

# Brief Operating Instructions

## Solitrend MMP42

Material moisture measurement



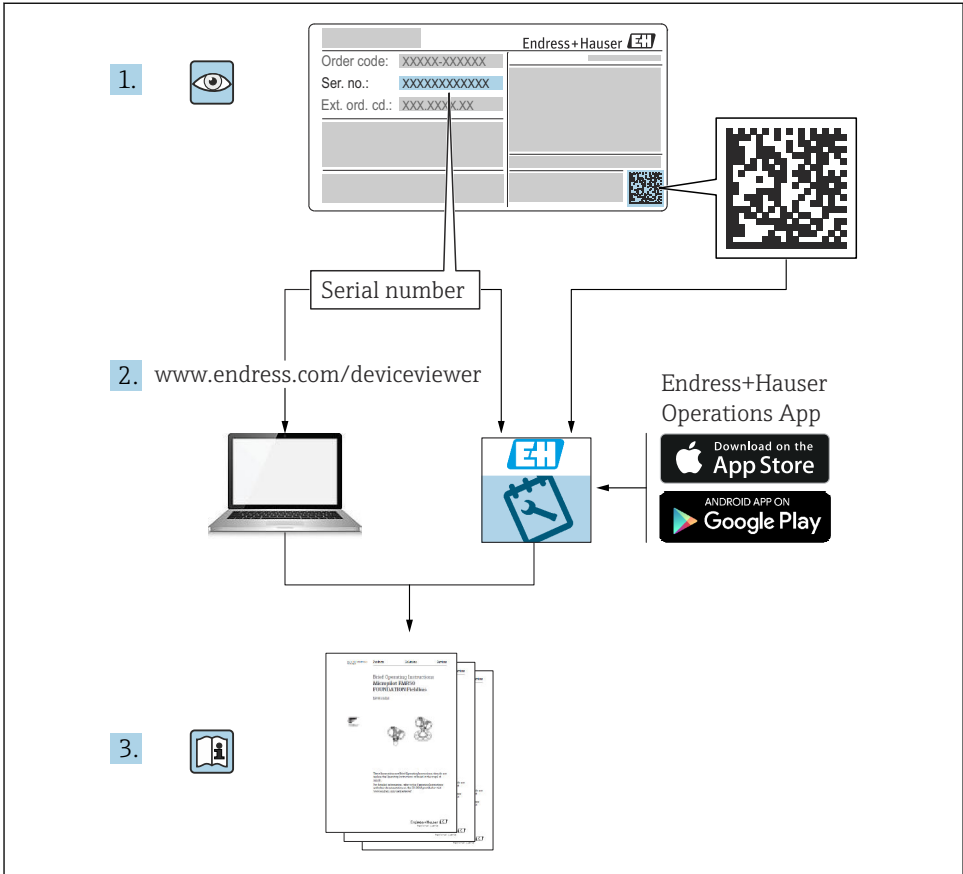
These Brief Operating Instructions are not a substitute for the Operating Instructions pertaining to the device.

Detailed information can be found in the Operating Instructions and the additional documentation.

Available for all device versions via:

- Internet: [www.endress.com/deviceviewer](http://www.endress.com/deviceviewer)
- Smartphone/tablet: Endress+Hauser Operations app

# 1 Associated documentation



## 2 About this document

### 2.1 Symbols used

#### 2.1.1 Safety symbols

** DANGER**

This symbol alerts you to a dangerous situation. Failure to avoid this situation will result in serious or fatal injury.

**⚠ WARNING**

This symbol alerts you to a dangerous situation. Failure to avoid this situation can result in serious or fatal injury.

**⚠ CAUTION**

This symbol alerts you to a dangerous situation. Failure to avoid this situation can result in minor or medium injury.

**ℹ NOTICE**

This symbol contains information on procedures and other facts which do not result in personal injury.

### 2.1.2 Symbols for certain types of information and graphics

**✔ Permitted**

Procedures, processes or actions that are permitted

**✘ Forbidden**

Procedures, processes or actions that are forbidden

**i Tip**

Indicates additional information



Reference to documentation



Reference to graphic



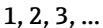
Notice or individual step to be observed



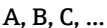
Series of steps



Result of a step



Item numbers



Views

## 3 Basic safety instructions

### 3.1 Requirements for personnel

The personnel for installation, commissioning, diagnostics and maintenance must fulfill the following requirements:

- ▶ Trained, qualified specialists must have a relevant qualification for this specific function and task.
- ▶ Personnel must be authorized by the plant owner/operator.

- ▶ Be familiar with federal/national regulations.
- ▶ Before starting work: personnel must read and understand the instructions in the manual and supplementary documentation as well as the certificates (depending on the application).
- ▶ Personnel must follow instructions and comply with general policies.

The operating personnel must fulfill the following requirements:

- ▶ Personnel are instructed and authorized according to the requirements of the task by the facility's owner-operator.
- ▶ Personnel follow the instructions in this manual.

## 3.2 Intended use

### Application and media

The measuring device described in this manual is intended for the continuous moisture measurement of a wide variety of materials. Due to its operating frequency of approx. 1 GHz, the device can also be used outside of closed metal vessels.

If operated outside of closed vessels, the device must be mounted in accordance with the instructions in the "Installation" section. The operation of the devices does not present any health risk. If the limit values specified in the "Technical data" and the conditions listed in the instructions and additional documentation are observed, the measuring device may be used only for the following measurements:

- Measured process variables: material moisture, material conductivity and material temperature

To ensure that the device remains in proper condition throughout the operating period:

- ▶ Use the device only for media to which the process-wetted materials are sufficiently resistant.
- ▶ Observe the limit values in the "Technical data".

### Incorrect use

The manufacturer is not liable for damage caused by using the device incorrectly or for purposes for which it was not intended.

Verification for borderline cases:

- ▶ With regard to special fluids and media used for cleaning, the manufacturer is glad to assist in clarifying the corrosion resistance of materials in contact with the fluid, but does not accept any warranty or liability.

### Residual risks

Due to the transfer of heat from the process and power dissipation within the electronics, the temperature of the electronics housing and the assemblies contained therein may increase to up to 70 °C (158 °F) during operation. When in operation, the sensor can reach a temperature close to the medium temperature.

Danger of burns from contact with surfaces!

- ▶ In the event of high medium temperatures, ensure protection against contact to prevent burns.

