

QUICK GUIDE for gravimetric pump system “GR-50” for extrusion in tracking mode

Connections:

- **Start signal** either as potential free open contact via signal cable (AUX Port/DB9 ↔ green & white wire) or 220 V power connection on right side
- 0-10V or 4-20mA **tracking-signal** from extruder control via signal cable (AUX Port/DB9 ↔ black & red wire) on right side
- 220 V **power connection** on back side

Start-up:

1. **Power Supply:** Switch on by On/Off-toggle on backside.
2. **Color supply:** Connect color package with hose and put it on holder. Insert hose in peristaltic pump head or connect it with progressive cavity pump respectively and connect it with extruder.
3. **Pre-conveying:** Press „**FORWARD**“. If necessary repeat procedure until the color has passed the pump head. By pressing "**STOP**" the process can be aborted.
4. **Calibration:** Press "**CALIBRATE**" followed by "**START**". If necessary repeat proceeding until a reasonable value > 10 g is displayed in the lowest line "SampleWgt(gr)".
5. **Enter dosage (%):** Select "**LDR %**" (let down ratio) via arrow keys, enter dosage and confirm with "**ENTER**".
6. **Enter throughput (kg/h):** Change to "**ProRate Kg/hr**", enter the extrusion throughput and confirm with "**ENTER**".
7. **Start:** Press "**START**".
8. **Activate Tracking mode:** Press button "**1**" and "**2**" simultaneously. Pump now follows the extrusion throughput.
9. **Stop:** Press "**STOP**".

Note:

- After each stop and restart the tracking mode must be re-activated!
- To prevent color drops after production the color can be conveyed back into the hose via pressing "**REVERSE**" permanently.