MODULE 4

Conveyor Types and Technology Selection

Conveyor Solutions Engineering | Professional Training Program

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SECTION 1: INTRODUCTION

Module 3 established the framework: every conveyor point in a system is either transportation or accumulation, calculations assume a perfect world, and the engineer's job is to apply judgment to the gap between theory and reality. Module 4 is where that framework gets applied to actual hardware.

In the Hytrol product line, the transportation versus accumulation distinction maps directly onto the naming convention. Every Hytrol conveyor falls into one of two categories: transportation, meaning the drive is either fully on or fully off with no zone-level product control, or accumulation, meaning the conveyor carries the EZLogic supervisory control system and can manage individual zones independently. Sorters, transfers, and diverters are all transportation conveyors by this definition. They do what they are told as a unit. Accumulation conveyors think zone by zone.

When you see EZ in a conveyor name, you know that the conveyor has a self-contained zone control system mounted on it, each zone has its own controller and photoeye, and the conveyor can accumulate product without involving the PLC in every zone-level decision. When you do not see EZ, you know the conveyor is transportation: fully on, fully off, no zone logic.

This module teaches you how to read that naming convention, what the EZLogic system actually does at the zone level, how zones talk to each other and to the controls system, and what the primary drivers are for choosing one accumulation model over another. It also teaches you the Aux I/O module, which is the bridge between the self-contained EZ world and the PLC-controlled world around it.

SECTION 2: LEARNING OBJECTIVES

By the end of this module you will be able to:

1	Use the Hytrol EZ naming convention to identify whether a conveyor is transportation or accumulation from its model number alone.
2	Explain how the EZLogic zone control system works: zone controllers, transducers, default zone behavior, and zone-to-zone communication.
3	Identify when an Aux I/O module is required and explain what it does, what connects to it, and how it bridges EZ accumulation conveyors to the PLC.

4	Apply the primary technology selection drivers to choose between accumulation conveyor models: weight capacity, maximum speed, desired accumulation behavior, run length, and total installed cost.
5	Explain the economy of scale that exists between E24-EZ and ABEZ selection based on unit length and total turnkey integration cost.
6	Recognize that default EZLogic behavior can be changed and understand when and why that configuration change is appropriate.

SECTION 3: PREREQUISITES

Required Prior Knowledge

Module 3: Conveyor Fundamentals and Component Anatomy. The transportation versus accumulation framework, the EZ versus non-EZ distinction, and the E24-EZ versus ABEZ comparison are all introduced conceptually in Module 3. Module 4 applies them to specific hardware and selection decisions.

Module 2: Product and Package Analysis. The Package Calcs outputs for weight, speed, and product mix feed directly into the technology selection decisions taught in this module.

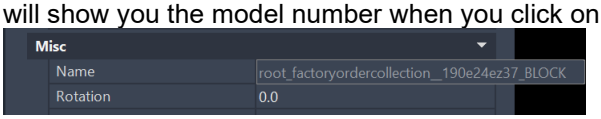
Basic understanding of what a PLC is. Module 9 covers PLC integration in depth. This module only requires that you know a PLC is the controls system that manages the conveyor system at the facility level.

SECTION 4: THE THREE W'S

The Three W's in this module apply to the EZ naming convention and to the two primary accumulation technology platforms covered here.

The EZ Naming Convention

WHY	The EZ naming convention is a field tool, not a trivia fact. When you are on a customer site, looking at a drawing, reviewing a quote, or specifying a system, the presence or absence of EZ in a model name tells you immediately whether that conveyor has self-contained zone logic or not. That distinction changes how you design the interface to the controls system, whether you need Aux I/O modules, and how the zone behaves when product backs up. Reading the name correctly means you are never surprised by what the conveyor does or does not do.
WHEN	Every time you specify, review, or troubleshoot a Hytrol conveyor. In the field, the model name is on the nameplate. On a drawing, it is in the equipment schedule. In a quote, it is in the line items. Read it every time and know immediately what category you are dealing with.
WHERE	The naming convention applies across the entire Hytrol product line and is referenced in every module from here forward. It is introduced in Module 4

	because this is where students first work with specific model selections. It is a foundational field skill that should become automatic. Pro Tip: Even without HyCad (Hytrols Drawing tool) open, you properties menu will show you the model number when you click on the conveyor in CAD 

