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GMC-X802

Communication

Manual

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V01.00.00

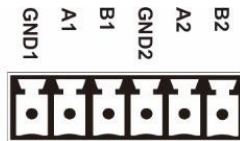
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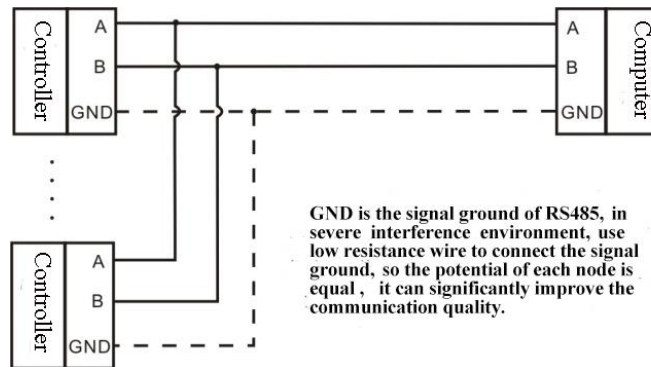
1. Serial port connection

Gmc-x802 can provide two RS485 serial communication interfaces, the serial interface supports MODBUS (RTU/ASCII) protocol, continuous transmission and result transmission protocol.

The interface is shown in the following figure:



RS485 connection mode:



Serial port troubleshooting:

If the serial port fails to communicate, check it:

- Check the connection according to the above connection method; Make sure the connection is correct

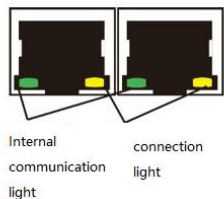
The RS485 port must be connected to cables A and B.

- Ensure that the parameters of the connection port are consistent with those of the host computer.

Slave number, baud rate, data format and communication protocol must be consistent with the host computer and PLC.

2. Network port connection(Optional)

The product supports single/dual network port communication and supports Modbus TCP network port protocol. Dual network ports are configured with built-in switches for easy expansion.



Internal communication light: The hardware connection is normal, and the internal communication light is steady on.

Connection indicator: The network cable is properly connected and the connection indicator is blinking.

2.1 Network port troubleshooting

If the network port fails to communicate, check it:

- Checking network port Indicators.

The hardware connection is normal, and the internal communication light is steady on.

The network cable is properly connected and the connection indicator is blinking.

- Check whether the communication protocol is consistent with the host computer and PLC.
- Verify that the instrument can be pinged from the network. If not, check the hardware interface.
- Check whether IP conflict occurs.
- Restart instrument.

3. Serial port parameter

Serial port 1 parameters:

No.	Parameter	Initial value	Instrument
3.1	Address id	1	Range: 0~99。
3.2	Baud rate (baud)	38400	Range: 9600、19200、38400、57600、115200
3.3	Communication mode	Modbus-RTU	Range: Modbus-RTU、Modbus-ASCII、continuous transmission、result sending
3.4	Data format	8-E-1	Range: 8-N-1、8-E-1、8-O-1、7-E-1、7-O-1 (8 bit data bit-Even Check bit-1bit stop bit)。
3.5	Hi-Low Byte (hi-low)	AB-CD	Modbus Communication display mode: Range: AB-CD(High in front)、CD-AB(low in front)
3.6	Send interval (interv)	5	Valid only under the continuous Send protocol Range: 0~1000ms

Serial port 2 parameters:

No.	Parameter	Initial value	Instrument
4.1	Address id	1	Range: 0~99。
4.2	Baud rate (baud)	38400	Range: 9600、19200、38400、57600、115200
4.3	Communication (mode)	Modbus-RTU	Range: Modbus-RTU、Modbus-ASCII、Continuous send、result sending
4.4	Data format	8-E-1	Range: 8-N-1、8-E-1、8-O-1、7-E-1、7-O-1 (8 bit data bit-even check-1bit stop bit)。
4.5	Hi-Lo Byte(hi-low)	AB-CD	Modbus communication display mode: Range: AB-CD(high in front)、CD-AB(low in font)
4.6	Send interval (interv)	5	Only valid in continuous transmission protocol Range: 0~1000ms

4. Network parameter

No.	Parameter	Initial value	introduction
5.1	IP address part 1 ip_1	192	Range: 0~255
5.2	IP address part 2 ip_2	168	Range: 0~255
5.3	IP address part 3 ip_3	80	Range: 0~255
5.4	IP address part 4 ip_4	125	Range: 0~255
5.5	Socket (Port)	502	Range: 0~60000 Network communication port number settings, 0 indicates closing the connection.

GMC-X802 have Optional network communication interface, connected with RJ-45 crystal head to realize communication with host computer or PLC.

1) When the single network port is selected, TCP protocol is supported. LAN1 can communicate with the network port, and LAN2 (marked N/A) is unavailable.

2) With dual network ports (1 IP group), built-in switch, supports up to 4 TCP connections.

3) Using Modbus-TCP communication protocol, the network port IP address should be set in working parameter 5 NET. For example, if the network port IP address is 192.168.101.106, then 5.1 ip_1 should be entered as 192, 5.2 ip_2 as 168, 5.3 ip_3 as 101, and 5.4 ip_4 as 106; the port number is set in 5.5 port.

4) MAC address view range: 10100~10111 (PLC address: 410101~410112).

5. Protocol Description

5.1 MODBUS Protocol

5.1.1 function code&Exception code

◆ Function codes supported by the instrument:

Function code	name	introduction
03	Read register	A maximum of 125 registers can be read at a time.
06	Write single register	Use this function code to write a single holding register.
10	Writing multiple registers	Only supports writing to dual registers. The address must be aligned when writing. It is not allowed to write only part of the dual register. It is allowed to read only part when reading.
01	Read coil	Note that this length is in bits.
05	Write coil	

Note: This instrument only supports the above MODBUS function codes. When sending commands with other function codes to this instrument, the instrument will not respond.

◆ MODBUS exception code

code	name	introduction
02	Illegal data address	The address in the receiving frame is unreasonable, such as misalignment when writing to a double-word register.
03	Illegal data value	The data value written exceeds the allowable range.
04	Slave Failure	An unrecoverable error occurred while the instrument was attempting to perform the requested operation.
07	Unsuccessful programming request	The received command cannot be executed under the current conditions.

5.1.2 MODBUS Transmission Mode

RTU Mode

When RTU mode is used for communication, each 8-bit byte in the information is divided into two 4-bit hexadecimal characters for transmission.

Data format: **8 data bit, 1 stop bit, even check(8-E-1)**

8 data bit, 1 stop bit, odd check(8-O-1)

8 data bit, 1 stop bit, no check(8-n-1)

8 data bit, 2 stop bit, no check(8-n-2)

Baud rate: **9600/19200/38400/57600/115200**(Choose one)

Code: Binary

ASCII mode

When ASCII mode is selected for communication, each 8-bit byte in a message is transmitted as 2 ASCII characters.

Data format: **8 data bit, 1 stop bit, even check(8-E-1)**

8 data bit, 1 stop bit, odd check(8-O-1)

8 data bit, 1 stop bit, no check(8-n-1)

8 data bit, 2 stop bit, no check(8-n-2)

7 data bit, 1 stop bit, even check(7-E-1)

7 data bit, 1 stop bit, odd check(7-O-1)

7 data bit, 2 stop bit, no check(7-n-2)

Baud rate: 9600/19200/38400/57600/115200 (Choose one)

Code: ASCII

5.1.3 MODBUS Communication address sheet

PLC address	Display address	Meaning	Introduction	
Weight status information parameters(Read-only)				
40001-40002	0000-0001	A scale weight value (4-byte signed integer)	When the screen is not displayed, return the weight value	
40003-40004	0002-0003	B scale weight value (4-byte signed integer)	When the screen is not displayed, return the weight value	
40005	0004	A scale weight status flag	Bit	Introduction
			.13-15	Reserve
			.12	Bipolar
			.11	Calculate weight by using theoretical values
			.10	ADC failure
			.09	Display net weight currently
			.08	Millivolt is stable
			.07	Loadcell negative overflow
			.06	Loadcell positive overflow
			.05	Weight negative overflow
			.04	Weight positive overflow
			.03	Overflow status
			.02	Display weight is negative
.01	Zero			
.00	Stable			
40006	0005	A scale error code 1 (Calibration class error)	.13-15	reserve
			.12	Remote calibration When forbidden (used when serial port calibration switch is available)
			.11	Under hardware protection during calibration (when hardware calibration switch is available)
			.10	Previous weight point uncalibrated (only use for multi-point calibration)
			.09	Beyond minimum resolution

			.08	The weight input exceeds the maximum range
			.07	The weight input cannot be zero
			.06	The weight is marked to be less than zero or the previous marked point
			.05	The loadcell is positive overflow during weight calibration
			.04	The Loadcell is negative overflow during weight calibration
			.03	Weight calibration is unstable
			.02	Loadcell overflow during zero calibration
			.01	Loadcell negative overflow during zero calibration
			.00	Zero calibration is unstable
40007	0006	A scale error code 2 (zero tare operation error code)	.10-15	Reserve
			.09	Remote tare operation permit switch is not enabled during remote tare operation (used when tare operation is available)
			.08	Taring is not allowed in the net weight state (for tare operation)
			.07	Net weight status is not allowed to zero (used when tare is used)
			.06	Remote zero switch is not enabled during remote zero (used when serial port zero switch is available)
			.05	The loadcell positive overflows when zeroing
			.04	The loadcell negative overflows when zeroing
			.03	Unstable when zeroing
			.02	Zero out of range
			.01	The zero is unstable during power-on
.00	The power-on zero exceeds the range			
40008	0007	B Weight status flag	Refer to A scale	
40009	0008	B scale error code 1- Calibration class error code	Refer to A scale	
40010	0009	B scale error code 2- Zero tare operation error code	Refer to A scale	
40011	0010	Flow status flag bit 1	.15	USB connected
			.14	Reserve
			.13	Supply material status, valid when supplying material

			.12	Lack material status, valid when lacking material
			.11	Coding status, valid when coding, invalid in slave status
			.10	Clip bag status: valid after clipping bag, invalid in slave mode
			.09	Interlock slave mode
			.08	Interlock master mode
			.07	B scale big vibrator test
			.06	B scale small vibrator test
			.05	A scale big vibrator test
			.04	A scale small vibrator test
			.03	Empty material mode (Any of the empty material signal will work)
			.02	IO test mode
			.01	Run (Any run feed is valid, including simulation runs)
			.00	Reserve, return 0b
40012	0011	A scale Flow status flag bit 2	.13-15	Reserve
			.12	A scale over/under suspension state: When the over/under suspension switch is turned on, over/under error occurs, the instrument is suspended, and this state is effective. When the clear alarm, stop, or emergency stop signal is received, this state is invalid.
			.11	A scale stopping....
			.10	Discharge status: effective after discharge starts, invalid after discharge is completed, invalid after stopping
			.09	A scale material replenishment: effective when running replenish material, invalid after completion of material replenishment, invalid after stopping
			.08	A scale result over/under: the waiting value exceeds the target value - the over/under value is valid, invalid after discharging or replenishing material, and invalid after stopping
.07	A scale result over: it is valid when the waiting value exceeds the target value + the over value, invalid after discharging, invalid			

				after stopping
			.06	A scale weigh ok: Valid after waiting, invalid when discharging, invalid after stopping
			.05	A scale feeding stop: effective at the end of slow feeding, invalid when discharging, invalid after stopping
			.04	A scale slow-feed: It is valid after the fast feed starts, invalid after the fast feed ends, and invalid after the stop
			.03	A scale mid feed: It is valid after the fast feeding starts, invalid after the fast feeding ends, and invalid after the stop
			.02	A scale fast feed: It is valid after the fast feeding starts, invalid after the fast feeding ends, and invalid after the stop
			.01	Preparation before feeding, effective after feeding and discharging, invalid after starting feeding, invalid after stopping
			.00	A scale running
40013	0012	B scale flow status mark bit 3(refet to A scale)		
40014	0013	Reserve		
40015	0014	Work flow error code area 1		
			.15	Empty material state does not allow operation, effective 2 seconds after disappearing, at the same time the buzzer sounds
			.14	The I/O test status does not allow the operation. the status disappears after 2 seconds, and the buzzer will sound
			.13	Does not allow the operation in the vibrator test status. After 2 seconds, it disappears and the buzzer will sound
			.12	Software error, can not be started, the status disappears after 2 seconds, at the same time the buzzer will sound
			.11	B scale discharging timeout alarm
			.10	B scale discharging timeout alarm
			.09	When B scale is powered on, the discharge gate is not closed, and the status disappears after 2 seconds, the buzzer rings at the

				same time
			.08	When B scale is started, the discharge gate is not closed, the status disappears after 2 seconds, and the buzzer will sound
			.07	B scale: over/ under alarm
			.06	B scale: the zero before feeding failure alarm, the status disappears after 2 seconds, the buzzer will sound at the same time
			.05	A scale discharging timeout alarm
			.04	A scale feeding timeout alarm
			.03	When A scale is powered on, the discharge gate is not closed, and the status disappears after 2 seconds, and the buzzer will sound
			.02	When A scale is started, the discharge gate is not closed, and the status disappear after 2 seconds, and the buzzer will sound
			.01	A scale over/under alarm
			.00	A scale before the feeding of zero failure alarm, effective 2 seconds after disappearing, while the buzzer will sound
40016	0015	Workflow code area 2 error	.13-15	Reserve
			.12	Feeding gate not closed properly
			.11	Motor feeding gate closing timeout
			.10	Batches completed
			.09	Failed to import parameters by USB.
			.08	Failed to export parameters by USB.
			.07	B scale OFL overflowed during startup and could not be started
			.06	A scale OFL overflowed during startup and could not be started
			.05	When starting, the reserve parameter of B scale is unreasonable and cannot be started
			.04	When starting, the reserve parameter of A scale is unreasonable and cannot be started
			.03	Reserve
			.02	Reserve
			.01	The target value of B scale is 0 and cannot be started
.00	The target value of A scale is 0 and cannot be started			

