

## **AUTO CONSISTENCE CONTROL**

**Part Number: 25531**

### **DESCRIPTION:**

Auto Consistence Control is the automatic introduction of water during the concrete mixing process so that the target consistence (slump, flow, vebe, or compactibility) is met before the truck is charged.

### **OPERATION:**

- Water is slowly added to the mixer during the mixing process until the desired consistence is reached. Automatic consistence control can reduce truck in-yard time and improve the batch-to-batch uniformity of the finished product.
- Mixer power consumption (in kilowatts) is used as an indicator of mix consistence. Low-slump ("stiff") mixes require more power consumption to mix than high-slump mixes. COMMANDbatch converts the relative power (in kilowatts) consumed by the mixer into a consistence value or "actual" reading that is used for enabling/disabling the introduction of the water.

### **SYSTEM REQUIREMENTS:**

- COMMANDbatch 01.05.253c or later.
- The mixer motor controls must be equipped with a power (Watt) transducer capable of providing a 0-10V DC proportional to mixer power consumption.

### **IMPLEMENTATION:**

- Connect the 0-10V signal from the power (Watt) transducer to a spare analog input (scale board) on the E-Z Cal Manual Station using standard techniques.
- Configure a consistence-controlled metered feed.
- Configure Consistence Control Groups and Set points.
- Refer to the "AutoConsist.pdf" document for more specific configuration information.

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