Warranty Card

Customer: _____ **No:** _____

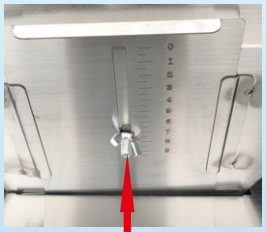
Model			Speeification		
Purchasing date			Strial No		
Damaged condition			Content of warranty		
	Client			Client	
Damaged condition			Content of warranty		
	Client			Client	
Damaged condition			Content of warranty		
	Client			Client	

Date

Remark: This product is guaranteed for one year. The failure caused by violations of human factors such as operation is not covered by the company's warranty. During the warranty period, repairs and spare parts are free of charge, but the round-trip freights will be paid by client.

Incline'd Filling Machine Instruction

1.Please dismantle 2 reinforced screws with spacers for transportation marked on baseplate before use.



● According to the size of the material to adjust the accuracy of the weighing of the material at the discharge port

2.Plug in and turn on the switch on the side face of the machine;

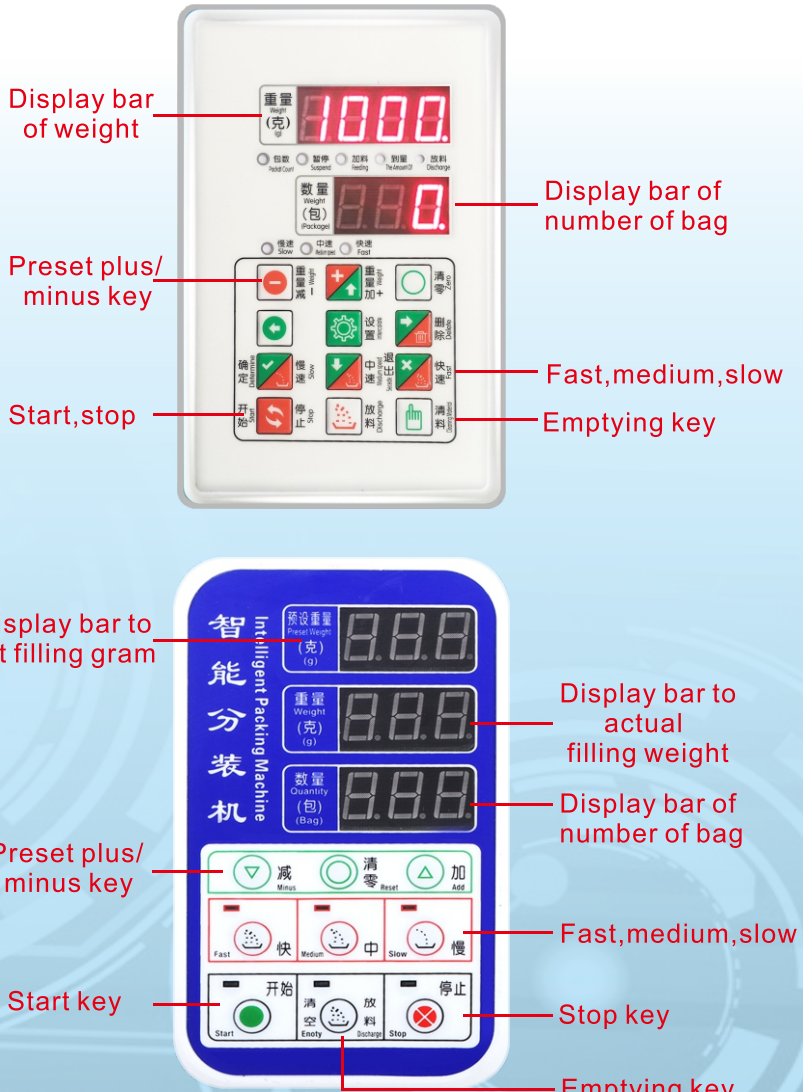
3.Presskeys on control panel to set packed weight you need (eg.07.0 represents 7 grams);

4.Press "fast, medium, slow" keys on control panel to select the spee- you need;

5.Press "start" key on control panel, the machine will get fully automaue mode, after quantitative illing, the materials will be packed through induction at discharge hole with manual bag provided;

