

Intelligent stacking

and destacking line



Intelligent stacking and destacking line

A safe investment

So that timber merchants and other companies kiln drying, sorting or grading timber can achieve an efficient production, System TM offers a unique handling and software solution for automatic measuring of dimensions, stacking and destacking of workpieces before and after kiln drying.

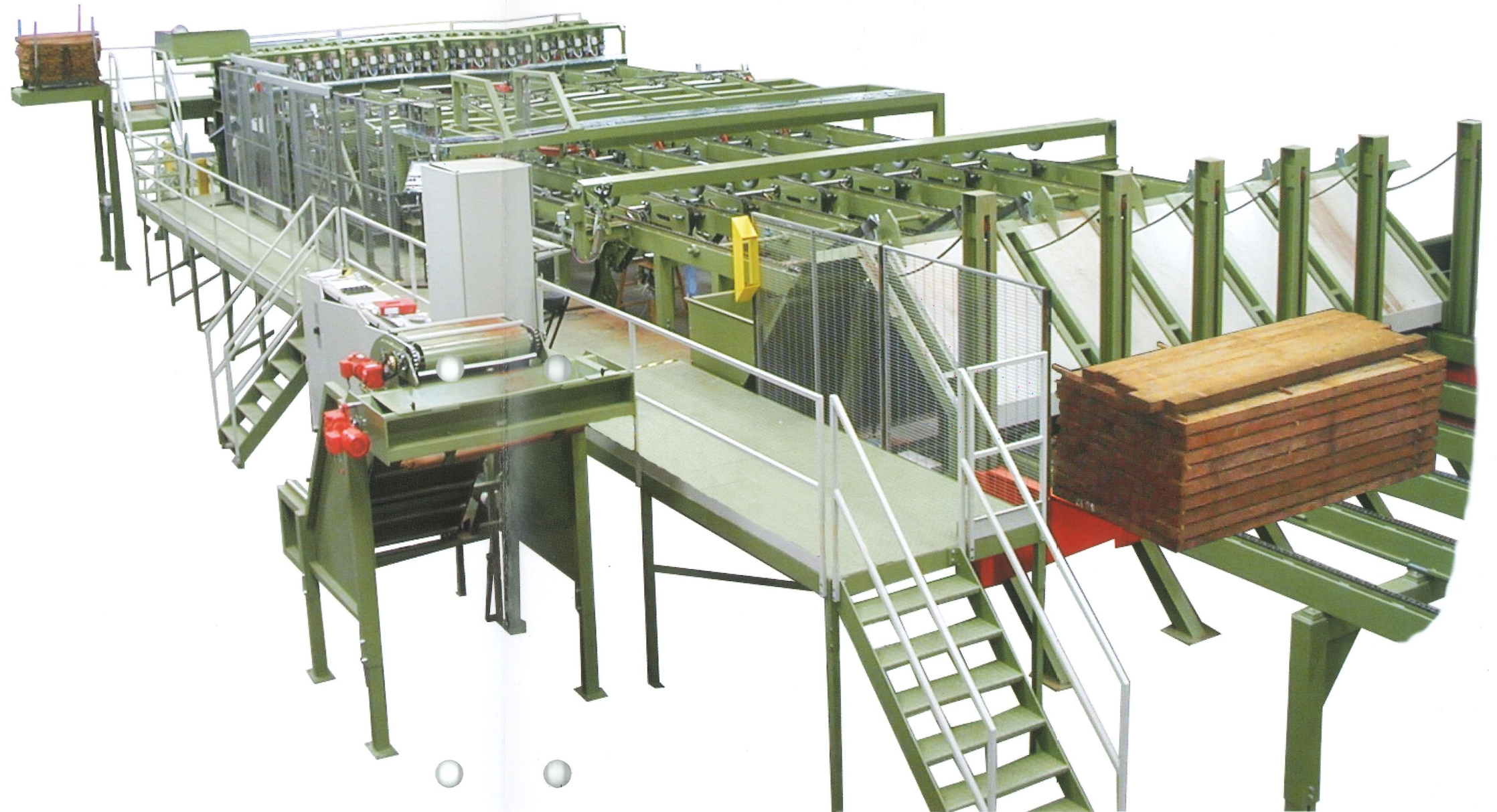
The system can be designed to match a number of different needs, such as:

- Stacking and destacking
- Measuring by dimensions - length, width, thickness
- Data logging to/from stock
- Labelling: by individual workpiece or by timber pack
- Control of purchased volume - ensuring that the stated purchased volume matches actual volume.
- Outsorting of defect workpieces or by requested workpiece dimension.

