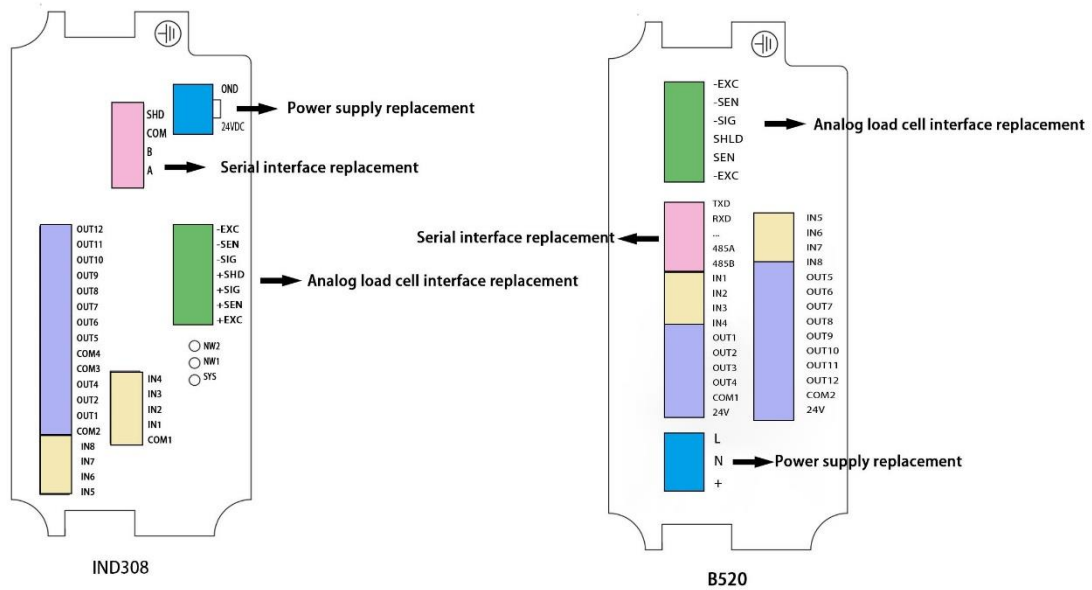


# IND308/B520 Replacement Quick Guide



## Hardware Replacement

1. Power supply (Notice: C30 requires 24VDC power supply)
2. Replacement of analog load cell interface follows the sequence of B520 wire
3. Serial interface

Pin	Description
GND	Negative terminal
+24VDC	Positive terminal

IND308 PIN	B520 PIN	Description
485A	485A	RS485 RxD+
485B	485B	RS485 RxD-
COM	COM	Common
SHD		Shield

## Scale calibration

→ 888888 →

Enter "Scale", set "Capacity & Increment"

Enter "Capacity & Increment", set  
F1.2 → "Capacity"  
F1.3 → "Increment"

→

Enter "Calibration", ("Linearity" set to "Disabled")

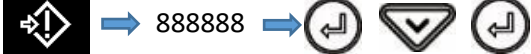




(1) Enter "Set Zero", empty the scale and press to do the zero calibration. When successful, the message "Capture Zero OK" displays and press to return.

(2) Enter "Span Calibration", enter "Test load 1", and press , place Test load 1 on the scale and press . When successful, the message "Capture Span OK" displays and press to return.

## PLC Mode DI/O Definition

Input replacement			Output replacement		
IND308 PIN	B520 PIN	Description	IND308 PIN	B520 PIN	Description
IN1	IN1	Start/Stop	OUT1	OUT1	Fast Feeding SP1
IN2	IN2	Emergency Stop	OUT2	OUT2	Middle Feeding SP2
IN3	IN4	Tolerance Accepted	OUT3	OUT3	Fine Feeding/ Spill Pr
IN4	IN5	Sever Valve ON OK	OUT4	OUT4	Discharge
COM1	COM1	I/O external power supply	OUT5	OUT8	Out of Tolerance
+24VDC	+24VDC		OUT6	OUT10	Near Zero
IN5	IN6	Tare	OUT7	OUT11	Sever Valve Output
IN6	IN7/IN8	Hopper Ready			
COM2	COM2	I/O external power supply			
+24VDC	+24VDC				

