

Flowmeters for batch dosing

Use of flowmeters in the food industry
to optimize simple batch dosing

Measurement made easy



Introduction

In the food industry, it is frequently necessary to dose, pump, mix and blend liquids. Continuous mixing processes can be implemented directly in piping using ratio-based or Blendline control systems, which removes the need for mixing containers. In smaller batch processes, the required components are dosed and mixed in containers one after the other using suitable flowmeters and counting equipment.

Components can also be dosed at a later stage after technical and sensory analyses. Not all systems are large enough to justify the investment in a control system, it may be more economical to use individual counters. The following description outlines a number of potential applications and implementation methods for batch dosing using individual counters.

Flowmeters for batch dosing

Implementation using an electromagnetic flowmeter with an internal counter

The electromagnetic flowmeter FEH500 with an internal counter can be used directly for batch dosing. Dosing times must be longer than three seconds for this purpose. An internal presetting counter, which can also be adjusted directly on the device, is installed in the flowmeter transmitter. Batches can be started via an external contact and stopped via the counter's output contact.

If a precontact is available, this can also be used in connection with a suitable valve to slow dosing at the end of the batch before the main contact terminates the entire process. To improve accuracy for short dosing processes, the device is equipped with automatic overrun correction, whereby the transmitter measures the quantity that continues to flow after its close command, thus indicating excess dosing.

Calculations are performed to determine the length of time by which the transmitter's close command should be moved forward in subsequent cycles in order to ensure accurate dosing.

This is a cost-effective solution which is simple to implement as no additional counter is required. One drawback of this arrangement is that inputs must always be made directly at the device in the piping (if the flowmeter has an integral mount design), and in-process counter readings are therefore laborious.

Centralization may also pose a challenge if several components are used. The dosing process is enabled via a contact input on the flowmeter which resets the internal counter. Any additional control functions required must be implemented via hardware or a PLC.

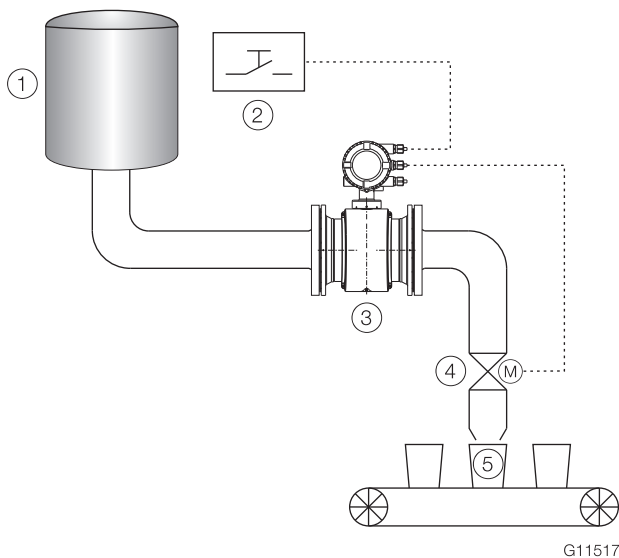


Fig. 1: Schematic representation
① Supply tank ② Start / stop contact ③ Flowmeter
④ Motor valve ⑤ Filled container

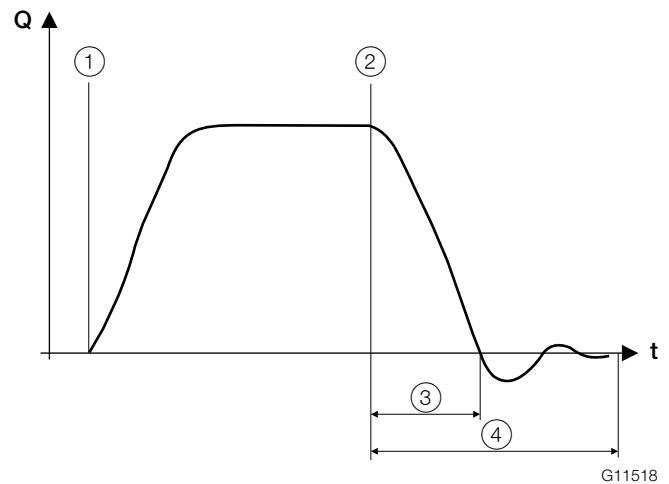


Fig. 2: Dosing procedure
① Valve opened (filling started)
② Valve closed (fill volume reached)
③ Valve close time t_v ④ Overrun time t_n

