



H&S

HANDLING &

STOCK SA_EL4S LEVEL 4 ENTRY LEVEL LOADER/UNLOADER

With more features and capabilities, STOCK'S™ Level 4, Entry Level Loader/Unloader Systemexpands upon the L1, L2, and L3 systems too further eliminate repetitive manual tasks. By connecting the loader and unloader modules with a shared platform and conveyance to transport baskets and layer pads, the L4 system is designed to be a complete loader/unloader system managed by a single operator. As an added system upgrade, a Shuttle (X,Y) can be provided to eliminate the labor-intensive task of transporting, loading, and unloading baskets into and out of the retort(s) providing another level of automation.

Operator Sequence:

- 1. Operator positions empty basket onto trolley
- 2. Operator locks trolley into position at buffer conveyor
- 3. Operator provides minimal assistance to transfer basket(s) onto buffer conveyor until full
- 4. Operator starts load conveyor
- 5. [A] Buffer conveyor transports baskets to loader
- 6. [A] Hydraulic scissor jack positions basket bottom plate to correct level (height)
- 7. [A] Load conveyor feeds containers against pattern former to create matrix fitting the basket profile
- 8. [A] Sweep arm pushes matrix on to the layer pad
- 9. [A] Hydraulic scissor jack increments to the next level (height)
- 10. [A] Layer pad is placed on top of containers (layer pads are automatically conveyed from unloader to loader)
- 11. Repeat steps 6 to 10 until basket is full
- 12. [A] Full basket is transferred from loader onto buffer conveyor
- 13. Operator provides minimal assistance to transfer basket(s) from buffer conveyor onto trolley
- 14. Repeat steps 5 to 13 until all baskets are full

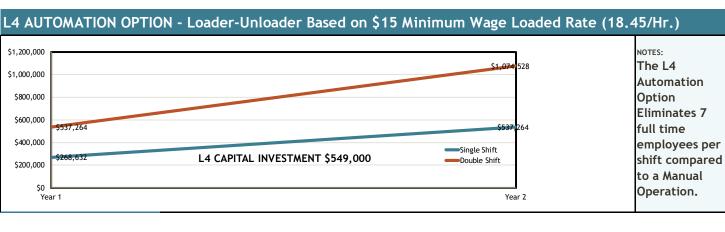
*Note1: [A] Designates Automated Function

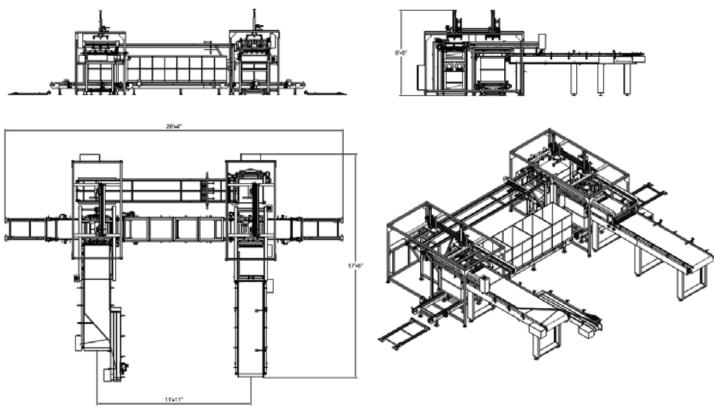
**Note 2: unloading is roughly the inverse of loading



STOCK // L4 ENTRY LEVEL LOADER/UNLOADER

L4 LABOR REQUIREMENTS	
LOADER/ UNLOADER OPERATIONAL TASKS	OPERATORS
FEEDING LOADER/ RETORT BASKET LOADING	
UNLOADING RETORT BASKETS/ FEEDING UNLOADER	
LOADER SEQUENCE OPERATOR	1
UNLOADER SEQUENCE OPERATOR	
LOADER PRODUCT BASKET CONTAINER PATTERN FORMER	
UNLOADER PRODUCT BASKET CONTAINER DISCHARGE	
LOADER LAYER PAD FEEDING/ FULL BASKET DISCHARGE	
UNLOADER LAYER PAD REMOVAL/ EMPTY BASKET DISCHARGE	





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