When production demand increases, multiple graders are often required. With stacked ‘waterfall’ style center grading systems, it is still possible to have multiple (up to 4) graders feed an Automatic Trimmer and Sorting System (bin or pull chain); all without losing the automation benefits of modern grading systems.

These systems require only one person to feed the subsequent grading stations. The graders can be fed by unluged backpressure and a dealing wheel (as shown), or with multi-chains and lugged feed for higher piece rates. All stations can handle a wide variety of boards, and are offered with either manual or automatic returning systems. Lugged feed systems can be integrated with overhead laser lights on a shifting frame, offering precision ‘Maxi-Trim’ solutions to the grader for greater recovery and flexibility.

All stations can also be provided with a mobile grading seat, that allows the grader to precisely position themselves over the center of their boards.
These systems allow multiple graders to operate above the lug at a reduced lug speed for better high speed grading quality. Many stations are available with automatic turning.

- **'Shark Fin' Above Lug Stations** - This allows piece rates of 25 bpm + per grader with multiple graders in sequence.

- **Sloped Table with Surge Hooks** - These stations allow for up to 22 bpm per grader and the grader can move with the more difficult boards. Each board ‘stops’ for a good inspection without motion at the hook stops.

- **Table without Surge Hooks** - these systems are capable of greater rates than the surge hooked stations and are able to fit more in a shorter footprint. Capable of 25+ bpm per grader.

- **Lugged Table with Inertial Turning** - Capable of 60+ bpm per station, with auto turning. A good system for high speed dimensional grading.

- **Lugged Table with Speedup Chains (not shown)** - Capable of 25+ bpm per grader, they allow the flexibility to move with the board along the station, and assist turning along their full travel.

- **Unlugged Grading from the End** - This allows multiple graders to grade boards that are not on lugs. The result is slower transfer speeds that can be coupled with board spacing systems for ease of turning.

**Multi-Grader - End Grading**

**Single Level - End Grading**

- **Sloped Chains with Speedup Chains** - Simple End Grading for multiple graders that can move with the lumber, and use the speedup chains to assist in turning the boards.

- **'Shark Fin' Grading Stations** - Available in sloped and unsloped chainways with single or multiple graders. The boards are automatically turned for the grader.

- **Lugged Grading with Serve Turner** - This turning system can selectively turn pieces and doesn’t require the proprietary lugs of the Shark Fin System. This results in transfer savings through the integration of even end rolls within the grading transfer.

- **Unlugged Grading from the End** - This allows multiple graders to grade boards that are not on lugs. The result is slower transfer speeds that can be coupled with board spacing systems for ease of turning.

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