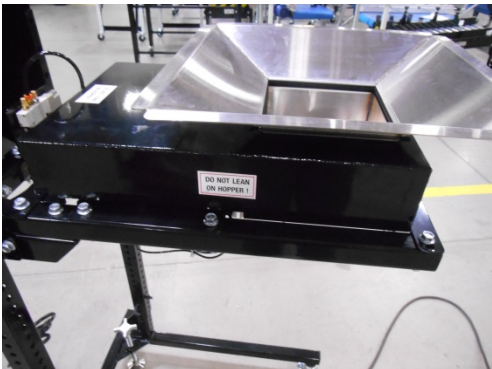


Fig 7

- Re-connect air supply lines to control cylinder. (Fig 5)
- Hopper assembly must be free of obstructions to insure accurate measurement. (Fig 6)
- Finish re-assembly by re-installing top cover. (Fig 7)

EMI WEIGH CONTROLLER CALIBRATION AND WEIGHT SETUP PROCEDURE

-Calibration

1. Via touch screen interface go to Configuration Parameters Programming Screen (Program Screen 1)
2. Enter a Cal Low Reference value of 0. (Factory setting is 0)
3. Enter a Cal High Reference value of the calibration weight being used.
Example: At factory a 50 lb. weight is used so a value of 50 is entered. (Factory setting is 50)
4. Enter an Averages value if necessary (Factory setting is 20)
5. Enter a Motion Tolerance value if necessary (Factory setting is 2)
6. Write configuration parameters by pressing Set Config. Pushbutton.
7. Via touch screen interface go to Calibration Parameters Programming Screen (Program Screen 2)
8. With no weight on the scale set the low calibration point for the scale by pressing Cal Low Pushbutton.
9. With the predetermined calibration weight on the scale set the high calibration point for the scale by pressing Cal High Pushbutton.
10. Save configuration and calibration parameters to memory by pressing Save Pushbutton.

-Weight

1. Via touch screen interface go to Weight Set Points Programming Screen (Program Screen 3)
2. Enter a dribble weight set point if applicable (This will be the value in which you want the part feeding conveyor to go into dribble speed)
3. Enter a final weight set point (This will be the value in which you want the container to be filled to)

EMI WEIGH HOPPER CALIBRATION AND PART SETUP PROCEDURE

-Calibration

1. Via touch screen interface go to Configuration Parameters Programming Screen (Program Screen 1)
2. Enter a Cal Low Reference value of 0. (Factory setting is 0)
3. Enter a Cal High Reference value of the calibration weight being used. For example, at factory a 1kg (1000 gram) weight is used so a value of 1000 is entered. (Factory setting is 1000)
4. Enter a Averages value if necessary (Factory setting is 20)
5. Enter a Motion Tolerance value if necessary (Factory setting is 50)
6. Write configuration parameters by pressing Set Config. Pushbutton.
7. Via touch screen interface go to Calibration Parameters Programming Screen (Program Screen 2)
8. With no weight on the scale set the low calibration point for the scale by pressing Cal Low Pushbutton.
9. With the predetermined calibration weight on the scale set the high calibration point for the scale by pressing Cal High Pushbutton.
10. Save configuration and calibration parameters to memory by pressing Save Pushbutton.

-Part

1. Via touch screen interface go to Sample and Part Setup Programming Screen (Program Screen 3)
2. Enter a parts per discharge set point (This will be the value in which you want the hopper to dump each cycle) “Typically $\frac{3}{4}$ full hopper amount”
3. Enter a parts per container set point (This will be the value in which you want the container to be filled to)
4. Enter a sample size set point (This will be the value in which you want to use for the amount of parts used for sampling to get individual part weight)
5. Enter a dribble part count set point (This will be the value in which you want the part conveyor to enter into dribble speed)
6. With no weight in the hopper set the low calibration point for the hopper by pressing Set Zero Pushbutton
7. With the predetermined amount of sample parts in the hopper “sample size” set the sample part weight by pressing Set Sample Pushbutton (A sample weight should appear)