

## STONOGA – an automatic machine for long pallet legs

### Product application and description:

- a board with blocks - joined using nails
- as a leg for a conventional pallet

### Fasteners, tools:

- 50 - 90 mm long nails in Jumbo coils
- three nailers with Jumbo coil drums



STONOGA 3000 is designed for fast production of pallet legs with lengths up to three meters with any number of blocks. STONOGA 3000 is intended for the production of legs of different lengths and a different number of blocks without the necessity to make any mechanical adjustments. The machine comprises of a board magazine and a single magazine for blocks - all settings for the number and spacing of the blocks are configured by the operator on a dedicated control panel. Therefore, settings can be changed very quickly, which significantly boosts the effectiveness for short production batches of non-standard elements. The nailing module is based on three nailers with JUMBO nail drums, which allows for the nailing of 600 blocks without interruptions before the need to reload the nails. The magazines of boards and blocks can be reloaded during machine operation (without the necessity of stopping it). The nailing process can be additionally integrated with an industrial robot which collects the legs and transfers them to the pallet-top mounting station.



The controller can be freely programmed in terms of the quantity and position of pads for any board lengths.

### Dimensions of nailed products for „3000" version:

- board lengths: 600 - 3,000 mm
- board and block widths: 70 - 140 mm
- block height: 75 - 100 mm

The machine is intended to be operated by a single employee. Boards can be replaced in the magazine and a new operating program must be selected to change the product type.

### Operation of the machine:

The operator manually places the blocks and boards in the magazines.

Both magazines can be refilled during operation.

The employee selects a proper nailing program on the control touchpanel. The entire operation cycle is automatic.

### Capacity:

The nailing duration is independent of the operator.

The nailing duration can be approximated with the following formula:  $T_z = 5 + n \cdot 2$

where:  $T_z$  [s] - nailing duration for a single block,  $n$  - number of blocks in a product.

For example, a 1,200 mm long product with three legs takes 11 seconds, for a 3-meter board with 5 blocks - 15 seconds.

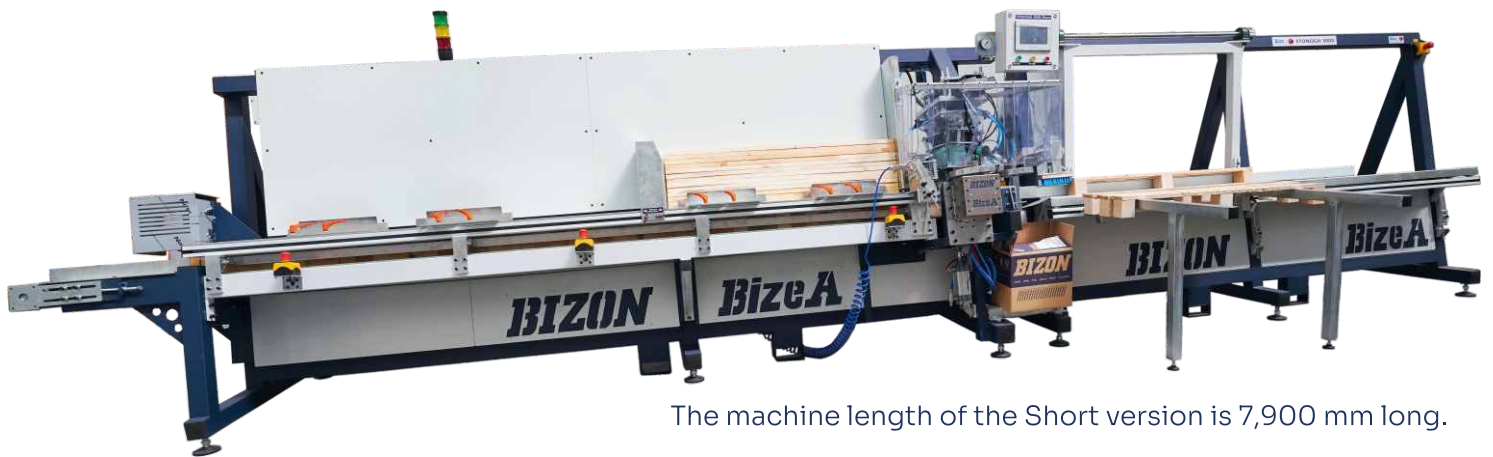
When nailing short elements only, the installation of a greater number of board pushers will increase the production capacity.



Three nailers with JUMBO nail drums - nailing at the same time



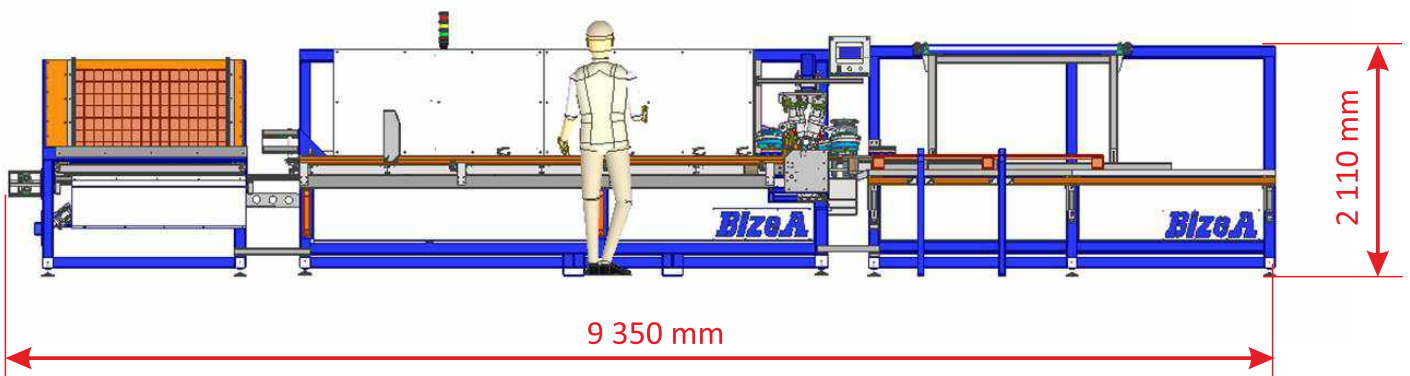
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The machine length of the Short version is 7,900 mm long.

## Stonoga Short

We can also offer the STONOGA machine in a SHORT version, where, instead of the magazine for feeding blocks, short conveyor belts are used to transport the wooden blocks directly from a table saw.



The presented STONOGA 3000 - standard version, requires space in the production hall with dimensions of at least 10 by 3.5 meters.

