1 Capsules per hour
Capsules per hour

x 1000

Capsules per hour multiplied by 1000

The number in capsules per hour is displayed in the actual field here.

The production volume is determined by machine’s cycle time minus the deactivated holders and tracks.

Version: 1.2
Datum: 09.05.2017

2 Rotary disk cycle time
Rotary disk cycle time of the machine

1/min

Cycle time of rotary disk in cycles per minute

The cycle time of the rotary disk in cycles per minute is entered here.

The rotary disk cycle time determines the machine’s cycle time.

The parameter is calculated from the switching and idle times (parameters 3 and 4) divided by one minute.

The sum of the switching time and idle time gives the time required for one cycle.

Version: 1.1
Datum: 09.05.2017

3 Idle time
Idle time of the machine

ms

Idle time of the machine in milliseconds

The idle time of the machine is entered here. The current value is shown in the actual field.

The idle time of the machine describes the time during which the rotary disk is not moving.

Processes such as insertion, separation, filling and closing of the capsules, for example, are carried out during this time.

The rotary disk cycle time (parameter 2) is determined by the switching and idle times (parameters 3 and 4).

The input limit is determined by the slowest process step during the idle time.

Version: 1.1
Datum: 09.05.2017

4 Switching time
Switching time of the machine

ms

Switching time of the machine in milliseconds.

The switching time of the machine is entered here. The current value is shown in the actual field.

The machine's switching time is the time during which the rotary disk moves to the next station.

The rotary disk cycle time (parameter 2) is determined by the switching and idle times (parameters 3 and 4).

The input limits are determined by the permitted speed of the rotary disk.

Version: 1.1
Datum: 09.05.2017

5 Rotary disk inertia
Moment of inertia of the rotary disk

kgcm^2

The moment of inertia of the rotary disk can be changed via this parameter in the main drive controller.

At a value of 0, the set moment of inertia in the main drive controller is not changed.

The format-dependent capsule holders of the rotary disk can differ in mass and thus in inertia.

Version: 0.1
Datum: 09.01.2019

14 Good production
Good production

x 1000

Good production multiplied by 1000 capsules

The total quantity of capsules to be produced multiplied by 1000 is entered here.

The actual field shows the current amount of produced capsules multiplied by 1000.

Counting in mono mode:

Side A = Total number of capsules produced multiplied by 1000.

Side B = Total number of capsules produced multiplied by 1000 (double rotary machine only)

If the selected number of capsules is reached, the machine is stopped with the corresponding diagnosis.

The good production counter is reset when a batch is finished.

Version: 1.1
Datum: 09.05.2017

15 Rejected production
Rejected production

Qty

Rejected production as a quantity

The rejected production is displayed as a quantity here.

All capsules that are rejected through the reject channel are counted with this parameter.

Unopened capsules which are extracted at the “Rejection of unopened capsules” station are

not counted with this parameter.

Counting:

Side A = Total quantity of all capsules rejected in the reject channel

Side B = number of rejected capsules in the reject channel on side B (double rotary machine only)

Rejected capsules are:

- all capsules produced in the setup run

- all capsules rejected into the reject channel by the reject function

- all capsules rejected into the reject channel by the discharge gate delay (parameter 68)

The rejected production counter is reset when a batch ends.

Version: 1.2
Datum: 09.05.2017

16 Good capsule fill volume
Good capsule fill volume

x 1000

Good capsule fill volume (quantity) x 1000 per drum

The good capsule fill volume is entered here as a quantity multiplied by 1000.

Every time the capsule volume is reached, the loading center or filling gate moves on one drum.

If "0" is entered:

- there is no onward movement,

- the actual value of parameter 16 is reset,

- the loading center moves on one drum

- the filling gate only moves on if option 01.100/187 is configured accordingly

With a new batch, the actual value is reset and the machine moves on to the next drum.

Only active with option 01.100/149 "Loading-Center" or option 01.100/187 "Separate filling gate".

Version: 1.2
Datum: 19.03.2019

17 Weight control limit
Weight control limit

%

Weight control limit as a percentage

The % value at which weight control is activated is entered here.

If the value is set to “0”, weight control will be activated when there is a 1% deviation between the set and actual values.

Only active with options 08.500/59 "Weightmaster" or 08.600/251 "Accura-C" and 08.500_600_700_800/252 "Weight control".

Version: 1.2

Datum: 19.03.2019

22 Capsule weight: Mean value
Capsule weight: Mean value

mg

Capsule weight, mean value in milligrams

The set weight of the capsules is entered here if the Weightmaster is used to take samples.

The current mean value of the last sample is shown in the actual field of this parameter.

The number of capsules per sample is entered in parameter 101.

The sampling interval (after X capsules) is entered in parameter 74.

Only active with option 05.200/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

23 Capsule weight: Mean max. deviation
Capsule weight: maximum deviation from mean

%

Capsule weight, maximum deviation from mean as a percentage

The maximum permitted deviation of the set weight from parameter 22 is entered here.

The current mean value of the last "Weightmaster" sample is shown in the actual field of this parameter.

Example:

Parameter 22 = 500 mg

Parameter 23 = 5 %

The machine is stopped with the corresponding diagnosis when the actual value in parameter 22 is greater than 525 mg or less than 475 mg.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

24 Capsule weight: s-rel

Capsule weight: Relative standard deviation

%

Relative standard deviation of the capsule weight as a percentage

The relative standard deviation of the capsule weight as a percentage is entered here.

The standard deviation is an important indicator of the scatter of single values about the calculated.

Mean value for a sample

The value for the last sample is displayed in the actual field.

If the actual value is higher than the preselected limit, the machine is stopped with the corresponding diagnosis.

Only active with option 08.500/59 "Weightmaster"

Version: 1.1
Datum: 19.03.2019

26 Capsule length
Capsule length

mm

Capsule length in millimeters

Length of the capsule in mm is entered here.

When the capsule type (capsule manufacturer and class) is selected, parameters 26 to 30 are preassigned for a recipe.

Version: 1.1
Datum: 09.05.2017

27 Capsule volume
Capsule volume

ml

Capsule volume in milliliters

The volume of the capsule in ml is entered here.

When the capsule type (capsule manufacturer and class) is selected, parameters 26 to 30 are preassigned for a recipe.

Version: 1.1

Datum: 09.05.2017

28 Empty capsule weight
Empty capsule weight (tare)

mg

Empty capsule weight in milligrams

The empty weight of the capsule in mg is entered here.

When the capsule type (capsule manufacturer and class) is selected, parameters 26 to 30 are preassigned for a recipe.

Version: 1.1
Datum: 09.05.2017

29 Capsule body height
Capsule body height

mm

Capsule body height in millimeters

The height of the capsule body is entered in mm here.

When the capsule type (capsule manufacturer and class) is selected, parameters 26 to 30 are preassigned for a recipe.

Version: 1.1
Datum: 09.05.2017

30 Capsule body diameter
Capsule body diameter

mm

Capsule body diameter in millimeters

The diameter of the capsule body is entered in mm here.

When the capsule type (capsule manufacturer and class) is selected, parameters 26 to 30 are preassigned for a recipe.

Version: 1.1
Datum: 09.05.2017

32 Control mode
Control mode

The re-adjustment is switched on or off here.

Enter “1” to switch on the re-adjustment and enter “0” to switch it off.

The entered digit will appear in both the actual and the set field..

If “1” is entered, the re-adjustment is made by the capsule weight.

0 : Control off

1 : Weightmaster

2 : NMC sensor

3 : Weightmaster and NMC sensor

4 : Accura-C

5 : FEQ

Version: 1.2
Datum: 19.03.2019

34 Intensity vertical conveying deduster
Intensity vertical conveying deduster

%

Intensity vertical conveying deduster as a percentage

This parameter can be used to pre-define the intensity of the vertical conveying deduster.

If “0” is entered the intensity of the vertical conveying deduster is set automatically, depending on the value entered in parameter 2.

The vertical conveying deduster is switched on in tandem with the capsule filling machine.

The vertical conveying deduster will continue to run after the capsule filling machine is stopped to remove the remaining capsules from its interior.

Version: 1.0
Datum: 01.04.2019

35 Capsule magazine
Capsule magazine format-specific part

Capsule magazine format-specific part

The installed capsule magazine is selected from the list here.

If option 06.131/920 (RFID format-specific part recognition) is active, the detected capsule magazine is displayed in the actual value.

If the set value and actual value do not tally, the machine cannot be started and a diagnosis appears.

If the machine does not have an RFID system, the actual value of this parameter remains set to 0.

1 : Magazine cl. 000

2 : Magazine cl. 00

3 : Magazine cl. 0

4 : Magazine cl. 1

5 : Magazine cl. 2

6 : Magazine cl. 3

7 : Magazine cl. 4

8 : Magazine cl. 5

9 : Magazine cl. 00 el

10 : Magazine cl. 0 el

11 : Magazine cl. 0 el*

12 : Magazine cl. 1 el

13 : Magazine cl. 2 el

14 : Magazine cl. 4 el

15 : Magazine cl. AAA

16 : Magazine cl. AA el

17 : Magazine cl. AA

18 : Magazine cl. A

19 : Magazine cl. B

20 : Magazine cl. C

21 : Magazine cl. D

22 : Magazine cl. E

Version: 1.2
Datum: 19.03.2019

37 CFC: Permitted number of faulty capsules
CFC: Permitted number of faulty capsules

Qty

CFC: Permitted number of faulty capsules as a quantity

The number of successive faulty capsules after which an air rejection pulse is required is entered here. This is evaluated separately for each track.

The value set for this parameter should be smaller than the value set for parameter 94 (Number of non-separated capsules in succession per track).

Version: 1.2
Datum: 30.05.2017

38 CFC: Air rejection pulse, start
CFC: Air rejection pulse, start

ms

CFC: air rejection pulse in milliseconds, Start

The starting time of the air rejection pulse in milliseconds is entered here.

This parameter is used for optimization during an air rejection pulse of the CFC function.

Version: 1.1
Datum: 09.05.2017

39 CFC: Air rejection pulse, duration
CFC: Air rejection pulse, duration

ms

CFC: air rejection pulse in milliseconds, duration

The duration of the air rejection pulse in milliseconds is entered here.

This parameter is used to optimize an air rejection pulse of the CFC function.

Version: 1.1
Datum: 09.05.2017

40 Capsule bed height 1 filling slide
Capsule bed height 1 filling slide

mm

Capsule bed height 1 filling slide in mm

The mechanical setting for the filling slide at capsule feeder 1 is entered here.

Version: 1.1
Datum: 09.05.2017

41 Capsule bed height 2 filling slide
Capsule bed height 2 filling slide

mm

Capsule bed height 2 filling slide in mm

The mechanical setting for the filling slide at capsule feeder 2 is entered here.

Version: 1.1
Datum: 09.05.2017

44 Filling cone fill level alarm delay
Filling cone fill level alarm delay

s

Filling cone fill level alarm delay in seconds

A stop delay is entered here.

This time indicates how long the machine should continue to produce when the actual value of parameter 110 / 111 (Filling cone fill level) is “0”.

A warning diagnosis is displayed while the delay time is active.

The machine stops when the time has elapsed.

If the machine stops within the delay time, e.g. because of another stop diagnosis, it only waits for the remaining time of the stop delay after starting up again.

Version: 1.1
Datum: 09.05.2017

46 Sorting fork end position
Sorting fork end position

mm

Sorting fork end position in millimeters

The end position of the sorting fork on the capsule feeder is entered here.

Version: 1.1
Datum: 09.05.2017

49 Extraction speed
Extraction speed

m/s

Extraction speed in meter per second

The extraction speed can be entered here in meter per second.

The extraction vacuum is controlled by means of a flow sensor and a corresponding control equipment.

Version: 1.0
Datum: 09.01.2019

49 Extraction vacuum
Extraction vacuum in the machine housing

hPa

Extraction vacuum in hectopascal (1 hPa ~ 1 mbar)

The extraction vacuum in hectopascal is entered here.

The extraction vacuum is controlled by a pressure transducer and associated control equipment.

If the actual value deviates by more than 0.5 hPa from the set value within one minute, the machine is stopped with the corresponding diagnosis.

Version: 1.1
Datum: 07.01.2019

52 Capsule separation - vacuum building time on
Capsule separation - vacuum building time on

ms

Capsule separation - vacuum building time on in milliseconds

The value entered here defines the switch-on time of the valve (configuration time).

Version: 1.0
Datum: 26.04.2016

53 Capsule separation - vacuum building time off
Capsule separation - vacuum building time off

ms

Capsule separation - vacuum building time off in milliseconds

The value entered here defines the switch-off time of the valve (configuration time).

Version: 1.0
Datum: 26.04.2016

54 Per number of capsules
Per number of capsules

Qty

Per number of capsules as a quantity

A reference number for parameter 93 (Non-separated capsules), 95 (Non-separated capsules per track),

325 (Non-closed capsules in total) and 327 (Non-closed capsules per track) is entered here.

If "0" is entered, parameters 54, 93, 95, 325 and 327 are deactivated.

Version: 1.1
Datum: 09.05.2017

55 Permitted metal pulses
Permitted metal pulses

Qty

Permitted metal pulses as a quantity

The number of rejection pulses from a metal detector in relation to parameter 56 (Per number of capsules) is entered here.

Example:

In order to allow 2 rejection pulses per 10 x 1000 = 10,000 capsules produced, the value "2" should be entered in parameter 55 and "10" in parameter 56.

If there are more than 2 rejection pulses for every 10,000 produced capsules, then the machine is stopped with the corresponding diagnosis.

If "0" is entered, this parameter is deactivated.

Version: 1.1
Datum: 09.05.2017

56 Per number of capsules x 1000
Per number of capsules x 1000

Qty

Per number of capsules multiplied by 1000

Parameter 56 serves as reference number for parameter 55.

If "0" is entered, parameters 55 and 56 are deactivated.

Version: 1.0
Datum: 26.04.2016

65 Block dosing
Block dosing

Qty

Block dosing as a quantity

The number of opened capsules within a capsule holder from which the dosing process starts can be entered here.

If the number of opened capsules is not reached, the dosing is blocked and the empty capsules are rejected through the reject channel.

Example:

Parameter 65 = 22: If there are either exactly 22 or more than 22 opened capsules in the capsule holder, the dosing process is started.

This function can switched on/off by means of a separate switch (via the “Process view separation”).

Version: 1.4
Datum: 07.01.2019

66 Active tracks per capsule holder
Active tracks per capsule holder

Qty

Active tracks per capsule holder as a quantity

The actual number of active tracks per capsule holder is displayed here. A track may be set to active or inactive in the single track check.

Version: 1.1
Datum: 09.05.2017

68 Discharge gate delay
Discharge gate delay

Cycles

Discharge gate delay in cycles

The discharge gate delay in cycles is entered here.

After the capsule filling machine is started, it may be necessary to leave the discharge gate in the reject position for a while.

This time period can be pre-selected here in cycles.

Version: 1.1
Datum: 15.05.2017

74 Sampling interval
Sampling interval

x 1000

Sampling interval multiplied by 1000 capsules

The automatic sampling interval multiplied by 1000 capsules is entered here.

A sample is taken every time the pre-set number of capsules is reached.

The first sampling occurs 30 seconds after a new batch is first started and then every "n" x 1000 capsules.

If the machine is stopped during sampling, then the sample is delayed by 30 seconds after the machine is restarted.

If "0" is entered, no sample is taken.

Version: 1.3
Datum: 10.04.2018

79 Capsule statistics save interval
Capsule statistics save interval

x 1000

Capsule statistics save interval multiplied by 1000 capsules

The interval at which the capsule statistics are saved for the production report is entered here.

The determined values are saved for the first time as soon as production starts and then every time the set save interval has elapsed.

The value “0” means that this function is deactivated.

Only active with option 01.100/253 "Capsule statistics"

Version: 1.2
Datum: 19.03.2019

82 Capsule statistics save interval
Separate sampling gate: Quantity

Qty

Separate sampling gate: Number of capsules as a quantity

The number of sample capsules for the separate sampling gate is entered here.

Version: 1.1
Datum: 19.03.2019

84 Temperature of main drive electronic circuit
Temperature of main drive electronic circuit

°C

Temperature of the main drive electronic circuit in degrees Celsius

The current temperature of the electronic circuit on the main drive is displayed here.

The temperature of the electronic circuit on the main drive is for information only and therefore has no set value.

The fans in the power cabinet are switched on automatically when the temperature rises above 58°C.

The fans in the power cabinet are switched off automatically when the temperature drops below 55°C.

Version: 1.1
Datum: 10.05.2017

86 Powder cone fill level alarm delay
Powder cone fill level alarm delay

s

Powder cone fill level alarm delay in seconds

A stop delay is set here.

This time indicates how long the machine should continue to produce after having reached the filling level limit.

A warning diagnosis is displayed while the delay time is active.

The machine stops when the time has elapsed.

If the machine stops within the delay time, e.g. because of another stop diagnosis, it only waits for the remaining time of the stop delay after starting up again.

Version: 1.1
Datum: 10.05.2017

89 Operating hours
Operating hours

h

Operating hours in hours.

The operating hours counter counts the operating hours of the machine.

The time corresponds to the actual turning time of the rotor.

Version: 1.1
Datum: 10.05.2017

91 Stroke for rejection of n.s.c.
Stroke for rejection of non-separated capsules

mm

Stroke for rejection of non-separated capsules in millimeters

The stroke of the pins for the rejection of non-separated capsules is entered here.

Version: 1.2
Datum: 17.05.2018

92 Filling slide for “Non-separated capsules” extraction unit
Filling slide for “Non-separated capsules” extraction unit

mm

Filling slide for “Non-separated capsules” extraction unit in millimeters

The value set for the mechanical filling slide of the extraction unit at the “Rejection of non-separated capsules” station is entered here.

Version: 1.2
Datum: 10.04.2018

93 Total number of non-separated capsules

Total number of non-separated capsules

Qty

Total number of non-separated capsules as a quantity

The maximum number of non-separated capsules that can be tolerated in relation to the quantity of capsules specified in parameter 54 (per number of capsules) is entered here.

If the specified maximum ratio is exceeded, the machine stops with the corresponding diagnosis.

The check is activated as soon as the number of capsules set in parameter 54 is produced.

Parameter 54 must be configured before the set value can be set.

The value “0” means that this function is deactivated.

Version: 1.1
Datum: 10.05.2017

94 Non-separated capsules in succession per track
Non-separated capsules in succession per track

Qty

Non-separated capsules in succession per track as a quantity

The maximum tolerated number of non-separated capsules in immediate succession per track is entered here.

If the set value is exceeded, the machine is stopped with the corresponding diagnosis.

The set value for this parameter should be greater than the set value for parameter 37 (CFC: Number of permitted capsules).

The value “0” means that this function is deactivated.

Version: 1.3
Datum: 10.04.2018

95 Non-separated capsules per track
Non-separated capsules per track

Qty

Non-separated capsules per track as a quantity

The maximum number of non-separated capsules that can be tolerated per track in relation to the quantity of capsules specified in parameter 54 (per number of capsules) is entered here.

If the specified maximum ratio is exceeded, the machine stops with the corresponding diagnosis.

The check is activated as soon as the number of capsules set in parameter 54 is produced.

Parameter 54 must be configured before the set value can be set.

The value “0” means that this function is deactivated.

Version: 1.1
Datum: 10.05.2017

96 Total non-separated capsules per batch
Total non-separated capsules per batch

Qty

Total non-separated capsules per batch (quantity)

The maximum number of non-separated capsules that can be tolerated in relation to the quantity of capsules specified in parameter 14 (good production) is entered here.

If the specified quantity of capsules is exceeded, the machine stops with the corresponding diagnosis.

The value “0” means that this function is deactivated.

Version: 1.1
Datum: 10.05.2017

100 Number of samples per container
Number of samples per container

Qty

Number of samples per container as a quantity

The number of samples to be collected in every sample container is entered here.

When a new batch number is entered, the actual value is set to "0" and the system moves on to sample container 1.

Only active with option 08.500/59 "Weightmaster"

Version: 1.1
Datum: 19.03.2019

101 Capsule weight: number
Capsule weight: number

Qty

Capsule weight: number as a quantity

The number of capsules for evaluating the weight can be entered here (option 05.200/59 "Weightmaster").

Version: 1.2
Datum: 19.03.2019

102 Capsule weight: +window
Capsule weight: +window

%

Capsule weight: +window as a percentage

The upper limit of the permitted range (window) for the capsule weight is entered here.

Example:

If a value of +30% is entered, only capsules up to 130% of the set weight are evaluated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.0
Datum: 19.03.2019

103 Capsule weight: -range
Capsule weight: -range

%

Capsule weight: -range as a percentage

The lower limit of the permitted range for the capsule weight is entered here.

