



**SYSTEM HALL**  
INCREASING EFFICIENCY IN THE WOOD INDUSTRY

# LFP 250

LFP 250 ENG 1 2019

## Line for panel 250

**LFP 250** is mainly developed to run products that require bundling, the handling to the resaw makes it especially good for panel even though its name the line can handle battens and construction wood as well. Much like the LFC250 the whole line is tuned and operated by panels that makes it easy for the operator to change timings and speeds on the line with savable recipes for your different products.

The bundle unit that is the heart in the line has been developed over many years and is constantly getting upgrades in the same pace as the technology advances. The latest development that is a option is that some parts are switched from pneumatic to servo-motors.

All the well-known units in the line for example tilt, elevator and stacker are units that is reliable and all spare parts are ready and available from the System Hall HQ.

*Can't find an option that suits your company? Feel free to contact us.*

## Technical

### Line for panel 250

Pieces per minute: maximum 60 p/m

Length: 1,8 – 6 m

Max width: 245 mm

Min width: 50 mm

Max thickness: 100 mm (Not when bundling)

Min thickness: 9 mm

Packet size (infeed): 1,2 x 1,2 m

Packet size (outfeed): 1,2 x 1,2 m

Max pack weight: 4000 kg

Color frame: RAL 1015

Color moving parts: RAL 2004



## LFP 250 capacity figures

PROFILE	PRODUCT	THICKNESS (mm)	WIDTH (mm)	LENGTH (m)	SPEED MOULDER (max 250 m)	PIECES/MIN AFTER MOULDER (max 60)	HIGH BUNDLE (pieces)	BUNDELS/MIN (max 10)	M3/HOUR
	Internal panel	11	96	3	150	50	10	5	7
				4,2	200	48	10	5	9
				6	200	33	10	3	9
	Internal panel	12	121	3	180	60	8	8	11
				4,2	200	48	8	6	12
				6	200	33	8	4	12
	Internal panel	14	146	3	180	60	6	10	15
				4,2	200	48	6	8	17
				6	200	33	6	6	17
	External panel	21	120	3	180	60	6	10	19
				4,2	230	55	6	9	24
				6	230	38	6	6	24
	External panel	21	145	3	180	60	6	10	23
				4,2	230	55	6	9	29
				6	230	38	6	6	29
	External panel	21	170	3	180	60	6	10	27
				4,2	230	55	6	9	34
				6	230	38	6	6	34
	External panel	21	195	3	180	60	6	10	31
				4,2	230	52	6	9	38
				6	230	38	6	6	40

# Sideview infeed

## 100. Buffer transport

Two buffer slots for packs and one slot where the pack gets fed in to the line.

## 101. Pack tilt

Lifts the pack and tilts it so that each layer falls down to the receiving conveyor, the sticks falls down simultaneously to the stick conveyor below.

## 102. Down fall conveyor for sticks

Receives the sticks and transports them to a container or optional to a stick handling system (Opt.1).

## 103. Receiving conveyor

Receives the layer from the pack tilt and transports it to the elevator unit.

## 104. Elevator unit

Lifts the pieces one by one up to the buffer conveyor.

## 105. Buffer conveyor

Area for visual inspection.

## 106. Piece picker

Holds the piece so that the cup measuring unit can determine the cup and then sends it away one by one.

## 107. Cup measurement

Measures what position the cup has and tells the turner if it should turn the piece or not.

## 108. Pneumatic turner

Turns the pieces to the right side for mouldering.

## 109. Gate

Depending on what recipe that the operator has chosen the gate adjust to go through bandsaw or directly to the moulder. In it's upper position (bandsaw-mode) the gate functions as a return gate.

## 110. Infeeding unit

Grips the pieces one by one and sends them to the moulder.  
*Opt.1 Stickhandling system*  
This system collects the sticks and bundles them, banding is done manually.

## 200. Bandsaw infeeder

Adjustable to feed the material both horizontally and vertically to the bandsaw.

## 202. Elevator

Lifts the material directly when leaving the bandsaw.

## 203. Material separator

When resawing vertically this unit separates the lowest material from the top material.

