

Hogue Industries High Speed Dual Fork Stacking Systems

Hogue Industries provides complete High Speed Dual Fork Stacking Systems with all of the infeed and out feed equipment.

Incline Chains with 81-XH chain, head shaft drives, and gear motors mounted at the far lumber line side for easy access.

The Incline Chains feed a bar unscrambler with heavy duty steel bars for 1" through 6" thick lumber, jamb relief gates in the trough, adjustable lift skids for the varying lumber thicknesses, a 2 15/16" head shaft and gear motor mounted on the far lumber line side. Beveled ends to the bars plus side skirts are also a standard in our design. The Unscramblers are also provided with a self-timing bar arrangement.

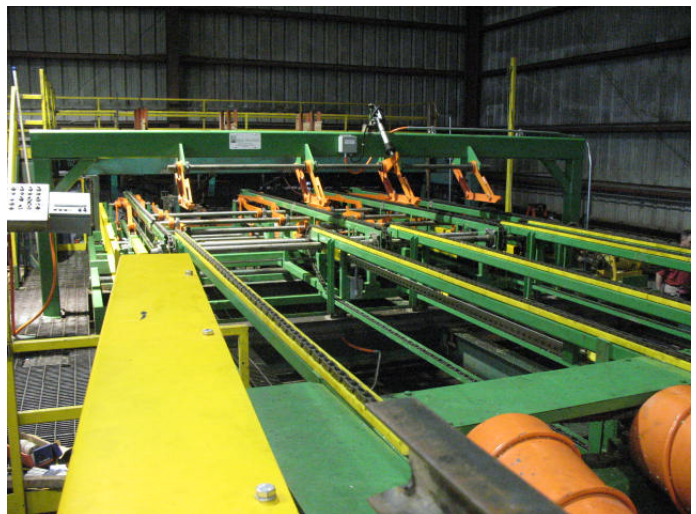


The Unscrambler feeds onto spiral rolls that utilize a belt even ender to establish the lumber line going into the Dual Fork Stacker.



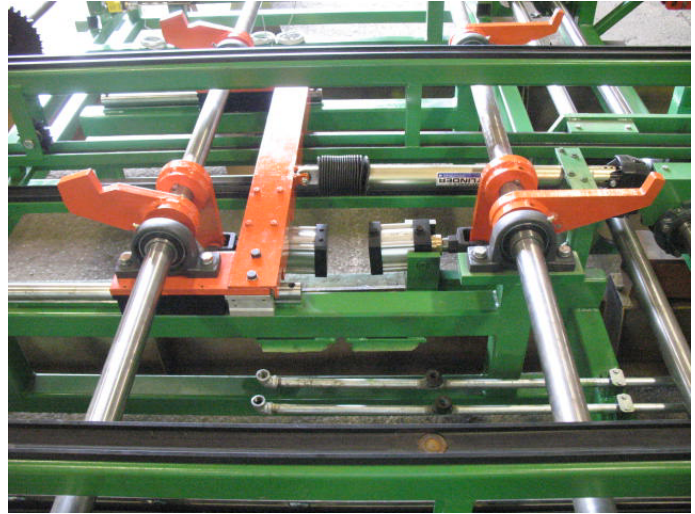
The incline chains, unscrambler, spiral rolls, belt even ender, and infeed chains are individually driven with VFD's for optimum performance.

The spiral roll system feeds the lumber at 150 FPM onto the stacker infeed chains.



The lumber course make up is located at the beginning of the stacker top chains. The over head hold down system is infinitely adjustable for 1" through 6" thick lumber of all grades. It is supported by a spanning bridge that frees up the entire operators work area.

The lower course pinch off is adjustable for the various package widths produced, and both the upper and lower width and thickness positioners are automatically set by entering the lumber to be run within the product tables on the operator console touch screen.

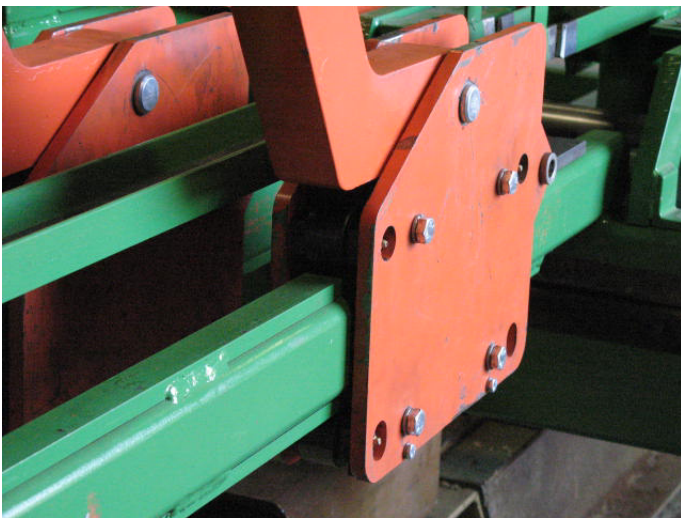


The lower course pinch off is unique in that it not only pinches off the course of lumber to be stacked, but raises up to block the incoming layer of lumber against the face of the pinch off arm so that lumber can't push its way through the pinch off.

