

HMI Manual

CR6/CR4



ORIGINAL INSTRUCTION

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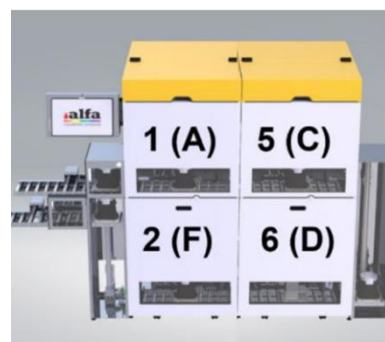
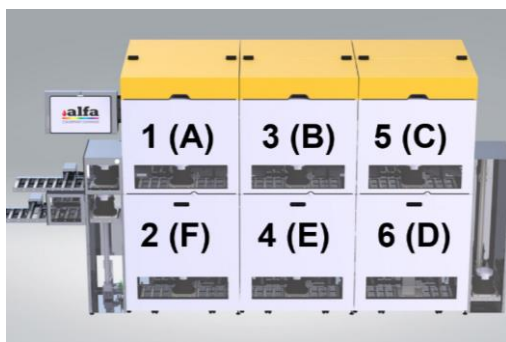
1. HOME PAGE

The machine is equipped with a touch display used as HMI (Human Machine Interface) by the operator, on which the machine software runs. The figure on the right shows the home page of the HMI.



The software uses references in letters and numbers to identify each dispensing head. The name of the dispensing heads are represented in the pictures below.

This Manual is applicable to both types of CR6 and CR4 machines



The HMI home page always shows the status of every single head (1). Each dispensing head can show the following statuses:

STANDBY: machine ready, waiting for commands.

DISPENSING: dispensing in progress.

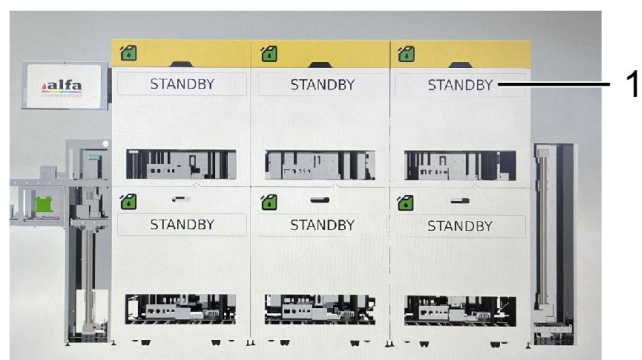
RESET: reset in progress.

ALARM: machine error.

DIAGNOSTIC: machine waiting for manual commands.












ROTATING: colorant circuit positioning (only for refill operations).

JAR POSITIONING: movement of roller conveyors and lifters.

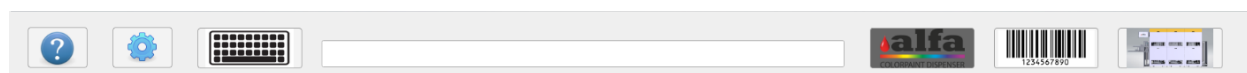





When the machine is switched on, the system runs a reset routine and sets all dispensing heads to STANDBY.



Below the list of the main buttons/images on the touch display and their meaning:

Button/image	Description
	Start production after placing shuttle on the roller conveyor
	Finish production by eject shuttle
	Access manual commands for each part of the machine
	Inactive photocell
	Machine automation working (Carousel ok) AND active photocell
	Machine automation paused (Carousel Frozen)
	Shuttle detected by the photocell
	NOT ready for refill
	Ready for refill
	One or more circuits need to be refilled
	One or more products are expired

At the bottom of each page we found the following tool bar with the following buttons:

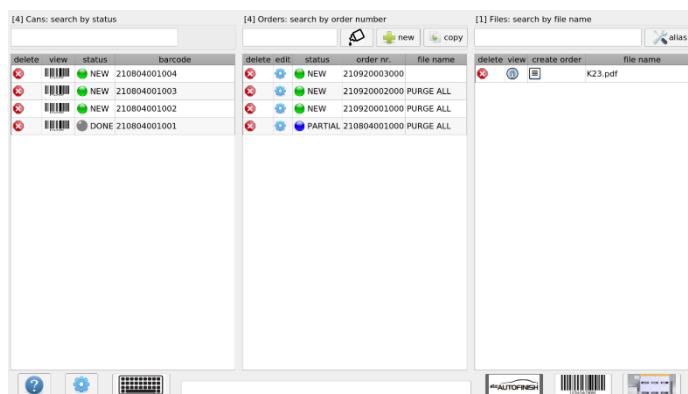


Button/image	Description
	Access user guide
	Access control panel
	Show keyboard

 1234567890	Access order page
	Access home page

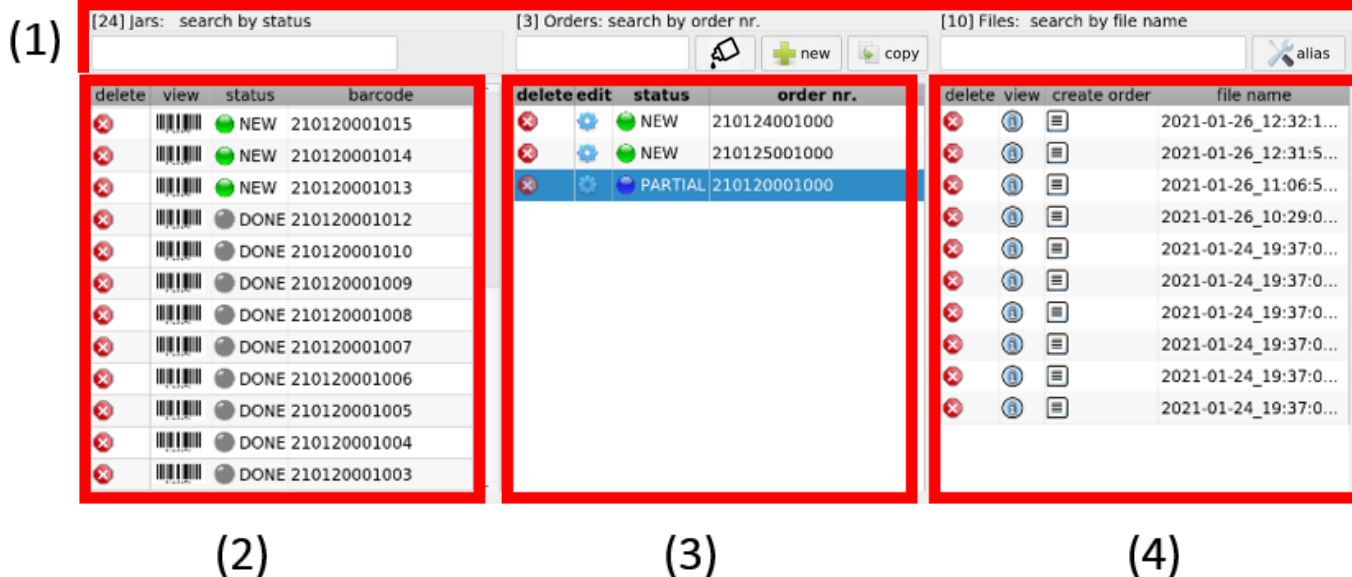
2. ORDER PAGE

The operator can access the order page by clicking on the barcode button on the tool bar. From this page the operator can control all the orders to be produced, in progress and completed, as well as adding new orders or deleting existing ones.



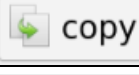














The image below shows the four sections of the order page:

- **Top bar (1)**: search features, copy or create a new order, purge all command, alias list
- **List of cans (2)**: shows the list of single cans to be produced/in progress or completed;
- **List of orders (3)**: shows the list of orders to be produced;
- **List of color formulas (4)**: shows the list of color formulas received by an external source or

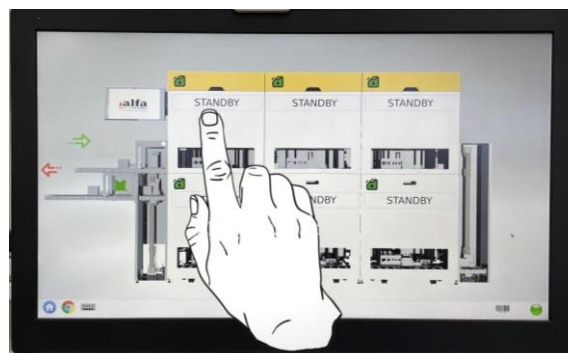


Below the list of the main buttons/images of order page and their meaning:

Button/image	Description
	Creates an order to purge all circuits
	Manually insert a new order
	Copy an existing order
	Shows the list of all products and all their possible names
	Delete an order
	New order, waiting to be produced (NEW)
	Completed order (DONE)
	Completed order but some products must be added manually (DONE!)
	Order in progress (IN PROGRESS)
	Order partially completed (PARTIAL)
	Order in error (ERROR)
	Print barcode of each order
	Edit an order
	Read the details of the color formula
	Create the order starting from the color formula

3. SERVICE PAGE

Each dispensing head has its own service page. To access service pages, please press on the rectangular button displaying its status. You can access the service page anytime, independently from the status of each dispensing head.



Each service page consists of 3 main sections as the image below:

- **Top part (1):** main machine status information.
- **Central part (2):** machine maintenance command.
- **Bottom part (3):** the information about the circuits.

