

Quote:

Customer:

By:

Date:

System Operation:

System operates on a keep-full basis pending the material level in the destination hopper using the high level indicator with an off-time delay for restarting. The destination airlock will only be controlled by a remote start/stop panel.

Startup Sequence:

- 1) Silo vent filter starts
- 2) Fill valve is diverted in thru position
- 3) Blower is started
- 4) Time delay (15 seconds) to allow blower to reach operating speed
- 5) Fill valve is diverted to divert position
- 6) The source airlock starts

Conveying Operation:

Material will be conveyed until either the operator presses the stop button or a high level indication is received from the destination hopper. If high level is reached the following sequence occurs:

- 1) Source airlock is stopped
- 2) Time delay (15 seconds) to allow convey line to purge
- 3) The fill valve diverts to thru position
- 4) Time delay (15 seconds) to allow return line to purge
- 5) Initiate an Off-Time delay (30 seconds) to allow material to drop below level indicator
  - a. If material drops below level indicator and off-time has expired, system will restart (see startup sequence #5)
  - b. If hopper remains full or if off-time has not expired, system will be inhibited (see below)

Inhibit Function:

When inhibit mode the system will remain on for a set time (Inhibit Run Time = 5 minutes) but no conveying will take place. The blower and silo vent filter will run, but the source and destination airlocks will be stopped and the fill valve will be diverted to the thru position. This reduces the starting and stopping of the blower. If no call for material is received during the inhibit run time, the system will completely shut down. If a call for material is received during the inhibit time or after a shutdown, the system will restart automatically.

Shut Down Sequence:

- 1) Source airlock is stopped
- 2) Time delay (15 seconds) to allow convey line to purge
- 3) The fill valve diverts to thru position
- 4) Time delay (15 seconds) to allow return line to purge
- 5) The blower is stopped
- 6) The silo vent filter is stopped

Destination Airlock:

The destination airlock will have a remote Start/Stop panel located near the tote loading station.

- The operator can Start the airlock to discharge material
- Or
- Stop the airlock when operation is completed

Purge:

The Purge button allows system to run without the feeding airlock energized to clear the convey line. It only operates manually while the operator depresses the button, once the button is released the system components stop. When the purge is initiated the hopper fill pass valve will be located in the thru position. Also, the silo vent filter will run when the purge feature is initiated.

Remote Truck Unload Start/Stop Panel:

This panel allows the truck operator to start and stop the silo vent filter. It will have a pilot indicating the status of the silo's high level indicator.