

# IMH STRINGER LINE 1500



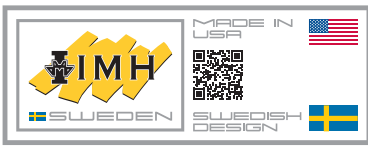
A line with **quick changeover** for  
double sided stringer pallets

**Online** connection for support

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**"IMH, we simply nail it"**





A line with **quick changeover** for double sided stringer pallets

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## 1 1<sup>st</sup> nailing machine (Top Deck)

- 1 PLC operator panel
- 3 stringer channels
- 2 top deck magazines
- 1 nail box
- 9 nailers (3/stringer)
- 1 notch support plate



Hydraulic individual nailers to ensure a powerful and reliable nailing (all nails run down even with different board heights).

Top Deck Boards	Imperial	Metric
Height	.472"–1.378"	12–35 mm
Width	2.953"–5.709"	75–145 mm
Length*	23.622"–55.118"	600–1,400 mm
Stringers		
Height	.630"–3.937"	16–100 mm
Width**	1.378"–5.709"	35–145 mm
Length	23.622"–55.118"	600–1,400 mm

\* 23.622" (600 mm) is possible if outer stringers are max 4.921" (125 mm) and middle stringer max 3.543" (90 mm) wide. Wings 0–3.937" (0–100 mm) in length of top deck. Other dimensions of wings, contact IMH.  
 \*\* Minimum width 1.063" (27 mm) as option.

## 2 Chain conveyor and flip flop

- 1 chain conveyor
- 1 flip flop turning the pallet upside down

## 3 2<sup>nd</sup> nailing machine (Bottom Deck)

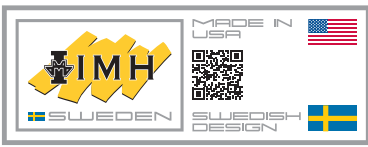
- 1 PLC operator panel
- 1 nail box
- 9 nailers (3/stringer)



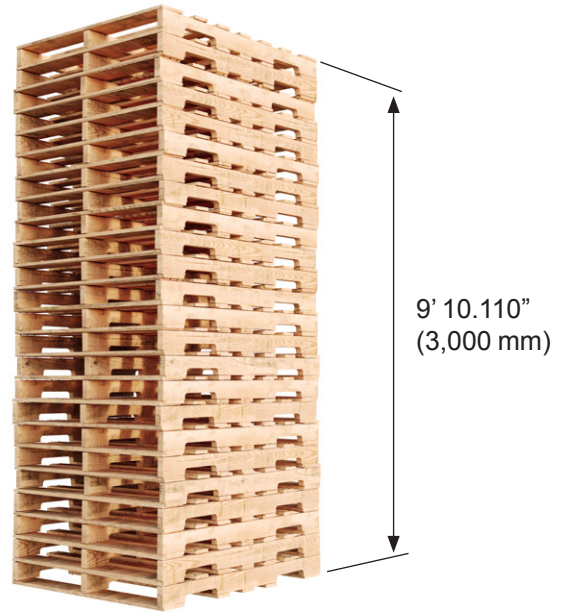
Hydraulic individual nailers to ensure a powerful and reliable nailing (all nails run down even with different board heights).

Bottom Deck Boards	Imperial	Metric
Height	.472"–1.378"	12–35 mm
Width	2.953"–5.709"	75–145 mm
Length*	23.622"–55.118"	600–1,400 mm

IMH STRINGER LINE 1500 DS requires that a bottom deck is nailed to the pallet.



# IMH STRINGER LINE 1500



- 4 **Chain conveyor and flip flop**
  - 1 chain conveyor
  - 1 flip flop turning the pallet upside down
- 5 **Stacker**
  - Stack height max 9' 10.110" (3,000 mm)
- 6 **Outfeed chain conveyor**
  - 16' 4.850" (5,000 mm)
  - 3 chains
  - Motorized changeover

## Line specification

### Capacity

Boards/min: 25 boards/min\* regardless of width (2.953"–5.709" (75–145 mm)) at 100 % efficiency. Expected real output at 75% efficiency is 18+ boards/min.

\* If the stringers have notches, the nailing speed must be reduced for the machine to be able to position the notch supports.

Set up and changeover time: All from seconds to minutes depending on pallet specifications.

### Operators, Education and Safety Instructions

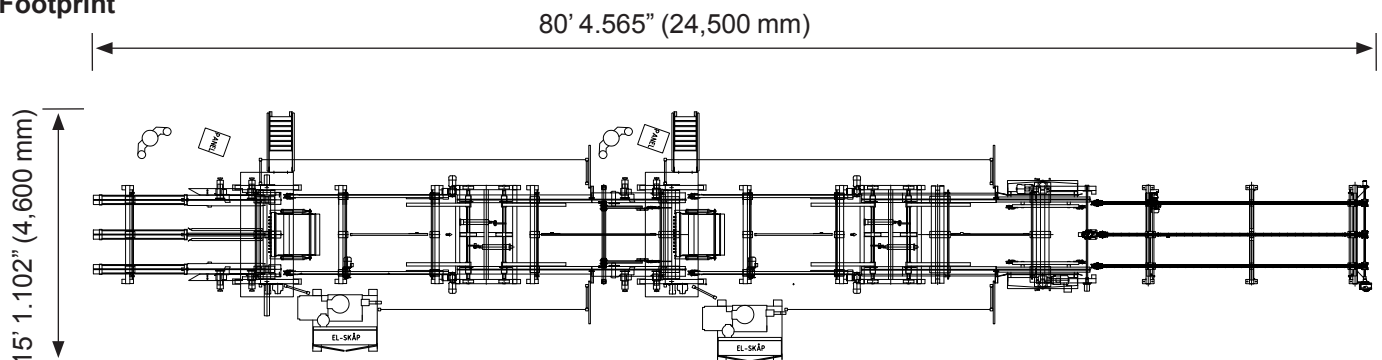
2 operators needed to run the line and one forklift driver feeding material to the operators and unloading stacks. Only IMH certified operators may run the line (see IMH Safety Instructions and IMH User Instructions, [www.imhmachinery.com](http://www.imhmachinery.com)).