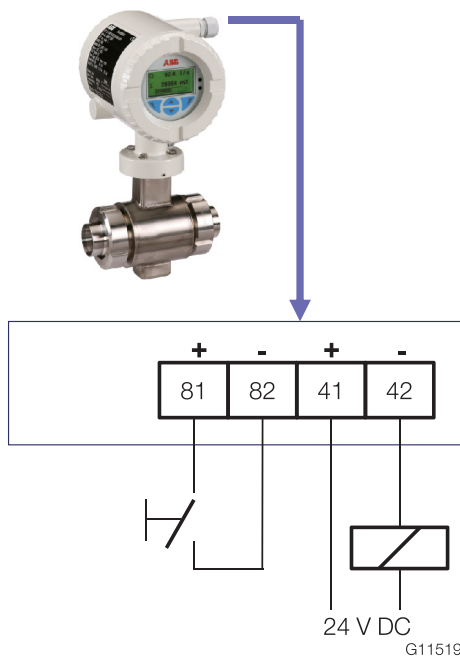


Fig. 3: Electrical connection for the electromagnetic flowmeter

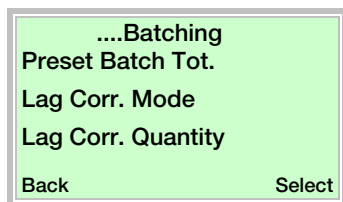


Fig. 4: Setting the dosing volume

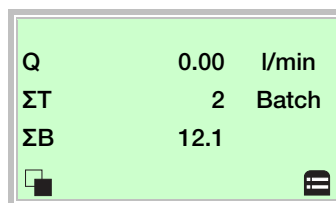
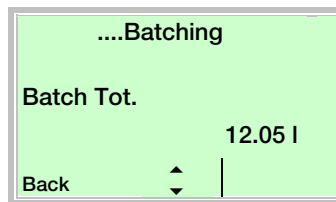
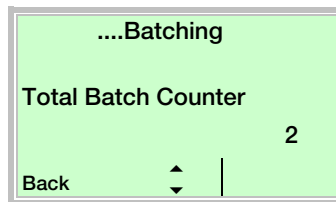
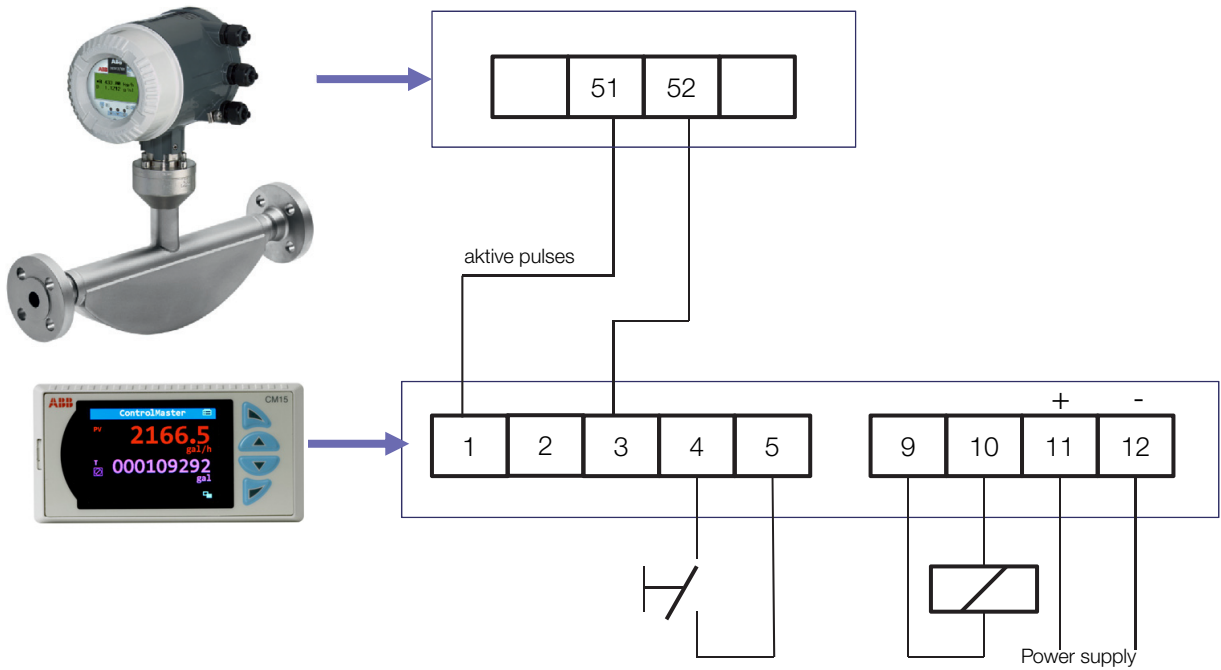
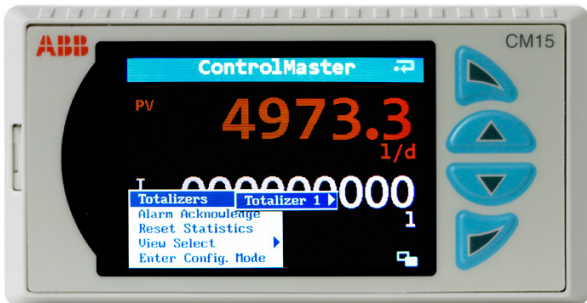


