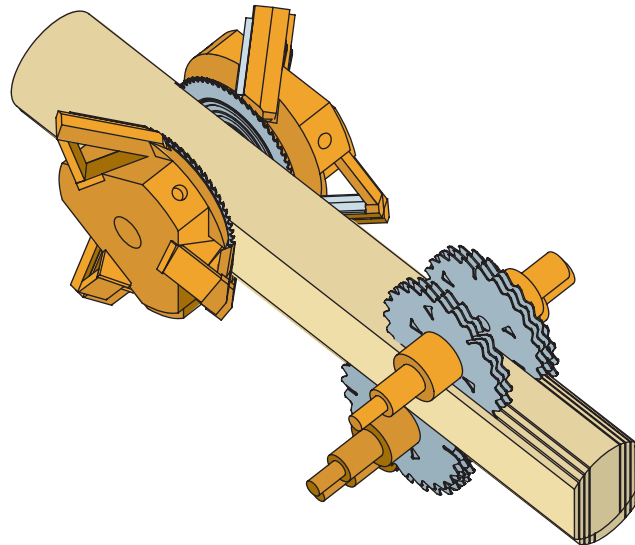




PALLET SAWMILL



Pallet Sawmills

Brødbæk & Co. sawmill lines for short, inferior quality logs provide a flexible production line with high recovery, capacity and quality.

The design and manufacture of the machinery secure low labour and maintenance costs.

This special type of line is based on the philosophy of cutting long, bent cants into short and straight cants for an individual optimization and maximum recovery.

In other words: To work up less valuable raw materials into a final product of good quality.

The flexible standard sawmill lines can be delivered for sorted or unsorted logs, with measuring by 2D or 3D scanner or by a combination of both.

