



H&S

HANDLING &
STERILIZING

STOCK SA_EL4S

LEVEL 4 ENTRY LEVEL LOADER/UNLOADER

With more features and capabilities, STOCK'S™ Level 4, Entry Level Loader/Unloader System expands 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



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	

L4 AUTOMATION OPTION - Loader-Unloader Based on \$15 Minimum Wage Loaded Rate (18.45/Hr.)