### Site conditions needed

The purchaser shall arrange for following site conditions before the line is installed:

- Floor Concrete floor minimum thickness 3.937" (100 mm).
- Ceiling height Minimum 14' 5.228" (4,400 mm)
- Temperature Production hall must have a temperature between 41–104 F (5–40 Celcius)
- Hydraulic oil Purchaser shall arrange 2 barrels (52.83 gallons/barrel (200 liters/barrel)) of mineral hydraulic oil SH68.
- Ethernet One cable to each of the electrical cabinets at the two nailing machines.
- Power To each of the electrical cabinets at the two nailing machines:  
 Electrical power: 480 V, 60 A, 60 Hz  
 System pressure: 1<sup>st</sup> nailing machine: 7–10 Bars, 92.5 gallons/min (350 liters/min)  
 2<sup>nd</sup> nailing machine: 7–10 Bars, 66.0 gallons/min (250 liters/min)

### Footprint



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## Optional equipment

### 4th stringer

Added 4th channel including 3 nailers in the 1<sup>st</sup> nailing machine and supports and 3 nailers in the 2<sup>nd</sup> nailing machine.



### Branding

2 thermal branding heads. These are added on the chain conveyor right after the 2<sup>nd</sup> nailing machine.



### Switch conveyor

By adding a switch conveyor, which will make the stack change direction by 90 degrees, the standard outfeed chain conveyor can be turned 90 degrees to the left or right. This makes it possible to unload two stacks at the same time.



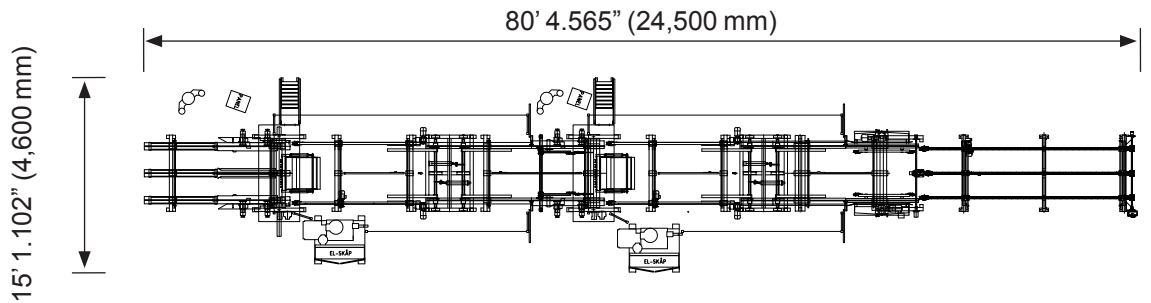
### Nail platform

By adding this platform, you can put a pallet of nails on the top, which makes it easy to refill the nail box. Max load on this platform is 3,307 lbs (1,500 kg).

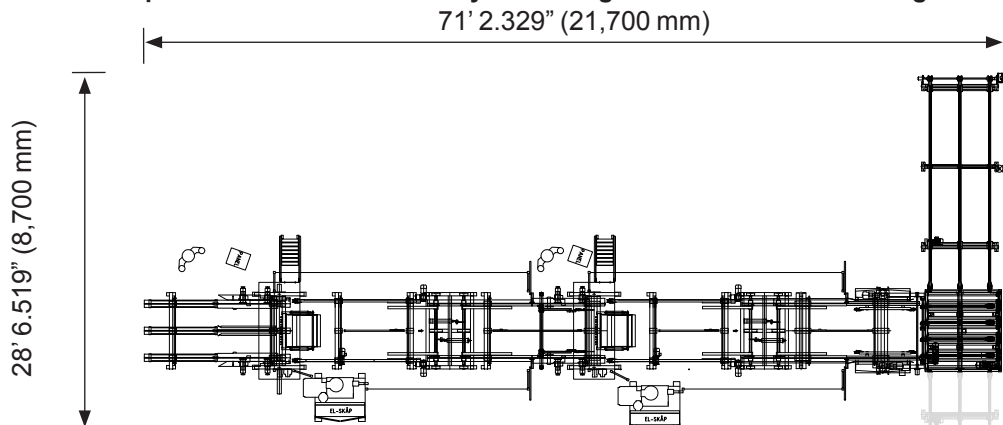


## Footprint

### Standard



### Added the option with the switch conveyor steering the stacks to the left or right



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