

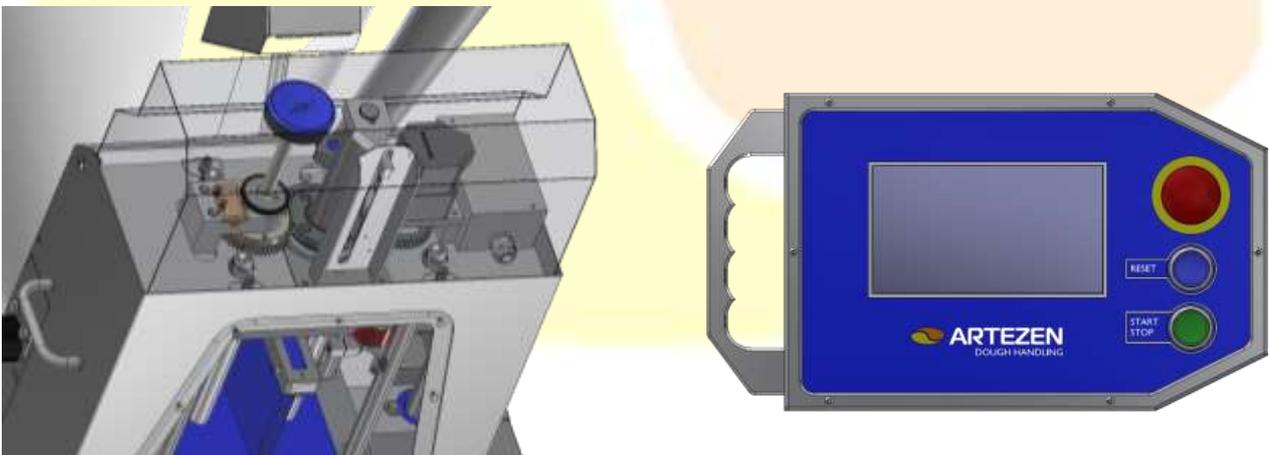
VOLUMETRIC DIVIDER

CALYBRA HD L

MANUAL FOR THE USE OF THE TOUCH SCREEN OPERATOR PANEL

TRANSLATION OF THE ORIGINAL INSTRUCTIONS

Document Code MAHD2 en 1



**Read this instruction manual carefully before
installing and using the machine**

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TABLE OF CONTENTS

1.	INTRODUCTION	3
1.1	General warnings	3
1.2	Using the manual	3
1.3	Consultation of the manual.....	3
1.4	Using of symbols	4
1.5	Consignees of the instruction manual	4
1.6	Normal rules	4
1.7	Password.....	4
2.	INSTALLATION.....	5
2.1	Use of the control panel	5
2.2	Description of the control panel.....	5
3.	DESCRIPTION OF THE FUNCTIONS	7
3.1	Workpieces conter.....	7
3.2	Oil temperature.....	8
3.3	Flour duster	9
3.4	Viewing any connection with Lybra	10
3.5	Details of the recipe being processed	10
3.6	Access to the recipes list.....	11
3.7	Access to the production plan	13
3.8	Adjustment dividing weight.....	17
3.9	Spped capacity	18
3.10	Outfeed belts speed	19
3.11	Saving.....	20
3.12	Cleaning operations	22
4	START THE PROCESS	23
4.1	Start and handling of process (recipe)	23
4.2	Change process (recipe)	24
4.3	Add a new process (recipe).....	25
4.4	Edit of an exhisting recipe	28
4.5	Cleaning cycle	30
4.6	EMERGENCY STOP	39
4.7	Internal set up parameters	41
4.8	Area reserved for installers	47
5	TROUBLE SHOTTING	48

1. INTRODUCTION

1.1 General warnings

This manual is an integral part of the MANUAL FOR USE AND MAINTENANCE “MAHD1_it/en” of the CALYBRA HD volumetric divider and specifically concerns the use of controls and operator interface software; therefore, before starting to use the machine it is necessary to have read and understood the contents of the main manual, especially (but not only) because it contains the necessary information for the correct and safe use of the machine.

This instruction manual is to be considered as a complement to the main manual “MAHD1_it/en” that accompanies the machine.

In case of non-observance of the contents of the main manual and of this manual, both by the user and by the technician in charge of the installation, Artezen Srl declines all responsibility and any accident and/or anomaly that may arise cannot be attributed to Artezen Srl.

The manufacturer declines all responsibility for possible inaccuracies contained in this manual, due to errors in transcription or printing. It also reserves the right to make any changes to the product that are deemed useful or necessary, without affecting the essential characteristics.

IMPORTANT

The CE Declaration of Conformity of the machine is included in the main manual.

1.2 Using the manual

The main manual and this manual must be read carefully and understood in all their parts before performing any operation with/on the machine.

In case of doubts about the correct interpretation of the instructions contained in the manuals, please contact the Manufacturer for the necessary clarifications.

1.3 Consultation of the manual

The manual must be consulted before installation at the workplace, before it is switched on for the first time and before it is used.

The manual must be consulted from the first chapters, in order to ensure correct installation and use, up to the last paragraphs, making sure that you have understood its contents.

1.4 Using of symbols

In order to draw the users' attention to the correct and safe use of the machine, the following graphic symbols are used in this manual.

	<p>NOTE! The symbol is used to catch attention to important information.</p>
	<p>CAUTION! The symbol is used to indicate danger to people or situations that may cause damage to the machine or affect the make-up process quality of the product.</p>
	<p>BAN! The symbol is used to indicate prohibited actions.</p>

1.5 Consignees of the instruction manual

Refer to the "MAHD1_it/en" manual in chapter 2.

1.6 Normal rules

Refer to the "MAHD1_it/en" manual in pharagraph 1.2.

The following prohibitions apply to employees:

The machine must not be operated with parameters other than those set by the manufacturer and determined by the purchase contract.

It is possible to request, by written communication to the manufacturer, the modification of these parameters, only after verification by the technical staff of the manufacturer.

The user is responsible for any damage resulting from failure to comply with the operating conditions set out in this manual;

The characteristic data labels must not be removed or tampered with.

1.7 Password

PASSWORD		
User password for managing recipes / work programs / save	pw	5 1 1

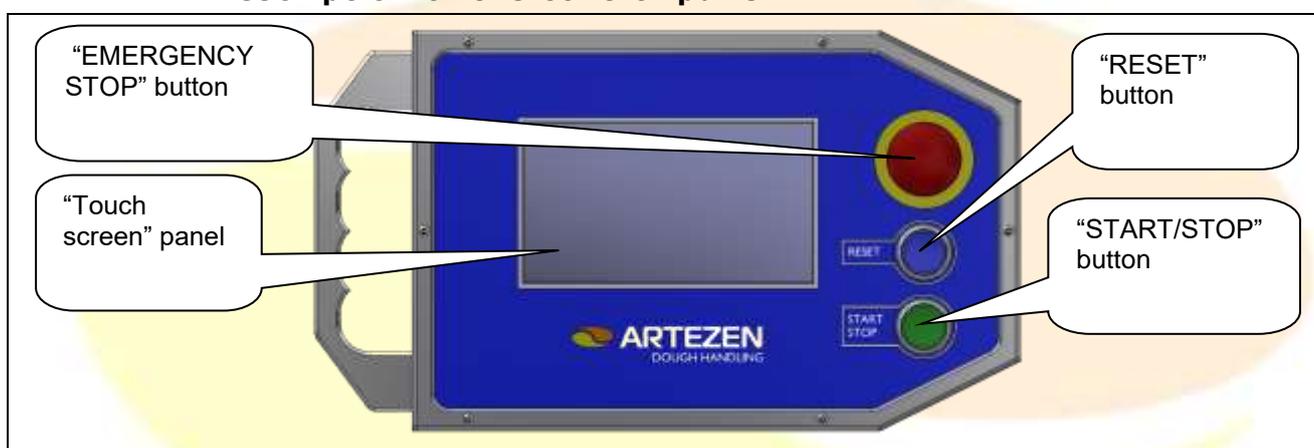
2. INSTALLATION

2.1 Use of the control panel

The "touch screen" digital control panel is used by lightly pressing with the fingertip, near the button corresponding to the various functions that the panel proposes, according to the availability of operations that can be enabled in the state in which the machine is at that moment.

	<p>NOTE!</p> <p>Use your fingertips to select the various functions.</p>
	<p>ATTENTION!</p> <p>NEVER use sharp objects, ballpoint pens, knives, or anything else to make the selection.</p>

2.2 Description of the control panel



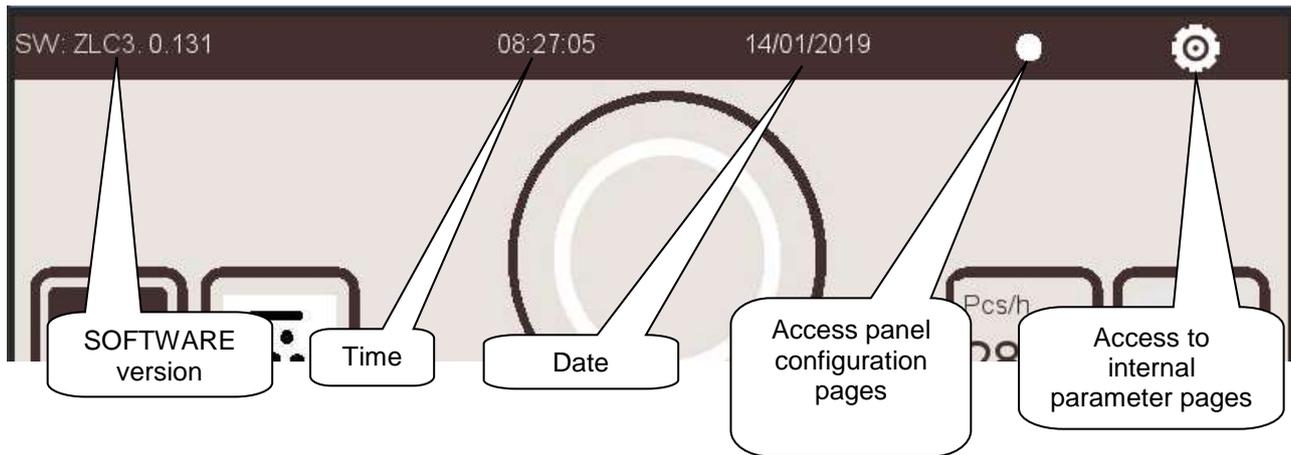
Press the "RESET" button to start the machine, the HOME screen will appear.