The system is centrally operated by a control unit and a computer with Windows based software. Software that everyone can operate and which easily can be linked to other computer management systems.

Today, we have several installations of this kind in operation at major European hardwood timber importers.

Regardless of size, all installations are subject to predelivery testing and installation at our facilities ensuring you a fast and safe commissioning.



Choose between various infeed systems. Here a vacuum infeed for a very gentle timber handling without occupying too much floor space. Thanks to its flexible mounting of the vacuum heads it can adjust any distortions in the timber pack automatically.



Another infeed option could be a tilt hoist infeed. For the safe and careful handling, the tilt hoist can be equipped with hold back arms, ensuring gentle and well-controlled descent onto the cross chain conveyor, reducing noise and damage to the timber.



Automatic measuring of length, width and thickness of the incoming workpieces allowing you to both control your timber suppliers and to provide data for stock management ensuring a high level of traceability.



Rejecting device for rejection of workpieces or manual quality inspection. Furthermore, it can be set up for automatic sorting according to specific dimensions, if required. For rejection during quality grading, the device is operated by a joy-stick.

Reliable, careful and fast handling

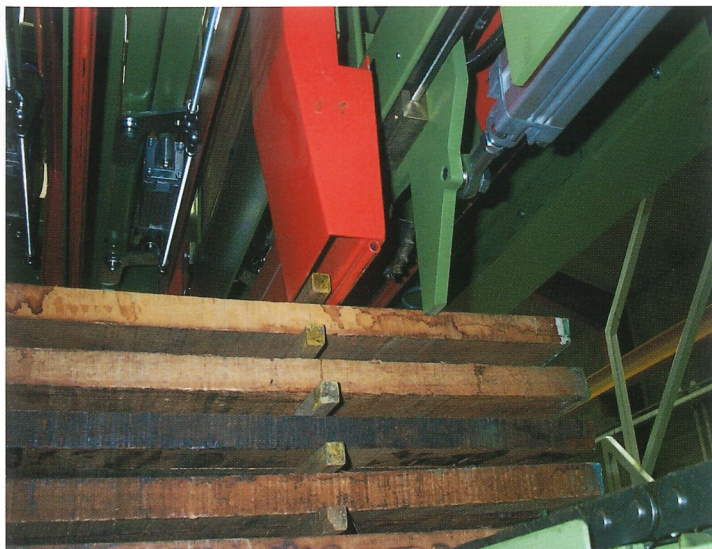


Picture (above): The system can be equipped with various types of stick magazines. Here fixed stick magazines are shown. The magazines are filled manually using a movable trolley equipped with a small stick storage ensuring a fast and efficient fill-up. The stick magazines can be pre-programmed to give the number of layers to be stacked, before sticks are laid. Based on the result of the length measuring, the system can automatically determine the number of sticks needed in relation to the actual layer.

Picture (right): Stacked and sticked timber ready for kiln drying.

This high speed line gives you the following advantages:

- Optimum utilisation of kiln drying halls
- Stack or de-stack using the same line
- Precise and careful stick positioning
- Control of incoming timber dimensions
- Efficient and rapid rejection of poor workpieces
- Bar code labelling for high traceability of individual boards
- Automatic sorting by dimension
- Intelligent and user-friendly software
- Automatic stacking and placing of stability sticks
- Minimum level of maintenance
- High level of flexibility
- Fast and easy operation with low set up time between production runs
- High up-time on the line



Automatic stick positioning. Sticks are carefully placed exactly above each other ensuring neat and nicely stacked packs of timber which in combination with a large pack size allows full optimisation of kiln drying halls.



In front of the pack chains, there is an area for manual strapping of the finished timber packs. This can be automated further, if needed.