Example:

If a value of 30% is entered, this means that only capsules greater than 70% of the set value are evaluated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.1
Datum: 19.03.2019

104 Capsule weight: +T2
Capsule weight: +T2

%

Capsule weight: +T2 limit as a percentage

The tolerance limit "+T2" for the weight of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0.1 ... 99.9%

With option 535 "Shut down limit T2", the machine stops after finishing a sample if a single value is outside this limit.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.1
Datum: 19.03.2019

105 Capsule weight: +T1
Capsule weight: +T1

%

Capsule weight: +T1 limit as a percentage

The tolerance limit "+T1" for the weight of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0.1 ... 99.9%

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.1
Datum: 19.03.2019

106 Capsule weight: -T1
Capsule weight: -T1

%

Capsule weight: -T1 limit as a percentage

The tolerance limit "-T1" for the weight of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0.1 ... 99.9%.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.1
Datum: 19.03.2019

107 Capsule weight: -T2
Capsule weight: -T2

%

Capsule weight: -T2 limit as a percentage

The tolerance limit "-T2" for the weight of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0.1 ... 99.9%

With option 535 "Shut down limit T2", the machine stops after finishing a sample if a single value is outside this limit.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.1
Datum: 19.03.2019

110 Capsule hopper 1 fill level
Capsule hopper 1 fill level

mm

Capsule hopper 1 fill level in millimeters

The fill level of the capsule hopper on feeder 1 is displayed in millimeters here.

The fill level display is for information only, so there is no set value.

The height of the capsule bed is monitored.

If the set minimum level (parameter 112) is not reached in standard run mode, this triggers a stop diagnosis; in all other run modes a warning diagnosis is triggered.

Version: 1.2
Datum: 10.05.2017

111 Capsule hopper 2 fill level
Capsule hopper 2 fill level

mm

Capsule hopper 2 fill level in millimeters

The fill level of the capsule hopper on feeder 2 is displayed in millimeters here.

The fill level display is for information only, so there is no set value.

The height of the capsule bed is monitored.

If the set minimum level (parameter 112) is not reached in standard run mode, this triggers a stop diagnosis; in all other run modes a warning diagnosis is triggered.

Version: 1.2
Datum: 10.05.2017

112 Filling cone minimum fill level
Filling cone minimum fill level

mm

Filling cone minimum fill level in millimeters

The minimum fill level of the feeder capsule bed in millimetres is entered here.

If the minimum level is not reached, this triggers a stop diagnosis.

Version: 1.2
Datum: 10.05.2017

115 Coolant temperature
Coolant temperature

°C

Coolant temperature in °C

The temperature value to be controlled is entered here.

The drives are cooled by circulating coolant.

The temperature of this coolant is controlled by the fan activity.

Version: 1.1
Datum: 10.05.2017

116 Capsule magazine 1, starting time for downward movement
Capsule magazine 1, starting time for downward movement

ms

Capsule magazine 1, starting time for downward movement in milliseconds

The starting time for the downward movement of the capsule magazine on capsule feeder 1 is entered here.

The accumulated sum of parameters 116 to 119 (upward and downward movement of the capsule magazine) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1
Datum: 10.05.2017

117 Capsule magazine 1, duration of downward movement
Capsule magazine 1, duration of downward movement

ms

Capsule magazine 1, duration of downward movement in milliseconds

The duration of the downward movement of the capsule magazine on capsule feeder 1 is entered here.

The accumulated sum of parameters 116 to 119 (upward and downward movement of the capsule magazine) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1
Datum: 10.05.2017

118 Capsule magazine 1, starting time for upward movement
Capsule magazine 1, starting time for upward movement

ms

Capsule magazine 1, starting time for upward movement in milliseconds

The starting time for the upward movement of the capsule magazine on capsule feeder 1 is entered here.

The accumulated sum of parameters 116 to 119 (upward and downward movement of the capsule magazine) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1

Datum: 10.05.2017

119 Capsule magazine 1, duration of upward movement
Capsule magazine 1, duration of upward movement

ms

Capsule magazine 1, duration of upward movement in milliseconds

The duration of the upward movement of the capsule magazine on capsule feeder 1 is entered here.

The accumulated sum of parameters 116 to 119 (upward and downward movement of the capsule magazine) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1
Datum: 10.05.2017

120 Capsule magazine 2, starting time for downward movement
Capsule magazine 2, starting time for downward movement

ms

Capsule magazine 2, starting time for downward movement in milliseconds

The starting time for the downward movement of the capsule magazine on capsule feeder 2 is entered here.

The accumulated sum of parameters 120 to 123 (upward and downward movement of the capsule magazine) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1
Datum: 10.05.2017

121 Capsule magazine 2, duration of downward movement
Capsule magazine 2, duration of downward movement

ms

Capsule magazine 2, duration of downward movement in milliseconds

The duration of the downward movement of the capsule magazine on capsule feeder 2 is entered here.

The accumulated sum of parameters 120 to 123 (upward and downward movement of the capsule magazine) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1
Datum: 10.05.2017

122 Capsule magazine 2, starting time for upward movement
Capsule magazine 2, starting time for upward movement

ms

Capsule magazine 2, starting time for upward movement in milliseconds

The starting time for the upward movement of the capsule magazine on capsule feeder 2 is entered here.

The accumulated sum of parameters 120 to 123 (upward and downward movement of the capsule magazine) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1
Datum: 10.05.2017

123 Capsule magazine 2, duration of upward movement
Capsule magazine 2, duration of upward movement

ms

Capsule magazine 2, duration of upward movement in milliseconds

The duration of the upward movement of the capsule magazine on capsule feeder 2 is entered here.

The accumulated sum of parameters 120 to 123 (upward and downward movement of the capsule magazine) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1
Datum: 10.05.2017

125 Weightmaster: chute rotation angle
Weightmaster: chute rotation angle

Weightmaster: chute rotation angle

The rotation angle of the Weightmaster chute is entered here in stages from "1-9".

This value must be optimized by trial and error to suit the capsule size and shape.

Only active with option 08.500/59 "Weightmaster"

Version: 1.1
Datum: 19.03.2019

126 Weightmaster: Chute rotation speed
Weightmaster: Chute rotation speed

Weightmaster: Chute rotation speed

The rotation speed of the Weightmaster chute is entered here in stages from "1 - 9".

This value must be optimized by trial and error to suit the capsule size and shape.

The lower the rotation speed, the greater the vibration of the chute.

The vibration of the chute can also be adjusted via the Weightmaster configuration.

Only active with option 08.500/59 "Weightmaster"

Version: 1.1
Datum: 19.03.2019

127 Weightmaster: Disk rotation speed
Weightmaster: Disk rotation speed

Weightmaster: Disk rotation speed

The rotation speed of the Weightmaster disk is entered here in stages from "1 - 9".

This value must be optimized by trial and error to suit the capsule size and shape.

Only active with option 08.500/59 "Weightmaster"

Version: 1.0
Datum: 19.03.2019

128 Air transport delay sampling procedure
Air transport delay sampling procedure

s

The air transport delay in seconds can be entered here.

The air transport delay is the period of time in which the air supply for the venturi system remains active after the sample gate has closed so that all capsules are blown out of the hose.

This value must be optimised by trial and error to suit the capsule size and weight.

Entering a value of "0" means this function will be deactivated.

Version: 1.2
Datum: 19.03.2019

129 Air transport delay good production
Air transport delay good production

s

Air transport delay in seconds

The air transport delay is the time in which the air supply of the Venturi system remains active after the stop of the machine so that all capsules are blown out of the hose.

This value must be optimised by trial and error depending on the capsule size and weight.

Entering a value of "0" is equivalent with deactivating the function.

Version: 1.0
Datum: 9.11.2018

136 Congestion detection delay
Congestion detection delay for line production

s

Congestion detection delay for line production in seconds

The congestion detection delay for the external congestion detectors (line production) in seconds is entered here.

Capsule congestion is detected if the input signal at the external congestion detectors was active for at least the time entered in this parameter.

Version: 1.1
Datum: 10.05.2017

138 Capsule weight: Mean value +T2
Capsule weight: Mean value +T2

%

Capsule weight: mean +T2 limit as a percentage

The "+T2"-limit for the mean value of the capsule weight is entered here.

The capsule filling machine stops after finishing a sample when a mean value falls outside this limit (option 677 K1xxx).

Capsules outside the "T2" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/59 "Mean value monitoring with T limit"

Version: 1.0
Datum: 19.03.2019

139 Capsule weight: Mean value +T1

Capsule weight: Mean value +T1

%

Capsule weight: Mean value +T1

The "+T1"-limit for the mean value of the capsule weight is entered here.

Capsules outside the "T1" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.0
Datum: 19.03.2019

140 Capsule weight: Mean value -T1
Capsule weight: Mean value -T1

%

Capsule weight: Mean value -T1 limit as a percentage

The "-T1" limit for the mean value of the capsule weight is entered here.

Capsules outside the "T1" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.0
Datum: 19.03.2019

141 Capsule weight: Mean value -T2
Capsule weight: Mean value -T2

%

Capsule weight: mean -T2 limit as a percentage

The "-T2" limit for the mean value of the capsule weight is entered here.

The machine stops after finishing a sample when a mean value falls below this limit (option 08.500/678).

Capsules outside the "T2" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/59 "Mean value monitoring with T limit"

Version: 1.0

Datum: 19.03.2019

143 Sorting fork, starting time for forward movement
Sorting fork, starting time for forward movement

ms

Sorting fork, starting time for forward movement in milliseconds

The starting time for the forward movement of the sorting fork at the capsule feeders is entered here.

The accumulated sum of parameters 143 to 146 (forward and backward movement of the sorting fork) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1
Datum: 10.05.2017

144 Sorting fork, duration of forward movement
Sorting fork, duration of forward movement

ms

Sorting fork, duration of forward movement in milliseconds

The duration of the forward movement of the sorting forks on the capsule feeders is entered here.

The accumulated sum of parameters 143 to 146 (forward and backward movement of the sorting fork) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1
Datum: 10.05.2017

145 Sorting fork, starting time for backward movement
Sorting fork, starting time for backward movement

ms

Sorting fork, starting time for backward movement in milliseconds

The starting time for the backward movement of the sorting forks on the capsule feeders is entered here.

The accumulated sum of parameters 143 to 146 (forward and backward movement of the sorting fork) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1
Datum: 10.05.2017

146 Sorting fork, duration of backward movement
Sorting fork, duration of backward movement

ms

Sorting fork, duration of backward movement in milliseconds

The duration of the backward movement of the sorting forks on the capsule feeders is entered here.

The accumulated sum of parameters 143 to 146 (forward and backward movement of the sorting fork) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1
Datum: 10.05.2017

151 Suction pad, starting time for upward movement
Suction pad, starting time for upward movement

ms

Suction pad, starting time for upward movement in milliseconds

The starting time for the upward movement of the suction cups on the capsule feeders is entered here.

The accumulated sum of parameters 151 to 154 (upward and downward movement of the suction cups) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1
Datum: 10.05.2017

152 Suction cup, duration of upward movement
Suction cup, duration of upward movement

ms

Suction cup, duration of upward movement in milliseconds

The duration of the upward movement of the suction cups on the capsule feeders is entered here.

The accumulated sum of parameters 151 to 154 (upward and downward movement of the suction cups) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1
Datum: 10.05.2017

153 Suction cup, starting time for downward movement
Suction cup, starting time for downward movement

ms

Suction cup, starting time for downward movement in milliseconds

The starting time for the downward movement of the suction cups on the capsule feeders is entered here.

The accumulated sum of parameters 151 to 154 (upward and downward movement of the suction cups) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1
Datum: 10.05.2017

154 Suction cup, duration of downward movement
Suction cup, duration of downward movement

ms

Suction cup, duration of downward movement in milliseconds

The duration of the downward movement of the suction cups on the capsule feeders is entered here.

The accumulated sum of parameters 151 to 154 (upward and downward movement of the suction cups) must not exceed the idle and switching time (parameters 3 + 4).

Version: 1.1
Datum: 10.05.2017

155 Track cam sep start of mov
Track cam separation, starting time of movement

ms

Track cam separation, starting time of movement in milliseconds

The starting time of the movement of the track cam on capsule feeder 2 is entered here.

Parameters 155 / 156 (track cam movement) must not exceed the idle and switching time (parameters 3 + 4) of the machine.

Version: 1.2
Datum: 19.02.2018

156 Track cam sep dur of mov
Track cam separation, duration of movement

ms

Track cam separation, duration of movement in milliseconds

The duration of the movement of the track cam on capsule feeder 2 is entered here.

Parameters 155 / 156 (track cam movement) must not exceed the idle and switching time (parameters 3 + 4) of the machine.

Version: 1.2
Datum: 19.02.2018

163 Vertical conveying deduster run-on
Vertical conveying deduster run-on

s

Vertical conveying deduster run-on in seconds

A run-on time is entered here for the vertical conveying deduster.

If the vertical conveying deduster is in automatic mode, it will continue to run on for this time after the machine is stopped (red button).

If no time is entered, the vertical conveying deduster will run on for 10 s.

Version: 1.1
Datum: 11.05.2017

164 Extraction run-on
Extraction run-on

s

Extraction run-on in seconds

A run-on time is entered here for the extraction unit.

If the extraction unit is in automatic mode, it will continue to run on for this time after the machine has changed into computer or test run.

If no time is entered, the extraction unit will run on for 60s.

Version: 1.0
Datum: 05.04.2019

170 Switch off gate monitoring
Switch off gate monitoring

Switch off gate monitoring

Monitoring of the sample and discharge gates is switched off here.

If a gate is deactivated, no diagnosis is displayed when the gate does not switch correctly.

Input:

0 : Monitoring of sample and discharge gates active

1 : Monitoring of sample gate deactivated

2 : Monitoring of discharge gate deactivated

3 : Monitoring of sample and discharge gates deactivated

Version: 1.2
Datum: 19.03.2019

173 External remote control
External remote control (line operation)

(0-7)

External remote control (line operation)

The run modes in which the external remote control (line operation) is active are entered here.

There are up to two remote control circuits. There is normally a packaging line connected to the 1st remote control circuit.

The 2nd remote control circuit is not yet defined.

The remote control circuits switched on and off via the set value of parameter 173.

If both remote control circuits are in use, it is the 1st remote control circuit that is controlled first. If the 1st circuit sends a start signal, the second remote control circuit is automatically activated.

The capsule filling machine does not start until the 2nd remote control circuit also sends a start signal.

If one of the two start signals drops out, the capsule filling machine stops with diagnosis 5027 “Interruption by external controller”.

0 : Remote control OFF

1 : Remote control circuit 1 active in all run modes

2 : Remote control circuit 1 active only in standard run mode

3 : Remote control circuit 2 active in all run modes

4 : Remote control 2 active only in standard run mode

5 : Remote control circuit 1 and 2 active in all run modes

6 : Remote control circuit 1 and 2 active only in standard run mode

7 : Remote control circuit 1 and 2 active only in standard run mode; remote control circuit 2 only active in setup run mode

Version: 1.1
Datum: 11.05.2017

176 Lubrication interval warning limit
Lubrication interval warning limit

%

Lubrication interval warning limit as a percentage

A warning limit for the lubrication intervals at which a warning diagnosis appears is entered here.

It is entered as a percentage and is converted into hours / days.

Example: If the operator enters “80”, a warning diagnosis will be triggered as soon as 80% of the time to the next lubrication time has elapsed.

The warning diagnosis disappears when the lubrication is confirmed.

Version: 1.1
Datum: 10.05.2017

192 Stop timer for start rejection
Stop timer for start rejection

min

Stop timer for start rejection in minutes

A machine standstill stop timer after which the start rejection is activated is entered here.

This function delays good production after the machine has been at a standstill for too long.

Parameter 192 defines a stop timer and parameter 193 defines a number of capsules.

The stop timer starts running if the machine is stopped. When the machine starts after the stop timer has elapsed, the discharge gate is held in the reject position until the number of capsules defined in parameter 193 has been produced.

The remaining runtime of the timer appears in the actual value field of parameter 192. The actual field for parameter 193 shows the number of capsules previously rejected by this function since the machine started.

If there is a stop timer still running, pressing function key F12 for a quick start will not restart the timer - it will continue to run.

The stop timer will not restart until the machine has been running for at least 10 seconds.

Only active with option 01.100/834.

Version: 1.1
Datum: 19.03.2019

193 Number of capsules for start rejection
Number of capsules for start rejection

Qty

Number of capsules for start rejection as a quantity

A number of capsules after which the good production starts is entered here.

This function delays good production after the machine has been at a standstill for too long.

Parameter 192 defines a stop timer and parameter 193 defines a number of capsules.

The stop timer starts running if the machine is stopped. When the machine starts after the stop timer has elapsed, the discharge gate is held in the reject position until the number of capsules defined in parameter 193 has been produced.

The remaining runtime of the timer appears in the actual value field of parameter 192. The actual field for parameter 193 shows the number of capsules previously rejected by this function since the machine started.

If there is a stop timer still running, pressing function key F12 for a quick start will not restart the timer - it will continue to run.

The stop timer will not restart until the machine has been running for at least 10 seconds.

Only active with option 01.100/834.

Version: 1.1
Datum: 19.03.2019

198 Vacuum flap angle
Vacuum flap angle

°

Vacuum flap angle in degrees

The angle of the vacuum flap is entered here.

Up to two vacuum flaps are installed in the machine.

If this parameter is set, the vacuum flap is set to this angle, regardless of the current vacuum and set value for parameter 49.

If there is no set value for parameter 198, the vacuum flap is set automatically so that the vacuum is continuously regulated according to the set value for parameter 49.

Version: 1.2
Datum: 11.05.2017

207 Fixed cycle rates capsule feeder
Fixed cycle rates capsule feeder

Fixed cycle rates can be entered here. These cycle rates serve as a reference number for calculating the motions of the capsule feeder.

The motion duration of the corresponding drives then corresponds to the saved travel times of the specified reference cycle rate and is independent of the rotary disk cycle.

At a value of 0, there is no such reference cycle rate and the corresponding motion duration is calculated dynamically depending on the rotary disk cycle.

Version: 1.0
Datum: 07.01.2019

208 Fixed cycle rates closing station
Fixed cycle rates closing station

Fixed cycle rates can be entered here. These cycle rates serve as a reference number for calculating the motions of the closing station.

The motion duration of the corresponding drives then corresponds to the saved travel times of the specified reference cycle rate and is independent of the rotary disk cycle.

At a value of 0, there is no such reference cycle rate and the corresponding motion duration is calculated dynamically depending on the rotary disk cycle.

Version: 1.0
Datum: 07.01.2019

209 Fixed cycle rates dosing disk
Fixed cycle rates dosing disk

Fixed cycle rates can be entered here. These cycle rates serve as a reference number for calculating the motions of the dosing disk of the tamping station.

The motion duration of the corresponding drives then corresponds to the saved travel times of the specified reference cycle rate and is independent of the rotary disk cycle.

At a value of 0, there is no such reference cycle rate and the corresponding motion duration is calculated dynamically depending on the rotary disk cycle.

Version: 1.0
Datum: 07.01.2019

210 Fixed cycle rates tamping pins
Fixed cycle rates tamping pins

Fixed cycle rates can be entered here. These cycle rates serve as a reference number for calculating the motions of the tamping pins.

The motion duration of the corresponding drives then corresponds to the saved travel times of the specified reference cycle rate and is independent of the rotary disk cycle.

At a value of 0, there is no such reference cycle rate and the corresponding motion duration is calculated dynamically depending on the rotary disk cycle.

Version: 1.0
Datum: 07.01.2019

211 Fixed cycle rates pellet station 1
Fixed cycle rates pellet station 1

Fixed cycle rates can be entered here. These cycle rates serve as a reference number for calculating the motions of the horizontal slide of the first pellet station.

The motion duration of the corresponding drives then corresponds to the saved travel times of the specified reference cycle rate and is independent of the rotary disk cycle.

At a value of 0, there is no such reference cycle rate and the corresponding motion duration is calculated dynamically depending on the rotary disk cycle.

Version: 1.0
Datum: 07.01.2019

212 Fixed cycle rates pellet station 1
Fixed cycle rates pellet station 1

Fixed cycle rates can be entered here. These cycle rates serve as a reference number for calculating the motions of the horizontal slide of the second pellet station.

The motion duration of the corresponding drives then corresponds to the saved travel times of the specified reference cycle rate and is independent of the rotary disk cycle.

At a value of 0, there is no such reference cycle rate and the corresponding motion duration is calculated dynamically depending on the rotary disk cycle.

Version: 1.0
Datum: 07.01.2019

213 Fixed cycle rates pellet station 3
Fixed cycle rates pellet station 3

Fixed cycle rates can be entered here. These cycle rates serve as a reference number for calculating the motions of the horizontal slide of the third pellet station.

The motion duration of the corresponding drives then corresponds to the saved travel times of the specified reference cycle rate and is independent of the rotary disk cycle.

At a value of 0, there is no such reference cycle rate and the corresponding motion duration is calculated dynamically depending on the rotary disk cycle.

Version: 1.0
Datum: 07.01.2019

214 Fixed cycle rates pellet station 4
Fixed cycle rates pellet station 4

Fixed cycle rates can be entered here. These cycle rates serve as a reference number for calculating the motions of the horizontal slide of the first pellet station.