Pressing the "RESET" button is necessary to restart the machine every time:

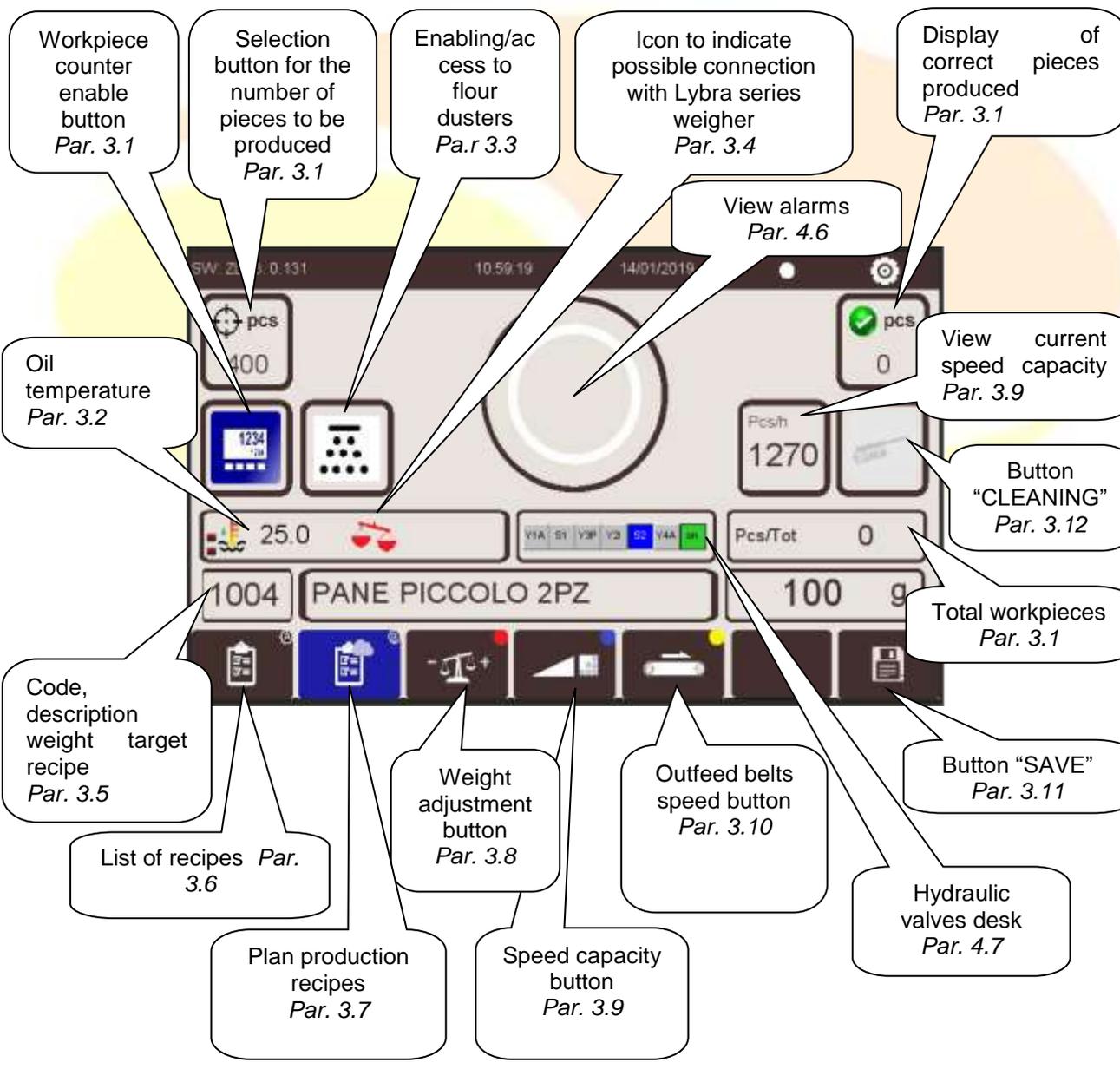
- Turning on the machine
- Operation is restarted after an emergency stop (by pressing the "EMERGENCY STOP" button, sensorised door opening, hopper protection intervention, thermal motor protection intervention, etc.)



• **Panel heading**

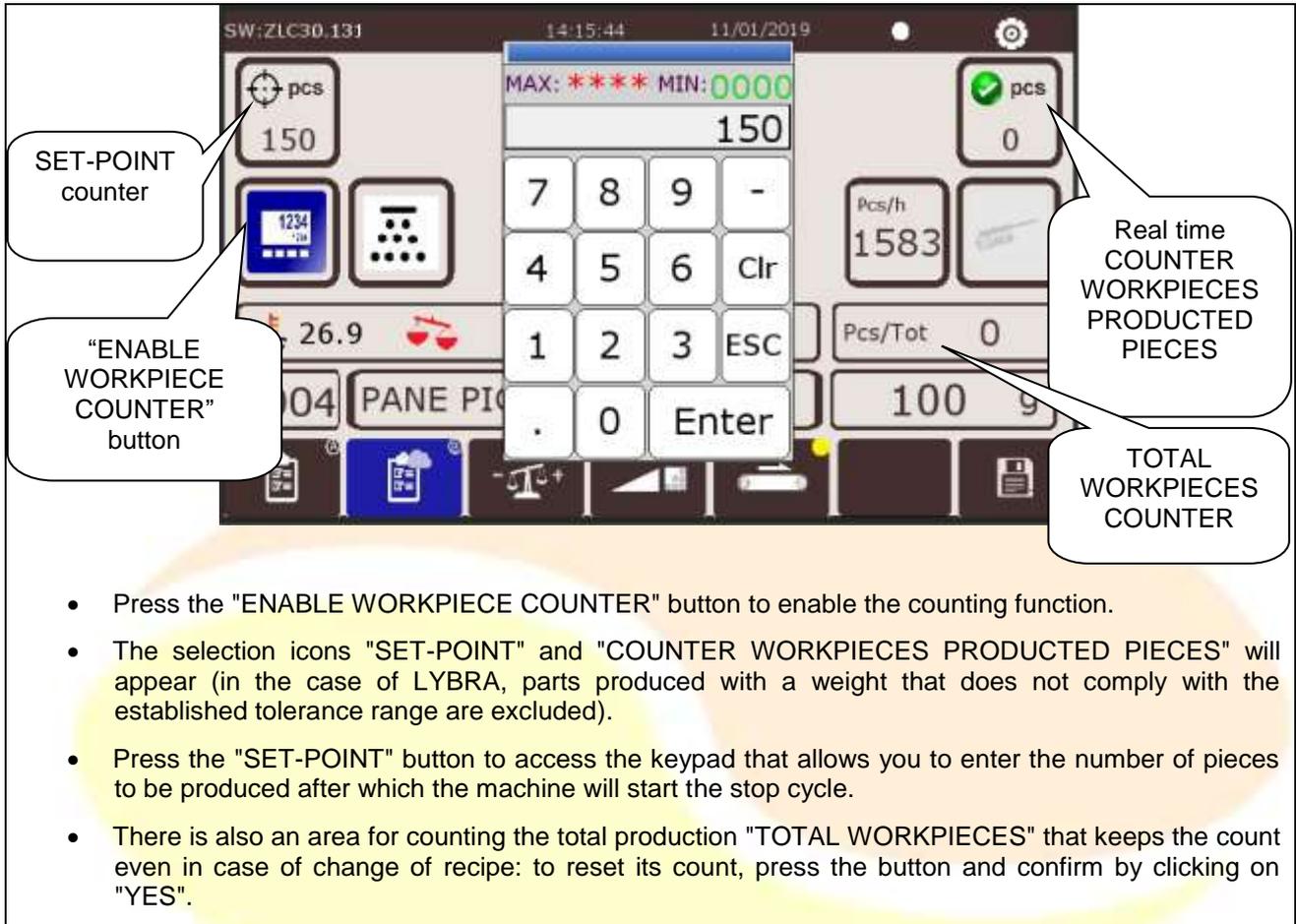


• **Conteints main page of the panel**



3. DESCRIPTION OF THE FUNCTIONS

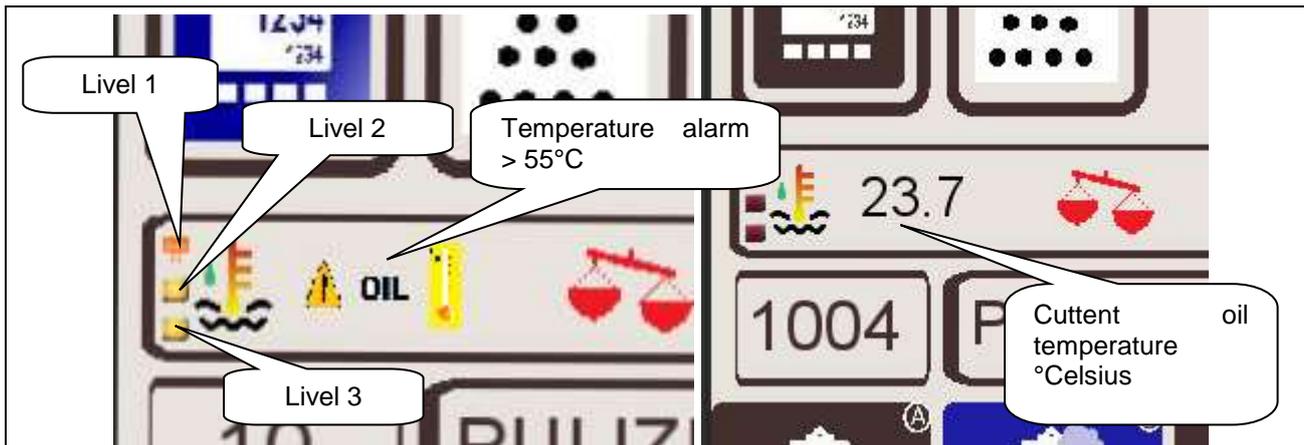
3.1 Workpieces conter



The screenshot shows the touch screen interface for the workpieces counter. It features a central keypad with numbers 0-9, a decimal point, and an 'Enter' key. To the left, there is a 'SET-POINT counter' displaying '150' and a button labeled '1234'. To the right, there is a 'Real time COUNTER WORKPIECES PRODUCED PIECES' displaying '0' and a 'TOTAL WORKPIECES COUNTER' displaying '100'. The screen also shows 'Pcs/h' (1583) and 'Pcs/Tot' (0). A callout box on the left identifies the 'ENABLE WORKPIECE COUNTER' button. The top of the screen displays 'SW: ZLC30.13J', '14:15:44', and '11/01/2019'.

- Press the "ENABLE WORKPIECE COUNTER" button to enable the counting function.
- The selection icons "SET-POINT" and "COUNTER WORKPIECES PRODUCED PIECES" will appear (in the case of LYBRA, parts produced with a weight that does not comply with the established tolerance range are excluded).
- Press the "SET-POINT" button to access the keypad that allows you to enter the number of pieces to be produced after which the machine will start the stop cycle.
- There is also an area for counting the total production "TOTAL WORKPIECES" that keeps the count even in case of change of recipe: to reset its count, press the button and confirm by clicking on "YES".

3.2 Oil temperature



- In the "OIL TEMPERATURE" field, the oil temperature of the hydraulic system is displayed in real time, expressed in °Celsius
- There are ranges, suitably indicated on the display, in which the machine behaves accordingly to the temperature reached. Below is the table of signals:

SIGNAL	TEMPERATURE	CONFORMANCE
	Level 1 when the oil reaches and exceeds 45°C:	The machine automatically starts the second heat exchanger
	Level 2: when the oil reaches and exceeds 55°C:	The first signal of pre-alarm lights up but the machine continues to work normally
	Level 3: when the oil reaches and exceeds 65°C:	The second signal of alarm lights up and the machine starts the cooling mode, which reduces the operating speed to facilitate the cooling of the oil.
	Level 4: when the oil temperature is below 10°C:	The alarm involves blocking the machine: below this temperature the viscosity of the oil is too high to guarantee the correct flow to the hydraulic actuators so that the machine cannot be started up.

- Conversely, when each signal goes out, the machine will resume its normal working status.
- For details about cleaning of heat exchangers to guarantee the original cooling of the hydraulic oil, refer to the "MAHD1_it/en" machine user manual.

3.3 Flour duster

The machine is designed to accommodate two flour dusters, which can be installed on the left side of the machine (see position 1°, front view) or on the right side of the machine (see position 2° front view), independently by the unloading side, left or right, on which is configured the machine.



- Press "FLOUR DUSTER" to access the appropriate adjustment page.
- The following window opens where you can set the working speed of each single flour duster installed, expressed in units from 0 to 100, and the time, expressed in seconds, at the end of which, if the divided dough is finished, it stops automatically.

1° 026

2° 016

Stop Duster No Dough 010 S ESC

Move the cursor to adjust the speed

By pressing "+" e "-" buttons you can adjust carefully the speed

MAX: 0999 MIN: 0000 026

15

7 8 9 - +

4 5 6 Clr 016

1 2 3 ESC

. 0 Enter

Stop Duster No Dough 15 S ESC

Press on the box to open the keypad and set the time in seconds after which the flour duster stops if no dough is passed on the outfeed belts.

3.4 Viewing any connection with Lybra



Icon communication with LYBRA

- If the “” icon is active, the feedback system will automatically correct the weight according to the control logic set in the "LYBRA".