6.Please press reset key if weight and number of bag are requiredeo be reset;

7.Please press" "emptying" key for 5 seconds till the machine gelse clearing material mode ifit is needed to clear away materials inside machine; (Remarks:please put few materials when test-run a machine at first time, and put more materials after commissioning of the machine)



check for zero	F11	CAL	Check the zero point, and press OK to display the current weight reset
Calibration range	F12	0000	Calibrate the displayed value (calibration weight) of the sensor, put in the weight and write the value corresponding to the weight
Clearing range	F13	X	X = 0-9: 2%, 5%, 10%, 20%, 50% and 100% of the packaging weight respectively; X = 0 (default)

Note: greater than 5KG sensor (or less than 1 kg) need to change fifth decimal places to 0 (or 2), seventh to 1 or 2 (20KG above), then transfer to 12 items, calibrate weights, then seventh to 0, press the exit key.

1.Please dismantle 4 reinforced screws for transportation marked on baseplate before use.

2.Plug in and turn on the switch on the side face of the machine;

3.Press “+/-”keys on control panel to set packed weight you need (eg. 07.0 represents 7 grams);

4.Press "fast, medium, slow" keys on control panel to select the speed you need;

5.Press "start" key on control panel, the machine will get fully automatic mode,after quantitative filling.the materials will be packed through induction at discharge hole with manual bag provided;

6.Please press "reset" key if weight and number of bag are required to be reset;

7.Please press "emptying" key for 5 seconds till the machine gets a clearing material mode if it is needed to clear away materials inside the machine; (Remarks: please put few materials when test-run a machineat first time,and put more materials after commissioning of the machine)

1.Please dismantle 3 reinforced screws for transportationmarked on baseplate before use.

2.Plug in and turn on the switch on the side face of the machine, the indicator light on the control panel of the computer turns on with a prompt tone of “dididi", then press "reset"key, the machine will reset to enter standby mode;

3.Pour materials to be filled into the charging basket. press “+/-”keys on control panel to set packed weight you need;

4.Set filling speed, press "fast,medium, slow"keys on control panel to select the speed you need (adjust in combination with dam-boar of big hopper and cardboard of vibration plate);

5.After selecting speed, press "start" key on control panel, the machine will get fully automatic mode,after quantitative filling, step on foot pedal to discharge materials;

6.During filling. if it is needed to suspend or materials have been filled completely,you can press "stop" key to stop the machine at standby mode;

7.Packing quantity of quantitative packing is displayed in "quantity” bar, please press “delete" key if it is needed to make zero to display quantity;

8.Press "emptying" key, the machine will get a clearing material mode if it is needed to clear away materials inside the machine;

9.After filling or if the machine is not used for a long time, please turn off the switch.(Remarks: please put few materials when test-run a machine at first time,and putmore materials after commissioning of the machine)

Zero tracking range	F03	X	X = 0: no tracking x = 1: zero tracking range 0.5 separation degrees X = 2: zero tracking range 1 separation x = 3: zero tracking range 1.5 separation X = 4: 2 separation degrees of zero tracking range (default) X = 5: zero tracking range 2.5 separation degrees
Weight swing detection sensitivity	F04	X	X = 0: 1 separation per second X = 1: 3 separations per second (default)
Decimal point position	F05	X	X = 0: display 1 X = 1: display 0.1 (default) X = 2: display 0.01 X = 3: display 0.001
Maximum display range	F06	X	X = 0: maximum display 1000 X = 1: maximum display 1200 X = 2: maximum display 1500 X = 3: maximum display 2000 X = 4: maximum display 250 X = 5: maximum display 4000 X = 6: maximum display 5000 X = 7: maximum display 6000 X = 8: maximum display 8000 X = 9: maximum display 9999 (default)
Separation degree	F07	X	X = 0: separation is 1 (default) X = 1: the separation is 2 X = 2: separation of 5 X = 3: separation is 10
Filtering time	F08	X	X = 0: no filtering, x = 1 --- 9: filtering time increases in turn; X = 4 (default) (the larger the number, the smaller the cleaning time)
Filtering range	F09	X	X = 0 -- 9: the filtering range increases in turn; X = 8 (default) (the larger the number, the faster the zeroing)
Weighing code	F10	XXXX	Weighing internal code XXXX is internal code: the current weighing code (AD data) is displayed in real time and cannot be changed

