

## Pallets Conveying System for material storage and finished goods storage.

The KÖHL Maschinenbau AG planned and realized a highly complex pallet-conveying-system for material stock and manufactured goods for the JTI in Trier. Requirements were to integrate the existing conveying and storage systems into the new concept and to install the new system during running production.



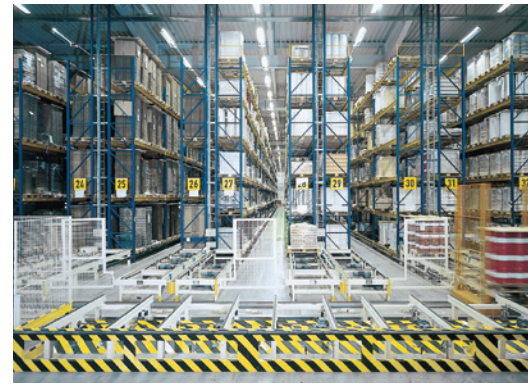
## MATERIAL STORAGE



Stock reception point (I-Point) and Contour-check



Acceptable pallets are transported to the I-Point via a chain conveyor.



Pallets from material storage that have to be dispatched are moved to a shuttle using the conveying system.

## Complete automation for economic effectiveness.

The conveying system installed by KÖHL Maschinenbau AG has provided the existing semi-automatic storage system with enormous economic improvements.

The storage system specially developed by JTI and the complete automation supplied by KÖHL's conveying system allow for the following online working processes: Storage and dispatch of goods from material depot, preparation in the commissioningzone, final storage point of manufactured goods, preparation of loading goods on truck or railway, pallet transfer from final storage to commissioning/dispatch zones as well as final storage of partially loaded-pallets.

Furthermore, future requirements regarding the conveying-system have been taken into consideration. For example, the connection of a pallet-winding machine, which is responsible for providing the partially loaded-pallets with a new stretch-foil, has already been included in the new design layout.

In addition to economic effectiveness, the conveying system is equipped with a user-friendly control-system which provides for continuous visualization of grouping and operating conditions. The conveying-system is also exemplary in its consideration of safety-regulations and requirements.

## FINISHED GOODS STORAGE



Production goods at a height of app. 6000mm are moved to an elevator. The elevator lowers the pallet app. 5500mm and hands it over to a chain-conveyor.



The conveyor which is used for relocating pallets from finished goods storage to the truck or railway loading area.



The flow storage system is a two storey construction consisting of 12 lanes. In each of these lanes, 18 pallets are prepared for truck loading.