



IMH-BBM-1500	IMH-BBM-2000	IMH-BBM-3000
<p><b>Machine specification</b></p> <p>Over board magazines 2 pcs</p> <p>Under board channels 2 pcs</p> <p>Nail boxes 1 pcs</p> <p>Individual nailers 6 pcs</p> <p>Minimum ceiling height: 4 400 mm</p> <p><b>Dimension of material</b></p> <p><b>Over boards:</b></p> <p>Tickness 12-35 mm</p> <p>Width 75-145 mm</p> <p>Length 600 - 1500 mm</p> <p><b>Under boards:</b></p> <p>Tickness 12-35 mm</p> <p>Width 75-145 mm</p> <p>Length 600 - 1400 mm</p> <p><b>Performance</b></p> <p>Change over time 3-15 minutes</p> <p>Deck boards &lt; 1400 mm 25* boards / min</p> <p>Wings 0-100** mm</p>	<p><b>Machine specification</b></p> <p>Over board magazines 2 pcs</p> <p>Under board channels 2 pcs</p> <p>Nail boxes 1 pcs</p> <p>Individual nailers 6 pcs</p> <p>Minimum ceiling height: 4 400 mm</p> <p><b>Dimension of material</b></p> <p><b>Over boards:</b></p> <p>Tickness 12-35 mm</p> <p>Width 75-145 mm</p> <p>Length 600 - 2000 mm</p> <p><b>Under boards:</b></p> <p>Tickness 12-35 mm</p> <p>Width 75-145 mm</p> <p>Length 600 - 1400 mm</p> <p><b>Performance</b></p> <p>Change over time 3-15 minutes</p> <p>Deck boards &lt; 1400 mm 25* boards / min</p> <p>Deck boards &lt; 2000 mm 20* boards / min</p> <p>Wings 0-100** mm</p>	<p><b>Machine specification</b></p> <p>Over board magazines 2 pcs</p> <p>Under board channels 2 pcs</p> <p>Nail boxes 1 pcs</p> <p>Individual nailers 6 pcs</p> <p>Minimum ceiling height: 4 400 mm</p> <p><b>Dimension of material</b></p> <p><b>Over boards:</b></p> <p>Tickness 12-35 mm</p> <p>Width 75-145 mm</p> <p>Length 600 - 3000 mm</p> <p><b>Under boards:</b></p> <p>Tickness 12-35 mm</p> <p>Width 75-145 mm</p> <p>Length 600 - 1400 mm</p> <p><b>Performance</b></p> <p>Change over time 3-15 minutes</p> <p>Deck boards &lt; 1400 mm 25* boards / min</p> <p>Deck boards &lt; 2000 mm 17* boards / min</p> <p>Wings 0-100** mm</p>

\* Using both deck board magazines

\*\*In the length of the over boards. Other dimensions of wings, contact IMH.

## Usage

Built into a line of machines in order to complete the perimeter base, i.e. nails the first and last perimeter boards across the legs at the bottom of perimeter pallets, or a complete bottom deck on 2-way pallets.

## Function

The finished pallet is turned upside down and positioned in the Bottom Board Machine to receive the perimeter boards (4-way pallets) or a complete bottom deck (2-way pallets). The under board conveyor pushes the pallet into nailing position and the overboard conveyor pushes the perimeter boards into position. After nailing it is pushed forward by the next pallet.

The release function of boards from the perimeter board magazines, and nail picking, are pneumatic. All other operations, incl. individual nailers, are hydraulic and 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

### Air consumption

System pressure	6-10 bar
Nominal working pressure	6-7 bar
Consumption at 100% capacity	250 L / min

### Operators side

To the right of the machine when looking in the production flow. The machine can be constructed to have the operator on the left side if needed.

### Options

Products	Remarks
Extended platform	<i>Nail storage</i>
Extra nail box	<i>Standard 1 pcs</i>
Extra nail gun	<i>Standard 6 pcs, max 12 pcs</i>
2.5 channel sections per channel	<i>Standard 2 sections</i>
3.0 channel sections per channel	<i>Standard 2 sections</i>
Automated change over system per system	
Automated side feeding bottom boards	
Extra bottom board magazine	<i>Standard 2 pcs</i>
Extra long wing size over board (300mm)	<i>Standard 100 mm</i>
Equipment for 4 stringer solutions	
Pallet outfeed puller	