(1)

STATUS	STANDBY	TEMPERATURE	49.60 °C	HUMIDIFIER WATER LEVEL	MINIMUM LEVEL	CAN PRESENCE	true
CAN ON SHELF	true	ERROR CODE	0	ERROR	NO_ALARM	AUTOCAP	OPEN

(2)

DIAGNOSTIC	WARM RESET	COLD RESET	ABORT	AUTOCAP OPEN/CLOSE
PURGE_ALL	INTELLIGENT_PURGE			

(3)

Name	Component	Curr Level	Max Level, Res Level, Min Level	Stirring	Recirc.	Purge [cc]	Refill [cc]	Specific Weight [g/cc]	QRcode Input
B01	Base Blanca	2985.00	22000.0 2000.00 2000.0	start stop	start stop	20.0	purge	0	1.986 QRcode
B02	Base Neutra	21231.99	22000.0 2000.00 2000.0	start stop	start stop	20.0	purge	0	1.07 QRcode
C01	pigment_01	1197.70	1500.0 300.00 200.0	start stop	start stop	2.0	purge	0	1.0 QRcode
C02	K200	680.58	1500.0 300.00 200.0	start stop	start stop	2.0	purge	0	1.026 QRcode
C03	pigment_03	965.00	1500.0 250.00 200.0	start stop	start stop	2.0	purge	0	1.0 QRcode
C04	pigment_04	974.00	1500.0 250.00 200.0	start stop	start stop	2.0	purge	0	1.0 QRcode
C05	YELLOW OXIDE XC26	817.30	1500.0 250.00 200.0	start stop	start stop	2.0	purge	0	1.877 QRcode
C06	MAGENTA XC147	735.64	1500.0 250.00 200.0	start stop	start stop	2.0	purge	0	1.125 QRcode
C07	BLUE XC6	774.45	1500.0 250.00 200.0	start stop	start stop	2.0	purge	0	1.188 QRcode


















































The **top part (1)** is quite intuitive and shows the status of the machine and the status of some of its parameters or functions.

STATUS	STANDBY	TEMPERATURE	32.50 °C	HUMIDIFIER WATER LEVEL	OK	CAN PRESENCE	false
CAN ON SHELF	false	ERROR CODE	0	ERROR	NO_ALARM	AUTOCAP	OPEN

The **central part (2)** contains maintenance buttons that refer to that particular dispensing head.

Name	Description
DIAGNOSTIC	Enter DIAGNOSTIC mode to give manual commands.
WARM RESET	This RESET can be carried out when the dispenser is not in ALARM mode but in DIAGNOSTIC mode: it exits DIAGNOSTIC mode without performing movements that are not strictly necessary.
COLD RESET	This RESET performs a complete reset of the machine, starting all photocell search movements. It is necessary to send this command when the dispenser assumes the ALARM status in order to restore the STANDBY status.
ABORT	The dispensing head stops all activities and needs a COLD RESET to get back to STANDBY status.
PURGE ALL	Start purge operation for all circuits with the amount set by default.

The **bottom part (3)** refers to the products circuits. Each line represents one circuit associated to a specific product, while the columns contain parameters and controls of each circuit, as described in more details below.

Name	Component	Curr Level	Max Level, Res Level, Min Level	Stirring	Recirc.	Purge [cc]	Refill [cc]	Specific Weight [g/cc]	QRcode input
C01	 pigment_01	1197.70	1500.0 300.00 200.0	 	 	2.0 	0 	1.0	QRcode
C02	 K200	680.58	1500.0 300.00 200.0	 	 	2.0 	0 	1.026	QRcode
C03	 pigment_03	965.00	1500.0 250.00 200.0	 	 	2.0 	0 	1.0	QRcode
C04	 pigment_04	974.00	1500.0 250.00 200.0	 	 	2.0 	0 	1.0	QRcode
C05	 YELLOW OXIDE XC26	817.30	1500.0 250.00 200.0	 	 	2.0 	0 	1.877	QRcode
C06	 MAGENTA XC147	735.64	1500.0 250.00 200.0	 	 	2.0 	0 	1.125	QRcode
C07	 BLUE XC6	774.45	1500.0 250.00 200.0	 	 	2.0 	0 	1.188	QRcode

Name	Description
NAME	The name of the circuit displayed as "CX" where X is a number from 01 to 16.
COMPONENT	The name of the product contained in the circuit and its RGB.
CURR LEVEL	The current level of the product contained in the circuit (expressed in cc).
MAX LEVEL RES LEVEL MIN LEVEL	The maximum level of product that can be contained in each circuit. The product warning level (the circuit will continue to dispense). The product minimum level (the circuit will stop to dispense).
STIRRING	Manual START and STOP stirring commands. When the stirring command is given for a circuit, all the circuits of the same dispensing head are stirred because the function is associated with the rotation of the turning table.
RECIRC	Manual START and STOP recirculation commands

PURGE (cc)	Purge a single circuit with the amount set by default. The value can be manually increased or decreased by modifying the value displayed in the box.
REFILL (cc)	Refill a single circuit by the quantity expressed in cc. The command to rotate the table will be executed to set the circuit to the refill position.
SPECIFIC WEIGHT(g/cc)*	At each refill the operator can manually modify the specific weight of the product and the circuit will dispense accordingly.
QRcode INPUT*	Scan the QRcode on the product's package to complete all refill information automatically (refill amount and specific weight).

***these fields are optional**

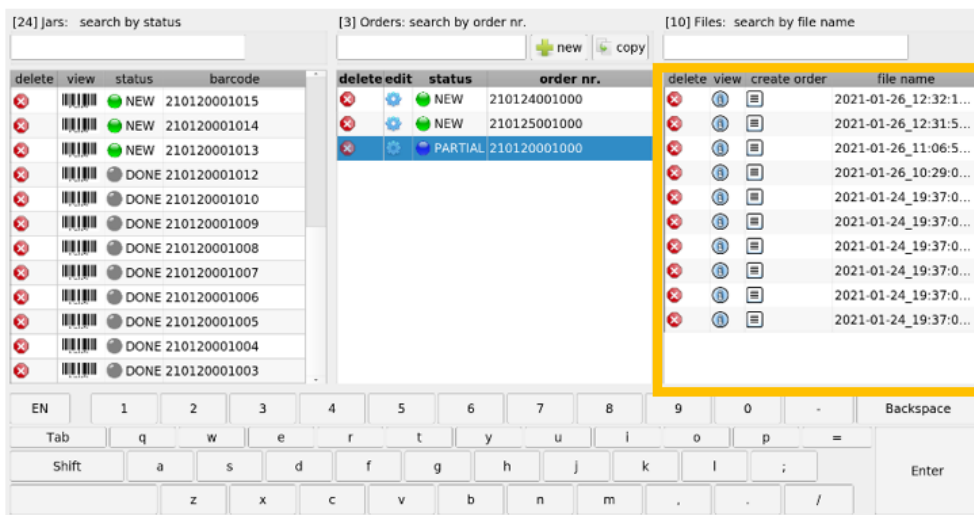
4. HOW TO PRODUCE A COLOR

There are two ways to produce a Color formula:

- A. The Formula software is directly integrated with the Machine and sends the color formula to be dispensed to the machine.
- B. The Formula software generates a file in an appropriate format. The file is saved in a select folder, and send to the CR by the Watchdog File.

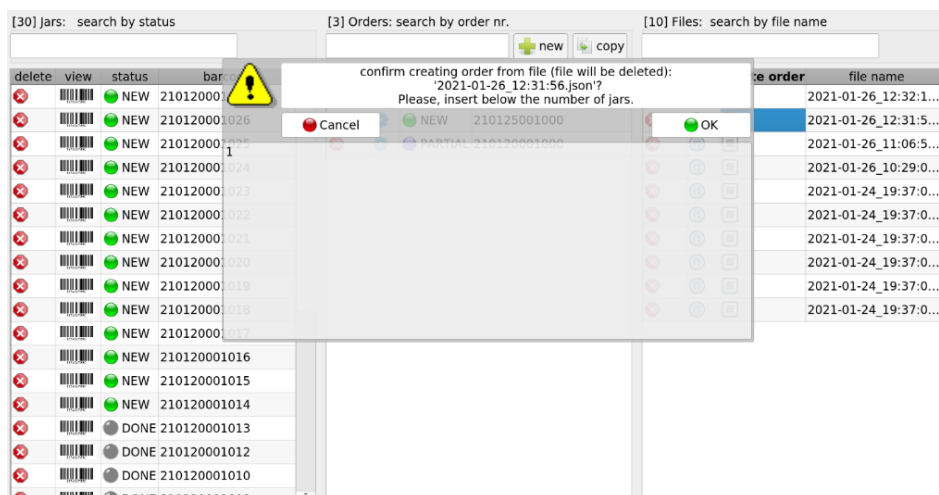
File Watchdog is a software application that allow to send the formula file generated by the formula software to the CR machine.

In both cases once the machine has received the information, the color formula will appear on the right column in the order page. The page must be refreshed in order to see the new orders.

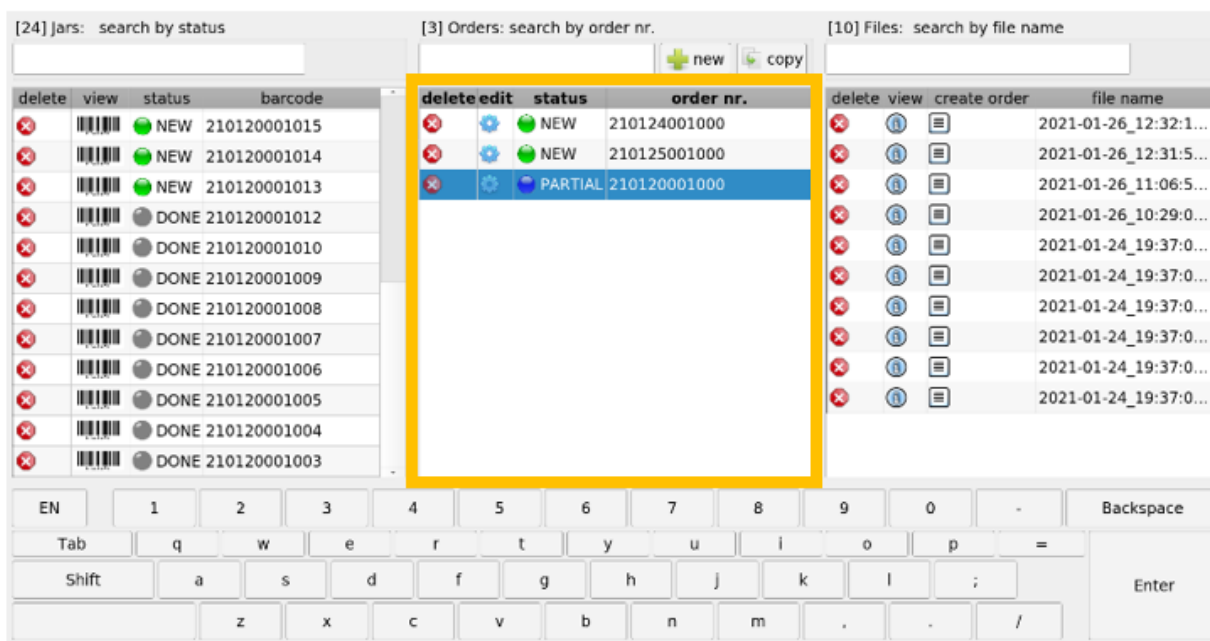



To proceed with order creation and dispensing, follow the steps below:

