



(22) Date de dépôt/Filing Date: 2013/09/13

(41) Mise à la disp. pub./Open to Public Insp.: 2014/04/17

(30) Priorité/Priority: 2012/10/17 (US61/714,744)

(51) Cl.Int./Int.Cl. *B27B 31/00* (2006.01)

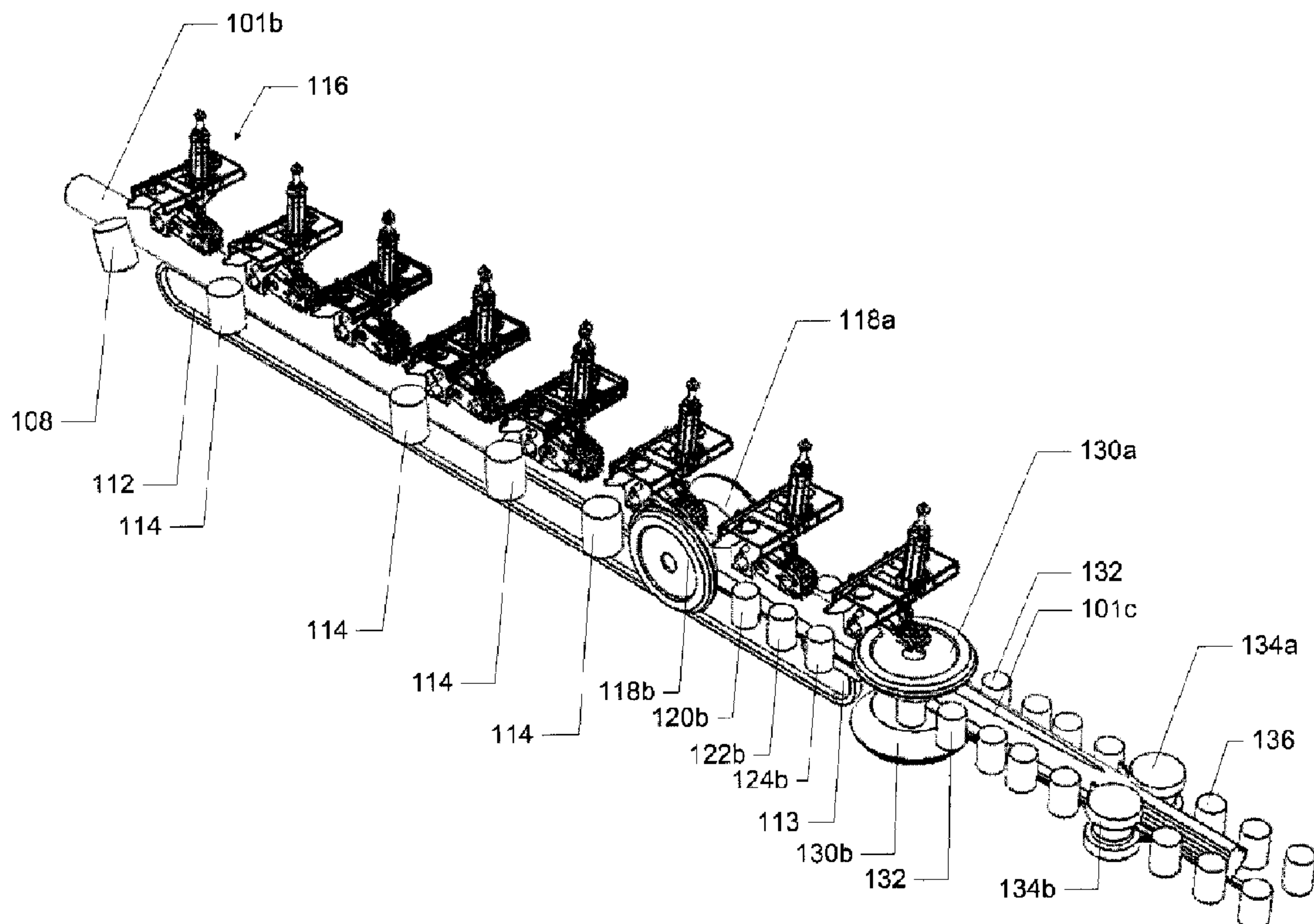
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(54) Titre : SYSTÈME DE POSITIONNEMENT DE PIÈCE À TRAVAILLER

(54) Title: WORKPIECE POSITIONING SYSTEM



(57) Abrégé/Abstract:

Embodiments provide a log positioning system configured to transport a log through one or more chipper/profiler modules to produce a cant with four chipped/profiled sides. In some embodiments, a log processing system may include an infeed, a positioning feed module downstream of the infeed, and one or more chipper/profiler modules disposed proximal to the positioning feed module. The positioning feed module may include a sharp chain coupled to one or more pairs of vertical positioning rolls. The positioning feed module may be selectively skewed, slewed, and/or tilted to match the vertical and angular orientation of the infeed.



Abstract of the Disclosure

Embodiments provide a log positioning system configured to transport a log through one or more chipper/profiler modules to produce a cant with four chipped/profiled sides. In some embodiments, a log processing system may include an infeed, a positioning feed module downstream of the infeed, and one or more chipper/profiler modules disposed proximal to the positioning feed module. The positioning feed module may include a sharp chain coupled to one or more pairs of vertical positioning rolls. The positioning feed module may be selectively skewed, slewed, and/or tilted to match the vertical and angular orientation of the infeed.

WORKPIECE POSITIONING SYSTEM

Technical Field

[0001] Embodiments herein relate to the field of lumber processing, and, more specifically, to system, methods, and apparatuses for positioning workpieces such as logs and cants.

Background

[0002] Chipper canters are used in some sawmills to process logs, or blocks, into flitches, cants and boards. A chipper canter transforms logs into cants by removing outer portions of wood from two or four sides of the log. However, force applied against the log by the chip heads may cause the log to shift on the conveyor, which can result in inaccurate positioning of the log and sub-optimal chipping/sawing. In addition, the curvature of some logs can present challenges to accurate chipping and sawing.

Brief Description of the Drawings

[0003] Embodiments will be readily understood by the following detailed description in conjunction with the accompanying drawings. Embodiments are illustrated by way of example and not by way of limitation in the figures of the accompanying drawings.

[0004] Figure 1 illustrates a perspective view of a log processing system;

[0005] Figures 2a-2b illustrate side and top views, respectively, of the log processing system of Figure 1;

[0006] Figures 3 illustrates a positioning feed module and other components of the log processing system of Figure 1;

[0007] Figure 4 illustrates a simplified plan view of a positioning feed module;

[0008] Figures 5a-5b illustrate front and rear elevational views, respectively, of the components shown in Figure 4;

[0009] Figure 6 illustrates a schematic plan view of a positioning feed module carriage; and

[0010] Figures 7 and 8 illustrate additional details of the log processing system of Figure 1, all in accordance with various embodiments.

Detailed Description of Disclosed Embodiments

[0011] In the following detailed description, reference is made to the accompanying drawings which form a part hereof, and in which are shown by way of illustration embodiments that may be practiced. It is to be understood that other embodiments may be utilized and structural or logical changes may be made without departing from the scope. Therefore, the following detailed description is not to be taken in a limiting sense, and the scope of embodiments is defined by the appended claims and their equivalents.

[0012] Various operations may be described as multiple discrete operations in turn, in a manner that may be helpful in understanding embodiments; however, the order of description should not be construed to imply that these operations are order dependent.