3.5 Details of the recipe being processed



Recipe code

Name recipe

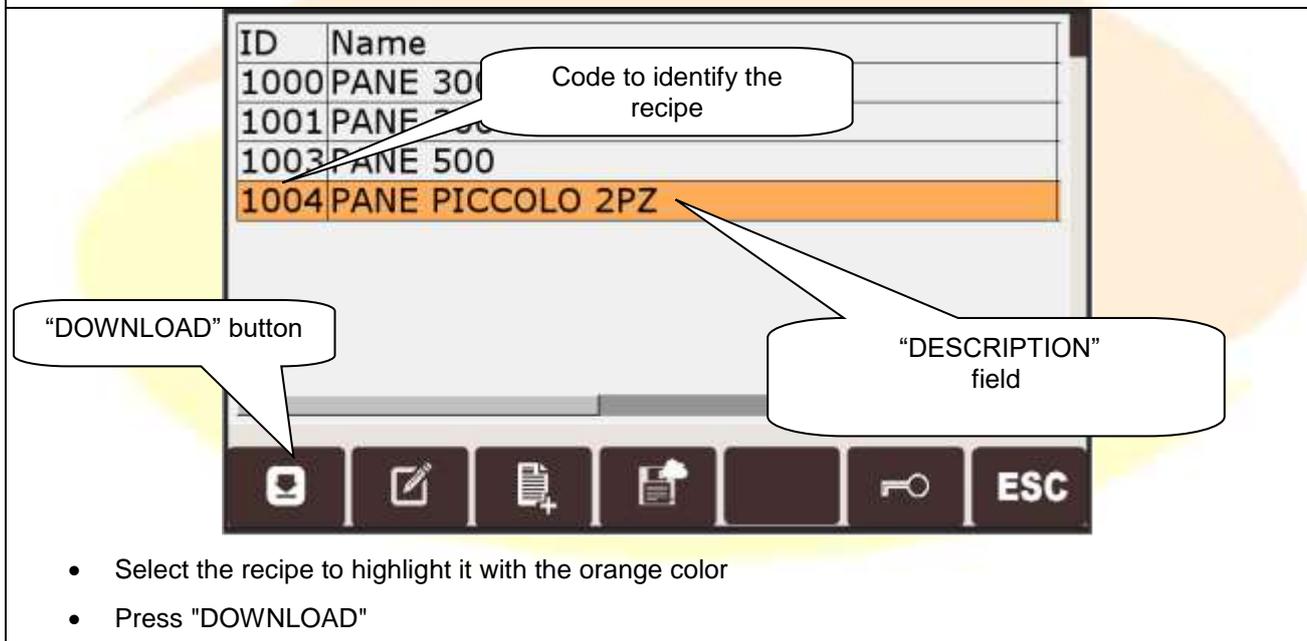
Nominal dividing weight recipe

- In the three adjacent fields are displayed the basic information of the recipe loaded during processing useful for immediate recognition by the user
- The CODE is particularly important for the management of the ARTEZEN CONNECT application specified in the dedicated manual "MAHD3_it/en".
- The name or description is useful for the immediate recognition of the product loaded during processing
- The nominal dividing weight is useful as a reminder for instinctive control and especially in case of communication with LYBRA

3.6 Access to the recipes list



- By pressing the “RECIPES” button, you can have access at the list of stored recipes



At the end of the loading of the recipe, if the recipe foresees the single or double splitting, which requires the manual setting of the dough release rollers, the adjacent screen is displayed: the machine will be allowed to start only after the mobile device has been correctly positioned.

Move the handle to the correct position, on the bases of the direction of the arrow.



After loading the recipe, if the recipe requires single or splitted division, requiring manual setting of the single or double selection lever, the adjacent screen is displayed: the machine can only be started after the mobile handle has been rotated correctly.

Rotate the lever to the correct position, on the bases of the direction of the arrow.

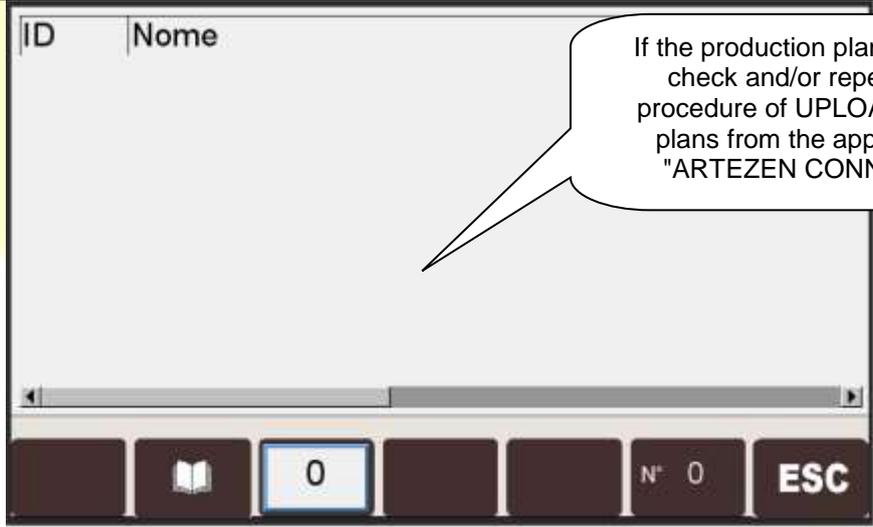


3.7 Access to the production plan

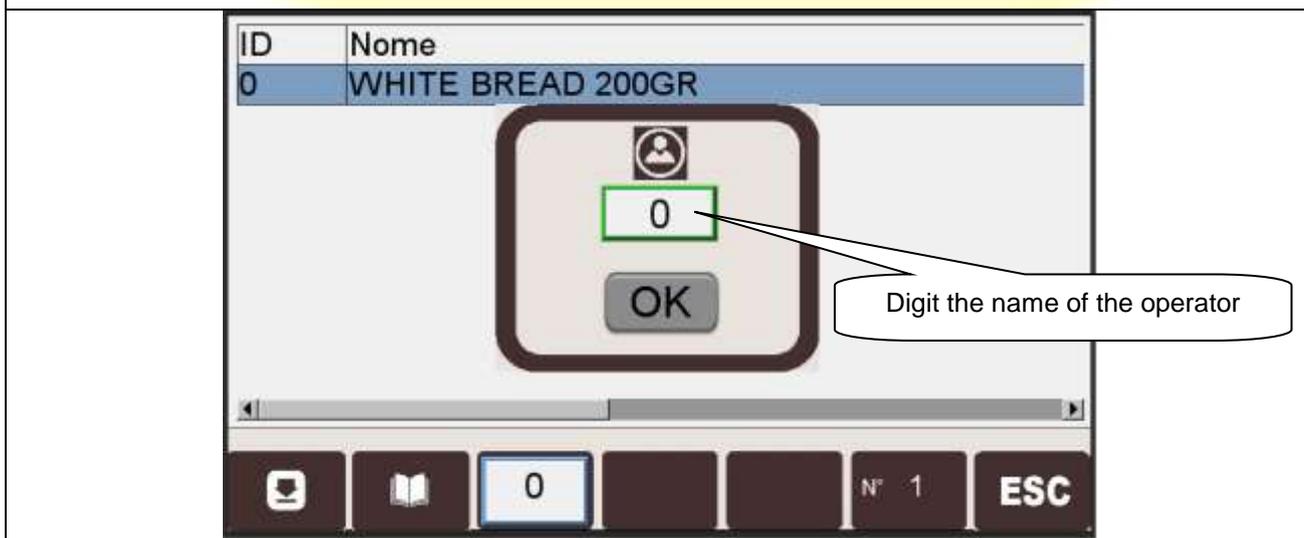
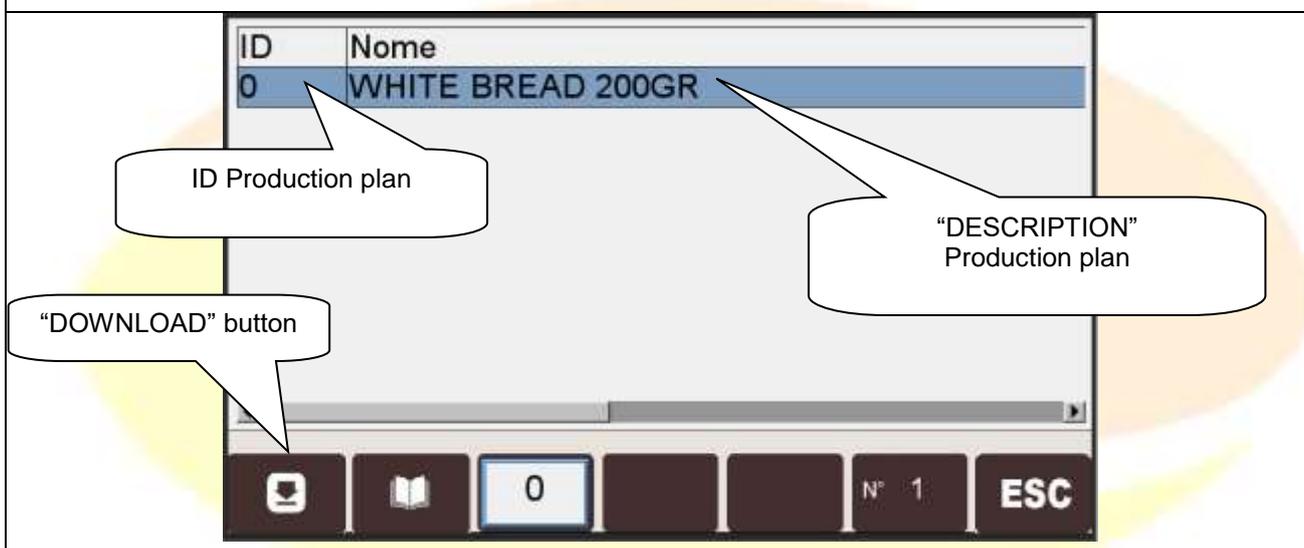
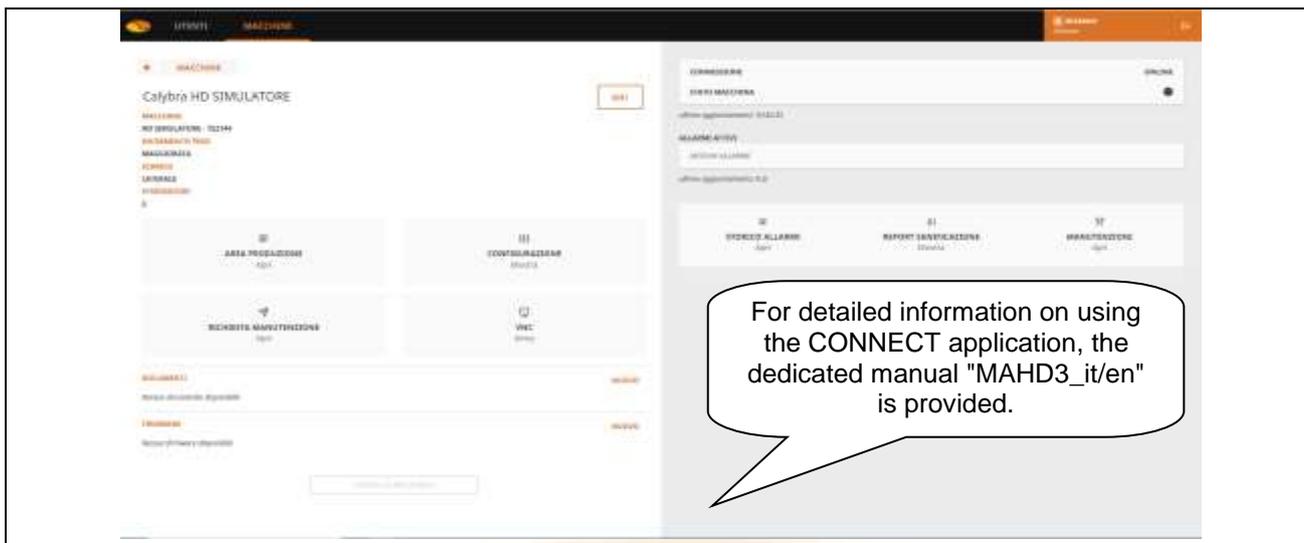


