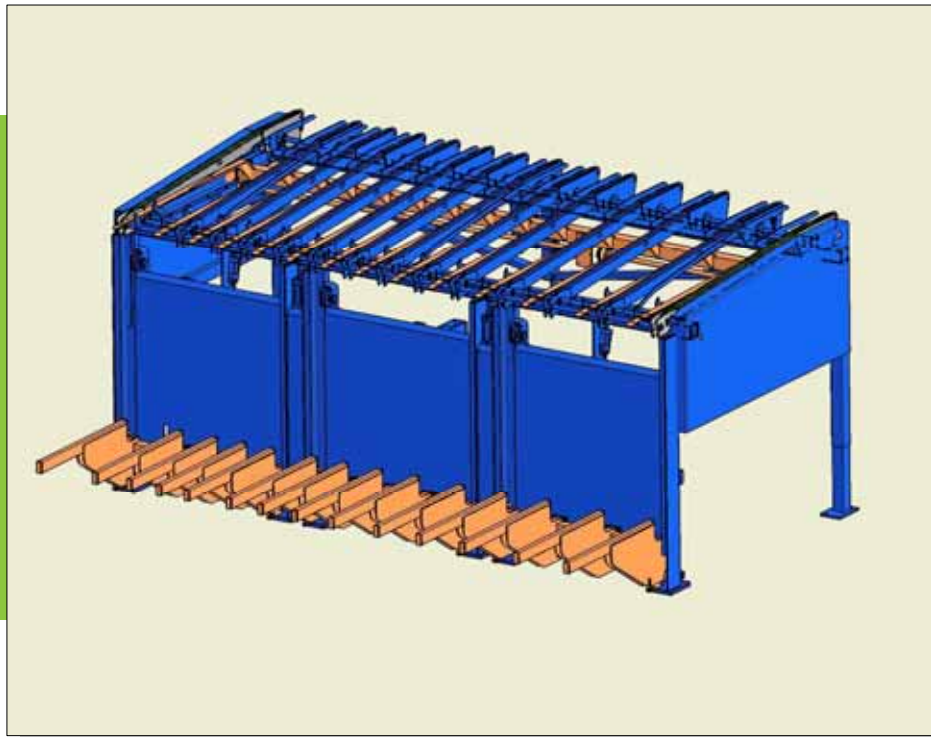




# ***SAWN TIMBER HANDLING***

*Sorting, Cross-cutting and Stacking – Added Value*



*The future is in components*

Sawn

## Timber Handling

Sorting, Cross-cutting and Stacking - Added Value

### Sorting

Brødbæk & Co. offers a wide range of sorting systems for various applications. From simple sorting by width, length and thickness to a complete 3D scanning by length, width, thickness and quality sorting.

The sorting systems can be fed by the main saw line, profiling line, edging line or destacking line.

It is possible to have more than 10 trays in a system. Each tray has the capacity of more than one wood pack. It is possible to start filling a tray while it is being unloaded. In this way only one tray per dimension is needed. Trays are very suitable for timber which is difficult to sort and handle.

Systems up to 6 trays are unloading onto a waterfall singulator incorporated in the tray conveyor. If more than 6 trays are used, the trays unload onto a chain conveyor leading the boards to an S-singulator.

If many sorting bins are required, push-bar sorting and sinking pockets may be flexible solutions.

After the singulator the boards are fair-ended and delivered layer by layer to stacker or cross-cut saw.



1. BCO Speed Feeder – single piece feeding



2. Scanning and optimizing



3. Dump gate before trimming



4. Stairway fair ending



5. Trimming and waste board cross-cutting



6. Tray sorting



7. Emptying trays on movable conveyor



8. Layer cross-cutting



9. Stacking and stick cassettes

### **Cross-cutting**

The sorting system can be delivered with cross-cut saws used for length or quality trimming with board optimizing. Cross-cut saws are available as single or multi saws and as layer cross-cut systems. Cross-cut saws are available with fully automatic CNC settings or manual setting of saw position.

