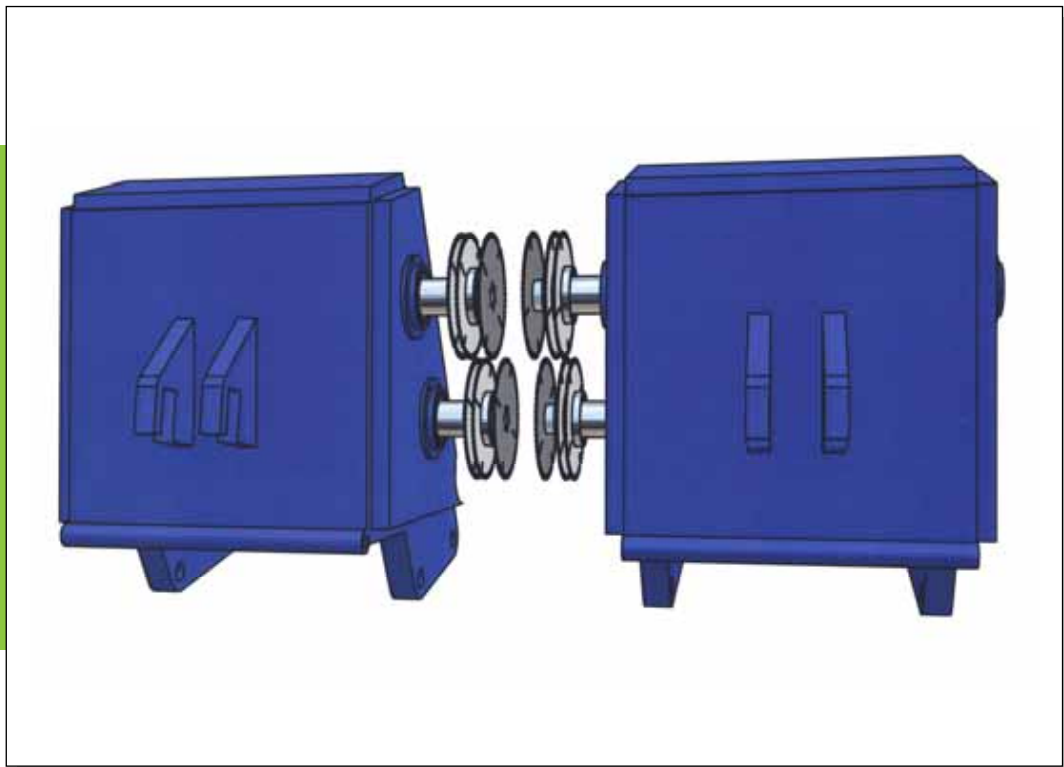




FLEXIBLE SAWMILL



Flexible Sawmill

Brødbæk & Co. flexible sawmill lines for timber production. These types of sawmill lines are based on maximizing flexibility for sawing several different products.

The concept allows for pre-sorted as well as for unsorted logs to be sawn.

Log measuring and optimizing is carried out by use of 3D measuring equipment for maximum recovery or by use of simpler 2D scanning equipment.

The machinery set-up may include band saws or circular saws or a combination of both. The layout can be a straight line, merry go round or a combination. The sideboards can be made by using a profiling line or an edging line.

Brødbæk & Co. sawmill lines are supplied on turnkey basis - wired and tested - to reduce installation and commissioning time.



1. Log deck



2. Log intake



3. Chipper canter infeed



4. Outfeed from 4-arbor saw



5. "Merry-go-round"



6. Multi-rip outfeed

Range in general (incoming logs):

Length : 2.0 - 6.0 m
 Diameter : 12 - 55 cm

Range after processing:

Side boards : 15 - 60 mm thick x
 70 - 200 mm wide
 Main product : 18 - 375 mm thick x
 18 - 375 mm wide
 Line feeding speed : 30 - 60, 50 - 80 or
 90 - 120 m/min
 Production capacity : 20 - 30 m³/hour,
 35 - 40 m³/hour, or
 45 - 50 m³/hour

Other dimensions are possible on request – please ask.