"PRODUCTION PLAN" button

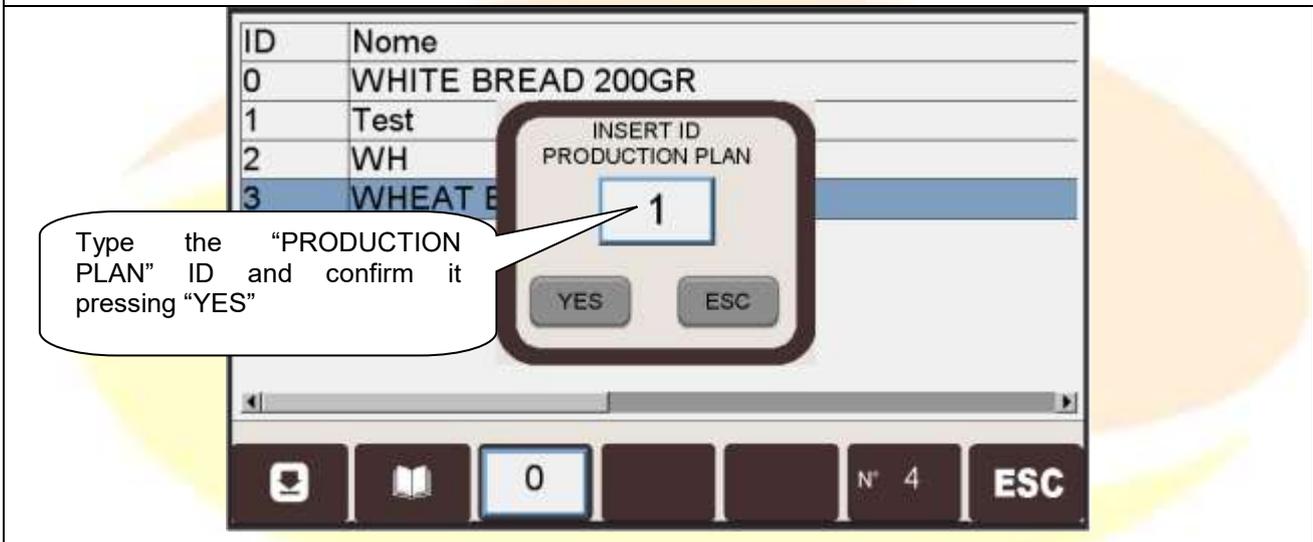
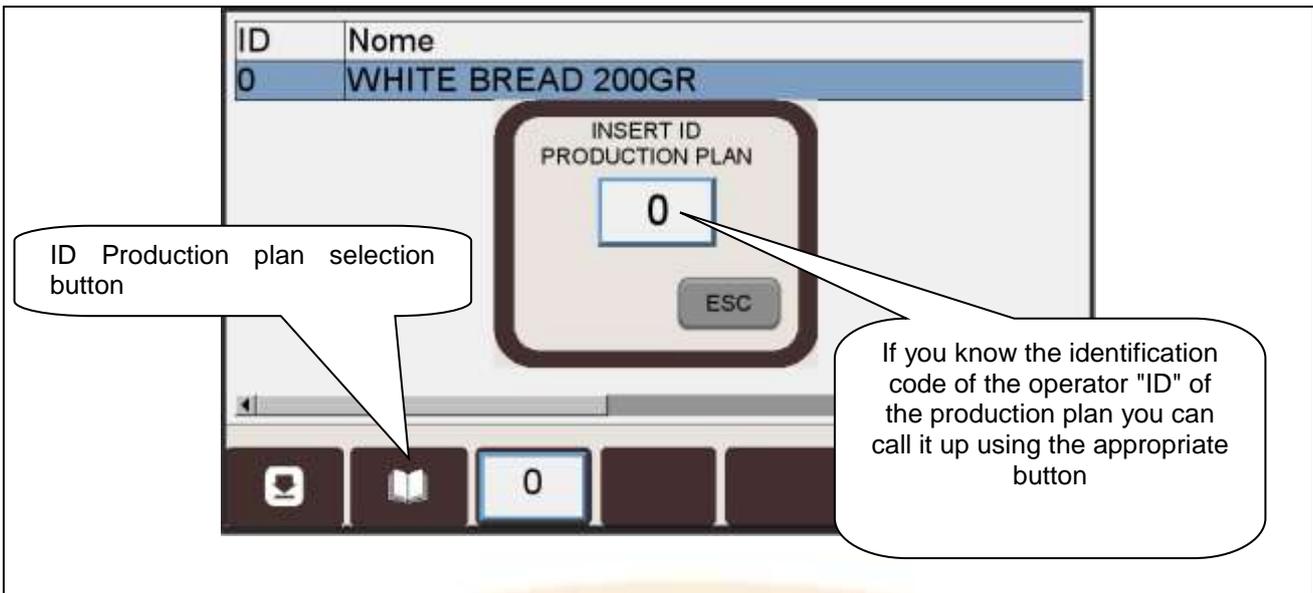
- The button allows access to the list of production plans present in the telematic application "ARTEZEN CONNECT".
- The production plan is useful for example to establish in advance the number, quantity and type of work to be carried out daily, so for example the production plan could be created weekly for daily production, numbering the different daily plans from 1 to 7.
- Press the button to enter the production plan selection area



If the production plan is blank check and/or repeat the procedure of UPLOAD of the plans from the application "ARTEZEN CONNECT".



- Press DOWNLOAD to load the production plan
- The name of the operator is requested and then it will be saved in the production plan once completed.



- After loading the recipe, the possibility of saving or accessing other recipes will not be granted during all the current production process.



The screenshot shows a touch screen interface with the following elements:

- At the top, a field labeled "ID" contains the number "3".
- To the right of the "ID" field, a larger field labeled "NAME" contains the text "WHEAT BREAD 300GR".
- Below these fields is a row of control buttons: a button with a book icon, a button with the number "0", a button with a trash can icon, a button with "N° 4", and a button with "ESC".

Callout boxes provide the following descriptions:

- "REACIPE" currently loaded (pointing to the "NAME" field)
- "PRODUCTION PLAN" button (pointing to the book icon button)
- "TRASH", button, to cancel the current process already completed from the "PRODUCTION PLAN" (pointing to the trash can icon button)
- Number of processes to be completed (pointing to the "N° 4" button)

At the end of the loaded process, after stopping the machine by "STOP" button, it will be possible to press the "TRASH" button to remove the newly completed RECIPE from the "PRODUCTION PLAN".

3.8 Adjustment dividing weight

The image shows two screenshots of the Calybra HD touch screen interface. The top screenshot displays the main control panel with various buttons and a central dial. A callout points to a button labeled "ADJUSTMENT WEIGHT". The bottom screenshot shows a detailed view of the weight adjustment screen, which includes a red bar with a scale, a green 'K' button, and an 'ESC' button. Callouts explain the functions of the '-' and '+' buttons (adjusting the dividing weight by 5 grams) and the 'K' button (resetting the specific weight).

“ADJUSTMENT WEIGHT” button

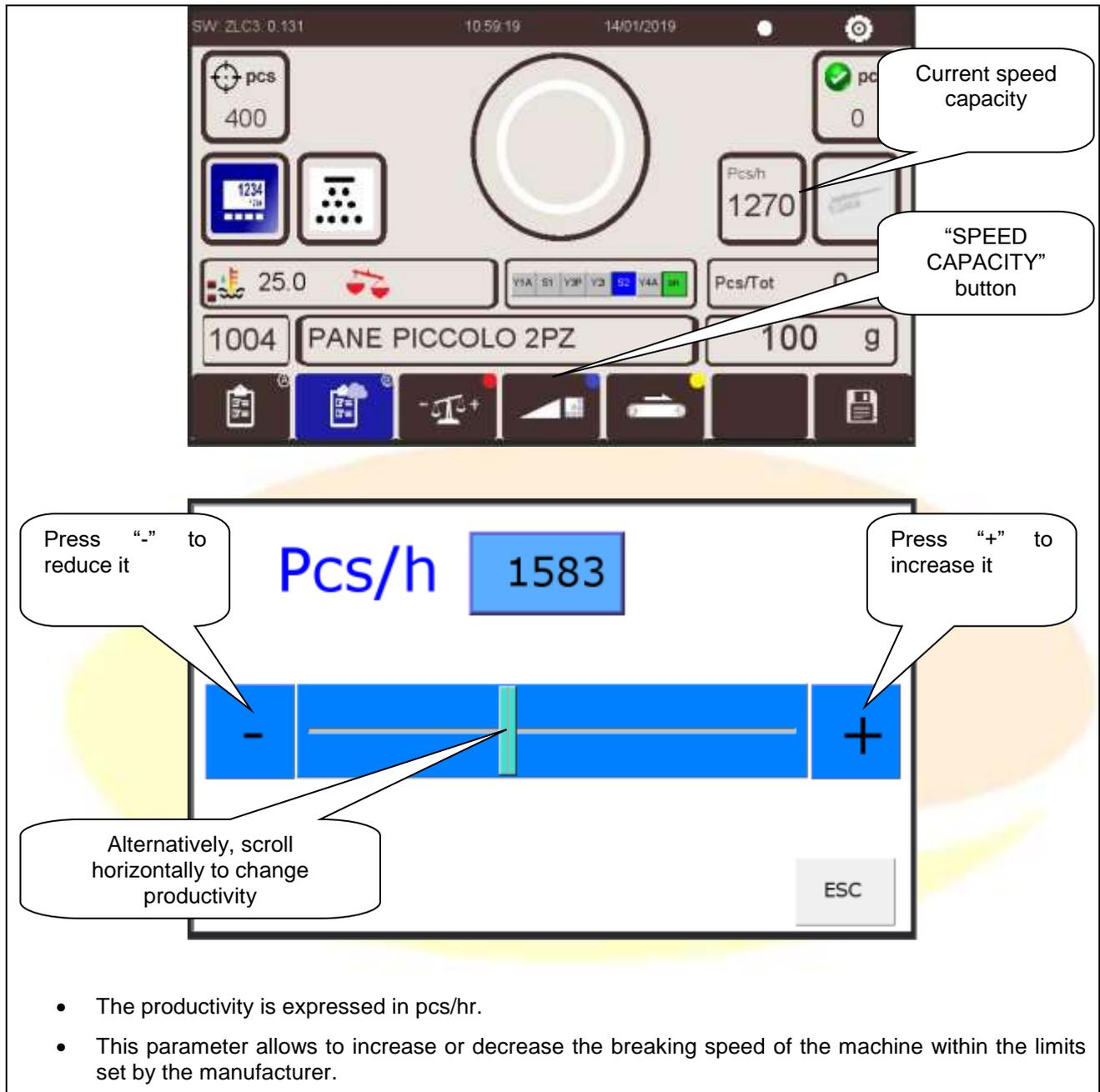
Press “-” to reduce the dividing weight 5 grams.

Press “+” to increase dividing weight 5 grams.

Press “K” to reset the specific weight at the original one

- The "K" coefficient restoration function is especially useful in the case of a particularly long dividing process which, in order to compensate for the proving of the dough, induces the operator to make subsequent weight corrections during the production process, thus modifying the original set up of the machine. Pressing button "K" will restore the original set up to start a new cycle of dividing with fresh dough.

3.9 Speed capacity



SW: ZLC3.0.131 10:59:19 14/01/2019

pcs 400

1234

Pcs/h 1270

25.0

Y1A Y1B Y2 Y3 Y4A

Pcs/Tot 0

1004 PANE PICCOLO 2PZ 100 g

Current speed capacity

“SPEED CAPACITY” button

Press “-” to reduce it

Pcs/h 1583

Press “+” to increase it

Alternatively, scroll horizontally to change productivity

ESC

- The productivity is expressed in pcs/hr.
- This parameter allows to increase or decrease the breaking speed of the machine within the limits set by the manufacturer.

3.10 Outfeed belts speed

The machine can be configured with:

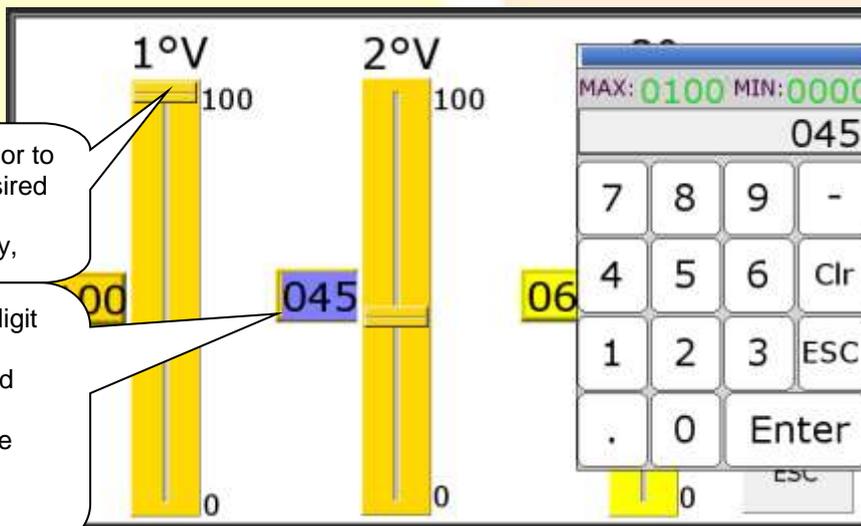
- a single internal flat belt and a single external swivel outfeed belt;
- a pair of belts arranged in a "V" pattern on the inside, and a single swivelling external outfeed belt

Depending on the configuration of the machine, the different selections will be available, in order to define the different speeds and manage them



"OUTFEED BELTS ADJUSTMENT" button

individually.