Once the course of lumber is formulated and released, it is sequenced through the stacker top chains to the stacking arm staging area. This allows the operator time to correct any cross ups, and “cherry pack” before the course of lumber is on the stacking arms.

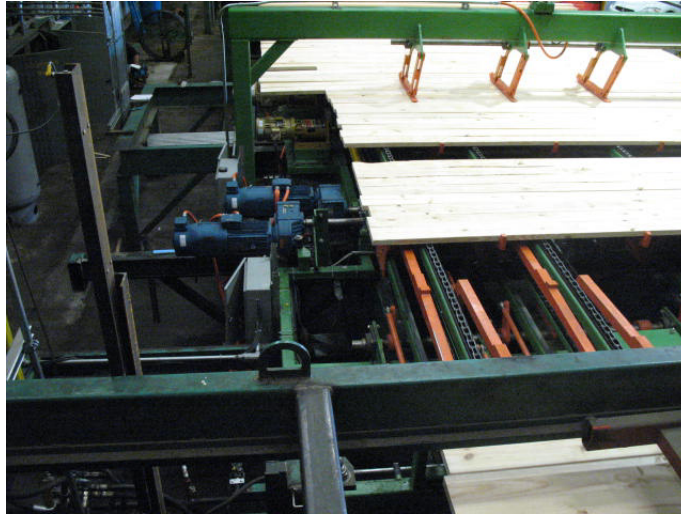


The Dual Fork Stacking arms ride on bearing sled assemblies with yoke style cam followers. The bearings ride on AR plate, and the arms are powered back and forth by a rack and pinion system.

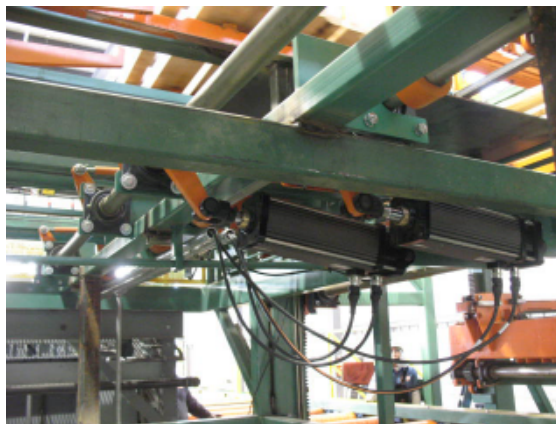


The Dual Fork Stacking Arms are set to cycle up to 26 CPM whenever a completed course of lumber is in position to be stacked. This will net about 22 layers per minute when stacking dimension sizes. There are 5 speed levels and are automatically or manually set depending on the product size.

The rack and pinion stacker arm drive shafts are powered by gear motors with VFD / Vector drives.



The Dual Fork Stacking arms are raised and lowered with crank arms on shafts, powered by Electric positioners. Hydraulic positioners could also be used in this area if hydraulic systems are available. The hydraulic positioners require about 22 GPM at 2000 psi to run at 24 cycles per minute.



The same machine running the 1" to 4" thick lumber up to 26 CPM is also running 6 x6 up to 12 x 12-- we use both sets of arms under the timbers at the same time, so you get twice the support, yet the higher speeds for dimension lumber.



This is a shot of us stacking 8" x 8" x 30' long Timbers using both forks at the same time.



The same machine stacking 10 x 10's--



Package Accumulation Lifts

The package accumulation lifts are available with no leaf chain raising and lowering them for the lighter package applications, or a leaf chain wrap-up design for the heavier loads. Either way, the lifts utilize a rack and pinion stabilizer system to keep the load level. The primary lift will rise to its up position in a little over 6 seconds. The package accumulation lift gear motor drive utilizes a VFD / Vector drive to index and hold its position electrically. Brakes are provided on the drives generally for power off conditions.

