

# PCS Low Material Level Hopper Alarm Operating Instructions



**Part No. LHA2000**

## Product Description

PCS Company's Low Level Material Hopper Alarm eliminates machine shutdowns caused by empty hoppers. The alarm uses a proximity sensor to monitor the material level in the machine hopper. If the material level drops below the sensor, a loud alarm sounds and a flashing red light alerts plant personnel. The low level alarm can be used in various processes such as injection molding, blow molding and extrusion. Simple installation requiring 110v and a 1-1/4" hole in the hopper.

## Installation

1. Lock & tag out incoming power for the machine to be modified.
2. Punch or drill a 1-1/4" hole in the hopper at the lowest position where you want the safety material supply before the hopper alarm is triggered. The higher you mount the sensor, the more safety material supply and time you have before the hopper empties.
3. Install one of the 2 nuts provided on to the sensor at least to the halfway point.
4. Install the sensor into the drilled hole. Now thread the second nut from the inside of the hopper to the desired depth & tighten both nuts securely.
5. Install the Alarm Box in a convenient place on the machine at least at ear level. Keep away from the hot machine barrel and any possible water source. Be sure to keep away from any moving parts of the machine.
6. Plug power cord into grounded 115/60/1 outlet.

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## Sensor Adjustment

The PCS Low Level Hopper Alarm requires the proximity sensor to operate as Normally Closed (N/C). Be sure the switch on the sensor is set to N/C. If the sensor has switch, the slot will point to the label N/C position if correct. The Normally Open/Normally Closed option will always be labeled on the switch if it has the ability to be switched.

Adjust sensor at installation and at material changes.

1. Fill hopper with enough plastic material to cover the entire switch which is protruding into the hopper.
2. Locate sensor sensitivity screw adjustment. Some sensors require a screw cover plug to be removed first.
3. Turn the adjusting screw counterclockwise until alarm sounds.
4. Once alarm sounds, turn screw clockwise just until alarm turns off.
5. Check the operation of the alarm by allowing material to drop below sensor level. Alarm will sound. If not, repeat steps 3 & 4.

This is a highly reliable product. If for any reason a failure occurs, contact PCS customer service for any replacement parts.