EZLogic Zone Control

WHY	EZLogic is a self-contained supervisory control system that lives on the conveyor. It manages zone-level accumulation without requiring the PLC to make every zone decision. Understanding how it works, what it does by default, and how its behavior can be changed is essential for anyone designing, commissioning, or troubleshooting an accumulation system.
WHEN	Any time you are designing, specifying, or commissioning an accumulation conveyor with EZ in the name. Also during troubleshooting when a zone is not behaving as expected. EZLogic behavior is often the first place to look when zone timing, product spacing, or release logic is not performing correctly.
WHERE	EZLogic applies specifically to EZ accumulation conveyors throughout the system. It is the zone-level intelligence that makes accumulation work without constant PLC involvement. Module 9 covers the PLC interface in depth. This module covers how EZLogic operates independently and where the two systems meet.

Aux I/O Module

WHY	The Aux I/O module is the bridge between the self-contained EZLogic world and the PLC-controlled world. Without it, the PLC cannot communicate with individual EZ zones, and EZ zones cannot send product detection signals to the PLC. Every end-of-conveyor zone that feeds a non-EZ conveyor, every zone that needs a PLC-commanded hold or release, and every zone that needs to report product presence to the controls system requires an Aux I/O module. Specifying Aux I/O incorrectly or missing it entirely is a common oversight
WHEN	During system design, when mapping the interfaces between EZ accumulation conveyors and the rest of the controls system. Specifically: at every point where an EZ conveyor terminates into a non-EZ conveyor or into a PLC-controlled process, and at every zone where the PLC needs to send a command or receive a signal.
WHERE	Aux I/O modules are specified in the controls design phase of the project and physically installed at the relevant zones during commissioning. They are referenced in Module 9 when PLC integration is taught in detail. This module introduces what they are and when they are needed so that students recognize the requirement during the system design phase, not after the conveyor is installed.

SECTION 5: CORE CONTENT

5.1 The Two Categories: Transportation and Accumulation

Every Hytrol conveyor is one of two things: transportation or accumulation. This is not a subtle distinction. It determines the entire control logic of the conveyor and everything that connects to it.

Transportation conveyors are all on or all off. When the control system turns the unit on, every package on the conveyor moves. When the control system turns it off, everything stops. There is no zone-level intelligence. Sorters, transfers, pop-up transfers, belt curves, and diverters all fall into this category. They respond to a single command from the control system. The control system decides when to run them and when to stop them. The conveyor itself does not make any decisions.

Accumulation conveyors manage product one zone at a time. Each zone is an independently controlled section of the conveyor that can stop and hold a package while the rest of the conveyor continues running. This allows products to queue before a merge, wait before a scan point, or stage before a pack station without crashing into one another.

By controlling the product this way, the conveyor creates a time buffer that keeps items separated and flowing smoothly. This buffer also prevents the entire upstream conveyor system from shutting down when downstream processes slow or stop. The zone level control that enables this behavior is called EZLogic.

HOW TO READ A HYTROL MODEL NAME

No EZ in the name means transportation. The conveyor is all on or all off. Examples: 190-E24, ABLR, NSP, Etc. These conveyors do not accumulate product independently.

EZ in the name means accumulation with EZLogic zone control. The EZ letters may appear as a suffix after the model number or embedded in the middle of the name. Examples: 190-E24EZC, 190-E24EZ, ABEZ, NSPEZ. These conveyors have zone controllers and transducers on every zone.

The base model tells you the conveyor type. The EZ designation tells you whether it has self-contained zone logic. Both pieces of information matter. A 190-E24 and a 190-E24EZ are physically similar conveyors with fundamentally different control architectures.

When in doubt, look for EZ. If it is there, zone controllers are present and Aux I/O planning is required. If it is not there, the conveyor is transportation and the unit is all on, or all off as a unit.

EZ NAMING CONVENTION: COMMON EXAMPLES

Model Name	Category	What the Name Tells You
190-E24	Transportation	E24 MDR zones All on, all off. No zone logic.
190-E24EZ	Accumulation	E24 MDR zones and EZLogic. Zone-level electric accumulation.
ABLR	Transportation	Belt Driven Live Roller . All on, all off. No zone logic.
ABEZ	Accumulation	Belt Driven Live Roller with EZLogic Zone-level pneumatic zone control. (Zones controlled by air)
NSP	Transportation	Line Shaft All on, all off.

