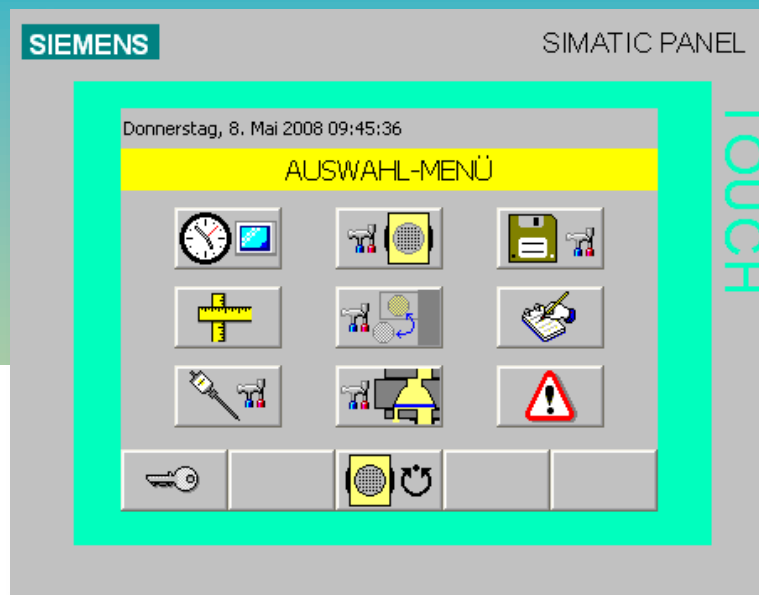


maax BF



Features:

- Convenient and safe operation via colour display with touch function and key
- Teleservice function for PLC programme and visualisation
- Online language changeover
- Signalling of operating mode and plant status
- Anti-block mode with motion monitoring
- Melt pressure measurement
- Recipe memory

Benefits:

- Simple and clear operation of all filter functions
- Increased productivity

Automated processes achieve more.

The maax BF control system is the innovative, advanced development of the previous control system used in recycling applications.

Tailored for our tried and proven double-piston Backflush Screen Changer CSC/BF-4F, this control system offers the user new potentials for cost-cutting and enhanced product quality in the filtration of highly-contaminated polymer melts.

Technical specifications:

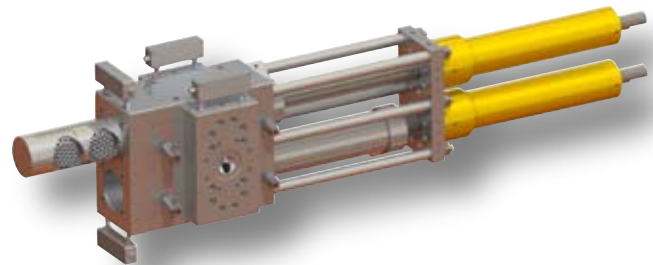
Control cabinet:	Rittal system cabinet
Operating voltage (standard):	3 x 400 V/N/PE
Control voltage:	24 VDC
Solenoid valves:	24 VDC
Displacement transducer:	Ultrasonic linear displacement transducer
Melt pressure:	DMS 3.3 mV/V
PLC:	SIMATIC S7-300
Operator panel:	Touch Panel 5.7", colour
Optional:	Heating control for 6 heating zones

Mode of operation

Mode 1: Positioning of pistons according to pressure conditions

In all recycling filters commonly available on the market, the cyclical screen cleaning and screen venting procedures are performed after a screen change, using small material quantities from the main melt stream due to the functional principle.

As a result, negative impacts caused to the process by these quantity drops could not always be excluded until now. The new, dynamic pistons positioning function now monitors the maximum deltaP value specified by the user in Mode 1 permanently, by a self-adjustment of the piston travel paths and the holding times to an optimum effect. This limits pressure fluctuations and reliably prevents the admissible product tolerances from being exceeded.



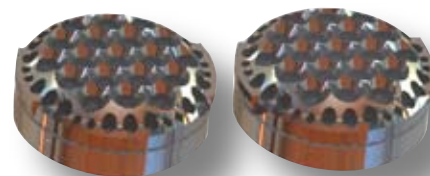
Mode 2: Volume regulation according to pressure conditions

The new control system, in conjunction with a constantly performing extruder or an extrex® melt pump guarantees, a practically consistent pressure and flow rate in the process. During the screen cleaning or screen venting cycles in Mode 2, the constant extruder or pump speed is temporarily suspended and the mould's preliminary pressure is applied as a control variable.

In this system, the pressure reduction caused by the quantity loss is compensated proportionally by temporary speed increases. While the volume flow and the melt pressure at the mould remain constant, an equally constant high product quality will be ensured. The controller then switches back to normal mode, in which the extruder or melt pump runs at constant speed.

maax BF offers you a full service:

- Supply of all electrical equipment mounted in the control cabinet
- Complete supply of the functional system
- Screen changer integrated into your production line control system
- Technical guidance and advice and process optimisation
- System commissioning and operator training
- "Round-the-clock" service with short response times



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