FLOW DIAGRAM
FRS-M with SPC-III

FLOW DIAGRAM FRS-M WITH SPC-III

Weight, moisture and temperature measurement
in the hopper of the mixer

Calculation of the required amount of water
to reach the moisture set value
of the mixer

Feeding the mixer and simultaneous addition
of the calculated amount of water
(if possible)

Taking a sand sample
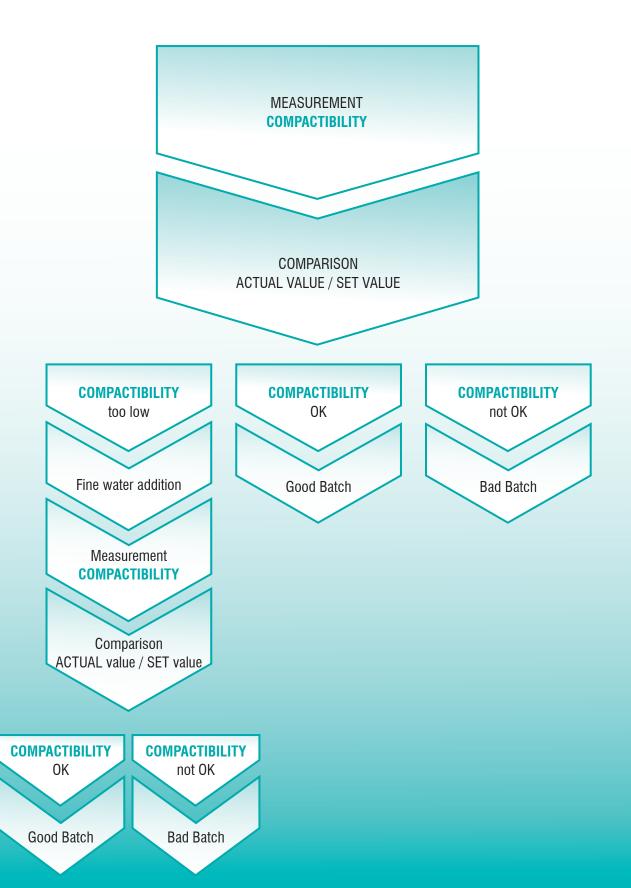from the mixer
after the pre-mixing time has elapsed

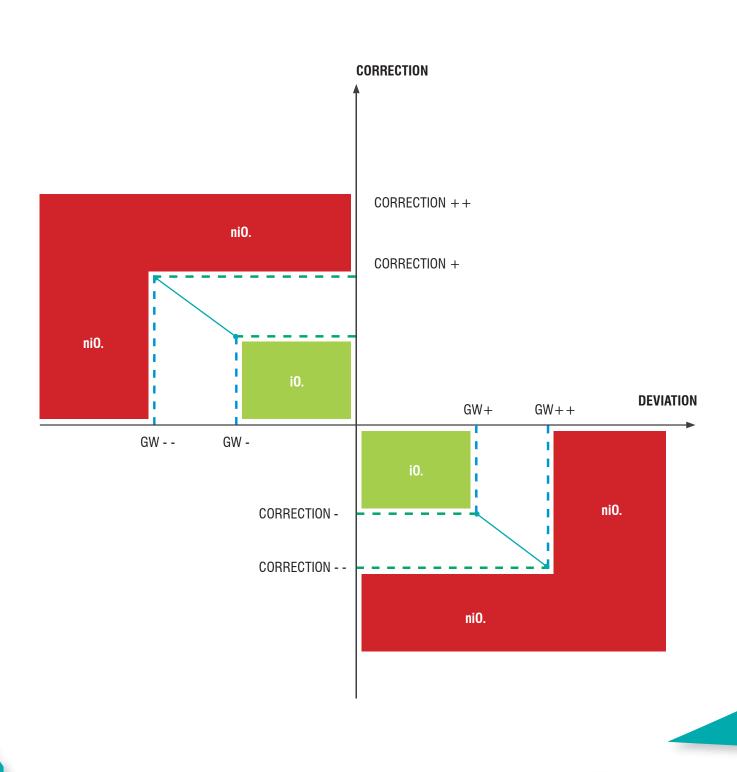MEASUREMENT
COMPACTIBILITY

MEASUREMENT
COMPRESSION STRENGTH

MEASUREMENT COMPACTIBILITY

MEASUREMENT
COMPACTIBILITY

COMPARISON
ACTUAL VALUE / SET VALUE

COMPACTIBILITY
too low

COMPACTIBILITY
OK

COMPACTIBILITY
not OK

Fine water addition

Good Batch

Bad Batch

Measurement
COMPACTIBILITY

Comparison
ACTUAL value / SET value

COMPACTIBILITY
OK

COMPACTIBILITY
not OK

Good Batch

Bad Batch

Adjustment of the amount of water to be dosed for the next batch
by changing the target moisture value (see function graph).
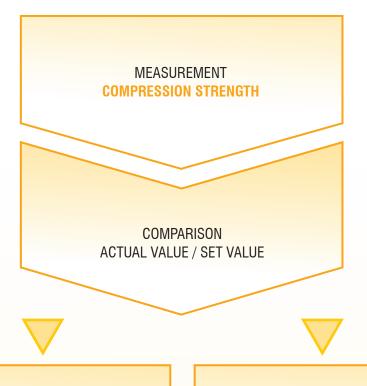
DEPENDING ON THE COMPACTIBILITY

CORRECTION

CORRECTION ++

CORRECTION +

niO.

niO.

iO.

DEVIATION

GW - -   GW -

GW+   GW++

iO.

CORRECTION -

niO.

CORRECTION - -

niO.

MEASUREMENT COMPRESSION STRENGTH

MEASUREMENT
COMPRESSION STRENGTH

COMPARISON
ACTUAL VALUE / SET VALUE

COMPRESSION STRENGTH
in the acceptable range

COMPRESSION STRENGTH
outside acceptable range

If necessary, correction of the amount of additives to be dosed.

Bad Batch