

72

sorting boxes



HASSLACHER GRUPPE  
Preding / AT

REFERENCE  
02.19

Together we make your project a  
**Story of success**



700,000

solid m<sup>3</sup> per year  
in two-shift operation



Log yard with  
dynamic gap control

HASSLACHER Group relies on a solution from Holtec.

**HOLTEC**

Holtec GmbH & Co. KG  
Anlagenbau zur Holzbearbeitung

- Dommersbach 52  
53940 Hellenthal
- +49 (0) 2482/82-0
- +49 (0) 2482/82-25
- info@holtec.de
- www.holtec.de



HASSLACHER

**HOLTEC**



## Exploring new paths

For the first time in the group's history, HASSLACHER Group decided to install a log yard made by Holtec at its Preding site

In September 2019, the commissioning of the new log yard has been finished successfully at HASSLACHER Group in Preding. About 34 years after the old yard was built, it has been renovated in two steps. The exchange of the log yard was part of a 30 million Euro investment package for the site in Preding. In 2018 they started with the enlargement of the drying capacity followed by the new installation of the log yard in 2019. In spring 2020 a new saw line was installed. Additionally, Holtec renewed the "bottle necks" of the sawmill infeed in this step. The separation and feeding are now made by means of a tandem step feeder. The acceleration conveyors as well as the feeding in front of the saw line have been optimized by the Holtec log runner.

### Log yard designed for 700,000 solid m<sup>3</sup> per year

For the first time in the group's history, they decided to install a complete solution made by Holtec GmbH & Co. KG. The installation is designed for a capacity of 700,000 solid m<sup>3</sup> per year in two shifts. "Certainly, we talked also to other suppliers, but all in all Holtec quoted the best package.", Manfred Steinwiedder, general manager of HASSLACHER PREDING Holzindustrie GmbH, explained the decision. One of the main points for this decision was the exact planning which created confidence as well as the convincing solutions in detail and for the whole system.

### Commissioning before the scheduled time

Only eight months after signing the contract, Holtec started the installation in Preding. To keep the downtime and the log logistics as small as possible the whole project has been divided in two steps. Step 1 was the feeding zone with separation and feeding to the measuring line. All this is placed opposite of the existing installation. "This way we could start the installation of step 1 while running the full production", Thomas Bierbacher, responsible for the new project at HASSLACHER PREDING Holzindustrie, explained. In step 2 the whole debarking line up to the sorting line has been exchanged. The downtime took 6 weeks and 5 days, including foundation works and commissioning. So the works could be finished two days before the shortly calculated time.

### Track record – Chainless

The installation started with the log infeed. For this, two separate log decks have been installed with a separating unit in between to separate one truck load from the next. The separation includes a tandem step feeder and charger. Then the short logs run on a cross conveyor through a milling disk which treats the soiled and discoloured front sides on a variable length of 1 to 5 cm. The step feeder is the main part of the chainless principle Holtec has developed 10 years ago. The most important point is to avoid chains and hydraulics. For the milling disk there were several advantages to use this in the high performance project. High stability on one hand as well as the low space requirements. Additionally, a further advantage was that the product of the milling disk is a chip and not a cut disc. So the product can be conveyed directly to the CHP.

### Gap-Control

After the cross-conveying in the separation zone, the short logs are transferred to the Holtec log runner. The rollers placed in V-shape guarantee an optimal acceleration of the short logs. By means of an intelligent control via laser and light barriers Holtec realises the dynamic "Gap-control". The optimised gap between the short logs provides for the best possible throughput rate. Based on a 3D measuring result, short logs which are classified as not sawable, are sorted out. For this, three special boxes have been installed in front of the debarker. The measuring provides information about the butt ends and decides automatically whether a log has to be reduced via the by-pass or not. After being reduced the short logs are fed again to a rollerway before the debarker. The gap is here also reduced to a minimum of 60 cm. The debarker is the bottle-neck of the system. So, it is more than important to keep the gap as small as possible. Behind the debarker the logs are scanned for metal. In the metal detector area Holtec installed a massive 60 mm thick plastic tube. After that the short logs are measured again and finally sorted into the 72 boxes on the 200 m sorting conveyor.

**HASSLACHER  
NORICA TIMBER**

From **wood** to **wonders**.

”

*One of the main points for the decision was the exact planning that created confidence and furthermore the convincing solutions in detail as well as for the whole system.*

Manfred Steinwiedder  
General manager

“

### Focus on cleaning effort and noise protection

The sorting conveyor is completely closed on both sides. Also the ejection stations as well as the chain return do have a complete sheet lining. So the waste is directly collected in the return of the conveyor. Thomas Bierbacher confirmed that this results in a very clean installation and that the cleaning works could be reduced to a minimum. The whole bark transport is realised by Holtec. Beside the cleanness, they paid a lot of attention to the noise protection. Therefore, Holtec installed quite all installation elements onto rubber-bonded metal rails. By optimising the transfers and thanks to a special geometry of the sorting boxes, further noise protection was given. Half a year after the commissioning of the system, Mr. Steinwiedder draws a really positive conclusion: "Holtec has been doing its very best from the beginning and they realised all they promised. For us, this has been a really successful project."

