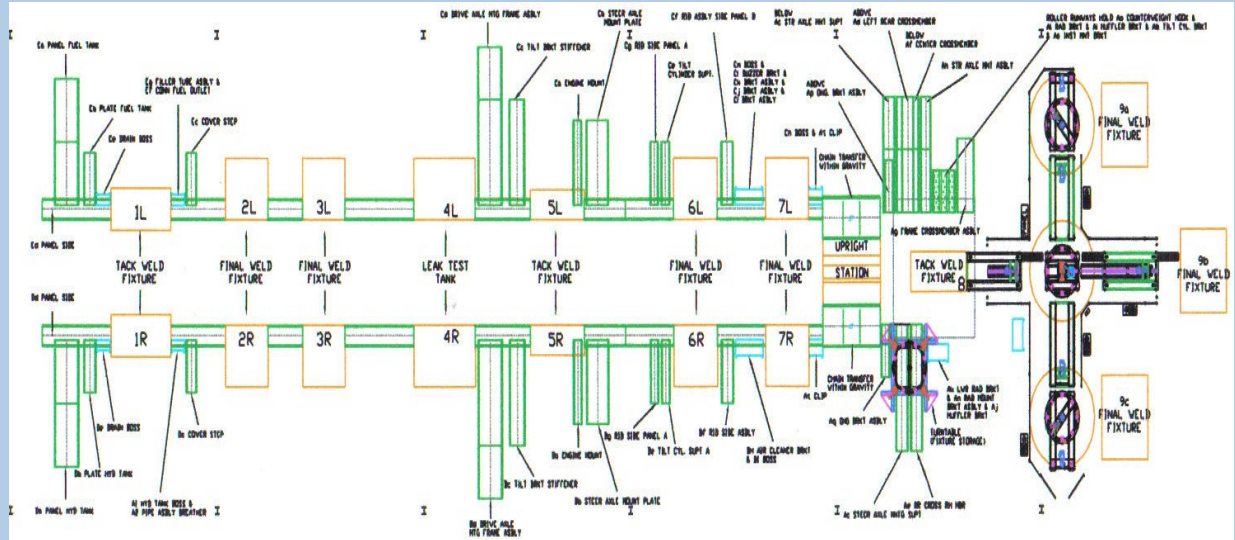


Case study: Forklift Manufacturer

SCHEME & EQUIPMENT, INC. ENGINEERED HANDLING SYSTEMS



A major Forklift Manufacturer had an unusual conveying need; their forklift welding line had to be able to easily transport forklift bodies from station to station during the welding process. The weldment got heavier and harder to handle as the process continued. SEI solved this problem with several standard approaches and some unique ones as well. Each side of the forklift body is moved forward from left to right in the drawing above (with the left body-half on the top line, the right body-half on the bottom line). Welding stations are brown, and roller conveyors are green. These conveyors are heavy duty gravity roller units up until a pop-up chain transfer after station(s) 7. The transfers pull each body-half weldment into the middle so they can be rough-welded to each other at station 8, about a five minute process. Since the operator needs to have access to move around the entire weldment, a Transfer car stands away to the right while this is done. When the rough-weld is completed, the T-car moves in and loads the weldment using a steel tabletop conveyor surface (a buss means the underside of the product is not firm and flat, so rollers would not work). Because station(s) 9 are actually three finish weld stations taking about 15 minutes each, a turntable with tabletop chain conveyor surface needs to deliver up on the page to 9A, straight ahead to 9B, or down on the page to 9C. The weldment goes up or down to 9A or 9C via a transit conveyor and then turns on another turntable. Alternatively, the weldment goes straight ahead to 9B using another Transfer car. That 9B Transfer car moves away during welding. The 9A and 9C turntables are actually cantilevered to rotate out of the operators way for welding.



Conveyors * Process Equipment * Packaging Equipment * Implementation

SCHEME & EQUIPMENT, INC.

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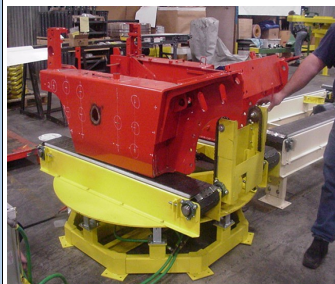
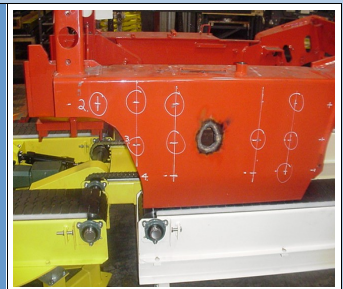
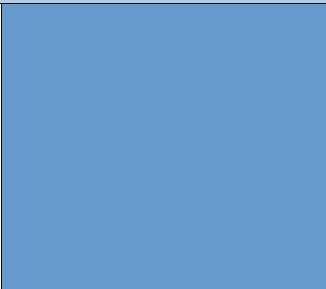
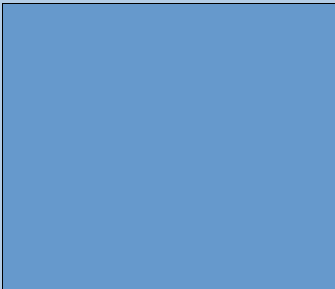
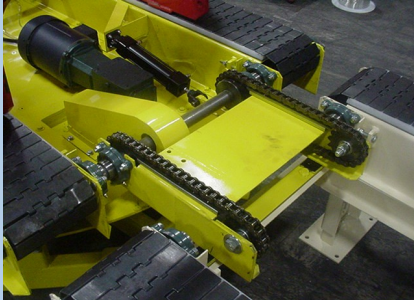
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Case Study: Forklift Manufacturer

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