

Cleaning the mixer

CAUTION: Mix blade hazard

There are two hazards associated with the mix blades. First, the blades are driven with substantial torque. Never place your hand in the mix chamber unless power (electric and pneumatic) is completely disconnected. Second, the mix blades may become razor sharp. Always be careful when touching or cleaning these blades. Check for sharp edges frequently. Replace blade if a hazard exists.

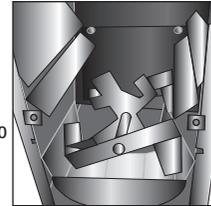
WARNING: This card provides only basic troubleshooting and maintenance information.

Users must be familiar with all safety information and procedures described in the TrueBlend User Guide.

- 1 Disconnect and lockout main power (electrical and pneumatic).
- 2 Open the “quick-release” locks of the mixing chamber access door.
- 3 Remove the batch weigh hopper. This will enable you to clean the mixing chamber and the shut off valve at the bottom of the chamber. You may need to use an industrial vacuum cleaner to fully evacuate the mixing chamber.
- 4 Close the mix chamber access door.
- 5 Restore power by closing the main disconnect switch and reconnecting compressed air.
- 6 Manually run the mixer for a short time to lower the material level. Press Home / More / Setup / Manual Control to run the mixer manually.
- 7 If applicable, open the discharge slide gate at the bottom of the mix chamber.
- 8 Open the mix chamber access door. The safety switch will prevent operation of the mixer with the door open.

>>> **TIP:** If using the optional drain chute with safety interlock, open the front access door, remove the weigh bin, and position the chute to direct material into a bucket or drum rather than the mix chamber.

- 9 In the Home screen, press the More button, then the Setup button. The TrueBlend Setup screen will open.
- 10 Press the More button.
- 11 Press Manual Control to switch to “manual mode.”
- 12 Press on the appropriate material hopper button to open the respective vertical valve.



Removing material

The dispense valve unit is opened and the material runs out of the material hopper through the optional deflector to the collection receptacle.

- 1 Discharge the material completely and clean the material hopper from the top (use the compressed air nozzle supplied if necessary.)
- 2 Press on the appropriate material hopper icon again to close the dosing unit.
- 3 Remove the optional drain chute. (If equipped.)

Shutting off in emergency

- 1 Switch the main switch to off. The power supply is interrupted. If the cone valve was open, it is closed. All other machine movement is stopped immediately. The batch is not finished. The main switch can also be locked manually with a lock.



Restarting after Emergency stop

- 1 Switch the main switch to on.

>>> **Note:** If the metering cycle was interrupted, the material in the weigh bin will empty automatically. This will prevent an incorrect mix ratio.

- 2 Carefully remove the weigh bin to prevent damage to the load cell and empty the bin, if required.

Quick Card

QCB012-0716

TrueBlend Gravimetric Blender SB-3 Control



Signaling alarm message

- The alarm beacon flashes.
- The alarm message is displayed in the lower left corner of the screen as a flashing button.
- The alarm message is displayed as text when the Alarm Button is pressed in the navigation bar.



If a dosing unit does not reach the set weight, production does not continue. The metering attempt is repeated several times (number of attempts can be set). If the required value is not reached, the alarm beacon is activated. The behavior of the controller in the event of an error can be specified in the configuration.

Warn: Alarm message is displayed, but unit continues to run.
-----: No alarm message, unit continues to run without message.
Stop: Alarm message is displayed, unit is stopped.

If a unit stop is set, the triggering alarm must be acknowledged. The alarm message remains visible as long as the error is pending in the controller.

Handling alarm messages

- 1 Press the Alarm button for an overview of all alarm messages.



- 2 Press the ACK button to silence alarms.



>>> **NOTE:** Acknowledging an alarm silences the alarm but does not clear the alarm.



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Alarms

The Alarm button allows the operator to view, silence and acknowledge alarms.

Understanding alarm codes: In front of some alarm messages you may see these designators: Component 1, Component 2, etc. along with alarm text. Component number stands for the component bin that is causing the alarm. It is important to look at the alarm text and check to see if there is a problem with the component bin number listed. For example, the alarm code “Component 2: Out Of Material.” indicates that this problem is occurring because of bin number 2.

There are 3 basic types of alarm codes: Common alarms, material position specific alarms, and loader option alarms. See the **User Guide** for a complete list of alarms.

Common Alarms

Problem	Possible cause	Solution
Mixer Door Open – If the blender door is opened during operation, this alarm will occur. The mixer motor will remain stopped, the cycle is stopped.	The door of the blender has been opened.	Close the safety door.
	Something is not allowing the door to close completely.	Open the door and check for any obstructions.
	Safety interlock switch is triggered.	Check wiring connection to safety switch.
Battery Error – if the battery in the control is defective or discharged, this alarm will occur.	Door is not open, but message still appears.	Check wiring connection to safety switch.
	The battery in the controller has become weak or is dead.	Order a battery from Conair parts. <i>Contact Conair Parts 1.800.458.1960. From outside of the United States, call: 814.437.6861.</i>
Batch Hopper Not Dumping – If the Hopper Empty value is outside the normal range, this alarm will occur.	There is no battery installed.	Follow the instructions in the User Guide for replacing the battery.
	The Empty range is compensated during operation. An exact zero is not required for normal operation.	When the unit starts a new batch, check the operation of the weigh bin. Make sure the bin is empty. Make sure the material sensor is adjusted correctly. See User Guide .
	The weigh bin may be full of material, or mechanically jammed.	Check why the material was not discharged (cone, weigh bin).
	The plunger may be installed incorrectly and pressing into the weigh bin.	Check plunger installation. Correct if necessary.
X20 Slice Failure – If there is a communication problem between the control and the PLC slots, this alarm will occur.	The operating pressure is too low, causing the weigh bin to close too slowly.	Check operating pressure and adjust if necessary to 6 bar (87 PSI).
	The choke check valve for closing the weigh bin is incorrectly adjusted, causing the weigh bin to close too slowly.	Adjust choke check valve correctly.
	During operation, the X2X Network connection between the control and the control board has been interrupted.	Check connections. Check the touch screen controller connection. Check the safety switch contacts.



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>>> **Note:** This alarm also occurs if the mixer door is opened.

Checking functions in manual mode

All mechanical parts can be manually activated with the “Manual Mode” function. If a vertical valve or the mix discharge is opened in manual mode, they are closed automatically by switching the main power switch OFF, by exiting the Manual Control screen, or if the power fails.

- 1 Make sure the safety door is closed.**
- 2 From the Home screen, press the More button, then the Setup button.** The TrueBlend Setup screen appears. 
- 3 Press the More button, then the Manual Control button.** Now you can operate the material hoppers, weigh bins, mixers, and discharge slide gate if supplied. 
- 4 Press each button to check that the alarm beacon and horn operates.** These devices are located on the door of the electrical power box. Press the button again to deactivate. 
- 5 Check the material hoppers by pressing the hopper buttons in sequence** to check that the various material hoppers valves can be opened and closed.
- 6 Check the weigh bin by pressing the button beside the weigh bin icon to open and close the weigh bin.**
- 7 Press the Mixer button to switch the mixer on and off.**
- 8 Press the bottom button to open and close the optional discharge slide gate.** (Only functions when a pneumatic discharge slide gate is installed.)
- 9 While the blades are rotating, open the safety door.** The blades should immediately stop. When you open the door, a screen should appear, indicating an alarm condition. This screen mask will only be closed when all actions have been completed.
- 10 Close the safety door.** The mixing blades rotation can be tested again.