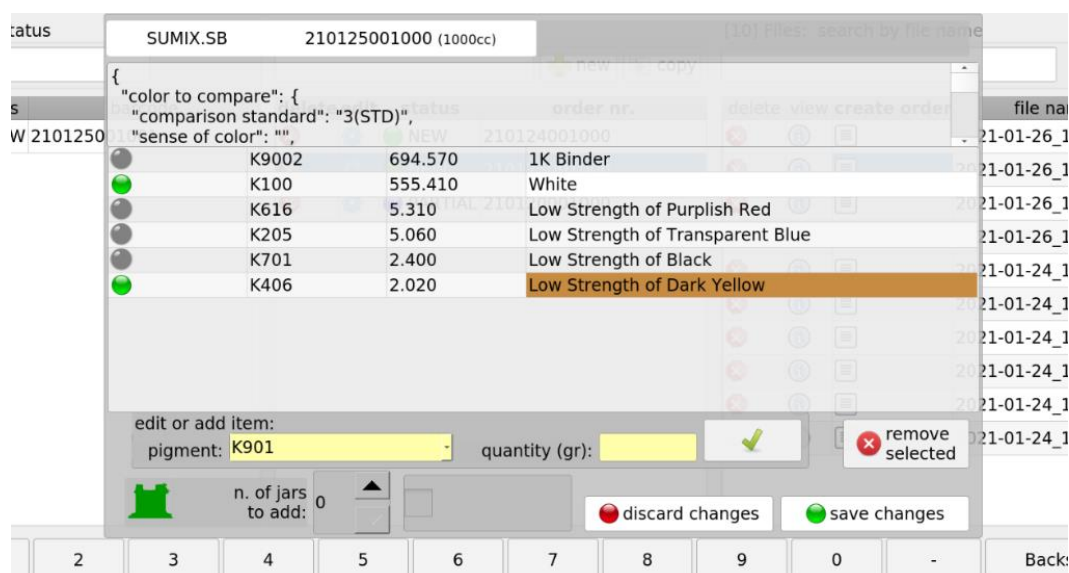
1. Click the CREATE ORDER button  select the number of cans to be produced and click OK.



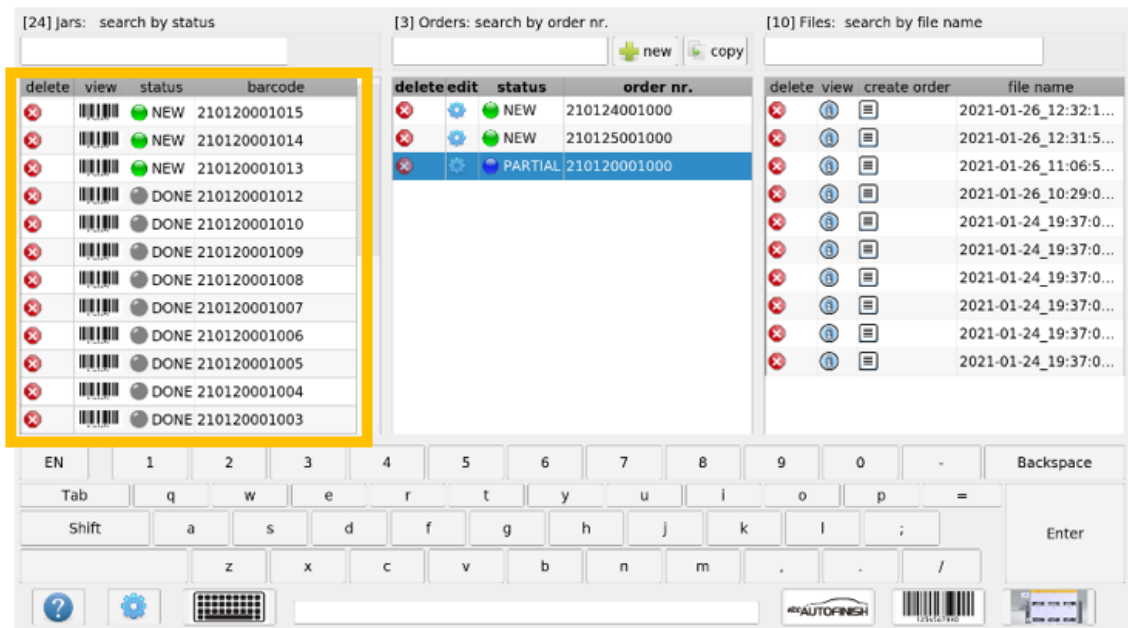
- The new order will appear on the central column in the order page.



- An order can be edited by clicking on the gear symbol . A pop up will show the color formula. Each line represents a product that will be dispensed to reproduce the color formula. The color formula can be edited by modifying the amount of each product to be dispensed, by adding a new product or by deleting one. The operator can then select the number of cans/jars to produce and print the required barcodes.



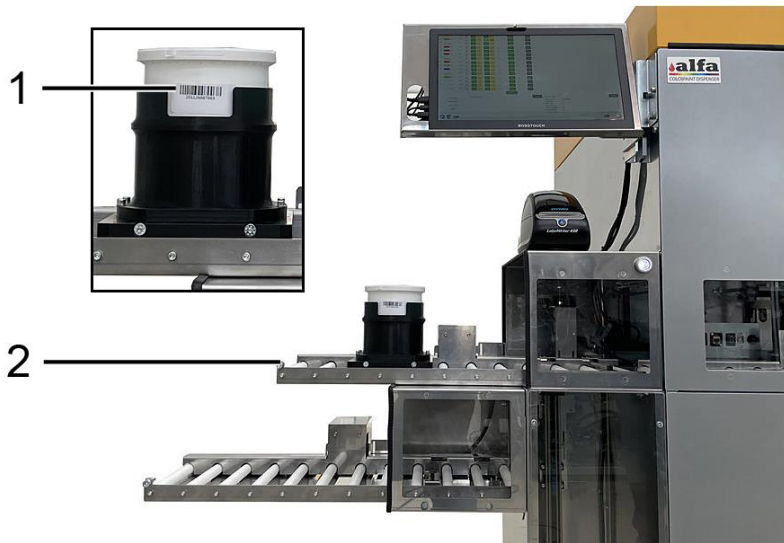
4. When an order is saved each can to be produce will appear on the left column in the order page. Here the operator can click on each barcode symbol to print again each barcode.



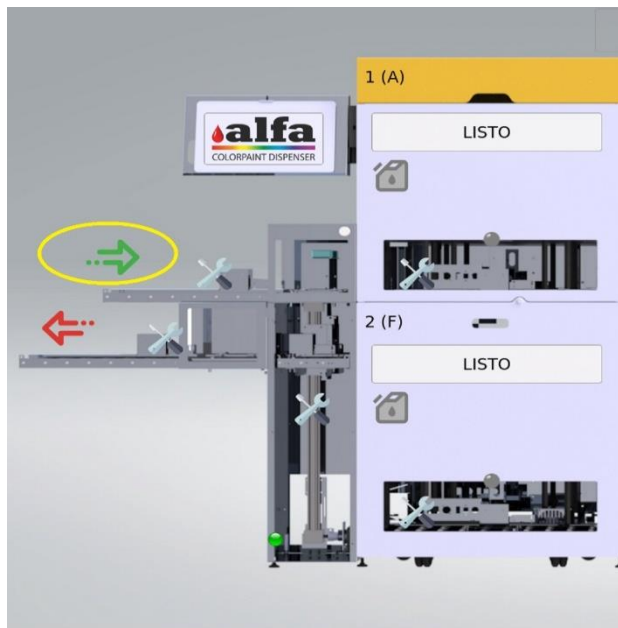
5. Apply the barcode label on the can and position it on a shuttle with a greater or equal capacity of the requested can.



6. Pay attention to position the barcode so that it can be fully read in the shuttle window (1) and position the shuttle on the loading roller conveyor (2).



7. To start the production process, press the “green arrow” button (1). The software will carry out a consistency check between the volume expected from the order (barcode reading) and the volume of the can (shuttle code reading).

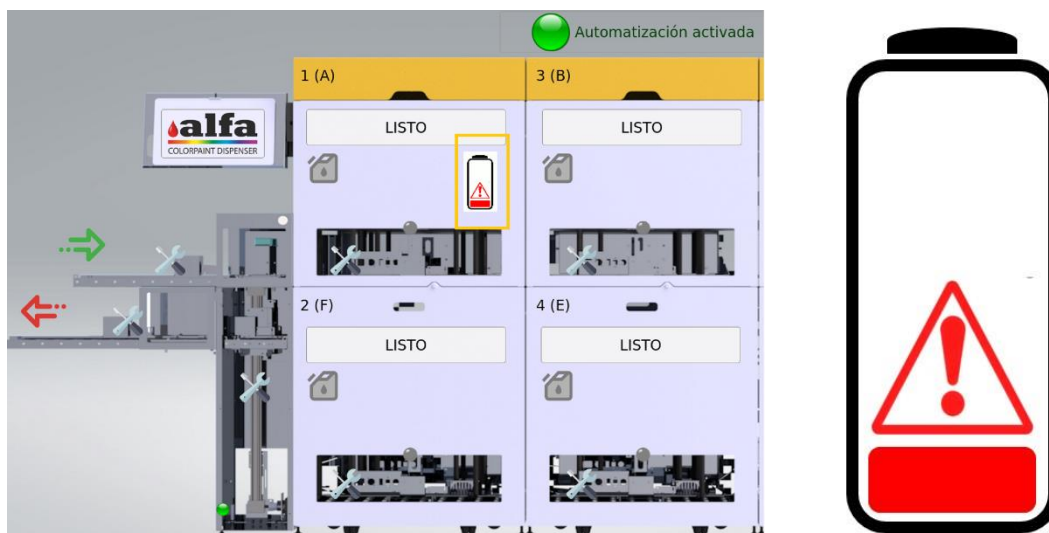


8. Wait for process completion, then remove the shuttle from the output roller conveyor by pressing the red arrow.

5. HOW TO REFILL A CANISTER

The refill procedure can be carried out with the Barcode reader (optional) reader or without.

