

Dry sorter with Robot trim saws, 30 bins and stacker, wrapping, press, strapping

Renholmen, Sweden, year 1984.

Heavily upgraded to very high technical standard, see end of description.

Currently in use. Available for deconstruction preliminary in May, 2019.

Kiln package size in max., w = 1.5, h = 2.7 m, l = 6.15 m.

Min. finished length 1.8 m.

With Robot trimmer for "any length" products, infinitely programmable.

Speed up to 100 lugs per minute, average 69 lugs per minute.

Two sorting stations, in total 6 operators per shift.

Sizes processed in the line; from 13x63 mm to 50x300 or 75x250 mm.

Consisting of

Package infeed deck in 2 sections

Tilt hoist

Stick separation, stick collection system to stick bins (belt, stick bin, unscrambler, stick bin)

Cross feeder

Unscrambler

Even ending rollers with live fence

Unscrambler

Even ending rollers with live fence

Roll bars

Single piece feeder to lug chain, butt end trim saw operator place

Lug chains

Butt end trim saw

Top end even ending rollers

Distribution to two grading stations

Two grading stations with lights, board turners and defect cutting top end trim saws

Collection to one lug chain

Even ending rollers

Limab exact length laser scanners, 2 ea.

Robot trimmer cross cut, for finished cutting to "any length"

Brookhuis in-line moisture meter

Matthews Jet-a-Mark R44 ink printer

Feeder belts to J-bar sorter conveyer

J-bar conveyer with drive

30 hydraulic bins

Bottom conveyors to stacker

Double unscrambler

Cross feeder, roll bars

Star wheel board singulator

Lugged chain to stacker

Even ending rollers

Marking equipment for shipping mark

Limab exact length laser scanner for package lists

Feeder belts, stacker forks, package lift

Stick cassettes, 4 ea.

Cross feeder for packages

Roller conveyors

Plastic- or paper wrapping station

Press and strapping with corner protectors

Roller conveyors

Package cross feeders

Waste conveyor system with Bruks 820 CS trim end drum chipper

Complete control system; MCC's, PLC controllers, frequency drives, control system computers
operator panels, operator screens, touch panels and control seats

Building size approx. 90 x 12 m

Upgrades:

2003 Robot trimmer

2004 New tilt hoist

2006 New in-line moisture meter

2008 New marking systems

2010 Mechanical upgrades (singulators, turners, etc.)

2010 Limab laser length measuring (3 ea.)

2011 New PLC control system; Siemens S7 with graphic machine interface (HMI),
modernization of all frequency drives in the plant

2014 New package press with PLC controller