



Waste Tracking Calibration on Twin-Trak Conveyors

PROBLEM: Replacement of sensor or recalibration.

The waste tracking option dumps (PLC output turns off) the waste gate a calibrated number of pulses after the waste switch is turned on. The number of pulses is the distance from the Press Operator Panel to the Dump Gate times 6 pulses per foot. This number may vary with installation according to where SDS sensor is located, the roll diameter and the number of teeth it senses. To Calibrate:

- **Waste Switch Off.**
- Jumper terminal **004 to 24 v dc**. This clears the number of waste tracking pulses from memory and prepares the PLC for a new value.
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- Turn **on the Waste Switch**. Place a newspaper on the conveyor near the Press Operator Panel Run the conveyor in Manual Mode until the newspaper moves to the Dump Gate.
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- **Waste Switch Off.**
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- **Remove** the jumper from **terminal 004**.
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- Test the calibrated value. Place a newspaper nearest the Press Operator Panel Turn the Waste Switch on. Run the conveyor and watch the Dump Gate turn off when the paper arrive at the dump gate. Repeat the calibration if necessary. Note that the PLC output turns on to raise the dumpgate and off to lower the gate to start waste.

Note: Waste Calibration is proprietary to Quipp Systems Inc. Information concerning calibration will only be given to companies that have purchased waste tracking systems from Quipp as indicated on a Sales Order or Product Release.