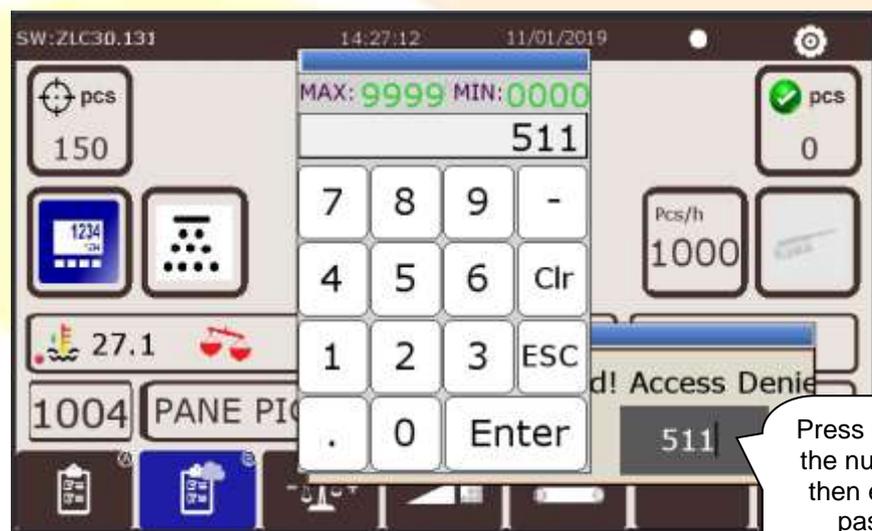
Scroll the cursor to select the desired speed or alternatively,

...click on the digit to display the numeric keypad from which to directly type the value

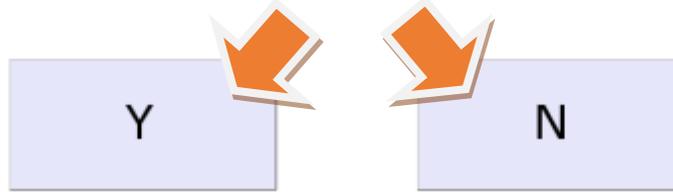
- The figures given are in percent at the maximum outfeed belts speed determined by the manufacturer.
- The speed of the belts must be chosen in such a way as to guarantee:
 - Unload othe pieces of dough at a constant frequency
 - Ensure the physical separation of two contiguous pieces

3.11 Saving

- The "SAVE" button is used to save a recipe after processing with manually entered parameters or after modifying an existing recipe.
- Put the machine in the STOP state, by pressing the dedicated button, and proceed as follows



Press YES/NO to confirm it or to exit



Press "SAVE" to confirm it



3.12 Cleaning operations

- The operations in paragraph 4.5 dedicated to the cleaning cycle are specified



4 START THE PROCESS

4.1 Start and handling of process (recipe)

- From the main screen choose the "RECIPES" button to access the global list of recipes

The screenshot shows the recipe selection interface. At the top, there are status indicators for 'SW: ZLC3.0.131', '10:59:19', and '14/01/2019'. Below this, there are several control panels including 'pcs' (0), 'Pcs/h' (1270), and 'Pcs/Tot' (0). The main display area shows a table of recipes:

ID	Name
1000	PANE 300 1PZ
1001	PANE 300 2PZ
003	PANE 500
004	PANE PICCOLO 2PZ

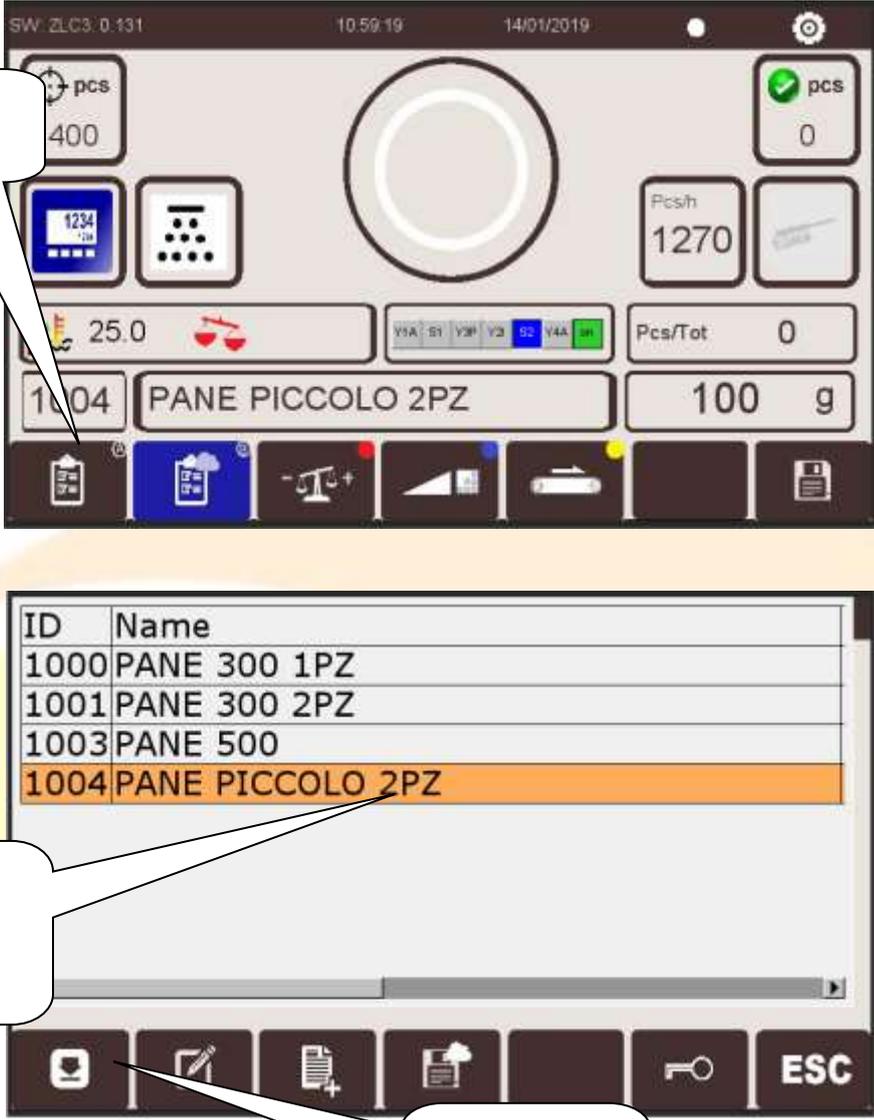
At the bottom of the screen, there is a row of buttons: 'EDIT', 'ADD', 'LOAD FROM PRODUCTION PLAN', 'SERVICE', and 'ESC'. Callout boxes provide the following descriptions:

- "RECIPES" button: Points to the 'RECIPES' button in the top left corner of the main screen.
- "DOWNLOAD" the requested recipe: Points to the 'DOWNLOAD' button in the bottom row.
- "EDIT" button to modify the recipe: Points to the 'EDIT' button in the bottom row.
- "ADD" button to add a new recipe: Points to the 'ADD' button in the bottom row.
- "LOAD FROM PRODUCTION PLAN" button, to load the recipes from ARTEZEN CONNECT app: Points to the 'LOAD FROM PRODUCTION PLAN' button in the bottom row.
- "SERVICE" button: Points to the 'SERVICE' button in the bottom row.
- "ESC" button to come back at the previous page: Points to the 'ESC' button in the bottom row.

- Choose the work program to be used from the list on the display. If necessary, scroll the vertical cursor to view the programs not included in the current display.
- Press the "DOWNLOAD" button to load the recipe.
- The machine will start an initial set-up cycle

4.2 Change process (recipe)

- Press "START/STOP" button to stop the machine



Press "RECIPE" button

Press "DOWNLOAD" to load the selected recipe

Select the requested recipe

ID	Name
1000	PANE 300 1PZ
1001	PANE 300 2PZ
1003	PANE 500
1004	PANE PICCOLO 2PZ

4.3 Add a new process (recipe)

Press "ADD" button to add a new recipe at the current list

ID	Name
1000	PANE 300 1PZ
1001	PANE 300 2PZ
1003	PANE 500
1004	PANE PICCOLO 2PZ

Type password and confirm it pressing "ENTER"

MAX: 9999 MIN: 0000
511

Click on this area to type the name of the recipe

Type the name of the program

BS=Backspace (cancell the last letter)
««=Move the cursor on the left
»»=MOVE the curson on the right
ENTER=Confirm

The screenshot shows the following parameters:

- ID: 1004
- NAME: PANE PICCOLO 2PZ
- Row 1: 100 (red icon), B1A, 100, 1° OFF, 26, m' Gr +5, 0
- Row 2: 1000 (blue icon), B1B, 31, 2° OFF, 16
- Row 3: 1.1100 (green icon), B2, 50, 2Pcs (with 2 yellow dots icon)

Callouts and instructions:

- Type the dividing nominal weight (gr.)
- Type the speed of the splitted outfeed belts
- Type the speed of the flour dusters
- Type the speed capacity (pcs/hr)
- Type the coefficient adjustment of the weight (usually it is "1")
- Click to set the single of double division
- WEIGHT GAIN: Enter the weight of the dough every time you wish to increase it by 5 grams, then confirm with "ENTER" - Useful to compensate for the rising of the dough during breaking. With parameter="0" no automatic timed weight variation will be made.

In the case of Calybra HD combined with the Weight checker "Lybra"

The screenshot shows the same parameters as the first screen, but with additional weight checker settings:

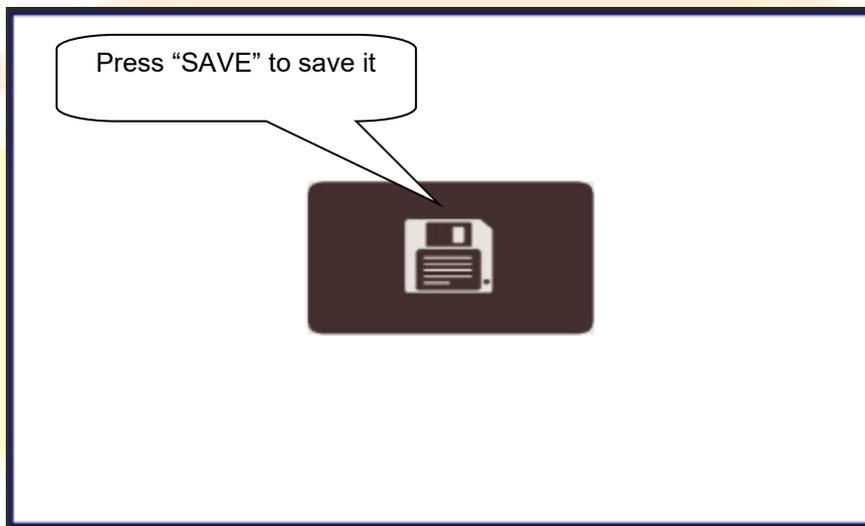
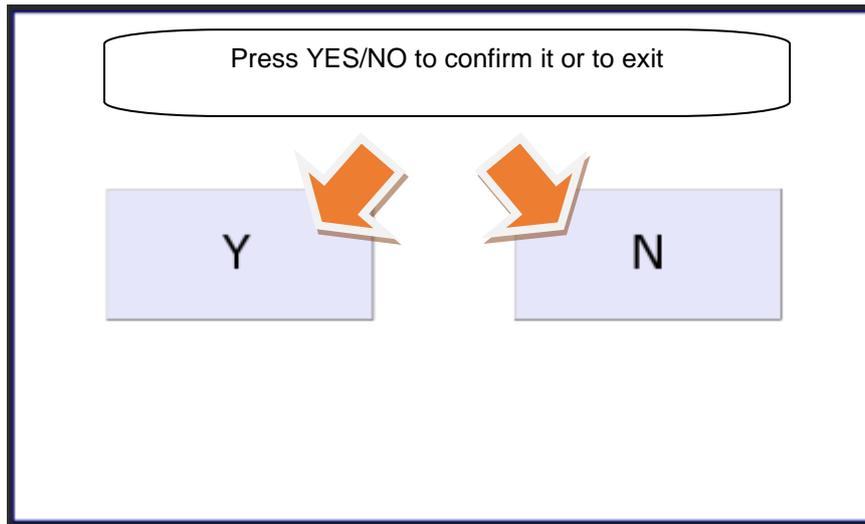
- ID: 1004
- NAME: PANE PICCOLO 2PZ
- Row 1: 100 (red icon), B1A, 100, 1° OFF, 26, m' Gr +5, 0
- Row 2: 1000 (blue icon), B1B, 31, 2° OFF, 16, [Gr-] 5, [Gr+] 5, [Gr+1] 5
- Row 3: 1.1100 (green icon), B2, 50, 2Pcs (with 2 yellow dots icon)