[0013] The description may use perspective-based descriptions such as up/down, back/front, and top/bottom. Such descriptions are merely used to facilitate the discussion and are not intended to restrict the application of disclosed embodiments.

[0014] The terms “coupled” and “connected,” along with their derivatives, may be used. It should be understood that these terms are not intended as synonyms for each other. Rather, in particular embodiments, “connected” may be used to indicate that two or more elements are in direct physical or electrical contact with each other. “Coupled” may mean that two or more elements are in direct physical or electrical contact. However, “coupled” may also mean that two or more elements are not in direct contact with each other, but yet still cooperate or interact with each other.

[0015] For the purposes of the description, a phrase in the form “A/B” or in the form “A and/or B” means (A), (B), or (A and B). For the purposes of the description, a

phrase in the form “at least one of A, B, and C” means (A), (B), (C), (A and B), (A and C), (B and C), or (A, B and C). For the purposes of the description, a phrase in the form “(A)B” means (B) or (AB) that is, A is an optional element.

[0016] The description may use the terms “embodiment” or “embodiments,” which may each refer to one or more of the same or different embodiments. Furthermore, the terms “comprising,” “including,” “having,” and the like, as used with respect to embodiments, are synonymous.

[0017] In exemplary embodiments, a computing device may be endowed with one or more components of the disclosed apparatuses and/or systems and may be employed to perform one or more methods as disclosed herein.

[0018] Embodiments herein provide systems, apparatuses, and methods for positioning a workpiece, such as a log/cant. Log processing systems as described herein may have a shorter length than typical existing primary log lines and/or provide improved workpiece positioning capabilities.

[0019] As described more fully below, a log positioning system may be configured to transport a log through one or more chipper/profiler modules to produce a cant with four chipped/profiled sides. In some embodiments, a log processing system may include an infeed, a positioning feed module downstream of the infeed, and one or more chipper/profiler modules disposed proximal to the positioning feed module. The positioning feed module may include a sharp chain coupled to one or more pairs of vertical positioning rolls. The positioning feed module may be selectively skewed, slewed, and/or tilted to match the vertical and angular orientation of the infeed.

[0020] The infeed may be configured to convey a log in a first direction generally parallel to a longitudinal axis of the log, and to position and/or tilt the log. The positioning feed module may adjust or maintain the optimized position of the log while feeding the log into a first pair of chip heads. The first pair of chip heads may be configured to chip vertical flat faces on the sides of the log. As the leading end of the workpiece (now a cant) exits the first pair of chip heads, the bottom of the workpiece is engaged by the sharp chain of the positioning feed module. The vertical

rolls of the positioning feed module contact the chipped vertical faces of the workpiece and continue to drive the workpiece in the first direction toward a second pair of chip heads. The sharp chain and vertical rolls of the positioning feed module may be selectively skewed, slewed, tilted, and/or vertically repositioned in concert to position the workpiece for chipping by the second set of chip heads. The second set of chippers may chip flat faces on the top and bottom of the workpiece.

[0021] In some embodiments, an optimizing scanner system may be provided upstream of the positioning feed module (e.g., positioned along the infeed). A log turner may be positioned along the infeed and/or the positioning feed module upstream of the first pair of chip heads. As a log is conveyed along the infeed, the optimizing scanner system may scan the log and determine an optimized rotational position and optimized cutting solution. The log turner may be controlled, directly or indirectly, by the optimizing scanner system to rotate the log optimized rotational position before the log is engaged by the sharp chain and processed by the first and second pairs of chip heads.

[0022] Optionally, one or more profiler and/or saw units may be provided downstream of the second pair of chippers. In one embodiment of a log processing system, a first pair of profilers is positioned downstream of the second pair of chip heads. A first saw module, such as a horizontal arbor saw, is positioned downstream of the first pair of profilers. The first pair of profilers may engage and profile the vertical sides of the workpiece, and the first saw module may subsequently cut side boards from the profiled workpiece. A second set of profilers may be provided downstream of the first saw module. The second set of profilers may profile the top and/or bottom of the workpiece. A second saw module, such as a vertical arbor saw, may be provided downstream of the second set of profilers. The second saw module may cut the workpiece into two or more pieces (e.g., boards).

[0023] Figure 1 illustrates a perspective view of a log processing system 100. Figures 2a-2b illustrate side and top views, respectively, of log processing system 100. Referring first to Figure 1, log processing system 100 may include one or more

of an infeed 102, a positioning feed module 110, a first profile/saw section 128, a second conveyor 140, and a second profile/saw section 150.

[0024] Referring now to Figures 2a-b, infeed 102 may include any type of conveyor known in the art for transporting logs, such as a flighted chain conveyor. In a particular embodiment, the conveyor is selectively operable to skew, slew, tilt, and/or vertically reposition a workpiece, such as a log/cant (101) on the conveyor. An optimizing scanner 106 may be provided along infeed 102. Optimizing scanner 106 may include a computing system communicatively coupled to one or more sensors positioned along the conveyor of infeed 102. Optionally, optimizing scanner 106 may further include one or more additional sensors arranged downstream of the conveyor and/or downstream of infeed 102. Optimizing scanner 106 may be configured to scan a workpiece and determine an optimized rotational position for the workpiece. In addition, optimizing scanner 106 may be configured to determine an optimized cutting solution and/or optimized cut pattern for the workpiece. In some embodiments, log processing line 100 may include two separate scanners, with the first scanner configured to provide rotation correction and the second scanner configured to provide turn detection (e.g., measure the actual log rotation against what was predicted) and/or source quality inspection (e.g., measure the horizontal position of the log against what was predicted).

[0025] A log turner 108 may be positioned proximal to infeed 102. In some embodiments, log turner 108 may be positioned between infeed 102 and positioning feed module 110. Log turner 108 may include knuckle turner rolls that will handle logs up to 18" diameter. Alternatively, log turner 108 may be a reciprocating log turner configured to accommodate logs of greater diameter (e.g., up to 30"). Log turner 108 may turn the log to the optimized rotational position determined by optimizing scanner 106. Optionally, one or more of the sensors of optimizing scanner 106 may be positioned to monitor the position of the log before, after, and/or during the turn. For example, a first group of sensors positioned along infeed 102 may be used to scan the log for calculation of optimized rotational position, and the first group of sensors and/or a second group of sensors positioned downstream of the

first group of sensors may be used to monitor the rotational position of the log. Optimizing scanner 106 may be configured to detect the actual rotational position of the log and to calculate a difference between the actual position and the optimized rotational position and/or predicted rotational position. Based on the calculated difference, optimizing scanner 106 may generate one or more commands to cause log turner 108 to correct the rotational position of the log (e.g., to continue the turn or initiate an additional turn). Optimizing scanner 106 may also measure the horizontal position of the log against a predicted horizontal position and calculate a difference between the actual horizontal position and the predicted horizontal position. Based on the calculated difference(s), optimizing scanner 106 may generate one or more commands to adjust positioning feed module 110 and/or a downstream cutting tool (e.g., chip heads and/or a saw) to offset the calculated difference(s).

[0026] Positioning feed module 110 may be disposed downstream of infeed 102 and/or log turner 108. Figures 3 and 4 illustrate additional details of positioning feed module 110 and additional components of log processing line 100. As best shown in Figure 3, positioning feed module 110 may include a sharp chain 112 operatively coupled to one or more pairs of vertical feed rolls (120, 122, and 124). Once the log has been turned, log turner 108 may deposit the log onto sharp chain 112. Sharp chain 112 and vertical feed rolls 120, 122, and 124 may be selectively repositioned in unison to match the vertical orientation and angle of infeed 102.