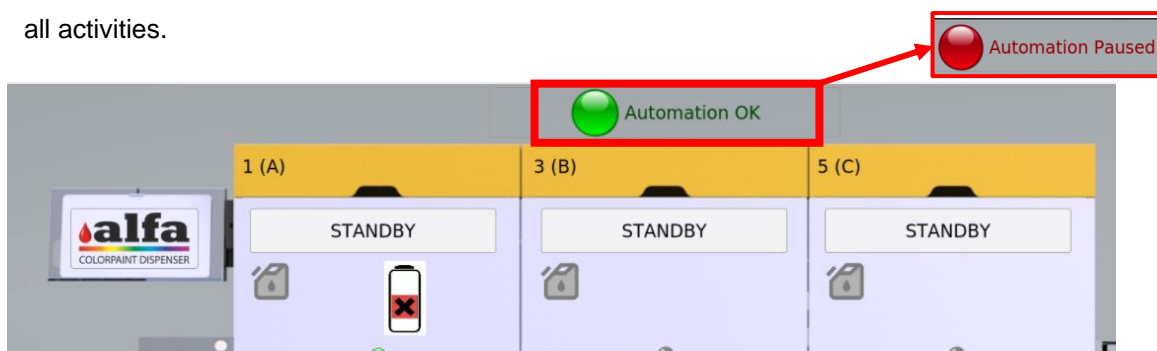
Each circuit can be set with a different reserve and minimum level when setting the machine. When a product reaches the warning reserve level, an alarm will be shown.



ATTENTION! Every time an order is sent to be produced, the software calculates if the volume of each product in the canisters is sufficient to complete the formula so that the residual volume is not lower than the minimum level. In case one of the products is not sufficient, the system will not dispense the formula.

Refill procedure without Barcode:

1. To start the refill process please click on the automation button on the top of the Home Page to pause all activities.



- When the activities of all dispensing heads are paused, the refill tanks will become green on all dispensing heads. To proceed please click on the service button of the dispensing head where the canister to be refilled is positioned.



- Click on the REFILL button of the canister you need to top up. A pop up message will appear to confirm the positioning of the canister in the front position of the dispensing head.

ESTADO	STANDBY	TEMPERATURA	23.00 °C	NIVEL DE AGUA HUMIDIFICADOR			
ENVASE EN LA PLATAFORMA	NO	CÓDIGO DE ERROR	NO_ALARM	ERROR			
<div> DIAGNÓSTICO WARM RESET COLD RESET ABORTAR </div> <div> PURGAR TODOS UNIT: CC </div>							
Componente	Curr Level	Max Level, Res Level, Min Level	Agitar	Recirc.	Purga	Llenar	Specific Weigh [g/cc]
K205	0.00	1500.00 400.00 300.00	start stop				1.01
K404	1137.73	1500.00 400.00 300.00	start stop				1.051
K406	1351.54	1500.00 400.00 300.00	start stop				1.124
K9001	2095.52	3000.00 600.00 500.00	start stop	start stop	2.00 purga	0 llenar	1.063
K801	1284.99	1500.00 400.00 300.00	start stop	start stop	2.00 purga	0 llenar	1.046

JavaScript Confirm...81/service_page/

confirm positioning turntable to pipe: C01

OK Cancel

- While the turning table is positioning the canister in the front position (if necessary), the status of the turning table is ROTATING. When the positioning is completed the status becomes DIAGNOSTIC. Please wait the DIAGNOSTIC status before opening the cover/extractable tray of the dispensing head.

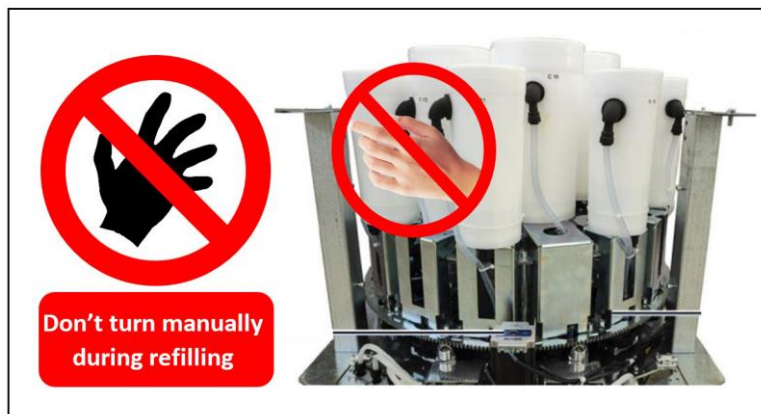
Home 21 Oct 2022 (04:00)

ESTADO	ROTATING
ENVASE EN LA PLATAFORMA	NO

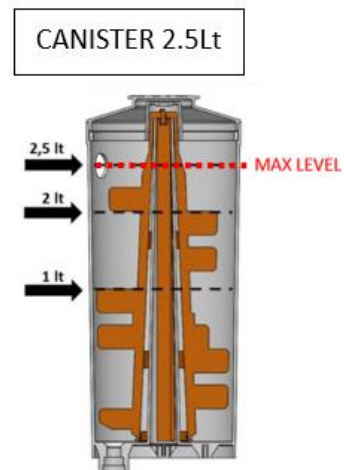
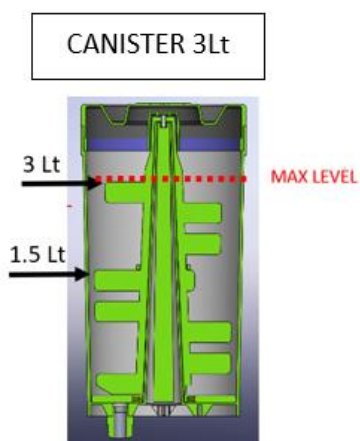
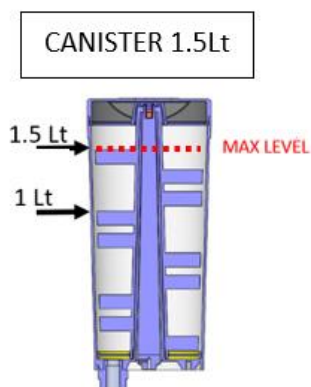
Home 21 Oct 2022 (04:00)

ESTADO	DIAGNOSTIC
ENVASE EN LA PLATAFORMA	NO

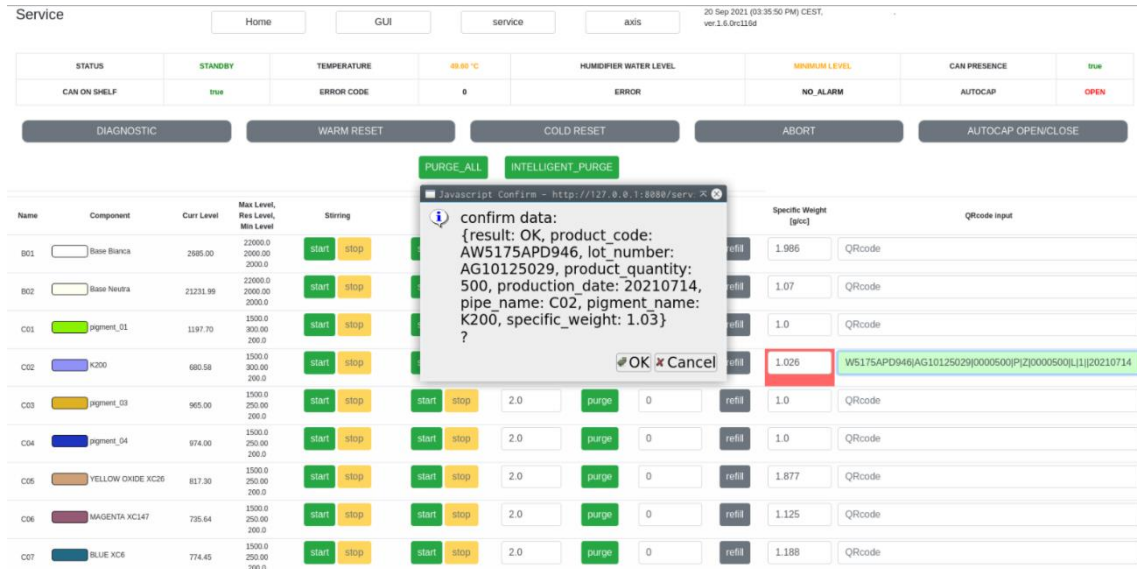
5. **WARNING!** Do not force manually the turning table rotation. Use the software controls and wait that the machine performs the necessary rotation.



6. When the status switches to DIAGNOSTIC, open the upper cover or the extractable tray. Remove the lid of the canister in the front position. Fill the canister with the appropriate product without exceeding the maximum level (MAX LEVEL).

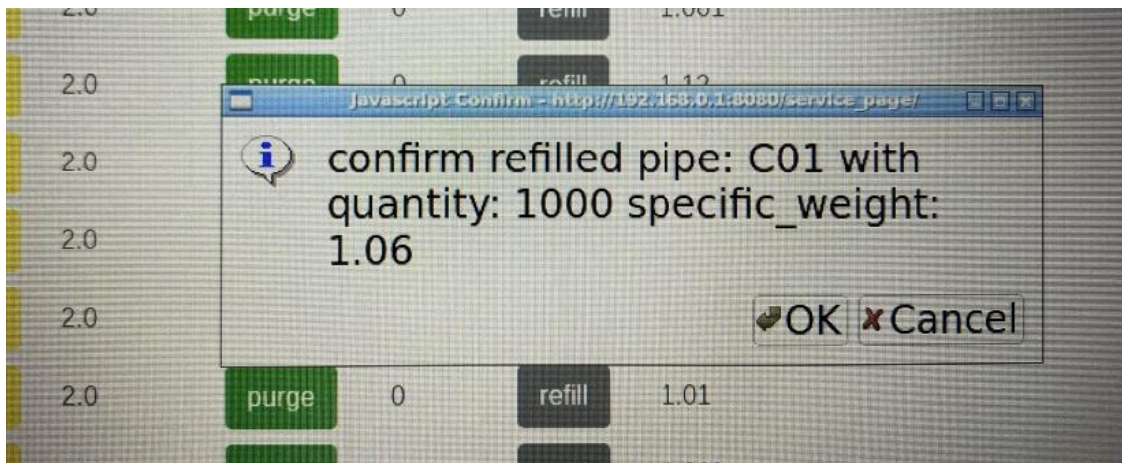


7. After each top-up operation, you must record the quantity added in the circuit and its specific weight (if this was different from the previous batch). These information are filled automatically when the operator scans the QRcode present on the product's package. In this case a pop up message will appear showing all information recorded with the QRcode.



