

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 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 Open the “quick-release” locks of the mixing chamber end cover and remove it.
- 2 Once the material compartment has been cleaned, remove the deflector. This will enable you to clean the mixing chamber and the shut off valve at the bottom of the chamber. You may need to run the mixing agitator for a short time to fully evacuate the mixing chamber. If not necessary, skip to step 6.
- 3 Close the mix chamber access door.
- 4 Restore power by closing the main disconnect switch.
- 5 Manually run the mixer for a short time to lower the material level. Refer to “Checking functions in manual mode” to see how to run the mixer manually.
- 6 If applicable, open the discharge slide gate at the bottom of the mix chamber.
- 7 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.

- 8 In the “Overview” screen, press the TrueBlend icon. The TrueBlend status screen will open.
- 9 Press the  button to open the “Settings” screen.
- 10 Press  to switch to “manual mode.”
- 11 Press on the appropriate material hopper icon 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.

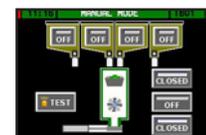
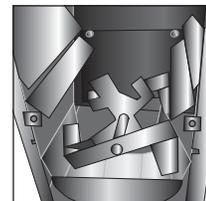


Restarting after Emergency stop

- 1 Switch the main switch to on. If switching on within two minutes of stop, the unit continues the interrupted process. This function is used to keep downtime in the event of a short power interruption as short as possible. The screen that was last open before switching off or power failure is opened. If switching on after more than two minutes, the internal functions are completely reset. The start screen will appear.

>>> **Note:** If the metering cycle was interrupted, the material in the weigh bin must be removed manually before restarting. See step 2 if necessary. This will prevent an incorrect mix ratio.

- 2 Remove the weigh bin carefully to prevent damage to the load cell and empty it. (Only necessary if the metering cycle was interrupted.)



Quick Card

QCB003-0512

TrueBlend Gravimetric Blender SB1 Control

Software Version 2.9.1



Signaling alarm message

- The alarm beacon flashes.
- The alarm message is displayed in the top right corner of the screen as a warning triangle.
- The alarm message is displayed as text when  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  for an overview of all alarm messages.
- 2 Press  to clear alarms.
- 3  Silences an active alarm but does not clear it.



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Alarms

Understanding alarm codes: In front of some alarm messages you may see these designators: C1, C2, C3, C4, C5, C6, along with alarm text. C stands for component and 1,2,3,4,5, and 6 refer to the 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 “C2: Too little Mat.” 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
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.	The battery in the controller has become weak or is dead.	Order a battery from Conair parts.
	There is no battery installed.	Follow the instructions in the User Guide for replacing the battery.
Tare Wrong – If the tare value is outside the normal range, this alarm will occur.	The range that can normally be compensated is -50 to 100 g. If the tare value is outside this range, it will alarm.	When the unit starts a new batch, check the operation of the weigh bin. Make sure the bin is empty. Perform a zero calibration. 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.
	The “No Slave” error occurred first, and the sale value remains at the last valid value.	Check CAN connection. (See “No Slave” error/ check safety switch.)
	The operating pressure is too low, causing the weigh bin to close too slowly.	Check operating pressure and adjust if necessary to 6 bar.
	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.
No Slave or Slave Disconnected – If there is a communication problem between the control and the control board, this alarm will occur.	During operation, the CAN connection between the control and the control board has been interrupted.	Check connections. Check the touch screen controller connection. Check the I/O board connection. If the connections are ok, replace either the I/O board or the controller. Check the safety switch contacts.



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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 or if the power fails.

- 1 Make sure the safety door is closed.**
- 2 From the “Overview” screen, press the TrueBlend icon.** The TrueBlend status screen appears.
- 3 Press .** The “Settings” Screen appears.
- 4 Press  to start manual mode.** Now you can operate the material hoppers, weigh bins, mixers, and discharge slide gate if supplied.
- 5 Press and hold the  button** to check that the alarm beacon and horn operates. These devices are located on the door of the electrical power box.
- 6 Check the material hoppers by pressing the hopper “OFF” buttons in sequence** to check that the various material hoppers valves can be opened and closed.
- 7 Check the weigh bins by pressing the first button beside the weigh bin icon to open and close the weigh bin.**
 or 
- 8 Press the middle button to switch the mixer on and off.**
 or 
- 9 Press the bottom button to open and close the optional discharge slide gate.** (Only functions when a pneumatic discharge slide gate is installed.)
 or 
- 10 Test the safety interlock switch by pressing the OFF or ON button to the right of the mixer icon.**
- 11 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.
- 12 Close the safety door.** The mixing blades should begin to rotate again.