## 204. Pneumatic turner

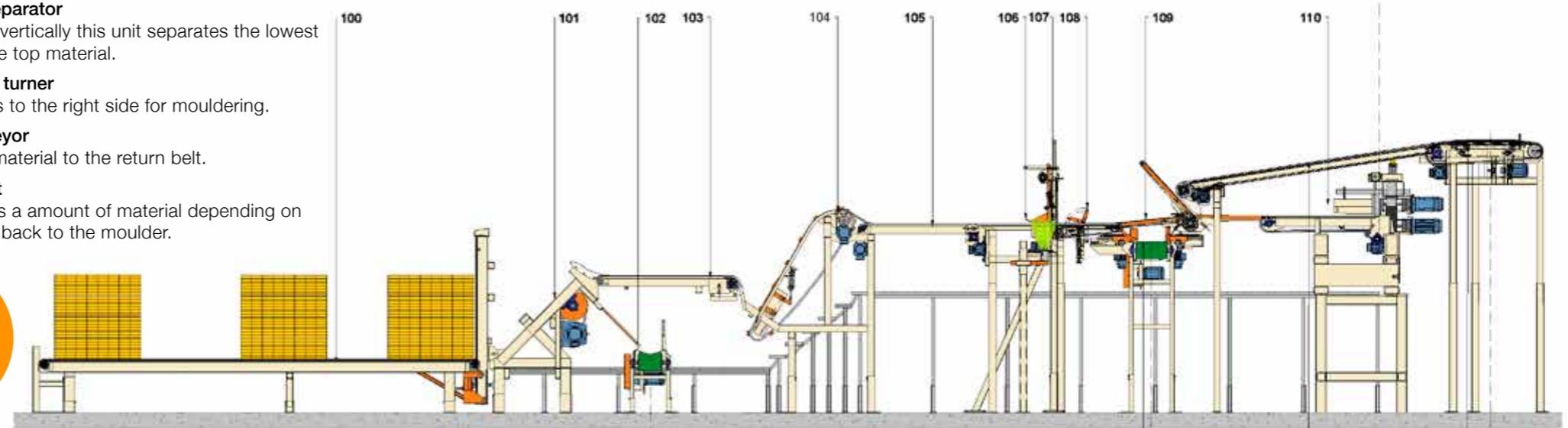
Turns the pieces to the right side for mouldering.

## 205. Side conveyor

Transports the material to the return belt.

## 206. Return belt

This belt collects a amount of material depending on width that goes back to the moulder.

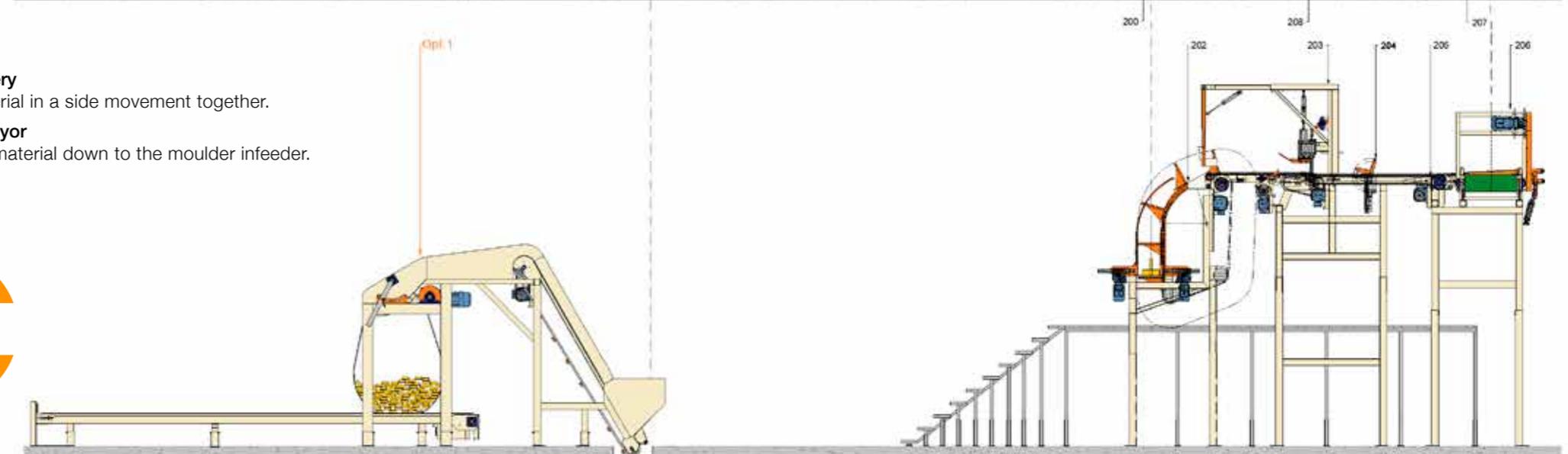


## 207. Side delivery

Moves the material in a side movement together.