NSPEZ	Accumulation	Line Shaft with EZLogic Zone-level pneumatic zone control. (Zones controlled by air).
Sorter (various)	Transportation	Any sorter type. All on, all off. Divert commands from PLC.
Transfer (various)	Transportation	Pop-up, chain, or belt transfer. All on, all off. Command from PLC.

5.2 How EZLogic Works

EZLogic is a self-contained supervisory control system that mounts directly on the accumulation conveyor. It does not require the PLC to manage individual zone decisions during normal accumulation operation. For the sake of this module, the system consists of two primary components per zone: a zone controller and a transducer.

The zone controller is the brain of each zone. It monitors the transducer in its own zone, communicates with the zone controllers upstream and downstream of it, and commands the zone drive to run or stop based on that information. Zone controllers are connected to each other in a daisy chain along the length of the conveyor. They talk to each other directly, without going through the PLC.

The transducer is a photoeye plugged into each zone. It detects whether a package is present in that zone. When the transducer sees a package, it reports that to the zone controller. The zone controller uses that information to decide whether to hold the package in place or release it.

EZLogic Default Zone Behavior

When a package enters a zone and the zone downstream is occupied, the current zone stops the package and holds it until the downstream zone clears.

When the downstream zone becomes empty, the zone controller releases the package and the package travels downstream.

If the downstream zone is already empty when the package arrives, the package does not stop at all. It travels through without interruption.

This default behavior creates singulated accumulation: one package per zone, release when clear downstream. It is the most common configuration and the one the system is set to out of the box.

Default behavior can be changed. Zone controllers can be configured to allow product to bunch together during accumulation rather than maintaining gaps, to hold all zones simultaneously when a downstream signal is received, or to release product in specific patterns. These configurations are application-specific and are discussed in Module 9.

5.3 The Aux I/O Module: Bridging EZ and the PLC

The EZLogic system manages zone behavior independently during normal accumulation. But every real system has points where the PLC needs to control a specific zone, and points where a specific zone needs to tell the PLC something. Those handoff points require an Aux I/O module.

The Aux I/O module plugs into the transducer port on one end, connecting it to the zone controller and the photoeye. The other end connects to the PLC control panel. This gives the PLC two capabilities it would not otherwise have: it can send a signal to the zone controller to hold or release that zone on command, and it can receive a signal from the transducer telling it whether a package is present in that zone.

FIELD INSIGHT | MICHAEL COLLINS

When you get to the end of an EZ conveyor and it is feeding something that is not an EZ conveyor, you need an Aux I/O module on that last zone. The PLC needs to be able to tell that zone to hold product and to know when a package is sitting there waiting. Without the Aux I/O, the zone does not know to wait and the PLC does not know what is happening in that zone.

Map your Aux I/O points during the design phase, not during commissioning. Every end-of-conveyor zone, every zone that needs a PLC-commanded hold, every zone that feeds a non-EZ piece of equipment needs to be identified before the panel is built. Finding a missing Aux I/O during commissioning costs time and sometimes requires a panel modification.

The Aux I/O module is a small component with a large impact. It is easy to overlook in the design. Make it part of your zone-by-zone review on every EZ system you design.

When an Aux I/O Module Is Required

End-of-conveyor zones: Any EZ zone that feeds a non-EZ conveyor, a sorter induction, a transfer, a scanner, or any other equipment that is controlled by the PLC rather than by EZLogic.

PLC-commanded holds: Any zone where the system logic requires the PLC to hold product in place pending a signal, a scan result, a weight check, or a downstream readiness condition.

Product presence reporting: Any zone where the PLC needs to know whether a package is present to make a routing or timing decision.

Merge control: Zones at the entry point of a merge where the PLC manages the merge sequence and needs to command zone releases in a specific order.

The rule: If the PLC needs to talk to the zone or listen to the zone, an Aux I/O module is required. Map every one of these points during design.

Although not typical, an Aux I/O can be controlled without a PLC. For example, a conveyor lined with pack stations could have a foot switch or button at each station that connects directly to the Aux I/O. In the zone controller settings, that local device can be configured to momentarily pause the zone while an operator places product onto the conveyor.

5.4 Choosing Between Accumulation Models: The Primary Drivers

Once you have determined that a location in the system requires EZ accumulation, the next question is which accumulation model. For the two most common platforms, E24-EZ and ABEZ, the selection comes down to four primary drivers: weight capacity and required speed, desired accumulation behavior and operational considerations, run length, and total turnkey integration cost.