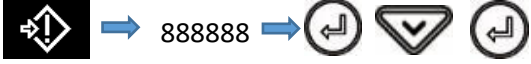





## PLC Mode Parameters setting

 <p>Enter "Application", and set F2.1: 0 → "Work Mode": "PLC Mode"</p>	 <p>Enter "Control Mode", and set F2.3: 0 → "Output Type": "Concurrent" F2.3: 1 → "Output Type": "Independent" F2.6: 0 → "Judge Tolerance": "Disabled" F2.6: 1 → "Judge Tolerance": "Enabled" F3.18: 0 → "Discharge Near Zero": "Disabled" F3.18: 1 → "Discharge Near Zero": "Enabled" F2.5: 0 → "Power Up Mode Continue Bagging": "Continue Bagging" F2.5: 1 → "Power Up Mode Continue Bagging": "Empty Reset"</p>
 <p>Enter "Time", and set F3.1.1 → "SP1 Inhibit Time" F3.1.2 → "SP2 Inhibit Time" F3.1.3 → "Spill Inhibit Time" F3.2 → "Stable Time" F3.3 → "Before Discharge Off" F3.4 → "After Discharge Off" F3.16 → "Jog Time"</p>	 <p>Enter "Input", if any input has no connection, set the input as "None". If any input function changes, set the input as corresponding function.</p>  <p>Enter "Output", if any output has no connection, set the output as "None". If any output function changes, set the output as corresponding function.</p>

## Bulk Grain Mode DI/O Definition

Input replacement			Output replacement		
IND308 PIN	B520 PIN	Description	IND308 PIN	B520 PIN	Description
IN1	IN1	Start/Stop	OUT1	OUT1	Fast Feeding SP1
IN2	IN2	Emergency Stop	OUT2	OUT2	Middle Feeding SP2
IN3	IN3	Last Package	OUT3	OUT3	Fine Feeding/Spill Pr
IN4	IN4	Tolerance Accepted	OUT4	OUT4	Discharge
IN5	IN5	Sever Valve ON OK	OUT5	OUT8	Out of Tolerance
COM1	COM1	I/O external power supply	OUT6	OUT10	Near Zero
+24VDC	+24VDC		OUT7	OUT11	Sever Valve Output
IN6	IN6	Upper Hopper Low			
IN7	IN7/IN8	Lower Hopper High			
IN8	IN7/IN8	Hopper Ready			
COM2	COM2	I/O external power supply			
+24VDC	+24VDC				







## Bulk Grain Mode Parameters Setting

 <p>888888</p> <p>Enter "Application", and set F2.1: 1 → "Work Mode": "Bulk Grain"</p>  <p>Enter "Sequence", and set F3.12 → "Bulk Weight"</p>	 <p>Enter "Control Mode", and set F2.3: 0 → "Output Type": "Concurrent" F2.3: 1 → "Output Type": "Independent" F3.10 → "Periodic Zero Cycles" F2.6: 0 → "Judge Tolerance": "Disabled" F2.6: 1 → "Judge Tolerance": "Enabled" F2.5: 0 → "Power Up Mode Continue Bagging": "Continue Bagging" F2.5: 1 → "Power Up Mode Continue Bagging": "Empty Reset" Enter "Signal Mode", and set F2.7: 1 → "Upper Hopper Low": "Default On" F2.7: 2 → "Upper Hopper Low": "Default Off" F2.8: 1 → "Lower Hopper High": "Default On" F2.8: 2 → "Lower Hopper High": "Default Off"</p>
 <p>Enter "Time", and set F3.1.1 → "SP1 Inhibit Time" F3.1.2 → "SP2 Inhibit Time" F3.1.3 → "Spill Inhibit Time" F3.2 → "Stable Time" F3.3 → "Before Discharge Off" F3.4 → "After Discharge Off" F3.16 → "Jog Time"</p>	 <p>Enter "Input", if any input has no connection, set the input as "None". If any input function changes, set the input as corresponding function.</p>  <p>Enter "Output", if any output has no connection, set the output as "None". If any output function changes, set the output as corresponding function.</p>

## Have Hopper Mode DI/O Definition

Input replacement			Output replacement		
IND308 PIN	B520 PIN	Description	IND308 PIN	B520 PIN	Description
IN1	IN1	Start (Auto) / Stop (Manual)	OUT1	OUT1	Fast Feeding SP1
IN2	IN2	Emergency Stop	OUT2	OUT2	Middle Feeding SP2
IN3	IN3	Clamp/Loose	OUT3	OUT3	Fine Feeding/Spill Pr
IN4	IN4	Tolerance Accepted	OUT4	OUT4	Discharge
COM1	COM1	I/O external power supply	OUT5	OUT5	Clamp
+24VDC	+24VDC		OUT6	OUT6	Flap/Drop
IN5	IN5	Sever Valve ON OK	OUT7	OUT7	Cycle Complete
IN6	IN6	Upper Hopper Low	OUT8	OUT8	Out of Tolerance
IN7	IN7/IN8	Lower Hopper High	OUT9	OUT10	Near Zero
IN8	IN7/IN8	Hopper Ready	OUT10	OUT11	Sever Valve Output
COM2	COM2	I/O external power supply			
+24VDC	+24VDC				