40017-40018	0016-0017	Reserve	
40019-40020	0018-0019	A scale gross weight, signed number, integral type	If the tare function is not available, the weight value is returned
40021-40022	0020-0021	A scale net weight, signed number, integral type	If the tare function is not available, the weight value is returned
40023-40024	0022-0023	A scale gross weight, signed number, integral type	If tare function is not available, 0 is returned
40025-40026	0024-0025	A scale flow, signed number, integral type	If tare function is not available, 0 is returned
40027-40028	0026-0027	A scale display value, signed number, float type	Returns the weight value when no screen is displayed
40029-40030	0028-0029	A scale gross weight, signed number, float type	If the tare function is not available, the weight value is returned
40031-40032	0030-0031	A scale net weight, signed number, float type	If the tare function is not available, the weight value is returned
40033-40034	0032-0033	A scale tare weight, signed number, float type	If tare function is not available, 0 is returned
40035-40036	0034-0035	A scale flow, signed number, float type	If flow function is not available, 0 is returned
40037-40038	0036-0037	A scale the AD code after filtering	The instrument uses the ADC's 21bit data for filtering, weight calculation, and mV voltage calculation
40039-40040	0038-0039	A scale loadcell voltage value	Read back "Loadcell input voltage" (absolute mV voltage corrected by correction factor), 4 decimal points
40041-40042	0040-0041	A scale relative to zero voltage value	Read return "Loadcell input voltage value - calibration zero voltage value" (the relative mV voltage corrected by the correction factor), 4 decimal points
40043-40044	0042-0043	B scale gross weight, signed number, integral type	If tare function is not available, 0 is returned
40045-40046	0044-0045	B scale net weight, signed number, integral type	If the tare function is not available, the weight value is returned
40047-40048	0046-0047	B scale tare weight, signed	If no tare function is available, 0 is returned

		number, integral type	
40049-40050	0048-0049	B scale flow , signed number, integral type	If no flow function is available, 0 is returned
40051-40052	0050-0051	B scale displayed value, signed number, float type	When the screen is not displayed, return the weight value
40053-40054	0052-0053	B scale gross weight, signed number, float type	When there is no tare function, the weight value is returned
40055-40056	0054-0055	B scale net weight, signed number, float type	When there is no tare function, the weight value is returned
40057-40058	0056-0057	B scale tare weight , signed number, float type	When there is no tare function, it returns 0
40059-40060	0058-0059	B scale flow , signed number, float type	When there is no flow function, it returns 0
40061-40062	0060-0061	B scale AD code after filtering	The instrument uses 21-bit data from the ADC for filtering, weight calculation, and mV calculation.
40063-40064	0062-0063	B scale loadcell voltage value	Read and return "loadcell input voltage" (absolute mV voltage value corrected by the correction factor), 4 decimal points
40065-40066	0064-0065	B scale relative zero voltage value	Read and return "loadcell input voltage value - calibration zero voltage value" (relative mV voltage value corrected by correction coefficient), 4 decimal points
40067-40068	0066-0067	A scale small vibrator real output analog value	Read out real-time output analog value
40069-40070	0068-0069	A scale big vibrator real output analog value	Read out real-time output analog value
40071-40072	0070-0071	B scale small vibrator real output analog value	Read out real-time output analog value
40073-40074	0072-0073	B scale big vibrator real output analog value	Read out real-time output analog value
40075-40082	0074-0081	reserve	
40083-40084	0082-0083	High byte of system total accumulated weight	Range: 0~999999
40085-40086	0084-0085	Low byte of system total accumulated weight	Range: 0~999999999

40087-40088	0086-0087	High byte system total accumulated batches	Range: 0~999999
40089-40090	0088-0089	Low byte system total accumulated batches	Range: 0~999999999
40091	0090	Reserve	
40092	0091	Input status zone (IN1-IN10)	Query the status of the instrument input port.1: valid, 0: invalid
40093	0092	Output status zone(OUT17-OUT20)	Query the output port status of the instrument 1: valid, 0: invalid
40094	0093	Out status zone(OUT1-OUT16)	Query the output port status of the instrument 1: valid, 0: invalid
40095~40100	0094~0099	Reserve	
Basic transmitter parameter area (basic parameters shared by scale A and scale B) (readable-writable)			
40101-40102	0100-0101	Power-on zero range	Range: 0-99 (0%-99% of max capacity) Default: 0 0 indicates that the power-on zero function is disabled (power-on zero timeout is fixed at 3 seconds).
40103-40104	0102-0103	Remote zero switch	There is a display of the instrument control can use the serial port to zero, the instrument does not show, the double word retained, writable, write meaningless, read back 0
40105-40106	0104-0105	Zero range	Range: 1-99 (1%-99% of maximum range) Default: 20
40107 ~ 40114	0106 ~ 0113	Reserve	
40115-40116	0114-0115	Stable range	Range: 0-99d, default: 1
40117-40118	0116-0117	Stable time	Range: 1-5000ms, default: 1000ms
40119-40120	0118-0119	Zero track range	The value ranges from 0 to 99d. Default value: 1
40121-40122	0120-0121	Zero track time	Range: 1-5000ms, default: 1000ms
40123-40124	0122-0123	Digital filtering	Range: 0-9, default: 4
40125-40126	0124-0125	Reserve	
40127-40128	0126-0127	AD sampling speed	Range: 0-9, default: 4 0:50; 1:60; 2:100; 3:120; 4:200; 5:240; 6:400; 7:480,000; 8:8,000; 9:960
40129-40130	0128-0129	loadcell signal range	Range: 0-2, default: 1 0:0-5mV; 1:0-10mV; 2:0-15mV
40131 ~ 40200	0130 ~ 0199	Reserve	
Calibration parameter area (readable-writable)			
40201-40202	0200-0201	Unit	Range: 0 to 3, default: 1 0-t, 1-kg, 2-g, 3-lb

40203-40204	0202-0203	Weight decimal point	Range: 0 to 4, default: 0 0-0, 1-0.0, 2-0.00, 3-0.000, 4-0.0000
40205-40206	0204-0205	Division	Range :0 to 8. Default value :0 0-1, 1-2, 2-5, 3-5, 4-20, 5-50, 6-100, 7-200, 8-500
40207-40208	0206-0207	Capacity	Range: 0- division *100000, default: 10000
40209-40210	0208-0209	Reserve	
A scale weight calibration area (readable-writable)			
40211-40212	0210-0211	Automatic zero calibration	Write non-0 data, perform zero calibration operation for the current state. Read: Current millivolts of the loadcell. Fixed: 4 decimal points.
40213-40214	0212-0213	Manual zero calibration	Read the zero millivolts of the last calibration
40215-40216	0214-0215	Weight calibration	Write weight value to complete weight calibration. Read: relative millivolts
40217-40218	0216-0217	Gain weight	The weight of the weight at the time of calibration
40219-40220	0218-0219	Zero calibration	Write 1 to perform zero calibration, read as 0
40221-40222	0220-0221	Gain calibration	Write 1 to calibrate according to the input weight of the weight, read as 0
40223-40224	0222-0223	Reserve	
40225-40226	0224-0225	Loadcell sensitivity calibration	Write using the actual sensitivity of the loadcell for theoretical value calibration, fixed:4 decimal points
40227-40228	0226-0227	Total loadcell range	Write the total loadcell range for theoretical calibration
40229-40230	0228-0229	Theoretical value effective switch	Range: 0-1. 0: Close the theoretical weight calculation, using the last weight calibration results for weight calculation. 1: Turn on the theoretical value calibration calculation and calculate the weight with the theoretical value.
40231-40232	0230-0231	Weight calibration correction factor	Range: 1~1000000,; Default: 100000; The weight calculated by the AD code is multiplied by this factor and divided by 100,000
40233-40234	0232-0233	Proportional calibration displayed weight	When there are no weights, you can calibrate through the material, after manually feeding, enter the weight value shown by the instrument.
40235-40236	0234-0235	Proportional calibration of the actual weight	After manual discharging, weigh the material on a standard scale and then enter the actual weight of the material
40237-40238	0236-0237	Proportional calibration	Write 1 Calibrate according to the displayed weight of the input and the actual weight. Read this as 0
40239-40240	0238-0239	Calibration results	11 Exceeding minimum resolution

			(less than 1 AD code per division)
			10 Weight input exceeding the maximum range
			09 The weight input cannot be zero
			08 Weight calibration less than zero or the previous calibration point (single point calibration weight point below zero)
			07 Positive loadcell overflow during weight calibration (greater than maximum loadcell voltage)
			06 Negative loadcell overflow during weight calibration (less than zero voltage)
			05 Weight calibration is unstable
			04 Positive loadcell overflow at zero calibration (greater than 80% of maximum loadcell voltage)
			03 Negative loadcell overflow during zero calibration (less than 20uv)
			02 Zero calibration is unstable
			01 Calibration success
			00 No operation
40241 ~ 40250	0240 ~ 0249	Reserve	
B Scale weight calibration area (readable-writable)			
40251-40252	0250-0251	Automatic zero calibration	Write non-0 data, zero calibration of the current state. Read: Current millivolts of the loadcell. Fixed: 4 decimal points.
40253-40254	0252-0253	Manual zero calibration	Read out the zero millivolts of the last calibration
40255-40256	0254-0255	Weight calibration	Write the weight value to complete the weight calibration. Read: Relative millivolts
40257-40258	0256-0257	the weight of the weights when calibration	The weight of the weights at the time of calibration
40259-40260	0258-0259	Zero calibration	Write 1 to perform zero calibration, read as 0
40261-40262	0260-0261	Weight calibration	Write 1 according to the input weight of the weight calibration, read as 0
40263-40264	0262-0263	Retain	
40265-40266	0264-0265	Loadcell sensitivity calibration	Write using the actual sensitivity of the loadcell for theoretical value calibration, fixed:4 decimal points
40267-40268	0266-0267	Total loadcell range	Write the total loadcell range for theoretical calibration
40269-40270	0268-0269	Theoretical value effective switch	Range: 0-1. 0: Close the theoretical weight calculation, using the last weight

			calibration results for weight calculation. 1: Turn on the theoretical value calibration and calculate the weight with the theoretical value.
40271-40272	0270-0271	Weight calibration correction factor	Range: 1~1000000. Default: 10000 The weight calculated by the AD code is multiplied by this factor and divided by 100,000.
40273-40274	0272-0273	Proportion displayed weight when calibration	When there is no weight, it can be calibrated by material. After manually feeding, wait for stabilization, then enter the weight value shown by the instrument.
40275-40276	0274-0275	Proportion actual weight when calibration	After manual discharging, weigh the material on a standard scale and then enter the actual weight of the material
40277-40278	0276-0277	Proportion calibration	Write 1 to calibrate according to the displayed weight of the input and the actual weight. Read this as 0
40279-40280	0278-0279	Calibration results	11 Exceeding minimum resolution (less than 1 AD code per division)
			10 Weight input exceeding the maximum range
			09 The weight input cannot be zero
			08 Weight calibration less than zero or the previous calibration point (single point calibration weight value below zero)
			07 Positive loadcell overflow during weight calibration (greater than maximum loadcell voltage)
			06 Negative loadcell overflow during weight calibration (less than zero voltage)
			05 Weight calibration is unstable
			04 Positive loadcell overflow at zero calibration (greater than 80% of maximum loadcell voltage)
			03 Negative loadcell overflow during zero calibration (less than 20uv)
			02 Zero calibration is unstable
01 Successful calibration			
00 No operation			
40281 ~ 40300	0280 ~ 0299	Reserve	
Apply parameters area (readable-writable)			
40301-40302	0300-0301	Working mode	Range: 0-3; Default: 0 0- Standard mode; 1- Host mode; 2- Slave mode; 3- Single hopper independent mode