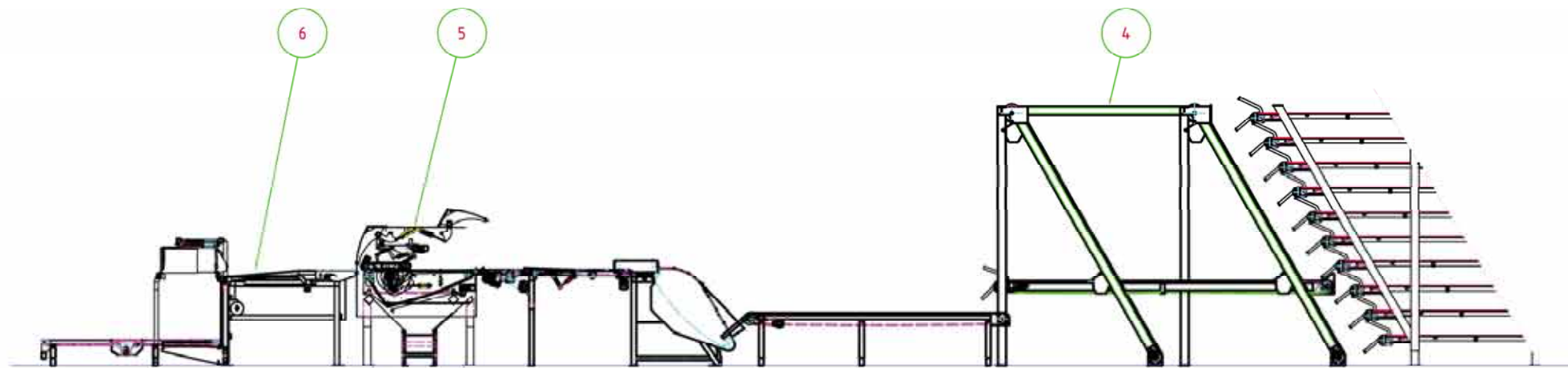
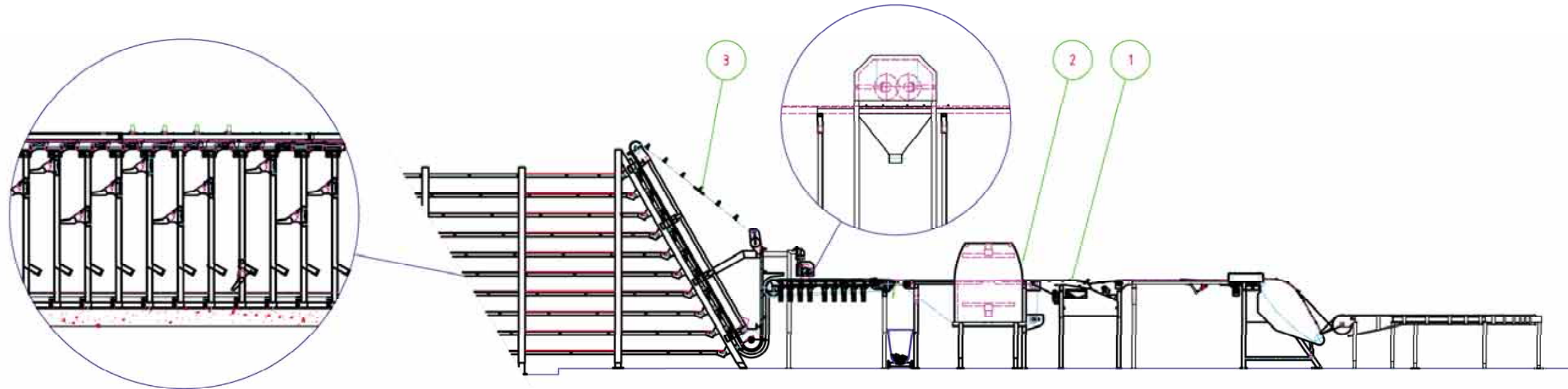
### **Stacking**

The stacker integrated in the sorting system is prepared for stacking all product types. The stacker is available with dump gates for board optimizing and can be equipped with automatic stick cassettes

Brødbæk & Co. lines are supplied as "turn-key" projects, wired and tested, to minimize set-up and start-up time.

Option : Push-bar sorting and sinking pockets

Option : Trimming saws



1. BCO Speed Feeder – single piece feeding
2. 3D scanner
3. Tray sorter
4. Movable conveyor for emptying
5. Layer cross-cutting
6. Stacking

### Scanning

There is a wide range of scanning options for the sorting lines.

