

Bread Maker Brings in the Dough

Learn how a new feeder controller helps improve control and accuracy for a dough-feeding line

Solutions

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- Hardy Instruments worked with the bread maker's engineering group to find an improved control loop and a scale that's easy to troubleshoot and calibrate
- These components needed to interact with its existing Allen-Bradley® ControlLogix® programmable automation controllers

Allen-Bradley ControlLogix

- The bread maker wasn't getting the desired accuracy from its previous solution, which used a control-loop algorithm its engineering group designed years earlier.
- To assist with seamless integration, Hardy developed the HI 1756-FC with the Rockwell Automation Integrated Architecture Builder (IAB) and Allen-Bradley Control-Logix Add-On Profile (AOP)

Results

Solution Delivers Results

- New feeder controller and new load cells have helped it to achieve better material flow- and feed-rate consistency, improve production, minimize waste, achieve accurate weight readings and improve plant safety

Anticipated Results Delivered

- After revamping one of its dough-feeder lines the bread maker increased productivity and profitability
- Solution delivered an improved control loop and a scale that's easy to troubleshoot and calibrate
- The IT Junction Box, which electronically diagnoses scale problems, helps improve plant safety and efficiency by allowing company personnel to troubleshoot the scale from the comfort of an office

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Learn how a new feeder controller helps improve control and accuracy for a dough-feeding line.

The ultimate goal of any upgrade is to increase productivity and profitability. A large bread maker in Southern California achieved these goals after revamping one of its dough-feeding lines. The company implemented a new feeder controller and new load cells that have helped it to achieve better material flow- and feed-rate consistency, improve production, minimize waste, achieve accurate weight readings and improve plant safety.

One of the company's objectives for the dough-feeding line upgrade was to find an improved control loop, preferably PID, and a scale that's easy to troubleshoot and calibrate. These components needed to interface with its existing Allen-Bradley® ControlLogix® programmable automation controllers (PAC) from Rockwell Automation.

The company's team considered many options for the revamp. The existing application used a continuous-rate control with an auger to control how much bread the company bakes per day.

The bread maker had been using its own PAC-based rate control solution with a ControlLogix system, and I/O modules on DeviceNet™ to communicate to the valves and feeder.

LISTEN.
THINK.
SOLVE.™

The line was using standard load cells to monitor loss-in-weight from the dough hopper. The bread maker wasn't getting the desired accuracy from its solution, which used a control-loop algorithm its engineering group designed years earlier.

Hooked by Accuracy

To help the bread maker, Hardy recommended that the bread maker use the new HI 1756-FC feeder controller for the ControlLogix platform, paired with its INTEGRATED TECHNICIAN® (IT) Junction Box and C2® ADVANTAGE® load cells.

To assist with seamless integration, Hardy developed the HI 1756-FC with the Rockwell Automation Integrated Architecture Builder (IAB) and Allen-Bradley ControlLogix Add-On Profile (AOP).

The feeder controller is a plug-in module that installs directly into the ControlLogix PAC rack. It requires only ladder logic programming that can be easily inserted into existing code to quickly program the feeder system application.

After a product demonstration, the bread maker's engineering director and other company personnel determined that the feeder controller's accuracy would be a key benefit to the dough-feeding line upgrade.

In addition to accuracy, the team was especially interested in the feeder controller's ControlLogix plug-in capability and inclusion of a PID control loop that Hardy developed.

The electronic calibration capability of the C2 load cells will help the bread maker recognize immediate cost and time savings as the company eliminates the need for calibration weights and an outside calibration service. The IT Junction Box, which electronically diagnoses scale problems, helps improve plant safety and efficiency by allowing company personnel to troubleshoot the scale from the comfort of an office.

Raking in the Dough

The bread maker's own engineering technicians and PAC programming knowledge helped to make it the most cost-effective solution for the company. The upgrade project's system integrator, Adaptive Engineering and Fabrication, Inc., Placentia, CA, that's installing a new hopper in the same system also will install load cells and a junction box.

The bread maker is pleased with the improved productivity and profitability it will see with this dough-feeding line revamp.



Rockwell Automation and PartnerNetwork companies collaborate to help you develop an ongoing approach to plant-wide optimization, improve your machine performance and achieve your sustainability objectives.

9440 Carroll Drive, Suite 150
San Diego CA 92121
USA
Phone: 858-278-2900
Fax: 858-278-6700
<http://www.hardyinst.com/>

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www.rockwellautomation.com

Power, Control and Information Solutions Headquarters

Americas: Rockwell Automation, 1201 South Second Street, Milwaukee, WI 53204-2496 USA, Tel: (1) 414.382.2000, Fax: (1) 414.382.4444

Europe/Middle East/Africa: Rockwell Automation NV, Pegasus Park, De Kleetlaan 12a, 1831 Diegem, Belgium, Tel: (32) 2 663 0600, Fax: (32) 2 663 0640

Asia Pacific: Rockwell Automation, Level 14, Core F, Cyberport 3, 100 Cyberport Road, Hong Kong, Tel: (852) 2887 4788, Fax: (852) 2508 1846