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



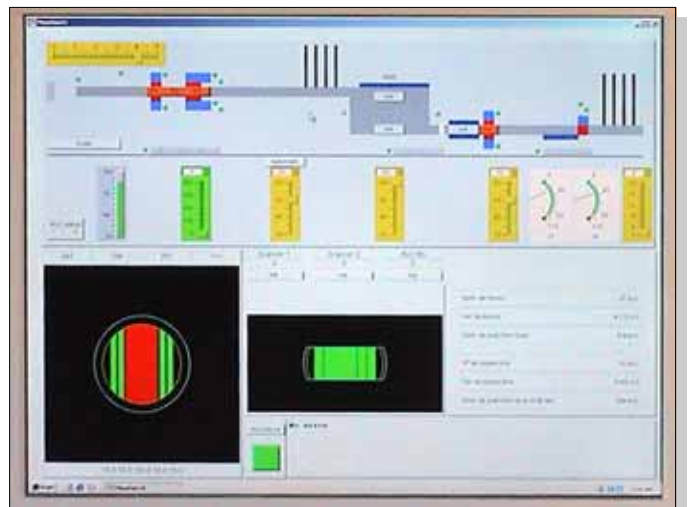
1. Log intake



2. Centring unit



3. Control room



4. Optimizing system



5. Outfeed conveyor



6. Cross-cut saw



7. Cant centring



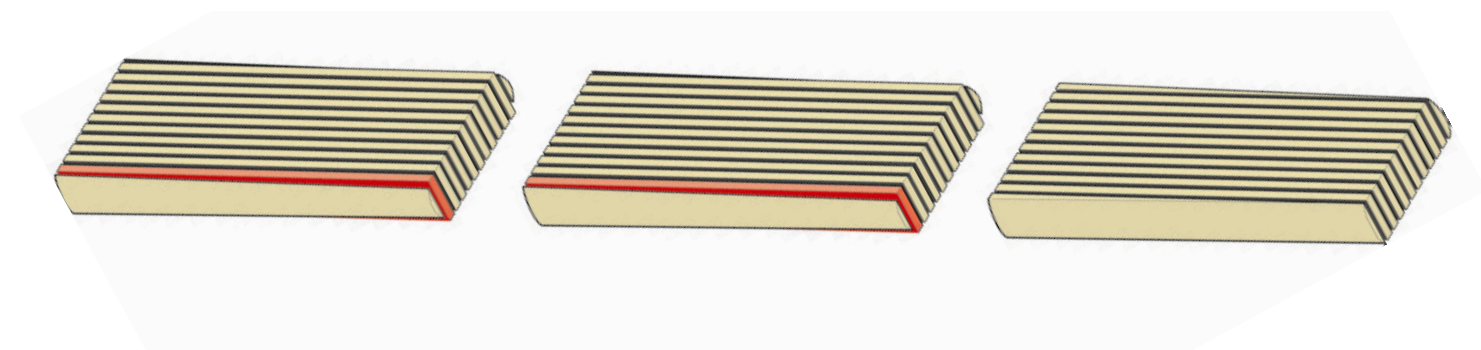
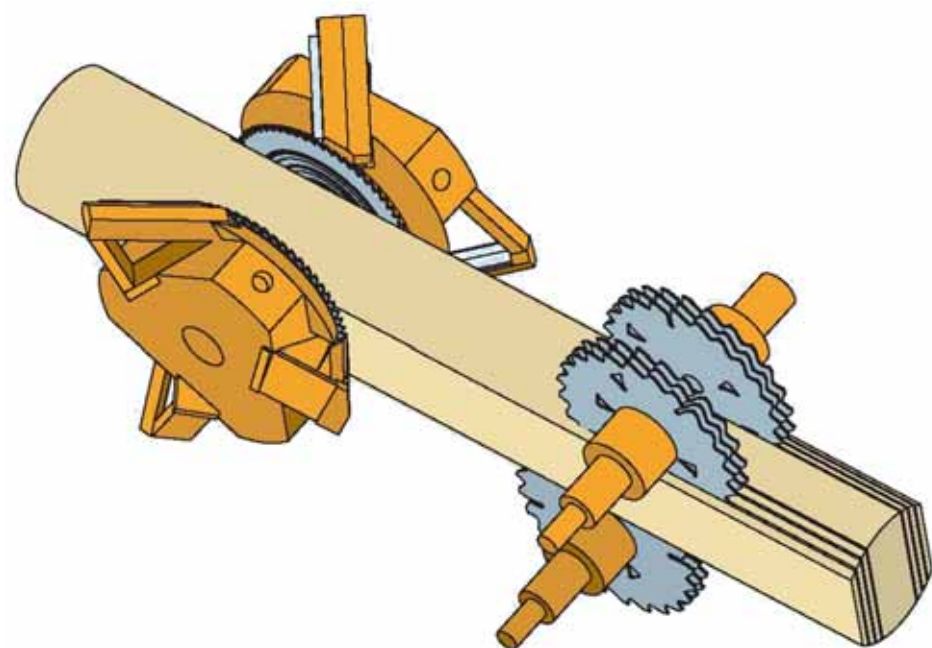
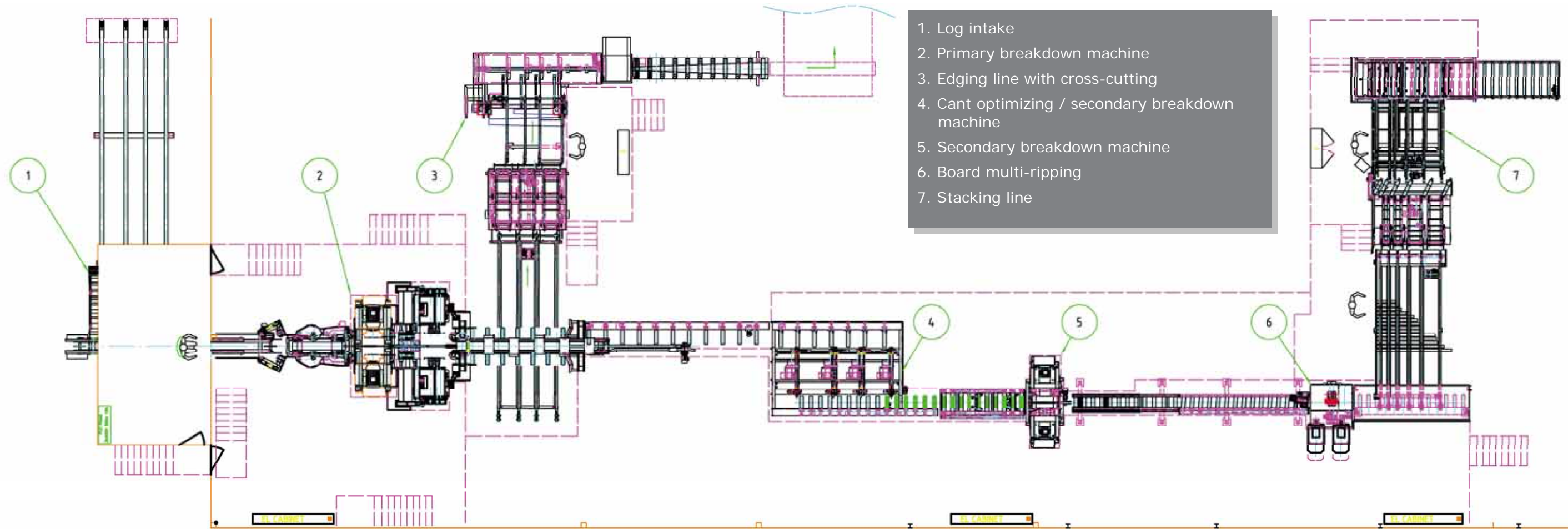
8. Chipper canter 2