40303-40304	0302-0303	Feed vibrator mode	Range: 0-1; Default: 1 0- Single vibrator mode, 1- Double vibrator mode
40305-40306	0304-0305	Discharge mechanism mode	Range: 0-7; Default: 0 0- Pneumatic discharge; 1- motor rotary discharge; 2- positive and negative motor rotation (dual photoelectric); 3- motor positive and negative rotation (single photoelectric); 4- motor positive and negative rotation (no photoelectric); 5- stepper motor rotation (photoelectric); 6-forward and reverse stepper motor rotation; 7- stepper motor rotation (number of pulses)
40307-40308	0306-0307	Discharge judgment mode	Range: 0-1; Default: 0 0- Time mode, 1-zero zone mode Determine the control condition for closing the discharge gate after completion of discharge.
40309-40310	0308-0309	Time between discharges	Range: 0-10000ms, default: 100ms. After the discharge execution is completed, no new discharge requirements are detected during the discharge interval.
40311-40312	0310-0311	Confirmation delay of discharge status from the machine	Range: 0-10000ms, default: 100ms. The host mode is used to prevent the continuous discharge request when scanning the slave, and the time is used to wait for the complete withdrawal of the discharge status signal from the slave to prevent the abnormal discharge caused by the withdrawal delay
40313-40314	0312-0313	Feeding timeout time	Range: 0-30000ms, default: 0 0- Turn off feed timeout detection When the feeding timeout time is not 0, it means that the feeding monitoring is turned on, the feeding time exceeds the parameter time, the stop alarm (buzzer), the alarm output is effective, and the corresponding marker is effective
40315-40316	0314-0315	Discharge timeout time	Range: 0-30000ms, default: 0 0- Turn off feed timeout detection. When the time of discharge and feeding is not 0, it means that the feeding monitoring is turned on. When the discharging time exceeds the time, the alarm will be stopped.
40317-40318	0316-0317	Dynamic filter switch	Range: 0-1, Default value: 0 (off),
40319-40320	0318-0319	Feed filter level	Range: 0-9, default: 4
40321-40322	0320-0321	wait filter level	Range: 0-9, default: 7

40323-40324	0322-0323	Filter level of discharge	Range: 0-9, default: 3
40325-40326	0324-0325	Start condition for next feeding	Range: 0-1, default: 0. 0: Start immediately after discharging, 1: Start after returning to zero zone after discharging (no judgment is made on the first start)
40327-40328	0326-0327	waiting value mode	Range: 0-2, default: 1 0- wait until stable, 1- wait by time, 2- wait by time and be stable (stable and then go through the waiting time)
40329-40330	0328-0329	Start additional zero times	Range: 0-99, default: 0 If it is 0, start the first packet to zero; When it is not 0, the first package is not zeroed, and the next bag are zeroed.
40331-40332	0330-0331	Zero additional delay	The value ranges from 0ms to 5000ms. Default value: 500ms After delay before feeding if you need to zero, entering this delay, zero after the time is up
40333-40334	0332-0333	Feeding zero timeout time	Range: 1000ms-5000ms, default: 3000ms. Reach (the time + stable time) and it is still not stable, skip zero operation and feeding directly.
40335-40336	0334-0335	Zero failure treatment method	Range: 0-3, default: 1 0- alarm only; 1- alarm, zero next bag ; 2- alarm automatically stops after three consecutive zero failures: 3- alarm, stop immediately
40337-40338	0336-0337	Feed level	Range: 0-1, default: 0. 0: two-level feed, only fast feed and slow feed, 1: three-level feed, there is fast feed, mid feed and slow feed.
40339-40340	0338-0339	A scale small vibrator empty material voltage	Range: 0-5000mV, default: 3500
40341-40342	0340-0341	A scale the large vibrator empty material voltage	Range: 0-5000mV, default: 3500
40343-40344	0342-0343	B Scale small vibrator empty material voltage	Range: 0-5000mV, default: 3500
40345-40346	0344-0345	B scale large vibrator empty material voltage	The value ranges from 0 to 5000mV. Default value: 3500
40347-40348	0346-0347	Zero and feed time	Range: 0-10000ms, default: 2000ms. When emptying the material, fill the material at this time and then discharge the material.
40349-40350	0348-0349	Reserve adaptive switch	Range: 0-1, default: 0. 0: Do not correct the recipe, run strictly according to the recipe parameters. 1:

			Fine-tune the reserve according to the mid feed and slow feed time
40351-40352	0350-0351	Adaptive level	Range: 1-5, default: 2. The smaller the value, the smaller the reserve value to adapt to, the faster speed."
40353-40354	0352-0353	Feeding voltage working mode	Range: 0-1, default: 1 0- Standard mode, slow feed ends then voltage back to 0, 1- pre-boost mode, slow feed ends the voltage does not return to 0, maintain the original value, until the voltage rises back to the first speed voltage when discharging (with fast feed back to fast feed voltage, no fast feed back to the mid feed voltage)
40355-40356	0354-0355	Delay after bag clamping	Range: 0ms-10000ms, default: 500ms
40357-40358	0356-0357	Delay before bag release	Range: 0ms-10000ms, default: 500ms (Compatible with the old mode address, modified is the current formula delay before loosening bag)
40359-40360	0358-0359	Coding delay	Range: 0ms-10000ms, default: 500ms
40361-40362	0360-0361	Code output valid time	Range: 0ms-10000ms, default: 500ms
40363-40364	0362-0363	Valid time without feed and analog switch	Range: 0-1, default: 0. 0: analog run time Parameter :1: analog run directly weigh ok.
40365-40366	0364-0365	Manual loose bag switch	Range: 0-1, default: 0. 0: Automatic loosening bag after discharging :1: manual loosening bag is required after discharging completed before discharging next time.
40367-40368	0366-0367	Manual separate feed switch	Range: 0-1, default: 0. 0: 'fast feed, medium feed and slow feed' are valid when manually fast feeding, 'medium feed and slow feed' are valid when manually mid feed, manual slow time only 'slow' is effective. 1: Manual operation is only effective for each
40369-40370	0368-0369	Number of stepper motor gate opening pulse	Range: 1-100000, default: 1000 The number of open gate pulses when the discharge mechanism is the positive and negative rotation of the stepper motor
40371-40372	0370-0371	Open gate shake time	Range: 0ms-3000ms; Default: 100ms Motor/stepper motor rotary discharge control is used, and the time of origin position signal is not judged after opening the gate
40373-40374	0372-0373	The time of opening the discharging gate	Range: 0-3000ms; Default: 1000ms Discharge mechanism 3 motor positive

			and negative rotation (single photoelectric) or 4 (motor positive and negative rotation without photoelectric) valid for the length of time given by the discharge gate open signal
40375-40376	0374-0375	The closing gate time of the discharging gate	Range: 0-3000ms; Default: 1000ms Discharge mode 4 (motor positive and negative rotation without photoelectric) is valid for the length of time given by the discharge gate closing signal
40377-40378	0376-0377	Discharge motor operating frequency	Range: 100-100000HZ; Default: 2000HZ
40379-40380	0378-0379	Discharge motor start frequency	Range: 100-100000HZ; Default: 200HZ The frequency at which the motor starts
40381-40382	0380-0381	Acceleration time of the discharging motor	Range: 0-10000ms, default: 100ms The time of acceleration from the starting frequency to the running frequency when the motor is running
40383-40384	0382-0383	waiting weight hold switch	Range: 0-1, default: 1 (the weight stays the same after the scale is done and does not refresh the weight until the discharging is complete)
40385 ~ 40390	0384 - 0389	Reserve	
40391-40392	0390-0391	Advance feed delay after closing gate	Range: 0-3000, default: 0 If it is not 0, start the delay when closing the gate. After the delay time, do not judge that the discharge gate has been in place, and directly proceed to the next step in order to improve the speed. The discharge mechanism is invalid under the pneumatic mode
40393-40394	0392-0393	Separate feed switch	Range: 0-1, default: 0; 0: fast feed, mid feed, slow feed signal output is effective when fast feeding; mid feed, slow feed signal output is effective when mid feeding . 1: only fast feed signal output is effective when fast feeding, only mid feed signal output is effective when mid feed, only slow feed signal output is effective when slow feeding
40395-40396	0394-0395	Analog mode	Range: 0-3, default: 0 0:0 ~5V; 1:0 ~10V; 2:4 ~20mA; 3:0 ~24mA;
40397-40398	0396-0397	Belt feeding frequency conversion time	Range: 0-1000ms, default: 100ms The time to switch between different frequencies when feeding by belt.
40399-40400	0398-0399	Reserve	

IO definition function address (specific function number definition, see 110612120003 GMC-X802 Standard Operation Instructions IO definition comparison table)			
40401-40402	0400-0401	IN1 function	Write and modify the corresponding port function, read as function code. Default value 1 (run(total))
40403-40404	0402-0403	IN2 function	Write and modify the corresponding port function, read as function code. Default value 3 (e-stop(total))
40405-40406	0404-0405	IN3 function	Write and modify the corresponding port function, read as function code. Default value 4 (allowed discharge(total))
40407-40408	0406-0407	IN4 function	Write and modify the corresponding port function, read as function code. Default value 5 (slave 1 discharge request(total))
40409-40410	0408-0409	IN5 function	Write and modify the corresponding port function, read as function code. Default value 6 (slave discharge status(total))
40411-40412	0410-0411	IN6 function	Write and modify the corresponding port function, read as function code. Default value 9 (clear alarm(total))
40413-40414	0412-0413	IN7 function	Write and modify the corresponding port function, read as function code. Default value 19 (A scale discharge gate closed in place)
40415-40416	0414-0415	IN8 function	Write and modify the corresponding port function, read as function code. Default value 20 (B scale discharge gate closed in place)
40417-40418	0416-0417	IN9 function	Write and modify the corresponding port function, read as function code. Default value 21 (A scale discharge gate open in place)
40419-40420	0418-0419	IN10 function	Write and modify the corresponding port function, read as function code. Default value 22 (B scale discharge gate open in place)
40421-40422	0420-0421	OUT1 function	Write and modify the corresponding port function, read as function code. Default value 1 (run(total))
40423-40424	0422-0423	OUT2 function	Write and modify the corresponding port function, read as function code. Default value 2 (stop(total))
40425-40426	0424-0425	OUT3 function	Write and modify the corresponding port function, read as function code. Default value 3 (weigh ok(total))
40427-40428	0426-0427	OUT4 function	Write and modify the corresponding port function, read as function code. Default value 4 (discharge status(total))
40429-40430	0428-0429	OUT5 function	Write and modify the corresponding

			port function, read as function code. Default value 9 (A scale fast feed)
40431-40432	0430-0431	OUT6 function	Write modify corresponding port function, read as function code. Default value 10 (B scale fast feed)
40433-40434	0432-0433	OUT7 function	Write and modify the corresponding port function, read as function code. Default value 11 (A scale mid feed)
40435-40436	0434-0435	OUT8 function	Write and modify the corresponding port function, read as function code. Default value 12 (B scale mid feed)
40437-40438	0436-0437	OUT9 function	Write and modify the corresponding port function, read as function code. Default value 13 (A scale slow feed)
40439-40440	0438-0439	OUT10 function	Write and modify the corresponding port function, read as function code. Default value 14 (B scale slow feed)
40441-40442	0440-0441	OUT11 function	Write and modify the corresponding port function, read as function code. Default value 17 (A scale over/under)
40443-40444	0442-0443	OUT12 function	Write and modify the corresponding port function, read as function code. Default value 18 (B scale over/under)
40445-40446	0444-0445	OUT13 function	Write and modify the corresponding port function, read as function code. Default value 23 (A scale discharge gate open)
40447-40448	0446-0447	OUT14 function	Write and modify the corresponding port function, read as function code. Default value 24 (B scale discharge gate open)
40449-40450	0448-0449	PW1(PWM) function	Write to modify the corresponding port function, read as a function code. Default value 25 (A scale discharge gate closed)
40451-40452	0450-0451	PW2(PWM) function	Write to modify the corresponding port function, read as a function code. Default value 26 (B scale discharge gate closed)
40453-40454	0452-0453	PW3(PWM) function	Write to modify the corresponding port function, read as a function code. Default value 27 (unloading status of A scale)
40455-40456	0454-0455	PW4(PWM) function	Write to modify the corresponding port function, read as a function code. Default value 28 (B scale discharge status)
40457-40458	0456-0457	PW5(PWM) function	Write to modify the corresponding port function, read as a function code. Default value 29 (A scale feeding/discharging timeout)

