

## P-DAQ Scale Issues

The following explains what can go wrong when P-DAQ uses scales to derive count. The following information is of utmost importance as the counts are dependant on the scales themselves, and on the operation of them. As we are all aware, the scales are electronic devices and are certainly not flawless. It is very important to ensure that the crew understands how to use them properly, and that the maintenance department has an understanding as to what to do when something goes wrong.

### Procedural Issues

Firstly, when a Job is loaded from the schedule, or entered manually for that matter, it is imperative that the paper folder is checked to ensure that the paper parameters are entered properly, and that they match the actual paper to be used.

P-DAQ calculates the piece weight of the stock based on the cutoff of the impression cylinder (constant), the width of the roll, and on the basis weight of the stock. This calculated piece weight is used during Makeready to calculate waste impressions, and is displayed in the Setup/Delivery folder on the main screen.

During makeready, once there is sufficient ink coverage, it is necessary to perform an actual piece weight measurement.

To do so, the stacker attendant is expected to derive the piece weight using the table scale, and to transfer the piece weight to the floor scale. On the Table scale, press the Tare button followed by the Units button to tell the scale how many sample signatures are to be used. Press the Tare button once the requested quantity is displayed. Wait for the scale to stabilize and place the requested number of signatures on the scale. Wait for the scale to stabilize and press the Tare button to record the piece weight.

Using the TT4 terminal, transfer the piece weight to the floor scale by pressing the All Other Options button, selecting 8 Set Piece Weight from the list and pressing the enter button.

P-DAQ has the capability to inform the pressmen and the stacker attendants when there are discrepancies between the calculated piece weight and the actual measured piece weight in excess of 3 percent. For the Stacker Attendant the \*POSSIBLE ERROR\* message is displayed on the TT4 terminal. For the Pressmen the Setup/Delivery folder displays the measured piece weight in red.

When there is such a discrepancy, it is necessary to re-check that the paper parameters are entered properly, that the intended paper is being used and that the piece weight measurement has been performed correctly. Keep in mind, in some cases where there is heavy ink coverage; this error may be displayed and may be normal.

There are a couple of reasons why the table scale can incorrectly measure the piece weight. First, the scale may not be calibrated properly, it may be necessary to keep, say, a 5lb weight handy and check the calibration occasionally by placing the weight on each corner of the scale and by weighing it in weigh mode.

Second, as mentioned earlier, you can choose a sample quantity IE... ADD 10, ADD 20 etc...

If you choose ADD 10 and put 50 sigs on the scale, the piece weight will be higher than we expected, therefore if you throw 50 sigs in the bin, the floor scale will think you threw 10 away. This will cause you to under-run the job.

If you choose ADD 50 and put 10 sigs on the scale, the piece weight will be lower than we expected, therefore if you throw 10 sigs in the bin, the floor scale will think you threw 50 away. This will cause you to over-run the job.

## Hardware Issues

If the scale is displaying an error message, it is normal procedure to take everything OFF the scale, unplug the scale indicator's power cord, wait 30 seconds, and reapply power.

Place the indicator into weigh mode using the **Units** button, and ensure that the scale weighs 0kg.

If the scale does NOT weigh 0kg, you need to ZERO the scale using the ZERO button. To enable the ZERO button, from the P-DAQ main screen, hold the CTRL key while clicking the Initialize Scales button in the Setup/Config folder. Once the scale has been zeroed, click the initialize scales button without the CTRL key to disable the button.

If the Floor Scale does not seem to be communicating at all, but weighs properly, check the cabling, and Initialize as previously described.