## 208. side conveyor

Transports the material down to the moulder infeeder.



# Sideview outfeed

## 302. Side delivery

Moves the material in one sweeping movement and also corrects the material to a even end.  
Equipped with brake flap for high breaking possibilities.

## 303. Piece picker

Send the material one by one to the sorting turner, equipped with lifting table.

## 304. Sorting turner

Turns the material in a “wing” movement that enables four side inspection, When turned the material gets turned so that the planed side is up.

## 305. Pneumatic turner

When the line is in bundle-mode this unit turns the last piece in the bundle to protect the moulded side.

## 306. Side conveyor

## 307. Gate

Depending on what recipe the line is adjusted to this moves the pieces either to stacker or to bundlestation.

## 308. Side conveyor

## 309. Sorting gate

Depending on operators' choice the gates opens when the operator wants to sort out a bad material.

## 310. Automatic stacker

Fully automatic stacking unit with even end adjuster that keeps the packs even.

## 311. Automatic stick dispensers

Dispenses the sticks on the package automatically.

## 312. Buffer transport

Two slots for buffering packs and one slot where the pack gets built.

## 400. Bundle station

Bundles the material to specified requirement, optional to have servo engines for a faster operation with more precision. This unit can bundle panel, construction wood and battens.

## 401. Strapping units

## 402. Place for foile machine

## 403. Bundle stacker

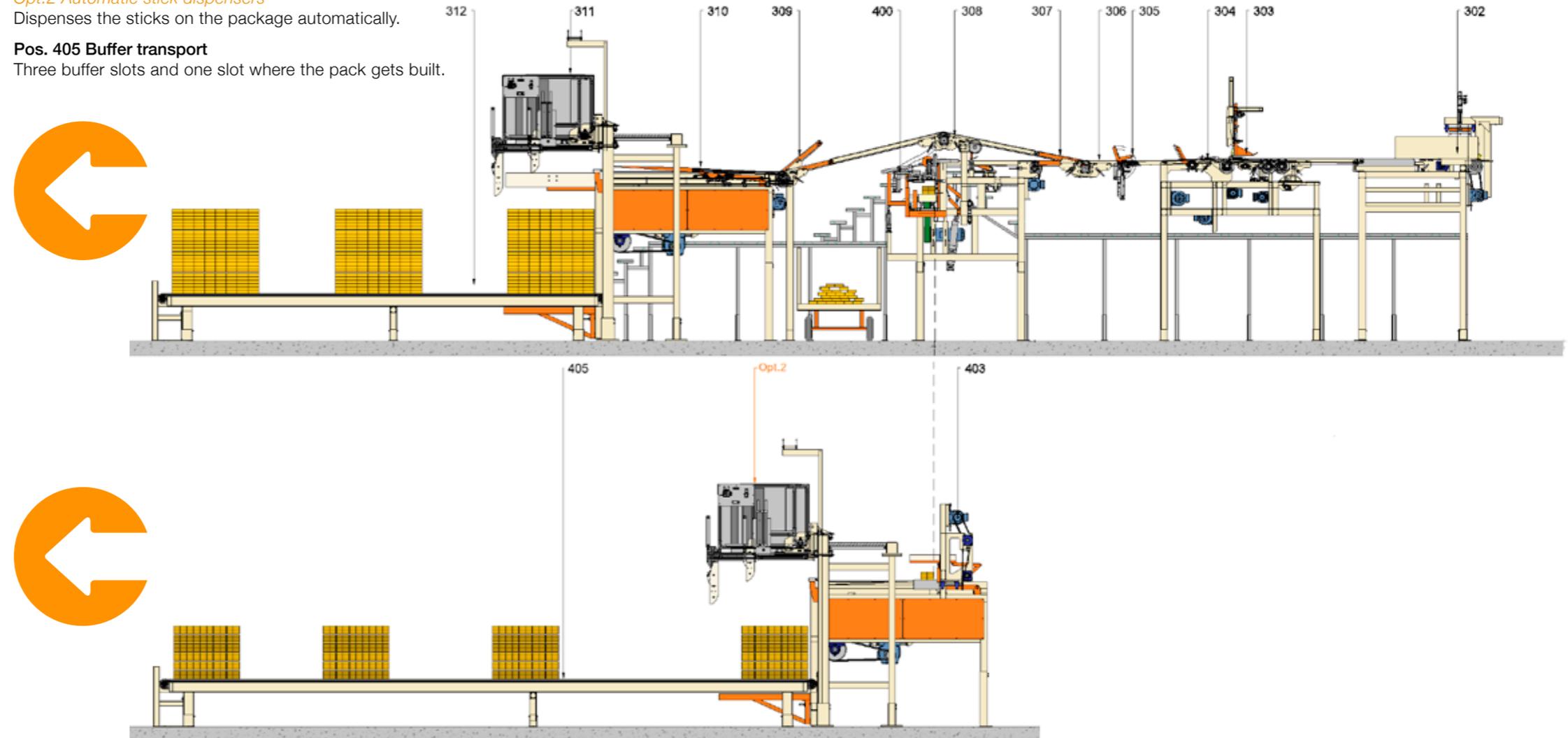
Stacks the bundles automatically.