Weight and Speed

These are the first filters. Every Hytrol accumulation conveyor has published weight capacity and maximum speed ratings. Check them against your Package Calcs outputs before any other selection criteria is considered. If the product weight or required belt speed exceeds the rating for a given model, that model is eliminated from consideration regardless of any other factor. This is a hard specification limit.

Desired Accumulation Behavior and Operational Considerations

Both E24-EZ and ABEZ use independently controlled zones and support zero-pressure accumulation with controlled gaps between packages. The difference comes down to how each system stops and holds product within a zone, and what that means operationally.

E24-EZ is all-electric. Each zone is driven by its own motor drive roller, and the bed rollers are directly yoked to that motor. Zone stops are precise and repeatable, and each zone can be configured with its own independent speed setting. E24-EZ is also easier to install and maintain, with fewer components and no compressed air infrastructure required. From a safety standpoint, the rollers can be stopped by hand pressure and the system has no pinch points, which is a meaningful advantage in environments where personnel work near the conveyor regularly.

ABEZ uses a centralized motor with a pneumatic belt drive to power zones. When a zone stops, the belt disengages and a brake engages the rollers to hold product in place. Because the drive is centralized, all zones run at the same speed. ABEZ requires compressed air infrastructure and a more involved installation, and the pneumatic mechanism introduces pinch points that are not present in an all-electric system.

For most applications, these operational factors favor E24-EZ. The primary reason to choose ABEZ is run length and the economics that come with it.

Run Length and Economy of Scale

This is the selection driver that surprises most engineers. Conventional thinking assumes E24-EZ is more expensive than ABEZ because MDR technology carries a higher unit price. That is true per zone. But the installed cost picture changes significantly depending on run length.

FIELD INSIGHT | MICHAEL COLLINS

E24 is typically more expensive per zone than ABEZ, but that is not the whole cost picture. On a short unit, E24 can actually be less expensive when you look at the total turnkey integration cost, because ABEZ has a high-voltage centralized motor that needs additional controls components, motor protection, and safety considerations. Those add cost that does not exist with E24.

As the conveyor gets longer, the equation can flip. The fixed cost of the ABEZ motor and panel components gets spread across more zones. At some point the lower per-zone cost of ABEZ overtakes the savings from E24's simpler electrical requirements. That crossover point depends on the specific application, the panel design, and the labor rates involved.

The right answer is always: run the total installed cost for both options on this specific run length, with this specific controls configuration, and let the numbers make the decision. Do not assume one is always cheaper than the other.

E24 VS ABEZ: PRIMARY SELECTION DRIVERS		
Factor	**E24 (Motor-Driven Roller)**	**ABEZ (Pneumatic)**
Drive mechanism	Motorized roller per zone, 24VDC or 48VDC	Centralized AC motor with pneumatic zone actuators
Zone stop behavior	Electric signal, consistent response	Air pressure, variable with supply quality
Default accumulation	Singulated: one package per zone with gaps	Can be configured to bunch product
External utilities	Low-voltage DC power only	High-voltage AC power plus compressed air
Controls components	Zone controllers only, minimal panel additions	Motor starter/VFD, overload, air filtration required
Short run total cost	Lower (simpler electrical, no motor panel)	Higher (motor and panel components fixed cost)
Long run total cost	Higher (zone controllers scale with length)	Lower (fixed motor cost spread over more zones)

5.5 Configuring EZLogic Beyond the Default

The default EZLogic behavior, singulated zone-by-zone accumulation with release when the downstream zone is clear, is appropriate for many applications. It is not appropriate for all of them. Understanding that the default can be changed, and knowing the most common configuration changes, is part of what separates an engineer who specifies a conveyor from an engineer who specifies a system.

Common EZLogic Configuration Changes

Slug release mode: All accumulated zones release at the same time as a group rather than one zone at a time. This is used when feeding an induction or sortation system that needs product presented in a controlled burst.

Cascade release mode: Zones release with a timed delay rather than immediately. It serves the same purpose as slug release, but lets you build a little more spacing into the released slug. When using ABEZ, this also reduces the shock load on the belt under the rollers.

Zone stop, signal to release: By default the release is set as signal to stop. If an Aux I/O is unplugged, the conveyor will release product uncontrollably. This can cause large pileups that may damage product or injure people working around the conveyor.

The rule: Identify the required accumulation behavior for each section of the system during the design phase. Do not assume the default setting is correct. Ask what the downstream system requires and configure the controls accordingly.