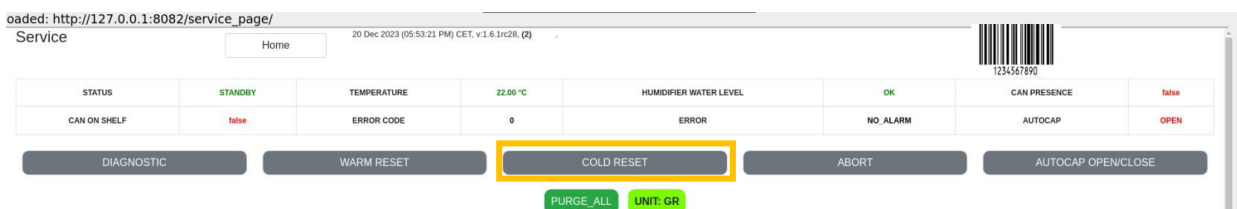
The screenshot shows the 'Service' page of the HMI. At the top, there are tabs for 'Home', 'GUI', 'service', and 'axis'. The 'service' tab is active. Below the tabs, there is a status bar with fields for STATUS (STANDBY), TEMPERATURE (48.88 °C), HUMIDIFIER WATER LEVEL (MINIMUM LEVEL), CAN PRESENCE (true), CAN ON SHELF (true), ERROR CODE (0), ERROR, NO_ALARM, and AUTOCAP (OPEN). Below the status bar, there are buttons for DIAGNOSTIC, WARM RESET, COLD RESET, ABORT, and AUTOCAP OPEN/CLOSE. A table lists components with columns: Name, Component, Curt Level, Max Level, Min Level, Start, Stop, and Specific Weight. A JavaScript confirm dialog is open, displaying the following data: {result: OK, product_code: AW5175APD946, lot_number: AG10125029, product_quantity: 500, production_date: 20210714, pipe_name: C02, pigment_name: K200, specific_weight: 1.03}. The dialog has OK and Cancel buttons.

8. In alternative, the information can be filled manually by entering in the REFILL(cc) box the quantity of product refilled and in the SPECIFIC WEIGHT (g/cc) box the new specific weight, then click the REFILL button. A pop up box will appear to confirm the amount refilled and the specific weight. If everything is correct please press OK.



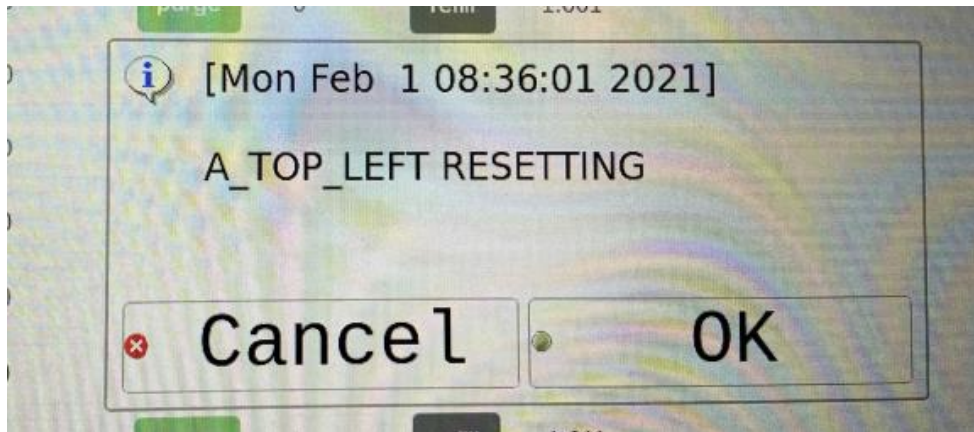
The screenshot shows the 'Service' page of the HMI. A JavaScript confirm dialog is open, displaying the following data: confirm refilled pipe: C01 with quantity: 1000 specific_weight: 1.06. The dialog has OK and Cancel buttons.

9. If another circuit in the same dispensing head must be topped up, please repeat the steps 3 to 8. When all canisters are refilled, please close the top cover or the extractable tray and click the COLD RESET button.



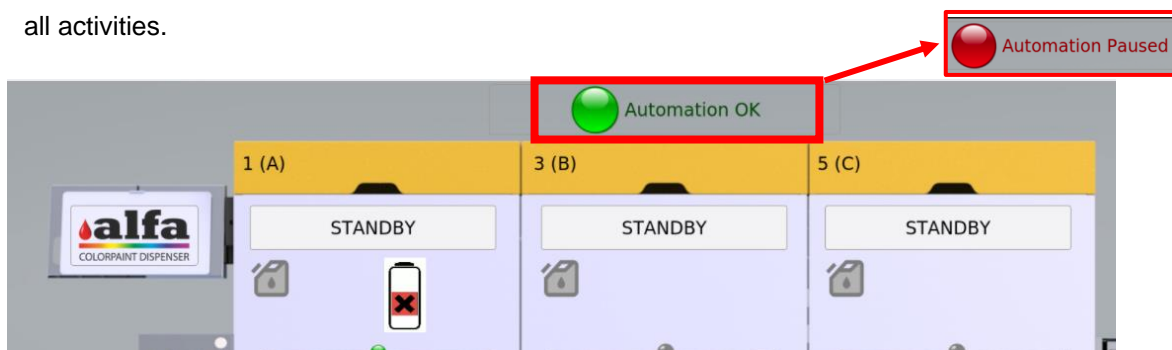
The screenshot shows the 'Service' page of the HMI. The 'COLD RESET' button is highlighted with a yellow box. The status bar shows STATUS (STANDBY), TEMPERATURE (22.00 °C), HUMIDIFIER WATER LEVEL (OK), CAN PRESENCE (false), CAN ON SHELF (false), ERROR CODE (0), ERROR, NO_ALARM, and AUTOCAP (OPEN). Below the status bar, there are buttons for DIAGNOSTIC, WARM RESET, COLD RESET, ABORT, and AUTOCAP OPEN/CLOSE. A barcode is visible on the right side of the page.

10. A pop up message will inform you that the dispensing head is running the reset procedure. Please press OK.

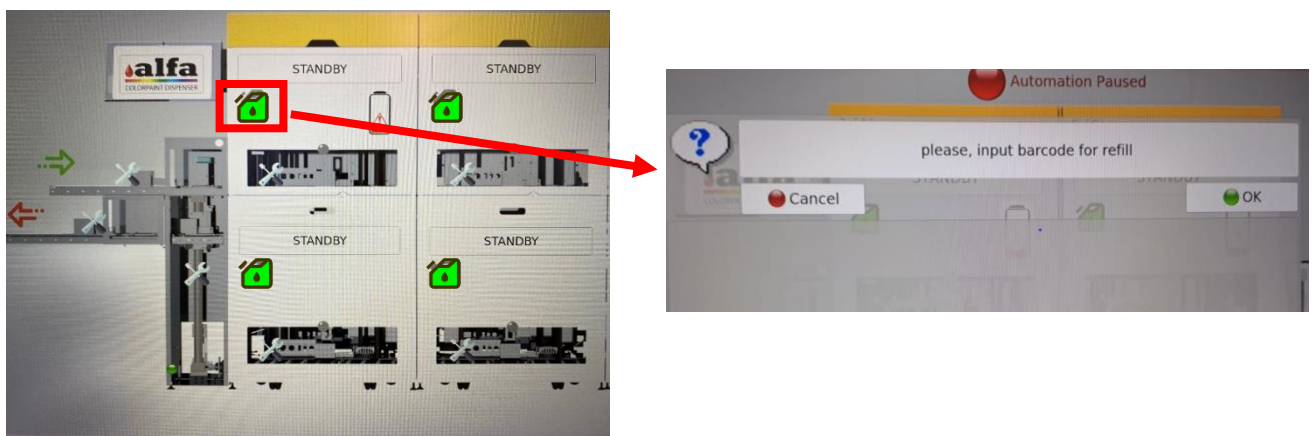


Refill procedure with barcode:

1. To start the refill process please click on the automation button on the top of the Home Page to pause all activities.



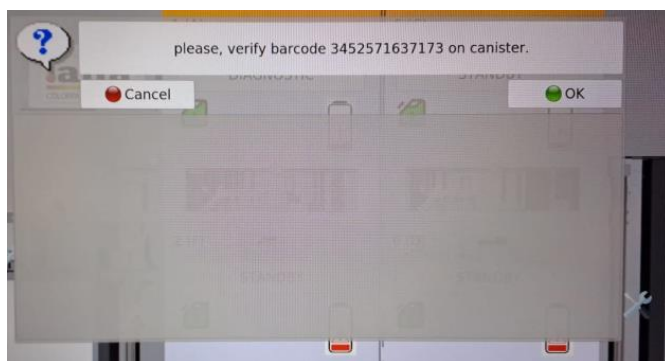
2. When the activities of all dispensing heads are paused, the refill tanks will become green on all dispensing heads. To proceed, please click on the green tank of the dispensing head where the canister to be refilled is positioned. A message of input a barcode will appear.



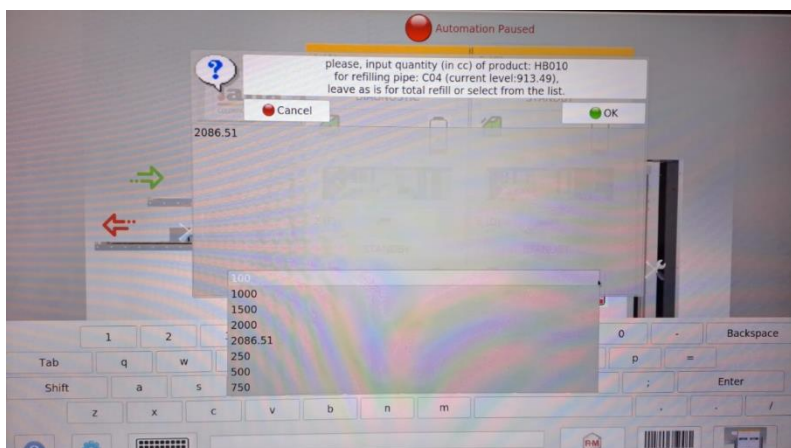
3. Scan the barcode of the on the packaging of the product you want to refill.



