

Working with recipes

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.

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 1000 recipes.

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

Calling Recipe Status

- 1 Press **Recipe** in the TrueBlend Home screen to view the recipe status. The recipe screen will appear.
- 2 Alter editing the recipe (if required), press **Automatic**.



Assigning an order number

- 1 Press the field to the left of "Automatic" to assign an order number or job number.
- 2 Input the value with the numeric keypad.
- 3 Confirm the value with .

>>> **NOTE:** "Use Order Names" must be enabled under Setup/System/Recipe



Naming and Saving a Recipe

- 1 Press **Book** to assign a recipe name and to save the recipe.
- 2 Use the +/- to select a storage location for the recipe or input a storage location number directly.
- 3 Press **Edit** to alter the set points of the specified recipe number.
- 4 Assign a recipe name with the keypad. A recipe name has a maximum of eight characters (alpha-numeric).
- 5 Confirm the value with .
- 6 Press **Save** to save the recipe.

>>> **TIP:** An error message may be displayed if a recipe error has been detected. Press the input field and make the correction, 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.



Load/View a Stored Recipe

- 1 Press **Book**, then +/-, or use direct input to load or view a recipe.
- 2 Press **Select** to load the recipe.
- 3 Press **Automatic**. The recipe is loaded and the formula for all components can be viewed.



Quick Card

QCB006-0113

TrueBlend Gravimetric Blender SB-2 Control



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	x Percentage of regrind	= 200 g
	1000 g	x 20%	

Additive: AB = Batch	Total weight of batch	x Percentage of additive	= 100 g
	1000 g	x 10%	

Natural Material: N = 100%	Natural mat. & add. nat. (color)	x Percentage of natural	700/1.02
	= 102% (700g)	x 100%	= 686.3 g

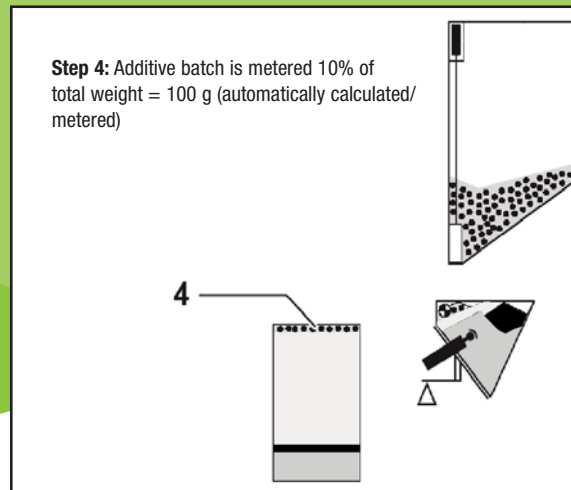
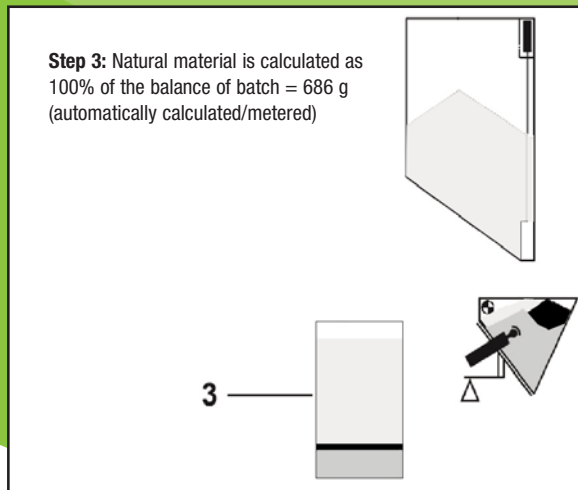
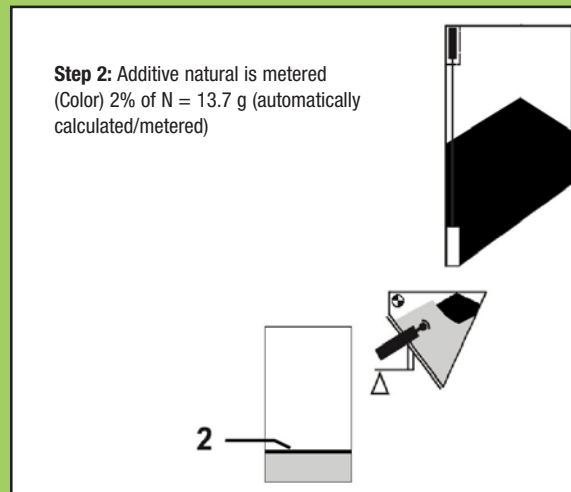
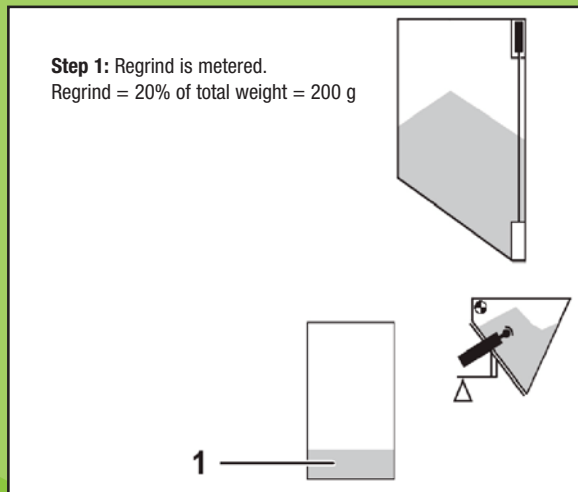
Additive Natural (color): AN	Natural Material	x Percentage of natural material x 2%	686.3 x .02
	686.3 g		= 13.7 g



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Example of a mixing process (con't)

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



- The controller must be set to match this sequence.
- The percentage of natural material must add to a total of 100. [Sum of Natural(s) material = 100%].
- The percentages of additive naturals are always based on the natural(s) material only.
- 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.



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Changing material in a blender component

QCB006-0113

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.**



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 an 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.
- 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.