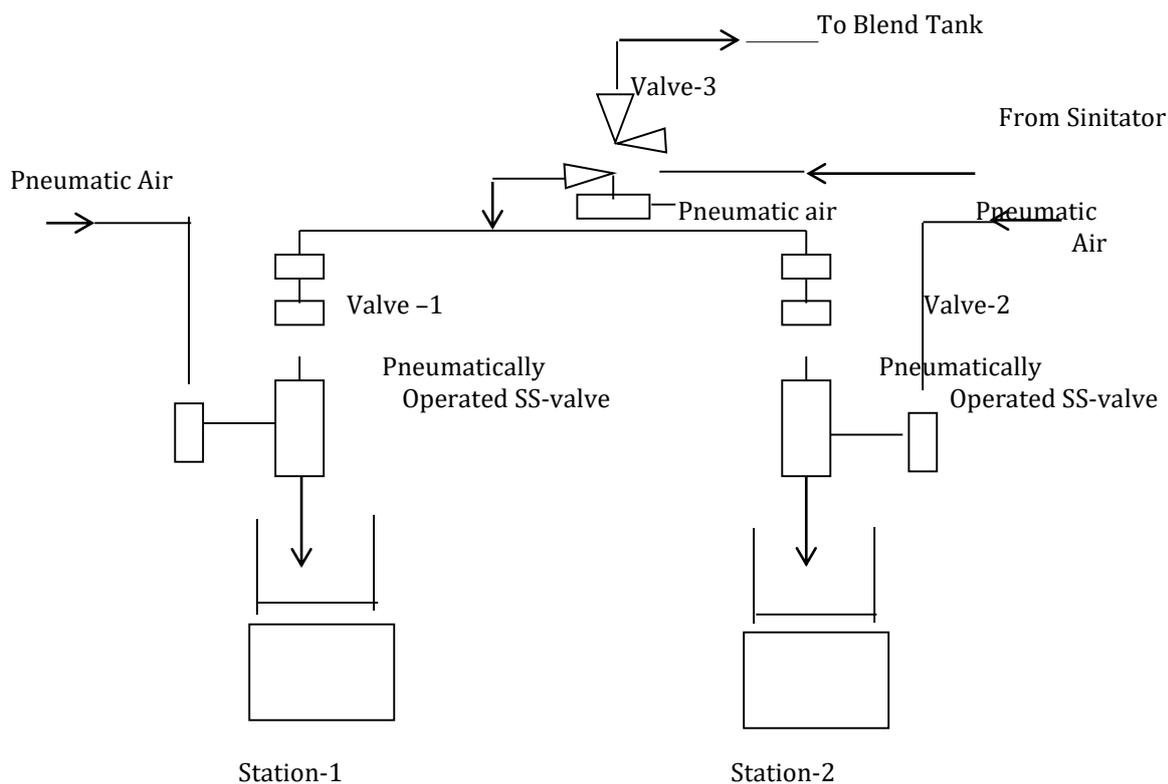




## Twin Head Filling Station – Manual Loading

The Twin Head Filling Station is a Bag in Box filler to Pack Shortening / Margarine in 5-25 Kg Boxes. The Twin Head Filling Station shall be a load cell based filling system with Programmable Weighing Controllers based control panel for the automation of weighing and packing of Bakery Shortening / Margarine with 2 weighing stations/Platforms each capable of weighing up to 25 kgs with least count of 05 grams.

### LOGIC FOR TWIN HEAD FILLING STATION FOR SHORTENING / MARGARINE



### Operational Logic

1. Since the flow from the Sinitators cannot be reduced or stopped, the total flow needs to be discharged at either Station 1 or Station 2 or return back to the Remelting Section
2. At the time of filling, initially Valve - 1 of Station - 1 opens and filling starts up to 85% of set weight whereas Valve - B of Station - 2 remains closed.
3. On reaching 85% of weight on Station - 1, Valve - 2 of Station - 2 opens and filling on both Stations - 1 & 2 continues simultaneously. The flow through Station A can be controlled by adjusting the flow during fine fill.
4. Once set weight is achieved on Station - 1, Valve - 1 closes and total flow will continue to Station - 2.
5. Same cycle of logic continues for Station - 2 to 1 as stated under Sl.No.2 above.
6. If there is no flow through Valve - 1 & 2, Valve - 3 opens to maintain circulation.
7. In the Manual Loading Filling Station, the operator will need to push the filled box for further packaging and load the station with a new empty box before the filling in Station 2 is complete.





<b>TECHNICAL SPECIFICATIONS FOR PLC BASED ELECTRONIC TWIN HEAD FILLING SYSTEM</b>	
Configuration	Twin Head Filling Station with common Feed Line with individual Feed Control Valves and Bypass Valve.
Capacity	Design : 25 Kg
Weighing Method	Gross [ with container ] or Net [ without container ] Programmable
Resolution	05 gms
Weighing Accuracy	+ / - 10 gm to +/-20 gm [depends on filling speed ]
Feed	From constant flow rate feed pump
Feed Control	pneumatically operated valve
Platform	SS-platform with Roller Conveyor
Bag in Box Positioner	Provided
Sensor	
Load Cell	High Precision Beam Type Load Cell; Cap:50/75 kg
Electronics	Programmable Batch Controller
	IT8000E Basic Unit For W&M Terminal Approved Weighing - Panel Mount with ADM analog scale interface module + I/O module, PIM with 2 digital inputs (24VDC) and 2 digital outputs
Displays	Weight, Batch Totalizer and Weight Totalizer and text message display for status
Indications	Coarse Feed, Fine Feed & Ready [ text message ]
	Operator Interface for setting :
Settings	Tare Weight
	Batch Weight
	Fine Feed Margin
	In-flight correction
	Zero Margin
	Totalizer Reset
External Input	1. Provision for External Auto Start / Stop.
	2. Bag in Box Position sensor. [ optional ]
Control outputs	Relay change over contacts for :
	Coarse Feed for individual filling line Valves
	Fine Feed for individual filling lines valves
	Bypass line Valves
	Filling over / ready status.
Indications [ common]	Power on
	Bypass
	Auto / manual
Indications [Individual]	Position
	Fill
	Ready
Selection[Common]	Auto / Manual
Interlock	For opening Bypass valve if both Filling Stations are full [ or ] if there is no container in either of the Filling Platforms.
Power Supply	230 VAC
Air Supply	5 Kg / sq.cm Instrument Quality Air for Pneumatics.





## Machine Dimensions

