

### “FILL” TIME:

Although this term may not appear on all controls, it is helpful to use for understanding the vacuum-on time of an individual receiver. The *total* vacuum-on time of a receiver (the length of time the vacuum sequencing TEE valve is open) can be referred to as FILL time. All functions that happen while the vacuum TEE valve is open (regrind proportioning, pocket conveying, purging, etc) is all part of the FILL time.

### “LOAD” TIME:

The vacuum time that a receiver uses to introduce material into a material conveying line is LOAD time. The term may be thought of as ‘loading the material line’. This term is important to understand with purging systems to distinguish between the time the purge (or pocket) valve is *opened* (LOAD time) compared to the time it is closed (PURGE time). On systems that have no pocket or purge valves, LOAD time equals FILL time. On systems with pocket or purge valves, LOAD time is just the *first part* of the FILL time. Purge time is the conclusion of FILL time.

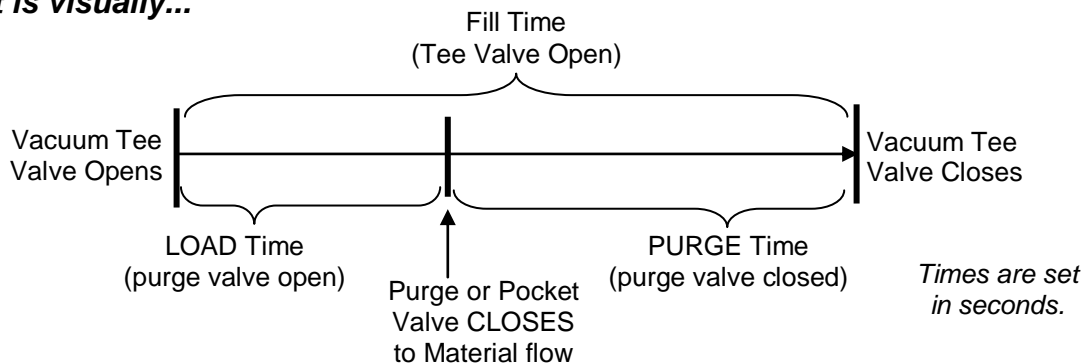
### “PURGE” TIME:

The vacuum time that a pocket or purge valve is *closed* to material flow, but vacuum air continues to flow thru the conveying line to clean out the material conveying line is referred to as PURGE time.

$$\text{LOAD time} + \text{PURGE time} = \text{FILL time}$$

Because the functions are identical, the term PURGE time is used for purging systems *and* pocket conveying systems for cleaning out the conveying line after loading.

**Here it is visually...**



Note that it is common to set *more* PURGE time than LOAD time on the conveying control, to allow the entire conveying line to be cleaned of all pellets and even dust from the conveyed material.

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