Fig. 5: Reading the batch number, current batch quantity or both with current flow rate



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Fig. 7: Electrical connection for the Coriolis mass flowmeter FCB350 with integrator



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Fig. 8: Preselection input screen for the indicator / totalizer CM15

Flowmeters for batch dosing

Implementation using a flowmeter and compact controller AC500eco

An ABB AC500 eco compact controller can be used as a counter and control device if the options provided by the above solution fall short of what is required. One or more presetting counters can be programmed in a controller of this kind, and control parameters such as locks, interruptions and similar can also be implemented.

A touchscreen (72 x 72 mm) is used to operate the device as well as to display preset quantities, the flow counter, and buttons and switches. The counter can only display figures up to 64000, but this does not generally present a problem since the counter is only used as a dosing counter for limited quantities rather than as a flow counter.

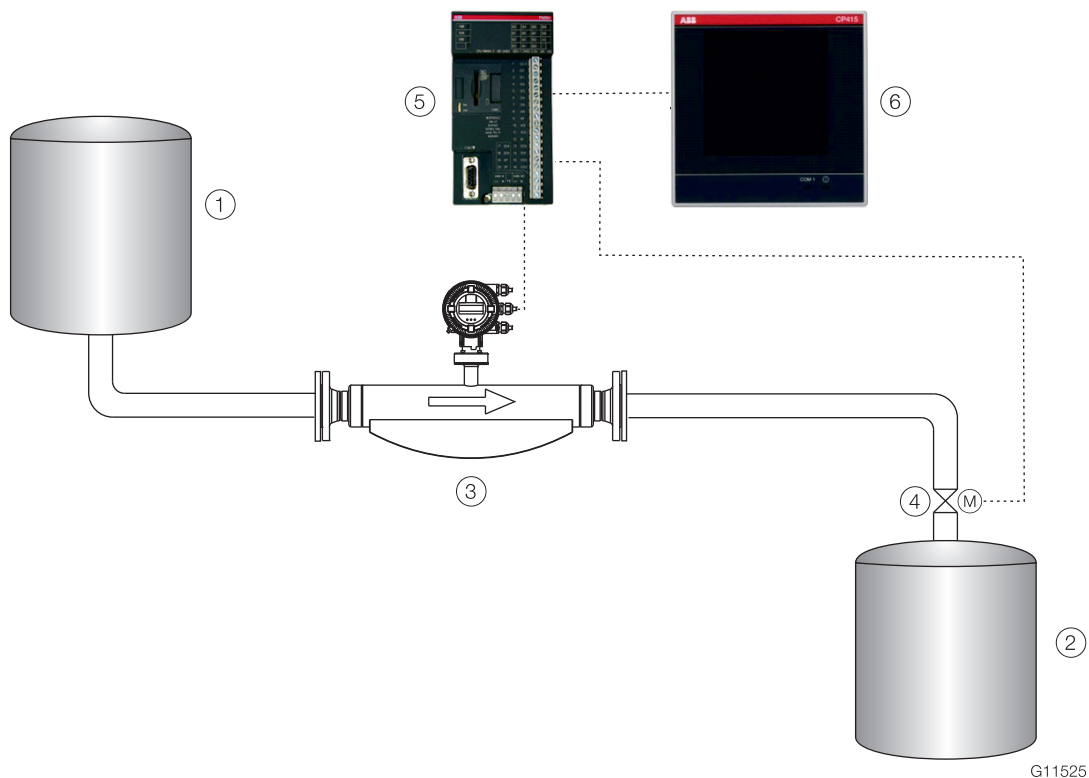
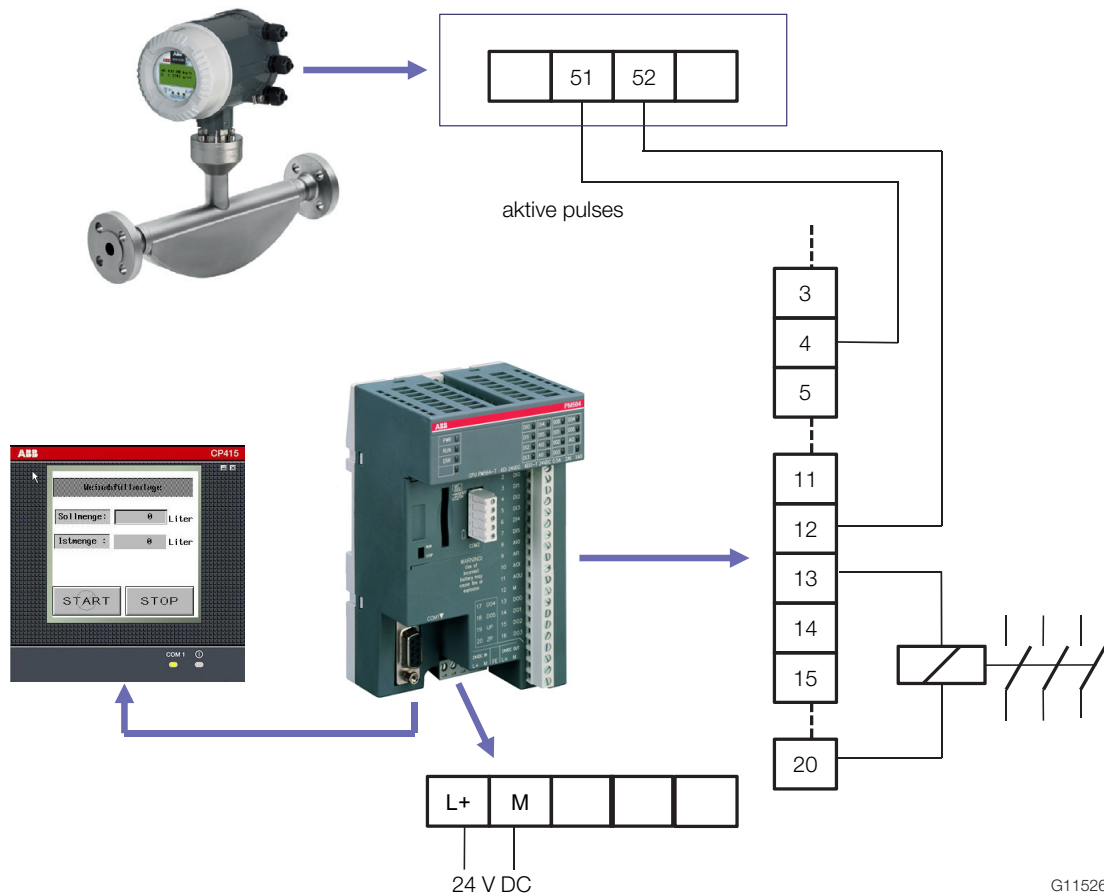