Impulse avoidance time	S12	ABCD	A: Press start or close the door after the second discharge, and start feeding after a * 0.2 second delay B: After receiving the quantity, delay the sampling time b * 0.2S and output the incoming signal. C: When discharging (opening the door), the delay time is c * 0.2 seconds, and then detect whether the discharging is completed (whether it is 0) D: Close the door after the completion of discharging with a delay of D * 0.2 seconds. Especially under small or large weight, the value of D can be increased appropriatelyDefault ABCD: 3111	3111	3111	3111
Jog times	S13	5	The maximum number of inching feeding, 05, will enter the inching feeding stage when it is judged that the quantity has not arrived after the slow heating	5	5	5

二、Parameter setting table of metering load cell:

In the standby mode, press and hold the setting key for 2 seconds to display "p000", enter the password "P200", press the OK key to enter the setting of metering parameters, display S00, press up plus 1 to display SO1, press OK to display the content of the parameter, and then set the parameters. The specific contents are as follows (this table is a global parameter, which can be set in any gear of fast, medium and slow):

Function name	Function number	display	Details (550 parameters)
sign out	F00		Press OK to exit
Data stability conditions	F01	X	X = 0-9: the larger the data, the stricter the stability conditions; X=2
Zero tracking time	F02	X	X = 0: zero tracking time 1s X = 1: zero tracking time 2 seconds (default)

1.Please dismantle 3 reinforced screws for transportationmarked on baseplate before use.

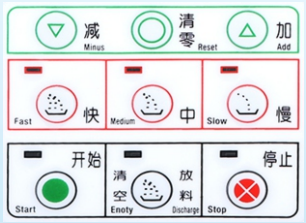
2： Parameter setting method of automatic speed regulation control:
In the working state, press and hold the setting key for 2 seconds, display "p000" (the old board is adjusted to 660), and press the setting key. Display "S00", press plus to display "S01", indicating the parameters in the function number (the parameters of each gear are different, so pay attention to distinguish between fast, medium and slow).
The control parameters of the current packaging speed level can be set

Function name	Function number	Display	Details (660 parameters of automatic speed regulating board, taking medium speed as an example)	Parameter factory settings		
Sign out	S00			Slow	Medium speed	fast
Allowable error	S01	0.2	The allowable packaging error is 0.2g	0.1	0.2	0.3
Fast acceleration vibration speed range	S02	0822	00-39, vibration speed range of fast acceleration 08-22	0822	0823	0824
Fast acceleration vibration speed speed	S03	15	00-39, fast acceleration initial vibration speed 15	14	15	17
Fast acceleration advance value	S04	2.9	Stop when it is quickly added to the rated weight of -2.9g	2.6	2.9	3.2
Fast feeding speed	S05	5. 0	Fast feeding speed 5.0 g / S	4.0	5.0	6.0
Fast acceleration timeout	S06	4	Fast acceleration enters pause after 04 seconds	4	4	4
Slow acceleration vibration speed range	S07	0010	00-39, slow acceleration vibration speed range 00-10	0010	0010	0012
Slow acceleration initial vibration speed	S08	05	00-39, slow acceleration, initial vibration speed 05	04	05	06
Slow acceleration advance value	S09	0.3	Stop when it is slowly added to the rated weight of -0.3 G	0.3	0.4	0.4
Slow feeding speed	S10	3.0	Slow feeding speed 3.0 g / S	2.0	3.0	4.0
Slow plus timeout			Slow add for more than 07 seconds to enter pause	07	07	07
Impulse avoidance time	S12	ABCD	A: After closing the door, delay a * 0.2 seconds to clear and feed B: Arrival delay sampling time b * 0.2S C: Discharge detection delay time c * 0.2S D: After discharging, delay d * 0.2S, close the door, ABCD: 2110	3110	3110	3110
Jog times	S13	05	When the quantity is not reached after the slow heating, the maximum number of inching feeding	05	05	05

Please note: the above parameter adjustment generally only adjusts option 2, 3, 7 and 8, and other options should be adjusted with your full understanding.