### 3.3 Workplace safety

For work on and with the device:

- ▶ Wear the required personal protective equipment according to federal/national regulations.

### 3.4 Operational safety

Risk of injury!

- ▶ Operate the device only if it is in proper technical condition, free from errors and faults.
- ▶ The operator is responsible for interference-free operation of the device.

#### Hazardous area

To eliminate the risk of danger to persons or the facility when the device is used in the approval-related area (e.g. explosion protection, pressure equipment safety):

- ▶ Check the nameplate to verify if the device ordered can be put to its intended use in the approval-related area.
- ▶ Observe the specifications in the separate supplementary documentation that is an integral part of this manual.

### 3.5 Product safety

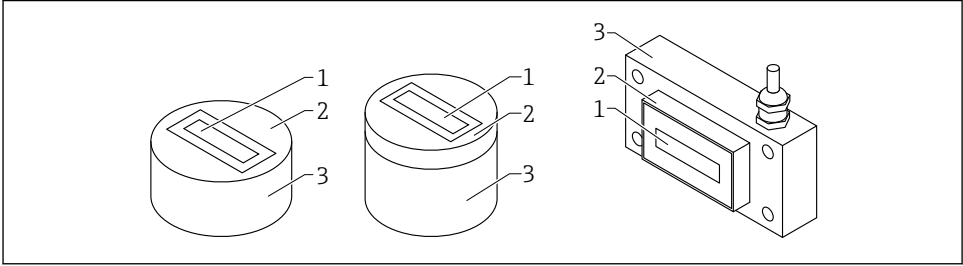
This device is designed in accordance with good engineering practice to meet state-of-the-art safety requirements, has been tested, and left the factory in a condition in which it is safe to operate.

It meets the general safety standards and legal requirements. It also complies with the EU directives listed in the device-specific EU Declaration of Conformity. The manufacturer confirms this by affixing the CE mark to the device.

## 4 Product description

TDR material moisture sensors for measuring bulk solids and media with material densities of 0.3 to 1.0 kg/dm<sup>3</sup> and conductivity values up to 2 mS/cm.

## 4.1 Product design

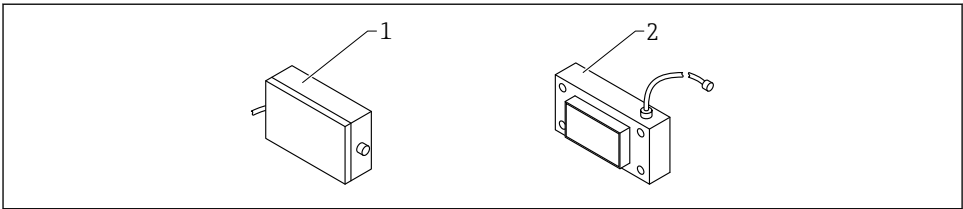


A0040209

### 1 Product design

- 1 Measuring cell; wave guide (1.4301) + ceramic (aluminum oxide)
- 2 Sensor plate
- 3 Housing

### 4.1.1 ATEX version



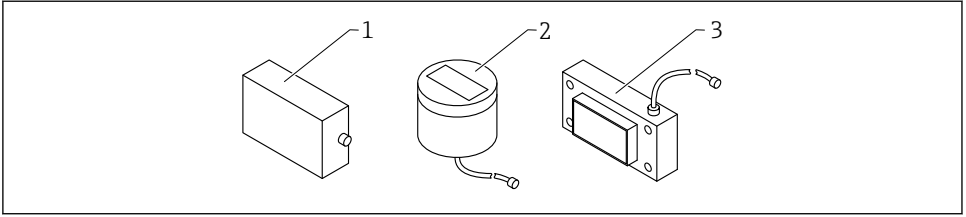
A0053310

### 2 Rectangular sensor, ATEX version

- 1 ATEX electronics housing
- 2 Rectangular sensor

### 4.1.2 Sensor temperature range up to 120 °C (248 °F)

In the case of the order option "Sensor temperature range up to 120 °C (248 °F)", the electronics module is always located in a separate housing and is connected using the HF cable that is permanently connected to the sensor (round sensor, middle version or rectangular sensor).




A004424

- 1 Electronics housing
- 2 Round sensor, middle with HF cable 2.5 m (8.2 ft)
- 3 Rectangular sensor with HF cable 2.5 m (8.2 ft)

## 5 Incoming acceptance and product identification

### 5.1 Incoming acceptance

Check the following during incoming acceptance:

- Are the order codes on the delivery note and the product sticker identical?
  - Are the goods undamaged?
  - Do the nameplate data match the ordering information on the delivery note?
  - If required (see nameplate): Are the safety instructions (XA) provided?
-  If one of these conditions is not met, please contact the manufacturer's sales office.

### 5.2 Product identification

The following options are available for identification of the device:

- Nameplate specifications
- Extended order code with breakdown of the device features on the delivery note
- ▶ Enter serial number from nameplates in *W@M Device Viewer* ([www.endress.com/deviceviewer](http://www.endress.com/deviceviewer))
  - ↳ All of the information on the measuring device and on the scope of the technical documentation pertaining to the device is displayed.
- ▶ Enter the serial number from the nameplate into the *Endress+Hauser Operations App* or scan the 2-D matrix code on the nameplate.
  - ↳ All of the information on the measuring device and on the scope of the technical documentation pertaining to the device is displayed.

## 5.3 Manufacturer's address

Endress+Hauser SE+Co. KG  
Hauptstraße 1  
79689 Maulburg, Germany

## 5.4 Storage, transport

### 5.4.1 Storage conditions

- Permitted storage temperature:  $-40$  to  $+70$  °C ( $-40$  to  $+158$  °F)
- Use original packaging.

### 5.4.2 Transporting the product to the measuring point

Transport the device to the measuring point in the original packaging.

# 6 Mounting

## 6.1 Mounting requirements

- The device must be installed at a point in the process in such a way that ensures a constant bulk density, as the bulk density directly affects the calculation of the water content. Where necessary, a bypass should be created or structural measures may be needed at the place of installation to ensure that the material flow, and therefore the bulk density, over the measurement surface is constant.
- The measuring field of the device must be completely covered by material and the material height must exceed the minimum layer of material covering on the measurement surface (depends on the device type and moisture).
- The flow of material over the measurement surface must be continuous. With the software, it is possible to automatically detect and bridge gaps in material flow in intervals of seconds.
- No material deposits or buildup may form on the measuring cell surface, as this would falsify the readings.