Fig. 9: Schematic representation

① Supply tank ② Filled container ③ Flowmeter ④ Motor valve ⑤ Compact controller AC500eco ⑥ Display for the compact controller CP415



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Fig. 10: Electrical connection for the Coriolis mass flowmeter

Flowmeters for batch dosing

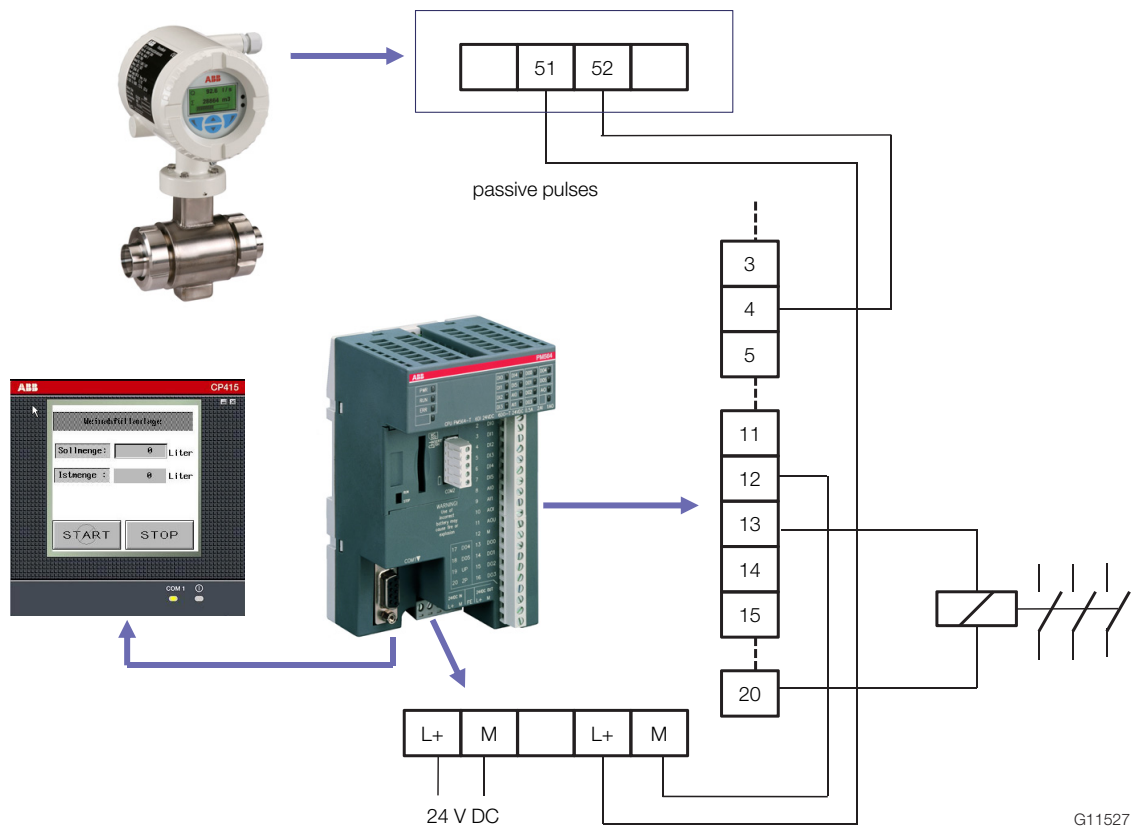
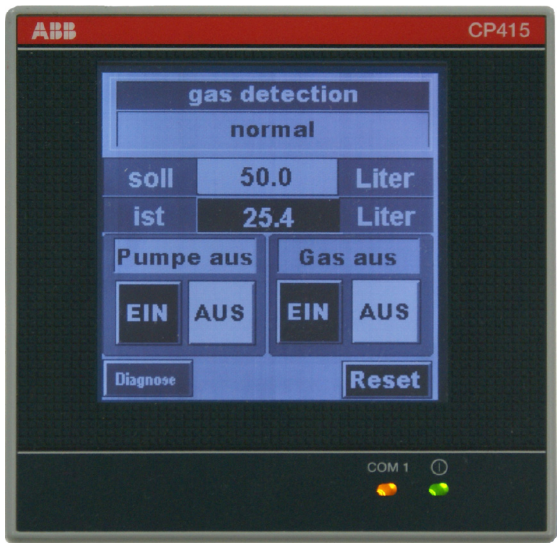