## Have Hopper Mode Parameters Setting

 <p>888888</p> <p>Enter "Application", and set F2.1: 2 → "Work Mode": "Have Hopper Mode"</p>  <p>Enter "Sequence", and set F2.16: 0 → "Flap/Drop Mode": "Flap" F2.16: 1 → "Flap/Drop Mode": "Drop" F3.7 → "Final Flap/Drop Times" F3.5 → "Flap Interval" F3.11 → "Preset Packages" F3.13 → "Ton Bag Weight"</p>	 <p>Enter "Control Mode", and set F2.3: 0 → "Output Type": "Concurrent" F2.3: 1 → "Output Type": "Independent" F3.10 → "Periodic Zero Cycles" F2.6: 0 → "Judge Tolerance": "Disabled" F2.6: 1 → "Judge Tolerance": "Enabled" F3.18: 0 → "Discharge Near Zero": "Disabled" F3.18: 1 → "Discharge Near Zero": "Enabled" F2.5: 0 → "Power Up Mode Continue Bagging": "Continue Bagging" F2.5: 1 → "Power Up Mode Continue Bagging": "Empty Reset" Enter "Signal Mode", and set F2.7: 1 → "Upper Hopper Low": "Default On" F2.7: 2 → "Upper Hopper Low": "Default Off" F2.8: 1 → "Lower Hopper High": "Default On" F2.8: 2 → "Lower Hopper High": "Default Off"</p>
 <p>Enter "Time", and set F3.1.1 → "SP1 Inhibit Time" F3.1.2 → "SP2 Inhibit Time" F3.1.3 → "Spill Inhibit Time" F3.2 → "Stable Time" F3.3 → "Before Discharge Off" F3.4 → "After Discharge Off" F3.16 → "Jog Time" F3.14 → "Clamp Delay" F3.15 → "Delay to Declamp"</p>	 <p>Enter "Input", if any input has no connection, set the input as "None". If any input function changes, set the input as corresponding function.</p>  <p>Enter "Output", if any output has no connection, set the output as "None". If any output function changes, set the output as corresponding function.</p>

## No Hopper Mode DI/O Definition

Input replacement			Output replacement		
IND308 PIN	B520 PIN	Description	IND308 PIN	B520 PIN	Description
IN1	IN1	Start (Auto) / Stop (Manual)	OUT1	OUT1	快喂料 SP1
IN2	IN2	Emergency Stop	OUT2	OUT2	中喂料 SP2
IN3	IN3	Clamp/Loose	OUT3	OUT3	Fast Feeding SP1
IN4	IN4	Tolerance Accepted	OUT4	OUT5	Middle Feeding SP2
COM1	COM1	I/O external power supply	OUT5	OUT6	Fine Feeding/Spill Pr
+24VDC	+24VDC		OUT6	OUT7	Clamp
IN5	IN5	Sever Valve ON OK	OUT7	OUT8	Flap/Drop
IN6		Upper Hopper Low	OUT8	OUT9	Cycle Complete
IN7	IN7/IN8	Lower Hopper High	OUT9	OUT10	Out of Tolerance
IN8	IN7/IN8	Bag Clamped OK	OUT10	OUT11	Rise Platform
COM2	COM2	I/O external power supply			
+24VDC	+24VDC				