Although this does not change pricing, it supports the approach we are aiming for, which is systems thinking.

SECTION 6: TIPS AND TRICKS

TIPS AND TRICKS | MICHAEL COLLINS

Read the model name before you read anything else. EZ or no EZ tells you the entire control architecture of that conveyor in two letters. Make it automatic.

Map your Aux I/O points on paper before the controls panel is designed. Write down every zone in the system that needs to talk to the PLC or listen to the PLC. Every one of those zones needs an Aux I/O module. If you find one during commissioning that you missed during design, you are adding a panel modification at the worst possible time.

Do not let price per zone make the decision for you on E24 versus ABEZ. Run the total installed cost. Include the motor, the starter or VFD, the panel components, the air supply, and the labor for each option. The answer may not be the one you assumed.

When a customer needs product to bunch during accumulation, ABEZ is the natural conversation. When a customer needs controlled gaps and consistent spacing going into a sorter or scanner, E24 is the natural conversation. Let the application behavior drive the first cut, then verify with cost.

EZLogic default behavior is a starting point, not a final configuration. Before you sign off on a system, confirm that the default zone behavior is actually what the downstream equipment and the system logic require. A sorter induction that needs slug release will not perform correctly on default singulated mode.

When you are troubleshooting zone behavior in the field, the zone controller is the first place to look. Check the configuration before you assume the hardware is faulty. A zone that is not releasing correctly is often a configuration issue, not a component failure.

SECTION 7: NOTES AND INSIGHTS

NOTES AND INSIGHTS

The EZLogic system is a Hytrol-specific implementation of zone accumulation control. Other manufacturers have equivalent systems under different names: Intelligrated has a similar zone control architecture, Hytrol competitors use motor-driven roller platforms with their own zone controller ecosystems. The underlying principle, zone-level independence with transducer-based product detection and zone-to-zone communication, is consistent across platforms even when the specific hardware and naming differ.

The transportation versus accumulation distinction introduced in Module 3 maps exactly onto the EZ versus non-EZ naming in the Hytrol product line. Sorters and transfers being transportation conveyors is not obvious to engineers who are new to the industry. They look like complex equipment and they are, but their control architecture is simple: the PLC tells them what to do and they do it. EZLogic is what makes a conveyor capable of managing product independently of that single PLC command.

whether PLC or WMS, does not have to manage every individual zone decision. Both systems exist to reduce the decision-making burden at the level above them.

Economy of scale in conveyor selection is a concept that applies beyond E24 and ABEZ. Any time two technology options have different fixed versus variable cost structures, the crossover point where

one becomes more economical than the other is a real engineering calculation worth running. Get in the habit of running it.

SECTION 8: EXPERT CALLOUT

EXPERT CALLOUT

Placeholder for expert insight on EZLogic configuration and the consequences of leaving zone behavior at default when the application required something different. Reviewer to share a specific commissioning or field experience where zone configuration, Aux I/O mapping, or the E24 versus ABEZ selection decision produced an unexpected outcome and what was learned from it.

[Reviewer Name, Title, Company]

SECTION 9: PITFALLS

!	Treating EZ as a generic label rather than a specific control architecture. EZ in the model name means zone controllers and transducers are present on every zone. Not knowing that during design means missing Aux I/O requirements, misconfiguring the controls interface, and being surprised by zone behavior during commissioning.
!	Assuming transportation conveyors can accumulate product. Sorters, transfers, and other transportation conveyors are all on or all off. If product needs to queue in front of a sorter, the accumulation must happen on a separate EZ conveyor upstream of the sorter, not on the sorter itself.
!	Missing Aux I/O modules during the design phase. Every EZ zone that needs to communicate with the PLC requires an Aux I/O module. Finding a missing Aux I/O during commissioning means a panel modification at the most inconvenient possible time. Map every Aux I/O point during design, before the panel is built.
!	Choosing between E24-EZand ABEZ based on unit price alone without running total installed cost. E24 has a higher per-zone hardware cost but lower controls complexity. ABEZ has a lower per-zone cost but requires centralized motor controls and compressed air infrastructure. The correct choice depends on run length, controls configuration, and the specific cost of each option in the actual application.
!	Leaving EZLogic at default configuration without verifying that the default behavior matches the application requirement. Singulated one-at-a-time release is correct for many applications and completely wrong for others. A sorter induction that needs slug release will underperform significantly if the accumulation conveyor feeding it is releasing products one zone at a time. Confirm the required behavior before commissioning.
!	Confusing the ABEZ air-driven mechanism with unreliability. ABEZ is a proven platform with a long track record. The consideration with pneumatic systems is not whether they work but whether the air supply infrastructure at this specific facility is stable and clean enough to support consistent zone behavior. Ask the question. Do not dismiss the technology.