Planermill Full and Half Pack style of Package Accumulation Lift



Secondary Lift receiving layers while the Primary is discharging



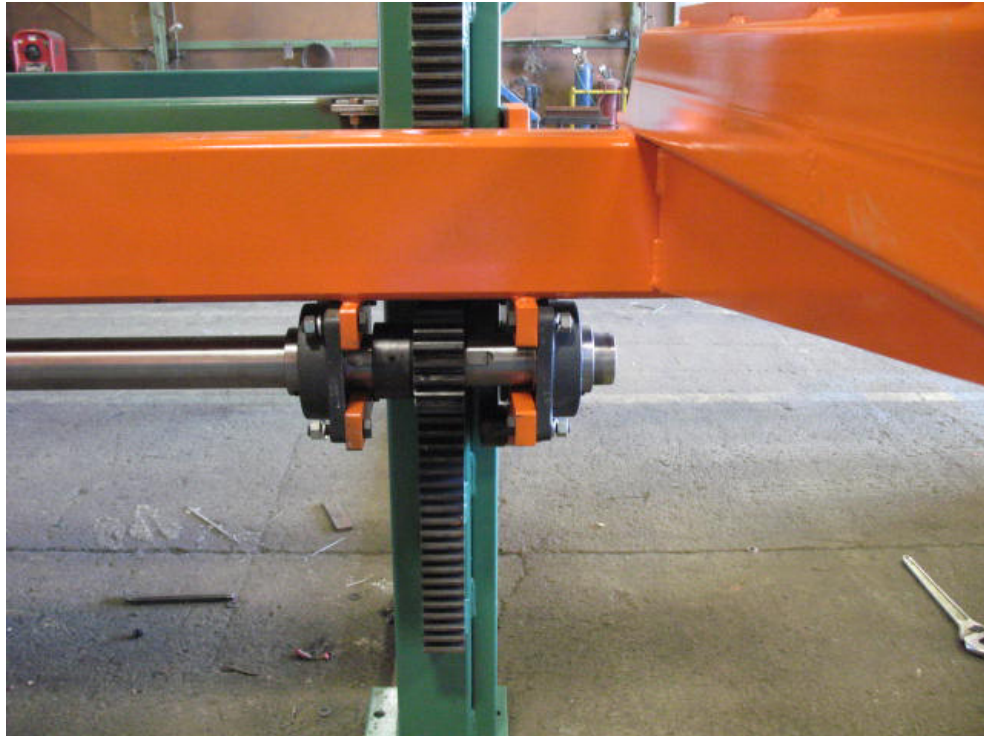
Retract Position



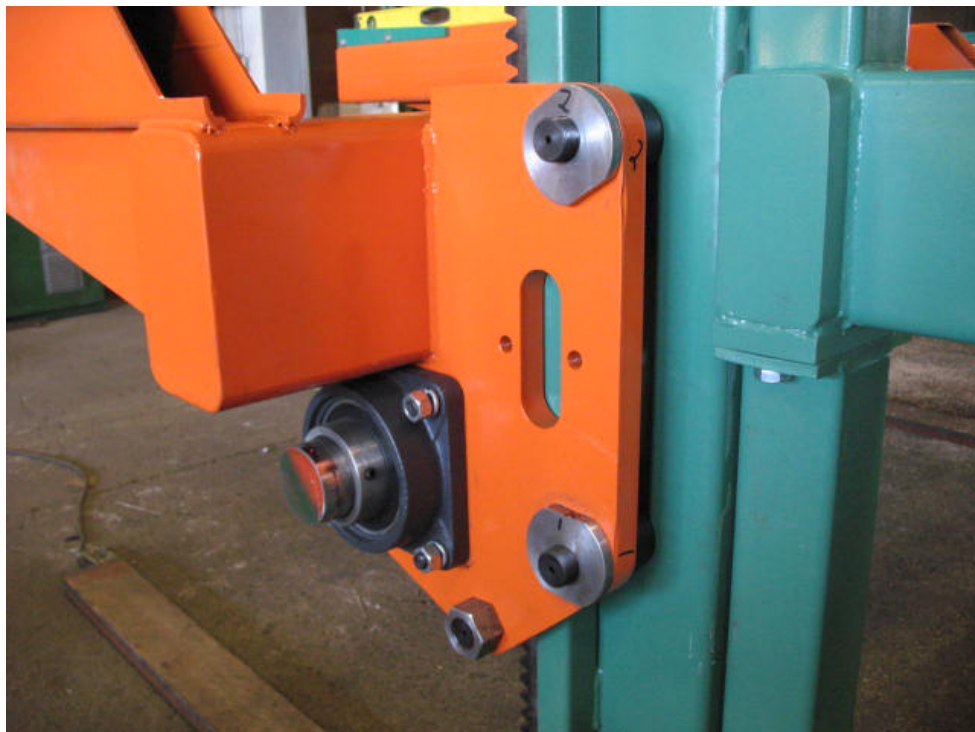
Sawmill Package Style of Package Accumulation Lift – Hydraulic Cylinder or a wrap up Leaf chain shaft with Gear Motor drive are both available



All Lifts have a rack and pinion stabilizer shaft assembly to keep it level side to side