Customer requirements

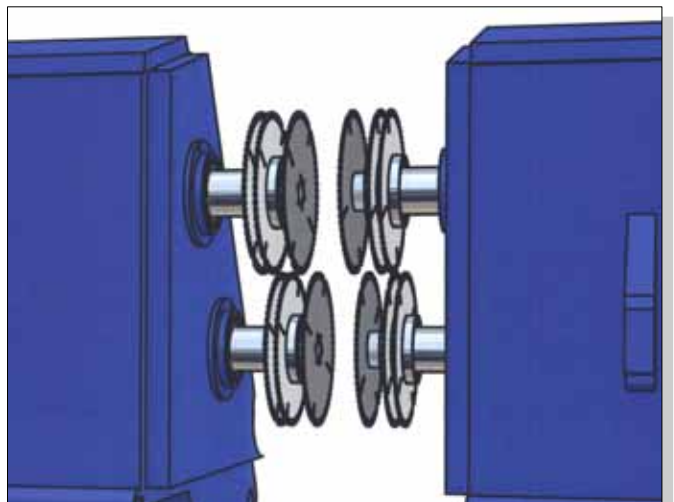
Sawn timber requirements are different for every customer, and therefore no less important.

The Brødbæk & Co. saw line equipment can be supplied to fit individual needs.

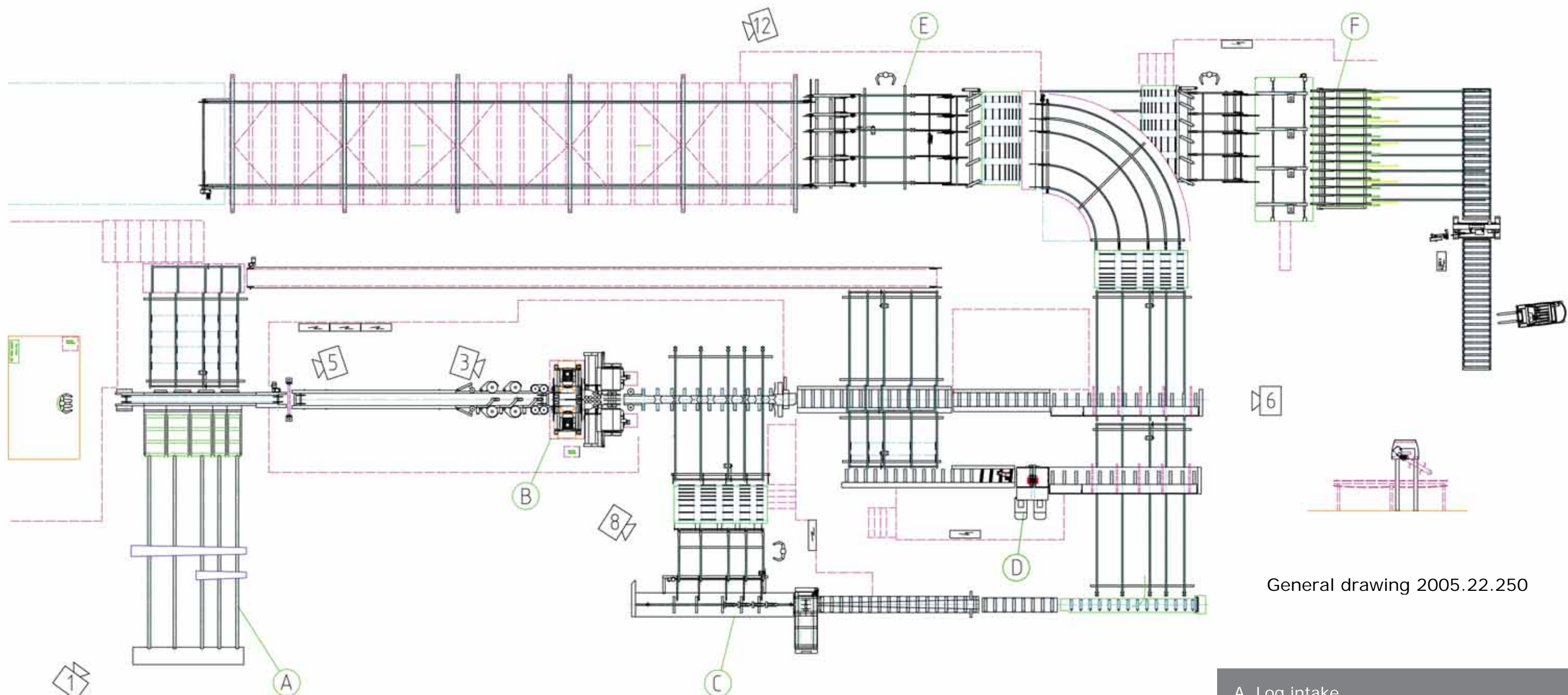
- High capacity or low capacity
- Short or long timber
- Basic sawing or multi-flexible sawing

The Brødbæk & Co. philosophy is to adapt known machine components in order to manufacture and supply a flexible, reliable customer specific solution.