40459-40460	0458-0459	PW6(PWM) function	Write to modify the corresponding port function, read as a function code. Default value 30 (B scale feeding/discharging timeout)
40461-40500	0460-0499	Retain	
40501	40500	Defined or not (total clip/loose bag)	Readout is 1 if defined, read out is 0 if not defined
40502	40501	Defined or not (lower level)	Readout is 1 if defined, read out is 0 if not defined
40503 ~ 40600	0502 ~ 0599	Reserve	
40601-40602	0600-0601	Sewing switch	Turn on the sewing machine function Range: 0-1, default: 0 0: off; 1: on.
40603-40604	0602-0603	The shake time when sewing machine starts	Range: 0-30000ms, default: 300ms. To prevent the start of the sewing machine photoelectric jitter resulting in abnormal work of the sewing machine. In the shaking time, the sewing machine photoelectric jitter, but at this time the output of the sewing machine is still valid
40605-40606	0604-0605	Startup delay of the sewing machine	Range: 0-3000ms, default: 500ms. After the start switch of the sewing machine is effective, the delay time of starting the sewing machine
40607-40608	0606-0607	Output time of the sewing machine	Range: 0-30000ms, default value: 4000ms. After the delay time reaches, start the output of the sewing machine and continue to output the output time of the sewing machine
40609-40610	0608-0609	Cutting machine start delay time	Range: 0-30000ms, default: 500ms. After the end of the output time of the sewing machine, start the cutting machine start delay time, and continue the cutting machine start delay time.
40611-40612	0610-0611	Output time of the cutting machine	Range: 0-30000ms, default: 500ms. After the end of the startup delay of the cutter, start the output of the cutter and continue the output time of the cutter
40613-40614	0612-0613	delay before stopping of sewing machine	Range: 0-30000ms, default: 500ms. After the cutting machine is finished, the sewing machine will continue to work, and the sewing machine will stop when the delay before stopping time reaches
40615-40616	0614-0615	Code switch	Enable the coding function. Range: 0-1, default: 0 0: Off; 1: On
40617 ~ 41000	0616 ~ 0999	Reserve	
Formula with feed control parameter area			
41001-41002	1000-1001	Current recipe	Range: 1-20, default: 1. After local

		number	modification, the parameters that follow the recipe number need to be refreshed simultaneously
41003-41004	1002-1003	Target Value	Not set, not allowed to start, if the working mode is single hopper independent, it is the target value of channel 1
41005-41006	1004-1005	B Scale the target value	The target value of B scale and A scale is the same when it is 0. When it is not 0, it is the target value of B scale
41007-41008	1006-1007	A scale small vibrator fast feed analog value	Range: 0-24000, default: 0
41009-41010	1008-1009	A scale small vibrator mid feed analog value	Range: 0-24000, default: 0
41011-41012	1010-1011	A scale small vibrator slow feed analog value	Range: 0-24000, default: 0
41013-41014	1012-1013	A scale large vibrator fast feed analog value	Range: 0-24000, default: 0
41015-41016	1014-1015	A scale large vibrator mid feed analog value	Range: 0-24000, default: 0
41017-41018	1016-1017	A scale large vibrator slow feed analog value	Range: 0-24000, default: 0
41019-41020	1018-1019	A scale fast feed reserve	Weight = stop fast feeding when (target value - fast feed reserve) is reached; Default value: 0
41021-41022	1020-1021	A scale mid feed reserve	Weight = stop mid feeding when (target value - mid feed reserve) is reached; Default value: 0
41023-41024	1022-1023	A scale free fall value	Weight = stop slow feeding when (target value - mid feed reserve) is reached; Default value: 0
41025-41026	1024-1025	A scale fast feed prohibit judgement time	Range: 0-5000ms, default: 500ms
41027-41028	1026-1027	A scale mid feed prohibit judgement time	Range: 0-5000ms, default: 800ms
41029-41030	1028-1029	A scale slow feed prohibit judgement time	Range: 0-5000ms, default: 800ms
41031-41032	1030-1031	B scale small vibrator fast feed analog	Range: 0-24000, default: 0
41033-41034	1032-1033	B scale small vibrator mid feed analog	Range: 0-24000, default: 0

41035-41036	1034-1035	B scale small vibrator slow feed analog	Range: 0-24000, default: 0
41037-41038	1036-1037	B scale large vibrator fast feed analog	Range: 0-24000, default: 0
41039-41040	1038-1039	B scale large vibrator mid feed analog	Range: 0-24000, default: 0
41041-41042	1040-1041	B scale large vibrator slow feed analog	Range: 0-24000, default: 0
41043-41044	1042-1043	B scale fast feed reserve	Weight = (target value - fast feed reserve), stop fast feeding, Default value: 0
41045-41046	1044-1045	B scale mid feed reserve	Weight = (target value - mid feed reserve), stop mid feeding, Default value: 0
41047-41048	1046-1047	B scale free fall	Weight = (target value - slow feed reserve), stop slow feeding, Default value: 0
41049-41050	1048-1049	B scale fast feed prohibit judgement time	Range: 0-5000ms, default: 500ms
41051-41052	1050-1051	B scale mid feed prohibit judgement time	Range: 0-5000ms, default: 800ms
41053-41054	1052-1053	B scale slow feed prohibit judgement time	Range: 0-5000ms, default: 800ms
41055-41056	1054-1055	Reserve	
41057-41058	1056-1057	Delay before feeding	The value ranges from 0 to 5000ms. Default value: 0ms. Each feeding need to go through this delay before starting to check the stability of the zero (if it is turned on), feeding and other processes
41059-41060	01058-1059	Feeding zero interval	Range: 0-99, default: 0. 0: Does not zero before zeroing, 1: zero before each feeding, 2: zero once every 2 bags (interval:1 bag)
41061-41062	01060-1061	wait delay	Range: 0-5000ms, default: 700ms
41063-41064	01062-1063	Overs/under detection	Range: 0-1, default: 0. 0: disables the over/under function. 1: enables the over/under function
41065-41066	01064-1065	Over value	If the weighing value is \geq the target value + the over value, it is judged as over. Default value: 0
41067-41068	01066-1067	Under value	If the Weighing value \geq target value - under value, then judged as under. Default value: 0
41069-41070	01068-1069	Retain	
41071-41072	01070-1071	Over pause switch	Range: 0-1, default: 0. 0: disables the over/under pause function. 1: disables

			the over/under pause function
41073-41074	01072-1073	Over/under error alarm pause time	Range: 0-9000ms, default value: 1000ms, specifies the time when the buzzer rings and the alarm signal output time
41075-41076	01074-1075	Correction range of free fall	Range: 0-3, default: 1. 0: Weak correction(25%), 1: Standard correction(50%); 2: Strong correction (75%); 3: Full correction (100%).
41077-41078	01076-1077	Free Fall correction reference times	Range: 0-99, default: 0. 0 indicates that the drop correction is turned off, and non-0 indicates how many times the instrument is weighed as a reference for the free fall correction to correct the free fall.
41079-41080	01078-1079	Free Fall correction range	Range: 0-100%, Default: 0, target value percentage. When the parameter is 0, no matter how much the deviation is corrected, otherwise the deviation value exceeds the target value * the percent of this parameter, it is considered that the mechanism is abnormal, and the free fall is not corrected
41081-41082	01080-1081	Maximum Material compensation time	Range: 0-10000ms, default: 3000ms. When feeding, if the material compensation time exceeds the value and still does not complete the material compensation , then stop the material compensation Condition of stopping material compensation: the weight reaches the target value, or the material compensation time exceeds this parameter"
41083-41084	01082-1083	Minimum feeding time	Range: 0 to 3000ms. Default value: 0ms. 0 indicates that the feeding function is disabled. Since there is some vibrator starting time of the vibrator feeding, this parameter specifies the minimum material compensation time, that is, the feeding time can not be less than this time after the material compensation start
41085-41086	01084-1085	Inching feed switch	Range: 0-1, default value: 0, after opening, the minimum feeding time is performed, until the target value is reached after the stop feeding
41087-41088	01086-1087	discharging delay	Range: 0-5000ms, default: 300ms. When discharging mode is 2, 3, 4, 6, if it is zero zone judgment, then reach the zero zone delay time and then give the motor reversal signal, if it is time judgment mode, then after the discharging

			gate open signal is closed, delay this parameter time, start to give the motor reversal signal (close the gate). When discharging mode 0, if it is a zero zone judgment, the gate is effective after reaching the zero zone, delay the time to open the gate is invalid, if it is a time determination mode, delay the time to open the gate after the effective time is invalid."
41089-41090	1088-1089	Zone Zero value	Range: 0 to the target value, default value: 0, when the discharging determination mode is zero zone mode, when the discharging weight is less than zero zone, it indicates that the discharging is completed, and the discharging gate is closed.
41091-41092	1090-1091	Discharge times	Range: 1-9, default: 1. Control how many times to rotate the motor rotation mode to complete the discharge (only valid if the discharge mode is the motor/stepper motor rotation mode)
41093-41094	1092-1093	Automatic zero threshold for the first start	Range: 0-100%, percentage of target value. When the parameter is 0, the first start is not zero. When the weight in the hopper is less than the target value * this value, the condition of starting zero is met.
41095-41096	1094-1095	The number of multi-hopper combination scale bags	Range: 1-99, default: 1. When the value is greater than 1, it means that the multi-hopper combination scale can be discharge at the same time.
41097-41098	1096-1097	Fast feed custom ports	Range :0 to 2, default :0. 0: overtime custom feed 1 is valid when fast feed; 1: custom feed 2 is valid when mid feed; 2: custom feed 1 and custom feed 2 both valid when mid feed
41099-41100	1098-1099	Mid feed custom ports	Range :0 to 2, default :1. 0: custom feed 1 is valid when mid feeding; 1: custom feed 2 is valid when mid feeding; 2: custom feed 1 and custom feed 2 both valid when mid feed
41101-41102	1100-1101	Delay before loosening the bag	Range: 0-10000ms, default: 500ms.
41103-41104	1102-1103	A scale small belt fast feed frequency	Range: 0-60000, default: 0
41105-41106	1104-1105	A scale small belt mid feed frequency	Used for belt feeding, the output defines "A scale: feeding small belt pulse ", and the IO module outputs the pulse of the corresponding frequency when feeding.
41107-41108	1106-1107	A scale small belt	it is the base of 100 when modifying.

