



acceleration, the eccentric ejector for sorting logs with short gaps between the logs, the tandem step feeder for chainless log separation, and the original rollerway for alignment with transfer wheel for reducing the gaps between the logs.

Holtec has delivered more than 250 log handling systems. Recent domestic successes comprise the logyard and the sawmill infeed at the sawmill Egger in Brilon as well as the mechanisation for handling long logs at the company Ladenburger in Kerkingen. This system started-up at the beginning of this year.

Overseas, It has been trusted abroad with the new sawmill for James Jones & Sons in Lockerbie, UK, which was delivered recently with full logyard and sawmill infeed. The requirements for handling these difficult logs from Scotland are met by a special system technology. The humid, mild climate enables fast tree growing and causes higher-than-average butts. Diameters more

than 700 mm are common. Bars from 2.5 to 5.1 m are loaded on the log deck without sorting according to butt-end and top-end. The separation and allocation is made by the a.m. tandem step feeder. The bars then run on the first longitudinal conveyor through a 2D measurement system.

According to the results of this measurement the logs are either directly transferred by a further step feeder and infeed conveyor to a turning device or, depending on the position of the butt-end and top-end, are conveyed to one of the two butt reducers.

There are six log storage steps before each butt reducer, which guarantee a continuous working process. Directly in front of the butt reducers are the bars aligned by a rollerway to a defined zero line. All bars, reduced or not, are then fed in-turn into the turning device using step feeders followed by an infeed conveyor. Behind the turning device the logs are optimally accelerated using the v-rollerway and are gap-optimised fed with top-end first into the Valon Kone debarker.

Behind the metal detector the bars are 3D-measured on the sorting conveyor and recorded by

The log yard has long since carried the responsibility of efficiently sorting logs for cutting assortments before sawing and for over 35 years these demands have been met by German supplier, Holtec. In order to meet the individual requirements of the different operation sizes, the company offers log handling systems in three performance classes.

Innovative solutions are especially advanced in the high performance segment 'solid plus' and after realisation they are transferred to the other performance classes 'basic line' and 'solid line', too. The latest Holtec developments comprise the V-rollerway for log



View to step feeders and butt reducers at James Jones, UK



The Holtec tandem step feeder enables execution without chains, sprockets, or mechanical sliding surfaces and hydraulic consumers reduce wear and costs for maintenance and lubricants



video camera in a fully automated process. This guarantees an optical documentation of each log with front side and back side. All measurement data and pictures can be opened companywide and enable a complete, gap-free check of the delivered logs. The measurement electronics and the Woodarchiv are from the company JÖRG Elektronik.

The bars are sorted into 20 concrete boxes. The sorting capacity is some 1,900 m³/shift, depending on the log diameter and length.

Once in the sawmill, the bars are sawn on a chipper canter

profiling line. To bridge the height between the log deck and sawing line, the bars are separated with a rail cross conveyor complete with integrated rollerway for alignment, which is followed by a step feeder and allocated to a v-rollerway. By means of the new dynamic gap optimisation, GapControl, the gaps between the logs are reduced in longitudinal conveyance and aligned to a defined measure. This reduces log gaps reduced by up to 50% to significantly increase the working degree and the output capacity of the main sawing machines **IF**



The v-rollerway – pairs of rollers at right angles to each other that set new standards in the field of log acceleration