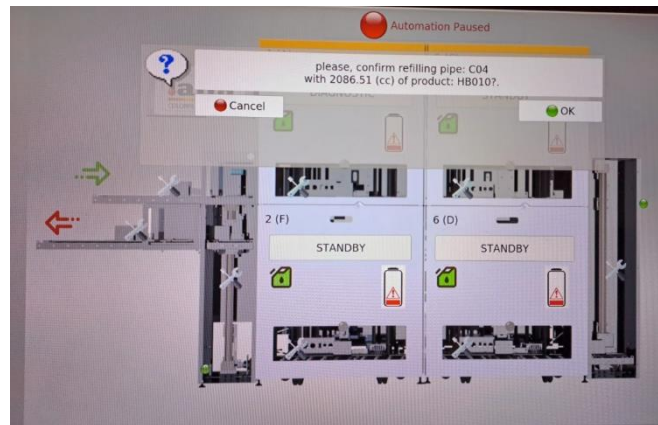
4. The software automatically rotate the carousel by positioning the circuit on the front position of the dispensing head. A message will appear on the screen to verify with the scan the barcode on the canister for a double check.



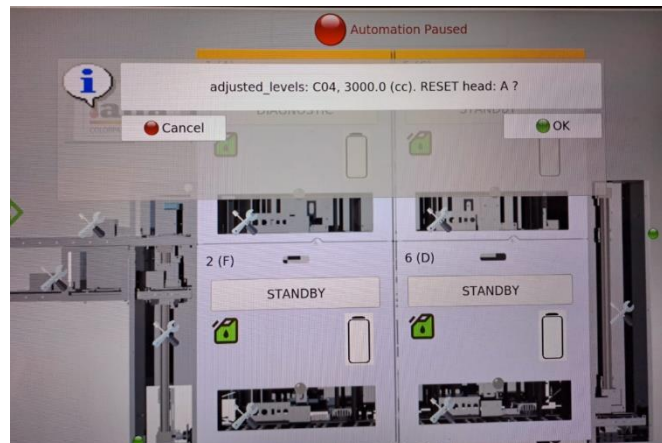
5. If the match is correct, on the screen will appear indication on the circuit, product name, actual fill level and quantity to be refill to achieved the full top level, anyway is possible to chose a different quantity to refill.



6. A pop up box will appear to confirm the amount refilled and the specific weight. If everything is correct please press OK.



7. If another circuit in the same dispensing head must be topped up, click on cancel and repeat the steps 1 to 5. When all canisters are refilled, please close the top cover or the extractable tray and click ok on the last pop up box to confirm the reset.



6. HOW TO CANCEL A CAN FROM AUTOMATION

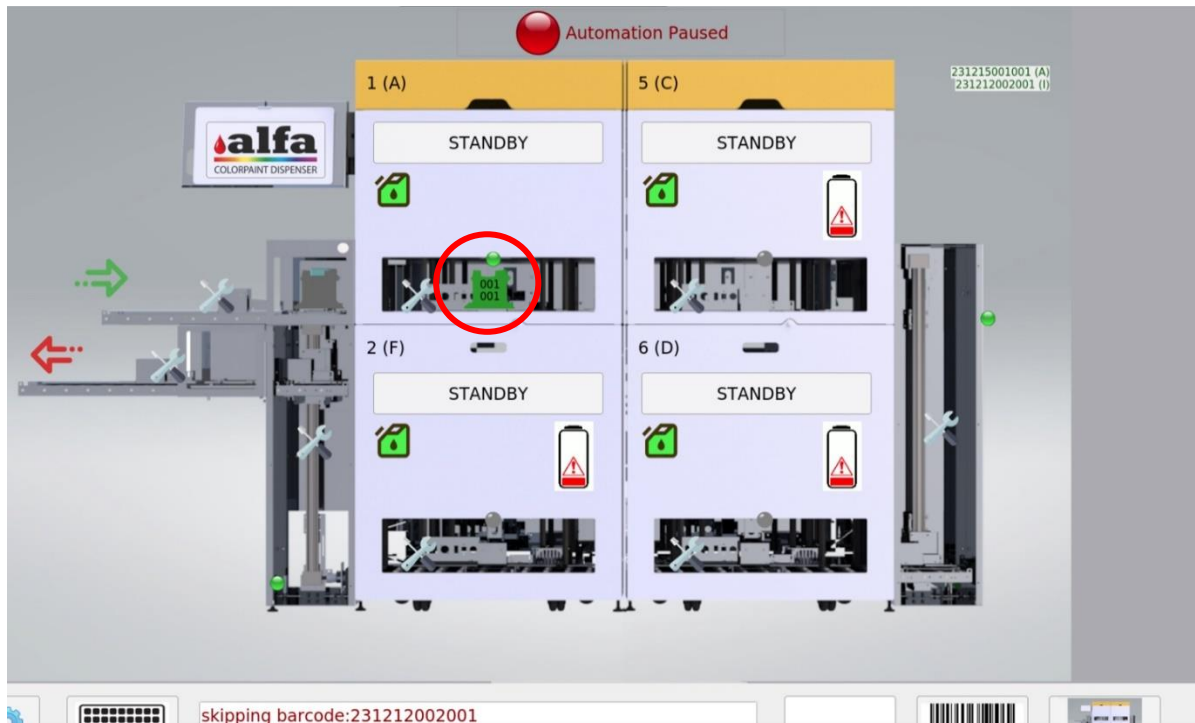
Once the barcode has been read, the automation keeps in memory this one in order to progress it on the sequence automation. If is needed, for a certain reason, to remove a can form the sequence automation, there are two possibilities to proceed.

Standard mode

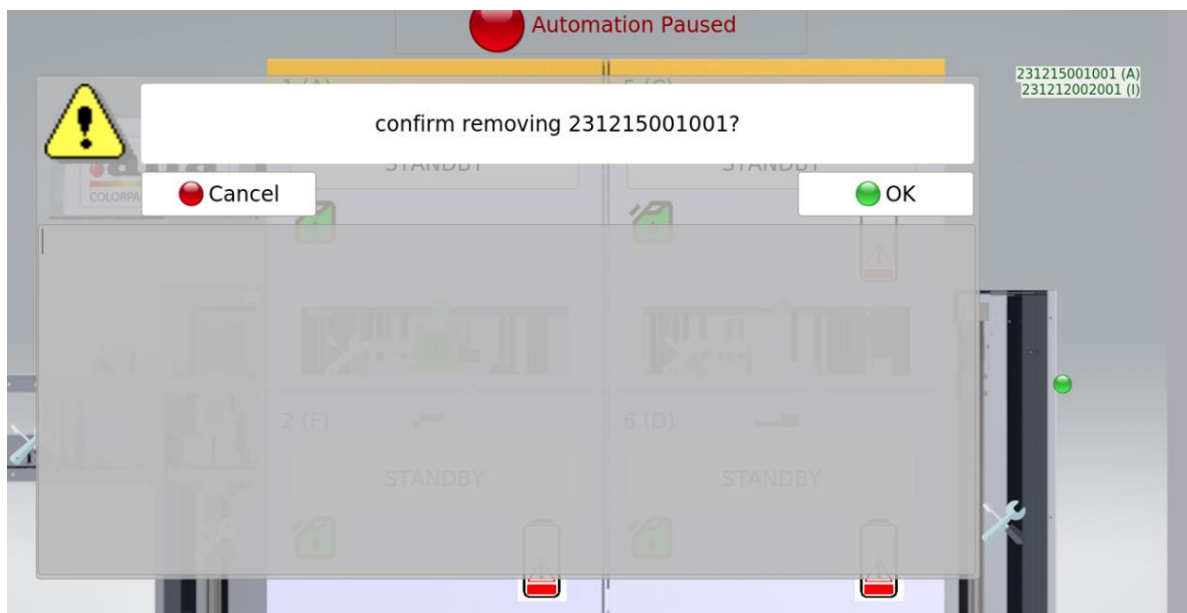
1. Put the automation on pause



2. When all the pop up message are terminate and the tanks are green is possible to click directly from the screen on the can to remove, if it is remove on the memory, the can must also physically remove.
- 3.



4. A pop up message appear to confirm the operation.



Advanced mode

1. Put the automation on pause.



2. When all the pop up message are terminate and the tanks are green click on the gear of the main page
3. Opening the page is possible to find, on the top right, the list of the can present in the automation sequence (there are barcode numbers of the cans and the position). By pressing cancel is possible to remove the relative can and proceed to remove it physically.