Callouts and instructions:

- Type the acceptable tolerance (gr.) under the nominal dividing weight. (in case of connection with "LYBRA")
- Type the acceptable tolerance (gr.) over the nominal weight that will be considered, in case of connection with "LYBRA", to handle an automatic adjustment of weight setting
- Type the acceptable tolerance (gr) over the nominal weight that will NOT make any adjustment at the dividing set up. (in case of connection with "LYBRA")
- Press "SAVE" to save it, overwriting the previous program.
- Press "ESC" to exit

In the example shown in the figure, the setting of acceptability of the weight of the dividing provides:

- 95÷105 gr= accepted weight range
- 105÷110 gr=weight accepted but start of the automatic correction cycle of the dividing set up



4.4 Edit of an existing recipe

Select the recipe to be modify

Press "EDIT"

Type "511" and confirm it pressing "ENTER"

If wrong typing,

- Press "ESC" to exit
- Cancel it typing "Clr"

Click on the field "PASSWORD"

Type the name of the program

BS=Backspace (cancell the last letter)
 ««=Move the cursor on the left
 »»=Move the curson on the right
 ENTER=Confirm

Click on the "NAME RECIPE" To modify the description

The screenshot shows the main configuration screen of the Calybra HD. At the top, it displays 'ID 1004' and 'NAME PANE PICCOLO 2PZ'. Below this, there are three rows of settings for different rollers: B1A (speed 100, 1° OFF 26), B1B (speed 31, 2° OFF 16), and B2 (speed 50, 2Pcs). A 'Gr +5' indicator is visible on the right. A 'SAVE' button is on the left and an 'ESC' button is on the right.

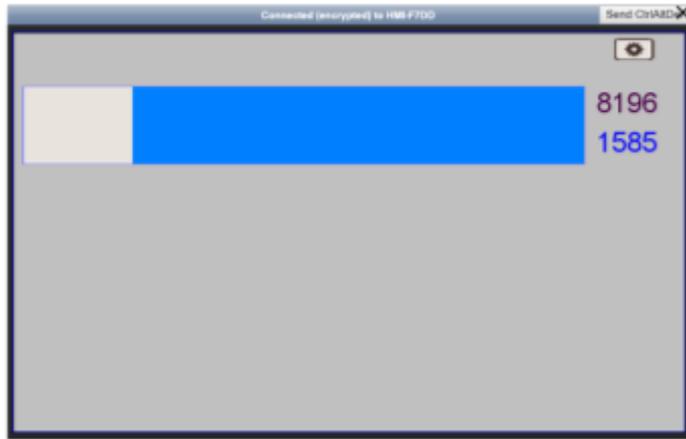
Callouts:

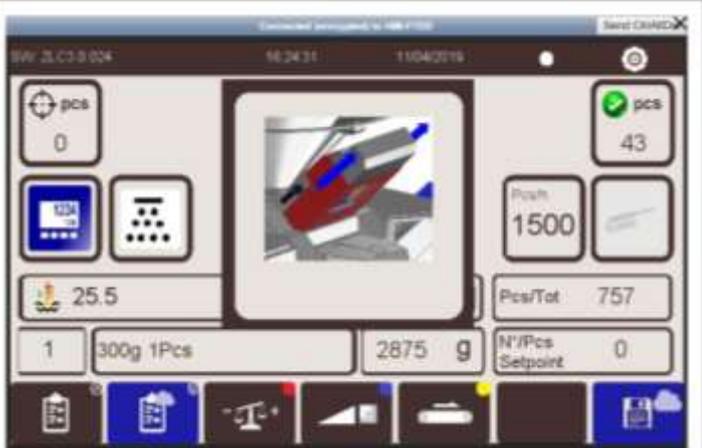
- Type the dividing nominal weight (gr.)
- Type the speed of the splitted outfeed belts
- Type the speed of the flour dusters
- Type the speed capacity (pcs/hr)
- Type the coefficient adjustment of the weight (usually it is "1")
- Click to set the single of double division
- WEIGHT GAIN: Enter the weight of the dough every time you wish to increase it by 5 grams, then confirm with "ENTER" - Useful to compensate for the rising of the dough during breaking. With parameter="0" no automatic timed weight variation will be made.
- Type the acceptable tolerance (gr.) under the nominal dividing weight. (in case of connection with "LYBRA")
- Type the acceptable tolerance (gr) over the nominal weight that will NOT make any adjustment at the dividing set up. (in case of connection with "LYBRA")
- Type the acceptable tolerance (gr.) over the nominal weight that will be considered, in case of connection with "LYBRA", to handle an automatic adjustment of weight setting
- Press "SAVE" to save it, overwriting the previous program.
- Press "ESC" to exit

In the case of Calybra HD combined with the Weight checker "Lybra"

4.5 Cleaning cycle

<p>The "CLEANING" button is not enabled if the machine has not been started with a production of at least 20 pieces of dough. The detection of the production of pieces of dough is done through the sensor (which also acts as a piece counter) installed at the inlet of the discharge conveyor, near the inside end of the removable safety tunnel.</p>	
<p>The "CLEANING" button is enabled after the production of pieces of dough has happened.</p>	
<p>By pressing the "CLEANING" button, you will be asked to accept the start of the procedure. Press "YES" to continue or "ESC" to exit the procedure.</p>	

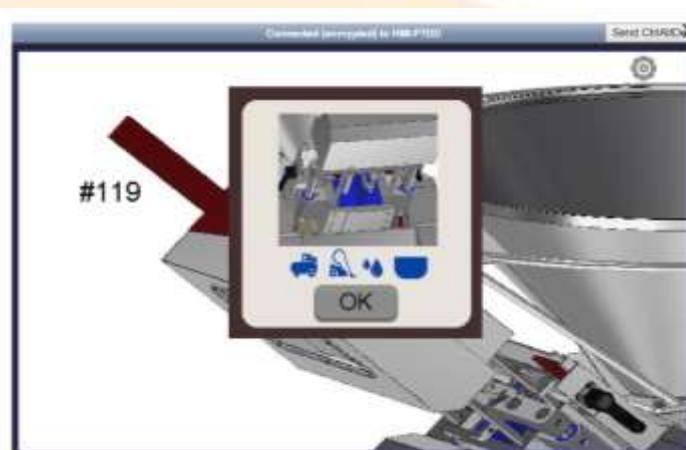
<p>The identification of the operator is requested and can be defined by the "Artezen Connect" application. Press "OK" to continue after selecting the operator ID if necessary.</p>	
<p>By pressing "OK", the machine starts a positioning suitable for the cleaning process to be carried out.</p>	
<p>A quantity of dough of about 5 kg is required to be placed in the hopper. Press "OK" to confirm that the quantity of dough has been placed in the hopper.</p>	

<p>Press the "START/STOP" button on the control panel.</p>	
	
<p>Remove the cover of the weight chamber in order to gain access to the inner zone.</p>	

Rimuovendo il carter della camera di peso si può procedere rimuovendo il deposito di pasta.



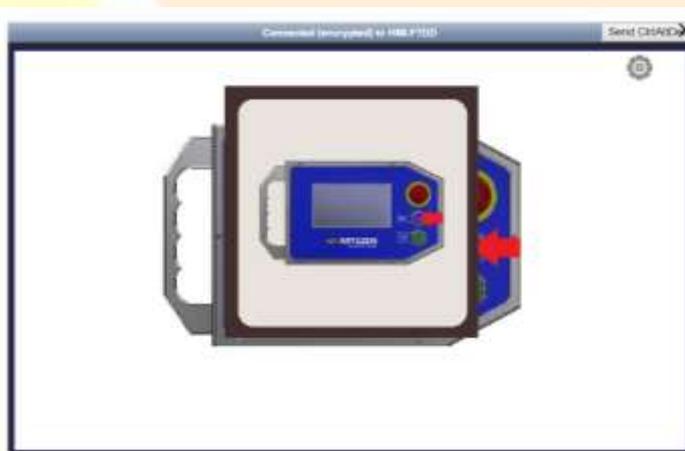
Al termine della pulizia, premere "OK"



Reinsert the weight chamber cover into its working position.

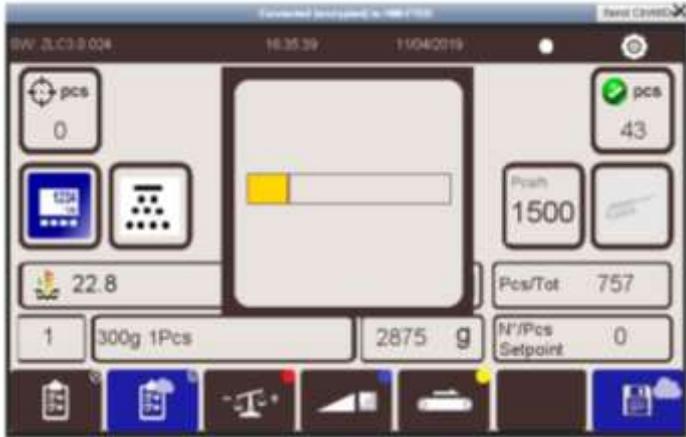
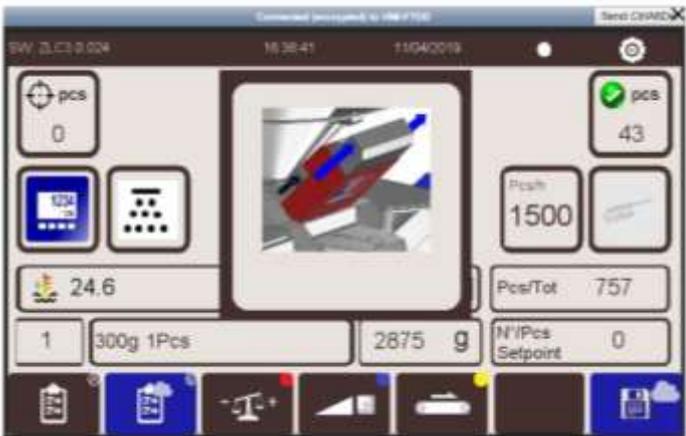


