



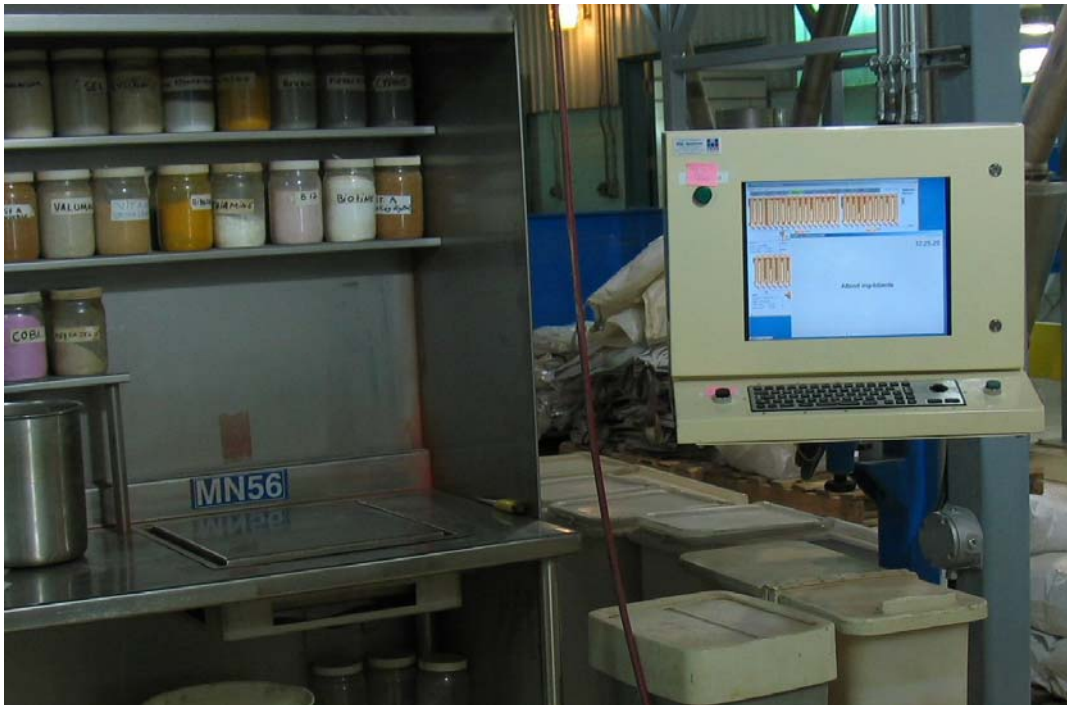
AutoPilot4Feed

Hand adds and Pre-weigh hand adds



AutoPilot4Feed has a powerful system for ensuring that the correct and accurate hand adds are always added. It is called PC Hand Adds.

A standard PC running Windows XP Pro is mounted in a dust-proof box near to the hand additives addition point. The PC is connected to a platform weigh scale used to do the actual weighing and networked to the main **AutoPilot4Feed** control PC.



Hand adds PC in dust-proof enclosure and platform scale on the left

The system can be used to weigh hand additives for main batches in the plant or in advance for batches which will be produced in the future (pre-weigh mode).



PC hand adds with platform scale on the right

Normal mode

When a batch is started which needs any hand adds, the PC displays what materials are required. The operator selects a material, enters the lot number (for traceable materials) and starts to weigh the material on the platform weigh scale. A moving weight bar on the left side of the PC display makes it easy and quick for the operator to see how close to the target weight it is. Large letters are used to help the operator with messages such as underweight, overweight, add material and so on.

Additifs Non-medicament MN56 PC Handadds V013

Product	BR FINISHER		
Batch	2 of 12	Dest Plant	NM 1 t
Mixing Line	F14	Sequence No	305

Material Code	Material	Required Weight (kg)	Actual Weight (kg)	Lot Number
WAFOLIN	Wafolin	4.104	4.200	419000111
LIMESTONE	Limestone	4.975	0.000	
TYLAN-G250	Tylan G250	2.487	0.000	
CU SULPHATE	Copper Sulphate	3.731	0.000	

Material	Required Weight (kg)	Weight to go (kg)
LIMESTONE	4.975	1.875
Add material		

The screen is easy to read and has a 'Weight bar' up the left side. The yellow bar shows the tolerances upper and lower.

If there is a barcode reader fitted then this can be used as a further check to wand a barcode on the material container or bag. This further reduces the possibility of any mistakes by the operator.

When the material weight is up to the target weight the operator presses the ‘check weight’ button and the computer checks that the weight is within the tolerances. Default material tolerances can be specified as part of the material definition but can also be specified per formula. This gives the operator the flexibility to adjust tolerances if required. Tolerances can be proportional to the required weight or a fixed amount in kg for all inclusions.

When all materials have been weighed and checked, an illuminated push button flashes to tell the operator when to add them into the main batch. The operator dumps the additives into the hopper and pushes the button which then illuminates steadily.

Since the hand adds PC is part of the **AutoPilot4Feed** network, formulations are never out of date and data entry is never duplicated, reducing mistakes and operator workload.

Pre-weigh mode

When the operator has spare time, he may prepare hand additives in advance for batches which may be produced later or even the following day.

The operator can select any product, whether it is in the program or not, and the PC will let the operator weigh the additives with all the functions and protection of normal hand adds weighing. Once all materials are weighed, a barcoded ticket is printed and this ticket is normally stuck on the outside or placed inside the container.

Later when the main batch is weighed, the operator wands the barcode and **AutoPilot4Feed** checks that all the ingredients are correct for the product. It logs the actual weights in with the main batch and allows the operator to dump it into the hand adds hopper. It is very straightforward and prevents operator mistakes.

Stock control of all hand ingredients is included and makes verification easy and quick.

If required, the Hand Adds PC can also be used to display graphics and alarms. The operator can therefore use the PC to monitor the plant and does not have to go back to the control room to take any action.

PC Hand Adds prevents mistakes, ensures the correct accuracy and records all operations.

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