*Opt.2 Automatic stick dispensers*

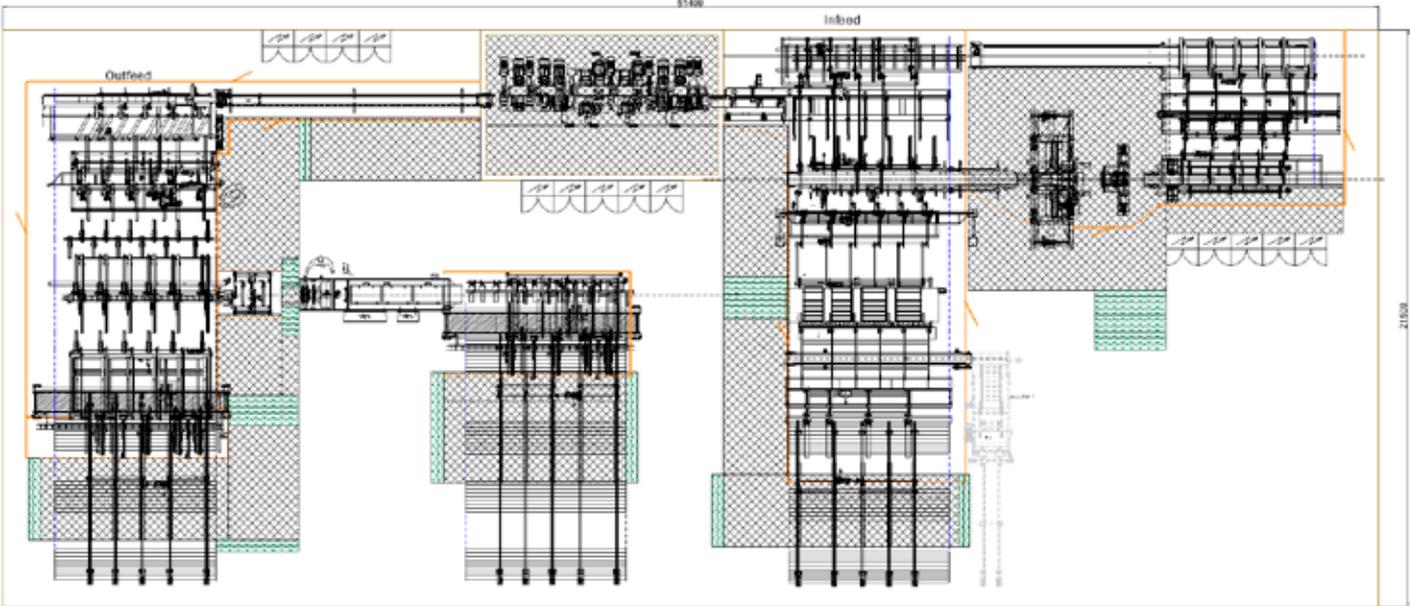
Dispenses the sticks on the package automatically.

## Pos. 405 Buffer transport

Three buffer slots and one slot where the pack gets built.



# Overview line-setup



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