



<b>IMH-AM-1500</b>	<b>IMH-AM-2000</b>	<b>IMH-AM-3000</b>
<b>Machine specification</b>	<b>Machine specification</b>	<b>Machine specification</b>
Leg channels 3 pcs	Leg channels 3 pcs	Leg channels 3 pcs
Nail boxes 1 pcs	Nail boxes 1 pcs	Nail boxes 1 pcs
Individual nailers 6 pcs	Individual nailers 6 pcs	Individual nailers 6 pcs
Minimum ceiling height: 4 400 mm	Minimum ceiling height: 4 400 mm	Minimum ceiling height: 4 400 mm
<b>Dimension of material</b>	<b>Dimension of material</b>	<b>Dimension of material</b>
<b>Decks:</b>	<b>Decks:</b>	<b>Decks:</b>
Tickness 28-64 mm	Tickness 28-64 mm	Tickness 28-64 mm
Width (flow direction) 600-1500 mm	Width (flow direction) 600-2000 mm	Width (flow direction) 600-3000 mm
Length (flow direction) 600-1400 mm	Length (flow direction) 600-1400 mm	Length (flow direction) 600-1400 mm
<b>Legs:</b>	<b>Legs:</b>	<b>Legs:</b>
Height: 87-132 mm	Height: 87-132 mm	Height: 87-132 mm
Width (flow direction) 75-145 mm	Width (flow direction) 75-145 mm	Width (flow direction) 75-145 mm
Length (flow direction) 600 - 1400 mm	Length (flow direction) 600 - 1400 mm	Length (flow direction) 600 - 1400 mm
<b>Pallets:</b>	<b>Pallets:</b>	<b>Pallets:</b>
Height: 111-196 mm	Height: 111-196 mm	Height: 111-196 mm
Width (flow direction) 600-1500 mm	Width (flow direction) 600-2000 mm	Width (flow direction) 600-3000 mm
Length (flow direction) 600-1400 mm	Length (flow direction) 600-1400 mm	Length (flow direction) 600-1400 mm
<b>Performance</b>	<b>Performance</b>	<b>Performance</b>
Change over time 3-15 minutes	Change over time 3-15 minutes	Change over time 3-15 minutes
Pallets 5 pallets / min	Pallets 5 pallets / min	Pallets 5 pallets / min
Wings 0-100** mm	Wings 0-100** mm	Wings 0-100** mm

\* Using both deck board magazines and 100% efficiency.

\*\*In width when looking in flow direction. Other dimensions of wings, contact IMH.

## Usage

The machine assembles finished wooden decks and legs to make 4-way pallets. There can be 2 or 3 legs per pallet.

## Function

Legs are fed into the leg channels and decks are placed on top. All parts are pushed by the same conveyor to the nailing position.

The finished pallets are pushed forward by the pallet behind.

Nail picking is pneumatic and all other operations incl. individual nailers are hydraulic (the machine has its own hydraulic unit).

The machine is controlled and monitored by its own PLC via an operator's panel.



### Nail dimensions

IMH nail boxes can handle following nail dimensions. Each ordered nailbox will be set for one selected nail dimension.

Diameter	2.1 - 4.2 mm
Length	40 - 100 mm
Quality	Machinery

### Electrical connections

Voltage	3 Phase 400 V 50 Hz
Main fuses	3 x 63 Ampere / Delay Action
Power consumption at 100% capacity	15 kWh

### Pneumatic connections

System pressure	6-10 bar
Nominal working pressure	6-7 bar
Consumption at 100% capacity	100 L / min

### Operators side

From the back end of the machine when looking in production flow direction.

### Options

Products	Remarks
Extended platform	<i>Extra space for nail storage.</i>
Extra nail box + fast change over	<i>Standard 1 pcs.</i>
Extra nailers	<i>Standard 6 pcs, max 12 pcs.</i>
4 leg channels	<i>Standard 3 pcs, 2 sections.</i> <i>Outer channels have their original motorized change over.</i> <i>Middle channel changed from fixed to manual change over via winch.</i> <i>The added middle channel (channel 3) is movable and manually fixed.</i>
5 leg channels (Standard 3 pcs, 2 sections)	<i>Outer channels have their original motorized change over.</i> <i>Middle channel stays fixed. Added channels 2 and 4, individually movable and manually fixed.</i>
2.5 channel sections per channel	<i>Standard 2 sections. Under board (leg) length increased from 1400 to 1700 mm.</i>
3.0 channel sections per channel	<i>Standard 2 sections. Under board (leg) length increased from 1400 to 2100 mm.</i>
Double motorized change over when 5 channels	<i>Middle fixed, 1 and 5 with their own change over, 2 and 4 with their own change over.</i>
2 x drive, 3 leg channels	<i>2 x drive to position decks and legs individually. 3 channel sections.</i>
2 x drive, 4 leg channels	<i>2 x drive to position decks and legs individually. 3 channel sections.</i>
2 x drive, 5 leg channels	<i>2 x drive to position decks and legs individually. 3 channel sections.</i>
Automated change over system per system	<i>Max 4 change over systems.</i>
Pallet outfeed puller	<i>Needed when after treatment conveyor comes after assembly machine.</i>