Working with recipes

Recipes are used so constant and recurring production processes can simply be called up instead of being input again and again. The controller can store up to 50 recipes.

>>> **TIP:** The recipe must be active before recipe data can be changed.

Calling Recipe Status

1 Press "Recipe" in the "TrueBlend Status" screen to view the recipe status.
   The recipe screen will appear.

Assigning an order number

1 Press the field beside "Order number" to assign an order number or job number.
2 Input the value with the numeric keypad.
3 Confirm the value with ⏎ .
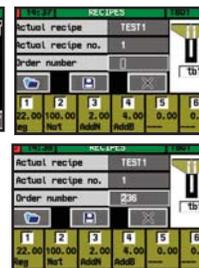
Naming and Saving a Recipe

1 Press 💾 to assign a recipe name and to save the recipe.
2 Use the scroll arrows to select a storage location for the recipe or input a storage location number directly.
3 Assign a recipe name with the keypad. A recipe name has a maximum of eight characters (alpha-numeric).
4 Confirm the value with ⏎ .
5 Press 💾 to save the recipe.
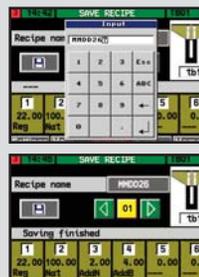
>>> **TIP:** An error message may be displayed if a recipe name has not been assigned. Press the input field and assign a name, then save the recipe.

>>> **NOTE:** The formula for all components is displayed in the component view. When it is saved, the current data is transferred to the preselected recipe name. Existing recipes can also be overwritten with this method.

Deleting a Recipe

1 Press ✕ to delete a recipe.
2 Select the recipe that you want to delete with the scroll arrows or by direct input.
3 Press ✕ to delete. The recipe is deleted from the memory and no longer exists.
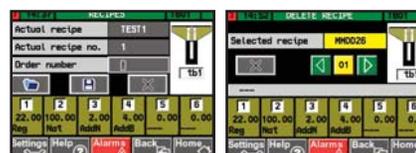
Load/View a Recipe

1 Press 📁 to load or view a recipe.
2 Select the recipe that you want to load with the scroll arrows or by direct input.
3 Press 📁 . The recipe is loaded and the formula for all components can be viewed.

TrueBlend
Gravimetric Blender
SB1 Control
Software Version 2.9.1

Example of a mixing process

Initial Values:
Total batch weight: 1000 g (TB100)
Number of materials: 4
Settings: Regrind: 20%; Natural material: AUTO (100% of balance batch after R, AB, and AN taken out); Additive batch: 10%; Additive natural (color): 2%

Calculation:

| Regrind: R=	Total weight of batch 1000 g	x Percentage of regrind x 20%	= 200 g
Additive: AB = Batch	Total weight of batch 1000 g	x Percentage of additive x 10%	= 100 g
Natural Material: N = 100%	Natural mat. & add. nat. (color) = 102% (700g)	x Percentage of natural x 100%	700/1.02 = 686.3 g
Additive Natural (color): AN	Natural Material 686.3 g	x Percentage of natural material x 2%	686.3 x .02 = 13.7 g

CONAIR™

Example of a mixing process (con't)

This is a typical dispense cycle based on the settings on the previous page.

Step 1: Regrind is metered.
Regrind = 20% of total weight = 200 g

Step 2: Natural material is calculated as 100% of the balance of batch = 686 g (automatically calculated/metered)

Step 3: Additive natural is metered (Color) 2% of N = 13.7 g (automatically calculated/metered)

