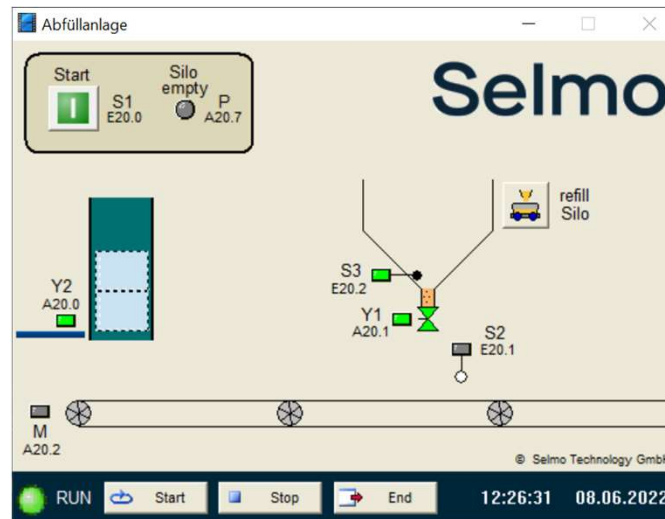


- Model Filling Line



Boris

- Functional Description

The automatic filling sequence is started via switch S1.

Via an impulse at the release output Y2, an empty container is transferred from the drop magazine to the conveyor belt, which is driven by motor M. The conveyor belt is then moved to the next level.

If the container is under the silo, sensor S2 supplies a logical on signal and the belt stops. Opening valve Y1, the container is then to be filled for 3 seconds. The belt then starts again and a new empty container is placed on the belt. Sensor S3 supplies an on signal when the silo is no longer sufficiently filled. In this case, the belt should stop and the warning lamp P should light up. The silo can be filled up by pressing the filling button on the right side of the silo. After the system has been switched off, the belt should continue to run for another 3 seconds in order to remove any remaining containers.

In/Output assignment

The in- and outputs of the model are assigned as follows (the designation input or output refers to the connected controller):

Input Nr.	Boris	PLC-Variable name	Specification
1	S1	I_S1 :BOOL;	On/off Switch
2	S2	I_S2 :BOOL;	Sensor container under Silo(closer)
3	S3	I_S3 :BOOL;	Sensor Silo empty (closer)
Output Nr.	Boris	PLC-Variable name	Specification
1	Y1	O_Y1 :BOOL;	Silo valve dosing
2	Y2	O_Y2 :BOOL;	Release flap container
3	M	O_M :BOOL;	Motor conveyor
4	P	O_P :BOOL;	Warning lamp silo empty