		slow feed frequency	
41109-41110	1108-1109	A scale large belt and fast feed frequency	Range: 0-60000, default: 0 Used for belt feeding, the output defines "A scale: feeding large belt pulse ", and the IO module outputs the pulse of the corresponding frequency when feeding. It is the base of 100 when modifying.
41111-41112	1110-1111	A scale large belt mid feed frequency	
41113-41114	1112-1113	A scale large belt slow feed frequency	
41115-41116	1114-1115	B scale small belt fast feed frequency	Range: 0-60000, default: 0 Used for belt feeding, the output defines "B scale: feeding small belt pulse ", the IO module outputs the pulse of the corresponding frequency when feeding. It is the base of 100 when modifying.
41117-41118	1116-1117	B scale small belt mid feed frequency	
41119-41120	1118-1119	B scale small belt slow feed frequency	
41121-41122	1120-1121	B scale large belt fast feed frequency	Range: 0-60000, default value: 0, Used for belt feeding, the output defines "B scale: feeding large belt pulse ", the IO module outputs the pulse of the corresponding frequency when feeding . It is the base of 100 when modifying.
41123-41124	1122-1123	B scale large belt mid feed frequency	
41125-41126	1124-1125	B scale large belt slow add frequency	
41127 ~ 41128	1126 ~ 1127	the motor group ID used in the current recipe	Range: 0 to 4, default: 0.
41129 ~ 41300	1128 ~ 1299	Reserve	
41301-41302	1300-1301	Source recipe number	/
41303-41304	1302-1303	Target recipe number	/
41305-41306	1304-1305	Perform copy operation	/
41307-41308	1306-1307	Copy current recipe channel parameters, from A scale to B scale	/
41309-41310	1308-1309	Copy current formula channel parameters, from B scale to A scale	/
41311-41312	1310-1311	Batches	/
41313-41314	1312-1313	Accumulative batches	/
41315-41316	1314-1315	Accumulative batches weight	/
41317 ~ 41400	1316 ~ 1399	Reserve	
Target values and cumulative values for each recipe (read only)			
41401-41402	1400-1401	Recipe 1 Target value	/
41403-41404	1402-1403	Recipe 2 Target	/

		value	
41405-41406	1404-1405	Formula 3 Target value	/
41407-41408	1406-1407	Recipe 4 Target value	/
41409-41410	1408-1409	Recipe 5 Target value	/
41411-41412	1410-1411	Recipe 6 Target value	/
41413-41414	1412-1413	Recipe 7 Target value	/
41415-41416	1414-1415	Recipe 8 Target value	/
41417-41418	1416-1417	Recipe 9 Target value	/
41419-41420	1418-1419	Recipe 10 Target value	/
41421-41422	1420-1421	Recipe 11 Target value	/
41423-41424	1422-1423	Recipe 12 Target value	/
41425-41426	1424-1425	Recipe 13 Target value	/
41427-41428	1426-1427	Recipe 14 Target value	/
41429-41430	1428-1429	Recipe 15 Target value	/
41431-41432	1430-1431	Formula 16 target value	/
41433-41434	1432-1433	Recipe 17 Target value	/
41435-41436	1434-1435	Recipe 18 Target value	/
41437-41438	1436-1437	Recipe 19 Target value	/
41439-41440	1438-1439	Formula 20 Target value	/
41441-41442	1440-1441	Formula 1 A scale cumulative weight	Currently read only cumulative low byte, maximum value to 999999999, and then increase overflow starting from 0.
41443-41444	1442-1443	Formula 1 A scale cumulative times	
41445-41446	1444-1445	Formula 1 B scale cumulative weight	
41447-41448	1446-1447	Formula 1 B scale cumulative weight	
41449-41450	1448-1449	Formula 2 A scale cumulative weight	
41451-41452	1450-1451	Formula 2 A scale cumulative times	
41453-41454	1452-1453	Formula 2 B scale cumulative weight	

41455-41456	1454-1455	Formula 2 B scale cumulative times
41457-41458	1456-1457	Formula 3 A scale cumulative weight
41459-41460	1458-1459	Formula 3 A scale cumulative times
41461-41462	1460-1461	Formula 3 B scale cumulative weight
41463-41464	1462-1463	Formula 3 B scale cumulative times
41465-41466	1464-1465	Formula 4 A scales cumulative weight
41467-41468	1466-1467	Formula 4 A scale cumulative times
41469-41470	1468-1469	Formula 4 B scale cumulative weight
41471-41472	1470-1471	Formula 4 B scale cumulative times
41473-41474	1472-1473	Formula 5 A scale cumulative weight
41475-41476	1474-1475	Formula 5 A scale cumulative times
41477-41478	1476-1477	Formula 5 B scale cumulative weight
41479-41480	1478-1479	Formula 5 B scale cumulative weight
41481-41482	1480-1481	Formula 6 A scale cumulative weight
41483-41484	1482-1483	Formula 6 A scale cumulative times
41485-41486	1484-1485	Formula 6 B scale cumulative weight
41487-41488	1486-1487	Formula 6 B scale cumulative times
41489-41490	1488-1489	Formula 7 A scale cumulative weight
41491-41492	1490-1491	Formula 7 A scale cumulative times
41493-41494	1492-1493	Formula 7 B scale cumulative weight
41495-41496	1494-1495	Formula 7 B scale cumulative times
41497-41498	1496-1497	Formula 8 A scale cumulative weight
41499-41500	1498-1499	Formula 8 A scale cumulative times
41501-41502	1500-1501	Formula 8 B scale cumulative weight
41503-41504	1502-1503	Formula 8 B scale cumulative times
41505-41506	1504-1505	Formula 9 A scale

		cumulative weight
41507-41508	1506-1507	Formula 9 A scale cumulative times
41509-41510	1508-1509	Formula 9 B scale cumulative weight
41511-41512	1510-1511	Formula 9 B scale cumulative times
41513-41514	1512-1513	Formula 10 A scale cumulative weight
41515-41516	1514-1515	Formula 10 A scale cumulative times
41517-41518	1516-1517	Formula 10 B scale cumulative weight
41519-41520	1518-1519	Formula 10 B scale cumulative times
41521-41522	1520-1521	Formula 11 A scale cumulative weight
41523-41524	1522-1523	Formula 11 A scale cumulative times
41525-41526	1524-1525	Formula 11 B scale cumulative weight
41527-41528	1526-1527	Formula 11 B scale cumulative weight
41529-41530	1528-1529	Formula 12 A scale cumulative weight
41531-41532	1530-1531	Formula 12 A scale cumulative times
41533-41534	1532-1533	Formula 12 B scale cumulative weight
41535-41536	1534-1535	Formula 12 B scale cumulative times
41537-41538	1536-1537	Formula 13 A scale cumulative weight
41539-41540	1538-1539	Formula 13 A scale cumulative times
41541-41542	1540-1541	Formula 13 B scale cumulative weight
41543-41544	1542-1543	Formula 13 B scale cumulative times
41545-41546	1544-1545	Formula 14 A scale cumulative weight
41547-41548	1546-1547	Formula 14 A scale cumulative times
41549-41550	1548-1549	Formula 14 B scale cumulative weight
41551-41552	1550-1551	Formula 14 B scale cumulative times
41553-41554	1552-1553	Formula 15 A scale cumulative weight
41555-41556	1554-1555	Formula 15 A scale cumulative times

41557-41558	1556-1557	Formula 15 B scale cumulative weight	
41559-41560	1558-1559	Formula 15 B scale cumulative times	
41561-41562	1560-1561	Formula 16 A scale cumulative weight	
41563-41564	1562-1563	Formula 16A scale cumulative times	
41565-41566	1564-1565	Formula 16 B scales cumulative weight	
41567-41568	1566-1567	Formula 16 B scale cumulative times	
41569-41570	1568-1569	Formula 17 A scales cumulative weight	
41571-41572	1570-1571	Formula 17A scales cumulative times	
41573-41574	1572-1573	Formula 17 B scales cumulative weight	
41575-41576	1574-1575	Formula 17 B scale cumulative times	
41577-41578	1576-1577	Formula 18 A scales cumulative weight	
41579-41580	1578-1579	Formula 18A weighs cumulative times	
41581-41582	1580-1581	Formula 18 B scales cumulative weight	
41583-41584	1582-1583	Formula 18 B scale cumulative times	
41585-41586	1584-1585	Formula 19 A scales cumulative weight	
41587-41588	1586-1587	Formula 19A scales cumulative times	
41589-41590	1588-1589	Formula 19 B scale cumulative weight	
41591-41592	1590-1591	Formula 19 B scale cumulative times	
41593-41594	1592-1593	Formula 20 A scales cumulative weight	
41595-41596	1594-1595	Formula 20A scales cumulative times	
41597-41598	1596-1597	Formula 20 B scales cumulative weight	
41599-41600	1598-1599	Formula 20 B scale cumulative times	
41601-41602	1600-1601	Total cumulative weight high byte	/
41603-41604	1602-1603	Total cumulative weight low byte	/
41605-41606	1604-1605	Total cumulative batches high byte	/
41607-41608	1606-1607	Total cumulative	/

		batches low byte	
41609-41610	1608-1609	A scale total cumulative weight high byte	/
41611-41612	1610-1611	A scale total cumulative weight low byte	/
41613-41614	1612-1613	A scale total cumulative batches high byte	/
41615-41616	1614-1615	A scale total cumulative batches low byte	/
41617-41618	1616-1617	B scale total cumulated weight high byte	/
41619-41620	1618-1619	B scale total cumulated weight low byte	/
41621-41622	1620-1621	B scale total cumulated batches high byte	/
41623-41624	1622-1623	B scale total cumulated batches low byte	/
41625-41626	1624-1625	Formula 1 B scale target value	/
41627-41628	1626-1627	Formula 2 B scale target value	/
41629-41630	1628-1629	Formula 3 B scale target value	/
41631-41632	1630-1631	Formula 4 B scale target value	/
41633-41634	1632-1633	Formula 5 B scale target value	/
41635-41636	1634-1635	Formula 6 B scale target value	/
41637-41638	1636-1637	Formula 7 B scale target value	/
41639-41640	1638-1639	Formula 8 B scale target value	/
41641-41642	1640-1641	Formula 9 B scale target value	/
41643-41644	1642-1643	Formula 10 B scale target value	/
41645-41646	1644-1645	Formula 11 B scale target value	/
41647-41648	1646-1647	Formula 12 B scale target value	/
41649-41650	1648-1649	Formula 13 B scale target value	/
41651-41652	1650-1651	Formula 14 B scale target value	/
41653-41654	1652-1653	Formula 15 B scale	/

		target value	
41655-41656	1654-1655	Formula 16 B scale target value	/
41657-41658	1656-1657	Formula 17 B scale target value	/
41659-41660	1658-1659	Formula 18 B scale target value	/
41661-41662	1660-1661	Formula 19 B scale target value	/
41663-41664	1662-1663	Formula 20 B scale target value	/
41665 ~ 42000	1664 ~ 1999	Reserve	
42001-42002	2000-2001	A scale fast feed time	When starting again after stopping, wait for the next fast feed to complete the update, which is 0 when powered on
42003-42004	2002-2003	A scale mid feed time	When starting again after stopping, wait for the next fast/mid feed to complete the update, and it is 0 when powered on
42005-42006	2004-2005	A scale slow feed time	When starting again after stopping, wait for the next fast/mid/slow feed to complete the update, which is 0 when powered on
42007-42008	2006-2007	A scale wait time	When the system restarts after stopping, wait for the next waiting value to be updated. The value is 0 when the system is powered on
42009-42010	2008-2009	A scale packaging total time	When starting up again after stopping, wait for the next completion of a packaging completion to update, which is 0 when powered on
42011-42012	2010-2011	A scale weight of previous bag	When starting up again after stopping, wait for the update after the next weighing ok, 0 when powered on
42013-42014	2012-2013	A scale formula number of previous bag	The formula used when the previous bag weight is generated
42015-42016	2014-2015	A scale the target value of the previous bag	The target value used when the previous bag weight is generated
42017-42018	2016-2017	A scale the deviation value of the previous bag	The deviation value between the actual weight and the target value
42019-42020	2018-2019	A scale packaging results sample identification	It is 3 when powered on, change to 2 when stopped after running, and jumps between 0 and 1 when the weight of the previous package generated, which is used for external HMI sample identification

42021-42022	2020-2021	A scale current cumulative over batches	After stopping, starting again or powering on again, the parameter will automatically change to 0 and start recording again
42023-42024	2022-2023	A scale current cumulative under batches	After the system stops, starts again, or powers on again, the parameter automatically changes to 0, and the system starts recording again
42025-42026	2024-2025	A scale current cumulative weight	After stopping, starting again or powering on again, the parameter will automatically change to 0 and start recording again
42027-42028	2026-2027	A scale current cumulative batches	After stopping, starting again or powering on again, the parameter automatically changes to 0 and starts recording again
42029 ~ 42040	2028 ~ 2039	Reserve	
42041-42042	2040-2041	B scale fast feed time	When starting again after stopping, wait for the next fast feed to complete the update, and it is 0 when powered on
42043-42044	2042-2043	B scale mid feed time	When starting again after stopping, wait for the next fast/mid feed to complete the update, and it is 0 when powered on
42045-42046	2044-2045	B scale slow feed time	When starting again after stopping, wait for the next fast/mid/slow feed to complete the update, and it is 0 when powered on
42047-42048	2046-2047	B scale waiting time	When starting again after stopping, wait for the next waiting to complete the update, which is 0 when powered on
42049-42050	2048-2049	B scale packing total time	When starting again after stopping, wait for the next packaging completion to update, which is 0 when powered on
42051-42052	2050-2051	B scale previous bag weight	When starting up again after stopping, wait for the update after the next weighing, 0 when powered on
42053-42054	2052-2053	B scale formula number of previous bag	The formula used when the previous bag weight is generated
42055-42056	2054-2055	B scale the target value of the previous bag	The target value used when the previous bag weight is generated
42057-42058	2056-2057	B scale the deviation value of the previous bag	The deviation value between the actual weight and the target value
42059-42060	2058-2059	B scale packaging results sample identification	It is 3 when powered on, change to 2 when stopped after running, and jumps between 0 and 1 when the weight of the previous package generated, which is used for external HMI sample identification