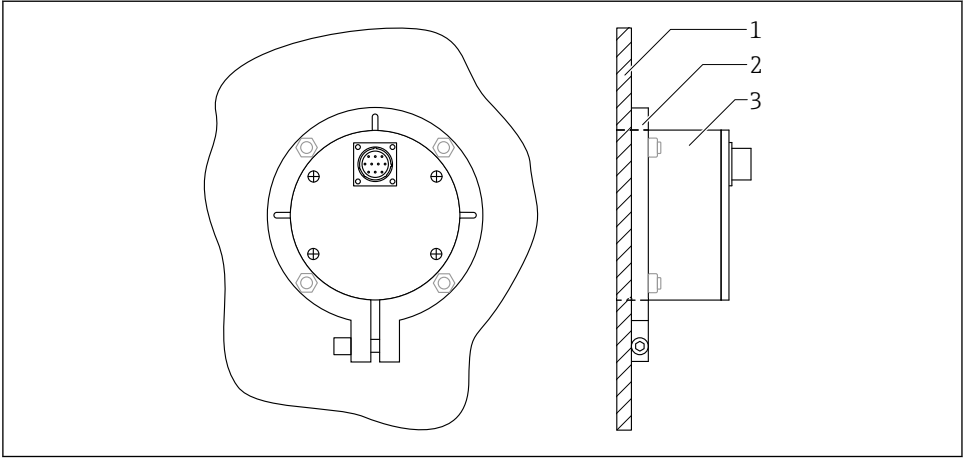


Longer averaging times increase the stability of the measured value.

## 6.2 Round sensor, short/middle

The round sensor, short / middle version, can be mounted with a mounting flange.



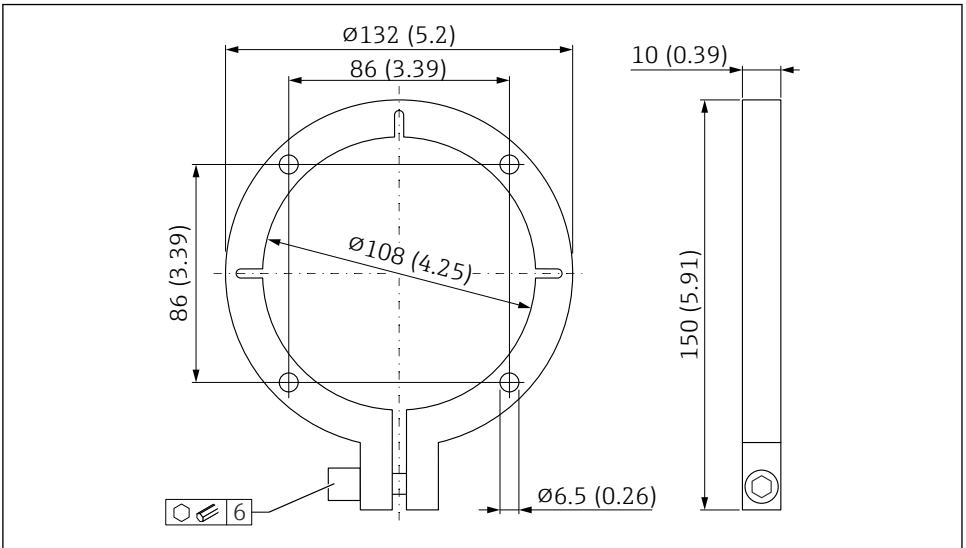


A0037422

3 Round sensor mounted, rear view

- 1 Vessel wall
- 2 Mounting flange
- 3 Round sensor, short / middle

The mounting flange for the round sensor, short version or for the round sensor, middle version can be mounted on the floor or on the side wall of the vessel.

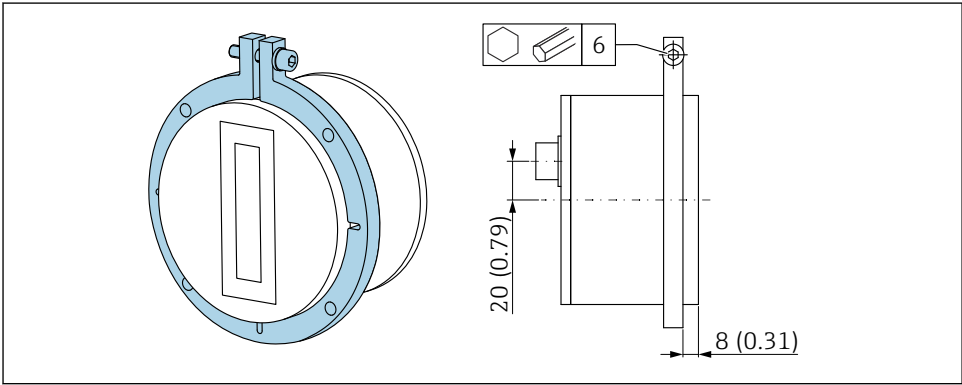


A0037423

4 Mounting flange for round sensor, short version or round sensor, middle version. Unit of measurement mm (in)

The mounting flange serves as a template for the mounting bore holes and the cut-out for the sensor at the mounting location:

1. Check the fit between the sensor and mounting flange
2. Make the cut-out for the sensor at the mounting location
3. Mount the sensor and align it
  - ↳ The surface of the measuring cell is flush-fitted on the material side



