Functional description:

The plant can be run with either dry or raw wood.
The changeover takes place very quickly through a pneumatically adjustable flap pos 37 and stop of elevator pos 80. Dry timber can be run to buffer conveyor for raw wood heading 60, 61 and 70 are filled. These hold about 30m³ of sawn goods.

Raw:

The operator controls the flow of sleepers or boards from his desk batchwise. That way the plant can be run slowly for sleepers and fast during the board phase. In addition, you dropp the two extremes are mixed, which facilitates handling.

The wood is feed with the root towards the operator and is automatically turned in front of him. The gross measuring ramp pos 109b reads the gross length of the bit and a variable laser beam marks the longest length at the top end (from the end). The accuracy of the length marking depends on the resolution of the measuring ramp. The root end is drawn in a zero line to the preamble pos 190.
After turning the piece, it is placed on the driven roller conveyor.
A fixed blade marker indicates where the piece will be rooted if none relocation takes place. Through a manipulator in the work chair, the operator can sleeplessly control the runway and move the piece of wood to the desired cutting position. That way he can choose root cuttings with retained control over the top cuttings. This is marked by it moving laser that specifies the maximum module length or standard length, depending on the variety pre-programming in the computer.

Through the above system with the movable touch laser at the top end, the sorter can determine an arbitrary or modular cut. Quality is indicated by pushbuttons.
Pushbuttons are also available for module cabinets.

Variety formation and subject selection takes place in the usual way by electronics. Width and thickness gauge is for operator, which gives the computer the ability to control the laser to a predetermined length.
The operator can then override if necessary to increase or decrease the length depending on condition.

Through all the possibilities of the system, the wood blanks can be cut with the least wood loss highest quality. A position able stop after the forelegs pos 190 moves the piece sideways in mm precision so that in combination with a selected trimmer blade each dimension between 1800 to 6000 mm can be obtained.

The cutting accuracy is better than +/- 2 mm up to 40 bits / min. In addition, it can deteriorate slightly but works well up to 60 bits / min, then 0-5 mm.

If the operator thinks so, he can make extra cuts with the trimmer also at the operator end. This is also non-contact, but often gives unnecessarily large cuts.

Dry:

The function for dry driving will be the same as for raw. The only difference is that the sorting takes place in another way and the cutting is carried out definitively.

The trimmer is designed to cut 170 mm thick wood.

The hook web has 5 carriers for each piece of wood and dimensioned for sleepers.

The sorting bins are ALMAB's automatic belt bins, which is a prerequisite for the idea to also run sleepers over the sorting.
The sprinkler and the lifts are adapted to sleepers and that also board dimensions can be run by a remote control of the elevators.