



Over-Under bar order filling stations are designed for systems using cantilever racks holding bar products in pans. Sideloaders bring pans to the station that are placed on a high elevation inbound accumulating chain conveyor. Up to 6 pans each holding 10,000 lbs of material are accumulated and stored for movement to the weighing and banding conveyor. This provides a buffer to the operator that will sustain a steady even flow of pans allowing the sideloader to have a variable delivery rate without interrupting the productivity of the station. The lower accumulating chain conveyor returns the pans back to the sideloader to complete a round trip for returning to the storage racks.

The operator selects a pan and lowers it to the best working elevation for packaging. Stripper arms move the material onto impact plates that are then lowered to the weighing and banding conveyor.

Bundling straps are used to compact the order into a tight bundle for strapping. Overhead mounted pneumatic strappers with 3 floor strapping reels allow the operator to quickly apply 2 or more straps to the order bundles. When shipping tags are applied, the bundle is released to the weighing and banding conveyor for transfer to the accumulating zones.

The bundle is then conveyed to one or more accumulation zones ready for direct truck loading or for off loading to floor laydown prior to truck loading.

Special die rubber inserts are available on the impact bars and coated rollers are used to handle surface critical material. Load cells are added for scales when required with digital readout and printers.

Over-Under stations should be used where volumes exceed 80 orders per shift and material is stored in pans serviced by conventional sideloaders. One station operator can handle up to 120 orders per shift with little or no effort required to lift or handle the material.

Multiple accumulation zones fed automatically from the station will increase productivity and eliminate double handling if trucks are directly loaded from the zone.

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**Developed and improved for over 20 years, Canrack has added many features to the Bar Order Filling Stations that improve safety, quality and productivity.**



Bundling straps rotate and manipulate the material into a tight bundle for strapping. The operator uses hydraulic controls for movement and rarely has to touch the material with his hands. Shapes can be nested and compressed and squares, rectangles and flats can be formed into square bundles.

Impact bars receive the material absorbing shock and lowering the material softly to the bundling and weighing conveyor. This feature protects the material from scratching or denting and removes impact from the scale eliminating frequent recalibration. Replaceable die rubber inserts on the impact bars reduce noise and avoid scratching or denting of material.



A control panel and the use of hydraulic soft start valves gives the operator perfect control on all machine movement. Manual or automatic modes give flexibility and in automatic mode relieves the operator to quickly begin processing the next order. Video screens mounted on the panel assists the operator with vision control of all elements where additional visibility is required.

Diagnostic screens with function read-outs on the main panel give instant information to the operator for any sensor or component malfunction. Quick disconnect components are used to enable quick repair.