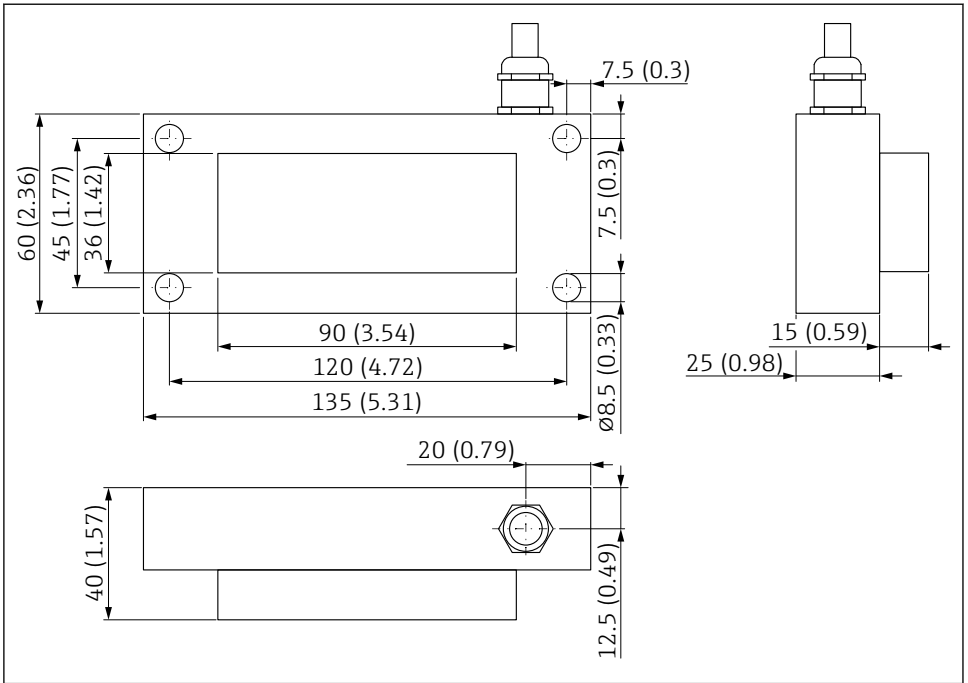
A0044393

5 Mounting position, mounting flange and round sensor. Unit of measurement mm (in)

### 6.3 Rectangular sensor

The rectangular sensor can be installed with four screws (M8).

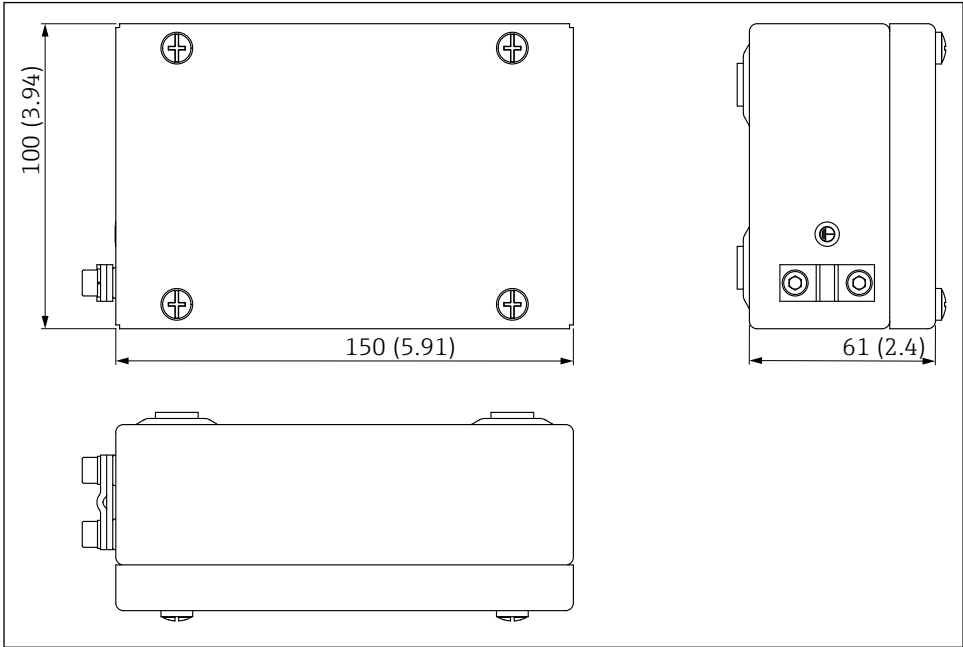
An appropriate cut-out must be created at the place of installation for the measuring cell and bores to secure it.



A0037426

6 Dimensions. Unit of measurement mm (in)

## 6.4 ATEX electronics housing



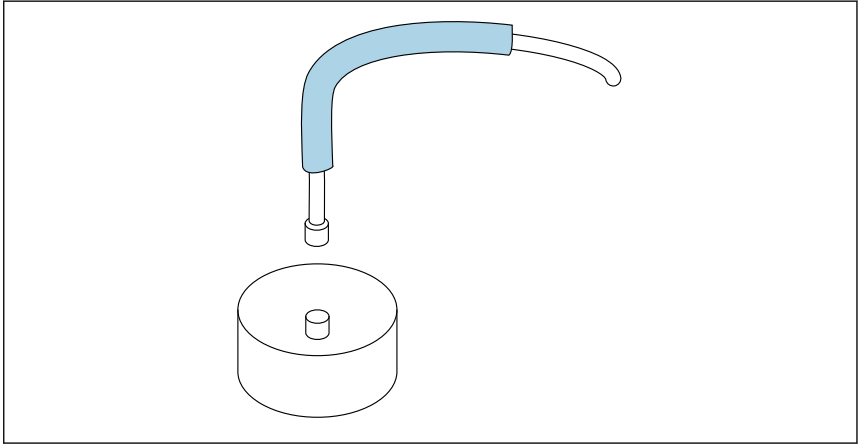
A0053050

7 Dimension of ATEX electronics housing. Unit of measurement mm (in)


## 6.5 Protection of sensor connector against abrasion

If sand and gravel can come into contact with the sensor connector when they flow over the baffle plate, it is recommended to mount an additional protective guard on the sensor connector.

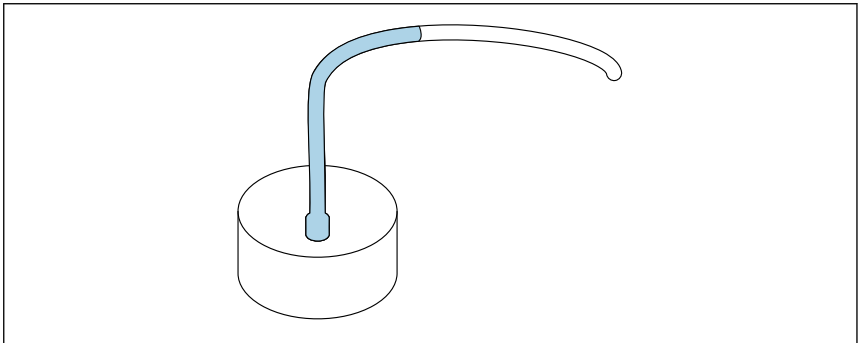
1. The heat-shrink tube supplied with the cable can be used to provide this protection.




