

Control instructions for feeding systems

- Storage and dosing bunkers
- Vibratory feeder
- Linear vibratory conveyor
- *... control properly*

sorting...

feeding...

seperate...

check...

mount...

mechanize...

automate...

... is our thing!



Control instructions for feeding systems



To ensure that the feed components function properly, the following instructions must be observed in order to avoid subsequent faults:

- ⇒ *The feeding component may only be switched on if the following discharging component is switched on to discharge the material to be conveyed*
- ⇒ *Die The feeding component may also only be switched on when the maximum fill level query of the following discharging component reports "free".*
- ⇒ *It must be ensured that the maximum fill level query of the downstream storage section is aligned in such a way that the query signal between two adjacent conveyed components is not released or the query flickers.*
- ⇒ *On the PLC (or in the case of linked control units), lead times and run-on times for the sensor input of the level request must be set up separately.*
- ⇒ **Lead time: The time from when the level request becomes free until the vibratory bowl feeder is switched on.**
If this time is chosen too short, the vibratory bowl feeder switches on the filling level request immediately (even if there is a short flickering). With increasing runtime, this can lead to the parts backing up into the vibratory bowl feeder. If this time is chosen too long, the accumulation route becomes increasingly empty with increasing running time and the delivery capacity may be reduced. no longer achieved.
Recommendation: approx 1 – 3 seconds, the optimal lead times must be determined individually.
- ⇒ **Follow-up time: Time from filling level request to switching off the vibratory bowl feeder.**
If this time is chosen too short, the vibratory bowl feeder switches off for a single part that is conveyed past the query and may reach no longer its performance. If this time is chosen too long, the parts may back into the vibratory bowl feeder.
Recommendation: approx 1 – 3 seconds, the optimal lead times must be determined individually.
- ⇒ *When linking several feed components (storage bunker, spiral conveyor, accumulation section), the activation sequence depending on the fill levels must be observed.*