



Compact, Unique Merging Solution Saves DC \$240,000

Features and Benefits

Merging eighteen receiving lines into three within a limited space and budget

Continuous flow, accumulation-free merging

600 feet (183 m) of accumulation conveyor eliminated

\$240,000 in conveyor costs saved

Industry Group:
OFS

“Having spent considerable time in the new facility during the year following its go-live, I can say that the merges never needed maintenance attention. Unlike conventional merges with a handful of necessary control devices, this tool, with its no-controls approach, limits and simplifies maintenance and improves up-time.”



A major global apparel manufacturer initiated a project to replace two of its distribution facilities with one new, efficient, ergonomic building.

Challenge

A key part of the facility design was the receiving area. Project requirements called for a conveyance system to receive floor-loaded cartons from six containers simultaneously. In the design, six flows of cartons merge first into three accumulation lanes; those three lanes then feed a saw-tooth merge prior to an in-line scale and carton sorter.

The consolidation of these flows into a single stream of cartons had to occur on a busy receiving dock with limited space for accumulation conveyor.

Solution

Rather than going with a traditional solution to employ 600 feet of accumulation conveyor between the receiving docks and multiple curves to weave the accumulation conveyor through the confined receiving area, the winning solution was instead an innovative way to save cost and space while merging eighteen conveyor lines into three. Six mobile extendable conveyors unload the eighteen dock doors. Each extendable conveyor feeds its own static belt conveyor incline; those inclines then

directly feed three a 2:1 ARB Perpetual Merge. Unlike alternative merging technologies, the ARB Perpetual Merge does not require accumulation.

Results

By using three continuous flow merging systems that require no starting/stopping of infeed conveyors, the solution eliminated the 600 feet of accumulation conveyor required by the traditional merge solutions—and saved the client approximately \$240,000 of conveyor expenses. The lack of accumulation conveyor further reduced the equipment footprint in the receiving area, freeing up valuable floor space for the end user. Finally, the Perpetual Merge eliminated the need for most controls and their associated costs.



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