## No Hopper Mode Parameters Setting

<p> 888888 → </p> <p>Enter "Application", and set F2.1: 3 → "Work Mode": "No Hopper Mode"</p> <p></p> <p>Enter "Sequence", and set F2.16: 0 → "Flap/Drop Mode": "Flap" F2.16: 1 → "Flap/Drop Mode": "Drop" F3.6 → "Middle Flap/Drop Times" F3.7 → "Final Flap/Drop Times" F3.5 → "Flap Interval" F3.11 → "Preset Packages" F3.9 → "Rising Threshold" F3.8 → "Rising Time"</p>	<p></p> <p>Enter "Control Mode", and set F2.3: 0 → "Output Type": "Concurrent" F2.3: 1 → "Output Type": "Independent" F3.10 → "Periodic Zero Cycles" F2.6: 0 → "Judge Tolerance": "Disabled" F2.6: 1 → "Judge Tolerance": "Enabled" F3.18: 0 → "Discharge Near Zero": "Disabled" F3.18: 1 → "Discharge Near Zero": "Enabled" F2.5: 0 → "Power Up Mode Continue Bagging": "Continue Bagging" F2.5: 1 → "Power Up Mode Continue Bagging": "Empty Reset"</p> <p>Enter "Signal Mode", and set F2.7: 1 → "Upper Hopper Low": "Default On" F2.7: 2 → "Upper Hopper Low": "Default Off" F2.8: 1 → "Lower Hopper High": "Default On" F2.8: 2 → "Lower Hopper High": "Default Off"</p>
<p></p> <p>Enter "Time", and set F3.1.1 → "SP1 Inhibit Time" F3.1.2 → "SP2 Inhibit Time" F3.1.3 → "Spill Inhibit Time" F3.2 → "Stable Time" F3.16 → "Jog Time" F3.14 → "Clamp Delay" F3.15 → "Delay to Declamp"</p>	<p></p> <p>Enter "Input", if any input has no connection, set the input as "None". If any input function changes, set the input as corresponding function.</p> <p></p> <p>Enter "Output", if any output has no connection, set the output as "None". If any output function changes, set the output as corresponding function.</p>

## Dual Scale Mode DI/O Definition

Input replacement			Output replacement		
IND308 PIN	B520 PIN	Description	IND308 PIN	B520 PIN	Description
IN1	IN1	Start/Stop	OUT1	OUT1	Fast Feeding SP1
IN2	IN2	Emergency Stop	OUT2	OUT2	Middle Feeding SP2
IN3	IN3	Clamp/Loose	OUT3	OUT3	Fine Feeding/Spill Pr
IN4	IN4	Tolerance Accepted	OUT4	OUT4	Discharge
COM1	COM1	I/O external power supply	OUT5	OUT5	Clamp
+24VDC	+24VDC		OUT7	OUT7	Cycle Complete
IN5	IN5	Dual Scale Sync	OUT8	OUT8	Out of Tolerance
IN6	IN6	Upper Hopper Low	OUT9	OUT10	Near Zero
IN7	IN7/IN8	Lower Hopper High	OUT10	OUT12	Dual Scale Sync
IN8	IN7/IN8	Hopper Ready			
COM2	COM2	I/O external power supply			
+24VDC	+24VDC				

## Dual Scale Mode Parameters Setting

 <p>888888</p> <p>Enter "Application", and set F2.1: 5 → "Work Mode": "Dual Scale Mode"</p>  <p>Enter "Sequence", and set F3.11 → "Preset Packages" F2.11: 0 → "Master/Slave Mode": Master Scale F2.11: 1 → "Master/Slave Mode": Slave Scale F2.12: 0 → "Dual Scale Discharge": "Combination" F2.12: 1 → "Dual Scale Discharge": "Interlock"</p>	 <p>Enter "Control Mode", and set F2.3: 0 → "Output Type": "Concurrent" F2.3: 1 → "Output Type": "Independent" F3.10 → "Periodic Zero Cycles" F2.6: 0 → "Judge Tolerance": "Disabled" F2.6: 1 → "Judge Tolerance": "Enabled" F3.18: 0 → "Discharge Near Zero": "Disabled" F3.18: 1 → "Discharge Near Zero": "Enabled" F2.5: 0 → "Power Up Mode Continue Bagging": "Continue Bagging" F2.5: 1 → "Power Up Mode Continue Bagging": "Empty Reset"</p> <p>Enter "Signal Mode", and set F2.7: 1 → "Upper Hopper Low": "Default On" F2.7: 2 → "Upper Hopper Low": "Default Off" F2.8: 1 → "Lower Hopper High": "Default On" F2.8: 2 → "Lower Hopper High": "Default Off"</p>
 <p>Enter "Time", and set F3.1.1 → "SP1 Inhibit Time" F3.1.2 → "SP2 Inhibit Time" F3.1.3 → "Spill Inhibit Time" F3.2 → "Stable Time" F3.3 → "Before Discharge Off" F3.4 → "After Discharge Off" F3.16 → "Jog Time" F3.14 → "Clamp Delay" F3.15 → "Delay to Declamp"</p>	 <p>Enter "Input", if any input has no connection, set the input as "None". If any input function changes, set the input as corresponding function.</p>  <p>Enter "Output", if any output has no connection, set the output as "None". If any output function changes, set the output as corresponding function.</p>