



**Material Handling Systems
& Factory Automation**

**Dakota
Automation** inc.

Innovative Products for Innovative People

midwest 
GROUP ONE

DA 2000 Single Bay Stacker/Feeder

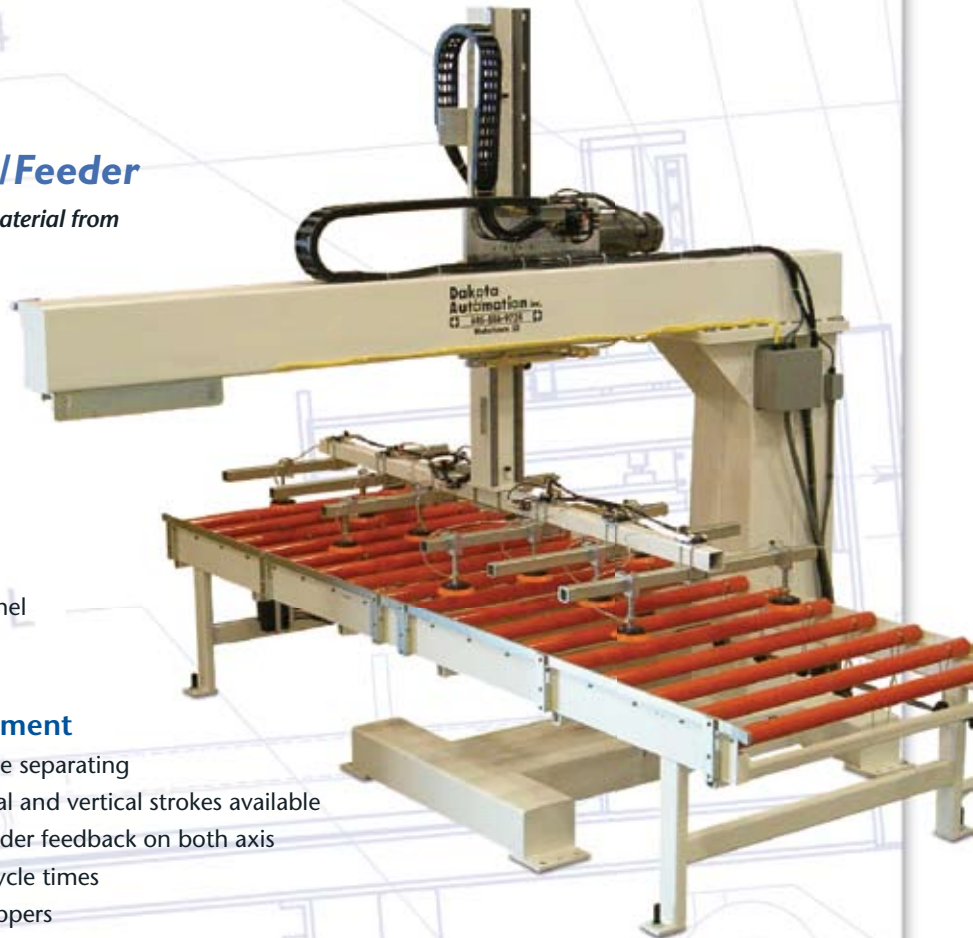
The DA 2000 is designed to feed or stack sheet material from a single position or onto a single position.

Standard Features

- Heavy duty welded frame
- VFD controlled AC motor on horizontal and vertical axis
- 72" usable horizontal stroke
- 50" usable vertical stroke
- Decentralized pneumatic vacuum system
- 500 lb load capacity
- Maximum cycle time is 10 seconds per panel
- UL508A control cabinet
- Allen Bradley controls

Optional Equipment

- Pneumatic piece separating
- Other horizontal and vertical strokes available
- AC motor encoder feedback on both axis for improved cycle times
- Mechanical grippers
- Part rotation
- Pneumatic short stroke vertical axis when used with lift table
- Safety guard fence and light curtain



DA 2001 Gantry Stacker/Feeder

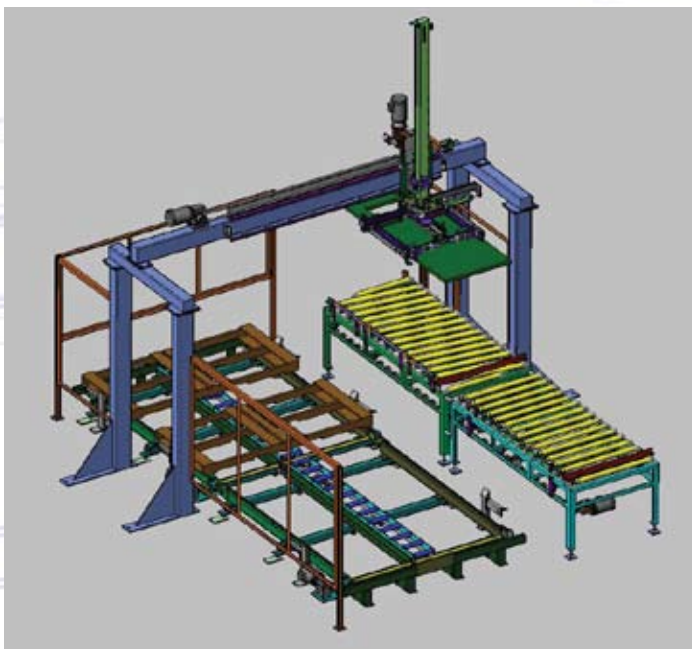
The DA 2001 is ideal for a customized feeder or stacker application.