Brødbæk & Co. product lines include:

#### Advanced 3D laser scanning system

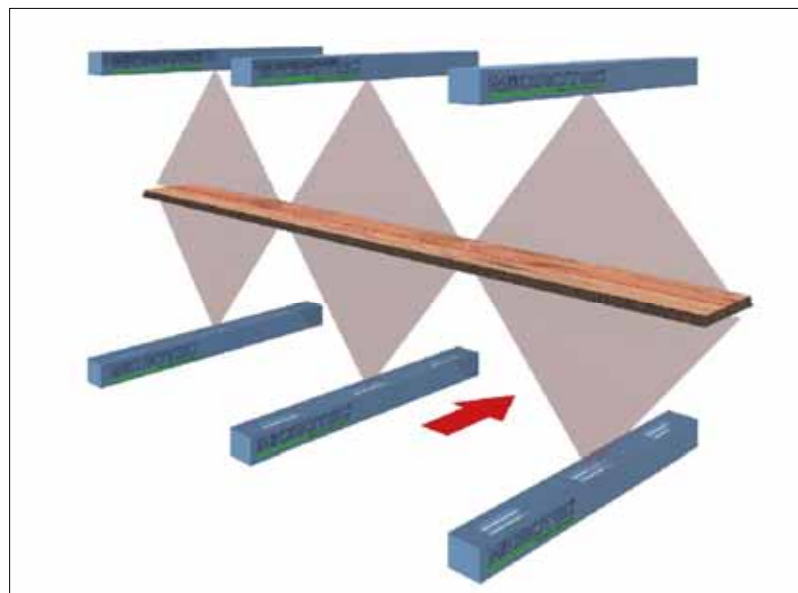
Scans length, width and thickness. Furthermore it is able to detect knots and wany parts of boards and to classify boards according to quality or position of knots and wany parts.

#### Standard length, width and thickness scanning

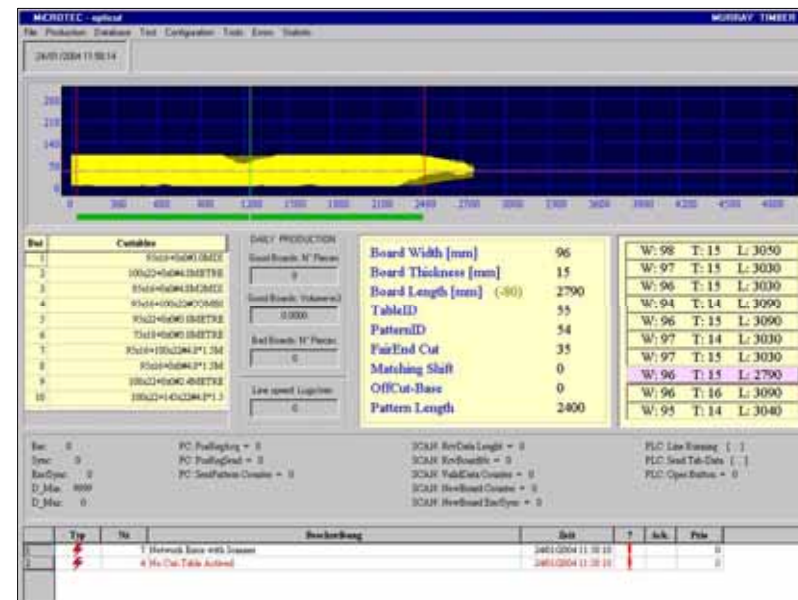
Fast scanning with customer defined measuring and precision. Relatively lower costs compared to a 3D-system.

#### Simple operator push-button systems

For low capacity systems or productions with non-measurable quality grading.



10. 3D scanning



11. On screen data display



12. Vacuum destacking – very fast process



13. Timber turning



14. X-ray or planing infeed - up to 400 m/min.



15. X-ray scanning + moisture meter



16. Stacking and strapping



17. Destacking with pushing system



18. Multi layer stacking – 500 boards/min.



19. Bundling and strapping of boards and battens



20. Slat stacking, 5 mm thick



21. Stacker after planer

### Snapshots of Added Value by making sawn timber into components:

Through the years Brødbæk & Co. has supplied many flexible solutions for adding value to sawn wood.

A few examples :

- X-ray and scanning lines for stress grading or gluelam
- Planing and splitting lines
- Resawing lines
- Bundling lines

Many different stacking lines, examples :

- Slat stacking
- Stacker for pallet boards +500 boards/min.
- Stacking of normal boards and big dimensions up to 12 m

Brødbæk & Co. presents a solution for nearly all requirements within added value and has completed a large number of complex, high-capacity projects, having proved large savings on manpower.

Solutions

Lösungen

Solutions

Soluciones

*Enquire regarding your specific requirements –  
Brødbæk & Co. will provide a specialized yet  
modular solution.*

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