The motion duration of the corresponding drives then corresponds to the saved travel times of the specified reference cycle rate and is independent of the rotary disk cycle.

At a value of 0, there is no such reference cycle rate and the corresponding motion duration is calculated dynamically depending on the rotary disk cycle.

Version: 1.0
Datum: 07.01.2019

218 Throughput time capsule conveyor
Throughput time capsule conveyor

s

The throughput time of a connected capsule conveyor can be entered here in seconds.

Pending samples are delayed by at least the time entered in this parameter after the start of the machine. Other factors such as a recent batch change may delay the sample procedure even further.

Only active with option 08.500/519 "Sample delay due to throughput time of capsule conveyor" with K1.

Version: 1.0
Datum: 19.03.2019

229 Vacuum row 1, start
Vacuum row 1, start

ms

Starting time for vacuum row 1 in milliseconds

The time at which the vacuum hold time starts for separating the first row of empty capsules is entered here.

Parameters 229 - 232 must not exceed the idle and switching time (parameters 3 + 4) and must be matched to the movements of the suction pads.

Version: 1.3
Datum: 11.05.2017

230 Vacuum row 1, duration
Vacuum row 1, duration

ms

Duration of vacuum row 1 in milliseconds

The duration of the vacuum hold time for separating the first row of empty capsules is entered here.

Parameters 229 - 232 must not exceed the idle and switching time (parameters 3 + 4) and must be matched to the movements of the suction pads.

Version: 1.3
Datum: 11.05.2017

231 Vacuum, start
Vacuum, start

ms

Vacuum starting time in milliseconds

The time at which the vacuum hold time starts for separating the empty capsules is entered here.

Parameters 231 / 232 must not exceed the idle and switching time (parameters 3 + 4) and must be matched to the movements of the vacuum pads.

Version: 1.3
Datum: 11.05.2017

231 Vacuum row 2, start
Vacuum row 2, start

ms

Starting time for vacuum row 2 in milliseconds

The time at which the vacuum hold time starts for separating the second row of empty capsules is entered here.

Parameters 231 / 232 must not exceed the idle and switching time (parameters 3 + 4) and must be matched to the movements of the vacuum pads.

Version: 1.3
Datum: 11.05.2017

231 Vacuum row 2, start
Vacuum row 2, start

ms

Starting time for vacuum row 2 in milliseconds

The time at which the vacuum hold time starts for separating the second row of empty capsules is entered here.

Parameters 231 / 232 must not exceed the idle and switching time (parameters 3 + 4) and must be matched to the movements of the vacuum pads.

Version: 1.3
Datum: 11.05.2017

232 Vacuum, duration
Vacuum, duration

ms

Vacuum duration in milliseconds

This specifies the duration of the vacuum hold time for separating the empty capsules.

Parameters 231 / 232 must not exceed the idle and switching time (parameters 3 + 4) and must be matched to the movements of the vacuum pads.

Version: 1.3
Datum: 11.05.2017

232 Vacuum row 2, duration
Vacuum row 2, duration

ms

Duration of vacuum row 2 in milliseconds

The duration of the vacuum hold time for separating the second row of empty capsules is entered here.

Parameters 231 / 232 must not exceed the idle and switching time (parameters 3 + 4) and must be matched to the movements of the vacuum pads.

Version: 1.3
Datum: 11.05.2017

232 Vacuum row 2, duration
Vacuum row 2, duration

ms

Duration of vacuum row 2 in milliseconds

The duration of the vacuum hold time for separating the second row of empty capsules is entered here.

Parameters 231 / 232 must not exceed the idle and switching time (parameters 3 + 4) and must be matched to the movements of the vacuum pads.

Version: 1.3
Datum: 11.05.2017

240 Machine layout
Machine layout

The machine layout is entered here.

The machine can only be started, if the switching of the individual stations does not contradict the set machine layout.

0 : Default = Single rotary machine

Version: 1.1
Datum: 19.02.2018

240 Machine layout
Machine layout

The machine layout is entered here.

The machine can only be started if the switching of the individual stations does not contradict the set machine layout.

0 : Default = Single rotary machine

Version: 1.1
Datum: 19.02.2018

240 Machine layout
Machine layout

The machine layout is entered here.

The machine can only be started if the switching of the individual stations does not contradict the set machine layout.

0 : Default = double rotary machine

1 : Single rotary machine; side A only

2 : Single rotary machine; side B only

12 : Single rotary machine; A after B

21 : Single rotary machine; B after A

Version: 1.2
Datum: 11.05.2017

250 Config. compact. station
Configuration compacting station

The powder bed height can be detected by different sensors. The installed sensor can be configured here.

0 : Laser sensor at the head piece of the machine (analogue value)

1 : Capacitve sensor at the dosing disk (digital value)

Version:
Datum: 20.02.2018

251 Tamping force - left drive
Tamping force - left drive

kN

Tamping force in kilonewton

The tamping force is shown here in kilonewton.

The tamping force of the tamping pins is not measured exactly, but determined via a current measurement in kilonewton. This measurement can be influenced by speed changes or traverse motions of the drives without affecting the actual tamping force.

Version: 1.0
Datum: 09.01.2019

252 Tamping force - right drive
Tamping force - right drive

kN

Tamping force in kilonewton

The tamping force is shown here in kilonewton.

The tamping force of the tamping pins is not measured exactly, but determined via a current measurement in kilonewton. This measurement can be influenced by speed changes or traverse motions of the drives without affecting the actual tamping force.

Version: 1.0
Datum: 09.01.2019

253 Powder bed height
Powder bed height

mm

Powder bed height in millimeters

The height of the powder bed in the compacting station in millimeters is entered here.

The minimum and maximum powder bed heights are monitored.

If the minimum or maximum level is violated in standard run mode, this triggers a stop diagnosis; in all other run modes a warning diagnosis is triggered.

The following formula applies to the tamping pin stroke:

H = a + b + c - e

where:

H ... Tamping pin stroke

a ... Height of the dosing disk (parameter 256)

b ... Height of the powder bed (parameter 253)

c ... Upward stroke from powder bed (parameter 257)

e ... Minimum spring setting (parameter 273)

The tamping pin stroke must not exceed the maximum of 53 mm.

Version: 1.3
Datum: 11.05.2017

254 Minimum powder bed height
Minimum powder bed height

mm

Minimum powder bed height in millimeters

The minimum height of the powder bed in the compacting station in millimeters is entered here.

If the minimum level is not reached in standard run mode, this triggers a stop diagnosis; in all other run modes a warning diagnosis is triggered.

Version: 1.2
Datum: 11.05.2017

255 Maximum powder bed height
Maximum powder bed height

mm

Maximum powder bed height in millimeters

The maximum height of the powder bed in the compacting station in millimeters is entered here.

If the maximum level is exceeded in standard run mode, this triggers a stop diagnosis; in all other run modes a warning diagnosis is triggered.

Version: 1.2
Datum: 11.05.2017

256 Dosing disk height
Dosing disk height

mm

Dosing disk height in millimeters

The height of the dosing disk is entered here.

If option 06.130/920 (RFID format-specific part recognition) is active, the detected dosing disk is displayed in the actual value.

If the set value and actual value do not tally, the machine cannot be started and a diagnosis appears.

If the machine does not have an RFID system, the actual value of this parameter remains set to 0.

The following formula applies to the tamping pin stroke:

H = a + b + c - e

where:

H ... Tamping pin stroke

a ... Height of the dosing disk (parameter 256)

b ... Height of the powder bed (parameter 253)

c ... Upward stroke from powder bed (parameter 257)

e ... Minimum spring setting (parameter 273)

The tamping pin stroke must not exceed the maximum of 53 mm.

Version: 1.3
Datum: 11.05.2017

257 Upward stroke from powder bed
Upward stroke from powder bed

mm

Upward stroke from powder bed in millimeters

The upward stroke of the rejection pins from the powder bed is entered here.

The following formula applies to the tamping pin stroke:

H = a + b + c - e

where:

H ... Tamping pin stroke

a ... Height of the dosing disk (parameter 256)

b ... Height of the powder bed (parameter 253)

c ... Upward stroke from powder bed (parameter 257)

e ... Minimum spring setting (parameter 273)

The tamping pin stroke must not exceed the maximum of 53 mm. The maximum for parameter 257 (upward stroke from powder bed) is therefore determined dynamically.

The following formula applies to the maximum for parameter 257 (upward stroke from powder bed):

c = H - a - b + e

If the powder bed height (b) is to be increased and this would exceed the maximum stroke of the tamping pins, parameter 257 “Upward stroke from powder bed” (c) must be reduced.

Version: 1.2
Datum: 28.04.2017

258 Tamping pin stroke offset +/-
Tamping pin stroke offset +/-

mm

Tamping pin stroke offset +/- in millimeters

An offset for the stroke of the tamping pins in millimeters is entered here.

A positive value means that the tamping pins move deeper into the dosing disk. The dosing volume increases.

A negative value means that the tamping pins move less deeply into the dosing disk. The dosing volume decreases.

If option "500_600_700_800/252" (Weight control) is active, then the Weightmaster uses this parameter for the “in-process control”.

In this case, the parameter should not be used to manually fine-tune the dosing volume.

An offset of 1 millimeter roughly corresponds to a change in compression force of 10 Newton.

Version: 1.4
Datum: 19.03.2019

259 Dosing disk moment of inertia
Dosing disk moment of inertia

kgcm²

Moment of inertia of the dosing disk in kgcm²

The moment of inertia of the dosing disk is entered here.

This parameter should only be changed by a service engineer.

The moment of inertia is used to control movement of the dosing disk. The value “0” means that the moment of inertia stored in the ECC is set.

Changing the moment of inertia will also change the control response of the dosing disk movement.

Version: 1.1

Datum: 12.05.2017

260 Dosing disk
Dosing disk

Type

Dosing disk

The type of dosing disk is entered here.

The installed dosing disk is selected from the list below. A dosing disk is always designed for a specific capsule class (cc).

If option 06.130/920 (RFID format-specific part recognition) is active, the detected dosing disk is displayed in the actual value.

The letter "S" stands for static dosing disks and letter "V" for variable, i.e. height-adjustable dosing disks.

If the set value and actual value do not tally, the capsule filling machine cannot be started and a diagnosis appears.

If the machine does not have a RFID system, the actual value of this parameter remains set to "0".

12 : S Dosing disk cl. 000

22 : S Dosing disk cl. 00

32 : S Dosing disk cl. 0

42 : S Dosing disk cl. 1

52 : S Dosing disk cl. 2

62 : S Dosing disk cl. 3

72 : S Dosing disk cl. 4

82 : S Dosing disk cl. 5

92 : S Dosing disk cl. 00 el

102 :S Dosing disk cl. 0 el

112 :S Dosing disk cl. 0 el*

122 :S Dosing disk cl. 1 el

132 :S Dosing disk cl. 2 el

142 :S Dosing disk cl. 4 el

152 :S Dosing disk cl. AAA

162 :S Dosing disk cl. AA el

172 :S Dosing disk cl. AA

182 :S Dosing disk cl. A

192 :S Dosing disk cl B

202 :S Dosing disk cl. C

212 :S Dosing disk cl. D

222 :S Dosing disk cl. E

1012 :V Dosing disk cl. 000

1022 :V Dosing disk cl. 00

1032 :V Dosing disk cl. 0

1042 :V Dosing disk cl. 1

1052 :V Dosing disk cl. 2

1062 :V Dosing disk cl. 3

1072 :V Dosing disk cl. 4

1082 :V Dosing disk cl. 5

1092 :V Dosing disk cl. 00 el

1102 :V Dosing disk cl. 0 el

1112 :V Dosing disk cl. 0 el*

1122 :V Dosing disk cl. 1 el

1132 :V Dosing disk cl. 2 el

1142 :V Dosing disk cl. 4 el

1152 :V Dosing disk cl. AAA

1162 :V Dosing disk cl. AA el

1172 :V Dosing disk cl. AA

1182 :V Dosing disk cl. A

1192 :V Dosing disk cl. B

1202 :V Dosing disk cl. C

1212 :V Dosing disk cl. D

1222 :V Dosing disk cl. E

Version: 1.4
Datum: 01.04.2019

261 Transfer port speed
Transfer port speed

1/min

Transfer port speed

The rotation speed of the port drive of the compacting station in RPM is entered here.

This value must be optimised by trial and error to suit the material properties and atmospheric humidity.

If there is no set value for parameter 261, the rotation speed is set automatically. The powder bed is constantly regulated according to the value set for parameter 253.

If the machine is set to manual operation, this parameter does not have any effect, the speed of the port drive is set to a defined value.

Version: 1.2
Datum: 19.02.2018

262 Dosing disk, starting time of 60° rotation
Dosing disk, starting time of 60° rotation

ms

Dosing disk, starting time of 60° rotation in milliseconds

The starting time for the 60° rotation of the dosing disk at the compacting station is entered here.

The input limits for parameters 262 and 263 are determined by the switching time (parameter 4).

Version: 1.1
Datum: 12.05.2017

263 Dosing disk, duration of 60° rotation
Dosing disk, duration of 60° rotation

ms

Dosing disk, duration of 60° rotation in milliseconds

The duration the 60° rotation of the dosing disk at the compacting station is entered here.

The input limits for parameters 262 and 263 are determined by the switching time (parameter 4).

Version: 1.1
Datum: 12.05.2017

264 Tamping pins, starting time for downward movement
Tamping pins, starting time for downward movement

ms

Tamping pins, starting time for downward movement in milliseconds

The starting time of the penetration time (downward movement) of the tamping pins is entered here.

The input limits for parameters 264 and 265 are determined by the idle time (parameter 3).

The pressure duration of the tamping pins (parameter 268) is determined by the pause in movement between the “Penetration and emergence time".

Version: 1.1
Datum: 12.05.2017

265 Tamping pins, duration of downward movement
Tamping pins, duration of downward movement

ms

Tamping pins, duration of downward movement in milliseconds

The duration of the penetration time (downward movement) of the tamping pins is entered here.

The input limits for parameters 264 and 265 are determined by the idle time (parameter 3).

The pressure duration of the tamping pins (parameter 268) is determined by the pause in movement between the “Penetration and emergence time".

Version: 1.1
Datum: 12.05.2017

266 Tamping pins, starting time for upward movement
Tamping pins, starting time for upward movement

ms

Tamping pins, starting time for upward movement in milliseconds

The starting time of the emergence time (upward movement) of the tamping pins is entered here.

The input limits for parameters 266 and 267 are determined by the switching time (parameter 4).

The pressure duration of the tamping pins (parameter 268) is determined by the pause in movement between the “Penetration and emergence time".

Version: 1.1
Datum: 12.05.2017

267 Tamping pins, duration of upward movement
Tamping pins, duration of upward movement

ms

Tamping pins, duration of upward movement in milliseconds

The duration of the emergence time (upward movement) of the tamping pins is entered here.

The input limits for parameters 266 and 267 are determined by the switching time (parameter 4).

The pressure duration of the tamping pins (parameter 268) is determined by the pause in movement between the “Penetration and emergence time".

Version: 1.1
Datum: 12.05.2017

268 Pressure duration
Pressure duration

ms

Pressure duration of the tamping pins in milliseconds

The pressure duration time for the tamping pins is entered here.

This value is retained even if the automatic calculation (Intellimatik) changes the idle and switching time.

Version: 1.1
Datum: 12.05.2017

269 Tamping force - both drives
Tamping force - both drives

kN

Tamping force in kilonewton

The tamping force is shown here in kilonewton.

The tamping force of the tamping pins is not measured exactly, but determined via a current measurement in kilonewton. This measurement can be influenced by speed changes or traverse motions of the drives without affecting the actual tamping force.

Version: 1.3
Datum: 09.01.2019

270 Avoid powder bed
Avoid powder bed

Switches plowing through the powder bed on / off

The (permissible) plowing through of the powder bed is switched on and off here.

A value of “0” means that the powder bed may be plowed through by the tamping pins during the movement of the dosing disk. The recipe check does not output a collision warning. The powder bed is ignored in the Intellimatik travel time calculation.

A value of “1” means that the powder bed must no be plowed through by the tamping pins during the movement of the dosing disk. The recipe check outputs a warning diagnosis in the event of a powder bed collision.

0 : No collision relevance

1 : Collision relevance set

Version: 1.2
Datum: 19.02.2018

271 Dosing disk KP
Dosing disk KP

Speed control proportional gain (KP) of the dosing disk

The speed control proportional gain (KP) of the dosing disk is entered here.

The proportional gain (KP) is used to control movement of the dosing disk. The value “0” means that the proportional gain stored in the ECC is set.

Changing the proportional gain will also change the control response of the dosing disk movement.

Version: 1.1
Datum: 12.05.2017

272 Dosing disk KV
Dosing disk KV

Position control gain factor (KV) for the dosing disk.

The position control gain factor (KV) for the dosing disk is entered here.

The gain factor (KV) is used to control movement of the dosing disk. The value “0” means that the gain factor stored in the ECC is set.

Changing the gain factor will also change the control response of the dosing disk movement.

Version: 1.1
Datum: 12.05.2017

273 Spring adjustment tamping pin block 1
Spring adjustment for tamping pin block 1

mm

Spring adjustment for tamping pin block 1 in millimeters

The spring adjustment for tamping pin block 1 (set using the adjusting screw) is entered here in millimeters.

The first tamping pin block normally penetrates deepest and should therefore have the smallest spring adjustment value.

The lower the spring adjustment value, the deeper the tamping pin block is lowered into the dosing disk. Attention: Risk of collision!

The following formula applies to the tamping pin stroke:

H = a + b + c - e

where:

H ... Tamping pin stroke

a ... Height of the dosing disk (parameter 256)

b ... Height of the powder bed (parameter 253)

c ... Upward stroke from powder bed (parameter 257)

e ... Minimum spring adjustment (parameter 273)

The tamping pin stroke must not exceed the maximum of 53 mm.

Version: 1.4

Datum: 10.04.2018

274 Spring adjustment tamping pin block 2
Spring adjustment for tamping pin block 2

mm

Spring adjustment for tamping pin block 2 in millimeters

The spring adjustment for tamping pin block 2 (set using the adjusting screw) is entered here in millimeters.

The lower the spring adjustment value, the deeper the tamping pin block is lowered into the dosing disk. Attention: Risk of collision!

Version: 1.4
Datum: 10.04.2018

275 Spring adjustment tamping pin block 3
Spring adjustment for tamping pin block 3

mm

Spring adjustment for tamping pin block 3 in millimeters

The spring adjustment for tamping pin block 3 (set using the adjusting screw) is entered here in millimeters.

The lower the spring adjustment value, the deeper the tamping pin block is lowered into the dosing disk. Attention: Risk of collision!

Version: 1.4
Datum: 10.04.2018

276 Spring adjustment tamping pin block 4
Spring adjustment for tamping pin block 4

mm

Spring adjustment for tamping pin block 4 in millimeters

The spring adjustment for tamping pin block 4 (set using the adjusting screw) is entered here in millimeters.

The lower the spring adjustment value, the deeper the tamping pin block is lowered into the dosing disk. Attention: Risk of collision!

Version: 1.4
Datum: 10.04.2018

277 Spring adjustment tamping pin block 5
Spring adjustment for tamping pin block 5

mm

Spring adjustment for tamping pin block 5 in millimeters

The spring adjustment for tamping pin block 5 (set using the adjusting screw) is entered here in millimeters.

The lower the spring adjustment value, the deeper the tamping pin block is lowered into the dosing disk. Attention: Risk of collision!

Version: 1.4
Datum: 10.04.2018

278 Spring type
Spring type

Type

Spring type [1-2] at pin block 1-5

The tamping pin spring type at the compacting station is entered here.

Exceeding the permissible maximum force can damage the springs.

The value range of the spring types refers to a punch. The maximum force is calculated by multiplying the value by 24 (punches) und 5 (pin blocks) respectively.

Example: Maximum force spring type 1:

152N * 24 * 5 = 18,24kN

1 : Spring type 1 : 28 - 152 N

2 : Spring type 2 : 13 - 108 N

3 : Spring type 3 : 11 - 190 N

Version: 1.2
Datum: 19.03.2019

280 Vibr. pow. hop. Vib. time
Vibrator powder hopper: Vibration time

ms

This parameter defines the switch-on time of the vibrator at the powder hopper.

If the set time exceeds the full cycle time, the vibrator is still deactivated at the end of the cycle time.

The interval for the control can be set via parameter 281.

Version: 1.0
Datum: 20.02.2018

281 Vibr. pow. hop. Interval
Vibrator powder hopper: Interval

Cycles

The interval for the control of the vibrator is entered here in cycles.

The vibrator is activated for the time span set via parameter 280.

0 = Function is deactivated

1 = The vibrator is activated for each cycle

2 = The vibrator is activated for every 2nd cycle

3 = The vibrator is activated for every 3rd cycle

etc.