Quick setting method:

At any speed, adjust the parameter of item 2 to 0039 and the parameter of item 7 to 0030. After pressing start, discharge the material for multiple blanking tests, input P102 (old 445), and observe the current vibration parameters in real time. After a few bags of work. It will stabilize at a relatively stable number. For example, in the figure below, 30 is fast acceleration, 20 is slow acceleration, item 2 is adjusted to 2535, item 3 is adjusted to 30, item 7 is adjusted to 1525, and item 7 is adjusted to 20.



Input password“P102”

Item 3
30

Item 8
20

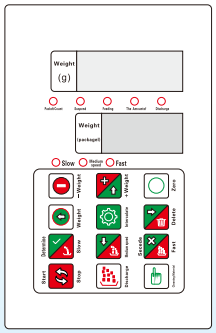
二、 Setting method of weighing parameters:

Press and hold the setting key for 2 seconds in the working state, and the display "p000" moves left. Moving left is the flashing of the moving position, and the flashing parameters are adjusted by adding and subtracting. Enter the password "P200" (the old board is adjusted to 550) and enter the setting of metering parameters (the parameters of each gear are the same, regardless of fast, medium and slow). The specific contents are as follows:

Function name	Function number	Dispaly	Details (550 parameters)
Sign out	F00		
Data stability conditions	F01	X	X = 0-9: the larger the data, the stricter the stability conditions; X=2
Zero tracking time	F02	X	X = 0: zero tracking time 1s X = 1: zero tracking time 2 seconds
Zero tracking range	F03	X	X = 0: no tracking x = 1: zero tracking range 0.5 separation degrees X = 2: zero tracking range 1 separation x = 3: zero tracking range 1.5 separation X = 4: zero tracking range 2 separators x = 5: zero tracking range 2.5 separators
Weight swing detection sensitivity	F04	X	X = 0: 1 separation per second X = 1 : 3 separations per second
Decimal point position	F05	X	X = 0: display 1 X = 1: display 0.1
Maximum display range	F06	XX	XX = 0: maximum display 100 XX = 1: maximum display 120 XX = 2: maximum display 150 XX = 3: maximum display 200 XX = 4: maximum display 250 XX = 5: maximum display 400 XX = 6: maximum display 500 XX = 7: maximum display 600 XX = 8: maximum display 800 XX = 9: maximum display 999
Separation degree (the sensor greater than 3kg needs to be adjusted to 1)	F07	X	X = 0: separation is 1 x = 1: separation is 2 X = 2: the separation is 5 x = 3: the separation is 10
Filtering time	F08	X	X = 0: no filtering, x = 1 --- 9: filtering time increases in turn; X=4
Filtering range	F09	X	X = 0 -- 9: the filtering range increases in turn; X=9
Internal code display	F10	XXXX	X is internal code zero coding (AD data)
check for zero	F11	CAL	check for zero
Calibration weight parameters	F12	0000	Calibration range
Clearing range	F13	X	X = 0-9: 2%, 5%, 10%, 20%, 50% and 100% of the packaging weight respectively; X=0

Note: when the sensor calibration is greater than 5KG, the E-02 will be adjusted to fifth decimal places instead of 0, seventh to 1 or 2, and then to 12 items. After calibration, the weights will be returned to seventh for 0.

Fast feeding speed	S05	5.0	The fast feeding speed of 5.0 g / S (reference value) is generally not adjusted	4.0	5.0	6.0
Fast acceleration timeout	S06	24	Fast acceleration timeoutS0624 The fast charging process does not reach the advance value of S04, and enters the slow charging stage after 24 seconds When using the rotating disc, increase it appropriately.	4	4	4
Slow acceleration vibration speed range	S07	0010	AB—CDThe maximum value is 39, the lowest value of slow acceleration vibration speed range AB (00) - the highest value of CD (10). The current slow acceleration vibration parameters will be adjusted between AB and CD according to the blanking conditions of materials. This parameter is smaller than S02	0010	0010	0012
Slow acceleration initial vibration speed	S08	05	The maximum value is 39, slowly add the initial vibration speed of 05,Note hat this parameter should be within the range of S07. It is better to set it as the parameter when it is stable. In the working state, enter p445 to display ABCD to view the current slow addition value of ab	04	05	06
Slow acceleration advance value	S09	000.3	Slowly add it to the last 0.3 g of rated weight, stop it, enter the judgment stage, and stop it within the error range	0.3	0.4	0.4
Slow feeding speed	S10	3.0	Slow feeding speed 3.0 g / S	2.0	3.0	4.0
Slow plus timeout	S11	17	When the slow acceleration process exceeds 17 seconds, it enters the pause state and sounds the alarm for a long time. You need to press start again to start working	17	17	17