42061-42062	2060-2061	B scale current cumulative over batches	After stopping, starting again or powering on again, the parameter will automatically change to 0 and start recording again
42063-42064	2062-2063	B scale current cumulative under batches	After the system stops, starts again, or powers on again, the parameter automatically changes to 0, and the system starts recording again
42065-42066	2064-2065	B scale current cumulative weight	After stopping, starting again or powering on again, the parameter will automatically change to 0 and start recording again
42067-42068	2066-2067	B scale current cumulative batches	After stopping, starting again or powering on again, the parameter automatically changes to 0 and starts recording again
42069 ~ 42080	2068 ~ 2079	Reserve	
42081-42082	2080-2081	packaging results acquisition identification (total)	It is 3 when powered on, change to 2 when stopped after running, and jumps between 0 and 1 when the weight of the previous package generated, which is used for external HMI sample identification
42083-42084	2082-2083	Previous bag channel number	when the previous bag weight is generated: 1-A scale, 2-B scale
42085-42086	2084-2085	Previous bag recipe number	The recipe used when the weight of the previous bag is generated
42087-42088	2086-2087	Previous bag target value	The target value used when the weight of previous bag is generated
42089 ~ 44000	2088 ~ 3999	Reserve	
44001 ~ 44002	4000 ~ 4001	Motor group ID used in the current recipe	Range: 0 to 4, default: 0.
44003 ~ 44004	4002 ~ 4003	Reserve	
44005 ~ 44006	4004 ~ 4005	Feed gate closes overtime	Range: 0~99.9s, default: 4.0s.
44007 ~ 44008	4006 ~ 4007	Feed gate in place type	Range: 0 to 1. Default value: 0. 0: in place when the signal is valid; 1: in place when signal is invalid.
44009 ~ 44010	4008 ~ 4009	Generator number	Range: 0 to 4, default value: 0.
44011 ~ 44012	4010 ~ 4011	A scale feeding frequency	Range: 1~65000Hz, default: 12000Hz.
44013 ~ 44014	4012 ~ 4013	A scale feeding slow feed pulse number	Range: 1~999999, default: 1800.
44015 ~ 44016	4014 ~ 4015	A scale feeding mid feed pulse number	Range: 1~999999, default: 4300.
44017 ~ 44018	4016 ~ 4017	A scale feeding fast feed pulse number	Range: 1~999999, default: 7750.

44019 ~ 44020	4018 ~ 4019	A scale feed opening gate direction signal status	Range: 0~1, default: 0; 0: it is the direction of opening gate when the signal is valid; 1: it is the direction of opening gate when the signal is invalid.
44021 ~ 44022	4020 ~ 4021	A scale feed motor start frequency	Range: 1 to 65000Hz. Default value: 2000Hz. (This value is preferably not greater than the feeding frequency)
44023 ~ 44024	4022 ~ 4023	A scale feed motor acceleration time	Acceleration time of feeding motor. Range: 0~9999s, default: 200s.
44025 ~ 44026	4024 ~ 4025	A scale feed motor deceleration time	Deceleration time of feeding motor. Range: 0~9999ms, default: 50ms.
44027 ~ 44028	4026 ~ 4027	A scale power-on back to zero frequency	Range: 1 to 65000Hz, default: 2000 Hz.
44029 ~ 44030	4028 ~ 4029	B scale feed frequency	Range: 1~65000Hz, default: 12000 Hz.
44031 ~ 44032	4030 ~ 4031	B scale feeding slow feed pulse number	Range: 1~999999, default: 1800.
44033 ~ 44034	4032 ~ 4033	B scale feeding mid feed pulse number	Range: 1~999999, default: 4300.
44035 ~ 44036	4034 ~ 4035	B scale feeding fast feed pulse number	Range: 1~999999, default: 7750.
44037 ~ 44038	4036 ~ 4037	B scale feeding gate direction signal status	Range: 0~1, default: 0; 0: open the door when the signal is valid; 1: the direction of opening the door when the signal is invalid.
44039 ~ 44040	4038 ~ 4039	B scale feed motor start frequency	Range: 1~65000Hz, default value: 2000Hz; (This value is preferably not greater than the feeding frequency)
44041 ~ 44042	4040 ~ 4041	B scale feed motor acceleration time	Feed motor acceleration time. Range: 0~9999s, default: 200s.
44043 ~ 44044	4042 ~ 4043	B scale feed motor deceleration time	Feed motor deceleration time. Range: 0~9999ms, default: 50ms.
44045 ~ 44046	4044 ~ 4045	B scale power-on back to zero frequency	Range: 1 to 65000Hz, default: 2000Hz.
44047 ~ 48000	4046 ~ 7999	Reserve	
Communication parameter setting area (readable except annotated ones, uothers are both readable and writable)			
48001	8000	Serial port 1 slave number	Range: 0-99, default: 1
48002	8001	Serial port 1 baud	Range: 0-4, default: 2.

		rate	0:9,600; 1:19,200; 2:38,400; 3:57,600; 4:115,200
48003	8002	Serial port 1 communication protocol	Range: 0-3, default: 0. 0: Modbus/RTU, 1: Modbus/ASCII, 2: continuous transmission, 3: result transmission
48004	8003	Serial port 1 data format	Range: 0-4, default: 1 0:8N1, 1:8E1, 2:8O1, 3:7E1, 4:7O1
48005	8004	Serial port 1 double word mode	Range: 0-1, default: 0. 0: AB-CD, 1: CD-AB
48006	8005	Serial port 1 Send interval	Range: 0-1000ms, default: 5ms This parameter is valid only under the continuous send protocol
48007 ~ 48020	8006 ~ 8019	Serial port 1 reserve address	
48021 ~ 48026	8020 ~ 8025	Serial port 2 relative address	For details, refer to serial port 1
48027 ~ 48040	8026 ~ 8039	Serial port 2 Reserve address	
48041 ~ 48059	8040 ~ 8058	Reserve	
48060	8059	Communication status	Used for synchronous communication, it is 0 when communication was successful, it is 1 after successful communication 2S. (Read only)
48061	8060	Serial Port number	Identifies the serial port number. serial port 1 is read out as 1; and serial port 2 is read out as 2. (Read only)
48062 ~ 48100	8061 ~ 8099	Reserve	
48101	8100	Local IP segment 1	Range: 0-255, default: 192
48102	8101	Local IP segment 2	Range: 0-255, default: 168
48103	8102	Local IP segment 3	Range: 0-255, default: 80
48104	8103	Local IP segment 4	Range: 0-255, default: 125
48105 ~ 48112	8104 ~ 8111	Reserve	
48113	8112	Connect 1 port number	Range: 0-60000, default: 502 0 indicates that the connection is closed
48114	8113	Connect 1 Communication protocol	Range: 0-2, Default: 0, 0:Modbus/TCP,1: continuous transmission,2: result transmission
48115	8114	Connect 1 High and low bytes	The value ranges from 0 to 1. Default value: 0 0:ABCD, 1:CDAB
48116	8115	Connect 1 Send interval	Range: 0-5000ms, default: 10
48117	8116	Connect 2 port numbers	Range: 0-60000, default: 502 0 indicates that the connection is closed
48118	8117	Connection 2 Communication protocol	Range: 0-2, default: 0 0:Modbus/TCP,1: continuous transmission,2: result transmission
48119	8118	Connection 2 High and low bytes	Range: 0-1, default: 0 0:ABCD, 1:CDAB

48120	8119	Connect 2 send interval	Range: 0-5000ms, default: 10
48121	8120	Connect 3 port numbers	The value ranges from 0 to 60000. Default value: 502 0 indicates that the connection is closed
48122	8121	Connection 3 Communication protocol	Range: 0-2, default: 0 0:Modbus/TCP,1: continuous transmission,2: result transmission
48123	8122	Connect 3 High and low bytes	Range: 0-1, default: 0 0:ABCD, 1:CDAB
48124	8123	Connect 3 send interval	Range: 0-5000ms, default: 10
48125	8124	Connect 4 port numbers	Range: 0-60000, default: 502 0 indicates that the connection is closed
48126	8125	Connection 4 communication protocol	Range: 0-2, default: 0 0:Modbus/TCP,1: continuous transmission,2: result transmission
48127	8126	Connection 4 High or low bytes	Range: 0-1, default: 0 0:ABCD, 1:CDAB
48128	8127	Connect 4 Send interval	Range: 0-5000ms, default: 10
48129 ~ 48300	8128 ~ 8299	Reserve	
I/O test parameters			
48301	8300	I/O test mode	Range: 0-1. 0: Exit I/O test mode; 1: Enable the serial port I/O test mode When entering the IO test, the output remains in the original state, and the output static returns to the entry when exiting
48302	8301	Input 1 Test	Read 0 means no input and read 1 means with input. Writing any value is invalid and only works in IO test mode
48303	8302	Input 2 Test	
48304	8303	Input 3 Test	
48305	8304	Input 4 test	
48306	8305	Input 5 Test	
48307	8306	Input 6 Test	
48308	8307	Input 7 Test	
48309	8308	Input 8 Test	
48310	8309	Input 9 Test	
48311	8310	Input 10 Test	
48312 ~ 48350	8311 ~ 8349	Reserve	
48351	8350	Output 1 Test	Write: 0 : turn off output, 1 : turn on output (only valid in IO test mode), read as the current IO port status, 0 : off, 1 : on
48352	8351	Output 2 Test	
48353	8352	Output 3 Test	
48354	8353	Output 4 Test	
48355	8354	Output 5 Test	
48356	8355	Output 6 test	
48357	8356	Output 7 Test	
48358	8357	Output 8 Test	
48359	8358	Output 9 Test	

48360	8359	Output 10 Test	
48361	8360	Output 11 Tests	
48362	8361	Output 12 Test	
48363	8362	Output 13 Test	
48364	8363	Output 14 Test	
48365	8364	Output 15 Test	
48366	8365	Output 16 Test	
48367	8366	Output 17 Test	
48368	8367	Output 18 Test	
48369	8368	Output 19 Test	
48370	8369	Output 20 Test	
48371 ~ 48400	8370 ~ 8399	Reserve	
Function operation class address area (corresponding to coil function), readable-writable			
48601	8600	Start	Write: 1- Start both channels Read: 0- Stop; 1- Run; 2- Slow stop
48602	8601	Stop	Write: 1- Stop after two channels finish discharging Read: 0- Stop; 1- Run; 2- Slow stop
48603	8602	E-stop	Write: 1- Both channels stop the running status immediately Read: 0- Stop; 1- Run; 2- Slow stop
48604	8603	Empty material	Write: 1- two channels start empty material; 0- exit empty material status, Read: 1- emptying material
48605	8604	Clear Alarm	Write: 1- Clear alarm; Read: 1- alarm output; 0- no alarm output
48606	8605	Simulation run	Write: 1- Two channels to start the simulation run Read: 1- Simulation run
48607	8606	Single run	Write: 1- Two channels to start a single run Read: 1- Run status
48608	8607	Save optimal parameters	Write: 1- Save the current as optimal parameters; Read: 0
48609	8608	Restore optimal parameters	Write: 1- Restore to optimal parameters; Read: 0
48610	8609	Clear Accumulations	Write: 1 to 20- Clear the accumulations for the corresponding recipe 0- Clear the current recipe cumulative 21- Clear all recipe accumulations Read: 0
48611	8610	A scale zero	Write: 1- Perform zero; Read: 1- at zero point
48612	8611	B scale zero	Write: 1- Perform zero; Read: 1- at zero point; 0- other
48613	8612	A scale start	Write: 1-A scale start Read: 0- Stop; 1- Run; 2- Slow stop
48614	8613	B scale start	Write: 1-B scale start; Read: 0- Stop; 1- Run; 2- Slow stop

