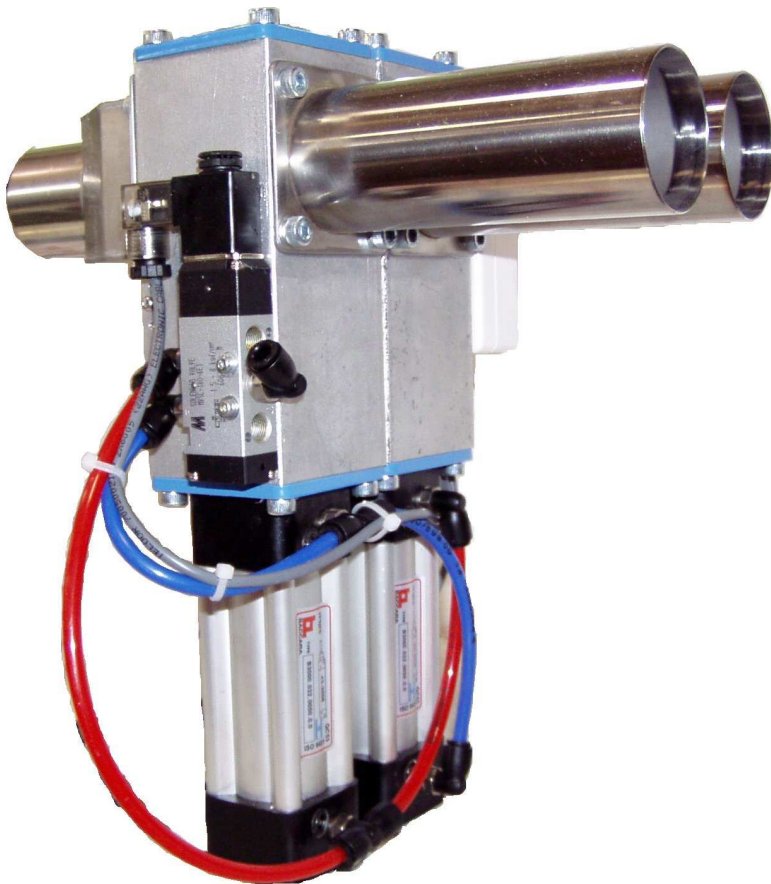
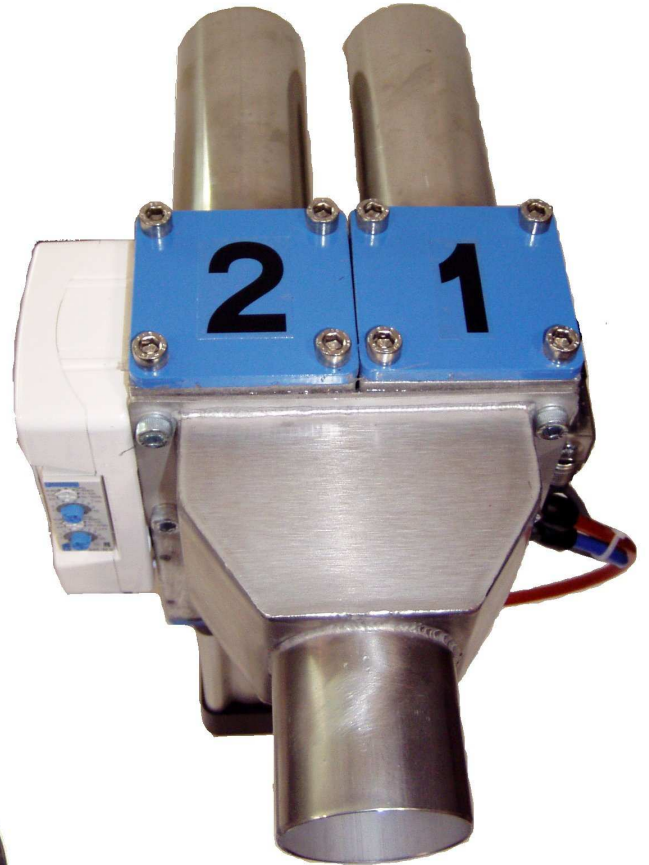


Proportional Valve

Sysmetric **Proportional Valve** is a vacuum valve designed to divide the conveying time between two sources of raw material. This valve usually used to feed back recycled material to the extruder or at any application of feeding two different raw materials from two different sources where the application does not require accurate ratio between the two materials.

When the **Proportional Valve** is activated (powered up) it enables material flow from the primary input [1] to the output for a set time T1 and from the secondary input [2] for a set time T2. This process repeats it self continuously until the valve is disabled (powered off). The set times T1 and T2 can be adjusted manually to receive the desired ratio between the material from the primary input and the material from the secondary input.



Setting the Timer

- Set **T1 Range** and **T2 Range** selectors to 1-10sec.
- Set **T2 Set Time** according to the percentage wanted from the secondary material.
- Set **T1 Set Time** to sum 10 with **T2 Set Time**.

The following table shows some examples of setting the timer to receive different percentage of vacuum time from the secondary pipe:

Percentage of Material From Secondary Pipe	T2 Set Time	T1 Set Time
10%	1	9
20%	2	8
50%	5	5

Electrical Wiring

- Connect constant 24VDC to the red wire.
- Connect 0VDC to the black wire to activate the proportional valve.
(Usually the black wire should be wired with the vacuum signal wire)

Status Indicator (green LED):

- LED is off – proportional valve is off
- LED is blinking slowly – secondary pipe is open
- LED is blinking fast – primary pipe is open