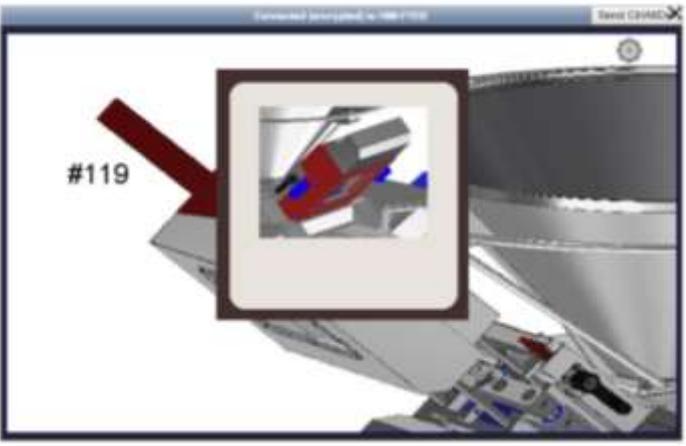
Press the "RESET" button

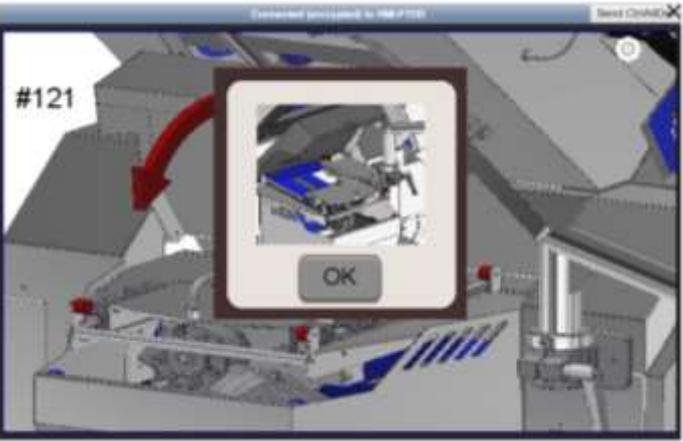
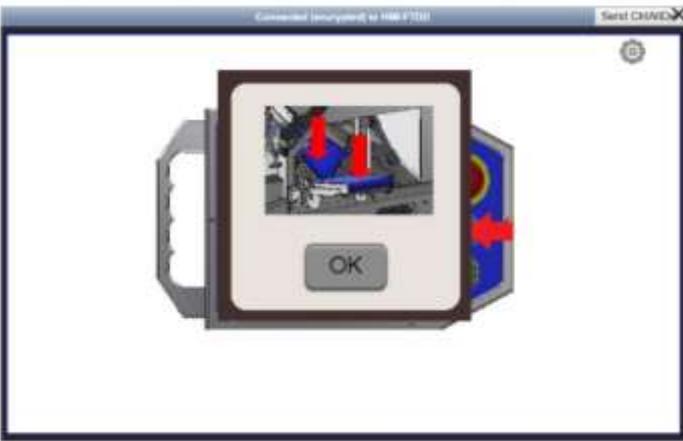


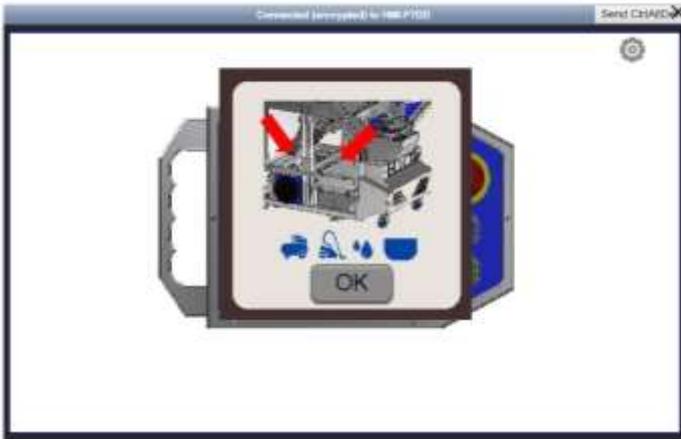
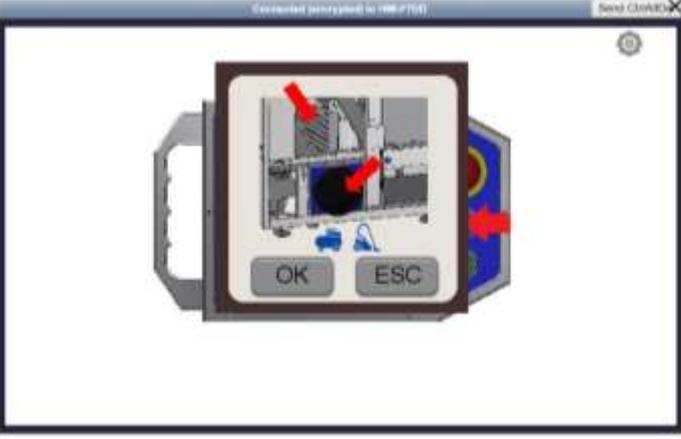
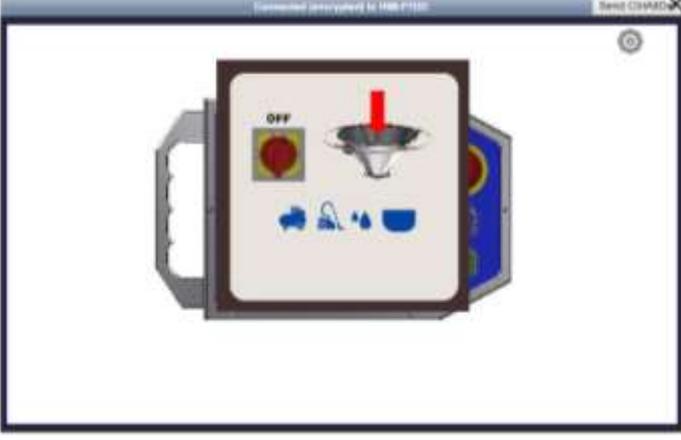
Press the "START/STOP" button.



<p>The machine will start a discharge cycle of the dough previously fed into the hopper.</p>	
<p>Remove the cover of the weight chamber in order to gain access to the inner zone.</p>	
<p>Finish the operation by lubricating the inside of the weight chamber.</p>	

<p>When lubrication is complete, press the "OK" button to continue.</p>	
<p>Replace the protective cover of the weight chamber in the working position.</p>	
	

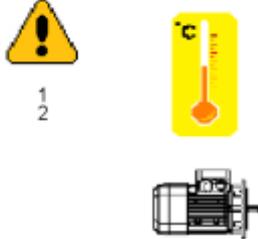
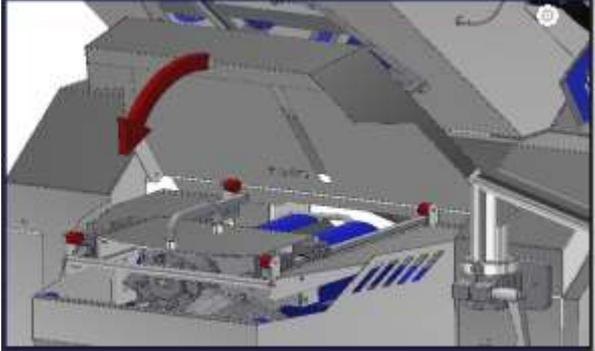
<p>Open the roller compartment by lifting the cover in front area of the machine. Press "OK" to proceed.</p>	
<p>Clean the roller unit. Press "OK" to proceed.</p>	
<p>Clean the unloading belts. After removing any residual dough, clean the belt scrapers, if necessary removing them from their housing, then lubricating the scraper profile. Press "OK" to proceed.</p>	

<p>Open the side covers of the frame and proceed by removing the residues of flour and dough deposited on the horizontal flat compartments. Press "OK" to proceed.</p>	
<p>Clean the surface of both heat exchangers (radiators) from flour dust deposits using a vacuum cleaner. This can be done using compressed air, taking care to protect the respiratory tract by means of a filter mask and sucking in the dust blown from the compressed air by means of a vacuum cleaner: it is better if this operation is carried out in a ventilated area outside the mixing area. Press "OK" to proceed.</p>	
<p>Conclude the cleaning process by removing residues from the hopper. Do not use metal scraping tools (knives, metal spatulas, metal wool pads) to clean the inner surface of the hopper. Wipe the inside surface of the hopper with a damp cloth. When finished, switch off the machine</p>	

	<p>WARNING! WARNING! Before closing the casing of the weight chamber, make sure that no objects remain in the weight chamber (rags, brush, brush, etc.); otherwise, the machine could be damaged mechanically, even very seriously, during subsequent start-up.</p>
	<p>WARNING! Remember to complete the cleaning operation by starting the machine for a few work cycles to make sure you discharge all the previous dough loaded into the hopper, which is also partially contained inside the weight chamber.</p>

4.6 EMERGENCY STOP

Every intervention of a safety device immediately interrupts the work and therefore the execution of the work cycle. The devices that cause the emergency stop of the working cycle are as follows:

<ul style="list-style-type: none"> • Press the red mushroom button "EMERGENCY STOP"; 	
<ul style="list-style-type: none"> • Pressure of the safety ring on the hopper; 	
<ul style="list-style-type: none"> • Tripping of one of the thermal protection of the electric motors; 	
<ul style="list-style-type: none"> • Opening of the front door 	

<ul style="list-style-type: none"> Lifting / removing of the safety cover placed over the outfeed belt 	
<ul style="list-style-type: none"> Opening / removing of the cover placed on the weight chamber 	
<ul style="list-style-type: none"> Opening / removing lateral door 	

To resume processing after the intervention of an emergency stop guard, you must restore the action that caused the machine to stop, so respectively;

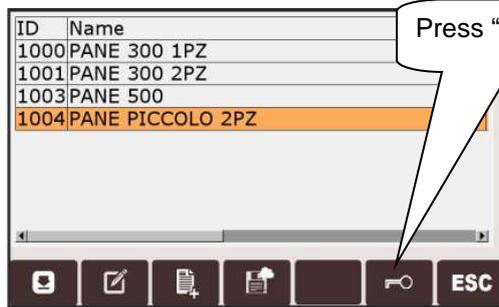
- Turn the red knurled ring nut of the emergency icon clockwise until it is released;
- Restore the working position of the sensitive ring on the hopper, checking that there is no obstacle to the ring;
- Wait for the motors to cool down.
- Close the access door to the needle roller unit and remove the pasta;
- Place the 'tunnel' casing on the product outlet belt in the working position;
- Place the closed housing of the weight chamber in the working position;
- Put the side cover back in the working position.

After restoring the cause of the emergency, it is necessary to press "RESET" to enable the start of the cycle.

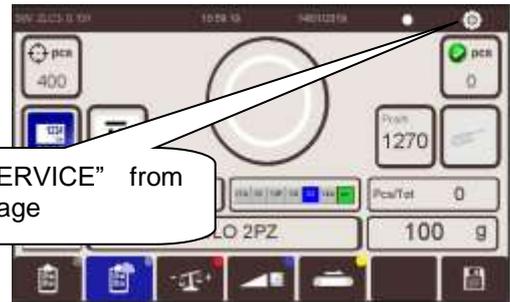
	<p>NOTE!</p> <p>The emergency stop of the machine causes the immediate stop of the machine, also interrupting the power supply to the control system of the movements.</p> <p>DO NOT USE THE STOP OF THE MACHINE FOR PURPOSES NOT CONFORMING INEXISTING EMERGENCY SITUATIONS, in order to avoid useless impediments and problems in the production flow of the product.</p>
	<p>WARNING!</p> <p>If, after the restoration of the emergency that caused the machine to stop or not restart, the control panel continues to show the emergency event, switch off the machine and contact the person in charge of the personnel.</p>

4.7 Internal set up parameters

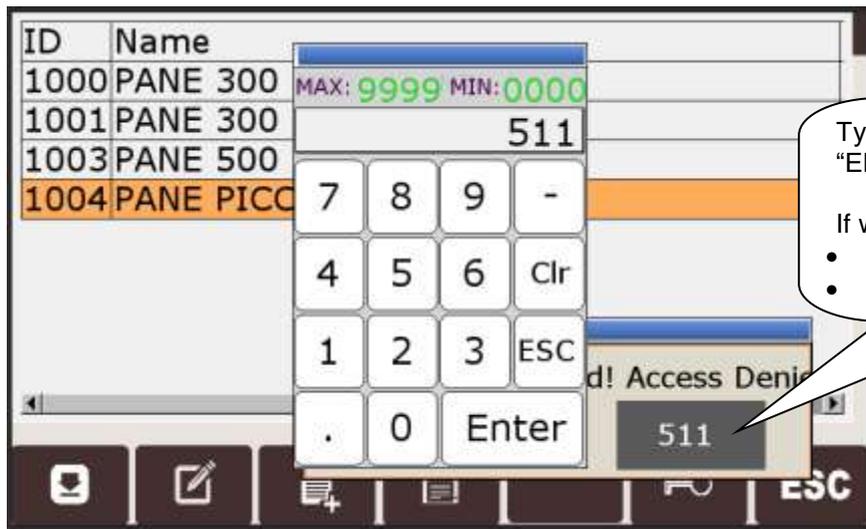
Press "SERVICE" button



Press "SERVICE"



Press "SERVICE" from "HOME" page



Type "511" and confirm it pressing "ENTER"

- Press "ESC" to exit
- Cancel it typing "Clr"



Scroll through the different windows to view and access the different parameters.