A0037427

 8 Example of round sensor

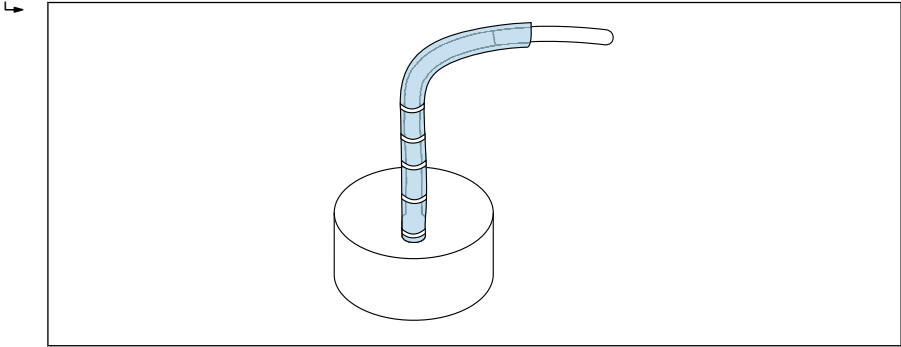
2. Once the sensor has been installed and the sensor cable connected, the heat-shrink tube can be shrunk onto the connector and cable with a hot air blower



A0037428

 9 Example of round sensor

3. In addition, the sensor and ground cable can be protected with a silicone tube (not included in the delivery)

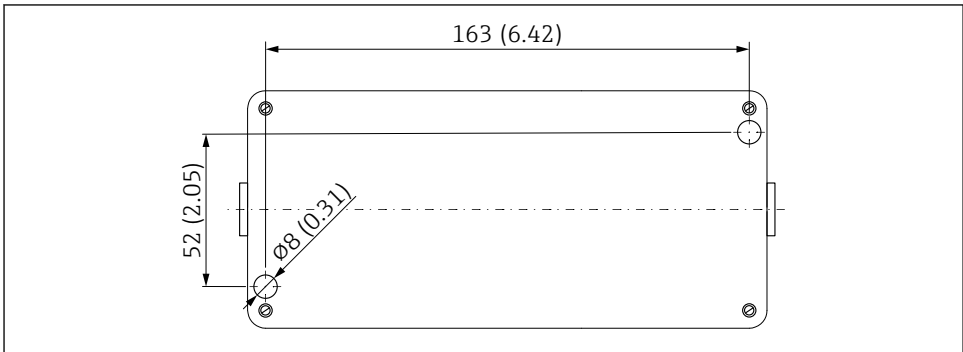


A0037429

10 Example of round sensor

## 6.6 Mounting the housing with the remote electronics module

The housing with the remote electronics module can be mounted with two screws (M5).



A0046898

11 Mounting stencil for housing with remote electronics module. Unit of measurement mm (in)

## 6.7 Post-mounting check

Perform the following checks after mounting the device:

- Is the device undamaged (visual inspection)?
- If provided: are the measuring point number and labeling correct?
- Are the connections established correctly and protected against mechanical influences?
- If used: is the device securely positioned in the mounting flange / mounting frame (visual inspection)?

- Is the device securely mounted and is the measuring cell surface flush on the material side (visual inspection)?
- Is sufficient material coverage / material flow over the measurement surface ensured?

## 7 Electrical connection

### 7.1 Connecting requirements

#### 7.1.1 Cable specification

Connecting cables are available in different versions and lengths (depending on design).

##### Device with 10-pin connector

Connecting cables with a pre-assembled 10-pin socket on the device side are available in different standard lengths:

- 4 m (13 ft)
- 10 m (32 ft)
- 25 m (82 ft)

**UNITRONIC PUR CP** shielded cable, twisted pairs  $6 \times 2 \times 0.25 \text{ mm}^2$ , PUR sheath resistant to oils and chemicals.

##### Rectangular sensors

Standard lengths (fixed cable):

- 5 m (16 ft)
- Cable lengths of 1 to 100 m (3 to 328 ft) are possible upon request

**UNITRONIC PUR CP** shielded cable,  $10 \times 0.25 \text{ mm}^2$ , PUR sheath resistant to oils and chemicals.

### 7.2 Connecting the measuring instrument

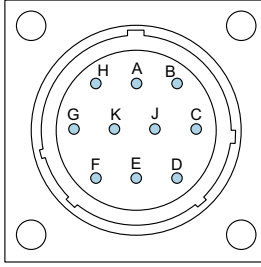
#### 7.2.1 Terminal assignment

##### Round sensors

Round sensors are supplied with a 10-pin MIL plug as standard.



In the high-temperature version 0 to 120 °C (32 to 248 °F), the sensor is separated from the electronics unit via a HF cable. The electronics housing is fitted with 10-pin MIL plugs on both sides.



A0037415

### 12 Assignment of the 10-pin plug

- A 12 to 24 V<sub>DC</sub> stabilized power supply  
Wire color: red (RD)
- B 0 V<sub>DC</sub> power supply  
Wire color: blue (BU)
- D 1st analog positive (+), material moisture  
Wire color: green (GN)
- E 1st analog return line (-), material moisture  
Wire color: yellow (YE)
- F RS485 A (must be enabled)  
Wire color: white (WH)
- G RS485 B (must be enabled)  
Wire color: brown (BN)
- C IMP-Bus RT  
Wire color: gray (GY) / pink (PK)
- J IMP-Bus COM  
Wire color: blue (BU) / red (RD)
- K 2nd analog positive (+)  
Wire color: pink (PK)
- E 2nd analog return line (-)  
Wire color: gray (GY)
- H Shield (is grounded at the sensor. The installation must be grounded correctly!)  
Wire color: transparent

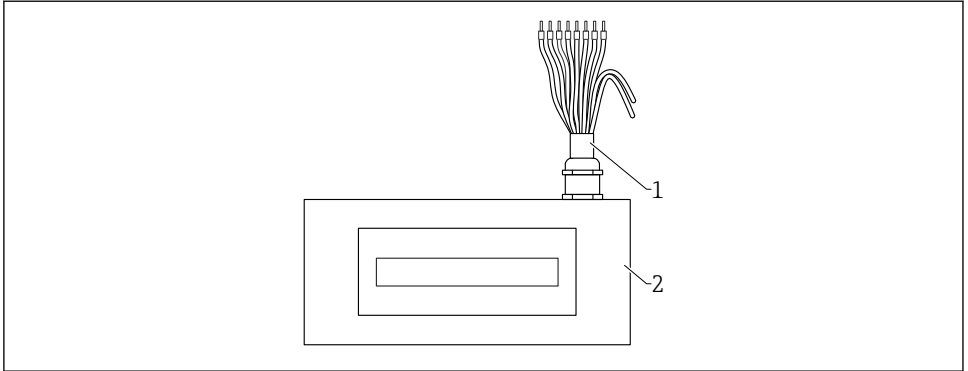
## Rectangular sensors

Standard version of rectangular sensor:

- Cable length: 5 m (10-pin)
- The cable is firmly connected to the sensor
- The other end of the cable is fitted with ferrules

**i** In the high-temperature version 0 to 120 °C (32 to 248 °F), the sensor is separated from the electronics unit via a HF cable. The electronics housing is fitted with 10-pin MIL plugs on both sides.





