

SMART CONVEYOR

Basic Operation

Powering up the system

1. Turn on the power isolators on both the master cabinet and the StakPro cabinet.
2. On the wireless controller, turn the ID Key (lower left corner) to the ON position and check the E-stop button is not pressed in.
3. To arm the StakPro, press and hold the green START button on the wireless controller for a few seconds until the green light at the top of the controller begins to flash slowly. The yellow STAKPRO indicator on the master cabinet will illuminate.
4. Manually reset all other E-stops (pull cord, master cabinet button and all buttons on the upstream Randek system). When done, all the yellow indicators on the bottom row of the master cabinet will illuminate.
5. To arm the full system, press the CONTROL button on the master cabinet for one second. Once released, the system will be fully armed and the CONTROL button will illuminate. At this point, the StakPro is functional using the wireless controller.
6. To start the roller line, press the green START button on the master cabinet.



Note: a buzzer will sound for about three seconds to ensure anyone near the roller line is warned it is about to start automated operation.

7. Trusses will automatically be brought and centred into bay 2 for stacking.



Note: The roller line can be stopped at any time by pressing the red STOP button on the master cabinet. The StakPro will remain fully functional.

Operating the system

Once the system is powered and armed using the steps above, you can use the wireless controller to stack trusses with the StakPro.

- > Use the UP button to raise the boom and lift the truss off the rollers.
- > Use the DOWN button to lower the boom and lay the truss onto a stack.



Note: These buttons have two speeds depending on how hard you press. The slow speed is recommended if you need to raise the boom while extended.

- > Use the EXTEND button to move the truss from the rollers to over the stack.
- > Use the RETRACT button to bring back the boom to the rollers.



Note: these buttons are single speed.

The intended operation of the StakPro in conjunction with the Smart Conveyor system is as follows:

1. If needed, softly press the LEFT or RIGHT button on the wireless controller to jog the truss into the correct position before lifting.



Note: hard press the RIGHT button if you want to send the truss to the next bay.

2. Raise the boom to lift the truss.
3. Extend the boom so that the truss is sitting past the reaction posts.
4. Lower the boom to just above the stack.
5. Retract the boom fully.



Note: this will pull the truss against the posts, holding it in place while the boom is retracted.

6. Lower the boom fully.



Note: the next truss will automatically load into position for stacking.

7. Repeat from step 1.
8. Once a stack is full, use the TRANSFER button on the wireless controller to move the stack of trusses towards the end of the truss transfer chains.



CAUTION: PAY ATTENTION TO ENSURE YOU DO NOT MOVE THE STACK TOO FAR AND COME OFF THE END OF THE CHAINS.

Resetting the system

In the unlikely event the Smart Conveyor system does not behave as expected, a full reset will solve the issue. Simply press and hold the AUX button on the wireless controller for at least three seconds. This will clear the memory and return the system to normal operation.

Monthly maintenance

Roller line

- Grease the bearings at each end of every roller (two bearings per roller).
- Check the belt tension on all the driven rollers and adjust if needed.
 1. Loosen off the four bolts that hold the motor bracket to the support leg.
 2. Pull the motor down while re-tightening the bolts.

Truss transfers

- Grease the bearings at each end of every leg (four bearings per leg).
- Check the chain tension on all the legs and adjust if needed by using the four tensioning bolts at the non-driven end of the chain.