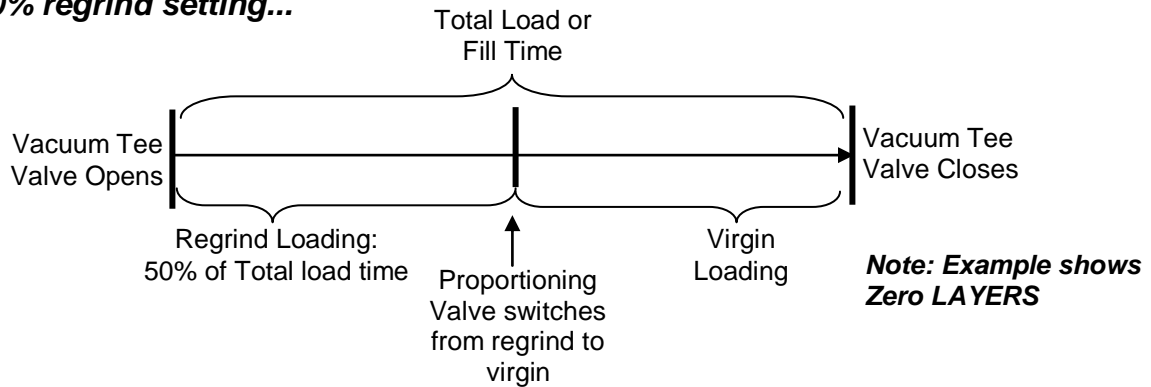


RATIO, PROPORTIONING or REGRIND PERCENTAGE:

All these terms typically define what percentage (%) of the total load time that the regrind port of a proportioning valve will be open during vacuum loading.

Example:

50% regrind setting...

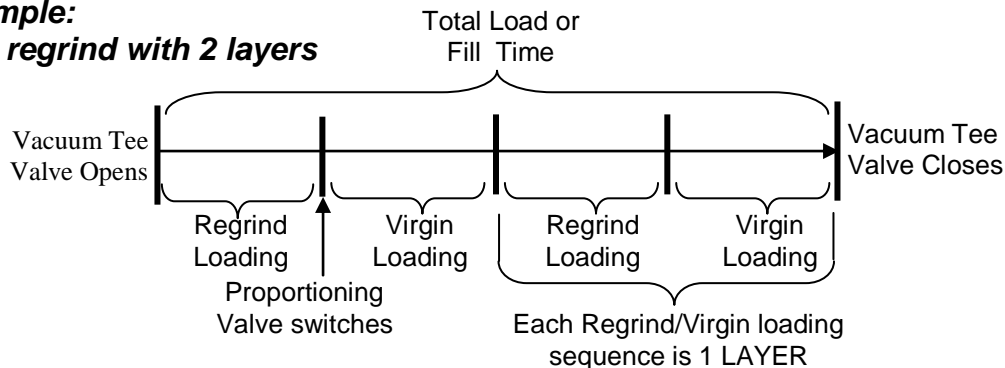


LAYERS:

This number defines how many times the proportioning valve will switch from virgin to regrind during a loading sequence.

Example:

50% regrind with 2 layers



ACCURACY:

Although proportioning controls provide highly accurate valve changes based on user settings, material variables often make settings only an approximation of expected results. The user should be aware of the different flow characteristics of virgin vs. regrind materials. Virgin typically flows easier, and the distance from each material supply can be quite different. These variations should be considered when adjusting the controls and gauging expected results.

MIXING with LAYERS:

Using the LAYERS feature, virgin and regrind can be somewhat 'mixed' as they are loaded. However, too many layers can stifle loading efficiency since each valve cycle requires the material flow to be started and then stopped, which can consume valuable vacuum time. In addition, multiple starts and stops from too many layers can encourage material line clogs. Trial and error settings are best.

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