[0027] A first pair of chip heads 118a and 118b may be arranged on opposite sides of sharp chain 112. Chip heads 118a and 118b may be side chip heads configured to chip vertical faces along the lateral sides of a workpiece 101c. A second pair of chip heads 130a and 130b may be positioned downstream of chip heads 118a/118b (e.g., at or near the terminal end of positioning feed module 110). Chip heads 130a and 130b may be top and bottom chip heads, respectively, configured to chip horizontal faces along the top and bottom of the workpiece. Chip heads 130a and 130b may be vertically aligned, with chip head 130a positioned above chip head 130b. Chip head 130b may be a fixed-position chip head, and chip head 130a may be vertically repositionable relative to chip head 130b to

accommodate various workpiece sizes and cut patterns. Alternatively, chip head 130a may be a fixed-position chip head and chip head 130b may be vertically repositionable. As still another alternative, chip heads 130a and 130b may both be vertically repositionable. In some embodiments, some or all of chip heads 118a, 118b, 130a, and 130b are conical chip heads configured to create a smooth surface finish on the cant.

[0028] Sharp chain 112 may extend between the first pair of chip heads 118a/118b. In some embodiments, sharp chain 112 may also extend between the second pair of chip heads 130a/130b. Alternatively, chip heads 130a/130b may be positioned downstream of sharp chain 112. Vertical feed rolls 120, 122, and 124 may move vertically/laterally with the chain to maintain the vertical lift, slew and skew of the log as it enters the second pair of chip heads 130a/130b.

[0029] One or more overhead press roll assemblies 116 may be provided along some or all of the length of sharp chain 112 to help maintain the workpiece in a desired position. Centering feed rolls 114 may be positioned along sharp chain 112 upstream of the first pair of chip heads. Likewise, additional vertical feed rolls 132 may be positioned downstream of the second pair of chip heads 130a/130b. In contrast to vertical feed rolls 120, 122, and 124, vertical feed rolls 132 may have fixed positions, such that they are not repositioned in unison with sharp chain 112.

[0030] As the workpiece travels into the first pair of chip heads 118a/118b, the workpiece may be maintained in position by overhead press rolls 116, sharp chain 112, and centering feed rolls 114. The first pair of chip heads 118a/118b may create vertical chipped faces that are engaged by vertical feed rolls 120, 122, and 124 to guide the workpiece into the second pair of chip heads 130a/130b. Sharp chain 112 and vertical feed rolls 120, 122, and 124 may be selectively repositioned to slew, skew, lift and/or tilt the workpiece to create the desired opening face with chip head 130b. The workpiece may be stabilized by the downward force exerted by the first pair of chip heads 118a/118b chipping down into the workpiece. In addition, the upstream chip heads 118a/118b may provide lateral support to the workpiece to counteract the lateral force exerted by the second pair of chip heads 130a/130b,

resulting in improved workpiece stability and positioning. Optionally, one or more guides may be positioned upstream of the second pair of chip heads 130a/130b to help guide the workpieces into the chip heads.

[0031] The positioning feed module 110 may include a carriage 160, illustrated in Figure 6. Carriage 160 may include two sides, one on each side of sharp chain 112, and a rail guide system that facilitates in/out and up/down shift of the two sides relative to sharp chain 112 to set the desired cant width. This may allow carriage 160 to be adjusted to accommodate different cant widths. In some embodiments, carriage 160 may include separate carriages on each side of sharp chain 112. Carriage 160 may support the pairs of vertical feed rolls 120, 122, and 124, and actuators 126. Vertical feed rolls 122 may remain in a fixed position with respect to carriage 160. In contrast, vertical feed rolls 120 and 124 may be selectively articulated/repositioned relative to carriage 160 by actuators 126 (e.g., air/hydraulic cylinders, linear positioners, etc.). Optionally, missed face logic may be employed, such that an actuator 126 is extended only when no chipped face is present at the corresponding vertical positioning roll (see e.g., Fig. 6, vertical positioning roll 124b extended by corresponding actuator 126 where chipped face is absent). This may allow the opposite side of the workpiece to be chipped with greater accuracy. Optionally, some or all of the vertical feed rolls 120, 122, and 124 may be equipped with roll scrapers to keep the knurl clean.

[0032] A centerline chain drive and chain support may be coupled to sharp chain 112. In some embodiments, the chain drive may be manufactured from polyester. A cylinder may be configured to lift the vertical feed rolls 120, 122, and 124 and the outfeed end of sharp chain 112 to maintain the lift/slew/skew of the workpiece as it travels into the second pair of chip heads 130a/130b. Knife edge support bars (e.g., support 113) may be provided on each side of sharp chain 112 to support the workpiece between the downstream end of sharp chain 112 (e.g., at a head sprocket of the sharp chain) and chip head 130b.

[0033] A first profile/saw section 128 may be positioned downstream of the second pair of chip heads 130a/130b. First profile/saw section 128 may include a

first pair of profiling heads 134a and 134b, vertical feed rolls 136, and a skid bar 152 (see Figs. 4 and 7). Optionally, guides 158 may also be provided proximal to the first pair of profiling heads (Fig. 7). Profiling heads 134a and 134b may be configured to profile the vertical sides of the workpiece. In the illustrated example, each of profiling heads 134a and 134b are four-stepped profiling heads that create eight separate side board notches on the sides of the workpiece (see e.g., Figure 5b). However, this example is not intended to be limiting, and profiling heads 134a and 134b may have any suitable configuration or number of steps. Profiling heads 134a and 134b may slide up and down on vertical splined arbors. Profiling heads 134a and 134b may be driven by drive motors (e.g., 200 hp drive motors). In some embodiments, the chain drive may be manufactured from polyester. Profiling heads 134a and 134b may be supported on a carriage that tilts to accommodate skewing the side boards.

[0034] After processing by the second pair of chip heads 130a/130b, the workpiece may proceed along skid bar 152 (Fig. 4) to profiling heads 134a/134b. Vertical feedrolls 132 positioned upstream of the profiling heads and additional vertical feedrolls positioned downstream of the profiling heads may maintain the workpiece in position (see e.g., Fig. 7). A first saw assembly 138 may be provided downstream of the profiling heads. First saw assembly 138 may include a band saw, an arbor saw, or any other suitable type of saw. For example, as illustrated, first saw assembly 138 may include one or more horizontal arbor saws positionable to saw one or more side boards from the workpiece.

[0035] In some embodiments, first saw assembly 138 may include a quad arbor sawbox with a shifting saw carriage on each side and fitted with fixed bottom arbor and tilting top arbor. The top arbor may equalize the depth of cut. Optionally, the top arbor may be actuated with a hydraulic servo valve. First saw assembly 138 may further include a sawguide system with #3 splined sleeves (6" diameter) and a profile rail guide system that allows for in/out shift.

[0036] A second conveyor section 140 may be positioned downstream of first saw assembly 138. Second conveyor section 140 may include a conveyor 156 and one or more overhead positioning roll assemblies 142 positioned above conveyor

156. Conveyor 156 may be a sharp chain conveyor. As the workpiece proceeds onto/along second conveyor 156, one or more side boards cut by first saw assembly 138 may be separated or diverted by conventional means for further processing. In some embodiments, side pinch rolls may contain the side boards, and may be actuated with a hydraulic linear positioner.