The process of adapting new equipment to existing equipment can be handled by the Brødbæk project team.



7. BCO 4-500 4-arbor saw L2/R2



General drawing 2005.22.250

- A. Log intake
- B. Chipper Canter/4 arbor saw
- C. Edging line
- D. Twin shaft multi-rip saw
- E. Board sorting
- F. Cross-cutting and stacking





8. Edging line infeed



9. Edger BCO 800/60

Edging:

Edging options are numerous - to emphasize a few:

Board edging

- Edging of incoming boards, based on board measurements and edging parameters

Cross-cutting before edging for maximum recovery

- Incoming boards are cross-cut into 2 pieces, individually measured, optimized and edged with the option of producing 2 different board widths from one incoming board

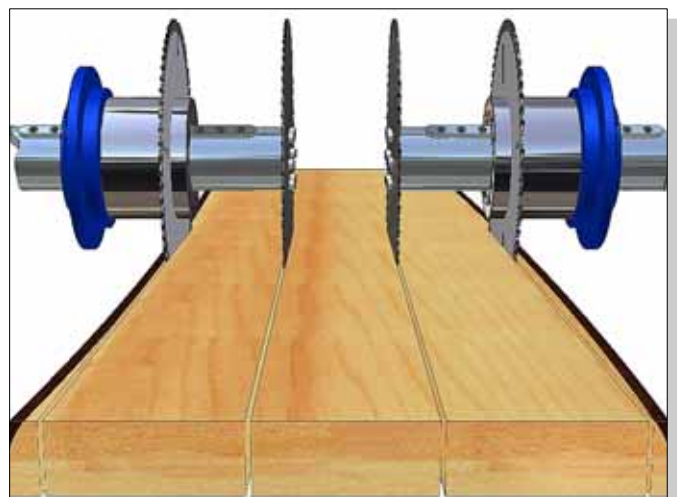
Length trimming of edged boards

- Edged boards can be trimmed according to length during the edging process thus becoming finished, cut-to-length boards - ready for sorting and stacking

The edging equipment can be supplied according to two systems :

- A semi-automatic system with some manual options. The operator is standing up at the cross transfer as a supervisor.
- An automatic system with pre-programmable parameters. The supervisor sits down and commands the line and its functions remotely.

| Technical data for Brødbæk Edger type BCO 800/60 : | |
|--|-------------------------------------|
| Capacity | : Up to 40 boards/min. |
| Board thickness | : 12 – 60 mm |
| Saw blade diameter | : ø 450 mm |
| Feed speed | : 30 – 400 m/min. |
| Main motors, max. | : 2 x 160 kW |
| Hydraulic networks | : 5.5 kW |
| Weight | : 5,000 – 9,000 kg with main motors |



10. Board edging



11. Tray sorting

Sorting

The finished products can be sorted according to 2 principles, depending on whether the saw line is set to saw sorted or unsorted logs.

Brødbæk & Co. offers a wide range of **box & tray sorting systems** for various applications - from simple sorting according to length or thickness to complete 3D board measuring for length, width, thickness & edge quality sorting.

The sorting systems can be fed from a main sawing line, an edging line or an incorporated de-stacking line.

Tray sorting:

Primarily used when the raw material is sorted logs. Each sorting tray can contain more than one whole pack of wood. It is possible to start filling a tray while unloading it, thus only one tray per dimension is needed.

Systems of up to 7-8 trays are normally able to unload boards into a waterfall singulator incorporated in the tray conveyor. If more than 7-8 trays are used they are normally unloaded onto a chain conveyor taking the boards to a waterfall singulator. It is possible to have more than 10 trays in a system.

Box-sorting:

If the raw material is unsorted logs many sorting allocations are often required. In these cases a **box sorting system** is a flexible solution. Brødbæk & Co. manufactures box sorting systems equipped with a J-bar or push bar for sorting boards into vertical boxes by using hydraulic sinking pockets.

The contents of the pockets are gently unloaded onto a chain conveyor transporting the boards to a waterfall singulator.

Brødbæk & Co. also supplies solutions as regards cross-cutting and stacking of sorted boards.



12. Box sorting



13. Stacking of mixed widths

Solutions

Lösungen

Soluciones

Soluciones

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

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