



Over & Under Conveyor System



Over & Under Conveyor systems are unique in that they are built differently to fit the customer's needs. This particular project consist of chain driven live roller conveyors on both top and bottom sections with a lift table at one end with another CDLR conveyor mounted to the deck. The customer needed a way to convey empty pallets underneath where they would one by one roll onto a lift table and be loaded with the product. Once the

operator filled the pallet to its maximum weight of 4500# the lift table would then raise to match the height of the top conveyor line. The full pallet would then flow to the left down the conveyor.



This system is fully automated, using 5' zone sections; photo eyes controlled the flow of the product. This system is equipped with emergency stop buttons every 5' and a control stand where the operator could override the system and run manually if needed. Another key feature to this conveyors system is the transfer car. The transfer car is programmed to take two full loads of product and drive it down to the packaging area. This transfer car is also fully automated

and communicates with each conveyor line to know when there is a load to be picked up. This allows the operators to spend more time on the job at hand and there is no need for fork truck drivers at this end of the plant.