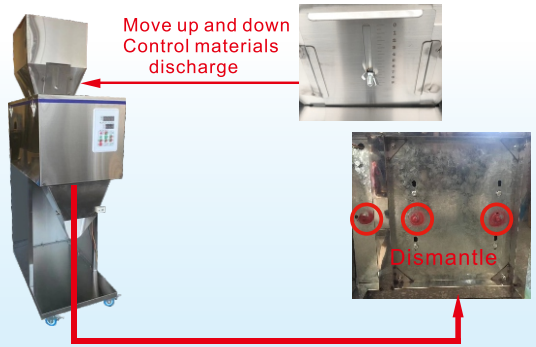
induction. Remember to set it after debugging the machine.

三、**Parameter setting method of metering automatic speed regulation control**:

The parameters of each gear shall be set separately. In the working state, press and hold the setting key for 2 seconds to display "p000". Directly press the OK key to display S00, and then press up to display SO1. Press OK to display the parameter content, and then set the control parameters of the current speed level. The specific contents are as follows (take medium speed as an example):

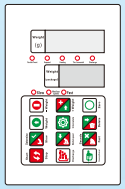
Function name	display	display	Details (automatic speed governing board, taking medium speed as an example)	Parameter factory settings (press p112 to restore)		
sign out	S00		Press the OK key to exit the setting	Solw	Medium speed	Fast
Allowable error	S01	000.2	The allowable packaging error is 0.2g, and finally	0.1	0.2	0.3
Fast acceleration vibration speed range	S02	0822 AB—CD	The maximum value is 39. The minimum value of AB (08) - the maximum value of CD (22) in the vibration speed range of fast acceleration. The current vibration parameters of fast acceleration will be determined according to the material	0822	0823	0824
Fast acceleration initial vibration speed	S03	15	The maximum value is 39, and the initial vibration speed of fast acceleration is 15. Note that this parameter should be within the range of S02. It is best to set it as a stable parameter. In the working state, enter p445 to display ABCD to view the current fast acceleration value of ab	15	16	17
Fast acceleration advance value	S04	002.0	Before fast adding to the last 2.0g of the set weight,use the fast adding vibration number. For example, set 10.0. When 8.0 is displayed from 0 to (10.0-2.0) for the first time, the vibration parameter is S03	2.6	2.9	3.2

1.Please dismantle 3 reinforced screws for transportationmarked on baseplate before use.



一、**Panel paper setting description**

（there are two kinds of panel paper, horizontal and vertical. The distribution of parameter setting keys is the same. The following is the vertical diagram）.



The first nixie tube is a 4-digit weight value. The actual weight is displayed in standby mode. When the weight is added and reduced, the setting value is displayed. In advanced setting, the setting parameter value is displayed.

The second nixie tube only displays the current number of packets.Indicator Description:

The first row of indicator lights, light 1: the number of packages is always on after startup, light 2: pause, standby light, standby when on, press start and then off, which is the working state, light 3: feeding, on when starting feeding, not on when not feeding, light 4: arrival, the light is on when the feeding reaches the set value, and off when the induction door is opened, light 5: discharging, on when the discharging motor is opened, and not on when closed.

The second row of indicators is the current speed indicator, light 6: slow, light 7: medium speed, light 8: fast.

Key Description:

In standby mode, the first row: the first weight is reduced, press the first nixie tube to display the setting value, and then press, the setting value is reduced by 1, long press, always reduce, do not press, do not reduce, the second weight is added, such as weight reduction, which is an upward value in advanced setting, and the third reset: the actual displayed weight is reset to zero.