Version: 1.0
Datum: 20.02.2018

282 Back left compacting ring adjustment
Back left compacting ring adjustment

mm

Back left compacting ring adjustment in millimeters

The adjustment of the back left compacting ring (viewed from the operator side) is entered here.

The set value describes the gap between the dosing disk and compacting disk.

This is a mechanical adjustment; it is saved in the recipe as a reference value.

Version: 1.1
Datum: 12.05.2017

283 Front left compacting ring adjustment
Front left compacting ring adjustment

mm

Front left compacting ring adjustment in millimeters

The adjustment of the front left compacting ring (viewed from the operator side) is entered here.

The set value describes the gap between the dosing disk and compacting disk.

This is a mechanical adjustment; it is saved in the recipe as a reference value.

Version: 1.1
Datum: 12.05.2017

284 Adjustment of compacting ring at front right
Adjustment of compacting ring at front right

mm

Adjustment of compacting ring at front right in millimeters

The adjustment of the front right compacting ring (viewed from the operator side) is entered here.

The set value describes the gap between the dosing disk and compacting disk.

This is a mechanical adjustment; it is saved in the recipe as a reference value.

Version: 1.1
Datum: 12.05.2017

285 Adjustment of compacting ring at back right
Adjustment of compacting ring at back right

mm

Adjustment of compacting ring at back right in millimeters

The adjustment of the back right compacting ring (viewed from the operator side) is entered here.

The set value describes the gap between the dosing disk and compacting disk.

This is a mechanical adjustment; it is saved in the recipe as a reference value.

Version: 1.1
Datum: 12.05.2017

286 Extraction slider for tamping
Extraction slider for tamping

mm

Extraction slider for tamping station in millimeters

The value set for the mechanical slider of the extraction unit at the tamping station is entered here.

The extraction volume at the compacting station is controlled by two radial slides.

These two slides should be set to identical values on the scale as the extraction opening

is located exactly in the middle between the air venting openings.

The scale end value "0" indicates completely closed air venting openings in the extraction system.

The scale end value “25” indicates completely open air venting openings.

This is a mechanical adjustment; it is saved in the recipe as a reference value.

Version: 1.2
Datum: 02.08.2018

287 Reg. metering drum: Kp
Regulation metering drum: Kp

This parameter is used to alter the regulation behaviour (proportional part) of the metering drum.

If this value is increased, the regulation becomes quicker or rather more dynamic.

If this value is decreased, the regulation becomes slower or rather more idle.

Version: 1.0
Datum: 20.02.2018

288 Reg. metering drum: Ki
Regulation metering drum: Ki

This parameter is used to alter the regulation behaviour (integral part) of the metering drum.

If this value is increased, the regulation becomes quicker or rather more dynamic.

If this value is decreased, the regulation becomes slower or rather more idle.

Version: 1.0
Datum: 20.02.2018

289 Max. speed metering drum

Regulation metering drum: Maximum speed

1/min

This parameter defines the maximum speed of the metering drum.

The speed limitation is only active, if the metering drum is in automatic mode. Therefore, parameter 261 must be set to "0".

Version: 1.2
Datum: 07.01.2019

290 Run-on time metering drum
Regulation metering drum: Run-on time

s

This parameter defines the run-on time of the metering drum.

The run-on time is solely active, if the capacitive sensor for the powder bed control is installed and configured via parameter 250. The run-on time starts as soon as the powder bed has reached a pre-defined height and the sensor thus starts detecting the powder bed. The metering drum is stopped as soon as the defined run-on time has expired.

Version: 1.2
Datum: 13.04.2018

291 Control metering drum: starting speed
Control metering drum: starting speed

1/min

This parameter can be used to define the control response (starting speed) of the metering drum

Version: 1.0
Datum: 01.04.2019

292 Reject function, starting time for upward movement
Reject function, starting time for upward movement

ms

Reject function, starting time for upward movement in milliseconds

The starting time for the upward movement of the rejection pins is entered here.

The accumulated sum of parameters 292 to 295 (upward and downward movement of the rejection pins) should be completed entirely within the idle time (parameter 3).

Version: 1.1
Datum: 15.05.2017

293 Reject function, duration of upward movement
Reject function, duration of upward movement

ms

Reject function, duration of upward movement in milliseconds

The duration of the upward movement of the rejection pins is entered here.

The accumulated sum of parameters 292 to 295 (upward and downward movement of the rejection pins) should be completed entirely within the idle time (parameter 3).

Version: 1.1
Datum: 15.05.2017

294 Rejection, starting time for downward movement
Rejection, starting time for downward movement

ms

Rejection, starting time for downward movement in milliseconds

The starting time for the downward movement of the rejection pins is entered here.

The accumulated sum of parameters 292 to 295 (upward and downward movement of the rejection pins) should be completed entirely within the idle time (parameter 3).

Version: 1.1
Datum: 15.05.2017

295 Reject function, duration of downward movement
Reject function, duration of downward movement

ms

Reject function, duration of downward movement in milliseconds

The duration of the downward movement of the rejection pins is entered here.

The accumulated sum of parameters 292 to 295 (upward and downward movement of the rejection pins) should be completed entirely within the idle time (parameter 3).

Version: 1.1
Datum: 15.05.2017

303 Track cam cl start fw mov
Track cam closing, starting time of forward movement

ms

Track cam closing, starting time of forward movement in milliseconds

The starting time of the forward movement of the track cam at the closing station is entered here.

Parameter 303/304 (forward movement of the track cam) must correspond to the up movement of the lower closing pins (parameter 317 + 318).

Version: 1.2
Datum: 20.02.2018

304 Track cam cl dur fw mov
Track cam closing, duration forward movement

ms

Track cam closing, duration of forward movement in milliseconds

The duration of the forward movement of the track cam at the closing station is entered here.

Parameter 303/304 (forward movement of the track cam) must correspond to the up movement of the lower closing pins (parameter 317 + 318).

Version: 1.2
Datum: 20.02.2018

305 Track cam cl start bw mov
Track cam closing, starting time of backward movement

ms

Track cam closing, starting time of backward movement in milliseconds

The starting time of the backward movement of the track cam at the closing station is entered here.

Parameter 305/306 (backward movement of the track cam) must fall completely into the switching time (parameter 4).

Version: 1.2
Datum: 20.02.2018

306 Track cam cl dur bw mov
Track cam closing, duration backward movement

ms

Track cam closing, duration of backward movement in milliseconds

The duration of the backward movement of the track cam at the closing station is entered here.

Parameter 305/306 (backward movement of the track cam) must fall completely into the switching time (parameter 4).

Version: 1.2
Datum: 20.02.2018

312 Starting position for upper closing pins
Starting position for upper closing pins

mm

Starting position for upper closing pins in millimeters

The starting position for the upper closing pins (which differs according to the capsule format) is entered here in millimeters.

Version: 1.0
Datum: 17.05.2017

313 Upper closing pins, starting time for downward movement
Upper closing pins, starting time for downward movement

ms

Upper closing pins, starting time for downward movement in milliseconds

The starting time for the downward movement of the upper closing pins is entered here.

The accumulated sum of parameters 313 to 316 (upward and downward movement of the closing pins) must not exceed the idle and switching time (parameters 3 + 4).

The closing pressure duration (parameter 323) is calculated from the stopped time for the movements of the upper and lower closing pins.

The movements of the upper and lower closing pins (parameters 313 to 320) should be as synchronized as possible.

Version: 1.1
Datum: 15.05.2017

314 Upper closing pins, duration of downward movement
Upper closing pins, duration of downward movement

ms

Upper closing pins, duration of downward movement in milliseconds

The duration of the downward movement of the upper closing pins is entered here.

The accumulated sum of parameters 313 to 316 (upward and downward movement of the closing pins) must not exceed the idle and switching time (parameters 3 + 4).

The closing pressure duration (parameter 323) is calculated from the stopped time for the movements of the upper and lower closing pins.

The movements of the upper and lower closing pins (parameters 313 to 320) should be as synchronised as possible.

Version: 1.1
Datum: 15.05.2017

315 Upper closing pins, starting time for upward movement
Upper closing pins, starting time for upward movement

ms

Upper closing pins, starting time for upward movement in milliseconds

The starting time for the upward movement of the upper closing pins is entered here.

The accumulated sum of parameters 313 to 316 (upward and downward movement of the closing pins) must not exceed the idle and switching time (parameters 3 + 4).

The closing pressure duration (parameter 323) is calculated from the stopped time for the movements of the upper and lower closing pins.

The movements of the upper and lower closing pins (parameters 313 to 320) should be as synchronised as possible.

Version: 1.1
Datum: 15.05.2017

316 Upper closing pins, duration of upward movement
Upper closing pins, duration of upward movement

ms

Upper closing pins, duration of upward movement in milliseconds

The duration of the upward movement of the upper closing pins is entered here.

The accumulated sum of parameters 313 to 316 (upward and downward movement of the closing pins) must not exceed the idle and switching time (parameters 3 + 4).

The closing pressure duration (parameter 323) is calculated from the stopped time for the movements of the upper and lower closing pins.

The movements of the upper and lower closing pins (parameters 313 to 320) should be as synchronised as possible.

Version: 1.1
Datum: 15.05.2017

317 Lower closing pins, starting time for upward movement
Lower closing pins, starting time for upward movement

ms

Lower closing pins, starting time for upward movement in milliseconds

The starting time for the upward movement of the lower closing pins is entered here.

The accumulated sum of parameters 317 to 320 (upward and downward movement of the closing pins) must not exceed the idle and switching time (parameters 3 + 4).

The closing pressure duration (parameter 323) is calculated from the stopped time for the movements of the upper and lower closing pins.

The movements of the upper and lower closing pins (parameters 313 to 320) should be as synchronised as possible.

Version: 1.1
Datum: 15.05.2017

318 Lower closing pins, duration of upward movement
Lower closing pins, duration of upward movement

ms

Lower closing pins, duration of upward movement in milliseconds

The duration of the upward movement of the lower closing pins is entered here.

The accumulated sum of parameters 317 to 320 (upward and downward movement of the closing pins) must not exceed the idle and switching time (parameters 3 + 4).

The closing pressure duration (parameter 323) is calculated from the stopped time for the movements of the upper and lower closing pins.

The movements of the upper and lower closing pins (parameters 313 to 320) should be as synchronised as possible.

Version: 1.1
Datum: 15.05.2017

319 Lower closing pins, starting time for downward movement
Lower closing pins, starting time for downward movement

ms

Lower closing pins, starting time for downward movement in milliseconds

The starting time for the downward movement of the lower closing pins is entered here.

The accumulated sum of parameters 317 to 320 (upward and downward movement of the closing pins) must not exceed the idle and switching time (parameters 3 + 4).

The closing pressure duration (parameter 323) is calculated from the stopped time for the movements of the upper and lower closing pins.

The movements of the upper and lower closing pins (parameters 313 to 320) should be as synchronized as possible.

Version: 1.1
Datum: 15.05.2017

320 Lower closing pins, duration of downward movement
Lower closing pins, duration of downward movement

ms

Lower closing pins, duration of downward movement in milliseconds

The duration of the upward movement of the lower closing pins is entered here.

The accumulated sum of parameters 317 to 320 (upward and downward movement of the closing pins) must not exceed the idle and switching time (parameters 3 + 4).

The closing pressure duration (parameter 323) is calculated from the stopped time for the movements of the upper and lower closing pins.

The movements of the upper and lower closing pins (parameters 313 to 320) should be as synchronized as possible.

Version: 1.1
Datum: 15.05.2017

321 Closing stroke of upper closing pins
Closing stroke of upper closing pins

mm

Closing stroke of upper closing pins in millimeters

The capsule format-specific closing stroke of the upper closing pins in millimeters is entered here.

Version: 1.1
Datum: 15.05.2017

322 Closing stroke of lower closing pins
Closing stroke of lower closing pins

mm

Closing stroke of lower closing pins in millimeters

The capsule format-specific closing stroke of the lower closing pins in millimeters is entered here.

Version: 1.1
Datum: 15.05.2017

323 Closing pressure duration
Closing pressure duration

ms

Closing pressure duration in milliseconds

The closing pressure time at the closing station is entered here.

This value is retained even if the automatic calculation (Intellimatik) changes the idle and switching time.

Version: 1.1
Datum: 15.05.2017

324 Limit for number of non-closed capsules per capsule holder
Tolerance limit for number of non-closed capsules per capsule holder

Qty

Tolerance limit for number of non-closed capsules per capsule holder as a quantity

The tolerance limit for the number of non-closed capsules per capsule holder can be entered here.

If the tolerance limit of a capsule holder is either reached or exceeded, all capsules of the respective holder are ejected via the reject channel.

Example:

Parameter 324 = 2: At a value of 2 or more non-closed capsules outside the tolerance limit, all capsules of the respective capsule holder are ejected via the reject channel.

Parameter 324 = 0: The function is deactivated. Non-closed capsules are ejected via the good channel.

Version: 1.7
Datum: 07.01.2019

325 Total number of non-closed capsules
Total number of non-closed capsules

Qty

Total non-closed capsules as a quantity

The maximum tolerated number of non-closed capsules in relation to the number of capsules indicated in parameter 54 (Per number of capsules) is entered here.

If the specified maximum ratio is exceeded, the machine stops with the corresponding diagnosis.

The check is activated as soon as the number of capsules set in parameter 54 is produced.

Parameter 54 must be configured before the set value can be set.

The value “0” means that this function is deactivated.

Version: 1.1
Datum: 15.05.2017

326 Non-closed capsules in succession per track
Non-closed capsules in succession per track

Qty

Non-closed capsules in succession per track as a quantity

The maximum tolerated number of non-closed capsules in immediate succession per track is entered here.

If the set value is exceeded, the machine is stopped with the corresponding diagnosis.

The value “0” means that this function is deactivated.

Version: 1.2
Datum: 10.04.2018

327 Non-closed capsules per track
Non-closed capsules per track

Qty

Non-closed capsules per track as a quantity

The maximum number of non-closed capsules that can be tolerated per track in relation to the quantity of capsules specified in parameter 54 (per number of capsules) is entered here.

If the specified maximum ratio is exceeded, the machine stops with the corresponding diagnosis.

The check is activated as soon as the number of capsules set in parameter 54 is produced.

Parameter 54 must be configured before the set value can be set.

The value “0” means that this function is deactivated.

Version: 1.1
Datum: 15.05.2017

328 Closing stroke offset +/-
Closing stroke offset +/-

mm

Closing stroke offset +/- in millimeters

An offset for the lower closing pins drive is entered here.

This parameter is used to adjust the closing stroke if the capsules are not closed correctly.

A positive value means that the lower closing pins move higher. The capsule is pushed together more.

A negative value means that the lower closing pins do not move up as far. The capsule is pushed together less.

Version: 1.1
Datum: 15.05.2017

329 Closing pin type
Closing pin type

Closing pin type

The type of closing pin installed is entered here.

The different capsule sizes need special closing pins to ensure that they close the capsules correctly.

Type 1: approx. Ø 6.0 mm for capsule class:

000, 00 el, 00, AAA, AA el, AA, A, B

Type 2: approx. Ø 4.7 mm for capsule class:

0 el, 0, 1 el, 1, 2 el, 2, C, D, E

Type 3: approx. Ø 3.6 mm for capsule class:

3, 4 el, 4, 5

1 : Closing pin type 1

2 : Closing pin type 2

3 : Closing pin type 3

Version: 1.2
Datum: 15.05.2017

330 Control cabinet temperature
Control cabinet temperature

°C

Control cabinet temperature in °C

Displays the current temperature in the control cabinet.

The control cabinet fans are controlled by a two-position controller.

The fans are switched on automatically when the temperature rises above 37°C.

The fans are switched off automatically when the temperature drops below 32°C.

The fans are also switched on when the temperature of the machine computer rises above 47 °C.

The fans are switched off when the temperature of the machine computer drops below 43 °C.

Version: 1.1
Datum: 15.05.2017

331 Power cabinet temperature
Power cabinet temperature

°C

Power cabinet temperature in °C

Displays the current temperature in the power cabinet.

The power cabinet fans are controlled by a two-position controller.

The fans are switched on automatically when the temperature rises above 37°C.

The fans are switched off automatically when the temperature drops below 32°C.

Version: 1.1
Datum: 15.05.2017

333 Total non-closed capsules per batch
Total non-closed capsules per batch

Qty

Total non-closed capsules per batch as a quantity

The maximum number of non-closed capsules that can be tolerated in relation to the quantity of capsules specified in parameter 14 (good production) is entered here.

If the specified quantity of capsules is exceeded, the machine stops with the corresponding diagnosis.

The value “0” means that this function is deactivated.

Version: 1.1
Datum: 15.05.2017

334 Cleaning interval
Cleaning interval

The cleaning interval for the cleaning pulse is entered here.

All capsule holders are cleaned, once the cleaning pulse is given.

At a double rotary machine, each of the two sides gives out a cleaning pulse which is then carried out for only half the capsule holders of the machine.

One cleaning pulse takes an entire rotation of the rotary disk (half a rotation at a double rotary machine).

1 = Cleaning pulse is activated after every cycle

2 = Cleaning pulse is activated after every second cycle

3 = Cleaning pulse is activated after every third cycle

Version: 1.2
Datum: 07.01.2019

335 Cleaning pulse starting time
Cleaning pulse starting time

ms

Cleaning pulse starting time in milliseconds

The starting time for the cleaning pulse at the capsule discharge is entered here.

Version: 1.1
Datum: 15.05.2017

336 Duration of cleaning pulse
Duration of cleaning pulse

ms

Duration of cleaning pulse in milliseconds

The duration of the cleaning pulse at the capsule discharge is entered here.

Version: 1.1
Datum: 15.05.2017

337 Ejecting pins, starting time for upward movement
Ejecting pins, starting time for upward movement

ms

Ejecting pins, starting time for upward movement in milliseconds

The starting time for the upward movement of the ejecting pins is entered here.

The sum of parameters 337 to 340 is limited by the idle time (parameter 3).

Version: 1.1
Datum: 15.05.2017

338 Ejecting pins, duration of upward movement
Ejecting pins, duration of upward movement

ms

Ejecting pins, duration of upward movement in milliseconds

The duration of the upward movement of the ejecting pins is entered here.

The sum of parameters 337 to 340 is limited by the idle time (parameter 3).

Version: 1.1
Datum: 15.05.2017

339 Ejecting pins, starting time for downward movement
Ejecting pins, starting time for downward movement

ms

Ejecting pins, starting time for downward movement in milliseconds

The starting time for the downward movement of the ejecting pins is entered here.

The sum of parameters 337 to 340 is limited by the idle time (parameter 3).

Version: 1.1
Datum: 15.05.2017

340 Ejecting pins, duration of downward movement
Ejecting pins, duration of downward movement

ms

Ejecting pins, duration of downward movement in milliseconds

The duration of the downward movement of the ejecting pins is entered here.

The sum of parameters 337 to 340 is limited by the idle time (parameter 3).

Version: 1.1
Datum: 15.05.2017

341 Ejection flap, starting time for forward movement
Ejection flap, starting time for forward movement

ms

Ejection flap, starting time for forward movement in milliseconds

The starting time for the forward movement of the ejection flap is entered here.

The sum of parameters 341 to 344 is limited by the idle time (parameter 3).

Version: 1.1
Datum: 15.05.2017

342 Ejection flap, duration of forward movement
Ejection flap, duration of forward movement

ms

Ejection flap, duration of forward movement in milliseconds

The duration of the forward movement of the ejection flap is entered here.

The sum of parameters 341 to 344 is limited by the idle time (parameter 3).

Version: 1.1
Datum: 15.05.2017

343 Ejection flap, starting time for backward movement
Ejection flap, starting time for backward movement

ms

Ejection flap, starting time for backward movement in milliseconds

The starting time for the backward movement of the ejection flap is entered here.

The sum of parameters 341 to 344 is limited by the idle time (parameter 3).

Version: 1.1
Datum: 15.05.2017

344 Ejection flap, duration of backward movement in milliseconds
Ejection flap, duration of backward movement in milliseconds

ms

Ejection flap, duration of backward movement in milliseconds

The duration of the backward movement of the ejection flap is entered here.

The sum of parameters 341 to 344 is limited by the idle time (parameter 3).

Version: 1.1
Datum: 15.05.2017

345 Offset of the discharge gate +/-
Offset of the discharge gate +/-

ms

This parameter can be used to adjust the switching time of the discharge gate.

Version: 1.0
Datum: 07.01.2019

346 Offset of the sample gate +/-
Offset of the sample gate +/-

ms

This parameter can be used to adjust the switching time of the sample gate.

Version: 1.1
Datum: 19.03.2019

361 100% scales format number
100% scales format number

100% scales format number

The format to be loaded on the scales is entered here from the list.

The format parameters can only be changed and saved directly on the scales.

Parameter 361 relates to a scales recipe on the Accura.

Version: 1.1
Datum: 15.05.2017

450 Pellet 1: Configuration
Pellet 1: Configuration

Pellet station 1: Configuration

The configuration of pellet station 1 (dosing 1) can be determined here.