[0037] A second profile/saw section 150 may be positioned downstream of second conveyor 156. As best shown in Figure 8, second profile/saw section 150 may include additional vertical positioning rolls 144, a second pair of profiling heads 146a/146b, and a second saw assembly 148. As the workpiece proceeds from second conveyor 156 toward profiling heads 146a/146b, vertical positioning rolls 144 may maintain the workpiece in position for profiling. Profiling head 146a may be positioned to profile the top of the workpiece, and profiling head 146b may be positioned to profile the bottom of the workpiece. Additional vertical positioning rolls 144 located downstream of profiling heads 146a/146b may maintain the workpiece in a desired position as the workpiece exits the profiling heads and proceeds toward second saw assembly 148.

[0038] Second saw assembly 148 may include a straight-sawing gang. Alternatively, second saw assembly 148 may include a curve-sawing gang. In one embodiment, second saw assembly 148 may include a double vertical arbor gang saw. As the workpiece proceeds through second saw assembly 148, the workpiece may be sawn into boards. Additional vertical positioning rolls located downstream of second saw assembly 148 may help to maintain the workpiece in a desired position for sawing.

[0039] Although certain embodiments have been illustrated and described herein, it will be appreciated by those of ordinary skill in the art that a wide variety of alternate and/or equivalent embodiments or implementations calculated to achieve the same purposes may be substituted for the embodiments shown and described without departing from the scope. Those with skill in the art will readily appreciate that embodiments may be implemented in a very wide variety of ways. This application is intended to cover any adaptations or variations of the embodiments

discussed herein. Therefore, it is manifestly intended that embodiments be limited only by the claims and the equivalents thereof.

Claims

What is claimed is:

1. A system for cutting a log comprising:
 - a log conveyor system for transporting a log in a first direction along its major axis that can position and or tilt the log in the vertical axis and feeds the log into a pair of chippers that chip vertical flat faces on the sides of the log;
 - at least one pair of vertical rolls attached to the conveyor system that move with the conveyor system in the vertical axis located on the output side of the chippers that contact the flat faces that have been chipped and continue to drive the log in the first direction; and
 - a second set of chippers that chip flat faces on the top and bottom of the log that follow the vertical rolls.
2. An apparatus for positioning a log, comprising:
 - a sharp chain;
 - one or more pairs of vertical feed rolls; and
 - a carriage coupled to the sharp chain and the vertical feed rolls, the carriage configured to reposition the sharp chain and the one or more pairs of vertical feed rolls in concert.
3. A method for processing a log to obtain a four-sided cant, the method comprising:
 - placing the log onto a sharp chain conveyor configured to convey the log toward a pair of side chip heads and a pair of top and bottom chip heads disposed downstream of the side chip heads;
 - actuating the side chip heads to chip vertical faces along opposite sides of the log; and
 - while the vertical faces of the log are engaged by the vertical positioning rolls, chipping the top and bottom of the log.