The second row: the fourth shift to the left, which takes effect during advanced setting. Press the fifth setting key for a long time to enter advanced

setting. The sixth delete key: in standby mode, the value of the number of deleted packets returns to zero

The third row: the seventh slow, the standby mode is the slow selection key, and the advanced setting is the OK key; The eighth medium speed, the standby mode is the medium speed selection key, and the advanced setting is the down value reduction key; The ninth is fast, the standby mode is slow selection key, and the advanced setting is exit key;

The fourth row: the tenth start stop key, which is standby stop when starting up. Press to enter the working state, the eleventh discharge key, which is effective in the standby state, press the discharge key, and the twelfth clear key, which is effective in the standby state. Press to enter the clearing program, the motor is turned on and the vibration output is carried out at the same time, and press the stop key to stop.

Press and hold "p000" to enter advanced setting.

Up is plus. Down is minus. Plus or minus displays the value of the flashing bit. The left and right arrows move left and right to adjust the bit, and the adjusted bit flashes.

For sure

Exit setting parameters.

二、working principle

After startup, it is in the stop standby state. Press start to enter the working state. You can press the stop key to enter the standby state at any time. There are three speeds, fast, medium and slow, which can be adjusted. Each speed has three gears of vibration (fast plus vibration, slow plus vibration and inching vibration). For example, if the weight is set to 10g, the front part of the weight (8G) will use the fast acceleration vibration stage to the rear certain value (S04), enter the slow acceleration vibration stage, and the slow acceleration vibration will stop at the last part of the value (S09). Judge whether the actual weight and the set weight are within the allowable error. If they are within the range, there is no need to jog the vibration. If they are not enough, When the inching vibration feeding is within the error range, stop the vibration and output the feeding signal. The buzzer will sound for a short time. If the weight exceeds the allowable error, the buzzer will alarm for a long time and wait for the inductive blanking signal. After the manual inductive photoelectric switch or the external machine inputs the blanking signal, the motor door will open and close after blanking. At this time, the blanking signal will return to the waiting state, and the blanking can be

carried out only after high-level blanking. The program will continue to enter the next packaging process, and so on

Advanced setting of display controller of 9999 sub assembly machine

In the standby mode, press and hold the set key for 2 seconds to display "p000", enter the password "pxxx", press the OK key to enter the parameter adjustment, press the OK key to automatically save the parameters after adjustment, and press the exit key to exit..

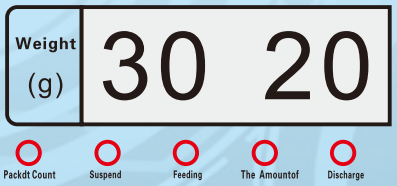
P000 (original 660): vibration output parameter setting (see the table below for details).

P200 (original 550): weighing parameter setting (see the table below for details). Generally, only F12 is used to calibrate the weight value.

P445 (or 102): display 4-digit ABCD, AB -- current fast acceleration vibration speed, CD -- current slow acceleration vibration speed. It is mainly used to press this parameter when debugging the machine. This parameter cannot be adjusted. It is used to observe the current fast acceleration (AB) and slow acceleration (CD) speed to determine the S02, S03 fast acceleration vibration and S07, S08 slow acceleration vibration in the 000 parameter table.

Quick setting method:

For example, at medium speed, adjust item 2 to 0039 and item 7 to 0030. After pressing start, discharge the material for multiple blanking tests, input P102, and observe the current vibration parameters in real time. After a few bags of work. It will be stabilized at a relatively stable number. For example, in the figure below, 30 is fast acceleration, 20 is slow acceleration, item 2 is adjusted to 2535, item 3 is adjusted to 30, item 7 is adjusted to 1525, and item 7 is adjusted to 20. Other gear parameters are added and subtracted according to the actual situation, such as fast 2, 3 and 7, 8 parameters plus 3 respectively.



P444 (or 101): display 4-digit ABCD, a --- automatic blanking (automatically open the door for blanking after material arrival and continue the next packaging). BCD is unknown. It is mainly used for debugging the machine without manual induction. Remember to set it after debugging the machine.