



# QUESTIONNAIRE

Technical specifications for the instrumentation of a molding sand preparation by Humidity control system at the Batch Mixer.

Company name:

Adress:

Factory:

Phone:  Fax No:

Ansprechpartner / Durchwahl:

## 1. FIRST SAND SPECIFICATIONS

Synthetic sand:  Yes  No

Natural sand:  Yes  No

Dosage per batch:  kg

**Aggregates in kg**

Betonite:  kg

Carbon:  kg

New sand:  kg

additional surcharges:  kg

Used sand residual moisture:  of  to  % H2O

Used sand temperature:  of  to  °C

Finish sand:  of  to  % H2O

## 2. MIXER SITUATION ( if possible drawing of sand preparation enclosed )

Type/model of the mixer/s:

Manufacturer:

Batch size:

Mxing cycle in seconds:

### Dosage used sand

A. volumetrically via conveyor belt:  Yes  No

Belt speed m/sec.:

Sand height in cm:

B. volumetrically with hopper:  Yes  No

C. gravimetrically by hopper scale:  Yes  No

D. gravimetrically with belt scale:  Yes  No

### 3. MOISTURE MEASUREMENT

Moisture Measurement on the conveyor belt  Yes  No

Moisture Measurement in the container or in the hopper scale  Yes  No

Dimensions of hopper:

Height of the conical heap with the highest occurring sand moisture (eg robbery sand) at usual batch weight

Height of the weighing container

### 4. TEMPERATURE MEASUREMENT

Bands, 1 temperature sensor, only when tape does not run empty

Tank installation, 2 temperature sensors, compared to vertically offset

### 5. WATER METERING

Water pressure:  bar

Previous average, metered amount of water in liters per batch  liter

If a spirit level to be installed to meter water and dirt can?  Yes  No

Connection to an existing weighing system?

  
  

### 6. RECIPE MANAGEMENT

How many recipes are to be managed?  recipes

**7. IF AN AUTOMATIC SAND TESTING SYSTEM TO BE INTEGRATED?**

Yes  No

Possible variants::

A. SPC II = mounting and sampling on a belt transfer station (recommended execution)

B. SPC III = mounting and sampling on the mixer

C. SPC IV = mounting and sampling on a belt conveyor

Possible measurements:

Compactibility:

Options:

Compression strength  Yes  No

Shear strength  Yes  No

Moisture measurement  Yes  No

Temperature measurement  Yes  No

(if moisture measurement is also selected, temperature measurement must be selected.)

**8. IPC WITH DATA ANALYSIS (DATA MANAGEMENT, ARCHIVING, ANALYSIS)**

Data Collection and Archiving  Yes  No

Presentation and Appraisal  Yes  No

**9. OTHER CUSTOMER REQUIREMENTS FOR THE SYSTEM**

Four horizontal light blue bars for text input.

**10. WHAT IMPROVEMENTS OVER THE CURRENT SITUATION, ONE SHOULD USE THE HUMIDITY CONTROL SYSTEM WILL BE SCORED?**

Four horizontal light blue bars for text input.

- Furthermore, we also provide humidity control systems for continuous mixers, refrigeration units. Please give us technical specifications / drawings for a quotation.
- Also level detector for your silos and bins are part of our range of services. Fill in your specification.
- We also modernize your mixer control system based on Siemens S 7/Serie. Please give us your specifications for a quote.