

DRYER INFEEED LOAD ACCUMULATOR



Westmill's Accumulator can be installed in your existing system, or as part of a new Dryer Infeed system.

Westmill's Dryer Infeed Accumulator keeps your Dryer line running uninterrupted during the changing of the infeed load stacks.

Typically, a Dryer without an Accumulator will not be able to feed veneer sheets during a load change, which can take from 45 seconds to two minutes, depending on loads and operators.

By using an Accumulator, your veneer production through your Dryer remains constant. Aside from the obvious advantage of continuous veneer throughput (higher production), the use of an Accumulator also prevents your Dryer from running with an empty spot during a load change. Empty spots in Dryers can affect the air flow, humidity, and temperature levels in the Dryer. These can have negative effects on final veneer moisture content.

Westmill's Accumulator can be installed into your existing Dryer Infeed system, or as part of a brand new Westmill™ Dryer Infeed system.



Accumulator supporting veneer during load change.



Accumulator roll with gear and rack



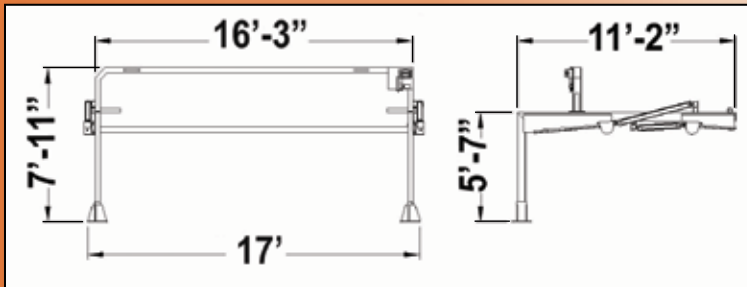
Dryer infeed with accumulator



Pneumatic valves wired to junction box

Product Features and Operation

The Accumulator allows you to feed veneer continuously by supporting the veneer during the load change. The Dryer Infeed Operator activates a hand-operated valve, which causes all four pneumatic cylinders to retract. As the cylinders retract, the two rolls (each driven by a cylinder pair) come from the outsides and beneath the load to support the remaining two inches of each of the the loads (for 1/8" thick veneer, approximately three stacks of 16 sheets). The rolls move via a gear "rack-and-pinion" design, common to Accumulators used in the veneer industry today.



The design is for full 4' x 8' green veneer sheets. Any sheet species may be used, as the design can accommodate different species weights (due to differing densities and moisture sorts – heartwood, sapwood). Accumulating while feeding random-width sheets (width x 8' long) may be possible but is not guaranteed. The Accumulator is not sold with the intent to handle random-width veneers. In some cases,

field modifications must be made to existing equipment to allow for accumulator to work properly with your standard veneer package height.

Westmill's Supply Includes:

- Free-standing main frame (independent of other machinery)
- Roll assemblies with spur gears, rack, and slider assemblies
- Pneumatic cylinders and pneumatic lines to one main customer hook-up
- Hand-operated manual four-way, two-position pneumatic valve
- Filter/Regulator/Lubricator unit
- Airbag assemblies to lift sagging veneer ends before Accumulators advance (if required when mounting to existing machinery. Not required on new Dryer Infeeds)
- Telescoping weld-on leg extensions for precise field elevation positioning (shipped loose)
- Valves and limit switches/proximity switches wired to a junction box

Optional Items Supplied by Westmill:

- Electrical push-button station for Infeed Chain Conveyor control
- Site electrical integration of Accumulator to your PLC (or other) control system
- Installation supervision and commissioning (mechanical and electrical)

Veneer Specifications

| | |
|--------------------------------|---|
| Veneer size: | Standard design: Any clip width x 8' length green veneer Designs available for any clip width x any veneer length 4' or longer |
| Veneer species: | Any |
| Green veneer moisture content: | Any |

Machinery Specifications

| | |
|--------------------------|--|
| Electrical requirements: | Single phase control power (no 3-phase required) |
| Field mounting: | Anchored to plant floor. Machinery feet have mounting holes. |
| Air requirements: | 60 PSI |

Operational Specifications

| | |
|-------------------------------|---|
| Accumulator operation: | Manual (decision by operator). Can be wired for automatic operation if safety precautions are implemented |
| Number of operators required: | 1 (Dryer Infeed Operator) |
| Operation method: | Hand-operated valve |