48615	8614	A scale stop	Write: 1-A scale to stop after discharging; Read: 0- Stop; 1- Run; 2- Slow stop
48616	8615	B scale stop	Write: 1-B scale to stop after discharging; Read: 0- Stop; 1- Run; 2- Slow stop
48617	8616	A scale to a slow stop	Write: 1-A scale stop immediately; Read: 0- Stop; 1- Run; 2- Slow stop
48618	8617	B - Slow stop	Write: 1-B scale stop immediately; Read: 0- Stop; 1- Run; 2- Slow stop
48619	8618	A scale empty material	Write: 1-A scale empty material; Read: 1- empty material; 0- Other
48620	8619	B scale empty material	Write: 1-B scale empty material; Read: 1- empty material; 0- Other
48621	8620	A scale manual fast feed	Write: 1-A scale fast feed; Read: 1- Fast feed; 0- Other
48622	8621	B scale manual fast feed	Write: 1-B scale fast feed; Read: 1- Fast feed; 0- Other
48623	8622	A scale manual mid feed	Write: 1-A scale mid feed; Read: 1- feed; 0- Other
48624	8623	B scale manual mid feed	Write: 1-B scale mid feed; Read: 1- feed; 0- Other
48625	8624	A scale manual slow feed	Write: 1-A scale slow feed; Read: 1- Slow feed; 0- Other
48626	8625	B scale manual slow feed	Write: 1-B scale slow add; Read: 1- Slow add; 0- Other
48627	8626	A scale manual discharge	Write: 1-A scale manual discharging; Read: 1- discharging in; 0- Other
48628	8627	B scale manual discharge	Write: 1-B scale manual discharging; Read: 1- discharging; 0- Other
48629	8628	A scale simulation run	Write: 1-A scale starts simulation run; Read: 1- simulation running; 0- Other
48630	8629	B Scale simulation run	Write: 1-B scale start simulation run; Read: 1- simulation running; 0- Other
48631	8630	A scale clear alarm	Write: 1-A scale clear alarm; Read: 1- Alarm; 0- Other
48632	8631	B Scale clear alarm	Write: 1-B scale clear alarm; Read: 1- Alarm; 0- Other
48633	8632	A Scale small vibrator test	Range: 0-24000, after writing the data, the vibrator begins to vibrate according to the corresponding voltage value, and the instrument enters the voltage test mode. Write 0 or give stop, emergency stop command after exit
48634	8633	B Scale small vibrator test	Operate as above A scale
48635	8634	A scale large vibrator test	Range: 0-24000, after writing the data, the vibrator begins to vibrate according to the corresponding analog value, and the instrument enters the voltage test mode. Write 0 or give stop, emergency

			stop command after exit
48636	8635	B Scale large vibrator test	Operate the same as the scale A above
48637	8636	A scale save the optimal parameters	Write: 1-A scale performs save parameters; Read: 0
48638	8637	B scales save optimal parameters	Write: 1-B scale performs save parameters; Read: 0
48639	8638	A scale restores optimal parameters	Write: 1-A scale restores optimal parameters; Read: 0
48640	8639	B Scale restores optimal parameters	Write: 1-B scale restores optimal parameters; Read: 0
48641	8640	A scale single run	Write: 1-A scale starts a single run; Read: 0
48642	8641	B Scale single run	Write: 1-B scale starts a single run; Read: 0
48643	8642	A Scale compensate material test	Write: 1-A scale start to compensate material; Read: 1- compensating material; 0- Other
48644	8643	B Scale compensate material test	Write: 1-B scale start to compensate material ; Read: 1- compensating material; 0- Other
48645	8644	A scale clear cumulative	Write: 1~20- Clear the accumulations for the corresponding recipe 0- Clears the current recipe cumulative 21- Clear all recipe accumulations Read: 0
48646	8645	B Scale clear cumulative	Write: 1~20- Clear the accumulations for the corresponding recipe 0- Clears the current recipe cumulative 21- Clear all recipe accumulations Read: 0
48647	8646	Manual supply material	Write: 1- supply material valid; 0- supply material not valid Read: Return feed status
48648	8647	Clip/loose Bag	Write: 1- Perform clip/loose bag; Read: Return to clip bag status
48649	8648	Clear Total accumulations	Write: 1- Clear total system cumulative; Read: 0
48650	8649	Empty the current recipe voltage	Write: 1- recipe vibrator voltage set to 0; Read: 0
48651	8650	Material level function disabled	Write: 1- Disable material level function Read: Returns to level disabled state, with upper level and lower level invalid when level disabled function is used.
48652	8651	B Scale clip/loose bag	Write 1 to perform the clip/loose bag action and read the return clip/loose bag status
48653	8652	USB parameter export	Write 1 to export all parameters,2 to

			export application parameters,3 to export weight parameters,4 to export communication parameters,5 to export IO parameters,6 to export transmitter parameters,7 to export recipe parameters, read as the exported state
48654	8653	USB parameter import	Write 1 to import all parameters,2 to import application parameters,3 to import weight parameters,4 to import communication parameters,5 to import IO parameters,6 to import transmitter parameters,7 to import recipe parameters, read as imported status
48655	08654	Clear batches accumulations	Write 1 Clear batches cumulative, read returns 0
48655 ~ 48699	08654 ~ 08698	Reserve	
48700	08699	Soft reboot (program reboot)	Write: 1- Restart; No operation allowed when running, read: 0
48701 ~ 48900	08700 ~ 08899	Reserve	
Reset parameters with LOGO configuration area			
48901	8900	Reset all parameters	Write 1 to perform the corresponding reset operation(the reset does not involve communication parameters). Read out are all 0.
48902	8901	Uncalibrated parameters reset	Readable/writable, write 1 Perform an uncalibrated parameter reset.
48903	8902	Calibration parameter reset	Both scale calibration parameters are reset
48904	8903	Application parameter reset	Write 1 resets application parameters except for the IO function, and write 2 resets all application parameters
48905	8904	Recipe parameter reset	Write 0 to reset the current formula parameter content, write 1-20 to reset the corresponding formula parameter, the above two operations no longer reset the formula number. Write 21 to reset all recipe parameters, including the recipe number
48906	8905	Transfer parameters reset	Write 1 Reset transmitter parameters
48907	8906	The I/O function resets	Write 1 resets the input function, write 2 resets the output function, write 3 resets all functions
48908	8907	A scale calibration parameter reset	Write 1 reset, only reset the A-scale calibration parameters
48909	8908	B scale calibration parameters reset	Write 1 reset, only reset B scale calibration parameters
48910	8909	The current formula feeding parameter of scale A is reset	Write 1 Reset feeding parameters (lead, voltage, forbidden time)

48911	8910	B scale current formula feeding parameters reset	Write 1 Reset feeding parameters (lead, voltage, forbidden time)
48912	8911	Reset the feeding parameters of the current recipe	Write 1 Reset the current recipe feed parameters (lead, voltage, forbidden time)
48913	8912	A scale all formula feeding parameters reset	Write 1 to reset all formula feeding parameters of A scale (lead, voltage, forbidden time)
48914	8913	B scale all formula feeding parameters reset	Write 1 to reset all formula feeding parameters of B scale (reserve, voltage, forbidden judge time)
48915	8914	Feed motor parameters reset	Write 1 reset, reset the feed motor parameters
48916 ~ 48920	8915 ~ 8919	Reserve	
48921	8920	Reset results	When the reset is successful, the read is not 0 for 2S. (Read only) 1: reset all parameters; 2: reset uncalibrated content; 3: reset calibration parameters; 4: reset application parameters except IO function; 5: reset all application parameters; 6: reset current recipe parameters; 7: reset formula parameter; 8: reset all formula parameters; 9: reset transfer parameters; 10: reset input definition; 11: reset output definition; 12: reset all definition; 13: reset A scale calibration parameters; 14: reset B scale calibration parameters; 15: reset A scale current formula feeding parameters 16: reset B scale current formula feeding parameters 17: reset current formula feeding parameters 18: reset A scale all formula feeding parameters 19: reset B scale all formula feeding parameters 20: reset feeding motor parameters
48922-48980	8922-8979	Reserve	
48981-48990	8980-8989	Boot logo Characters 1-10 (10 characters)	The sequence corresponds to the 1st to 8th characters of the startup logo , which needs to be written in Ascii code, ranging from 0-9,A-Z,a-z , space, '-', default: GMC-X802cd

48991 ~ 49000	8990 ~ 8999	reserve	
Module system information area (read-only area)			
410001	10000	Software version (high byte)	/
410002	10001	Software version (low byte)	If read is 10000, version:01.00.00
410003	10002	Compile date (high word)	/
410004	10003	Date of compilation (low word)	/
410005 ~ 410017	10004 ~ 10016	instrument serial number characters 1-13	/
410018 ~ 410029	10017 ~ 10028	instrument code characters 1-12	/
410030	10029	Reserve	
410031 ~ 410040	10030 ~ 10039	Meter model characters 1-10	/
410041 ~ 410100	10040 ~ 10099	Reserve	
410101	10100	Network port 0 instrument Mac address segment 1	0-255
410102	10101	Network port 0 instrument Mac address segment 2	0-255
410103	10102	Network port 0 instrument Mac address segment 3	0-255
410104	10103	Network port 0 instrument Mac address segment 4	0-255
410105	10104	Network port 0 instrument Mac address segment 5	0-255
410106	10105	Network port 0 instrument Mac address segment 6	0-255
410107	10106	Network port 1 instrument Mac address segment 1	0-255
410108	10107	Network port 1 instrument Mac address segment 2	0-255
410109	10108	Network port 1 instrument Mac address segment 3	0-255
410110	10109	Network port 1 instrument Mac address segment 4	0-255
410111	10110	Network port 1 instrument Mac address segment 5	0-255
410112	10111	Network port 1 instrument Mac address segment 6	0-255
410113	10112	Bluetooth Mac address segment 1	0-255
410114	10113	Bluetooth Mac address segment 2	0-255
410115	10114	Bluetooth Mac address segment 3	0-255
410116	10115	Bluetooth Mac address segment 4	0-255
410117	10116	Bluetooth Mac address segment 5	0-255

410118	10117	Bluetooth Mac address segment 6	0-255
410119 ~ 410200	10118 ~ 10199	Reserve	
Coil address			
0x00001	00000	Start 1	Write ON (0xFF00) to start, write OFF to stop (0x0000), read 1 is run, 0 is stop (any run is 1)
0x00002	00001	Start 2	Write ON (0xFF00) to start, write OFF to stop (0x0000), read 1 is run, 0 is stop (any run is 1)
0x00003	00002	Stop	Write ON (0xFF00) to stop, write OFF (0x0000) no response, read 1 is run, 0 is stop (any run is 1)
0x00004	00003	E-stop	Write ON (0xFF00) to E-stop, write OFF (0x0000) no response, read 1 is run, 0 is stop (any run is 1)
0x00005	00004	Empty material	Write ON (0xFF00) to start empty material, write OFF (0x0000) to stop empty material, read 1 means empty material, and 0 means not empty material
0x00006	00005	Clear Alarm	Write ON (0xFF00) to clear alarm, write OFF (0x0000) no response, read as 0
0x00007	00006	Simulation Run	Write ON (0xFF00) to start the simulation run, write OFF (0x0000) to stop the simulation run, read out 1 means simulation run, and 0 means non-simulation run
0x00008	00007	Run once	Writing ON (0xFF00) to starts a single run, writing OFF (0x0000) returns an error, reading 1 to run and 0 to stop
0x00009	00008	Save the optimal parameters	Write ON (0xFF00) to save the optimal parameters of the current recipe, write OFF (0x0000) to return an error, read as 0
0x00010	00009	Restore optimal parameters	Write ON (0xFF00) to restore the optimal parameters of the current recipe, write OFF (0x0000) to return an error, read as 0
0x00011	00010	Clear accumulations	Write ON (0xFF00) to clear the current recipe cumulative, write OFF (0x0000) to return an error, read as 0
0x00012	00011	Clear all recipe accumulations	Write ON (0xFF00) to clear all recipe accumulations (excluding total system accumulations), write OFF (0x0000) to return an error, read as 0
0x00013	00012	A Scale zero	Writing ON (0xFF00) to zero channel 1, writing OFF (0x0000) returns an error, and read out is 0
0x00014	00013	B Scale zero	B scale, operate as above
0x00015	00014	A Scale start 1	Write ON (0xFF00) to start channel 1, write OFF (0x0000) to E-stop, read out is 1 means channel 1 to run, and 0 means stop
0x00016	00015	B Scale start 1	B scale, operate as above

0x00017	00016	A Scale start 2	Write ON (0xFF00) channel 1 to start, write OFF(0x0000) to scram, read 1 for channel 1 to run, and 0 for stop
0x00018	00017	B Scale start 2	B scale, operate as above
0x00019	00018	A Scale stop	Writing ON (0xFF00) channel 1 stops, writing OFF (0x0000) returns an error, reading 1 for channel 1 running and 0 for stopping
0x00020	00019	B Scale stop	B scale, operate as above
0x00021	00020	A Scale to stop	Write ON (0xFF00)to e-stop channel 1, write OFF (0x0000) to return an error, read out 1 means channel 1 to run, and 0 means stop
0x00022	00021	B Scale to stop	B scale, operate as above
0x00023	00022	A scale empty material	Write ON (0xFF00) channel 1 to start cleaning, write OFF (0x0000) to stop cleaning, read 1 for channel 1 cleaning and 0 for non-cleaning
0x00024	00023	B scale empty material	B scale, operate as above
0x00025	00024	A scale manual fast feed	Write ON (0xFF00) to make channel 1 to start manual fast feed, write OFF (0x0000) to stop fast flow, read out is 1 means channel 1 fast feed, and 0 means non-fast feed
0x00026	00025	B scale manual fast feed	B scale, operate as above
0x00027	00026	A scale manual feed	Write ON (0xFF00) to make channel 1 to start manual mid feed, write OFF (0x0000) to stop mid feed, read out is 1 means channel 1 mid feed, 0 means non-mid feed
0x00028	00027	B scale manual feed	B scale, operate as above
0x00029	00028	A scale manual slow feed	Write ON (0xFF00) to make channel 1 to start manual slow feed, write OFF (0x0000) to stop slow feed, read out is 1 means channel 1 slow feed, 0 means non-slow feed
0x00030	00029	B scale manual slow feed	B scale, operate as above
0x00027	00026	A scale manual slow feed	Write ON (0xFF00) to make channel 1 to start manual discharge, write OFF (0x0000) to return error, read out 1 means channel 1 discharge, and 0 means non-discharge
0x00028	00027	B scale manual slow feed	B scale, operate as above
0x00029	00028	A Scale manual slow feed	Write ON (0xFF00) to make channel 1 to start simulation run, write OFF (0x0000) to stop simulation run, read out is 1 means channel 1 simulation run, and 0 means non-simulation run