SECTION 10: FOREST THROUGH THE TREES

How Technology Selection Connects to Everything That Follows

The technology selections made in Module 4 cascade through every subsequent module. The conveyors you choose here determine the controls architecture in Module 9, the accumulation zone sizing in Module 5, the speed and rate calculations in Module 6, and the system layout in Module 7.

The EZ naming convention is a thread that runs through the entire program. Every accumulation conveyor in every system layout from Module 7 forward will have a model name. That name carries control architecture information. An engineer who reads those names automatically is an engineer who never misses an Aux I/O requirement and never assumes a transportation conveyor can accumulate.

The Aux I/O module introduced here is covered in depth in Module 9 when PLC integration is taught. The foundation laid here, understanding what Aux I/O does and when it is needed, is what makes the Module 9 content applicable rather than abstract.

The E24-EZ versus ABEZ cost analysis is a specific example of a general principle that applies throughout the program: total installed cost is the right metric, not unit price. That principle reappears in Module 11 when systems are scoped and quoted. Students who understand it here will apply it naturally when they are building proposals.

SECTION 11: KEY TAKEAWAYS

KEY TAKEAWAYS | MODULE 4

EZ in the model name is not marketing. It means zone controllers and transducers are on every zone and the conveyor manages accumulation independently of the PLC. No EZ means transportation: all on, all off, PLC controls everything.

Sorters, transfers, and diverters are transportation conveyors. They do not accumulate product.

EZLogic default behavior is singulated accumulation: one package per zone, release when downstream is clear. Default is a starting point. Confirm that the application requires default behavior before commissioning.

Every EZ zone that needs to communicate with the PLC requires an Aux I/O module. Map every Aux I/O point during design, before the panel is built.

Weight, speed, accumulation behavior, run length, and total installed cost are the five primary drivers for choosing between E24 and ABEZ. Unit price is not the right metric. Run the total installed cost for each option.

E24 is often lower total cost on short runs because it requires no centralized motor or high-voltage panel components. ABEZ can become lower total cost on longer runs because the fixed motor cost spreads over more zones.

ABEZ is the natural fit when a product needs to bunch during accumulation. E24 is the natural fit when controlled gaps and consistent spacing are required.

SECTION 12: MODULE ASSESSMENT

Knowledge Check

Q1
What does the presence of EZ in a Hytrol conveyor model name tell you about the control architecture of that conveyor? Give two examples of model names where EZ appears in different positions and explain what each name tells you.

Q2
Explain the default EZLogic zone behavior. Under what application conditions would you change the default configuration, and what configuration would you change it to?

Q3
What is an Aux I/O module, what does it connect to, and what two capabilities does it give the PLC that it would not otherwise have on an EZ accumulation conveyor?

Selection Scenario

Q1
You are specifying a 40-foot accumulation section feeding a sorter induction. The product mix is standard cartons from 6 to 18 inches long, 2 to 20 lbs. Required belt speed is 120 FPM. The customer's facility has no existing compressed air infrastructure in this area. The sorter induction needs product presented in controlled slugs not singulated. Walk through your E24 versus ABEZ decision: which drivers favor E24, which favor ABEZ, what does the air infrastructure condition do to the decision, and what EZLogic configuration is required for the sorter induction feed?

Aux I/O Mapping Exercise

Q1
You are designing a system with the following layout: Three 60-foot ABEZ conveyor that feeds a belted merge, which feeds a sorter. The sorter has three E24 divert lanes each ending at a pack station. Identify every point in this system where an Aux I/O module is required and explain specifically why each point requires one.

END OF MODULE 4

Next: Module 5 | Accumulation Zone Design

Before continuing, complete the Aux I/O mapping exercise in writing with a simple sketch of the layout. The ability to identify Aux I/O requirements from a system layout is a design skill that must be practiced.

The EZ naming convention will be used in every module from here forward. Treat reading model names as a habit, not a step.

Module 5 builds the accumulation zone sizing work that the conveyors selected in this module will be used to execute.