Range: (incoming logs)

Length : 1.8 – 3.6 m
 Diameter : 10 – 40 cm

Range: (after processing)

Side boards : 1.8 – 3.6 m
 Side boards sizes : 15 – 50 mm
 Main product : 0.8 – 3.6 m
 Board thickness : 15 – 150 mm
 Board width : 75 – 165 mm
 Production : 6 – 15 logs/min.
 Production volume : 20 – 30 m³ boards/hour



The diagram shows a 3.6 m cant, with a taper of 1 cm per meter, cut into 3 x 1.2 m shorter cants.

The cant cross-cutting philosophy of cutting long cants into shorter cants will increase recovery by min. 5%, without additional costs.

Crook and sweep have not been considered, in regard to this theoretic log, but will indeed improve recovery.

When processing curved cants recovery will increase by up to or more than 25%.



9. Double arbor multi-rip saw



10. Double arbor side



11. Stacking line



12. Board singulator



13. Board fair ending



14. Automatic stick cassette



15. Board turner/dump flap



16. Board optimizing



17. Board edging

Types of lines

For unsorted logs:

The concept of this line is based on a system of 2 scanners, one for logs and one for cants.

The first scanner optimizes number and thickness of the side boards for any given size of centre cant. The primary breakdown machine group operates with variable settings for each log.

The second scanner measures the width of each individual, short cant, and optimizes for maximum recovery by means of the saw bush in the multi-rip saw.

For sorted logs:

The concept of this line is based on pre-sorted logs and one scanner for short cant optimization.

The secondary breakdown machine group operates with fixed settings for each batch. The scanner measures the width of the individual, short cant, and optimizes for maximum recovery, by means of the saw bush in the multi-rip saw.

In general:

High capacity lines can be equipped with 3D log scanning and automatic rotation.

Both lines can be supplied with 3D cant scanning for skewing. An addition to this type of line could be a second cross-cutting/trimming saw, with 2 heads for end-trimming the optimized 4-sided cants, according to specific length requirements, without loss of line capacity.

The boards can be sorted into sorting trays or bins and stacked automatically. Stacking can be done in bundles at a capacity of up to and more than 500 pieces per min., or with a layer cross-cut saw or with sticks for drying.

Board edging can be carried out with a 2, 3 or 4 movable saw blade edger for maximum flexibility.

Solutions

Lösungen

Soluciones

Soluciones

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

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