

MPM ENGINEERING LTD.

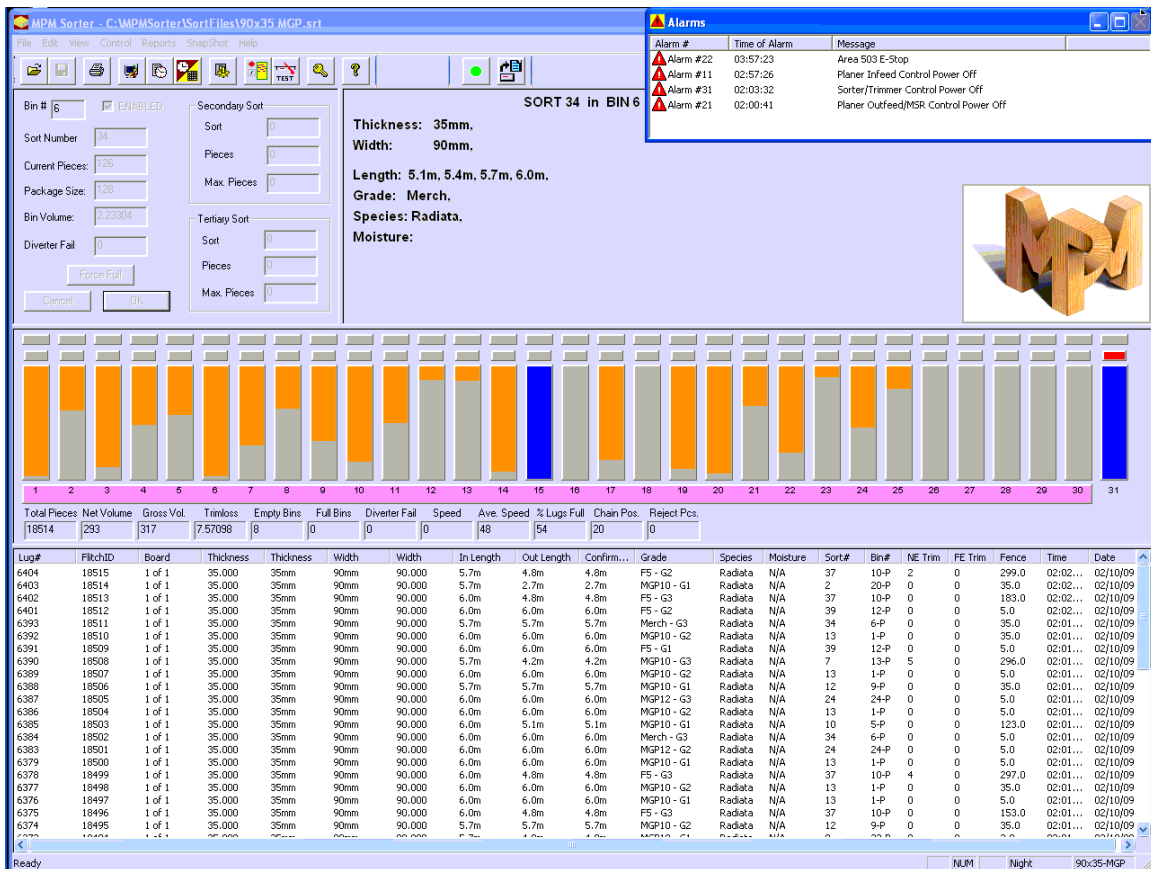
RESEARCH ENGINEERING SALES

Lumber Sorting Controls and PC Interface

MPM's Lumber Sorting System is programmable logic controller (PLC) based with a Microsoft® Windows interface that makes it very user-friendly and easy for the operator to set up. The design operating speed is 200+ lugs per minute.

Bin assignments can be fixed or self-seeking. The system can set any combination of parameters (lengths, widths, thicknesses, grades, species, and moisture) within a sorting pattern. Each sort can be assigned to a particular zone in the sorter. This can all be simply and easily programmed by the user.

The standard sorting capability typically provides up to 32 lengths, 16 widths, 16 thicknesses, 16 grades, 16 species and 16 moisture levels. The user can assign a text description (such as "Grade A") to each category that acts as a "tag specifier." The tags are used to specify sort patterns and generate reports. Each sort pattern contains a primary sort and provision for secondary and tertiary sorts, along with a corresponding maximum piece count per package.



Key Features:

- Automatic bin seeking in tertiary, secondary, primary, and then by empty bin order.
- Assigning up to 9 zones in the sorter system.
- Edit individual bin data while system is running (i.e. add or subtract boards from a package).
- View what is going into any bin by simply moving the mouse over the bin.
- View data on each board in the snapshot window as the system is running for quick identification of problems (boards are not getting sorted).
- Diagnostics are available for troubleshooting and system monitoring (snapshot view).
- Set-up and fine-tuning is handled easily via the computer interface, and system timing is dynamically adjusted according to sorter speed.
- System reports can be generated on an extensive range of factors. The user can modify these reports or create custom reports with Crystal Reports™ for Windows.
- Monitors diverter failures using a photocell at the recirculation point.
- Bin faults to detect overfilling of bins.
- Length limit switch (photocell) faults to monitor and advises the operator on limit switch/photocell/Trim saw failures.
- Skewed board detection.
- Broken hook detection to disable dealing a board for that lug and to advise the operator.
- Long-range photocells to detect lumber tangled up in a bin.
- Indicators in sequence to advise the operator that: only one bin is empty, that no empty bins are available, that all bins are full and lumber is going into recirculation.
- Hot backup of sorter data to the master computer hard disk every 30 seconds in case of a PLC crash.
- Operator display provides the bin chaser with real-time bin status along with pop-up error messages for sorter problems.
- Management report package for defining and modifying sort specifications, monitoring system status, diagnosing problems, and reporting production information.

Note: This system can be easily customized to accommodate any sawmill's specific lumber sorting requirements.



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