

1.1.1 Material supply of the weighing hoppers

As batches of material of 3-6 kg are required for the throughput collection from the weighing system, a corresponding supply of material must be available above the slide valve. Mostly there is sufficient material in the feed pipes from the hopper loaders lying above or suction conveyors. If the suction conveyors are installed directly above the weighing system, the required batches are to be manufactured in the shortest time (approx. 30 sec). An increase in the supply of material in the suction conveyor would offer a satisfactory solution for this. The picture below shows one possible layout of the suction conveyors above the weighing hoppers.

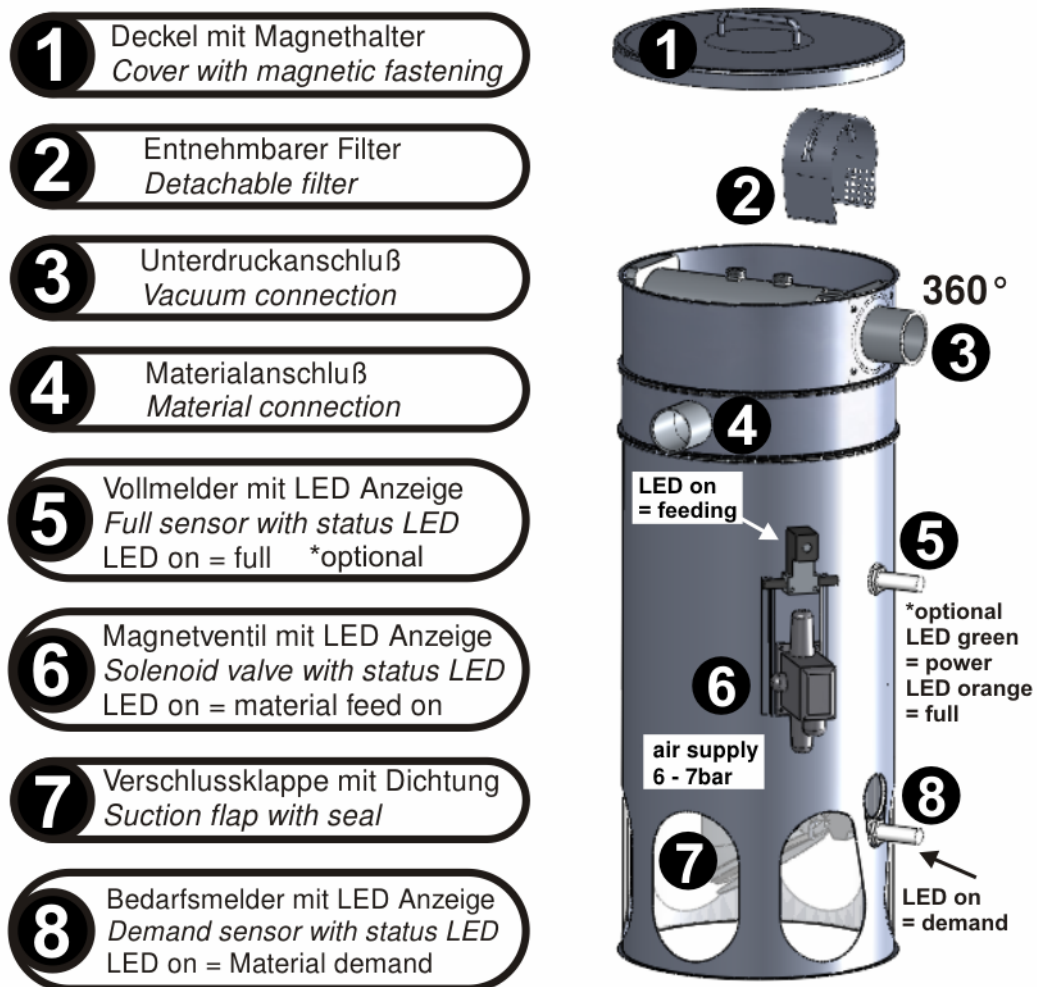


Picture 1 PCH Type Material Conveyors

1.1.1.1 Conveyor schematic

For the operation of the PCH type conveyors a compressed air supply of 6 - 7bar (87 - 102 psi) is necessary!