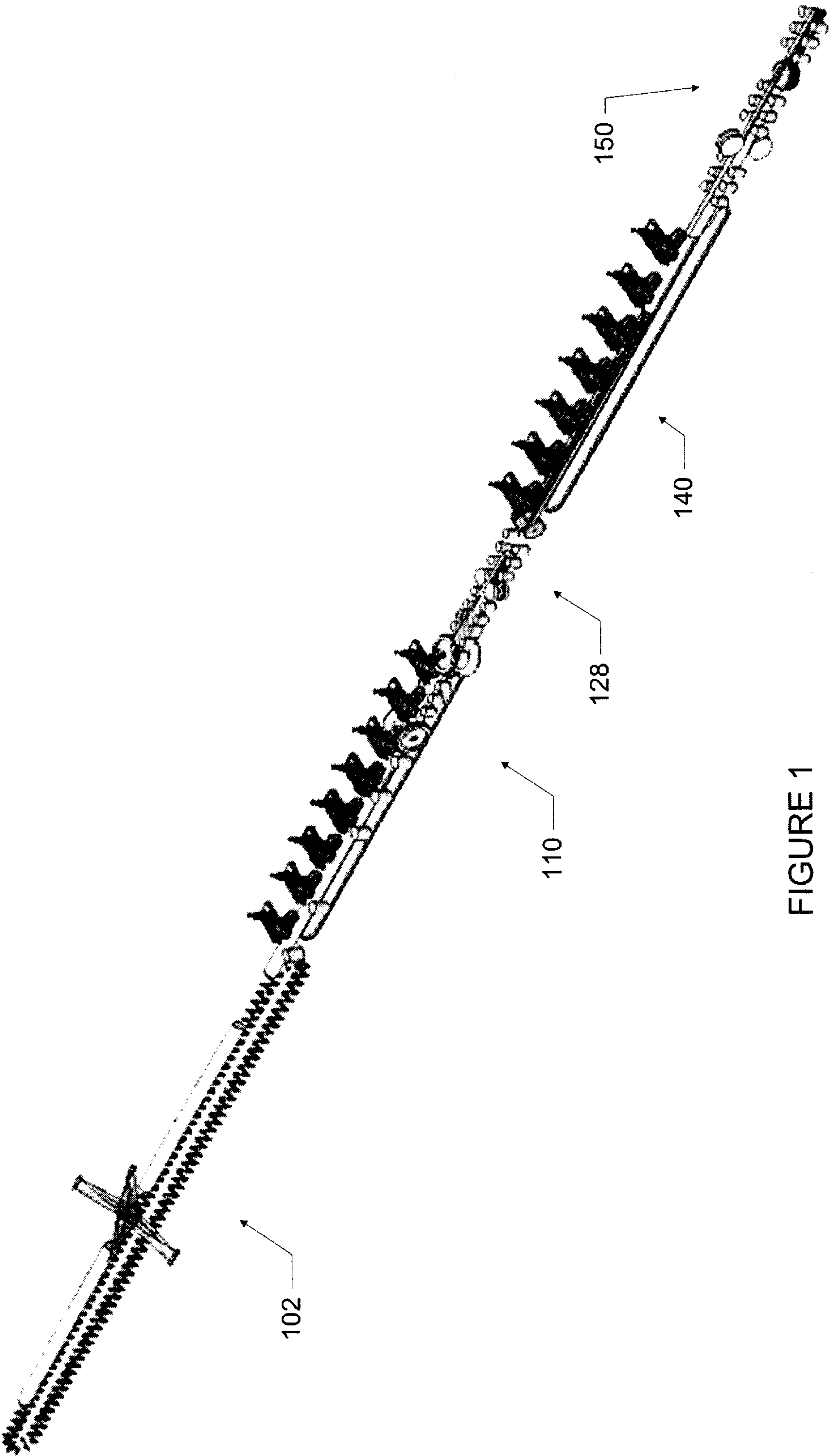


FIGURE 1

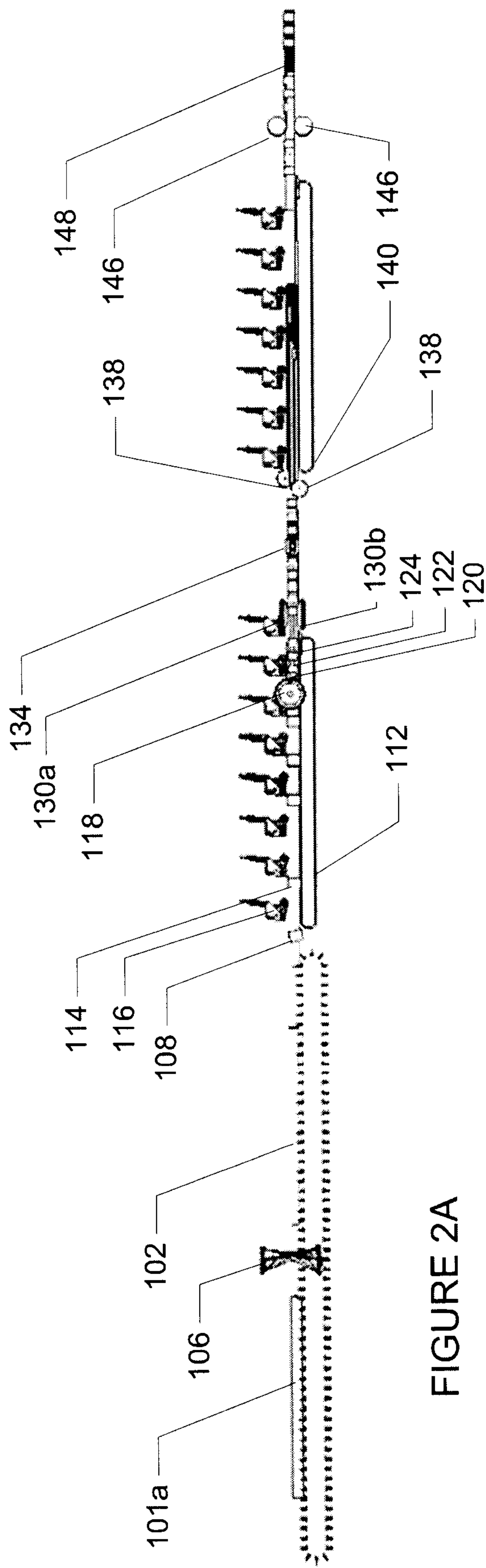


FIGURE 2A

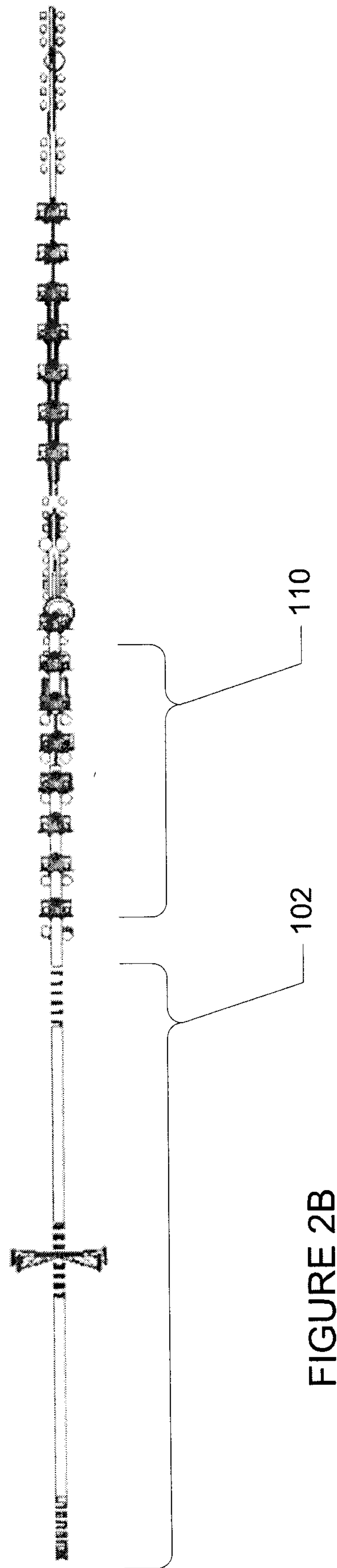
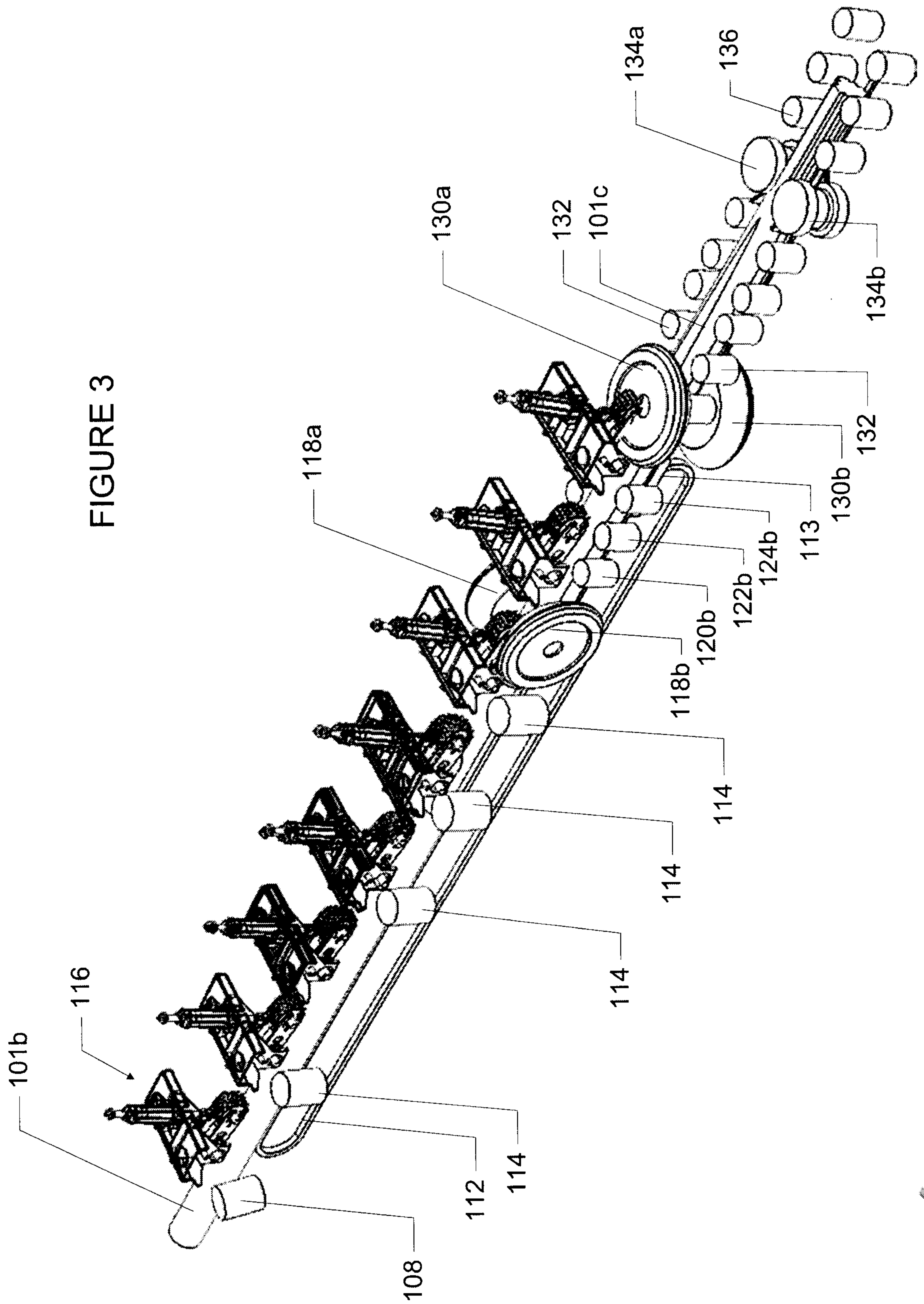