0 : -

1 : NMC sensor

Version: 1.1
Datum: 07.01.2019

451 Pellet 1: Filling level
Pellet 1: Filling level

mm

Pellet station 1: Filling level

The filling level of the first pellet station is entered here.

The filling level heights are monitored.

If the set minimum level is not reached in standard run mode, this triggers a stop diagnosis; in all other run modes a warning diagnosis is triggered.

Version: 1.2
Datum: 17.05.2017

452 Pellet 1: Min. filling level
Pellet 1: Min. filling level

mm

Pellet station 1: Minimum filling level

The minimum filling level of the first pellet station is entered here.

If the minimum level is not reached in standard run mode, this triggers a stop diagnosis; in all other run modes a warning diagnosis is triggered.

Version: 1.2
Datum: 17.05.2017

453 Pellet 1: Max. filling level
Pellet 1: Max. filling level

mm

Pellet station 1: Maximum filling level

The maximum filling level of the first pellet station is entered here.

Version: 1.2
Datum: 17.05.2017

454 Pellet 1: Filling slide position
Pellet 1: Filling slide position

mm

Pellet station 1: Filling slide position

The position of the filling slide of the first pellet station is entered here. The filling slide position describes the size of the pellet feeder gap from the storage container into the pellet doser.

Version: 1.1
Datum: 17.05.2017

455 Pellet 1: Filling range
Pellet 1: Filling range

Pellet station 1: Filling range

The filling range of the first pellet station can be determined here. Depending on the desired filling quantity of pellets per capsule, different filling ranges are available.

0 : Filling range 0

1 : Filling range 1

2 : Filling range 2

3 : Filling range 3

4 : Filling range 4

5 : Filling range 5

Version: 1.3
Datum: 07.01.2019

456 Pellet 1: Height adjustment
Pellet 1: Height adjustment

mm

Pellet station 1: Height adjustment

The height adjustment of the first pellet station is entered here. The height adjustment determines the quantity of pellets to be filled in each capsule. If weight control is active (option “08.500_600_700_800/252”), this parameter is used to dynamically adjust dosing in line with weight changes.

Version: 1.1
Datum: 19.03.2019

457 Pellet 1 - Starting time traverse movement
Pellet 1 - Starting time traverse movement

ms

Pellet station 1 - Starting time of traverse movement in milliseconds

This parameter contains the optimal starting time for the traverse movement of the filling slide at the pellet station.

Version: 1.1
Datum: 17.05.2017

458 Pellet 1 - Duration of traverse movement
Pellet 1 - Duration of traverse movement

ms

Pellet station 1 - Duration of traverse movement in milliseconds

This parameter contains the optimal duration of the traverse movement of the filling slide at the pellet station.

Version: 1.1
Datum: 17.05.2017

459 Pellet 1: Vol. adj. mode
Pellet 1: Volume adjustment mode

Pellet station 1: Volume adjustment mode

The mode of the volume adjustment actuator drive for the first pellet station is set here, particularly the mode for reducing the volume. Some pellets may become jammed between the dosing plate and transfer plate when the volume is reduced, thus preventing further operation or resulting in excessive product losses.

Volume adjustment mode is recommended to minimise faults and product losses for these pellets; in this mode the volume adjustment actuator drive only moves for a reduction in volume if the dosing unit drive is moving the dosing unit.

This does not affect the moving of the actuator drive using the hand-held terminal or travel directly to the reference position, park position, lubrication position or cleaning position, and all these movements are executed immediately.

0 : movement-dependent

1 : not movement-dependent

Version: 1.2
Datum: 20.02.2018

460 Pellet 2: Configuration
Pellet 2: Configuration

Pellet station 2: Configuration

The configuration of pellet station 2 (dosing 2) is determined here.

0 : -

1 : NMC sensor

Version: 1.1
Datum: 07.01.2019

461 Pellet 2: Filling level
Pellet 2: Filling level

mm

Pellet station 2: Filling level

The filling level of the second pellet station is entered here.

The filling level heights are monitored.

If the set minimum level is not reached in standard run mode, this triggers a stop diagnosis; in all other run modes a warning diagnosis is triggered.

Version: 1.2
Datum: 17.05.2017

462 Pellet 2: Min. filling level
Pellet 2: Min. filling level

mm

Pellet station 2: Minimum filling level

The minimum filling level of the second pellet station is entered here.

If the minimum level is not reached in standard run mode, this triggers a stop diagnosis; in all other run modes a warning diagnosis is triggered.

Version: 1.2
Datum: 17.05.2017

463 Pellet 2: Max. filling level
Pellet 2: Max. filling level

mm

Pellet station 2: Maximum filling level

The maximum filling level of the second pellet station is entered here.

Version: 1.2
Datum: 17.05.2017

464 Pellet 2: Filling slide position
Pellet 2: Filling slide position

mm

Pellet station 2: Filling slide position

The position of the filling slide at the second pellet station is entered here. The filling slide position describes the size of the pellet feeder gap from the storage container into the pellet doser.

Version: 1.1
Datum: 17.05.2017

465 Pellet 2: Filling range
Pellet 2: Filling range

Pellet station 2: Filling range

The filling range of the second pellet station can be determined here. Depending on the desired filling quantity of pellets per capsule, different filling ranges are available.

0 : Filling range 0

1 : Filling range 1

2 : Filling range 2

3 : Filling range 3

4 : Filling range 4

5 : Filling range 5

Version: 1.3
Datum: 07.01.2019

466 Pellet 2: Height adjustment
Pellet 2: Height adjustment

mm

Pellet station 2: Height adjustment

The height adjustment of the second pellet station is entered here. The height adjustment determines the quantity of pellets to be filled in each capsule. If weight control is active (option “08.500_600_700_800/252”), this parameter is used to dynamically adjust dosing in line with weight changes.

Version: 1.1
Datum: 19.03.2019

467 Pellet 2 - Starting time traverse movement
Pellet 2 - Starting time traverse movement

ms

Pellet station 2 - Starting time of traverse movement in milliseconds

This parameter contains the optimal starting time for the traverse movement of the filling slide at the pellet station.

Version: 1.1
Datum: 17.05.2017

468 Pellet 2 - Duration of traverse movement
Pellet 2 - Duration of traverse movement

ms

Pellet station 2 - Duration of traverse movement in milliseconds

This parameter contains the optimal duration of the traverse movement of the filling slide at the pellet station.

Version: 1.1
Datum: 17.05.2017

469 Pellet 2: Vol. adj. mode
Pellet 2: Volume adjustment mode

Pellet station 2: Volume adjustment mode

The mode of the volume adjustment actuator drive for the second pellet station is set here, particularly the mode for reducing the volume. Some pellets may become jammed between the dosing plate and transfer plate when the volume is reduced, thus preventing further operation or resulting in excessive product losses.

Volume adjustment mode is recommended to minimise faults and product losses for these pellets; in this mode the volume adjustment actuator drive only moves for a reduction in volume if the dosing unit drive is moving the dosing unit.

This does not affect the moving of the actuator drive using the hand-held terminal or travel directly to the reference position, park position, lubrication position or cleaning position, and all these movements are executed immediately.

0 : movement-dependent

1 : not movement-dependent

Version: 1.2
Datum: 19.02.2018

470 Pellet 3: Configuration
Pellet 3: Configuration

Pellet station 3: Configuration

The configuration of pellet station 3 (dosing 3) can be determined here.

0 : -

1 : NMC sensor

Version: 1.1
Datum: 07.01.2019

471 Pellet 3: Filling level
Pellet 3: Filling level

mm

Pellet station 3: Filling level

The filling level of the third pellet station can be determined here.

The height levels of the filling level are monitored.

When the filling value falls below the set minimum, a diagnosis appears in standard run and a warning diagnosis in all other run types.

Version: 1.2
Datum: 07.01.2019

472 Pellet 3: Min. filling level
Pellet 3: Minimum filling level

mm

Pellet station 3: Minimum filling level

The minimum filling level of the third pellet station can be determined here.

When the filling value falls below the set minimum, a stop diagnosis appears in standard run and a warning diagnosis in all other run types.

Version: 1.2
Datum: 09.01.2019

473 Pellet 3: Max. filling level
Pellet 3: Maximum filling level

mm

Pellet station 3: Maximum filling level

The maximum filling level of the third pellet station can be determined here.

Version: 1.2
Datum: 07.01.2019

474 Pellet 3: Filling slide position
Pellet 3: Filling slide position

mm

Pellet station 3: Filling slide position

The position of the filling slide at the third pellet station can be entered here. The filling slide position describes the size of the pellet feeder gap from the storage container into the pellet doser.

Version: 1.1
Datum: 08.01.2019

475 Pellet 3: Filling range

Pellet station 3: Filling range

Pellet station 3: Filling range

The filling range of the third pellet station can be determined here. Depending on the desired filling quantity of pellets per capsule, different filling ranges are available.

0 : Filling range 0

1 : Filling range 1

2 : Filling range 2

3 : Filling range 3

4 : Filling range 4

5 : Filling range 5

Version: 1.3
Datum: 07.01.2019

476 Pellet 3: Height adjustment
Pellet 3: Height adjustment

mm

Pellet station 3: Height adjustment

The height adjustment of the third pellet station can be entered here. The height adjustment determines the quantity of pellets to be filled in each capsule. In case of an active weight regulation (option "08.500_600_700_800/252"), this parameter is used for dynamic dosing adjustments for weight change.

Version: 1.1
Datum: 19.03.2019

477 Pellet 3 - Starting time traverse motion
Pellet 3 - Starting time traverse motion

ms

Pellet station 3 - Starting time traverse motion in milliseconds

This parameter contains the optimal starting time for the traverse motion of the slide at the pellet station.

Version: 1.1
Datum: 08.01.2019

478 Pellet 3 - Duration of traverse motion

Pellet 3 - Duration of traverse motion

ms

Pellet station 3 - Duration of traverse motion in milliseconds

This parameter contains the optimal duration of the traverse motion of the slide at the pellet station.

Version: 1.1
Datum: 08.01.2019

479 Pellet 3: Vol. adj. mode
Pellet 3: Volume adjustment mode

Pellet station 3: Volume adjustment mode

The mode of the volume adjustment actuator drive for the third pellet station is set here, particularly the mode for reducing the volume. Some pellets may become jammed between the dosing plate and transfer plate when the volume is reduced, thus preventing further operation or resulting in excessive product losses.

Volume adjustment mode is recommended to minimise faults and product losses for these pellets; in this mode the volume adjustment actuator drive only moves for a reduction in volume, if the dosing unit drive is moving the dosing unit.

This does not affect the moving of the actuator drive using the hand-held terminal or travel directly to the reference position, park position, lubrication position or cleaning position, and all these movements are executed immediately.

0 : movement-dependent

1 : not movement-dependent

Version: 1.2
Datum: 08.01.2019

481 Pellet 4: Filling level
Pellet 4: Filling level

mm

Pellet station 4: Filling level

The filling level of the fourth pellet station can be determined here.

The height levels of the filling level are monitored.

When the filling value falls below the set minimum, a diagnosis appears in standard run and a warning diagnosis in all other run types.

Version: 1.2
Datum: 07.01.2019

482 Pellet 4: Min. filling level
Pellet 4: Minimum filling level

mm

Pellet station 4: Minimum filling level

The minimum filling level of the fourth pellet station can be determined here.

When the filling value falls below the set minimum, a stop diagnosis appears in standard run and a warning diagnosis in all other run types.

Version: 1.2
Datum: 07.01.2019

483 Pellet 4: Max. filling level
Pellet 4: Maximum filling level

mm

Pellet station 4: Maximum filling level

The maximum filling level of the fourth pellet station can be determined here.

Version: 1.2
Datum: 07.01.2019

484 Pellet 4: Filling slide position
Pellet 4: Filling slide position

mm

Pellet station 4: Filling slide position

The position of the filling slide at the fourth pellet station can be entered here. The filling slide position describes the size of the pellet feeder gap from the storage container into the pellet doser.

Version: 1.1
Datum: 08.01.2019

485 Pellet 4: Filling range
Pellet 4: Filling range

Pellet station 4: Filling range

The filling range of the fourth pellet station can be determined here. Depending on the desired filling quantity of pellets per capsule, different filling ranges are available.

0 : Filling range 0

1 : Filling range 1

2 : Filling range 2

3 : Filling range 3

4 : Filling range 4

5 : Filling range 5

Version: 1.3
Datum: 07.01.2019

486 Pellet 4: Height adjustment
Pellet 4: Height adjustment

mm

Pellet station 4: Height adjustment

The height adjustment of the fourth pellet station is entered here. The height adjustment determines the quantity of pellets to be filled in each capsule. If weight control is active (option “08.500_600_700_800/252”), this parameter is used to dynamically adjust dosing in line with weight changes.

Version: 1.1
Datum: 19.03.2019

487 Pellet 4 - Starting time traverse motion
Pellet 4 - Starting time traverse motion

ms

Pellet station 4 - Starting time traverse motion in milliseconds

This parameter contains the optimal starting time for the traverse motion of the slide at the pellet station.

Version: 1.1
Datum: 08.01.2019

488 Pellet 4 - Duration of traverse motion
Pellet 4 - Duration of traverse motion

ms

Pellet station 4 - Duration of traverse motion in milliseconds

This parameter contains the optimal duration of the traverse motion of the slide at the pellet station.

Version: 1.1
Datum: 08.01.2019

489 Pellet 4: Vol. adj. mode
Pellet 4: Volume adjustment mode

Pellet station 4: Volume adjustment mode

The mode of the volume adjustment actuator drive for the fourth pellet station can be set here, particularly the mode for reducing the volume. Some pellets may become jammed between the dosing plate and transfer plate when the volume is reduced, thus preventing further operation or resulting in excessive product losses.

Volume adjustment mode is recommended to minimise faults and product losses for these pellets; in this mode the volume adjustment actuator drive only moves for a reduction in volume if the dosing unit drive is moving the dosing unit.

This does not affect the moving of the actuator drive using the hand-held terminal or travel directly to the reference position, park position, lubrication position or cleaning position, and all these movements are executed immediately.

0 : movement-dependent

1 : not movement-dependent

Version: 1.2
Datum: 08.01.2019

490 Pellet filling cone fill level alarm delay
Pellet filling cone fill level alarm delay

s

Pellet filling cone fill level alarm delay in seconds

A stop delay is set here.

This time indicates how long the machine should continue to produce after having reached the filling level limit.

A warning diagnosis is displayed while the delay time is active.

The machine stops when the time has elapsed.

If the machine stops within the delay time, e.g. because of another stop diagnosis, it only waits for the remaining time of the stop delay after starting up again.

Version: 1.1
Datum: 10.05.2017

500 Dosing combination
Dosing combination

Dosing combination

This parameter describes the types of dosing station

and their mounting positions at the machine. The hundredths decimal place

indicate the type at station 4 (first filling station), the tenths decimal place indicates the type at

station 5 (second filling station) and the ones decimal place indicates the type at station 6

(third filling station).

The following coding is used:

X ... no dosing station (the associated decimal place in the parameter value is set to 0)

T ... compacting station (the associated decimal place in the parameter value is set to 1)

P ... pellet station (the associated decimal place in the parameter value is set to 2)

The compacting station, if installed, is mounted at station 6.

0 : (00)0 = X-X-X

2 : (00)2 = X-X-P

10 : (0)10 = X-T-X

12 : (0)12 = X-T-P

20 : (0)20 = X-P-X

22 : (0)22 = X-P-P

200 :200 = P-X-X

202 :202 = P-X-P

210 :210 = P-T-X

212 :212 = P-T-P

220 :220 = P-P-X

222 :222 = P-P-P

Version: 1.1
Datum: 20.02.2018

500 Dosing combination
Dosing combination

Dosing combination

This parameter describes the types of dosing station

and their mounting positions at the machine. The hundredths decimal place

indicate the type at station 4 (first filling station), the tenths decimal place indicates the type at

station 5 (second filling station) and the ones decimal place indicates the type at station 6 (third

filling station).

The following coding is used:

X ... no dosing station (the associated decimal place in the parameter value is set to 0)

T ... tamping pin station (the associated decimal place in the parameter value is set to 1)

P ... pellet station (the associated decimal place in the parameter value is set to 2)

The tamping pin station, if installed, is mounted at station 6.

0 : (00)0 = X-X-X

2 : (00)2 = X-X-P

10 : (0)10 = X-T-X

12 : (0)12 = X-T-P

20 : (0)20 = X-P-X

22 : (0)22 = X-P-P

200 :200 = P-X-X

202 :202 = P-X-P

210 :210 = P-T-X

212 :212 = P-T-P

220 :220 = P-P-X

222 :222 = P-P-P

Version: 1.3
Datum: 18.01.2018

500 Dosing combination
Dosing combination

Dosing combination

This parameter describes the types of dosing station

and their mounting positions at the machine. The tenths decimal place

indicate the type at station 3 (first filling station), the ones decimal place indicates the type at

station 4 (second filling station).

The following coding is used:

X ... no dosing station (the associated decimal place in the parameter value is set to 0)

T ... compacting station (the associated decimal place in the parameter value is set to 1)

P ... pellet station (the associated decimal place in the parameter value is set to 2)

The compacting station, if installed, is mounted at station 4.

0 : (0)0 = X-X

1 : (0)1 = X-T

2 : (0)2 = X-P

20 : 20 = P-X

21 : 21 = P-T

22 : 22 = P-P

Version: 1.3
Datum: 19.02.2018

501 Single weight 1: Sampling interval
Single weight 1: Sampling interval

x 1000

Single weight 1: sampling interval

A sample is taken each time the pre-selected number of capsules is reached.

The first sampling occurs 30 seconds after a new batch is first started and then every "n" x1000 capsules.

If the machine is stopped during sampling, then the sample is delayed by 30 seconds after the re-start of the machine.

When "0" is entered, no sample is taken.

Version: 1.3
Datum: 10.04.2018

502 Single weight 1: Number of samples per container
Single weight 1: Number of samples per container

Qty

Single weight 1: Number of samples per container (quantity)

The number of samples to be collected in every sample container is entered here.

When a new batch number is entered, the actual value is set to "0" and the system moves on to sample container 1.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

503 Single weight 1: Number
Single weight 1: Number

Qty

Single weight 1: Number as a quantity

The number of capsules to be sampled in order to evaluate the weight is entered here.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

504 Single weight 1: Mean value
Single weight 1: Mean value

mg

Single weight 1 mean value in milligrams

The first set single capsule weight (first filling station) is entered here if the "Weightmaster" is used to take samples.

The current mean value of the last sample is shown in the actual field of this parameter.

The number of capsules per sample is entered in parameter 503.

The sampling interval (after X capsules) is entered in parameter 501.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

505 Single weight 1: Mean value for maximum deviation
Single weight 1: Mean value for maximum deviation

%

Single weight 1: Mean value for maximum deviation as a percentage

The maximum permissible deviation of the mean value of the first set single weight (first filling station) from parameter 504 is entered here.

The mean value of the last Weightmaster sample is displayed in the actual field.

Example:

Parameter 504 = 500 mg

Parameter 505 = 5 %

The machine is stopped with the corresponding diagnosis when the actual value in parameter 504 is greater than 525 mg or less than 475 mg.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

506 Single weight 1: s-rel
Single weight 1: s-rel

%

Relative standard deviation (s-rel) of single weight 1 as a percentage

The actual field displays the corresponding value of the last capsule sample for single weight 1 (first filling station).

If the actual value is higher than the preselected limit, the machine is stopped with the corresponding diagnosis.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

509 Single weight 1: +range
Single weight 1: +range

%

Single weight 1: +range as a percentage

The upper limit of the permitted range of the first single capsule weight (first filling station) is entered here.

Example:

If a value of +30% is entered, only capsules up to 130% of the set weight are evaluated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

510 Single weight 1: -window
Single weight 1: -window

%

Single weight 1: -range as a percentage

The lower limit of the permitted range of the first single capsule weight (first filling station) is entered here.

Example:

If a value of -30% is entered, only capsules that are more than 70% of the set weight are evaluated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

514 Single weight 1: +T2
Single weight 1: +T2

%

Single weight 1: +T2 limit as a percentage

The tolerance limit "+T2" for the first single weight (first filling station) of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%

With option 05.200/535 "Shut down limit T2" the machine stops after finishing a sample if a single value falls outside this limit.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

515 Single weight 1: +T1
Single weight 1: +T1

%

Single weight 1: +T1 limit as a percentage

The tolerance limit "+T1" for the first single weight (first filling station) of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

516 Single weight 1: -T1
Single weight 1: -T1

%

Single weight 1: -T1 limit as a percentage

The tolerance limit "-T1" for the first single weight (first filling station) of the sample capsules is entered here.

The tolerance limit "-T1" for the first single weight (first filling station) of the sample capsules is entered here.

