



## Upgrade to 3818-NT Compactability Controller- Conductivity measurement

### Bulletin Number

#2005001

### Affected Products

Model 3818-NT Simpson Compactability Controller

### Part Number:

- Simpson Conductivity kit - 204136

### Revision Date

February 2005

### The Issues

The performance of your Simpson 3818-NT compactability controller could benefit by having a means to vary the amount of initial flush water (flush water addition for B&P Speedmullor®/base water addition for Simpson Mix-Muller®) that is added to a batch muller. Currently the initial water addition is a fixed amount that is entered by an operator and can only be manually changed manually. Sand systems with return sands that have large variances in moisture may result in the initial water setting being too large or too small.

### The Solution

Simpson Technologies has developed a means to automatically adjust the initial water amount based on a conductivity reading at the feed belt to the muller weigh hopper. The initial water setting will always adjust so that it is below the total amount of water needed for the batch. Then the 3818-NT will determine the trim water addition and add the final water required.

The hardware required to make this change consists of two conductivity probes wired to a custom built power supply which can be located in the main controls enclosure. The user is required to fabricate a simple bracket system to mount these probes on the feed belt. A software modification is made to the existing compactability controller program to allow for the automatic flush water control. This software change requires that a Simpson field engineer be present to install this software and perform any required system tuning.

The part number for this conductivity kit is 204136, consisting of:

- 1.) one 5.2761.3.501.3 - Conductivity probe-Left
- 2.) one 5.2761.4.501.3 - Conductivity probe-Left
- 3.) one 0072626- Power supply
- 4.) one Software upgrade

To order the upgrade kit, please contact Simpson by phone (630-978-0044), fax (630-978-0068) or email ([parts@simpsongroup.com](mailto:parts@simpsongroup.com)).

## SIMPSON GROUP

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- Molding Sand Cooling
- Molding Sand Preparation (batch & continuous)
- On-line Controls for Sand Preparation Systems
- Flaskless, Matchplate Mold Making Equipment
- Core Sand Preparation Equipment
- Core Making Equipment
- Sand Reclamation Equipment
- Pollution Control Equipment
- Sand Laboratory Testing Instrumentation
- OEM Spare Parts and Field Service
- Laboratory Testing and Rental Equipment



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