FIGURE 2B

FIGURE 3



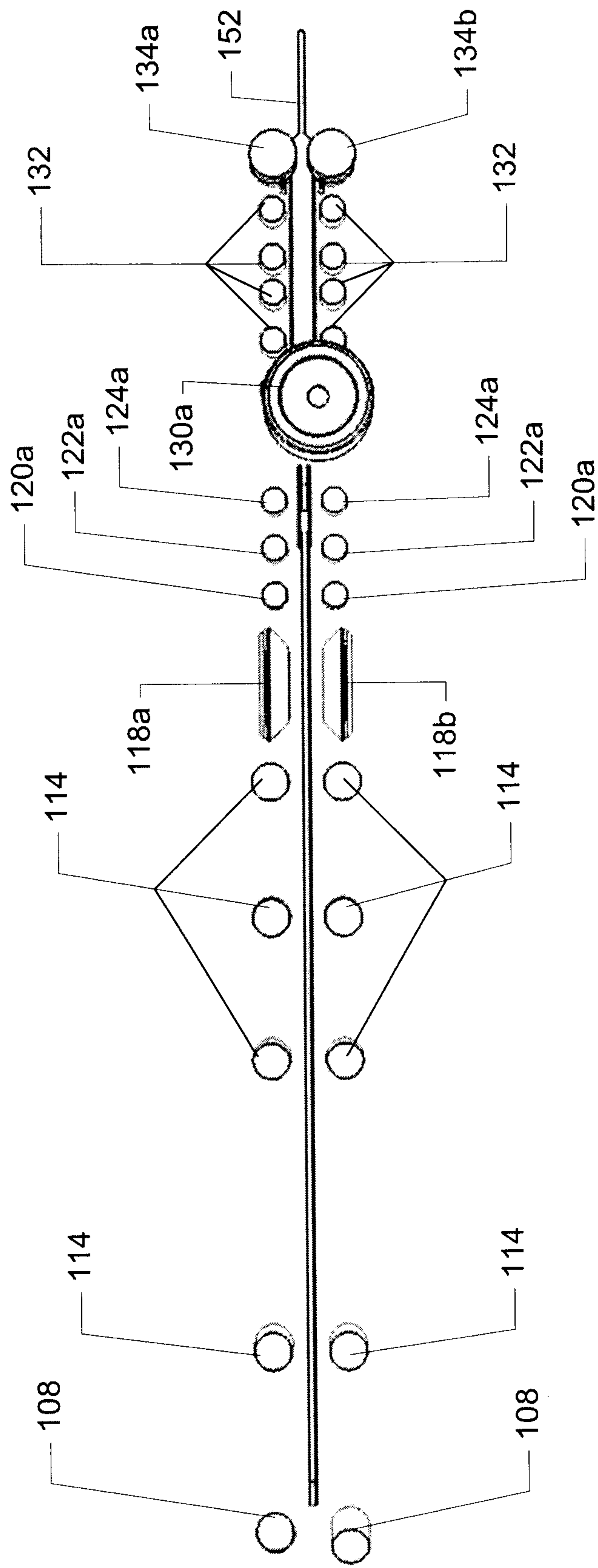
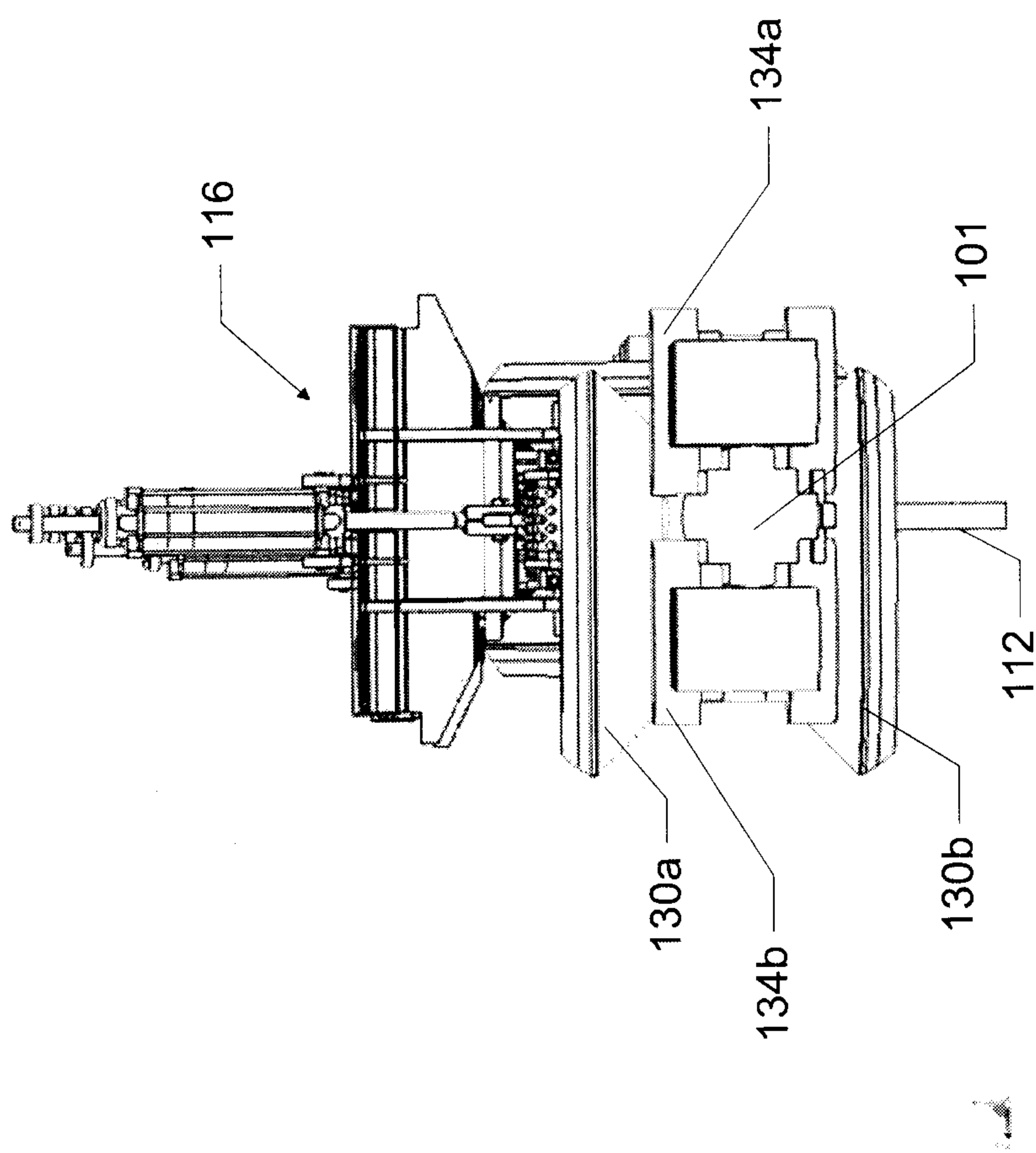
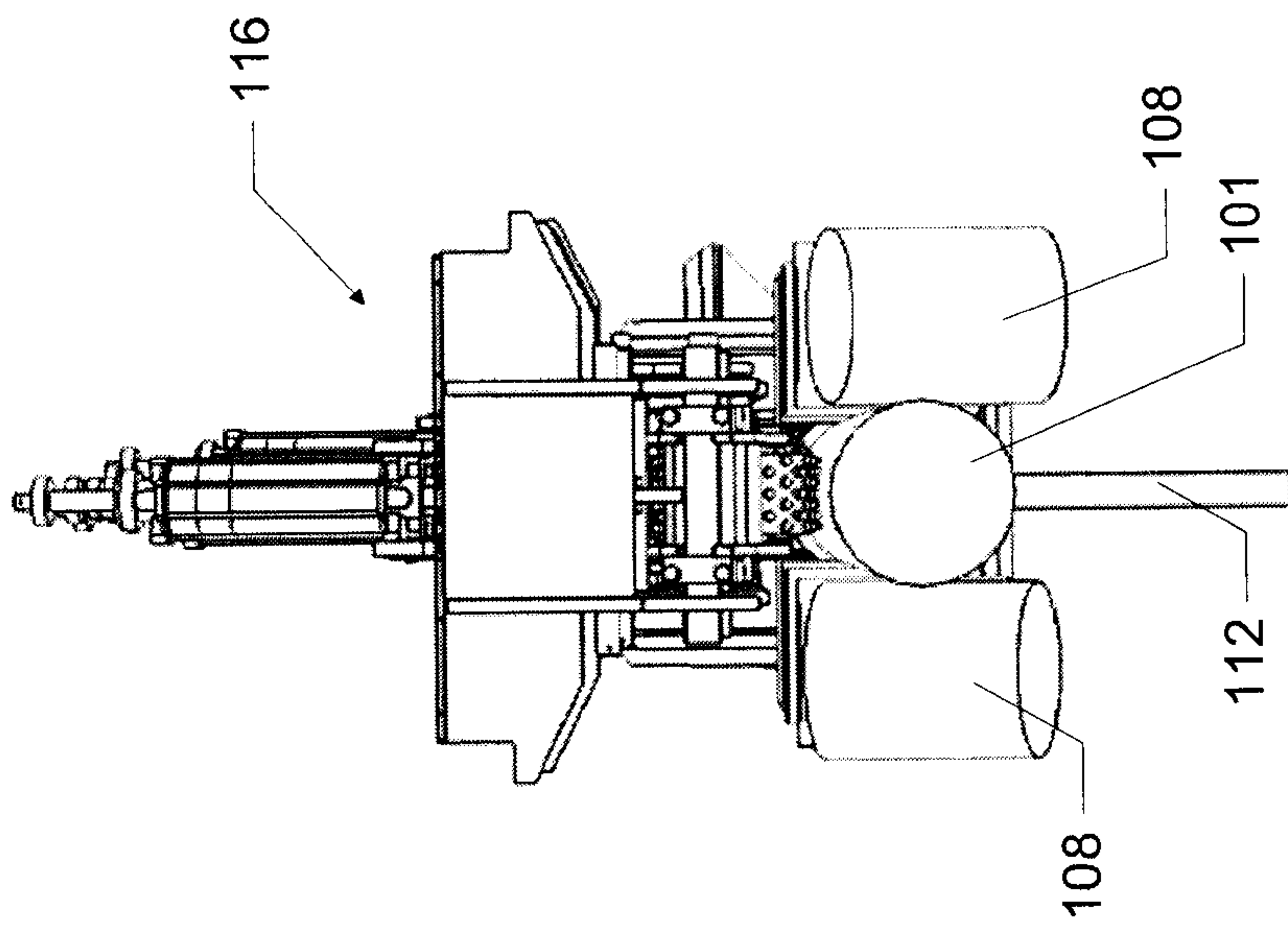