app ver.: 0.0.1rc181a - jar_size_detect:1, 0x01 ready_to_read_a_barcode:False [Fri Dec 22 10:24:38 2023]
 carousel_frozen:True - mirror: 0x200 0x00
 Change Language to: [ENGLISH](#) - [KOREAN](#) - [ITALIAN](#) - [FRENCH](#) - [GERMAN](#) - [SPANISH](#)

```
# "jar photocells status" mask bit coding:
0000 0000 0001 | 0x0001 # bit0: JAR_INPUT_ROLLER_PHOTOCELL
0000 0000 0010 | 0x0002 # bit1: JAR_LOAD_LIFTER_ROLLER_PHOTOCELL
0000 0000 0100 | 0x0004 # bit2: JAR_OUTPUT_ROLLER_PHOTOCELL
0000 0000 1000 | 0x0008 # bit3: LOAD_LIFTER_DOWN_PHOTOCELL
0000 0001 0000 | 0x0010 # bit4: LOAD_LIFTER_UP_PHOTOCELL
0000 0010 0000 | 0x0020 # bit5: UNLOAD_LIFTER_DOWN_PHOTOCELL
0000 0100 0000 | 0x0040 # bit6: UNLOAD_LIFTER_UP_PHOTOCELL
0000 1000 0000 | 0x0080 # bit7: JAR_UNLOAD_LIFTER_ROLLER_PHOTOCELL
0001 0000 0000 | 0x0100 # bit8: JAR_DISPENSING_POSITION_PHOTOCELL
0010 0000 0000 | 0x0200 # bit9: JAR_DETECTION_MICROSWITCH_1
0100 0000 0000 | 0x0400 # bit10: JAR_DETECTION_MICROSWITCH_2
```

```
# progressing_jars:
0:[m:None, status:ENTERING, position:IN, 231212002000:1] d:0.0 CANCEL
1:[m:[0:A], status:PROGRESS, position:A, 231215001000:1] d:38.0 CANCEL
```

ord.	name	addr	jar_photocells_status	crx_outputs	(cp) level (cs)	last update	commands
head 1	A	127.0.0.1	0011 0000 0001 0x0301	0000 0000 0x00 0	(1) STANDBY (0)	10:23:26	RESET LOTINFO UPDATE DIAG
head 5	C	127.0.0.1	0000 0000 0000 0x0000	0000 0000 0x00 0	(0) STANDBY (0)	10:17:37	RESET LOTINFO UPDATE DIAG
head 6	D	127.0.0.1	0000 0001 0000 0x0010	0000 0000 0x00 0	(0) STANDBY (0)	10:24:37	RESET LOTINFO UPDATE DIAG
head 2	F	127.0.0.1	0000 0010 0000 0x0020	0000 0000 0x00 0	(0) STANDBY (0)	10:24:11	RESET LOTINFO UPDATE DIAG

move.00_01	move.01_02	move.02_03	move.03_04	move.04_05	move.05_06	move.06_07	move.07_08	move.08_09	move.09_10	move.10_11	move.11_12
download KCC Specific Gravity file	freeze carousel	unfreeze carousel	stop_all	alert	remote UI	show network	show settings	minimize main window	open URL in text bar	open admin page in firefox	move.12_00
run a complete cycle	refresh	clear jars	clear answers	reset jar db status	reset all heads	EXIT	ALARM	read barcode	delete orders in db	open order dialog	view orders

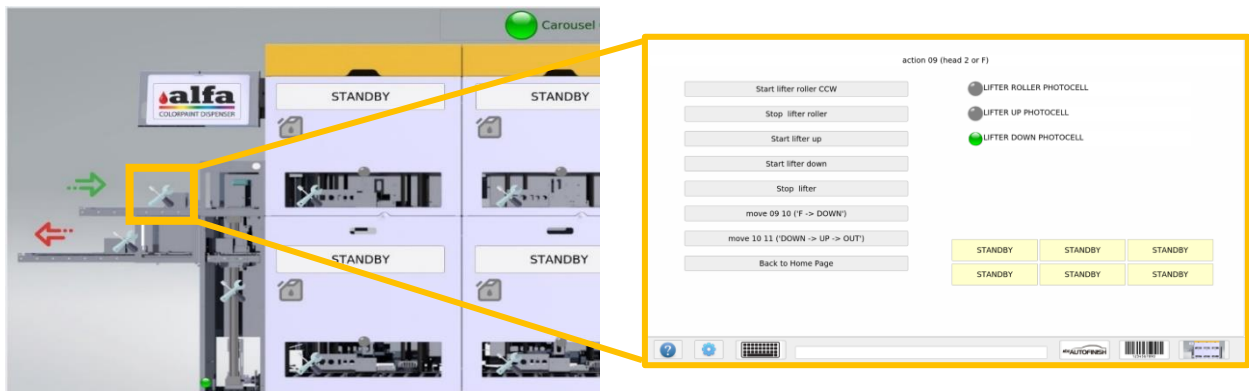
```

Fri Dec 22 10:17:21 2023: {'status_code': 0, 'error': 'no error', 'command': 'CRX_OUTPUTS_MANAGEMENT_END'}
A:Fri Dec 22 10:17:22 2023: {'status_code': 0, 'error': 'no error', 'command': 'CRX_OUTPUTS_MANAGEMENT_END'}
A:Fri Dec 22 10:17:22 2023: {'status_code': 0, 'error': 'no error', 'command': 'CRX_OUTPUTS_MANAGEMENT_END'}
A:Fri Dec 22 10:17:23 2023: {'status_code': 0, 'error': 'no error', 'command': 'CRX_OUTPUTS_MANAGEMENT_END'}
C:Fri Dec 22 10:17:35 2023: {'status_code': 0, 'error': 'no error', 'command': 'CRX_OUTPUTS_MANAGEMENT_END'}
C:Fri Dec 22 10:17:36 2023: {'status_code': 0, 'error': 'no error', 'command': 'CRX_OUTPUTS_MANAGEMENT_END'}
C:Fri Dec 22 10:17:37 2023: {'status_code': 0, 'error': 'no error', 'command': 'CRX_OUTPUTS_MANAGEMENT_END'}
  
```

skipping barcode: 231212002001

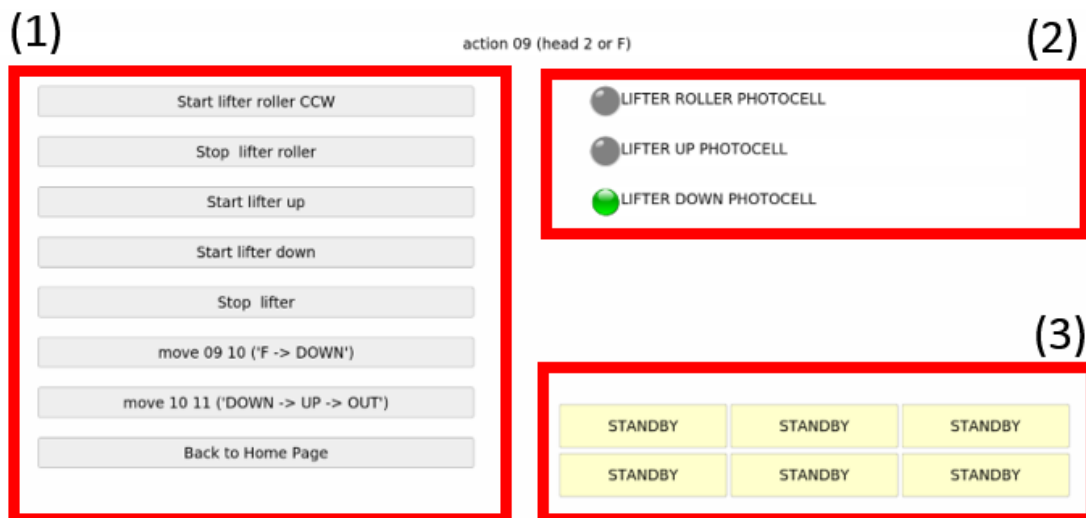
7. MANUAL CONTROL PAGE

By clicking on the TOOLS button, on the home page of the HMI, the operator can access the manual control page, where all manual commands buttons are located.



Each manual control page consists of 3 main sections as the image below:

- **Commands (1):** list of manual commands;
- **Photocells (2):** photocells status;
- **Dispensing heads (3):** dispensing heads status.



WARNING! the use of manual controls must be limited only to specific cases, and must be done by trained operators.

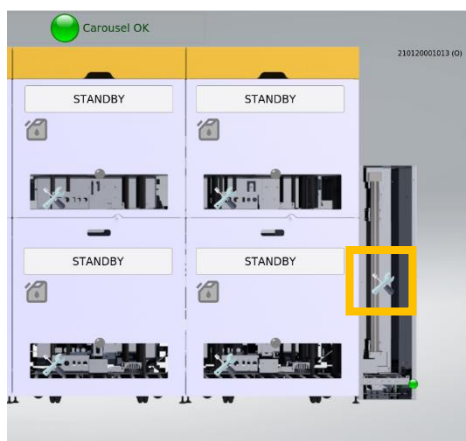
8. HOW TO MOVE THE SHUTTLE WITH MANUAL COMMANDS

Below the example of how to move the shuttle from dispensing head 5 to 6 using the lifter.

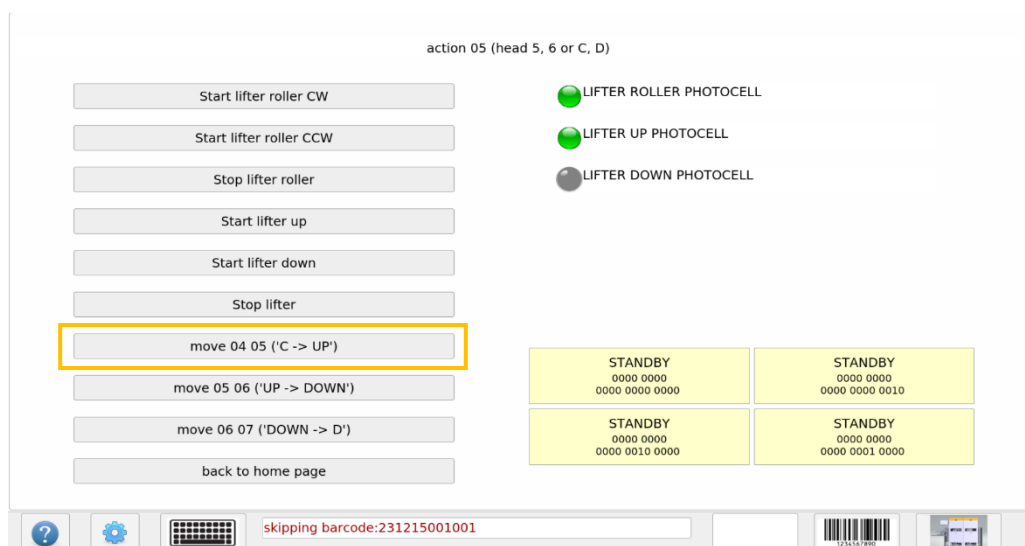
1. Make sure the shuttle is located under dispensing head 5.



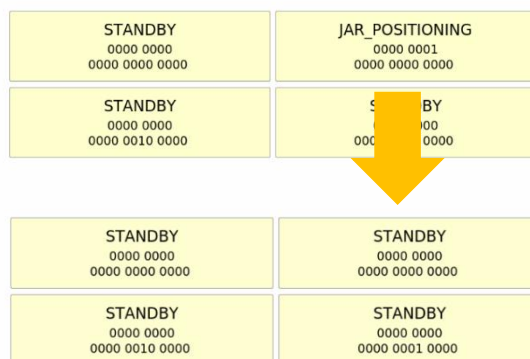
2. Press the TOOL button on lifter to access its manual command page.