Fig. 11: Electrical connection for the electromagnetic flowmeter

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Fig. 12: Sample user interface with presetting counter, switch elements and other supplementary information



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Fig. 13: Components of a batch dosing system with electromagnetic flowmeter and compact controller AC500eco

Implementation of a filling application using a rapid mass flowmeter, AC500eco and rapid Modbus connection

Very short dosing processes such as those frequently required by filling applications can be achieved by combining a Coriolis mass flowmeter and the AC500eco with a rapid Modbus connection used for communications between the two. The controller features software which has been specially developed for filling processes. The system also records any overrun quantities after the close command and can perform self-corrections. Filling times must be greater than or equal to three seconds.

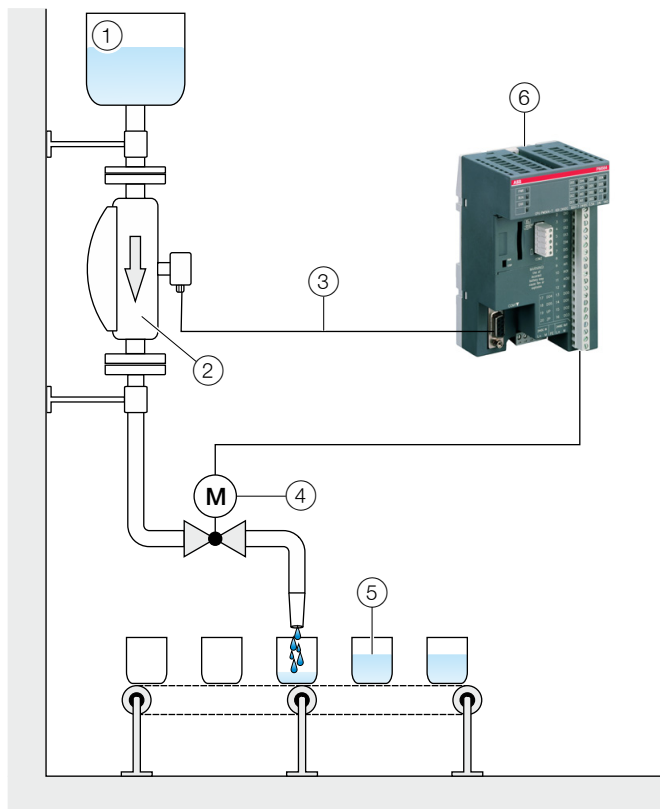


Fig. 14: Rapid filling with FCB100 and AC500eco
 ① Supply tank ② FCB100 ③ Modbus connection
 ④ Selector valve with reproducible close times
 ⑤ Container to be filled ⑥ AC500eco

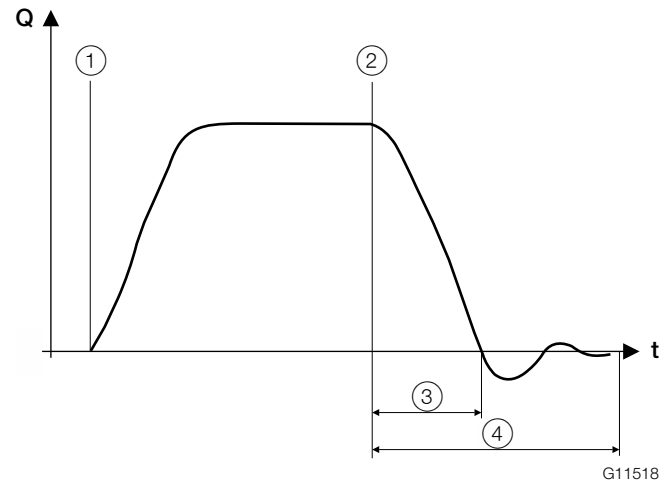


Fig. 15: Dosing procedure
 ① Valve opened (filling started) ② Valve closed (fill volume reached)
 ③ Valve close time t_v ④ Overrun time t_n

