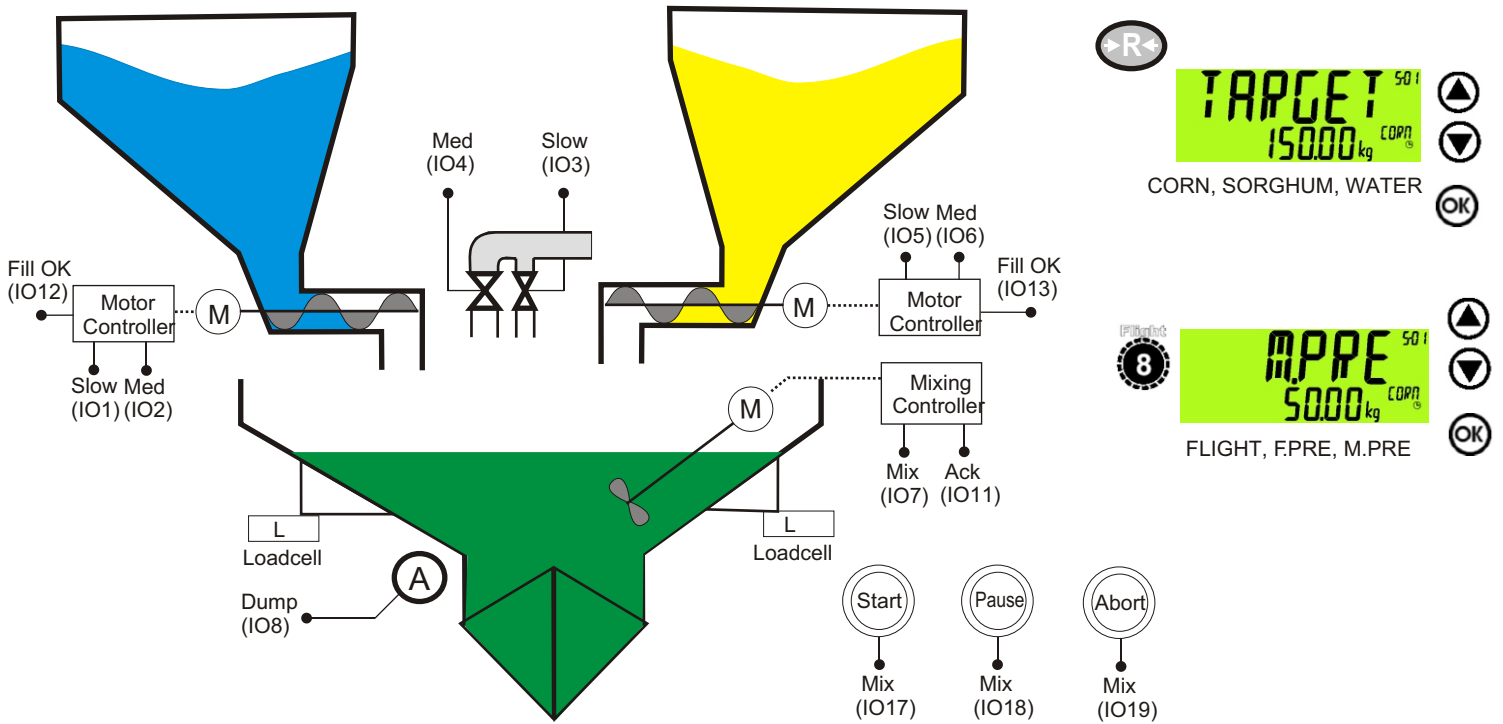


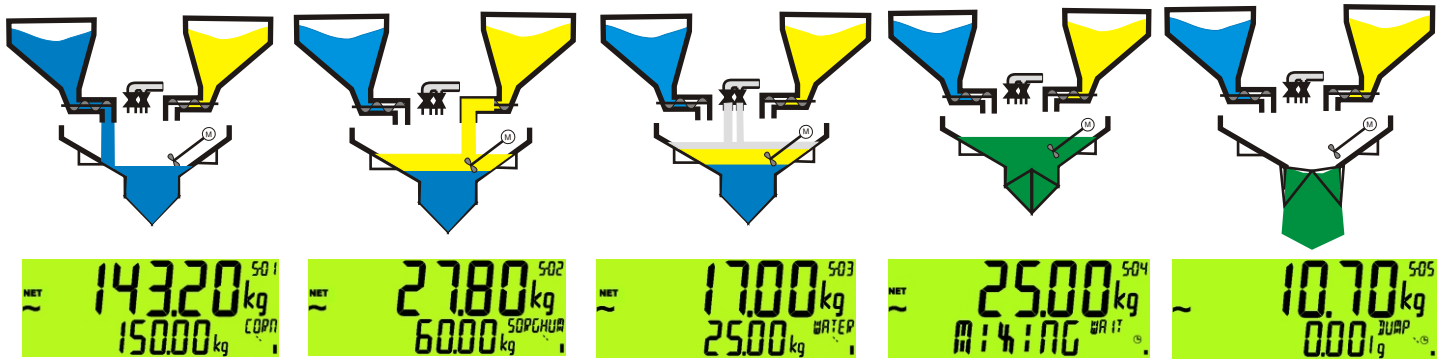


K411 App Note 2: Three Material Feed Mixer



Target 15000 kg
CORN, SORGHUM, WATER

MPRE 5000 kg
FLIGHT, FPRE, M.PRE



Notes:

Multi-speed Filling stage ensures fast accurate filling.

Auto-inflight correction is used to ensure filling accuracy is maintained as header silos empty and fill rate slows.

Dump-to-weight is used to ensure all product leaves hopper before end of batch

Fill Interlocks from motor controller error signals are used to stop fill if header silo is empty.

Feedback from mixing controller is used to time the mix stage.

```

[-] SETUP
  ...
  [-] FUNC
    NUM      :  _3_
    [-] SF1
      TYPE   :  START
      KEY    :  I017
    [-] SF2
      TYPE   :  PAUSE
      KEY    :  I018
    [-] SF3
      TYPE   :  ABORT
      KEY    :  I019
    ...
  
```

```

[-] SETUP
  ...
  [-] BATCH
    [-] MAT
      NAME1   :  CORN
      NAME2   :  SORGHUM
      NAME3   :  WATER
      ...
    [-] STAGES
      NUM     :  _5_
      [-] STAGE.1
        TYPE   :  FILL
        S.FILL :  I01
        M.FILL :  I02
        F.FILL :  NONE
        I.LOCK :  I012
        ...
        MAT    :  MAT.1
        ST.ACT :  TARE
        CORR   :  AUT.FLT
        ...
      [-] STAGE.2
        (same as STAGE.1)
      [-] STAGE.3
        (same as STAGE.1)
      [-] STAGE.4
        TYPE   :  WAIT
        NAME   :  WAIT
        INPUT  :  I011
        STG.OUT :  I07
        LINK   :  PREV
      [-] STAGE.5
        TYPE   :  DUMP
        DMP.OUT :  I08
        ...
        DMP.TYP :  WEIGHT
        TOL.HI  :  0.5 kg
        ...
    ...
  
```

Note:

WAIT stage has LINK set to PREV so that mixing only occurs if WATER has been added during the batch.