Intelligent stacking and destacking line with data logging and measuring of workpieces

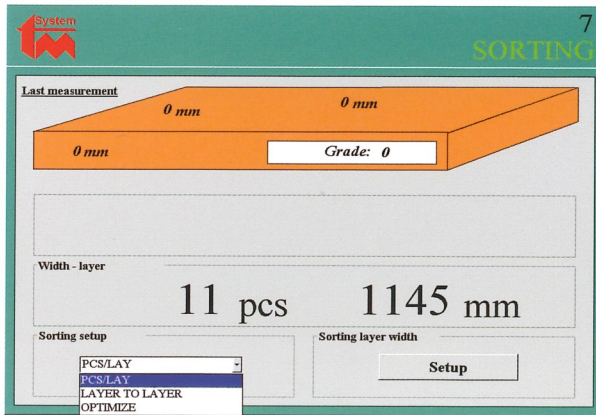
Technical data:

Overall data:

Material : all hardwood
 Board conditions: full or half edge sawn boards

Timber specifications:

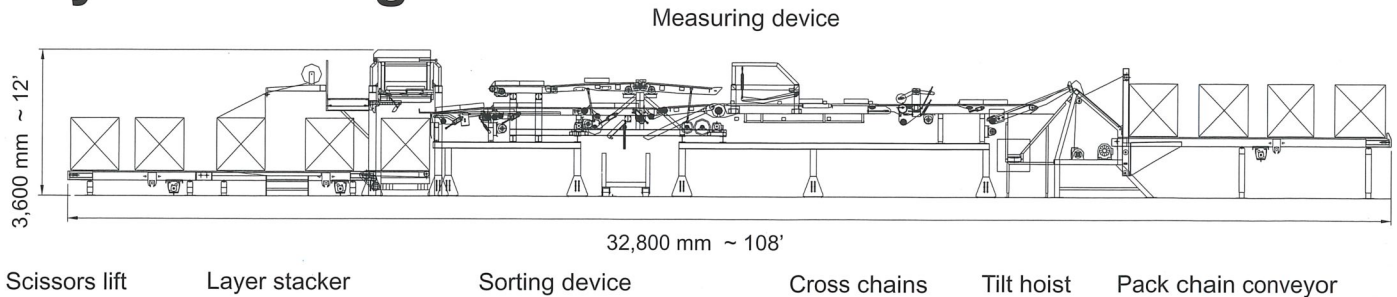
Board length: min. 1,500 and max 6,000 (anything between min. and max.)
 min. 58" and max 19' 8" (anything between min. and max.)
 Board length variation: 30%
 Board width: Random from 75 mm to 600 mm (from 3" to 24")
 Board thickness: min. 20 mm (3/4") max. 110 mm (4 1/2")
 Max dimension: thickness = 110 mm x width = 600 mm (max. 515 kg)
 thickness = 4 1/4" x width =24"(max. 1,100 lbs)
 Max. pack size to the line: width=1,200 mm height=1,700 mm, max. 6,000 kg
 width=48" height=5' 6", max.13,200 lbs
 Max. pack size from the line: width=1,200 mm height=1,700 mm, max. 6,000 kg
 width=48" height=5' 6" max. 13,200 lbs
 Stick dimension/automatic sticking: 20 x 20 mm to 24 x 24 x 1,200 mm
 3/4"x 3/4" to 1" x 1 " x 48"
 Tilt hoist infeed/vacuum infeed: Max. 7.5 layers/min.
 Stud carrier: Max. 45 pieces/min. with a width of 305 mm (12")
 Layer stacker: Max. 7.5 layers/min.



Intelligent software:

- Windows based software
- Data logging in Windows Excel
- Three different options of layer management:
- Pieces per layer
- Layer to layer
- Optimised layer width

System design:



*Technical data subject to change without prior notice. The data can vary according to the specific design of the line. Please contact us should you need any further information.

Automation for the timber industry

Founded in 1977, System TM began producing high quality woodworking machinery and advanced systems for the solid timber industry.

System TM's strategy is to create, develop and manufacture first class system solutions for the optimization of timber and human resources within the production of value added timber products.



Today our product range includes:

- Optimizing cross cut saw
- Mechanical handling equipment
- Sorting and grading of solid timber
- Sticking and stacking



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