



gradingmaster

Automatic Grading and Stacking of Veneer Faces

gradingmaster

Automatic Grading and Stacking of Veneer Faces

SEQUENCE OF OPERATION

The operator selects the grading box at a push of a palm button and slides the veneer face over a light table to the two contact rollers of the edge reinforcing and trimming machine Edgemaster.

The spotlight of the selected grading box illuminates for a visual confirmation of the selected position.

The veneer face is retracted as soon as the two contact rollers of the Edgemaster are activated, is edge-reinforced and trimmed to the previously set length. The operator has enough time to rate the grade of the veneer face during this operation and to select the appropriate grading box for stacking.

Once the veneer face has passed the photo sensor of the first grading box, clearance for infeed of the next veneer face to the Edgemaster is given. The veneer face is then transported to the selected grading box, realigned and properly stacked. The number of faces to be stacked (stacking height) can be individually programmed for each grading box. Once the grading box is filled, the scissor-lifting table lowers and enables the carriage to roll out sideways with properly stacked veneer faces.



GRADING

The operator selects the grading box at a push of a palm button. The spotlight of the selected grading box illuminates for a visual confirmation of the selected position.



AUTOMATIC POSITIONING

Once the veneer face has passed the photo sensor of the first grading box, clearance for infeed of the next veneer face to the Edgemaster is given.



REALIGNING AND STACKING

The veneer face is then transported to the selected grading box, realigned and properly stacked.





PROGRAMMABLE STACKING HEIGHT

The number of faces to be stacked can be individually programmed for each grading box.



GRADING BOX

Once the grading box is filled, the scissor-lifting table lowers automatically.



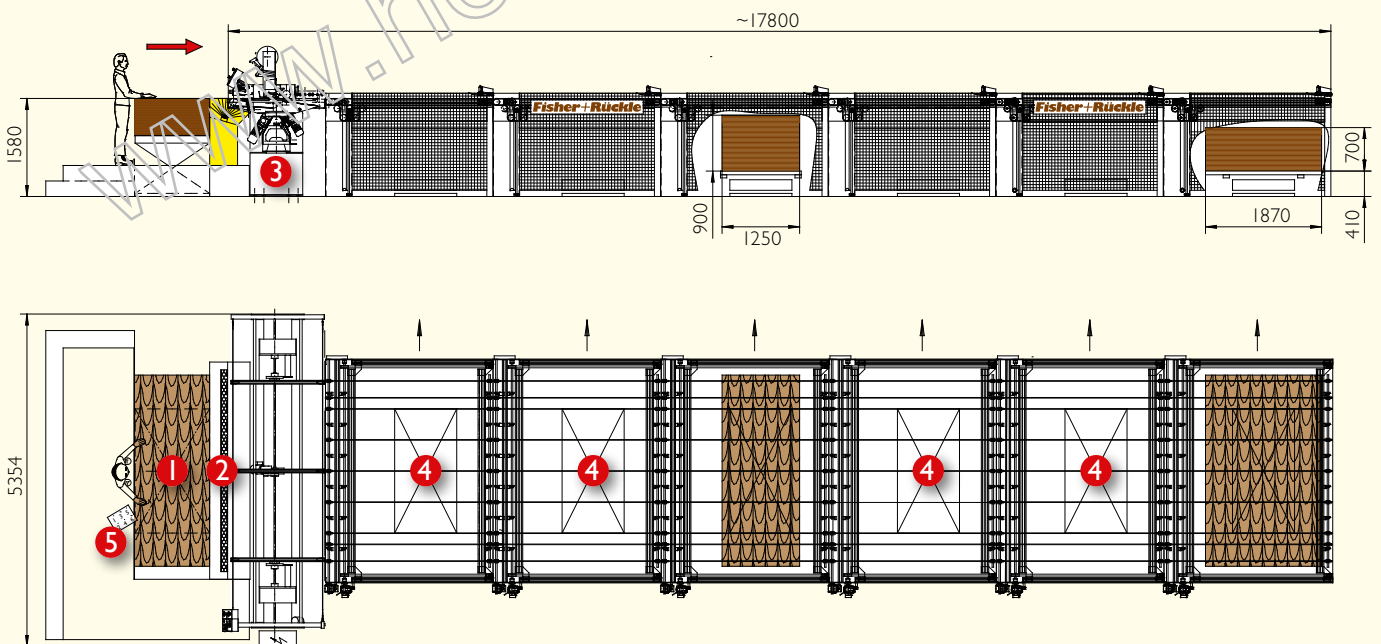
STACK UNLOADING

A carriage enables to roll out the properly stacked veneer faces sideways.

PROGRAMMABLE LOGIC CONTROLLER

Different parameter settings on the PLC allow programming for the installation of various veneer face sizes and species for most efficient grading and stacking of nearly all kinds of wood, species and sizes.

EXAMPLE WITH SIX GRADING BOXES



- ❶ Scissor lifting table
- ❷ Light table
- ❸ Edge reinforcing and trimming device
- ❹ Gradingbox with scissor-lifting table
- ❺ Selector pushbuttons

gradingmaster

Automatic Grading and Stacking of Veneer Faces

FEATURES AND BENEFITS AT A GLANCE

- Reinforces the veneer edges, trims, grades and stacks up to 20 veneer faces per minute by one operator
- Properly squared veneer stacks of consistent grades
- Veneer faces are trimmed exact and rectangular to size
- Best use of floor space and most efficient work flow compared to conventional veneer grading
- Reduces labor substantially compared to conventional grading procedures



Grading boxes with stacked veneer faces

edgemaster



Longitudinal or crossfeed spliced veneers are reinforced by means of an adhesive tape (optional by glue thread) and exactly square trimmed on the edges by the Edgemaster.



The trimming position is visualized by a laser light.

Fisher+Rückle

Fisher + Rückle AG

Postfach CH-5200 Brugg Switzerland
T +41 (0)56 460 67 00 F +41 (0)56 460 67 01
sales@fisher-ruckle.ch www.fisher-ruckle.ch

Representatives in over 50 countries



A member of the group SIH Holding AG