Step 4: Additive batch is metered 10% of total weight = 100 g (automatically calculated/metered)
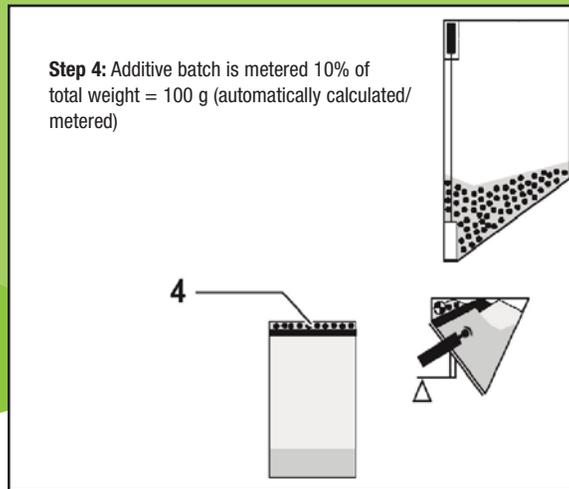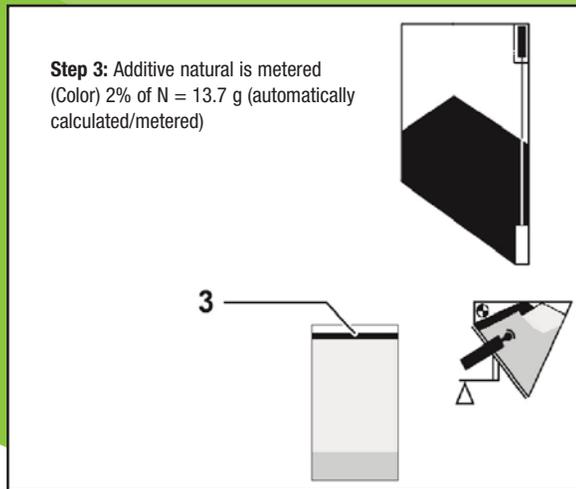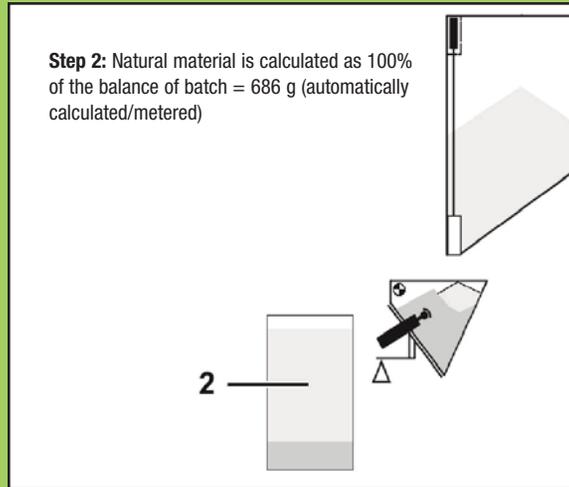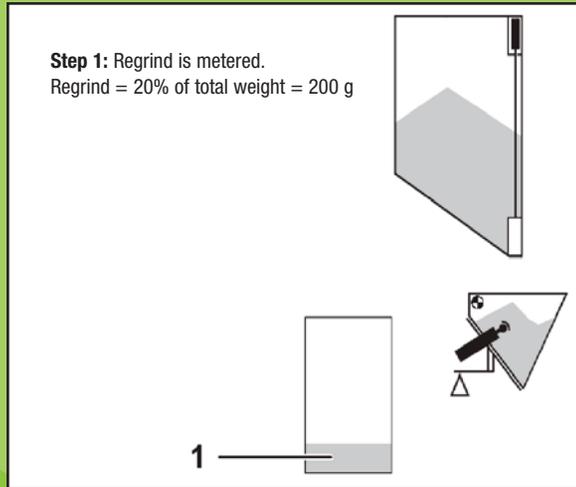
- The controller must be set to match this sequence.
- The percentage of natural material is automatically calculated by the controller. [Sum of Natural(s) material = 100%].
- The percentages of additive naturals are always based on the natural(s) material.
- The percentages of the additive batch are always based on the entire batch and therefore are metered last.
- If too much or too little was metered in the batch, this is compensated accordingly.
- The metering process is self-optimizing on the next batch.
- The regrind is metered first and deducted from the total batch weight. If there is more than one virgin material, the percentages are interpreted as ratios of the virgin materials and dispensed next.
- If there are multiple additive naturals or additive batches, they are metered in order of ascending percentage of the total regardless of the sequence of the supply hoppers.

⚠ **WARNING:** This card provides only basic troubleshooting and maintenance information.
Users must be familiar with all safety information and procedures described in the TrueBlend User Guide.

# Changing material in a blender component

Detachable material hopper procedure

For models TB45 (4 bins) and TB100 (2 bin models) and TB250R (2 bins).

To remove any of these detachable hoppers for cleaning or material changeover:

1 **Remove the automatic loading/receiving device.**
2 **Use the proper hex head socket or screwdriver to loosen the captive retainer.**
3 **Carefully remove the hopper.**

CAPTIVE RETAINER

To reinstall the hoppers, simply reverse the above steps. Once the hoppers have been placed and anchored, the loaders can be installed.

>>> **NOTE:** Upon reinstalling the detachable hopper, it is very important to re-anchor the respective hopper(s) using the captive retainer to provide stability during normal operation of the blender.

Manual Cleaning

Detachable material hopper procedure

1 **Turn off the main power and use the disconnect on the power cabinet.**
2 **Disconnect compressed air.**
3 **Open the front access door and remove the weigh bin.**
4 **Position a deflector (cardboard tray) to divert material from collecting in the mix chamber to and outside drum or bucket.**

>>> **TIP:** A Conair Drain Chute is available as an accessory. This allows the discharge valves to be operated in manual mode.

5 **Using a "dowel rod" approximately 12 inches long, press vertically into the respective valve opening and raise the plunger cone to allow materials to flow from the material compartments.** Material will flow out of the hopper compartment through the valve opening onto the deflector and into the drum or bucket.

OPTIONAL DRAIN CHUTE

6 **Discharge the material completely and clean the material hopper from the top down.**

>>> **TIP:** You may also want to clean the material receiver at this time while accessing the gravity dump valve through the respective blender clean out door.

7 **Reassemble blender.** If using the optional drain chute, be sure to engage the safety switch into the compartment receptacle.