FIGURE 4



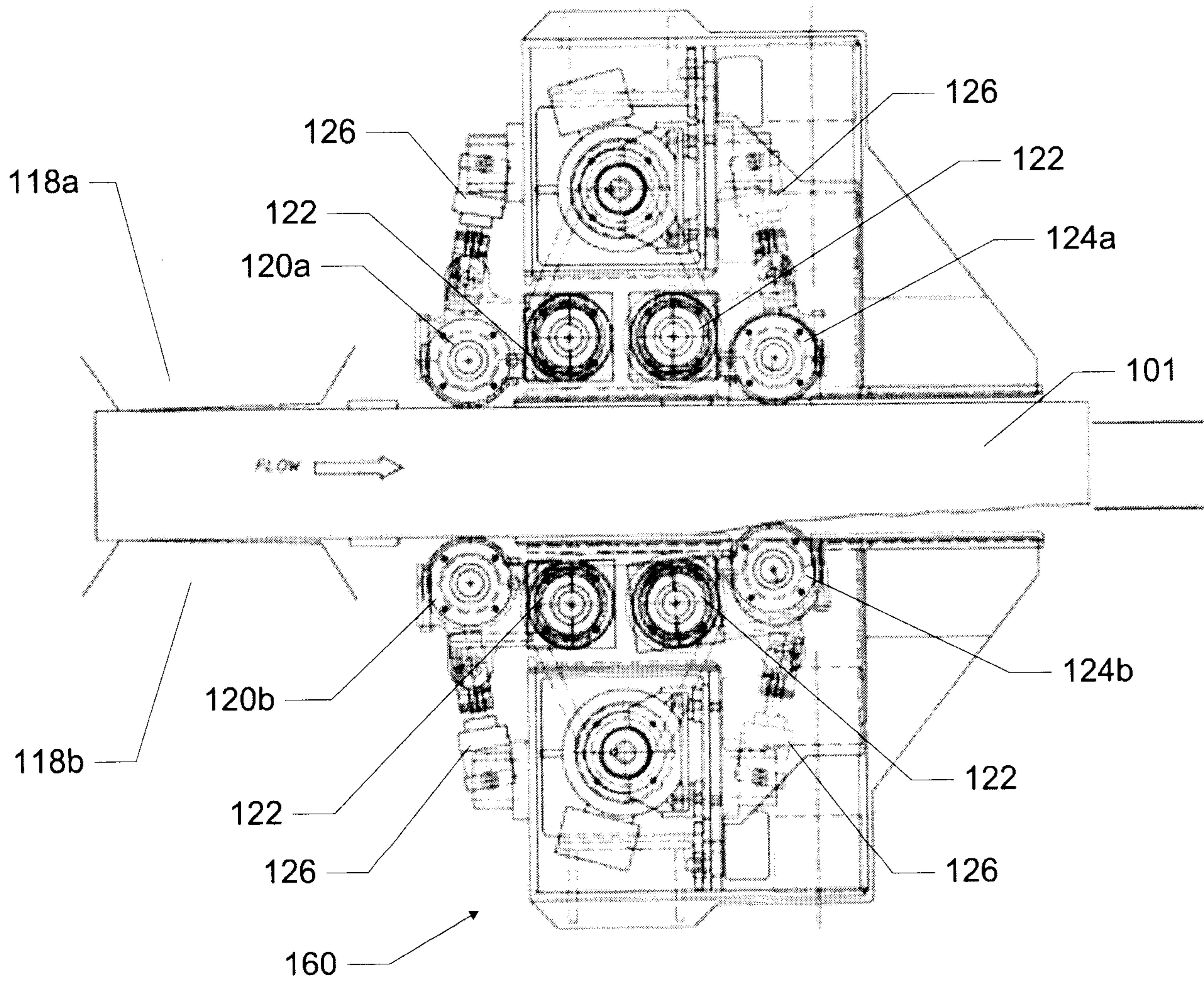
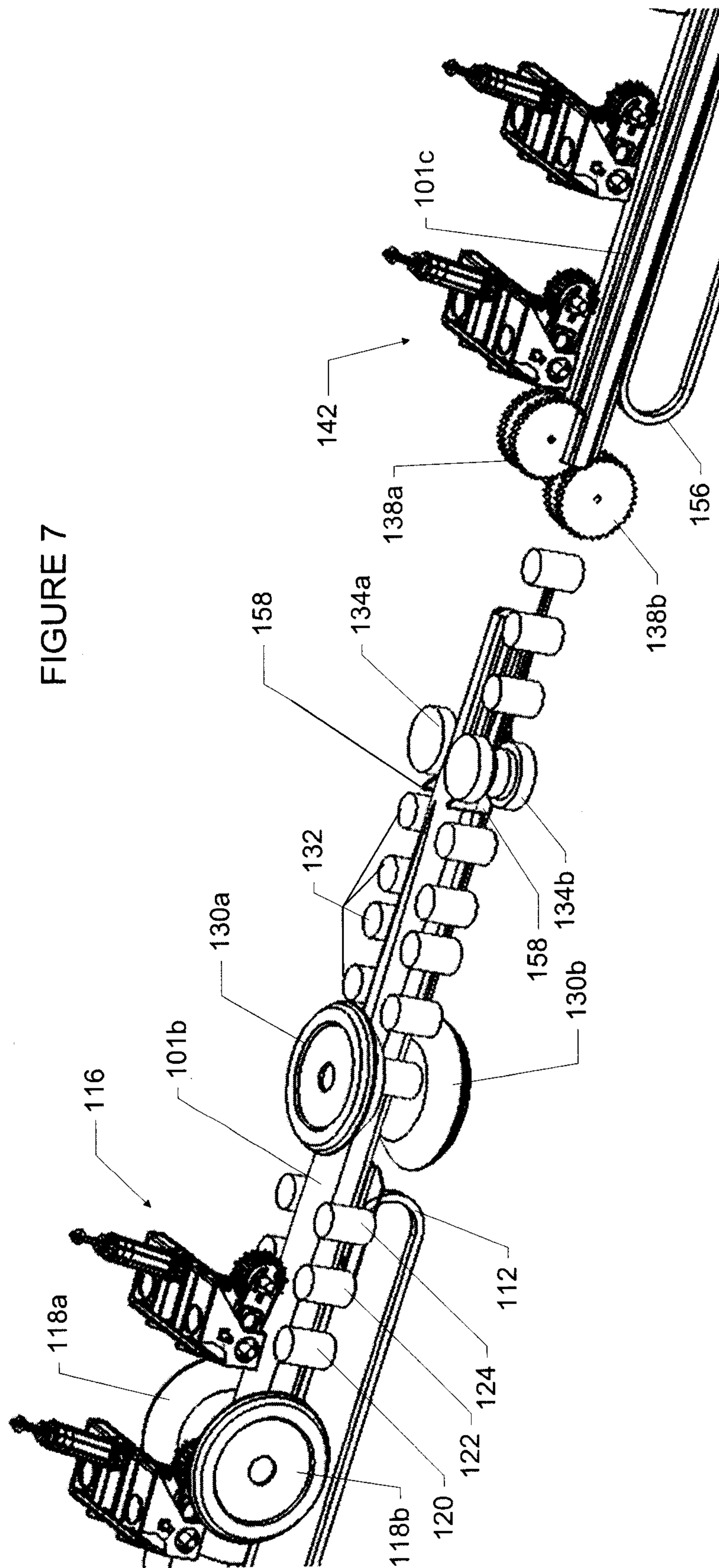