A0041156

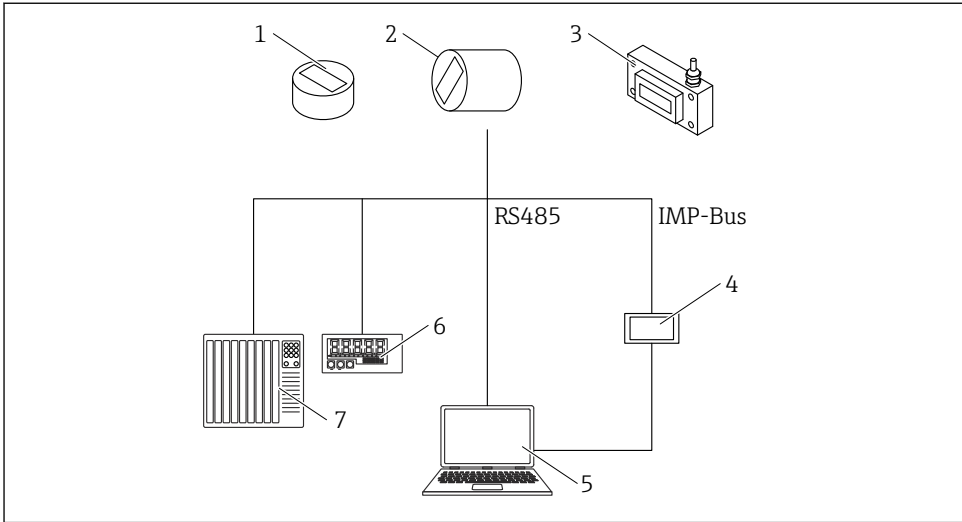
📌 13 Rectangular sensor (standard version) with 10-pin cable assignment

- 1 10-pin cable with ferrules
  - 12 to 24 V<sub>DC</sub> stabilized power supply  
Wire color: white (WH)
  - 0 V<sub>DC</sub> power supply  
Wire color: brown (BN)
  - 1st analog positive (+), material moisture  
Wire color: green (GN)
  - 1st analog return line (-), material moisture  
Wire color: yellow (YE)
  - IMP-Bus RT  
Wire color: pink (PK)
  - IMP-Bus COM  
Wire color: gray (GY)
  - 2nd analog positive (+)  
Wire color: blue (BU)
  - 2nd analog return line (-)  
Wire color: violet (VT)
- 2 Rectangular sensor

### 7.3 Post-connection check

- Is the device or cable undamaged (visual inspection)?
- Does the supply voltage match the specifications on the nameplate?
- Are the connections established correctly and protected against mechanical influences?

## 8 Operating options



A0040211

### 14 Overview

- 1 Round sensor, short
- 2 Round sensor, middle
- 3 Rectangular sensor
- 4 Remote display
- 5 Computer
- 6 LED display
- 7 PLC or water dosing computer

## 9 Commissioning

### 9.1 Analog outputs for measured value output

The measured values are output as a current signal via the analog output. The device can be set to 0 to 20 mA or 4 to 20 mA.

**i** The current output can also be set inversely to 20 to 0 mA or 20 to 4 mA for special controllers and applications.

The analog outputs can be set differently to the following possible options:

#### Moisture, temperature

- Output 1: moisture in % (variable setting)
- Output 2: material temperature 0 to 100 °C (32 to 212 °F), this also applies for the high-temperature version.

**Moisture, conductivity**

- Output 1: moisture in % (variable setting)
- Output 2: conductivity 0 to 20 mS/cm(factory setting)

**Moisture, temperature/conductivity**

- Output 1: moisture in % (variable setting)
- Output 2: material temperature 0 to 100 °C (32 to 212 °F) and conductivity 0 to 20 mS/cm with automatic window switching.

It is also possible to divide output 2 into two ranges to output both the conductivity and the temperature, namely the 4 to 11 mA range for the temperature and the 12 to 20 mA range for the conductivity. Output 2 automatically switches between these two windows every 5 s.



Output 1 can be scaled at the factory or subsequently scaled as required (variably) using the remote display (optionally available), e.g. 0 to 10 %, 0 to 20 % or 0 to 30 %

**9.1.1 Possible settings**

There are several possible settings for the analog outputs:

**Analog outputs****Options:**

- 0 to 20 mA
- 4 to 20 mA



The current output can also be set inversely for special controllers and applications.

- 20 to 0 mA
- 20 to 4 mA

**Channels of the analog outputs**

The analog outputs can be set differently to the following possible options:

**Moisture, temperature**

Output 1 for moisture, output 2 for material temperature.

**Moisture, conductivity**

Output 1 for moisture, output 2 for conductivity in the range from 0 to 20 mS/cm (factory setting)


**Moisture, temperature/conductivity**

Output 1 for moisture, output 2 for material temperature and conductivity with automatic window switching.

**Moisture range**

The moisture range and the temperature range at outputs 1 and 2 can be individually configured.

- **Moisture range in %**
  - Maximum: e.g. 20 %
  - Minimum: 0 %
- **Temperature range in °C**
  - Maximum: 100 °C, this also applies for the high-temperature version.
  - Minimum: 0 °C
- **Conductivity in mS/cm**
  - Maximum 20 mS/cm
  - Minimum 0 mS/cm

 The devices can measure the conductivity depending on the device type and the moisture. The output is set to 0 to 20 mS/cm at the factory.