Permitted input: 0,1 ... 99,9%.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

517 Single weight 1: -T2
Single weight 1: -T2

%

Single weight 1: -T2 as a percentage

The tolerance limit "-T2" for the first single weight (first filling station) of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%

With option 05.200/535 "Shut down limit T2", the machine stops after finishing a sample if a single value falls outside this limit.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

519 Single weight 1: Mean value +T2
Single weight 1: Mean value +T2

%

Single weight 1: Mean value +T2 limit as a percentage

The "+T2" limit for the mean value of the first single capsule weight (first filling station) is entered here.

The machine stops after finishing a sample when a mean value is below this limit (option 08.500/678).

Capsules outside the "T2" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.2
Datum: 19.03.2019

520 Single weight 1: Mean value +T1
Single weight 1: Mean value +T1

%

Single weight 1: Mean value +T1 limit as a percentage

The "+T1" limit for the mean value of the first single capsule weight (first filling station) is entered here.

Capsules outside the "T1" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.2
Datum: 19.03.2019

521 Single weight 1: Mean value -T1
Single weight 1: Mean value -T1

%

Single weight 1: Mean value -T1 limit as a percentage

The "-T1" limit for the mean value of the first single capsule weight (first filling station) is entered here.

Capsules outside the "T1" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.2
Datum: 19.03.2019

522 Single weight 1: Mean value -T2
Single weight 1: Mean value -T2

%

Single weight 1: Mean value -T2 limit as a percentage

The "-T2" limit for the mean value of the first single capsule weight (first filling station) is entered here.

The machine stops after finishing a sample when a mean value is below this limit. (Option 08.500/678)

Capsules outside the "T2" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.2
Datum: 19.03.2019

551 Single weight 2: Sampling interval
Single weight 2: Sampling interval

x 1000

Single weight 2: Sampling interval

A sample is taken each time the pre-selected number of capsules is reached.

The first sampling occurs 30 seconds after a new batch is first started and then every "n" x1000 capsules.

If the machine is stopped during sampling, then the sample is delayed by 30 seconds after the re-start of the machine.

When "0" is entered, no sample is taken.

Version: 1.3
Datum: 10.04.2018

552 Single weight 2: Number of samples per container
Single weight 2: Number of samples per container

Qty

Single weight 2: Number of samples per container (quantity)

The number of samples to be collected in every sample container is entered here.

When a new batch number is entered, the actual value is set to "0" and the system moves on to sample container 1.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

553 Single weight 2: Number
Single weight 2: Number

Qty

Single weight 2: Number as a quantity

The number of capsules to be sampled in order to evaluate the weight is entered here.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

554 Single weight 2: Mean value
Single weight 2: Mean value

mg

Single weight 2 mean value in milligramm

The second set single capsule weight (second filling station) is entered here if the "Weightmaster" is used to take samples.

The current mean value of the last sample is shown in the actual field of this parameter.

The number of capsules per sample is entered in parameter 553.

The sampling interval (after X capsules) is entered in parameter 551.

Single weight 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

555 Single weight 2: Mean value for maximum deviation
Single weight 2: Mean value for maximum deviation

%

Single weight 2: Mean value for maximum deviation as a percentage

The maximum permitted deviation from the mean value of the second set single weight (second filling station) from parameter 554 is entered here.

The mean value of the last Weightmaster sample is displayed in the actual field.

Example:

Parameter 554 = 500 mg

Parameter 555 = 5 %

The machine is stopped with the corresponding diagnosis when the actual value in parameter 554 is greater than 525 mg or less than 475 mg.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

556 Single weight 2: s-rel
Single weight 2: s-rel

%

Relative standard deviation (s-rel) of single weight 2 as a percentage

The actual field displays the corresponding value of the last capsule sample for single weight 2 (second filling station).

If the actual value is higher than the preselected limit, the machine is stopped with the corresponding diagnosis.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

559 Single weight 2: +range
Single weight 2: +range

%

Single weight 2: +range as a percentage

The upper limit of the permitted range for the second single capsule weight (second filling station) is entered here.

Example:

If a value of +30% is entered, only capsules up to 130% of the set weight are evaluated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

560 Single weight 2: -range
Single weight 2: -range

%

Single weight 2: -range as a percentage

The lower limit of the permitted range of the second single capsule weight (second filling station) is entered here.

Example:

If a value of -30% is entered, only capsules that are more than 70% of the set weight are evaluated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

564 Single weight 2: +T2
Single weight 2: +T2

%

Single weight 2: +T2 limit as a percentage

The tolerance limit "+T2" for the second single weight (second filling station) of the sample capsules is entered here.

The tolerance limit "+T2" for the second single weight (second filling station) of the sample capsules is entered here.

Permitted input: 0,1 ... 99,9%

With option 05.200/535 "Shut down limit T2", the machine stops after finishing a sample if a single value falls outside this limit.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

565 Single weight 2: +T1
Single weight 2: +T1

%

Single weight 2: +T1 limit as a percentage

The tolerance limit "+T1" for the second single weight (second filling station) of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

566 Single weight 2: -T1
Single weight 2: -T1

%

Single weight 2: -T1 limit as a percentage

The tolerance limit "-T1" for the second single weight (second filling station) of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677

Version: 1.2
Datum: 19.03.2019

567 Single weight 2: -T2
Single weight 2: -T2

%

Single weight 2: -T2 limit as a percentage

The tolerance limit "-T2" for the second single weight (second filling station) of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%

With option 05.200/535 "Shut down limit T2", the machine stops after finishing a sample if a single value is outside this limit.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 19.03.2019

569 Single weight 2: Mean value +T2
Single weight 2: Mean value +T2

%

Single weight 2: Mean value +T2 limit as a percentage

The "+T2" limit for the mean value of the second single capsule weight (second filling station) is entered here.

The machine stops after finishing a sample when a mean value is below this limit (option 08.500/678).

Capsules outside the "T2" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.2
Datum: 19.03.2019

570 Single weight 2: Mean value +T1
Single weight 2: Mean value +T1

%

Single weight 2: Mean value +T1 limit as a percentage

The "+T1" limit for the mean value of the second single capsule weight (second filling station) is entered here.

Capsules outside the "T1" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.2
Datum: 19.03.2019

571 Single weight 2: Mean value -T1

Single weight 2: Mean value -T1

%

Single weight 2: Mean value -T1 limit as a percentage

The "-T1" limit for the mean value of the second single capsule weight (second filling station) is entered here.

Capsules outside the "T1" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.2
Datum: 19.03.2019

572 Single weight 2: Mean value -T2
Single weight 2: Mean value -T2

%

Single weight 2: Mean value -T2 limit as a percentage

The "-T2"-limit for the mean value of the second single capsule weight (second filling station) is entered here.

The machine is stopped after finishing a sample when a mean value falls below this limit (option Option 08.500/678).

Capsules outside the "T2" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.2
Datum: 19.03.2019

601 Single weight 3: Sampling interval
Single weight 3: Sampling interval

x 1000

Single weight 3: Sampling interval

A sample is taken each time the pre-selected number of capsules is reached.

The first sampling occurs 30 seconds after a new batch is first started and then every "n" x1000 capsules.

If the machine is stopped during sampling, then the sample is delayed by 30 seconds after the re-start of the machine.

When "0" is entered, no sample is taken.

Version: 1.3
Datum: 10.04.2018

602 Single weight 3: Number of samples per container
Single weight 3: Number of samples per container

Qty

Single weight 3: Number of samples per container (quantity)

The number of samples to be collected in every sample container is entered here.

When a new batch number is entered, the actual value is set to "0" and the system moves on to sample container 1.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 19.03.2019

603 Single weight 3: Number
Single weight 3: Number

Qty

Single weight 3: Number as a quantity

The number of capsules to be sampled in order to evaluate the weight is entered here.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 19.03.2019

604 Single weight 3: Mean value
Single weight 3: Mean value

mg

Single weight 3 mean value in milligrams

The third set single capsule weight (third filling station) is entered here if the "Weightmaster" is used to take samples.

The current mean value of the last sample is shown in the actual field of this parameter.

The number of capsules per sample is entered in parameter 603.

The sampling interval (after X capsules) is entered in parameter 601.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 19.03.2019

605 Single weight 3: Mean value for maximum deviation
Single weight 3: Mean value for maximum deviation

%

Single weight 3: Mean value for maximum deviation as a percentage

The maximum permitted deviation of the mean value of the third set single weight (third filling station) from parameter 604 is entered here.

The mean value of the last Weightmaster sample is displayed in the actual field.

Example:

Parameter 604 = 500 mg

Parameter 605 = 5 %

The machine is stopped with the corresponding diagnosis when the actual value in parameter 604 is greater than 525 mg or less than 475 mg.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 19.03.2019

606 Single weight 3: s-rel
Single weight 3: s-rel

%

Relative standard deviation (s-rel) of single weight 3 as a percentage.

The actual field displays the corresponding value of the last capsule sample for single weight 3 (third filling station).

If the actual value is higher than the preselected limit, the machine is stopped with the corresponding diagnosis.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3

Datum: 19.03.2019

609 Single weight 3: +range
Single weight 3: +range

%

Single weight 3: +range as a percentage

The upper limit of the permissible range of the third single capsule weight (third filling station) is entered here.

Example:

If a value of +30% is entered, this means that only capsules up to 130% of the set weight are evaluated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 19.03.2019

610 Single weight 3: -range
Single weight 3: -range

%

Single weight 3: -range as a percentage

The lower limit of the permitted range of the third single capsule weight (third filling station) is entered here.

Example:

If a value of -30% is entered, only capsules that are more than 70% of the set weight are evaluated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 19.03.2019

614 Single weight 3: +T2
Single weight 3: +T2

%

Single weight 3: +T2 limit as a percentage

The tolerance limit "+T2" for the third single weight (third filling station) of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%

With option 05.200/535 "Shut down limit T2", the machine stops after finishing a sample if a single value is outside this limit.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

615 Single weight 3: +T1
Single weight 3: +T1

%

Single weight 3: +T1 limit as a percentage

The tolerance limit "+T1" for the third single weight (third filling station) of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%

No input (set value 0.0) means that this limit is not activated

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

616 Single weight 3: -T1
Single weight 3: -T1

%

Single weight 3: -T1 limit as a percentage

The tolerance limit "-T1" for the third single weight (third filling station) of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

617 Single weight 3: -T2
Single weight 3: -T2

%

Single weight 3: -T2 limit as a percentage

The tolerance limit "-T2" for the third single weight (third filling station) of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%

With option 05.200/535 "Shut down limit T2", the machine stops after finishing a sample if a single value is outside this limit.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.2
Datum: 22.03.2019

619 Single weight 3: Mean value +T2
Single weight 3: Mean value +T2

%

Single weight 3: Mean value +T2 limit as a percentage

The "+T2" limit for the mean value of the third single capsule weight (third filling station) is entered here.

The machine stops after finishing a sample when a mean value is below this limit (option 08.500/678).

Capsules outside the "T2" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.2
Datum: 22.03.2019

620 Single weight 3: Mean value +T1
Single weight 3: Mean value +T1

%

Single weight 3: Mean value +T1 limit as a percentage

The "+T1" limit for the mean value of the third single capsule weight (third filling station) is entered here.

Capsules outside the "T1" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.2
Datum: 22.03.2019

621 Single weight 3: Mean value -T1
Single weight 3: Mean value -T1

%

Single weight 3: Mean value -T1 limit as a percentage

The "-T1" limit for the mean value of the third single capsule weight (third filling station) is entered here.

Capsules outside the "T1" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.2
Datum: 22.03.2019

622 Single weight 3: Mean value -T2
Single weight 3: Mean value -T2

%

Single weight 3: Mean value -T2 limit as a percentage

The "-T2"-limit for the mean value of the third single capsule weight (third filling station) is entered here.

The machine is stopped after finishing a sample when a mean value is below this limit (option 08.500/678).

Capsules outside the "T2" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.2
Datum: 22.03.2019

651 Single weight 4: Sampling interval
Single weight 4: Sampling interval

x 1000

Single weight 4: Sampling interval

A sample is taken each time the pre-selected number of capsules is reached.

The first sampling occurs 30 seconds after a new batch is first started and then every "n" x1000 capsules.

If the machine is stopped during sampling, then the sample is delayed by 30 seconds after the re-start of the machine.

When "0" is entered, no sample is taken.

Version: 1.3
Datum: 10.04.2018

652 Single weight 4: Number of samples per container
Single weight 4: Number of samples per container

Qty

Single weight 4: Number of samples per container (quantity)

The number of samples to be collected in every sample container is entered here.

When a new batch number is entered, the actual value is set to "0" and the system moves on to sample container 1.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

653 Single weight 4: Number
Single weight 4: Number

Qty

Single weight 4: Number as a quantity

The number of capsules to be sampled in order to evaluate the weight is entered here.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

654 Single weight 4: Mean value
Single weight 4: Mean value

mg

Single weight 4 mean value in milligrams

The fourth set single capsule weight (fourth filling station) is entered here if the "Weightmaster" is used to take samples.

The current mean value of the last sample is shown in the actual field of this parameter.

The number of capsules per sample is entered in parameter 653.

The sampling interval (after X capsules) is entered in parameter 651.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

655 Single weight 4: Mean value for maximum deviation
Single weight 4: Mean value for maximum deviation

%

Single weight 4 Mean value for maximum deviation as a percentage

The maximum permitted deviation of the mean value of the fourth set single weight (fourth filling station) from parameter 654 is entered here.

The mean value of the last Weightmaster sample is displayed in the actual field.

Example:

Parameter 654 = 500 mg

Parameter 655 = 5 %

The machine is stopped with the corresponding diagnosis when the actual value in parameter 654 is greater than 525 mg or less than 475 mg.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

656 Single weight 4: s-rel
Single weight 4: s-rel

%

Relative standard deviation (s-rel) of single weight 4 as a percentage.

The actual field displays the corresponding value of the last capsule sample for single weight 4 (fourth filling station).

If the actual value is higher than the preselected limit, the machine is stopped with the corresponding diagnosis.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

659 Single weight 4: +range
Single weight 4: +range

%

Single weight 4: +range as a percentage

The upper limit of the permitted range of the fourth single capsule weight (fourth filling station) is entered here.

Example:

If a value of +30% is entered, only capsules up to 130% of the set weight are evaluated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

660 Single weight 4: -range
Single weight 4: -range

%

Single weight 4: -range as a percentage

The lower limit of the permitted range of the fourth single capsule weight (fourth filling station) is entered here.

Example:

If a value of -30% is entered, only capsules that are more than 70% of the set weight are evaluated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

664 Single weight 4: +T2
Single weight 4: +T2

%

Single weight 4: +T2 limit as a percentage

The tolerance limit "+T2" for the fourth single weight (fourth filling station) of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%

With option 05.200/535 "Shut down limit T2", the machine stops after finishing a sample if a single value is outside this limit.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

665 Single weight 4: +T1
Single weight 4: +T1

%

Single weight 4: +T1 limit as a percentage

The tolerance limit "+T1" for the fourth single weight (fourth filling station) of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

666 Single weight 4: -T1
Single weight 4: -T1

%

Single weight 4: -T1 limit as a percentage

The tolerance limit "-T1" for the fourth single weight (fourth filling station) of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

667 Single weight 4: -T2
Single weight 4: -T2

%

Single weight 4: -T2 limit as a percentage

The tolerance limit "-T2" for the fourth single weight (fourth filling station) of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%

With option 05.200/535 "Shut down limit T2", the machine stops after finishing a sample if a single value is outside this limit.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

669 Einzelgewicht 4: Mittelwert +T2
Einzelgewicht 4: Mittelwert +T2

%

Einzelgewicht 4: Mittelwert +T2-Grenze in Prozent

Hier wird die "+T2" Grenze für den Mittelwert des vierten Kapsel-Einzelgewichts (vierte Füllstation) eingegeben.

Die Kapselfüllmaschine stoppt nach Beendigung einer Probe, wenn der Mittelwert unterhalb dieser Grenze liegt. (Option 08.500/678)

Kapseln außerhalb der "T2" Grenze werden in das Ergebnisprotokoll eingetragen.

Nur aktiv mit Option 08.500/59 "Weightmaster" und Option 08.500/677 "Mittelwertueberwachung mit T-Grenze"

Version: 1.3
Datum: 26.02.2019

670 Single weight 4: Mean value +T1
Single weight 4: Mean value +T1

%

Single weight 4: Mean value +T1 limit as a percentage

The "+T1" limit for the mean value of the fourth single capsule weight (fourth filling station) is entered here.

Capsules outside the "T1" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 “Mean value monitoring with T limit”.

Version: 1.3
Datum: 22.03.2019

671 Single weight 4: Mean value -T1
Single weight 4: Mean value -T1

%

Single weight 4: Mean value -T1 limit as a percentage

The "-T1" limit for the mean value of the fourth single capsule weight (fourth filling station) is entered here.

Capsules outside the "T1" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.3
Datum: 22.03.2019

672 Single weight 4: Mean value -T2
Single weight 4: Mean value -T2

%

Single weight 4: Mean value -T2 limit as a percentage

The "-T2" limit for the mean value of the fourth single capsule weight (fourth filling station) is entered here.

The machine stops after finishing a sample when a mean value is below this limit (option 08.500/678).

Capsules outside the "T2" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.3
Datum: 22.03.2019

701 Empty capsule weight: Sampling interval
Empty capsule weight: Sampling interval

x 1000

Empty capsule weight: Sampling interval

A sample is taken each time the pre-selected number of capsules is reached.

The first sampling occurs 30 seconds after a new batch is first started and then every "n" x 1000 capsules.

If the machine is stopped during sampling, then the sample is delayed by 30 seconds after the re-start of the machine.

When "0" is entered, no sample is taken.

Version: 1.3
Datum: 10.04.2018

702 Empty capsule weight: Number of samples per container
Empty capsule weight: Number of samples per container

Qty

Empty capsule weight: Number of samples per container (quantity)

The number of samples to be collected in every sample container is entered here.

If a new batch number is entered, the actual value is set to "0" and the system moves on to sample container 1.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

703 Empty capsule weight: Number
Empty capsule weight: Number

Qty

Empty capsule weight: number as a quantity

The number of capsules to be sampled in order to evaluate the weight is entered here.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

704 Empty capsule weight: Mean value
Empty capsule weight: Mean value

mg

Empty capsule weight, mean value in milligrams

The empty capsule weight is entered here if the Weightmaster is used to take samples.

The current mean value of the last sample is shown in the actual field of this parameter.

The number of capsules per sample is entered in parameter 703.

The sampling interval (after X capsules) is entered in parameter 701.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

705 Empty weight: Mean value for maximum deviation
Empty weight: Mean value for maximum deviation

%

Empty weight: Mean value for maximum deviation as a percentage

The maximum permissible deviation of the mean value of the empty capsule weight from parameter 704 is entered here.

The mean value of the last Weightmaster sample is displayed in the actual field.

Example:

Parameter 704 = 500 mg

Parameter 705 = 5 %

The machine is stopped with the corresponding diagnosis when the actual value in parameter 704 is greater than 525 mg or less than 475 mg.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

706 Empty capsule weight: s-rel
Empty capsule weight: s-rel

%

Relative standard deviation (s-rel) of the empty capsule weight as a percentage.

The actual field displays the value of the last capsule sample for the empty capsule weight.

If the actual value is higher than the preselected limit, the machine is stopped with the corresponding diagnosis.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

709 Empty capsule weight: +range
Empty capsule weight: +range

%

Empty capsule weight: +range as a percentage

The upper limit of the permitted range for the empty capsule weight is entered here.

Example:

If a value of +30% is entered, only capsules up to 130% of the set weight are evaluated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

710 Empty capsule weight: -range
Empty capsule weight: -range

%

Empty capsule weight: -range as a percentage

The lower limit of the permitted range for the empty capsule weight is entered here.

Example:

If a value of -30% is entered, this means that only capsules greater than 70% of the set value are evaluated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

714 Empty capsule weight: +T2
Empty capsule weight: +T2

%

Empty capsule weight: +T2 limit as a percentage

The tolerance limit "+T2" for the empty capsule weight of the sample capsules is entered here.

After this and further T-limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%

With option 05.200/535 "Shut down limit T2" the capsule filling machine stops after finishing a sample if a single value is outside this limit.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

715 Empty capsule weight: +T1
Empty capsule weight: +T1

%

Empty capsule weight: +T1 limit as a percentage

The tolerance limit "+T1" for the empty capsule weight of the sample capsules is entered here.

After this and further T-limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

716 Empty capsule weight: -T1
Empty capsule weight: -T1

%

Empty capsule weight: -T1 limit as a percentage

The tolerance limit "-T1" for the empty capsule weight of the sample capsules is entered here.

After this and further T-limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

717 Empty capsule weight: -T2
Empty capsule weight: -T2

%

Empty capsule weight: -T2 limit as a percentage

The tolerance limit "-T2" for the empty weight of the sample capsules is entered here.

After this and further T limits, the capsules are evaluated in the production report, the result report, etc., and displayed in the histogram.