Flowmeters for batch dosing

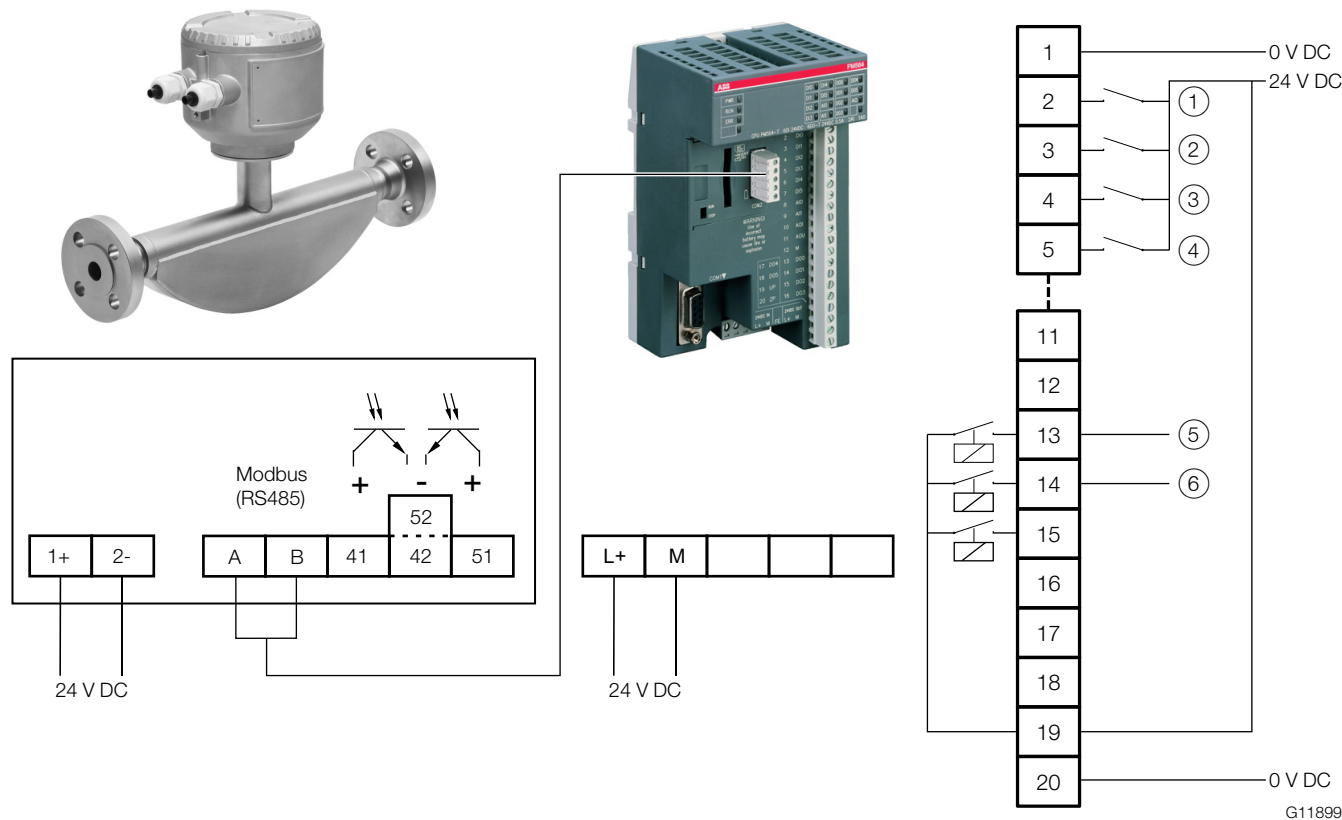


Fig. 16: Wiring for FCB100 and AC500eco

① Fill enable (1 = active; 0 = inactive) ② Pause (1 = pause) ③ Reset (1 = reset) ④ Cleaning (1 = cleaning) ⑤ Open valve (1 = open) ⑥ Fine dosing (1 = active)