Eccentric Bushings allow the lifts to be level front to back



New Product Development

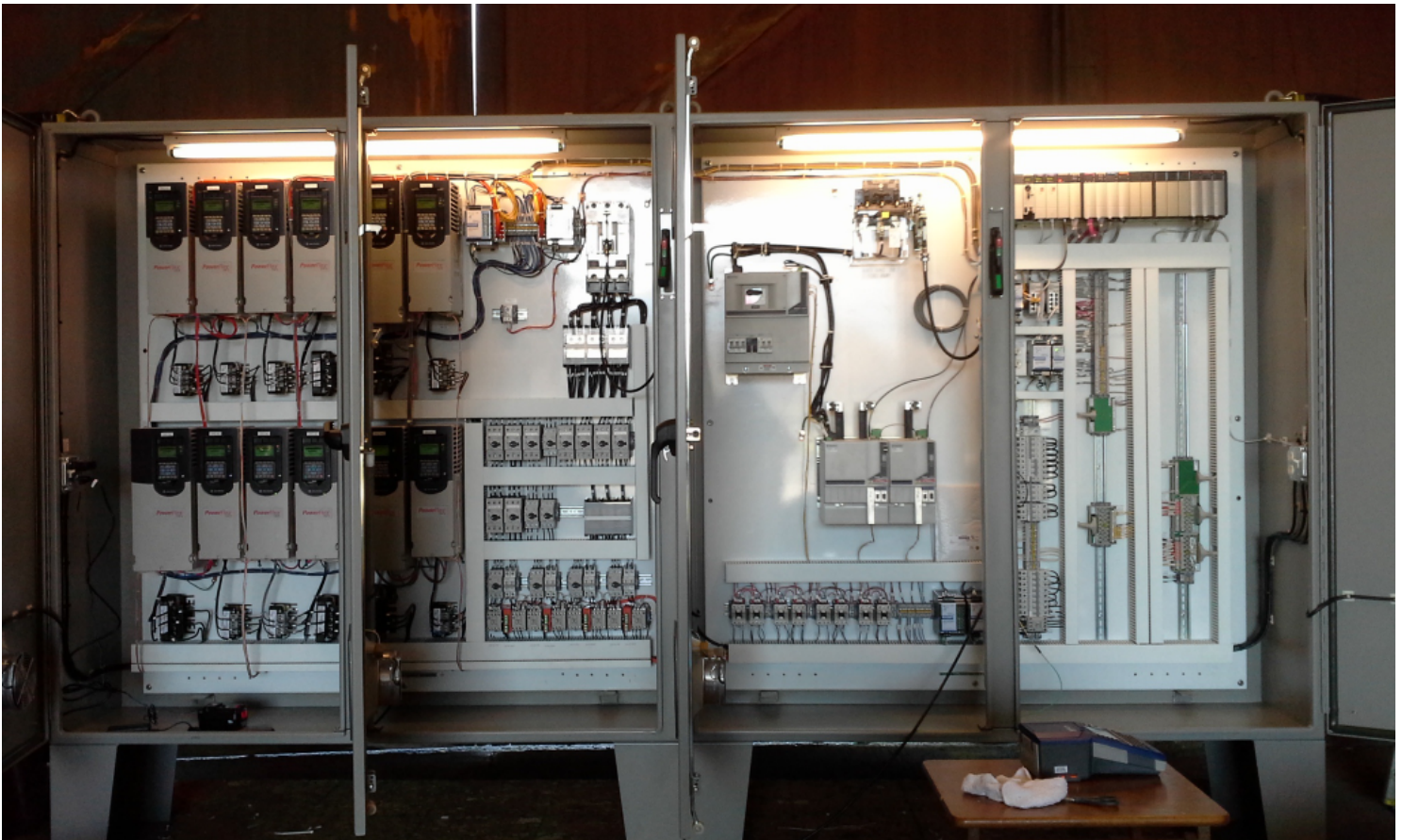
Hogue Industries has recently developed an infinitely adjustable Package Compression and Retaining System for the Package while it's still on the Accumulation Hoist. This will allow for an automated package retainer applicator that is to hold the package together until it arrives at the strapper.



The 4' long vertical arms are used to crowd each course as it is placed on the package being formulated as well as also used to compress the completed package for the automatic application of the package retaining hoop in order to hold the package together as it is lowered and transported to the strapper.

Controls Systems

We also provide the complete PLC Control System along with all of the VFD and Vector drives if you wish. Operator consoles with touch screens are also a standard.



The VFD enclosure is available as shown or as the Allen Bradley 2100 style of MCC Enclosure



You can see videos of the various systems running on YouTube through our web site--

Thank you—

Gary Hogue
Hogue Industries
503-656-5100

ghogue@hogueindustries.com

Patent protected—US 7,201,554 & 7,651,314 Canadian 2,463,210 & 2,590,852, and patent pending for the course crowder / hoop applicator system

2961 Ascot Circle • West Linn, Oregon 97068
Phone: (503) 656-5100 Fax: (503) 656-5111