



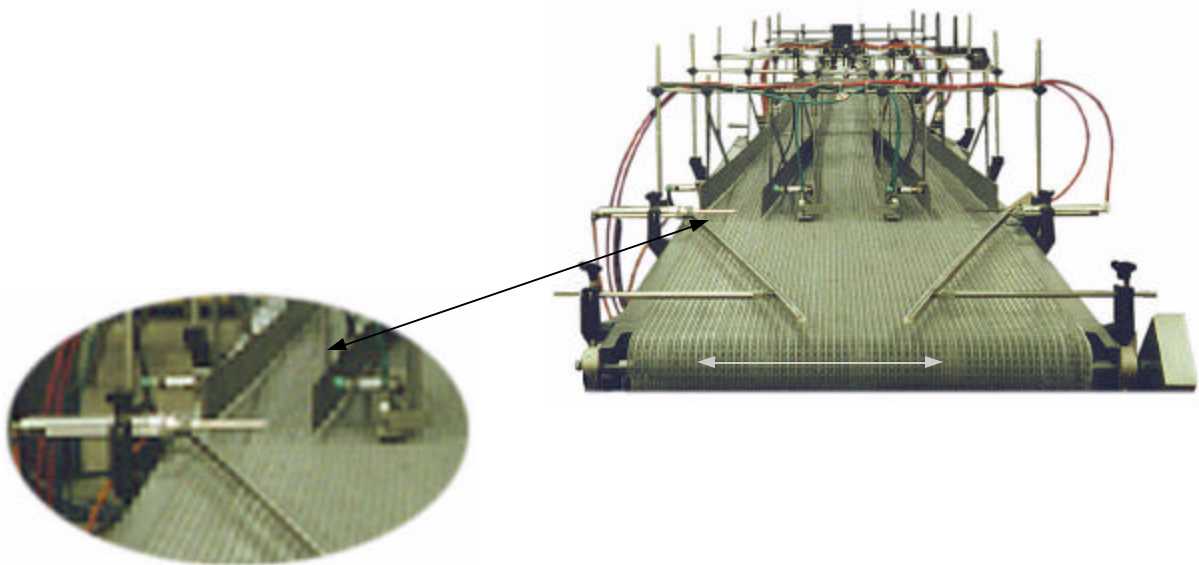
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3 to 1 Gate and Release Merge Conveyor



This unique Merge Conveyor is part of a Product Handling System designed and manufactured for a cookie baking company that was looking for ways to improve product-per-package-count accuracy and increase overall product output. This 3-lane conveyor has LED displays that accept data from a serial output from an upstream checkweigher, and multiple photo sensors that operate timed stop and release gates (shown in inset) to aid operators and control flow at the downstream end of the conveyor.

Cookie weight determines the count per box. If a box is of the correct weight, it leaves the checkweigher and is directed down the center lane of the conveyor. Underweight and overweight cartons are diverted to their designated outside lane for correction. The stop and release gates in these two lanes control the flow of cartons to operators to ensure they have adequate time to add or remove cookies. The number of cookies to be added or removed from each box is displayed in 3.5" numerals on the LEDs at each operator station for the particular box that is stopped in front of the operator. Cartons are released on a timed basis from the ends of the under and over lanes to maintain a smooth, constant flow.

As with every *Wrabacon* design, all commercial parts used on this system are reliable, high quality, heavy duty parts requiring low maintenance. The system design meets or exceeds applicable OSHA standards and the National Electrical Code for Industrial Machinery.