Permitted input: 0,1 ... 99,9%

With option 05.200/535 "Shut down limit T2" the machine stops after finishing a sample if a single value is outside this limit.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.500/59 "Weightmaster"

Version: 1.3
Datum: 22.03.2019

719 Empty capsule weight: Mean value +T2
Empty capsule weight: Mean value +T2

%

Empty capsule weight: Mean value +T2 limit as a percentage

The "-T1" limit for the mean value of the fourth single capsule weight (fourth filling station) is entered here.

The machine stops after finishing a sample when a mean value is below this limit (option 08.500/678).

Capsules outside the "T2" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.3
Datum: 22.03.2019

720 Empty capsule weight: Mean value +T1
Empty capsule weight: Mean value +T1

%

Empty capsule weight: Mean value +T1 limit as a percentage

The "+T1" limit for the mean value of the empty capsule weight is entered here.

Capsules outside the "T1" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.3
Datum: 22.03.2019

721 Empty capsule weight: Mean value -T1
Empty capsule weight: Mean value -T1

%

Empty capsule weight: Mean value -T1 limit as a percentage

The "-T1" limit for the mean value of the empty capsule weight is entered here.

Capsules outside the "T1" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.3
Datum: 22.03.2019

722 Empty capsule weight: Mean value -T2
Empty capsule weight: Mean value -T2

%

Empty capsule weight: Mean value -T2 limit as a percentage

The "-T2" limit for the mean value of the empty capsule weight is entered here.

The machine stops after finishing a sample when a mean value is below this limit (option 08.500/678).

Capsules outside the "T2" limit are entered in the result report.

Only active with option 08.500/59 "Weightmaster" and option 08.500/677 "Mean value monitoring with T limit"

Version: 1.3
Datum: 22.03.2019

751 Accura-C: Control interval multiplied by x1000
Accura-C: Control interval multiplied by x1000

Qty

Accura-C: Control interval multiplied by 1000 capsules

The control interval 1000 multiplied by 1000 capsules is entered here.

Only active with option 08.600/251 "Accura-C" and 08.500_600_700_800/252 "Weight control".

Version: 1.1
Datum: 22.03.2019

752 Accura-C: Number of capsules
Accura-C: Number of capsules

St.

Accura-C: Number of capsules

The number of capsules for a sample is entered here.

Only active with option 08.600/251 "Accura-C" and option 08.500_600_700_800/252 "Adjustment".

Version: 1.2
Datum: 22.03.2019

753 Accura-C: Control mean value of the last sample
Accura-C: Control mean value of the last sample

mg

Accura-C: Control mean value of the last sample

The mean value of the last Accura-C sample is shown here. This mean value is used for the adjustment of the Accura-C.

The number of capsules per sample is entered in parameter 752.

Only active with option 08.600/251 "Accura-C" and option 08.500_600_700_800/252 "Adjustment".

Version: 1.2
Datum: 19.03.2019

754 Accura-C: Mean value
Accura-C: Mean value

mg

Accura-C: Mean value

The set weight of the capsules for the Accura-C is entered here.

The current mean value of the entire Accura-C batch is shown in the actual field of this parameter.

No input (set value 0.0) means that the adjustment is not activated.

Only active with option 08.600/251 "Accura-C" and 08.500_600_700_800/252 "Weight control".

Version: 1.3
Datum: 19.03.2019

755 Accura-C: Mean value max. deviation
Accura-C: Mean value max. deviation

%

Accura-C maximum deviation from mean value as a percentage

The maximum permissible deviation of the Accura-C mean value of the weight from parameter 754 is entered here.

The deviation of the current mean value is shown in the actual field of this parameter.

Example:

Parameter 754 = 500 mg

Parameter 755 = 5 %

The machine is stopped with the corresponding diagnosis, if the actual value of parameter 754 is greater than 525 mg or less than 475 mg.

No input (set value 0.0) means that this limit is not activated.

Only active with option 08.600/251 "Accura-C"

Version: 1.2
Datum: 19.03.2019

756 Accura-C: s-rel
Accura-C: s-rel

%

Relative standard deviation (s-rel) of the Accura-C weight as a percentage.

The maximum permissible capsule-weight standard deviation of the entire batch is entered here.

The relative standard deviation of the entire batch is displayed in the actual field.

If the actual value is greater than the pre-selected limit, the machine is stopped with the corresponding diagnosis.

No input (set value 0.0) means that this function is not activated.

Only active with option 08.600/251 "Accura-C" and 08.500_600_700_800/252 "Weight control".

Version: 1.2
Datum: 19.03.2019

757 Accura-C: s-rel last sample
Accura-C: s-rel last sample

%

Relative standard deviation of the Accura-C weight of the last sample.

The maximum permissible capsule-weight standard deviation of the last sample is entered here.

The relative standard deviation of the last sample is displayed in the actual field.

If the actual value is greater than the pre-selected limit, the machine is stopped with the corresponding diagnosis.

No input (set value 0.0) means that this function is not activated.

Only active with option 08.600/251 "Accura-C" and 08.500_600_700_800/252 "Weight control".

Version: 1.0
Datum: 05.04.2019

759 Accura-C: +range
Accura-C: +range

%

Accura-C: +range as a percentage

The upper limit of the permitted range for the Accura-C capsule weight is entered here.

Example:

If a value of +30% is entered, this means that only capsules up to 130% of the set weight are evaluated.

Only active with option 08.600/251 "Accura-C"

Version: 1.2
Datum: 19.03.2019

760 Accura-C: -range
Accura-C: -range

%

Accura-C: -range as a percentage

The lower limit of the permitted range for the Accura-C capsule weight is entered here.

Example:

If a value of -30% is entered, this means that only capsules greater than 70% of the set weight are evaluated.

Only active with option 08.600/251 "Accura-C"

Version: 1.2
Datum: 19.03.2019

761 Accura-C: Per number of capsules x1000
Accura-C: Per number of capsules x1000

Qty

Accura-C: Per number of capsules multiplied by 1000

The number of capsules multiplied by 1000 in capsules is entered here.

Parameter 761 serves as reference number for parameter 762.

Only active with option 08.600/251 "Accura-C" and 08.600/259 "T2 machine shutdown with diagnosis".

Version: 1.0
Datum: 05.04.2019

762 Accura-C: Permissible T2 violations
Accura-C: Permissible T2 violations

The number of permissible T2 violations referring to parameter 761 (Accura-C: Per number of capsules x1000) is entered here.

Example:

If 2 T2 violations are allowed for 10 x 1000 = 10,000 filled capsules, then "2" is entered for parameter 762 and "10" for "Parameter 761".

If more than 2 T2 violations occur per 10,000 filled capsules, then the capsule filling machine is stopped with a corresponding diagnosis.

If "0" is entered, this parameter is deactivated.

Only active with option 08.600/251 "Accura-C" and 08.600/259 "T2 machine shutdown with diagnosis".

Version: 1.0
Datum: 05.04.2019

764 Accura-C: +T2
Accura-C: +T2

%

Accura-C: +T2-limit as a percentage

The tolerance limit "+T2" for the Accura-C capsule single weight is entered here.

After this T-limit, the capsules are evaluated and displayed in the batch report.

Permitted input: 0,1 ... 99,9%

With option 05.200/259 "Shutdown limit T2", machine stops after finishing a sample, if a single value falls outside this limit.

machine stops after finishing a sample, if a single value is outside this limit..

Only active with option 08.600/251 "Accura-C".

Version: 1.2
Datum: 19.03.2019

765 Accura-C: +T1
Accura-C: +T1

%

Accura-C: +T1-limit as a percentage

The tolerance limit "+T1" for the Accura-C single capsule weight is entered here.

After this T-limit, the capsules are evaluated and displayed in the batch report.

Permitted input: 0,1 ... 99,9%

No input (i.e. set value 0.0) means that this limit is not activated.

Only active with option 08.600/251 "Accura-C"

Version: 1.2
Datum: 19.03.2019

766 Accura-C: -T1
Accura-C: -T1

%

Accura-C: -T1-limit as a percentage

The tolerance limit "-T1" for the Accura-C single capsule weight is entered here.

After this T-limit, the capsules are evaluated and displayed in the batch report.

Permitted input: 0,1 ... 99,9%.

No input (i.e. set value 0.0) means that this limit is not activated.

Only active with option 08.600/251 "Accura-C"

Version: 1.2
Datum: 19.03.2019

767 Accura-C: -T2
Accura-C: -T2

%

Accura-C: -T2-limit as a percentage

The tolerance limit "-T2" for the Accura-C single capsule weight is entered here.

After this T-limit, the capsules are evaluated and displayed in the batch report.

Permitted input: 0,1 ... 99,9%

With option 05.200/259 "Shutdown limit T2", the machine stops after finishing a sample, if a single value falls outside this limit.

No input (i.e. set value 0.0) means that this limit is not activated.

Only active with option 08.600/251 "Accura-C"

Version: 1.2
Datum: 19.03.2019

769 Accura-C: Mean value +T2
Accura-C: Mean value +T2

%

Accura-C: Mean value +T2-limit as a percentage

The "+T2"-limit for the mean value of the Accura-C capsule weight is entered here.

The machine stops after finishing a sample when a mean value lies above this limit (option 08.600/261).

Only active with option 08.600/251 "Accura-C" and option 08.600/260 "Mean value monitoring with T-limit".

Version: 1.2
Datum: 19.03.2019

770 Accura-C: Mean value +T1
Accura-C: Mean value +T1

%

Accura-C: Mean value +T1-limit as a percentage

The "+T1"-limit for the mean value of the Accura-C capsule weight is entered here.

Only active with option 08.600/251 "Accura-C" and option 08.600/260 "Mean value monitoring with T-limit".

Version: 1.2
Datum: 19.03.2019

771 Accura-C: Mean value -T1
Accura-C: Mean value -T1

%

Accura-C: Mean value -T1 as a percentage

The “-T1”-limit for the mean value of the Accura-C capsule weight is entered here.

Only active with option 08.600/251 "Accura-C" and option 08.600/260 "Mean value monitoring with T-limit".

Version: 1.2
Datum: 19.03.2019

772 Accura-C: Mean value -T2
Accura-C: Mean value -T2

%

Accura-C: Mean value -T2-limit as a percentage

The "-T2"-limit for the mean value of the Accura-C capsule weight is entered here.

The machine stops after finishing a sample when a mean value falls below this limit (option 08.600/261).

Only active with option 08.600/251 "Accura-C" and option 08.600/260 "Only active with option".

Version: 1.2
Datum: 19.03.2019

800 NMC sensor 1: Calibration weight row 1 track 1
NMC sensor 1: Calibration weight row 1 track 1

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

801 NMC sensor 1: Calibration weight row 1 track 2
NMC sensor 1: Calibration weight row 1 track 2

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 09.01.2019

802 NMC sensor 1: Calibration weight row 1 track 3
NMC sensor 1: Calibration weight row 1 track 3

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

803 NMC sensor 1: Calibration weight row 1 track 4
NMC sensor 1: Calibration weight row 1 track 4

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

804 NMC sensor 1: Calibration weight row 1 track 5
NMC sensor 1: Calibration weight row 1 track 5

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

805 NMC sensor 1: Calibration weight row 1 track 6
NMC sensor 1: Calibration weight row 1 track 6

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

806 NMC sensor 1: Calibration weight row 1 track 7

NMC sensor 1: Calibration weight row 1 track 7

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

807 NMC sensor 1: Calibration weight row 1 track 8
NMC sensor 1: Calibration weight row 1 track 8

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

808 NMC sensor 1: Calibration weight row 1 track 9
NMC sensor 1: Calibration weight row 1 track 9

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

809 NMC sensor 1: Calibration weight row 1 track 10
NMC sensor 1: Calibration weight row 1 track 10

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

810 NMC sensor 1: Calibration weight row 1 track 11
NMC sensor 1: Calibration weight row 1 track 11

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

811 NMC sensor 1: Calibration weight row 1 track 12
NMC sensor 1: Calibration weight row 1 track 12

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

812 NMC sensor 1: Calibration weight row 2 track 1
NMC sensor 1: Calibration weight row 2 track 1

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

813 NMC sensor 1: Calibration weight row 2 track 2
NMC sensor 1: Calibration weight row 2 track 2

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

814 NMC sensor 1: Calibration weight row 2 track 3
NMC sensor 1: Calibration weight row 2 track 3

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

815 NMC sensor 1: Calibration weight row 2 track 4
NMC sensor 1: Calibration weight row 2 track 4

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

816 NMC sensor 1: Calibration weight row 2 track 5
NMC sensor 1: Calibration weight row 2 track 5

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1

Datum: 08.01.2019

817 NMC sensor 1: Calibration weight row 2 track 6
NMC sensor 1: Calibration weight row 2 track 6

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

818 NMC sensor 1: Calibration weight row 2 track 7
NMC sensor 1: Calibration weight row 2 track 7

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

819 NMC sensor 1: Calibration weight row 2 track 8
NMC sensor 1: Calibration weight row 2 track 8

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

820 NMC sensor 1: Calibration weight row 2 track 9
NMC sensor 1: Calibration weight row 2 track 9

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

821 NMC sensor 1: Calibration weight row 2 track 10
NMC sensor 1: Calibration weight row 2 track 10

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

822 NMC sensor 1: Calibration weight row 2 track 11
NMC sensor 1: Calibration weight row 2 track 11

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

823 NMC sensor 1: Calibration weight row 2 track 12
NMC sensor 1: Calibration weight row 2 track 12

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 836 and 837.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

824 NMC sensor 1: Global mass factor

NMC sensor 1: Global mass factor

NMC sensor 1: Global mass factor

The global mass factor for the NMC sensor can be entered here.

After transferring the determined weights (parameters 800-823), this parameter is automatically set to "1".

If a constant trend (drift) in the measured values of the NMC sensor is detected, this parameter can be used to adjust all tracks.

Version: 1.1
Datum: 08.01.2019

825 NMC sensor 1: Mean value
NMC sensor 1: Mean value

NMC sensor 1: Mean value

The set value of the capsules at pellet station 1 can be entered here.

Version: 1.1
Datum: 08.01.2019

826 NMC sensor 1: +range
NMC sensor 1: +range

NMC sensor 1: +range in percent

The upper limit of the permissible range of the capsule weight at pellet station 1 can be entered here.

Example:

If a value of +30% is entered, it means that only only capsules up to 130% of the set weight are evaluated.

Version: 1.1
Datum: 08.01.2019

827 NMC sensor 1: -range
NMC sensor 1: -range

NMC sensor 1: -range in percent

The lower limit of the permissible range of the capsule weight at pellet station 1 can be entered here.

Example:

If a value of 30% is entered, this means that only capsules greater than 70% of the set weight (parameter 825) are evaluated.

Version: 1.1
Datum: 08.01.2019

828 NMC sensor 1: +T2
NMC sensor 1: +T2

NMC sensor 1: +T2-limit in percent

The tolerance limit "+T2" for the capsule weight at pellet station 1 can be entered here.

If no value is entered (set value is set to "0.0") it means that the limit is not activated.

Version: 1.1
Datum: 08.01.2019

829 NMC sensor 1: +T1
NMC sensor 1: +T1

NMC sensor 1: +T1-limit in percent

The tolerance limit "+T1" for the capsule weight at pellet station 1 can be entered here.

If no value is entered (set value is set to "0.0") it means that the limit is not activated.

Version: 1.1
Datum: 08.01.2019

830 NMC sensor 1: -T1
NMC sensor 1: -T1

NMC sensor 1: -T1-limit in percent

The tolerance limit "-T1" for the capsule weight at pellet station 1 can be entered here.

If no value is entered (set value is set to "0.0") it means that the limit is not activated.

Version: 1.1
Datum: 08.01.2019

831 NMC sensor 1: -T2
NMC sensor 1: -T2

NMC sensor 1: "-T2" limit in percent

The tolerance limit "-T2" for the capsule weight at pellet station 1 can be entered here.

If no value is entered (set value is set to "0.0") it means that the limit is not activated.

Version: 1.1
Datum: 08.01.2019

832 NMC sensor 1: Mean value +T2
NMC sensor 1: Mean value +T2

NMC sensor 1: Mean value "+T2" limit in percent

The "+T2" limit for the mean value of the capsule weight at pellet station 1 can be entered here.

Version: 1.1
Datum: 08.01.2019

833 NMC sensor 1: Mean value +T1
NMC sensor 1: Mean value +T1

NMC sensor 1: Mean value "+T1" limit in percent

The "+T1" limit for the mean value of the capsule weight at pellet station 1 can be entered here.

Version: 1.1
Datum: 08.01.2019

834 NMC sensor 1: Mean value -T1
NMC sensor 1: Mean value -T1

NMC sensor 1: Mean value "-T1" limit in percent

The "-T1" limit for the mean value of the capsule weight at pellet station 1 can be entered here.

Version: 1.1
Datum: 08.01.2019

835 NMC sensor 1: Mean value -T2
NMC sensor 1: Mean value -T2

NMC sensor 1: Mean value "-T2" limit in percent

The "-T2" limit for the mean value of the capsule weight at pellet station 1 can be entered here.

Version: 1.1
Datum: 08.01.2019

836 NMC sensor 1: Number of measurement drives
NMC sensor 1: Number of measurement drives

NMC sensor 1: Number of measurement drives

The number of measurement drives for calibration can be entered here.

The value of this parameter indicates, how often the measurement drive has to be carried out.

Together with parameter 837 (Number of slider motions) this results in the number of measurements for a calibration procedure.

Version: 1.1
Datum: 09.01.2019

837 NMC sensor 1: Number of slider motions
NMC sensor 1: Number of slider motions

NMC sensor 1: Number of slider motions

The number of slider motions for a measurement drive during calibration can be entered here.

The value of this parameter indicates, how often the measurement drive has to be carried out.

Together with parameter 836 (Number of measurement drives) this results in the number of measurements for a calibration procedure.

Version: 1.1
Datum: 09.01.2019

838 NMC sensor 1: s-rel
NMC sensor 1: s-rel

%

Relative standard deviation s-rel of the pellet 1 weight in percent

In the actual field, the corresponding value of the last capsules for the pellet 1 weight is shown.

If the actual value exceeds the pre-determined limit, the capsule filling machine is stopped with a corresponding diagnosis.

Only active with option 02.500/223 "NMC sensor"

Version: 1.2
Datum: 19.03.2019

839 NMC sensor 1: Mean value of max. deviation
NMC sensor 1: Mean value of max. deviation

%

NMC sensor 1: Mean value of maximum deviation in percent

The maximum permissible deviation of the mean weight value of NMC sensor 1 (parameter 825) can be entered here.

The actual field shows the deviation from the current mean value

Example:

Parameter 825 = 500 mg

Parameter 839 = 5 %

The capsule filling machine stops with a corresponding diagnosis, if the actual value of parameter 825 is greater than 525 mg or less than 475 mg.

Only active with option 02.500/223 "NMC sensor"

Version: 1.2
Datum: 19.03.2019

840 NMC sensor 1: Starting time measurement
NMC sensor 1: Starting time measurement

ms

NMC sensor 1: Starting time measurement in milliseconds

The starting time for the measurement procedure during a cycle at pellet station 1 can be entered here in milliseconds.

Parameter 840 (Starting time measurement) and 841 (Duration of measurement) must not exceed the cycle time.

Version: 1.0
Datum: 09.01.2019

841 NMC sensor 1: Duration of measurement
NMC sensor 1: Duration of measurement

ms

NMC sensor 1: Duration of measurement in milliseconds

The duration of the measurement procedure during a cycle at pellet station 1 can be entered here in milliseconds.

Parameter 840 (Starting time measurement) and 841 (Duration of measurement) must not exceed the cycle time.