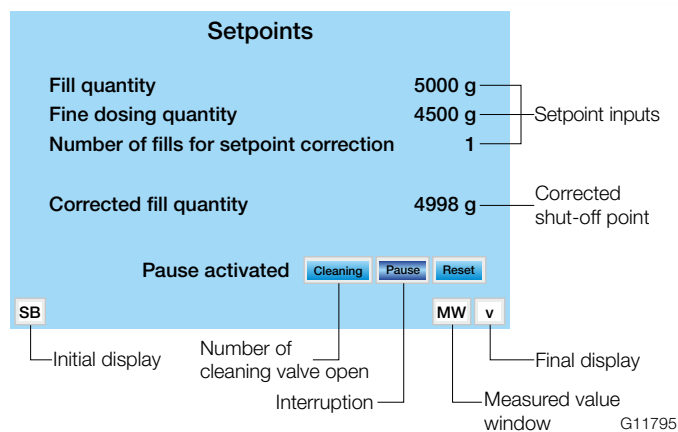


Fig. 17: Example: set point control screen

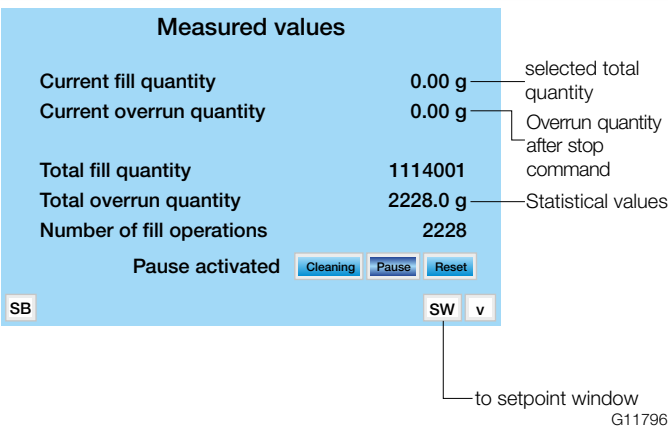


Fig. 18: Example: measured value control screen

Product information

Electromagnetic flowmeter FEH500		
		Integral mount design Nominal diameter DN (if required) PFA liner Electrodes made of SST 1.4571 (AISI 316Ti) Material used for sensor: stainless steel Material used for transmitter housing: cast aluminum, painted Adjustable flow velocity Power supply: 100 ... 230 V AC, 24 V AC/DC Output signal: 4 ... 20 mA
Coriolis mass flowmeter CoriolisMaster FCH300		
		Simultaneous measurement of mass flow, density and concentration No conductive medium required High level of accuracy of up to 1 g per liter for density measurements High level of accuracy of up to 0.15 % of measured value for flow measurements Wetted materials made of stainless steel Self-draining Power supply: 100 ... 230 V AC, 24 V AC/DC Output signal: 4 ... 20 mA
Coriolis mass flowmeter CoriolisMaster FCB100, FCH100		
		Nominal diameter range: DN 10 to DN 200 (DN 25 to DN 80 for hygienic applications) Materials: stainless steel, polished meter tube (optional) Measuring accuracy of flow measurements: mass flow rate 0.1 % and 0.15 % of measured value, volume flow rate 0.15 % of measured value Accuracy of density measurements for liquids: 0.002 kg/l, 0.001 kg/l, 0.0005 kg/l (with field adjustment) Outputs: 2 active/passive digital outputs, Modbus communications Power supply: 11 ... 30 V DC
Indicator / integrator ControlMaster CM15		
		Analog / frequency input Totalizer and counter functions Variable display Computational and logic functions Variable inputs / outputs Standard: 2 universal inputs, 1 analog output, 1 relay output
Compact controller AC500eco with display		
		Controller with analog, frequency and binary inputs Binary outputs Touch display Program for dosing functions

Contact us

ABB Limited

Process Automation

Howard Road, St. Neots
Cambridgeshire, PE19 8EU
UK

Tel: +44 (0) 870 600 6122

Fax: +44 (0)1480 213 339

Mail: enquiries.mp.uk@gb.abb.com

ABB Inc.

Process Automation

125 E. County Line Road
Warminster PA 18974
USA

Tel: +1 215 674 6000

Fax: +1 215 674 7183

ABB Automation Products GmbH

Process Automation

Dransfelder Str. 2
37079 Goettingen
Germany

Tel: +49 551 905-0

Fax: +49 551 905-777

www.abb.com/flow

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