

## **OP 1 : Feedback Control System by TIME/SEC**

**This system can control a filling Machine of a previous production lines based on The user Parameter Setting Points.**

Also This Feedback Control System will be displayed on the main Screen.

When a new article is being entered in the article memory or when the stored article Data/settings of a certain article are being modified,

Feedback Control System work after leaving the Article Interval screen.

Depending on the checkweigher version all parameters shown below or less will Appear on the screen.

For a Example.

- Pulses/g when Feedback Controlling is effected by Transmitting Pulses.  
: When the filling machine works with “1pulse/g” 10pulses are required(and Transmitted from the checkweigher) to compensate for a weight deviation of 10Grams to readjust the filling machine.
- Sec/g when Feedback controlling is effected by means of pulse width modulation.  
: The pulse width,Duration depends on the weight deviation which is to be Compensated for.

If the filling machine`s control requires a variable control factor,  
The feedbackcontrol program is designed such that the checkweigher automatically calculates the suitable control factor and adapt it permanently to the filling behavior of the filling machine.in this case the control factor does not appear on the Article – Feedback control data-input screen and thus cannot be modified by the operator.