Version: 1.0
Datum: 09.01.2019

850 NMC sensor 2: Calibration weight row 1 track 1
NMC sensor 2: Calibration weight row 1 track 1

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

851 NMC sensor 2: Calibration weight row 1 track 2
NMC sensor 2: Calibration weight row 1 track 2

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

852 NMC sensor 2: Calibration weight row 1 track 3
NMC sensor 2: Calibration weight row 1 track 3

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

853 NMC sensor 2: Calibration weight row 1 track 4
NMC sensor 2: Calibration weight row 1 track 4

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

854 NMC sensor 2: Calibration weight row 1 track 5
NMC sensor 2: Calibration weight row 1 track 5

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

855 NMC sensor 2: Calibration weight row 1 track 6
NMC sensor 2: Calibration weight row 1 track 6

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

856 NMC sensor 2: Calibration weight row 1 track 7
NMC sensor 2: Calibration weight row 1 track 7

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

857 NMC sensor 2: Calibration weight row 1 track 8
NMC sensor 2: Calibration weight row 1 track 8

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

858 NMC sensor 2: Calibration weight row 1 track 9
NMC sensor 2: Calibration weight row 1 track 9

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

859 NMC sensor 2: Calibration weight row 1 track 10
NMC sensor 2: Calibration weight row 1 track 10

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

860 NMC sensor 2: Calibration weight row 1 track 11
NMC sensor 2: Calibration weight row 1 track 11

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

861 NMC sensor 2: Calibration weight row 1 track 12
NMC sensor 2: Calibration weight row 1 track 12

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

862 NMC sensor 2: Calibration weight row 2 track 1
NMC sensor 2: Calibration weight row 2 track 1

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

863 NMC sensor 2: Calibration weight row 2 track 2
NMC sensor 2: Calibration weight row 2 track 2

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

864 NMC sensor 2: Calibration weight row 2 track 3
NMC sensor 2: Calibration weight row 2 track 3

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

865 NMC sensor 2: Calibration weight row 2 track 4
NMC sensor 2: Calibration weight row 2 track 4

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

866 NMC sensor 2: Calibration weight row 2 track 5
NMC sensor 2: Calibration weight row 2 track 5

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

867 NMC sensor 2: Calibration weight row 2 track 6
NMC sensor 2: Calibration weight row 2 track 6

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1

Datum: 08.01.2019

868 NMC sensor 2: Calibration weight row 2 track 7
NMC sensor 2: Calibration weight row 2 track 7

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

869 NMC sensor 2: Calibration weight row 2 track 8
NMC sensor 2: Calibration weight row 2 track 8

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

870 NMC sensor 2: Calibration weight row 2 track 9
NMC sensor 2: Calibration weight row 2 track 9

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

871 NMC sensor 2: Calibration weight row 2 track 10
NMC sensor 2: Calibration weight row 2 track 10

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

872 NMC sensor 2: Calibration weight row 2 track 11
NMC sensor 2: Calibration weight row 2 track 11

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

873 NMC sensor 2: Calibration weight row 2 track 12
NMC sensor 2: Calibration weight row 2 track 12

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 886 and 887.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

874 NMC sensor 2: Global mass factor
NMC sensor 2: Global mass factor

NMC sensor 2: Global mass factor

The global mass factor for the NMC sensor can be entered here.

After transferring the determined weights (parameters 850-873), this parameter is automatically set to "1".

If a constant trend (drift) in the measured values of the NMC sensor is detected, this parameter can be used to adjust all tracks.

Version: 1.1
Datum: 08.01.2019

875 NMC sensor 2: Mean value
NMC sensor 2: Mean value

NMC sensor 2: Mean value in milligramm

The set weight of the capsules at the pellet station 2 can be entered here.

Version: 1.1
Datum: 08.01.2019

876 NMC sensor 2: +range
NMC sensor 2: +range

NMC sensor 2: +range in percent

The upper limit of the permissible range of the capsule weight at pellet station 2 can be entered here.

Example:

If a value of +30% is entered, it means that only capsules up to 130% of the set weight (parameter 875) are evaluated.

Version: 1.1
Datum: 08.01.2019

877 NMC sensor 2: -range
NMC sensor 2: -range

NMC sensor 2: -range in percent

The lower limit of the permissible range of the capsule weight at pellet station 2 can be entered here.

Example:

If a value of +30% is entered, it means that only capsules greater than 70% of the set weight (parameter 875) are evaluated.

Version: 1.1
Datum: 08.01.2019

878 NMC sensor 2: +T2
NMC sensor 2: +T2

NMC sensor 2: "+T2" limit in percent

The tolerance limit "+T2" for the capsule weight at pellet station 2 can be entered here.

If no value is entered (set value is set to "0.0") it means that the limit is not activated.

Version: 1.1
Datum: 08.01.2019

879 NMC sensor 2: +T1
NMC sensor 2: +T1

NMC sensor 2: "+T1" limit in percent

The tolerance limit "+T1" for the capsule weight at pellet station 2 can be entered here.

If no value is entered (set value is set to "0.0") it means that the limit is not activated.

Version: 1.1
Datum: 08.01.2019

880 NMC sensor 2: -T1
NMC sensor 2: -T1

NMC sensor 2: "-T1" limit in percent

The tolerance limit "-T1" for the capsule weight at pellet station 2 can be entered here.

If no value is entered (set value is set to "0.0") it means that the limit is not activated.

Version: 1.2
Datum: 08.01.2019

881 NMC sensor 2: -T2
NMC sensor 2: -T2

NMC sensor 2: "-T2" limit in percent

The tolerance limit "-T2" for the capsule weight at pellet station 2 can be entered here.

If no value is entered (set value is set to "0.0") it means that the limit is not activated.

Version: 1.1
Datum: 08.01.2019

882 NMC sensor 2: Mean value +T2
NMC sensor 2: Mean value +T2

NMC sensor 2: Mean value "+T2" limit in percent

The "+T2" limit for the mean value of the capsule weight at pellet station 2 can be entered here.

Version: 1.1
Datum: 08.01.2019

883 NMC sensor 2: Mean value +T1
NMC sensor 2: Mean value +T1

NMC sensor 2: Mean value "+T1" limit in percent

The "+T1" limit for the mean value of the capsule weight at pellet station 2 can be entered here.

Version: 1.1
Datum: 08.01.2019

884 NMC sensor 2: Mean value -T1
NMC sensor 2: Mean value -T1

NMC sensor 2: Mean value "-T1" limit in percent

The "-T1" limit for the mean value of the capsule weight at pellet station 2 is entered here.

Version: 1.1
Datum: 08.01.2019

885 NMC sensor 2: Mean value -T2
NMC sensor 2: Mean value -T2

NMC sensor 2: Mean value"-T2" limit in percent

The "-T2" limit for the mean value of the capsule weight at pellet station 2 can be entered here.

Version: 1.1
Datum: 08.01.2019

886 NMC sensor 2: Number of measurement drives
NMC sensor 2: Number of measurement drives

NMC sensor 2: Number of measurement drives

The number of measurement drives for calibration can be entered here.

The value of this parameter indicates, how often the measurement drive has to be carried out.

Together with parameter 887 (Number of slider motions), this results in the number of measurements for a calibration procedure.

Version: 1.1
Datum: 08.01.2019

887 NMC sensor 2: Number of slider motions
NMC sensor 2: Number of slider motions

NMC sensor 2: Number of slider motions

The number of slider motions for a measurement drive during calibration can be entered here.

The value of this parameter indicates, how many slider motions are carried out for one measurement drive.

Together with parameter 886 (Number of measurement drives), this results in the number of measurements for a calibration procedure.

Version: 1.1
Datum: 09.01.2019

888 NMC sensor 2: s-rel
NMC sensor 2: s-rel

%

Relative standard deviation s-rel of the pellet 2 weight in percent.

In the actual field, the corresponding value of the last capsules for the pellet 2 weight is shown.

If the actual value exceeds the pre-determined limit the capsule filling machine stops with a corresponding diagnosis.

Only active with option 02.500/223 "NMC sensor"

Version: 1.2
Datum: 19.03.2019

889 NMC sensor 2: Mean value of max. deviation
NMC sensor 2: Mean value of max. deviation

%

NMC sensor 2: Mean value of maximum deviation in percent

The maximum permissible deviation of the mean weight value of NMC sensor 2 (parameter 875) can be entered here.

The actual field shows the deviation from the current mean value.

Example:

Parameter 875 = 500 mg

Parameter 889 = 5 %

The capsule filling machine stops with a corresponding diagnosis, if the actual value of parameter 875 is greater than 525 mg or less than 475 mg.

Only active with option 02.500/223 "NMC sensor"

Version: 1.2
Datum: 19.03.2019

890 NMC sensor 2: Starting time measurement
NMC sensor 2: Starting time measurement

ms

NMC sensor 2: Starting time measurement in milliseconds

The starting time for the measurement procedure during a cycle at pellet station 2 can be entered here in milliseconds.

Parameters 840 (Starting time measurement) and 841 (Duration of measurement) must not exceed the cycle time.

Version: 1.0
Datum: 09.01.2019

891 NMC sensor 2: Duration of measurement
NMC sensor 2: Duration of measurement

ms

NMC sensor 2: Duration of measurement in milliseconds

The duration of the measurement procedure during a cycle at pellet station 2 is entered here in milliseconds.

Parameters 840 (Starting time measurement) and 841 (Duration of measurement) must not exceed the cycle time.

Version: 1.0
Datum: 09.01.2019

900 NMC sensor 3: Calibration weight row 1 track 1
NMC sensor 3: Calibration weight row 1 track 1

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

901 NMC sensor 3: Calibration weight row 1 track 2
NMC sensor 3: Calibration weight row 1 track 2

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

902 NMC sensor 3: Calibration weight row 1 track 3
NMC sensor 3: Calibration weight row 1 track 3

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

903 NMC sensor 3: Calibration weight row 1 track 4
NMC sensor 3: Calibration weight row 1 track 4

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

904 NMC sensor 3: Calibration weight row 1 track 5
NMC sensor 3: Calibration weight row 1 track 5

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

905 NMC sensor 3: Calibration weight row 1 track 6
NMC sensor 3: Calibration weight row 1 track 6

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

906 NMC sensor 3: Calibration weight row 1 track 7
NMC sensor 3: Calibration weight row 1 track 7

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

907 NMC sensor 3: Calibration weight row 1 track 8
NMC sensor 3: Calibration weight row 1 track 8

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

908 NMC sensor 3: Calibration weight row 1 track 9
NMC sensor 3: Calibration weight row 1 track 9

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

909 NMC sensor 3: Calibration weight row 1 track 10
NMC sensor 3: Calibration weight row 1 track 10

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

910 NMC sensor 3: Calibration weight row 1 track 11
NMC sensor 3: Calibration weight row 1 track 11

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

911 NMC sensor 3: Calibration weight row 1 track 12
NMC sensor 3: Calibration weight row 1 track 12

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

912 NMC sensor 3: Calibration weight row 2 track 1
NMC sensor 3: Calibration weight row 2 track 1

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

913 NMC sensor 3: Calibration weight row 2 track 2
NMC sensor 3: Calibration weight row 2 track 2

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

914 NMC sensor 3: Calibration weight row 2 track 3
NMC sensor 3: Calibration weight row 2 track 3

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

915 NMC sensor 3: Calibration weight row 2 track 4
NMC sensor 3: Calibration weight row 2 track 4

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

916 NMC sensor 3: Calibration weight row 2 track 5
NMC sensor 3: Calibration weight row 2 track 5

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

917 NMC sensor 3: Calibration weight row 2 track 6
NMC sensor 3: Calibration weight row 2 track 6

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

918 NMC sensor 3: Calibration weight row 2 track 7
NMC sensor 3: Calibration weight row 2 track 7

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1

Datum: 08.01.2019

919 NMC sensor 3: Calibration weight row 2 track 8
NMC sensor 3: Calibration weight row 2 track 8

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

920 NMC sensor 3: Calibration weight row 2 track 9
NMC sensor 3: Calibration weight row 2 track 9

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

921 NMC sensor 3: Calibration weight row 2 track 10
NMC sensor 3: Calibration weight row 2 track 10

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

922 NMC sensor 3: Calibration weight row 2 track 11
NMC sensor 3: Calibration weight row 2 track 11

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

923 NMC sensor 3: Calibration weight row 2 track 12
NMC sensor 3: Calibration weight row 2 track 12

mg

To calibrate the NMC sensor, a calibration drive must be carried out.

The calibration drive can be configured by parameters 936 and 937.

Afterwards, the dosed pellets are weighed and the track-related weight is entered here.

Version: 1.1
Datum: 08.01.2019

924 NMC sensor 3: Global mass factor
NMC sensor 3: Global mass factor

The global mass factor for the NMC sensor can be entered here.

After transferring the determined weights (parameters 900-923), this parameter is automatically set to "1".

If a constant trend (drift) in the measured values of the NMC sensor is detected, this parameter can be used to adjust all tracks.

Version: 1.1
Datum: 08.01.2019

925 NMC sensor 3: Mean value
NMC sensor 3: Mean value

NMC sensor 3: Mean value

The set weight of the capsules at pellet station 3 can be entered here.

Version: 1.1
Datum: 08.01.2019

926 NMC sensor 3: +range in percent
NMC sensor 3: +range in percent

NMC sensor 3: +range in percent

The upper limit of the permissible range of the capsule weight at pellet station 3 can be entered here.

Example:

If a value of +30% is entered, it means that only capsules up to 130% of the set weight (parameter 925) are evaluated.

Version: 1.1
Datum: 08.01.2019

927 NMC sensor 3: -range
NMC sensor 3: -range

NMC sensor 3: -range in percent

The lower limit of the permissible range of the capsule weight at pellet station 3 can be entered here.

Example:

If a value of 30% is entered, this means that only capsules greater than 70% of the set weight (parameter 925) are evaluated.

Version: 1.1
Datum: 08.01.2019

928 NMC sensor 3: +T2
NMC sensor 3: +T2

NMC sensor 3: "+T2" limit in percent

The tolerance limit "+T2" for the capsule weight at pellet station 3 can be entered here.

If no value is entered (set value is set to "0.0") it means that the limit is not activated.

Version: 1.1
Datum: 08.01.2019

929 NMC sensor 3: +T1
NMC sensor 3: +T1

NMC sensor 3: "+T1" limit in percent

The tolerance limit "+T1" for the capsule weight at pellet station 3 can be entered here.

If no value is entered (set value is set to 0.0) it means that the limit is not activated.

Version: 1.1
Datum: 08.01.2019

930 NMC sensor 3: -T1
NMC sensor 3: -T1

NMC sensor 3: "-T1" limit in percent

The tolerance limit "-T1" for the capsule weight at pellet station 3 can be entered here.

If no value is entered (set value is set to 0.0) it means that the limit is not activated.

Version: 1.1
Datum: 08.01.2019

931 NMC sensor 3: -T2
NMC sensor 3: -T2

NMC sensor 3: "-T2" limit in percent

The tolerance limit "-T2" for the capsule weight at pellet station 3 can be entered here.

If no value is entered (set value is set to "0.0") it means that the limit is not activated.

Version: 1.1
Datum: 08.01.2019

932 NMC sensor 3: Mean value +T2
NMC sensor 3: Mean value +T2

NMC sensor 3: Mean value "+T2" limit in percent

The "+T2" limit for the mean value of the capsule weight at pellet station 3 is entered here.

Version: 1.1
Datum: 08.01.2019

933 NMC sensor 3: Mean value +T1
NMC sensor 3: Mean value +T1

NMC sensor 3: Mean value "+T1" in percent

The "+T1" limit for the mean value of the capsule weight at the pellet station 3 can be entered here.

Version: 1.1
Datum: 08.01.2019

934 NMC sensor 3: Mean value -T1
NMC sensor 3: Mean value -T1

NMC sensor 3: Mean value "-T1" limit in percent

The "-T1" limit for the mean value of the capsule weight at pellet station 3 can be entered here.

Version: 1.1
Datum: 08.01.2019

935 NMC sensor 3: Mean value -T2
NMC sensor 3: Mean value -T2

NMC sensor 3: Mean value "-T2" limit in percent

The "-T2" limit for the mean value of the capsule weight at pellet station 3 can be entered here.

Version: 1.1
Datum: 08.01.2019

936 NMC sensor 3: Number of measurement drives
NMC sensor 3: Number of measurement drives

NMC sensor 3: Number of measurement drives

The number of measurement drives for calibration can be entered here.

The value of this parameter indicates, how often the measurement drive has to be carried out.

Together with parameter 937 (Number of slider motions), this results in the number of measurements for a calibration procedure.

Version: 1.1
Datum: 08.01.2019

937 NMC sensor 3: Number of slider motions
NMC sensor 3: Number of slider motions

NMC sensor 3: Number of slider motions

The number of slider motions for a measuring drive during calibration can be entered here.

The value of this parameter indicates, how many slider motions are carried out for one measuring drive.

Together with parameter 936 (Number of measurement drives), this results in the number of measurements for a calibration procedure.

Version: 1.1
Datum: 08.01.2019

938 NMC sensor 3: s-rel
NMC sensor 3: s-rel

%

Relative standard deviation s-rel of the pellet 3 weight in percent

In the actual field, the corresponding value of the last capsules for the pellet 3 weight is shown here.

If the actual value exceeds the pre-determined limit the capsule filling machine stops with a corresponding diagnosis.

Only active with option 02.500/223 "NMC sensor"

Version: 1.2
Datum: 19.03.2019

939 NMC sensor 3: Mean value of max. deviation
NMC sensor 3: Mean value of max. deviation

%

NMC sensor 3: Mean value of maximum deviation in percent

The maximum permissible deviation of the mean weight value of NMC sensor 3 (parameter 925) can be entered here.

The actual field shows the deviation from the current mean value.

Example:

Parameter 925 = 500 mg

Parameter 939 = 5 %

The capsule filling machine stops with a corresponding diagnosis, if the actual value of parameter 925 is greater than 525 mg or less than 475 mg.

Only active with option 02.500/223 "NMC sensor"

Version: 1.2
Datum: 19.03.2019

940 NMC sensor 3: Starting time measurement
NMC sensor 3: Starting time measurement

ms

NMC sensor 3: Starting time of measurement in milliseconds

The starting time for the measurement procedure during a cycle at pellet station 3 is entered here in milliseconds.

Parameters 840 (Starting time measurement) and 841 (Duration of measurement) must not exceed the cycle time.

Version: 1.0
Datum: 09.01.2019

941 NMC sensor 3: Duration of measurement
NMC sensor 3: Duration of measurement

ms

NMC sensor 3: Duration of measurement in milliseconds

The duration of the measurement procedure during a cycle at pellet station 3 is entered here in milliseconds.

Parameters 840 (Starting time measurement) and 841 (Duration of measurement) must not exceed the cycle time.

Version: 1.0
Datum: 09.01.2019

950 Pellet 1: Vib. amplitude
Pellet 1: Vibration amplitude

%

Pellet station 1: Vibration amplitude

After filling the pellets into capsules, the servo motor can transmit some vibrations onto the dosing unit via parameter 950 “Vibration amplitude” and parameter 951 “Vibration wave length”.

The vibration amplitude is given in percent. The following table shows how the percentage value corresponds to the dynamic range in millimeters.

10% ~ 0.01mm

30% ~ 0.1mm

50% ~ 0.26mm

80% ~ 0.65mm

100% ~ 1.0mm

150% ~ 2.2mm

200% ~ 3.75mm

Version: 0.1
Datum: 20.02.2018

951 Pellet 1: Vib wave length
Pellet 1: Vibration wave length

ms

Pellet station 1: Vibration wave length

After filling the pellets into capsules, the servo motor can transmit some vibrations onto the dosing unit via parameter 950 “Vibration amplitude” and parameter 951 “Vibration wave length”.

The vibration wave length is the duration of a vibration in ms. If the cycle time is long enough, 4 vibrations can be transmitted. If the cycle time is shorter, the number of vibrations transmitted decreases, respectively to the full length of the cycle time.

Version: 0.1
Datum: 20.02.2018

960 Pellet 2: Vib. amplitude
Pellet 2: Vibration amplitude

%

Pellet station 2: Vibration amplitude

After filling the pellets into capsules, the servo motor can transmit some vibrations onto the dosing unit via parameter 960 “Vibration amplitude” and parameter 961 “Vibration wave length”.

The vibration amplitude is given in percent. The following table shows how the percentage value corresponds to the dynamic range in millimeters.

10% ~ 0.01mm

30% ~ 0.1mm

50% ~ 0.26mm

80% ~ 0.65mm

100% ~ 1.0mm

150% ~ 2.2mm

200% ~ 3.75mm

Version: 0.1
Datum: 20.02.2018

961 Pellet 2: Vib wave length
Pellet 2: Vibration wave length

ms

Pellet station 2: Vibration wave length

After filling the pellets into capsules, the servo motor can transmit some vibrations onto the filling slide via parameter 960 “Vibration amplitude” and parameter 961 “Vibration wave length”.

The vibration wave length is the duration of a vibration in ms. If the cycle time is long enough, 4 vibrations can be transmitted. If the cycle time is shorter, the number of vibrations transmitted decreases, respectively to the full length of the cycle time.

Version: 0.1
Datum: 20.02.2018

970 Pellet 3: Vibration amplitude
Pellet 3: Vibration amplitude

%

Pellet station 3: Vibration amplitude

After filling the pellets into the capsules, some vibrations can be transmitted to the dosing unit by the servo motor via parameters 970 "Vibration amplitude" and 971 "Vibration wave length".

The vibration amplitude is given in percent and the following table shows how the percentage value affects the vibration range in millimeters.

10% ~ 0.01mm

30% ~ 0.1mm

50% ~ 0.26mm

80% ~ 0.65mm

100% ~ 1.0mm

150% ~ 2.2mm

200% ~ 3.75mm

Version: 0.1
Datum: 09.01.2019

971 Pellet 3: Vibration wave length
Pellet 3: Vibration wave length

ms

Pellet station 3: Vibration wave length

After filling the pellets into the capsules, some vibrations can be transmitted to the dosing unit by the servo motor via parameters 970 "Vibration amplitude" and 971 "Vibration wave length".

The vibration wave length is the duration of a vibration in ms. If the time in the cycle allows it, 4 vibrations are carried out, if not, the number of vibrations is reduced accordingly.

Version: 0.1
Datum: 09.01.2019