## 9.2 Operating mode

The sensor configuration is preset at the factory before the sensor is delivered. This device setting can then be optimized to suit the process.

### Measure mode and parameters:

The following sensor settings can be changed

- Measure mode A - OnRequest (only in network mode for calling up measured values via the serial interface for calibration purposes).
- Measure mode C - Cyclic (default setting for sensors with cyclic measurement).
- Average time, reaction speed of the measured values
- Calibration (when different materials are used)
- Filter function
- Precision of a single value measurement

 Each of these settings is retained even after the sensor is switched off, i.e. the setting is saved to the non-volatile memory of the sensor.

### 9.2.1 Operating mode

The sensor is supplied from the factory with the **CA** mode for general process applications. 6 different operating modes are available in the **C** measuring mode, depending on the application.

- **CS** mode (Cyclic-Successive)

For very short measurement cycles in the seconds range (e.g. 1 to 10 s) without averaging and without filter functions, and with up to 100 measurements per second internally and a cycle time of 250 ms at the analog output.

- **CA** mode (Cyclic Average Filter)

Standard averaging for relatively fast but continuous measurement processes, with simple filtering and an accuracy of up to 0.1 %. The CA operating mode is also used to record raw values, without averaging and filtering, to be able to subsequently analyze the measured data and determine the optimum operating mode.

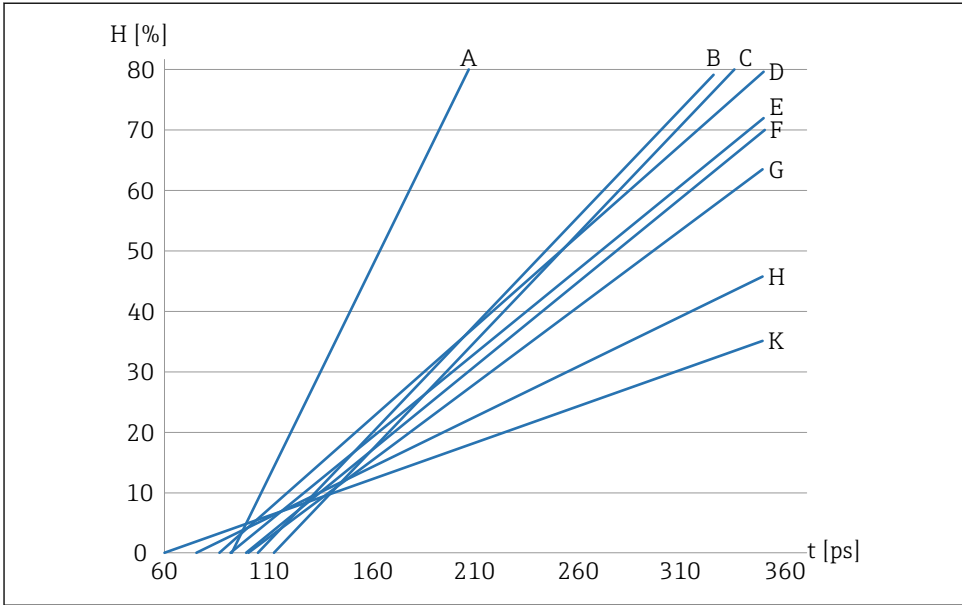
- **CF** mode (Cyclic Floating Average with Filter)

Floating average for very slow and continuous measurement processes, with simple filtering and an accuracy of up to 0.1 %. Suitable for applications on a conveyor belt etc.

- **CK** mode (Cyclic with Boost Filter)  
For complex applications in mixers and dryers
- **CC** mode (Cyclic Cumulated)  
With automatic totalization of moisture quantity measurements in one batch process if no PLC controller is used
- **CH** mode (Cyclic Hold)  
Standard operating mode for applications in the construction industry. Similar to the **CC** mode, but with filtering and without totalization. The **CH** mode is ideal for very short batch times down to 2 s if the sensor has been installed under the silo discharge hatch. The **CH** mode performs filtering automatically. This allows drip water that forms in the silo to be filtered out of the measured value, for example.

### 9.3 Calibration curve set B for grain

For the measurement of different types of grain, special calibration curves for maize, rye, wheat, barley, soy, etc. can be saved in the sensor and can be activated via the remote display.



A0044421

15 Calibration curve set B (Cal.A, Cal.B, Cal.C, Cal.D, Cal.E, Cal.F, Cal.G, Cal.H, Cal.K)

- H* Gravimetric moisture; %  
*t* Radar transit time; picoseconds  
*A* Cal.A, sunflower seeds  
*B* Cal.B, barley with temperature compensation at 60 °C (140 °F)  
*C* Cal.C, wheat, maize, rye; with temperature compensation at 60 °C (140 °F)  
*D* Cal.D, soy without temperature compensation  
*E* Cal.E, barley without temperature compensation  
*F* Cal.F, wheat, maize, rye; without temperature compensation  
*G* Cal.G, soy with temperature compensation at 60 °C (140 °F)  
*H* Cal.H, canola seed and oilseeds  
*K* Cal.K (Cal.14), air/water 0 to 100 %

The graphic shows the linear calibration curves (Cal.A to Cal.K) for various types of grain that are saved and can be selected in the device. The gravimetric moisture (*H*) is indicated as a percentage on the y-axis, and the associated radar transit time (*t*) in picoseconds is indicated on the x-axis. The radar transit time is displayed simultaneously with the moisture value during moisture measurement. In air, the devices measure at a radar transmit time of approx. 60 ps, and 145 ps in dry glass beads.

**i** Calibration curve set A for general bulk solid applications (e.g. sand, gravel, grit, wood chips) is available on request.

**SD02333M Remote display** - Description of operation and material calibration.

### 9.3.1 Installation in or at the discharge hopper

With this type of installation, it is important to set the right calibration curve to match the grain type so that the final moisture is displayed correctly as an absolute moisture value.

If product is continuously discharged and the measuring surface is always permanently covered with grain, a calibration curve with temperature compensation must also be set here.

However, if product is discharged intermittently and the measuring surface is uncovered most of the time, the integrated temperature sensor adapts to the air temperature instead of the grain temperature, which can cause measured errors.

Therefore, a calibration curve without temperature compensation is the recommended setting for intermittent discharge.

To precisely measure and display absolute moisture readings at the discharge point, the calibration curve must be correctly set and fine-adjusted.