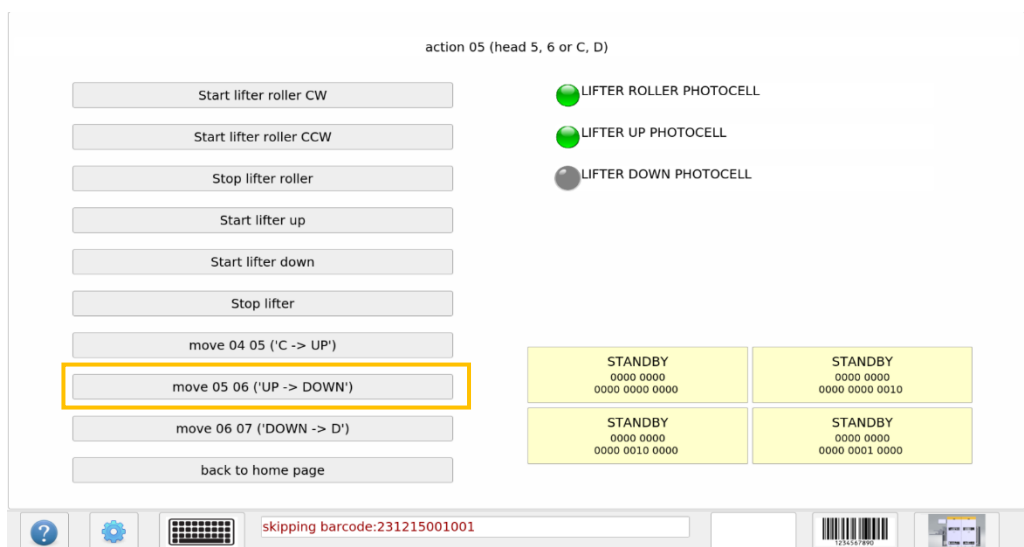
3. By clicking on “move 04 05 ('C-> UP')” the machine will automatically position the lifter up and load the shuttle.



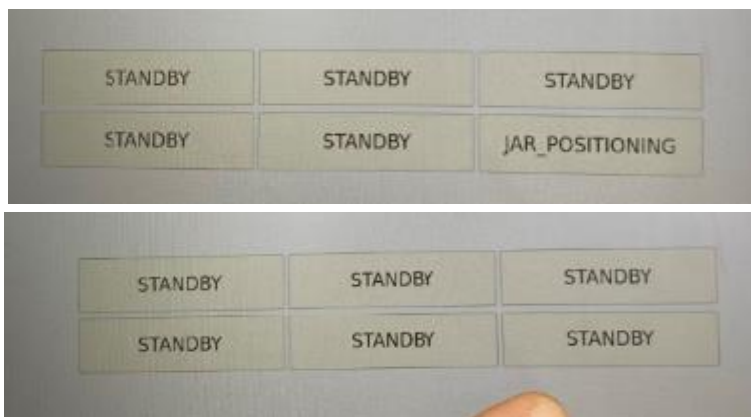
- The status of the dispensing head 5 will become JAR_POSITIONING. Please wait until the status go back to STANDBY.



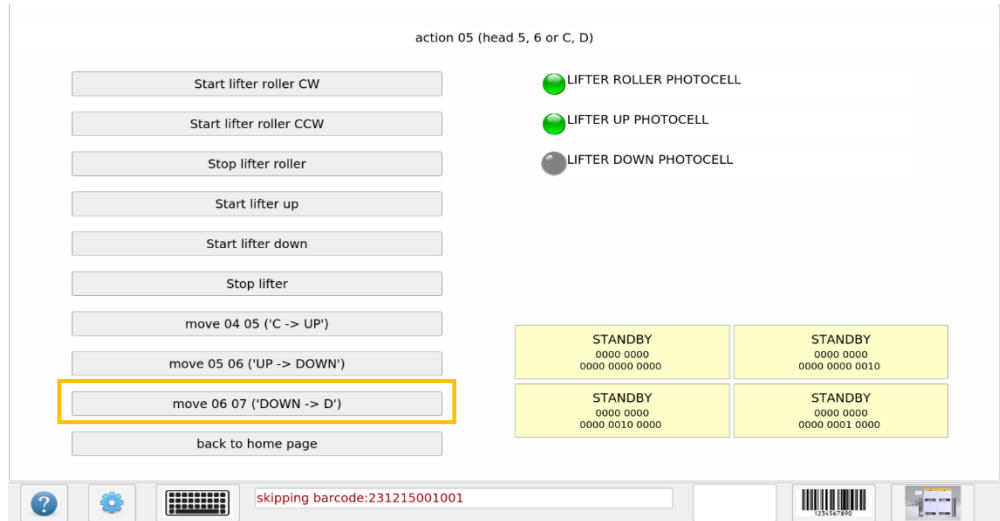
- Now click on “move 05 06 ('UP-> DOWN')” the machine will automatically move the lift with the shuttle down.



- The status of the dispensing head 6 will become JAR_POSITIONING. Please wait until the status go back to STANDBY.



- Now click on “move 06 07 ('DOWN-> D')” the machine will automatically move the shuttle from the lifter to dispensing head 6.


































8. The process is exactly the same for all dispensing heads. Just to summarize, these are the manual commands to be used to move the shuttle around manually:

Command	Description
move 01 02 ('IN -> A')	Move shuttle from barcode reader to dispensing head 1(A).
move 02 03 ('A -> B')	Move shuttle from dispensing head 1(A) to 3(B).
move 03 04 ('B -> C')	Move shuttle from dispensing head 3(B) to 5(C).
move 04 05 ('C -> UP')	Move shuttle from dispensing head 5(C) to lifter.
move 05 06 ('UP -> DOWN')	Move the lifter down.
move 06 07 ('DOWN -> D')	Move shuttle from lifter to dispensing head 6(D).
move 07 08 ('D -> E')	Move shuttle from dispensing head 6(D) to 4(E).
move 08 09 ('E -> F')	Move shuttle from dispensing head 4(E) to 2(F).
move 09 10 ('F -> DOWN')	Move shuttle from dispensing head 2(F) to lifter.
move 10 11 ('DOWN -> UP -> OUT')	Move the lifter up.

9. HOW TO PURGE ONE CIRCUIT, MORE CIRCUITS OR ALL CIRCUITS

The purge function consists in dispensing a small quantity of product from one or several circuits, so as to ensure proper cleaning of the dispensing circuits and prevent settling or drying out issues that could compromise machine operation.

To purge all circuits of all dispensing heads, please click on the button as shown in the image below. This will create a new order called PURGE ALL and the related barcode. The order contains all products and its automatically created with the defined purge quantity for each circuit.

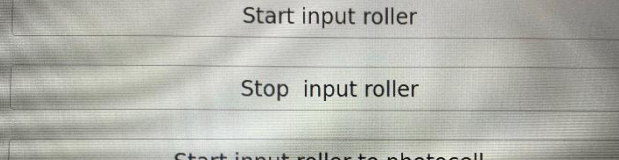
[4] Cans: search by status				[4] Orders: search by order number					[1] Files: search by file name			
<input type="text"/>				<input type="text"/>   					<input type="text"/> 			
delete	view	status	barcode	delete	edit	status	order nr.	file name	delete	view	create order	file name
		 NEW	210804001004			 NEW	210920003000					K23.pdf
		 NEW	210804001003			 NEW	210920002000	PURGE ALL				
		 NEW	210804001002			 NEW	210920001000	PURGE ALL				
		 DONE	210804001001			 PARTIAL	210804001000	PURGE ALL				

On the other hand, the operator can decide to purge only one or more circuits. To do so, the shuttle must be moved under each dispensing head using the manual commands, as described below.

1. Place a can in a shuttle and place it on the roller conveyor. Then click the “green arrow” (1) to move the shuttle in front of the barcode reader.



-

- 
- A screenshot of a terminal window with a dark background and light green text. The terminal displays a menu of options, each on a new line. The options are: "Start input roller", "Stop input roller", "Start input roller to photocell", "move 01 02 ('IN -> A')", and "Back to Home Page". The option "move 01 02 ('IN -> A')" is highlighted with a yellow rectangular box. A mouse cursor is visible pointing at the highlighted option.
- ```
Start input roller
Stop input roller
Start input roller to photocell
move 01 02 ('IN -> A')
Back to Home Page
```

- |      |                                   |            |                                       |                  |                 |                  |                 |                |                  | PURGE_ALL | INTELLIGENT_PURGE |
|------|-----------------------------------|------------|---------------------------------------|------------------|-----------------|------------------|-----------------|----------------|------------------|-----------|-------------------|
| Name | Component                         | Curr Level | Max Level,<br>Res Level,<br>Min Level | Stirring         |                 | Recirc.          |                 | Purge [cc]     |                  |           |                   |
| C01  | <div><div></div> pigment_01</div> | 1197.70    | 1500.0<br>300.00<br>200.0             | <div>start</div> | <div>stop</div> | <div>start</div> | <div>stop</div> | <div>2.0</div> | <div>purge</div> |           |                   |
| C02  | <div><div></div> K200</div>       | 680.58     | 1500.0<br>300.00<br>200.0             | <div>start</div> | <div>stop</div> | <div>start</div> | <div>stop</div> | <div>2.0</div> | <div>purge</div> |           |                   |
| C03  | <div><div></div> pigment_03</div> | 965.00     | 1500.0<br>250.00<br>200.0             | <div>start</div> | <div>stop</div> | <div>start</div> | <div>stop</div> | <div>2.0</div> | <div>purge</div> |           |                   |
| C04  | <div><div></div> pigment_04</div> | 974.00     | 1500.0<br>250.00<br>200.0             | <div>start</div> | <div>stop</div> | <div>start</div> | <div>stop</div> | <div>2.0</div> | <div>purge</div> |           |                   |

- 
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Service

Home

|              |            |  |
|--------------|------------|--|
| STATUS       | DISPENSING |  |
| CAN ON SHELF | false      |  |

6. Repeat the same steps 2 to 6 to purge more circuits in other turning tables.



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