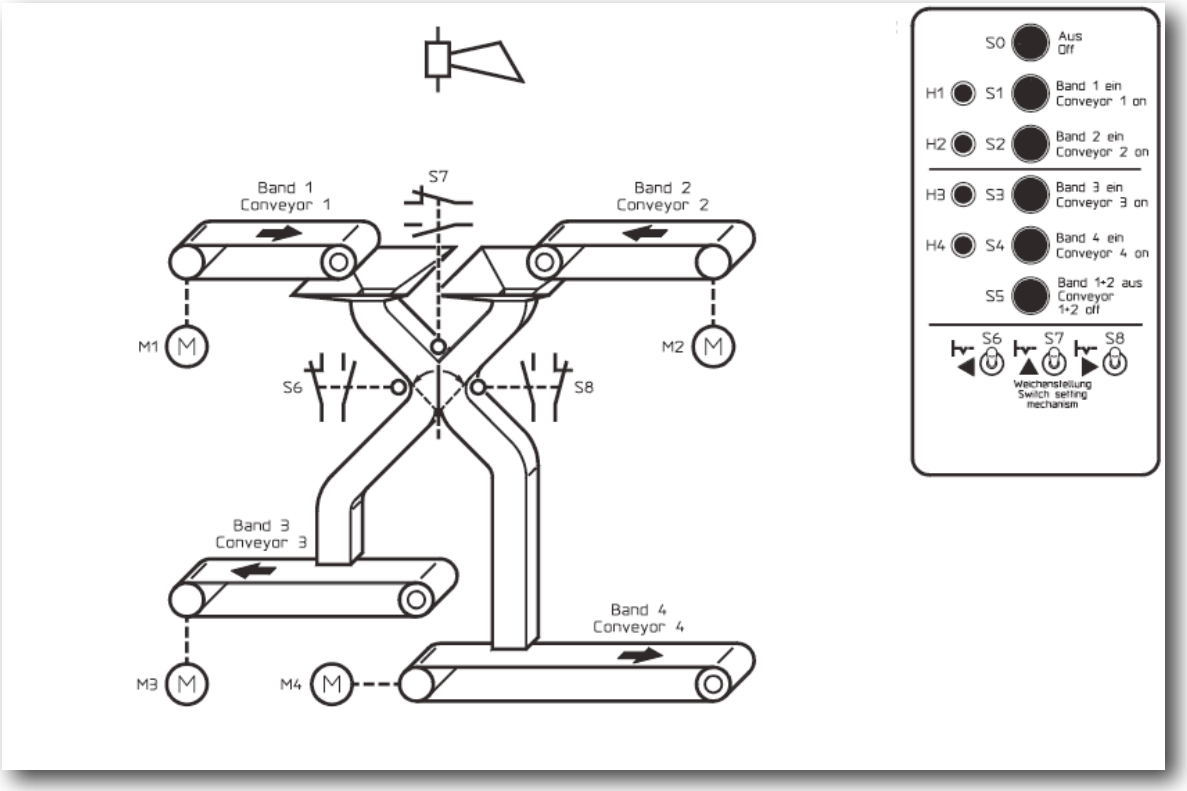
2.23 Belt loading system (M23)

- **Process mask**



- **Presentation**

Two conveyor belts (1 and 2) bring materials that must be transferred to two exit belts (3 and 4). An intersection point has been designed into the system so that materials from any of the input lanes can be transferred to any of the output lanes. Each of the bands can be turned on individually. The operating status of the strips is indicated by the P1, P2, P3 and P4 marking lamps. All bands must be stopped simultaneously when pressing the S0 button; The input lanes must be stopped simultaneously when the S5 button is pressed.

- **Functional description 1**

Only one of the input lanes can work and only if the corresponding output lane (depending on the position of the selection flap at the intersection point) is switched on. The valve position is simulated by the corresponding switching of switches S6, S7 and S8

- **Functional description 2**

Unlike the behavior from functional description 1, both input bands can be turned on simultaneously, if the position of the selector valve allows (S7 - middle) and if the output bands are also simultaneously turned on. In addition, due to the environment in which the system operates, it is assumed that the valve position can sometimes be incorrectly determined (sensors blocked by impurities) and therefore the condition of the valve must be monitored: if 2 sensors are activated simultaneously, the system stops and an alarm sounds for 5 seconds .