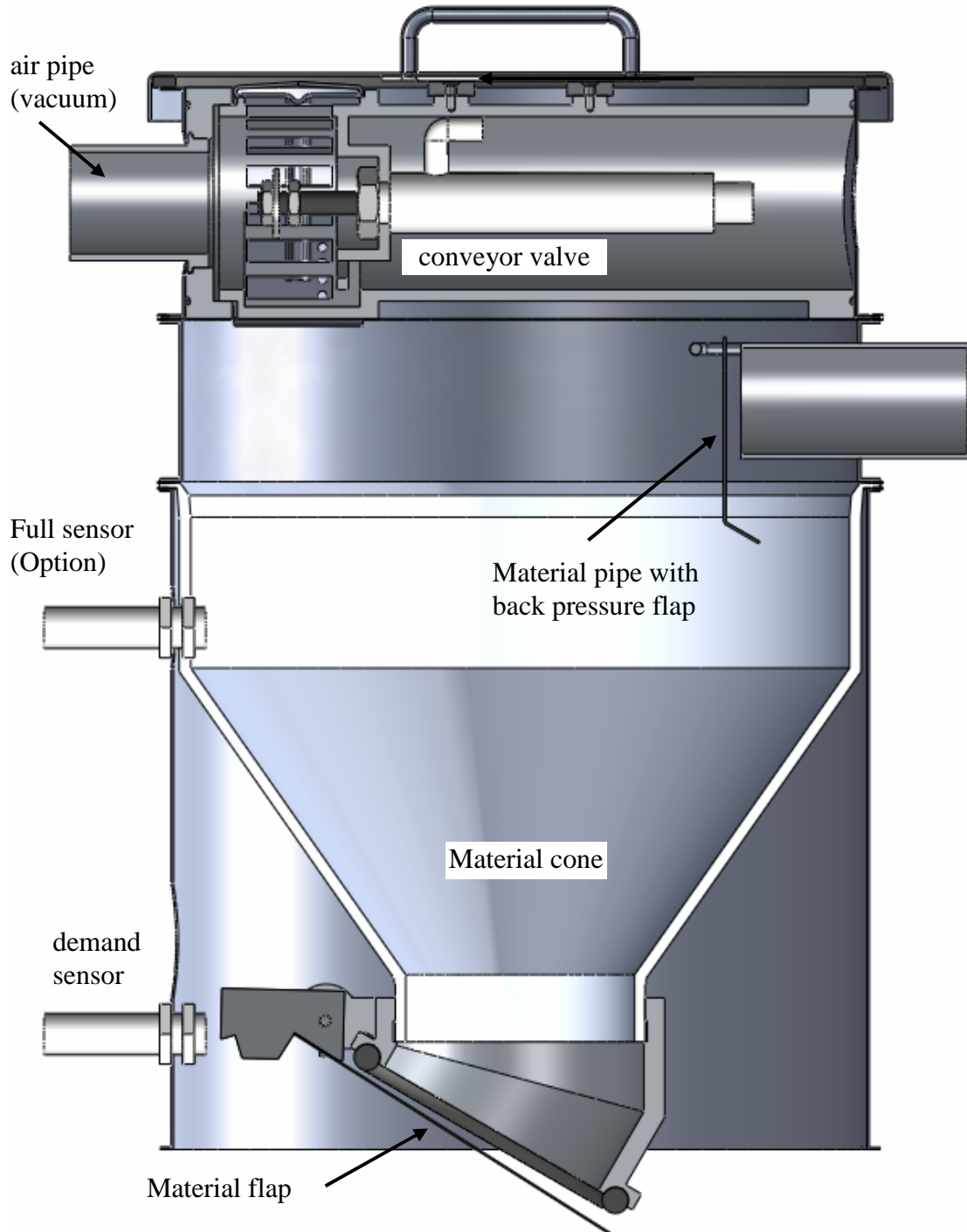
Conveyor schematic PCH 400/800:



