

This system controls the charging of a cupola in an automotive foundry. The system controls material hoppers, conveyors, and weight hoppers to gather the specified materials in the correct order and in the correct amounts and delivers the materials to the cupola.

The system is controlled by an Allen-Bradley PLC. The operator interface is Cutler-Hammer PanelMate. The PLC interfaces directly to load cells to perform weighing operations.

The operator interface displays the status of all equipment in the system, displays the types of materials in bins, and the amount of material in weigh hoppers. The operator can adjust the charging program and makeup and correction factors.