Underground parameterization allows the machine to perform its work cycle correctly and to manage the configuration correctly.



Tampering with its parameters by unskilled personnel could compromise the functionality of the machine itself; in this case, the Company declines all responsibility in the event of faults.

Description	View page																																
<p>1.0= coefficient weight set up Calybra 1.0</p> <p>1.1= coefficient weight set up Calybra 1.5 single division</p> <p>1.1= coefficient weight set up Calybra 1.5 splitted division</p> <p>1.3= coefficient weight set up Calybra 2.5 single division</p> <p>1.4= coefficient weight set up Calybra 2.splitted division</p> <p>1.5= coefficient weight set up Calybra 0.2</p>	<table border="1"> <thead> <tr> <th>weight coefficient</th> <th>g/RPM</th> <th>1Pcs</th> <th>2Pcs</th> </tr> </thead> <tbody> <tr> <td>CALYBRA 1.0</td> <td>1.0</td> <td>78</td> <td></td> </tr> <tr> <td>CALYBRA 1.5</td> <td>1.1</td> <td>110</td> <td>1.2 44</td> </tr> <tr> <td>CALYBRA 2.5</td> <td>1.3</td> <td>165</td> <td>1.4 73</td> </tr> <tr> <td>CALYBRA 0.2</td> <td>1.5</td> <td>14</td> <td></td> </tr> </tbody> </table>	weight coefficient	g/RPM	1Pcs	2Pcs	CALYBRA 1.0	1.0	78		CALYBRA 1.5	1.1	110	1.2 44	CALYBRA 2.5	1.3	165	1.4 73	CALYBRA 0.2	1.5	14													
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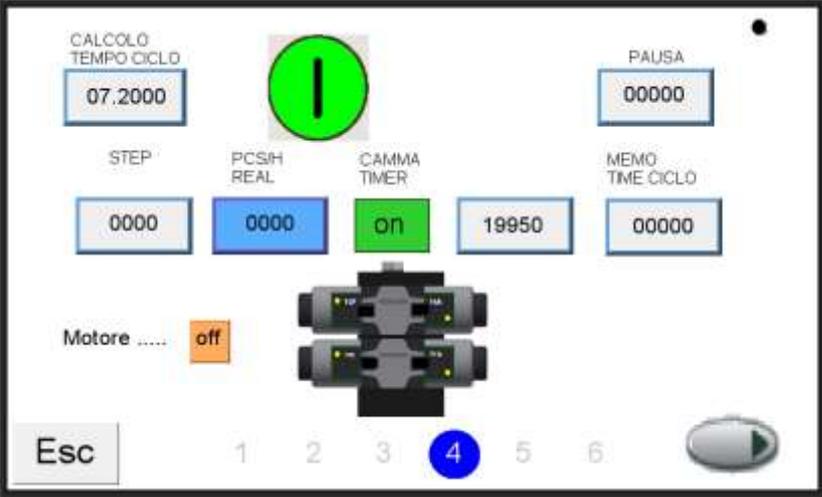
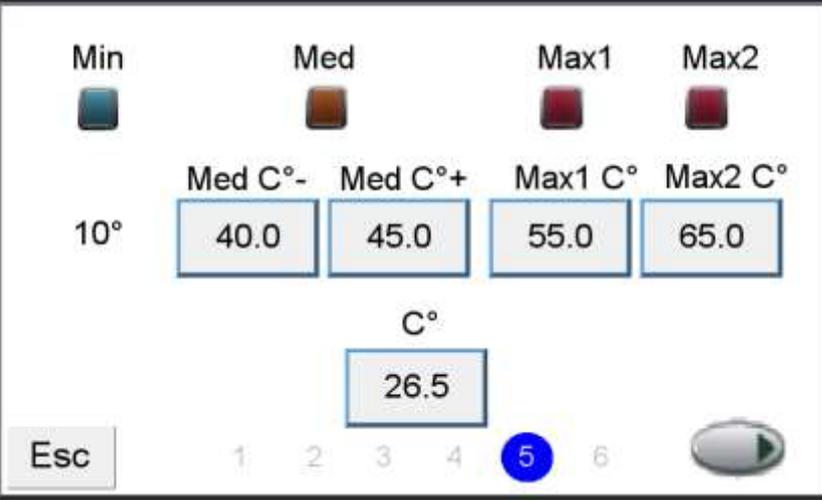
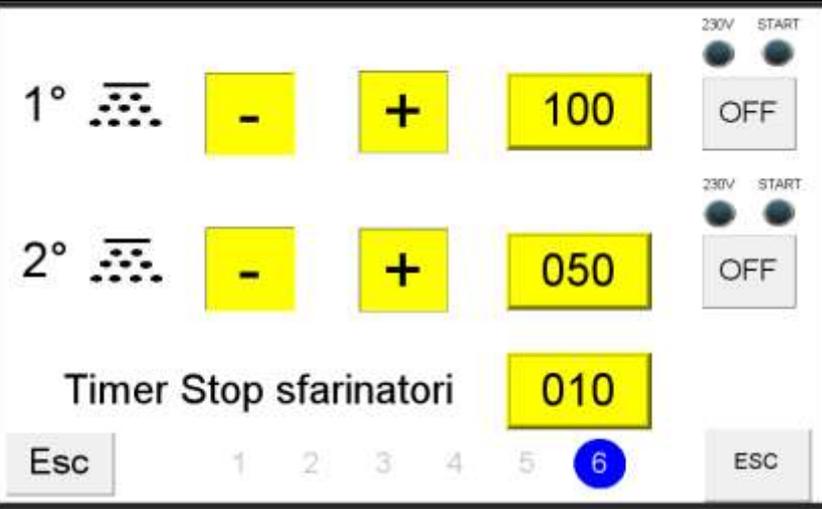
Description	View page
<p>4.0=Timer outfeed belt stopping</p> <p>4.1=Timer outfeed belt stopping arresto after cleaning process</p> <p>4.2=Step increase / decrease weight</p> <p>4.3= In case of combination with 'Lybra' is the percentage of the nominal weight of the acceptable weight difference in the evaluation of any correction</p> <p>4.4=Setup velocità nastro di uscita</p> <p>4.5= Production break for weight reset 'Lybra' in case of combination with 'Lybra'</p> <p>4.6= Production pause time for weight reset 'Lybra' when combined with 'Lybra'</p> <p>4.7=Timer stop end of production</p>	
<p>5.0=Version Calybra</p> <p>5.1=Version weight chamber</p> <p>5.2=Available increasing weight pack</p> <p>5.3=Available selection single or splitted division</p>	
<p>6.0=View hydraulic valve lighting during process</p> <p>6.1=Possible insertion of production pause</p> <p>6.2=Possible insertion timer "S1" and "S2"</p> <p>6.3=Second outfeed belt</p> <p>6.4=Activation adjustment "V" belts</p> <p>6.5=Possible lubrication unit</p>	

Description	View page
<p>7.0=Function AUTO/MAN 7.1=Automatic stop end production 7.2=Flour duster Pos.1 7.3=Flour duster Pos.2 7.4=Direction automatic weight adjustment 7=Download original parameters</p>	

Then you will find the installer service pages where you will see useful information about the operation of the machine

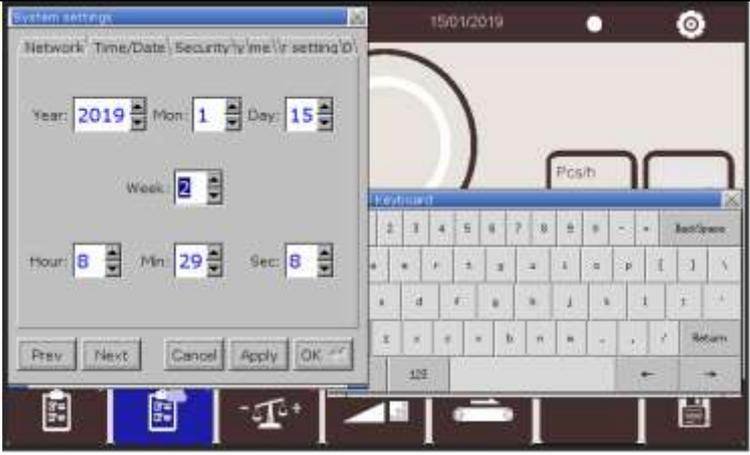
Description	View page
<p>From the succession of pages described above, by pressing the "SERVICE" icon indicated by the arrow, you can access the pages of control, verification, manual start of the machine: exclusive use of technical staff</p>	
<p>There are inputs that generate alarms, sensor inputs, to be able to analyze any malfunction in the detection of the inputs of the PLC</p>	

<p>In this second window it is possible to access the management of the motorized movement of the weight selection, verifying the functionality of the impulse counting.</p>	<p> Finecorsa alto on Finecorsa basso on Visualizza Output discesa off Visualizza Output salita off Visualizza Output rallenta off Posizionamento ricetta ok Posizionamento correzione .. no I0 conteggio on I1 direzione conteggio* off on = decrementa - off = incrementa </p> <p> prodotta Quota reale 608 610 </p> <p>Auto</p> <p>Esc 1 2 3 4 5 6</p>
<p>In this third window, the pump motor and the individual solenoid valves can be started up in 'manual' mode, verifying the effect obtained.</p>	<p> Motore <input type="checkbox"/> Gruppo indietro <input type="checkbox"/> Gruppo avanti <input type="checkbox"/> Pistone aspira <input type="checkbox"/> Pistone pressa <input type="checkbox"/> </p> <p>GRUPPO ELETTRORVALVOLE</p> <p> Motore off Y2I indietro off Y1A avanti off Y4A aspira off Y3P pressa off S1 avanti on S2 indietro off </p> <p>REGOLAZIONE PRESSIONE</p> <p>Esc 1 2 3 4 5 6</p>

Description	View page
<p>Possibility to start some functions of the machine in 'SERVICE MODE'.</p>	
<p>Set-up of the limits regarding the temperatures of the hydraulic fluid</p>	
<p>Manual start up and adjustment of the flour dusters</p>	

4.8 Area reserved for installers

From the "HOME" screen you will find the "RESERVED AREA" button from where you can parameterize the functions external to our production software.

Descrizione	Visualizzazione pagina
<p>From the main screen, by pressing the circular button at the top right, you can access the set up of the display, with its configuration of brightness, contrast, date and time, communication addresses, etc..</p> <p>The password in this case is: 111111</p>	
<p>Example of the network address configuration window</p>	
<p>Local date and time configuration window.</p>	

5 TROUBLE SHOOTING

PROBLEM	POSSIBLE CAUSE	REMEDY
<p>When a program is first selected, the weight selection system installed on the weight chamber does not respond to commands for which the machine is not started.</p>	<p>For some reason the control system has not been started</p>	<div data-bbox="927 353 1281 976" data-label="Image">  </div> <p>Try to restart the machine by turning off the main switch installed on the electrical cassette and turning it on again after a pause of at least 10 seconds.</p>
	<p>The connector is not well connected to its socket</p>	<p>Disconnect and reconnect the above connector, as shown in the figure below, then try to restart the machine by turning off the main switch installed on the electrical box and turning it on again after a pause of at least 10 seconds.</p>

PROBLEM	POSSIBLE CAUSE	REMEDY	
<p>After successive program selections, the system does not generate the weight selection for which the machining is not started. The above instructions have not solved the problem</p>	<ul style="list-style-type: none"> • Mechanical problem in the transmission of the servo-assisted movement; • Electronic problem of impulse management; • Error in reading of the weight chamber filling limit switch • Error in electronic engine management 		<p>Manual weight selection is preferred. To do so, completely disconnect the connector from its socket as shown in the image below.</p>
			<p>Remove the carter of the weight chamber</p>
			<p>Maneuver the handwheel to refine the division set up, exactly as if it were a manually adjustable weight divider</p>
			<p>Then lock the position by turning the lever</p>

PROBLEM	POSSIBLE CAUSE	REMEDY	
		Switch off the machine from its main switch installed on the electrical box!	
<p>The touch screen control panel doesn't work anymore</p>	<p>Breakage of the tactile operator panel Error in its connection to the control PLC</p>		<ul style="list-style-type: none"> • Remove the casing of the weight chamber • Pull out the electrical connection connector to the motor system of the automatic weight set up • Manually set the breaking weight • Lock the adjustment made • Start the machine by pressing the START button