Picture 2 Schematic PCH400/800

1.1.1.2 Function principle

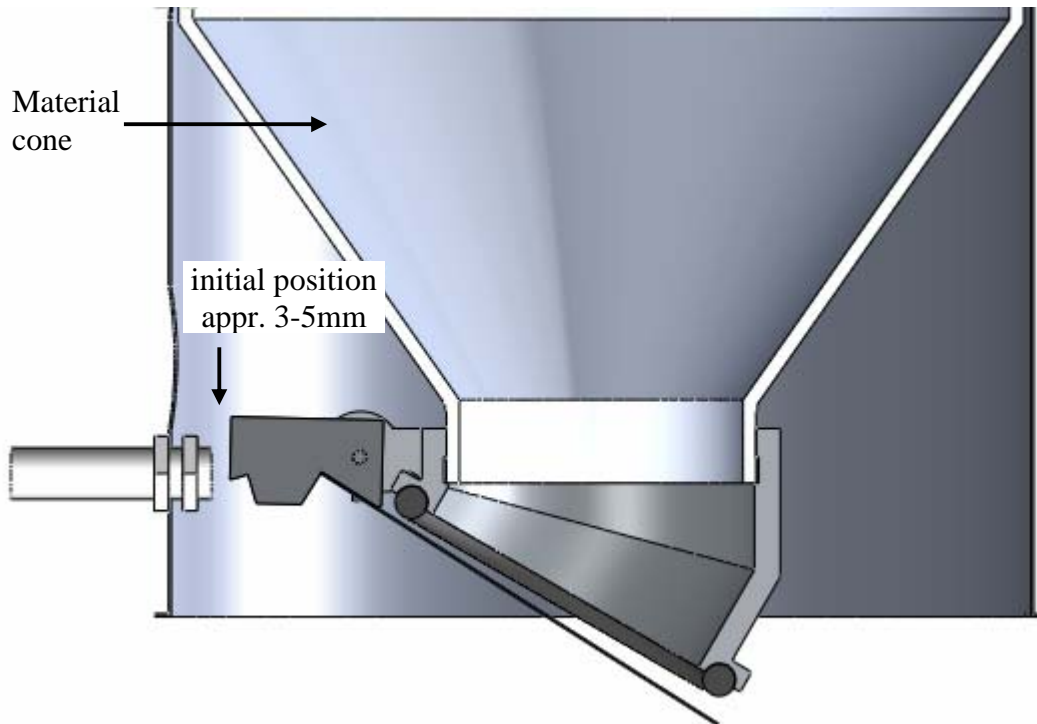
A conveyor indicates "Material demand" by means of a demand sensor. The blower starts and builds up low pressure in the conveying pipe. Depression is directed inside the conveyor by the conveyor valve. Material suction takes place until the conveying time is elapsed. The conveyor valve is switched off and depression inside the conveyor falls off. This will open the material flap and material drops out.



Picture 3 PCH type Material conveyor

1.1.1.3 Adjustment of the demand sensor

The switching point of the demand sensor can be mechanically adjusted by the positioning of the sensor. The demand sensor is operated by a balancing weight attached to the material flap:



Picture 4 Detailed view of material cone with demand sensor



In any case the material flap must be freely movable from opening to closing position.

1.1.1.4 Adjustment of full sensor (Option)

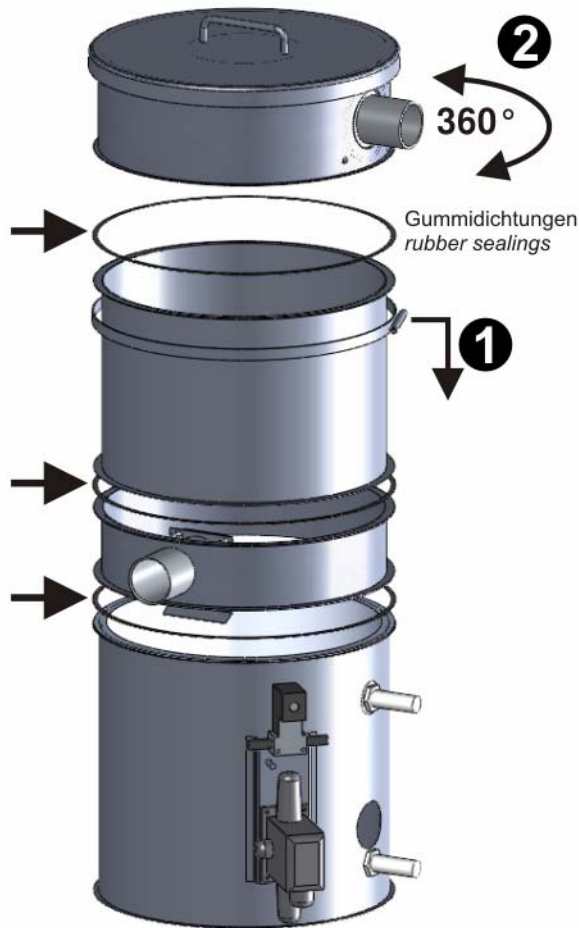
The sensor sensitivity is adjustable by a built in potentiometer directly at the full sensor.

1.1.1.5 Connector adjustment PCH 400 / 800, PCP



Attention Rubber Sealings!

To adjust the connections remove the clamping ring (1) and lift off the respective segment (2) completely. Fasten again in desired position! To avoid a mechanical damage or leakage do not turn the parts if the clamping ring is still in place!



Picture 5 Conveyors Rubber Sealings