**To Setup a belt sorter in Experior**

1. Build the sorter using Belt sorter components only. Use Belt conveyors for all straight sections and delete the Line Release photocell from each.

2. At the beginning of the sorter an Induct belt should be used (with photocell). Main Induct Point

3. On the induct conveyor set the conveyor speed and the window size

4. Straight conveyor section on the belt sorter set the correct conveyor speed

5. On all other induct points (Angled or popup) set the conveyor speed and select the Main Induct Point.

6. On the main induct point insert a load with an identification of “teach1” and let the load run past each induct point. This will set-up the “Main Induct Time” on each merge point.

7. On each induct insert a load with an identification of “teach2” and let the load run until the merge point. This will set-up the “This Induct Time” on the induct.

8. When both teach1 and teach2 are complete then each merge will have an “Offset Timer” setup, this will tell the induct it is in relation to the main induct windows and release the loads into the correct part of the window at that specific induct

9. Lastly induct a load at the main induct point with an identification of “teach3” this will insert check photocells into the model at each induct point. This photocell is used by the induct to ensure the window is clear before releasing a load into the sorter.

10. Set each diverts control properties to diverts correctly

11. Set each merge Control Type to Local