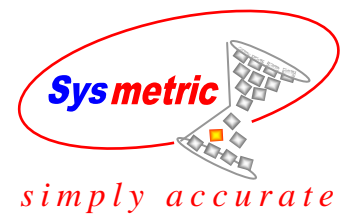


CD Series Dosing Systems

Recycled Material and Channel-Skipping

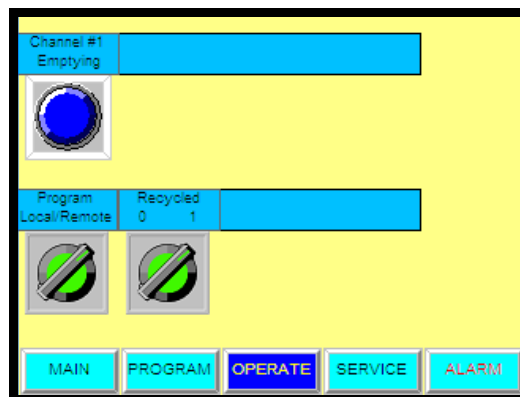


The Sysmetric CD Series dosing system has an option of a **Dedicated Recycled Material Channel**. The purpose of this special channel is to ensure optimal operation of the dosing system when handling recycled materials from two aspects: good material flow even with fluffy / chopped materials and automatic additive reduction (taking into account the fact that the recycled material already contains all of the additives).

The dedicated recycled channel is channel #2 and it can work in two modes:

1. **Recycled mode** – the material fed to channel #2 already contains all of the ingredients. Other additives ratio is automatically reduced accordingly to save money. In this mode, if channel #2 runs out of material the system will alarm and will automatically skip the recycled channel advancing to the next channel. This operation has no affect on the product and it will repeat every batch until the recycled channel is re-filled with material.
2. **Normal mode** – channel #2 is treated like any other component. In this mode automatic skipping is disabled.

Enabling **Recycled** mode is carried out in the Operate screen:

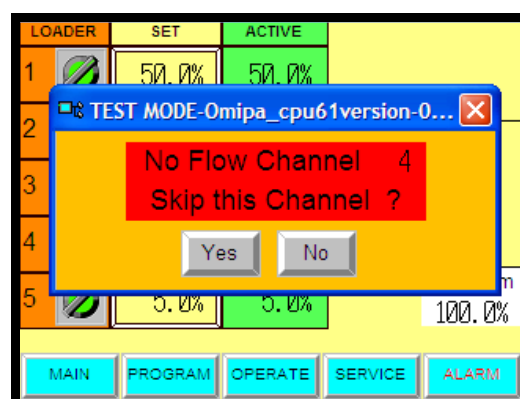


Operate Screen with Recycled switch

For all other channels (and for channel #2 in "normal mode") whenever material shortage is detected, an alarm and a message will appear allowing the operator to skip the channel for one dosing cycle. This will allow batch preparation to continue without this ingredient.

Whenever the operator commands the system to skip a channel, an appropriate message will be added to the alarms log and will appear in the alarms screen. Skipping a channel when preparing a batch of raw material will damage the product but it will prevent the machine from stopping due to material shortage. If the material shortage can not be fixed shortly, the operator can either remove the material from the dosing formula or to continue pressing the skip button every cycle of batch preparation.

Skipping a channel that runs out of material is carried out by selecting **Yes** in the screen that appears when the system detects material shortage:



Skip Channel Pop up screen