Once the device has been fine-tuned for all possible grain types, these parameters are permanently stored in the device. If the type of material to be measured is changed, the user only needs to select the relevant calibration curve during operation, as the influence of the installation location remains constant and the bulk density within a product is also largely the same.

#### Possible settings

- The grain calibration curve can be configured depending on the type
- Depending on the installation location, a zero point offset correction can be performed for the selected calibration curve



The use of the remote display is recommended to perform the fine-adjustment. The device can only be fine-adjusted when it is installed in the system, as the installation location and the bulk density of the grain has a considerable influence on moisture measurement.

The fine-adjustment must be performed separately with each type of grain.

#### Absolute moisture measurement depends on the following parameters:

- Installation location (e.g. metal objects in the field of measurement)
- Bulk density of the material



Another calibration curve must be selected as soon as one of these parameters changes if you want to display the moisture as an absolute moisture value.


## 9.4 Settings

### 9.4.1 Material calibration

Different calibrations are saved in the sensor depending on the intended application of the sensor.

In the "Material calibration" menu item, the necessary calibration can be selected via the optional remote display, depending on the application. In this way, one sensor can cover a variety of applications.

It is also possible to perform your own calibrations and overwrite an existing calibration curve.

 SD02333M **remote display** - description of operation and material calibration.

## 9.5 Special functions

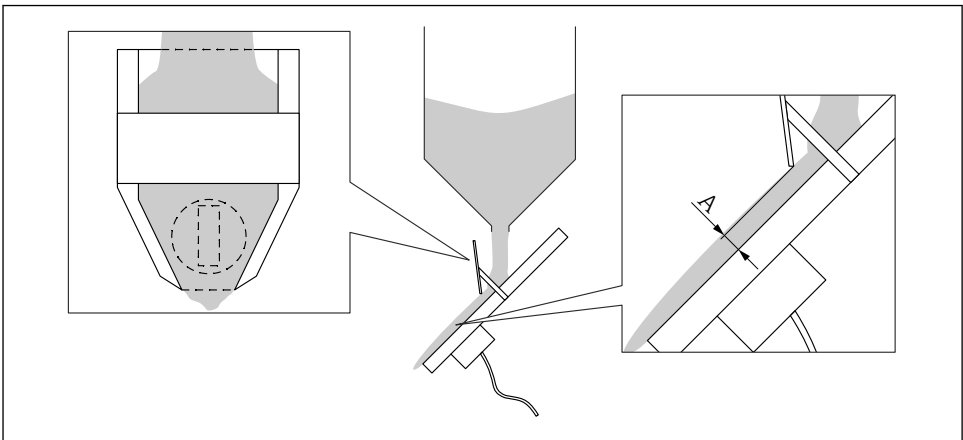
Special functions that are available are described in the Operating Instructions pertaining to the device.

# 10 Diagnostics and troubleshooting


## 10.1 Optimizing the material flow

For accurate measurement results, certain limits must be respected with regard to the installation and environmental conditions, and the associated bulk density of the material being measured. Furthermore, there must be a sufficiently thick layer of material covering the sensor.

If the material flow is too fast, the level of material above the surface of the sensor can be too low. A hopper chute with guide plates can concentrate and increase the level of material above the sensor head. Ideally - particularly in the case of wet sand - the guide plates have a PTFE coating so that no material can stick to them. The sensor requires a layer of material of at least 60 mm (2.36 in). There are installations where the amount of material is too low or too spread out to ensure sufficient material flow over the sensor. In such cases it may be necessary to "concentrate" the material flow so that material accumulates above the sensor as it flows. The diagram below shows an example of a possible unit where the material is concentrated at the side of the sensor and above the sensor.



A0037430

 16 Example: "Concentration of material"



In addition, in the case of non-homogeneous material flow it is possible to use the filter functions, with upper and lower limits, that are implemented in the sensor to filter out wrong measured values.

## 10.2 Difference between measured moisture value and laboratory value too large during initial commissioning


The device is normally precalibrated with calibration set B and **Cal.14** (air/water 0 to 100 %) upon delivery.

The sensor can then be fine-tuned to achieve an accuracy of  $\pm 0.1$  % in relation to the laboratory value in a variety of ways.

- Depending on the PLC, it is possible to perform a parallel shift/offset in the PLC. The parameter has different names depending on the PLC (e.g. initial load, zero point, offset, measuring range, etc.).  
Please contact the PLC manufacturer for more information.
- With the remote display, a fine adjustment or parallel shift in the sensor can be performed using the "Offset" parameter.

**If the moisture value of the sensor deviates by more than  $\pm 0.1$  % from the laboratory value during initial commissioning, this may be due to the following:**

- The sensor is not correctly installed in the material flow. The sensor surface must be covered sufficiently. A good, stable flow of material **must** be guaranteed. A video of the material flow during the batch process can be helpful for analysis purposes.
- The wrong calibration curve is configured in the sensor. The sensor is delivered with calibration curve **Cal.14** (air/water 0 to 100 %).
- Incorrect moisture scaling is configured in the PLC. In the sensor, 0 to 20 % moisture corresponds to the current output of 0 to 20 mA or 4 to 20 mA. The 0 to 20 % moisture scaling must also be entered in the PLC.  
Please contact the PLC manufacturer for more information.
- In the case of materials where the slope does not roughly correspond to a calibration curve saved in the sensor, a 2-point calibration (dry and wet material sample) may be necessary in the PLC or sensor.

 SD02333M **Remote display** - Description of operation and material calibration.

- In the case of coarse-grained or hydrophobic materials, water can escape directly onto the measuring cell and therefore cause a high moisture value. In this case, limits must be entered in the PLC.  
Please contact the PLC manufacturer for more information.
- Due to inaccurate data processing, it may be necessary to check the moisture value displayed in the PLC. For this purpose, connect the sensor to the remote display and check/compare the moisture value shown in the PLC with the moisture value shown on the display.

**Caution:**

The **CA** operating mode in the sensor must then be set to the **CS** mode for a test run, and then switched back to **CA** afterwards.

- Check the start/stop conditions in the PLC
  - Start condition: time in seconds or kg in the scales
  - Stop condition: usually % of target weight
  - Please contact the PLC manufacturer for more information.



If the solutions outlined here do not rectify the problem, contact the manufacturer's Service Department.





71698261

[www.addresses.endress.com](http://www.addresses.endress.com)

---