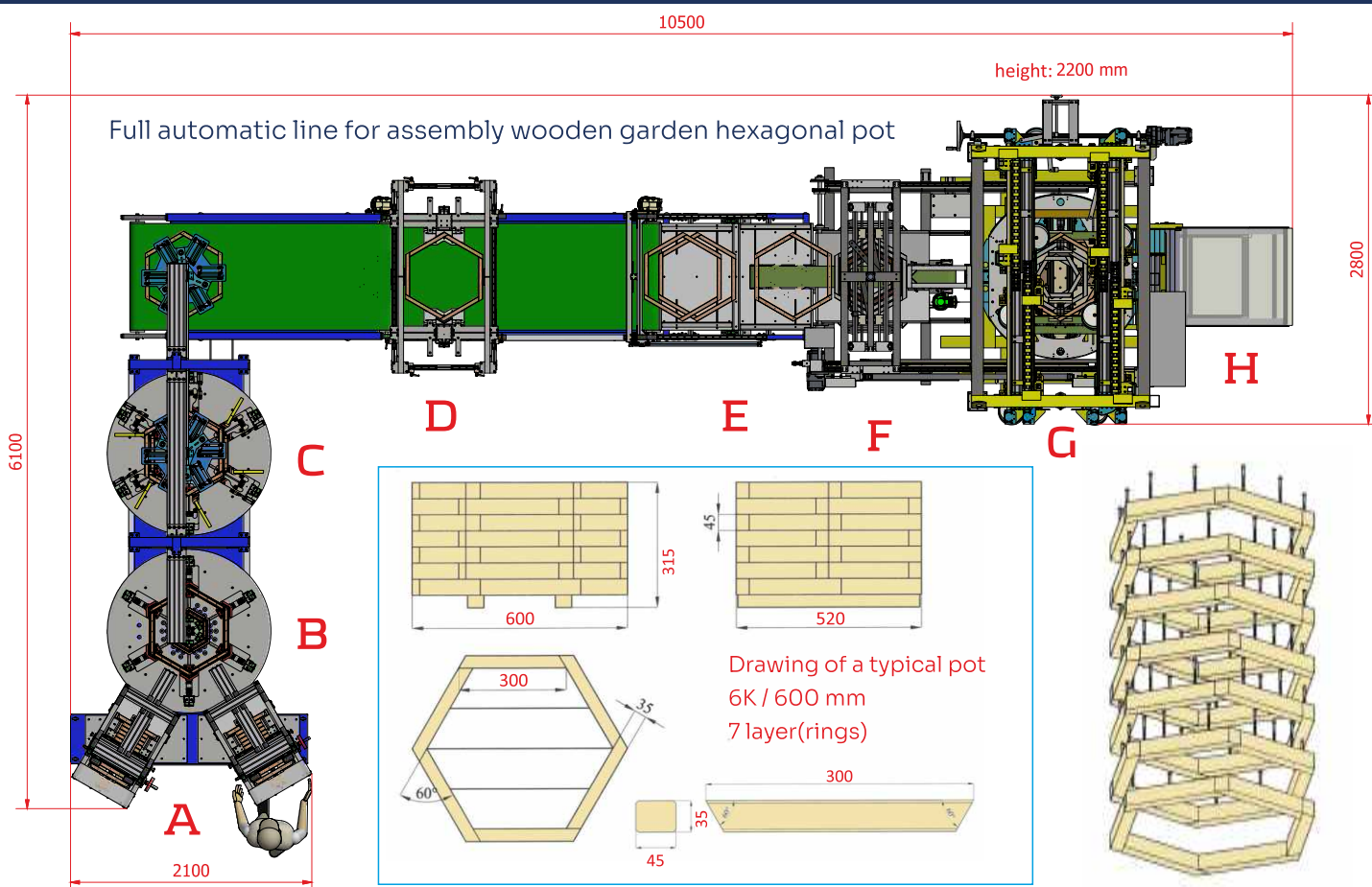


## DONICE 6K (hexagonal) wooden garden pot assembly line



The entire production process on the D6K line is fully automated.

The line can produce 6K (hexagonal) garden pot elements (without bottoms) within the dimensions:

- Slat length: from 200 to 320 mm; diagonal length of hexagonal frame: from 400 to 650 mm
- Garden pot height: 180–315 (4 to 7 rings)

The nailing line is operated by two people.

One person manually inserts the slats into the magazines, loads the W15 corrugated nails and starts the nailing cycle.

The second person is responsible for collecting the finished parts and reloading the pneumatic nail guns.

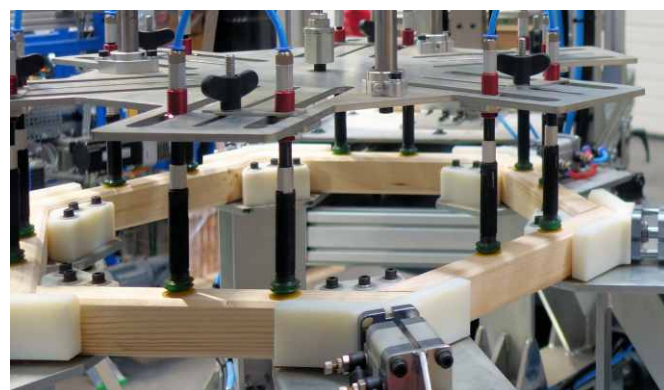
The nailing time for one hexagonal ring is 20 seconds.

Estimated output of the assembly line:

approx. 290 pieces of 5-layer pots, per shift.

Description of the elements of the 6K garden pot assembly line:

- A - slat magazines
- B - automatic hex. ring stacking machine (photo right)
- C - module for connecting the rings with W15 nails
- D - ring buffer conveyor
- E - module for turning over selected rings
- F - feeder
- G - module of connecting rings with pneumatic nail guns
- H - collection of finished pots (without bottoms)



Frequency of element loading:

- coil nails 900 pieces every 100 minutes
- W15 corrugated nails every 35 minutes
- frame magazines on a regular basis (2 x 14 pieces)

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Fastening systems: Staples, nails, tools and machines.