FIGURE 6



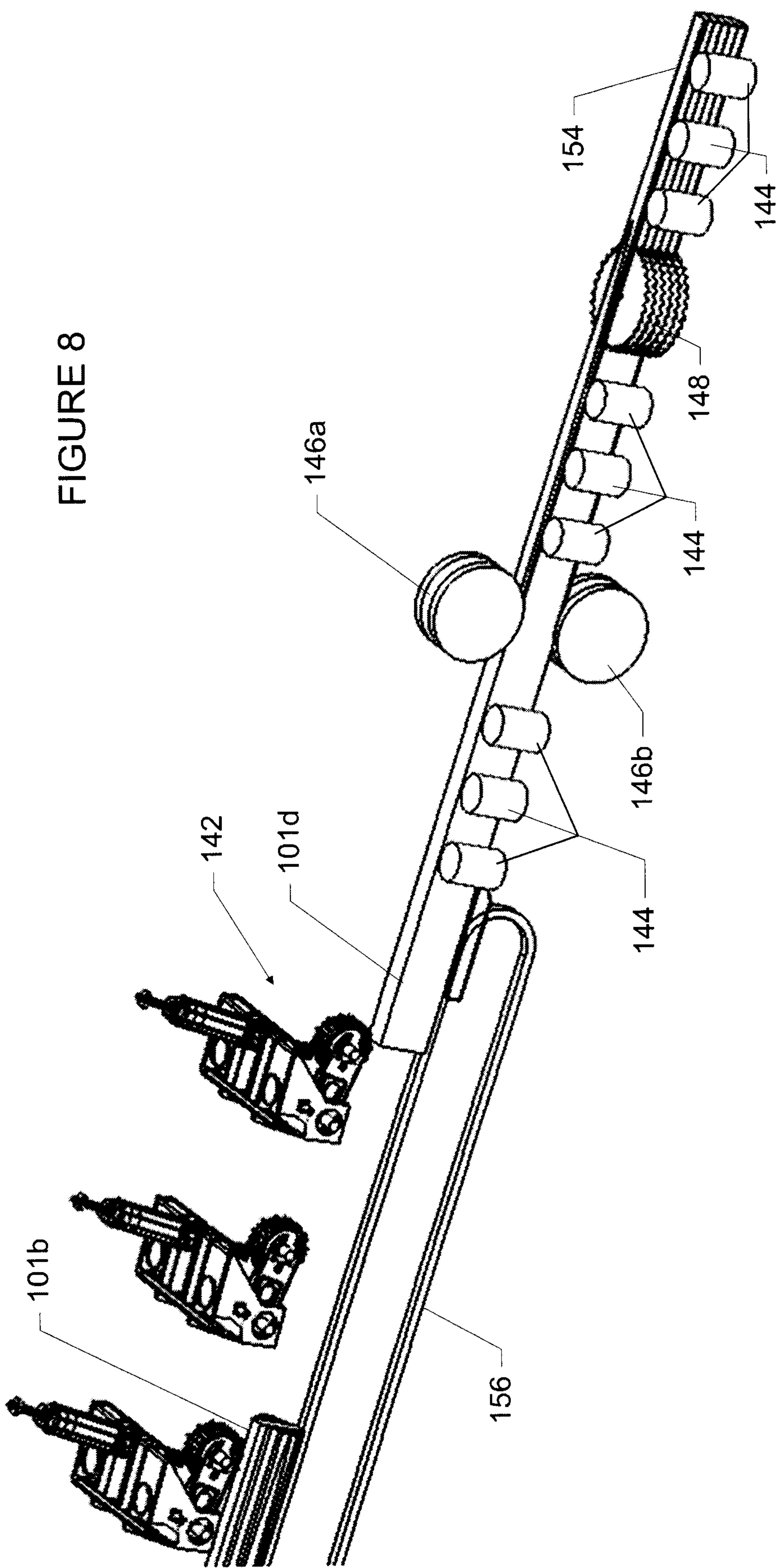


FIGURE 8

