

Abstract**Bulk conveying system and method of controlling a bulk conveying system**

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The bulk conveying system comprises a container (1) for storing bulk material having a bulk inlet (11) and a bulk outlet (12). A main conveying pipe (2) connected to the bulk outlet (12) of the container (1) has a pump (21) for driving the bulk material through the main conveying pipe (2). Each one of a plurality of distribution pipes (3) is connected to the main conveying pipe (2) and has a distribution valve (31) for opening and closing it. Each one of a plurality of distribution units (4) has a distribution unit container (41), an inlet (42) connected to the main conveying pipe (2) through a corresponding one of the distribution pipes (3), a material distribution outlet (44) and a stock level detector (43). The stock level detector (43) detects whether or not the actual stock level in the distribution unit container (41) is equal to or falls below a predetermined minimum stock level and whether or not it is equal to a predetermined maximum stock level. A conveyance control system (5) sequentially receives detected values from the stock level detector (43) of each of the distribution units (4) and controls the distribution valve (31) of each of the distribution pipes (3) and the pump (21) on the basis of the detected values. The control is carried out in such a manner that bulk material is being conveyed from the container (1) to the distribution unit container (41) of one of the distribution units (4).

Figure 1