0x00030	00029	B Scale manual slow feed	B scale, operate as above
0x00031	00030	A Scale manual discharge	Write ON (0xFF00) to make channel 1 to clear alarm, write OFF (0x0000) to return error, read as 0
0x00032	00031	B Scale manual discharge	B scale, operate as above
0x00033	00032	A scale simulation run	Write ON (0xFF00) to save channel 1 current formula optimal parameters, write OFF (0x0000) to return an error, read as 0
0x00034	00033	B Scale simulation run	B scale, operate as above
0x00035	00034	A scale clear alarm	Write ON (0xFF00) to restore channel 1 current formula optimal parameter, write OFF (0x0000) to return error, read as 0
0x00036	00035	B scale clear alarm	B scale, operate as above
0x00037	00036	A scale saves optimal parameters	Write ON (0xFF00) to start channel 1 for a single run, write OFF (0x0000) to return an error, read 1 for run and 0 for stop
0x00038	00037	B scale saves optimal parameters	B scale, operate as above
0x00039	00038	A scale restores optimal parameters	Write ON (0xFF00) to start the feed test of channel 1, write OFF (0x0000) to return an error, read out is 1 means replenishing materials, 0 means non-replenishing materials
0x00040	00039	B Scale restores optimal parameters	B scale, operate as above
0x00041	00040	A scale run once	Write ON (0xFF00) to clear the current formula accumulation in channel 1. Write OFF (0x0000) to return an error and read as 0
0x00042	00041	B Scale run once	B scale, operate as above
0x00043	00042	A Scale replenish material test	Write ON (0xFF00) to clear channel 1 All recipes accumulation, write OFF (0x0000) to return an error, read as 0
0x00044	00043	B Scale replenish material test	B scale, operate as above
0x00045	00044	A scale clear current recipe accumulation	Write ON (0xFF00) to make supply material be valid, write OFF (0x0000) or upper level is valid to make supply material invalid. Read return supply material status
0x00046	00045	B Scale clear current recipe accumulation	Write ON (0xFF00) to perform clip/loose bag action, read as clip/loose bag status
0x00047	00046	A Scale clear all recipe accumulations	Write ON (0xFF00) to clear total system accumulations, read returns 0

0x00048	00047	B Scale clear all recipe accumulations	Write ON (0xFF00) to set the recipe vibrator voltage to 0, read to return 0
0x00049	00048	Manual feeding	Write ON (0xFF00) to disable the feed level function, write OFF (0x0000) to undisable, read as disabled state
0x00050	00049	Clip/loose Bag	Write ON (0xFF00) to clip/loose bag action, read as pinch bag status
0x00051	00050	Clear Total Cumulative	Write ON (0xFF00) to start, write OFF to stop (0x0000), read 1 means run, 0 means stop (any run is 1)
0x00052	00051	Clear the current formula voltage	Write ON (0xFF00) to start, write OFF to E-stop (0x0000), read 1 means run, 0 means stop (any run is 1)
0x00053	00052	Disabled Material level function	Write ON (0xFF00) stop, write OFF (0x0000) no response, read 1 means run, 0 means stop (any run is 1)
0x00054	00053	B Scale clip/loose bag	Write ON (0xFF00) emergency stop, write OFF (0x0000) no response, read 1 for run, 0 for stop (any run is 1)
0x00055	00054	Clear batch Accumulations	Write ON (0xFF00) to clear batch accumulation, read as 0
0x00055~ 0x00299	00054 ~ 00298	Reserve	
0x00300	00299	Soft restart	Write ON (0xFF00) to let program restart, no operation allowed when running, read 0
0x00301	00300	Reset all parameters	Writing ON (0XFF00) performs a reset, writing OFF (0x00) returns an error, reading out returns 0.
0x00302	00301	Uncalibrated content reset	Writing ON (0XFF00) performs a reset, writing OFF (0x00) returns an error, and reading out returns 0.
0x00303	00302	Calibration reset	Writing ON (0XFF00) resets both channel calibration parameters, writing OFF (0x00) returns an error, and reading out returns 0.
0x00304	00303	Application parameter reset	Writing ON (0XFF00) resets all application parameters, writing OFF (0x00) returns an error, reading out returns 0.
0x00305	00304	Non-I/O functions Define reset	Writing ON (0XFF00) resets application parameters other than the IO function, writing OFF (0x00) returns an error, and reading out returns 0.
0x00306	00305	I/O function reset	Writing ON (0XFF00) resets the IO function, writing OFF (0x00) returns an error, reading out returns 0.
0x00307	00306	Input port function reset	Writing ON (0XFF00) resets the input port function, writing OFF (0x00) returns an error, and reading out returns 0.
0x00308	00307	Output port function reset	Writing ON (0XFF00) resets the output port

			function, writing OFF (0x00) returns an error, and reading out returns 0.
0x00309	00308	Current recipe feed parameter reset	Write ON (0XFF00) to reset the current recipe feeding parameters (reserve, voltage, forbidden judge time), write OFF (0x00) to return an error, read out to return 0. Note that this operation does not change the recipe number
0x00310	00309	current recipe parameter reset	Writing ON (0XFF00) resets all parameters of the current recipe, writing OFF (0x00) returns an error, reading out returns 0. Note that this action does not change the recipe number
0x00311	00310	Reset all recipe parameters	Writing ON (0XFF00) resets all recipe parameters, writing OFF (0x00) returns an error, reading out returns 0. Note that this operation will reset the recipe number
0x00312	00311	reset transfer parameter	Writing ON (0XFF00) resets transmitter parameters, writing OFF (0x00) returns an error, and reading out returns 0.
0x00313	00312	A scale calibration parameter reset	Write ON (0XFF00) to reset channel 1 calibration parameter, write OFF (0x00) to return error, read out to return 0.
0x00314	00313	B scale calibration parameter reset	Write ON (0XFF00) to reset channel 2 calibration parameters, write OFF (0x00) to return an error, read out to return 0.
0x00315	00314	A Scale resets the current recipe feed parameter	Write ON (0XFF00) to reset channel 1 current formula feeding parameters (reserve, voltage, forbidden judge time), write OFF (0x00) to return error, read out to return 0. Note that this operation does not change the recipe number
0x00316	00315	B Scale resets the current recipe feed parameter	Write ON (0XFF00) to reset the current formula feeding parameters (reserve, voltage, forbidden judge time) in channel 2, write OFF (0x00) to return an error, read out to return 0. Note that this operation does not change the recipe number
0x00317	00316	A balance all formula feeding parameters reset	Write ON (0XFF00) to reset channel 1 All formula feeding parameters (reserve, voltage, forbidden judge time), write OFF (0x00) to return error, read out to return 0. Note that this operation does not change the recipe number
0x00318	00317	B Scale all formula feed parameters reset	Write ON (0XFF00) to reset all formula feeding parameters (reserve, voltage, forbidden judge time) in channel 2, write OFF (0x00) to return error, read out to return 0. Note that this operation does not change the recipe number
0x00319	00318	Feed motor parameters	Write ON (0XFF00) to reset the feed motor parameters, write OFF (0x00) to return an

		reset	error, read out to return 0. Note that this operation does not change the recipe number
0x00320~ 0x00329	00319-00328	Reserved	
0x00330	00329	Reset results	Read out returns 1 when the above reset is successful for 2S
0x00331~ 0x00400	00330-00399	reserve	
0x00401	00400	Enter IN1 status	Read only area 0 : invalid; 1 valid
0x00402	00401	Enter IN2 status	
0x00403	00402	Enter IN3 status	
0x00404	00403	Enter IN4 status	
0x00405	00404	Enter IN5 status	
0x00406	00405	Enter IN6 status	
0x00407	00406	Enter IN7 status	
0x00408	00407	Enter IN8 status	
0x00409	00408	Enter IN9 status	
0x00410	00409	Enter IN10 status	
0x00411~ 0x00450	00410 ~ 00449	Reserve	
0x00451	00450	Output OUT1 status	Read only area Read Return each output status bit 0 : invalid; 1 valid
0x00452	00451	Output OUT2 status	
0x00453	00452	Output OUT3 status	
0x00454	00453	Output OUT4 status	
0x00455	00454	Output OUT5 status	
0x00456	00455	Output OUT6 status	
0x00457	00456	Output OUT7 status	
0x00458	00457	Output OUT8 status	
0x00459	00458	Output OUT9 status	
0x00460	00459	Output OUT10 status	
0x00461	00460	Output OUT11 status	
0x00462	00461	Output OUT12 status	
0x00463	00462	Output OUT13 status	
0x00464	00463	Output OUT14 status	
0x00465	00464	Output PW1 status	
0x00466	00465	Output PW2 status	
0x00467	00466	Output PW3 status	
0x00468	00467	Output PW4 status	
0x00469	00468	Output PW5 status	
0x00470	00469	Output PW6 status	
0x00471~ 0x00800	00470 ~ 00799	Reserve	

5.2 Continuous Sending Protocol

Data frame Format description:

Start character	A Scale weight status	A scale charging status	A scale weight	B Balance weight status	B scale feeding status	B Scale weight	Check-sum	Terminator
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◆ Start character - 1 bit, 40H

◆ Weight status - 1 position, A scale /B scale weight status

D7	D6	D5	D4	D3	D2	D1	D0
	Is 0 (unchanged)	1-AD failure 0 - Normal	1 - over range 0 - Normal	1 - Negative overflow 0 - Normal	1 - Positive overflow 0 - normal	1 - zero 0 -non-zero	1- Stable 0- Unstable

◆ Feeding state - 2, A scale /B scale feeding state: state 0; Status 1

State **0**:

D7	D6	D5	D4	D3	D2	D1	D0
	Is 0 (unchanged)	1- Weigh ok 0 - Normal	1- Replenishing materials 0 - Not	1- feed completed 0 - Not	01 - Slow feed 10: Mid feed 11: Fast feed		1- Before feeding 0- not

Status **1**:

D7	D6	D5	D4	D3	D2	D1	D0
	Be 0 (unchanged)	00: Stop 01: Run 10: empty material 11: Vibration plate test		1 -IO test 0 - not	1- under 0- not	1- over 0- not	1-discharge 0- Not

◆ Weight -- 8 bits, A scale /B scale weight; Contains symbol and decimal point, blank supplement is 20H

◆ Checksum - 2 digits, standard CRC

◆ Terminator - 2 digits: 0D 0A

If sending data:

40 01 00 00 20 20 20 20 2B 31 36 32 01 00 00 20 20 20 20 2B 33 31 32 02 C7 0D 0A

Then it means that the scale A is stable and stopped, and the weight is +1632; scale B is stable and stopped, with a weight of +312.

5.3 Result sending mode

When the serial port communication protocol is selected as "result sending" (that is, when the address of 48003 and 48023 is selected as "3"), each scale is sent once (weigh ok status is valid). If another scale is completed during the sending process of a scale, the results of another scale need to be sent after the end of the sending interval "continuous sending time interval".

Data frame format description:

Start character	A scale status	A Scale result serial number	A Scale weight	B balance state	B Scale result serial number	B Scale weight	Check-sum	Terminator
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◆ Start character - 1 bit, 40H

◆ Status - 1 digit, A scale /B scale weight result status

O: over; U: unde; Q: qualified; F: feeding

- ◆ Result sequence number - 1 digit, +1 for each completion, only add 1 after this channel completes a feeding, only related to whether the fixed weight packing process of this channel is completed.
- ◆ Weight -- 8 digits, A scale /B scale weight; Contains symbol and decimal point, blank supplement for 20H