Standard Features

- Heavy duty welded frame
- H Style gantry stacker/ feeder
- VFD controlled AC motor on horizontal and vertical axis
- Customer specified usable horizontal stroke
- Customer specified usable vertical stroke
- Decentralized pneumatic vacuum system
- 500 lb load capacity
- UL508A control cabinet
- Allen Bradley controls

Optional Equipment

- Pneumatic piece separating
- AC motor encoder feedback on both axis for improved cycle times
- Mechanical grippers
- Part rotation
- Pneumatic short stroke vertical axis when used with lift table
- Safety guard fence and light curtain



DA 2002 Singulating Panel Feeder

The DA 2002 is designed to feed single sheets of material into a process line with no manual setup for lengths.

Standard Features

- Heavy duty welded frame
- VFD controlled AC motor driven pusher dogs
Note: No manual length setup required
- Standard material lengths 8', 10', and 12'
- Rear bunk loading
- Lift table and lift conveyor will be quoted separately per customer specifications

Optional Equipment

- UL508A control cabinet and PLC for independent operation
- Intermediate fork system
- Side loading
- Safety guard fence and light curtain



DA 3000 Belt/Beam Panel Flipper

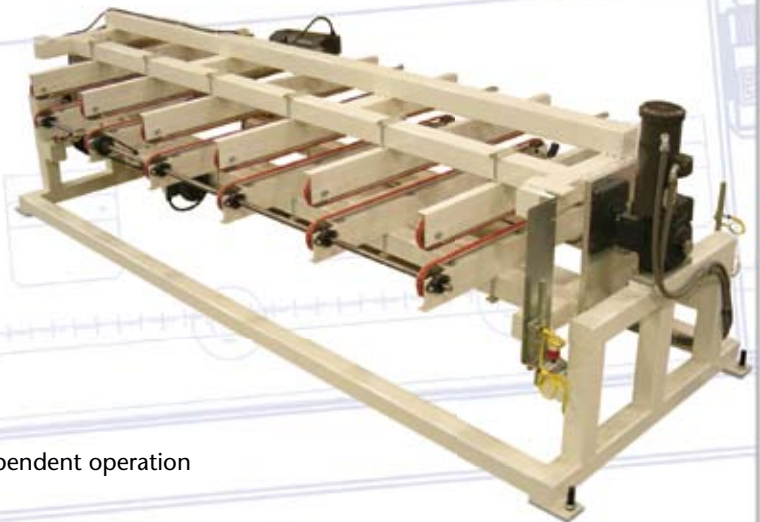
The DA 3000 is ideal for flipping sheet material when being conveyed laterally.

Standard Features

- Heavy-duty welded frame
- Maximum panel size is 5'x 12'
- Minimum panel size is 2'x 4'
- Two belt beam conveyors with B-section link belts
- VFD controlled AC motor belt conveyor drives
- VFD controlled AC motor rotational positioning

Optional Equipment

- UL508A control cabinet and PLC for independent operation
- Safety guard fence



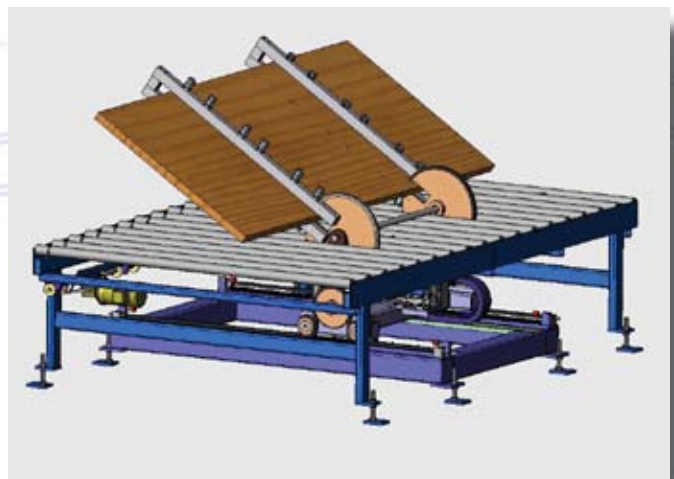
DA 300I Fork Style Door Flipper

Standard Features

- Heavy-duty welded frame
- Line shaft roller conveyor driven with ¼ diameter laser welded urethane belts
- 2.5" diameter steel or vinyl rollers
- Minimum door size is 16"x 48"
- Maximum door size is 56"x 120"
- Maximum door weight is 250 lbs
- VFD controlled AC motor rotational positioning
- Flipping forks with pneumatic cylinder clamps

Optional Equipment

- Safety guard fence



The DA 300I is ideal for flipping doors or large panels inline.

DA 1000 Powered Roller Conveyor

The DA 1000 is ideal for conveying single sheet material and customization for the customer's application.



Standard Features

- Heavy-duty welded frame
- Line shaft roller conveyor driven with 1/4 diameter laser welded urethane belts
- 1.9" or 2.5" diameter steel or vinyl sleeved rollers
- Customer specified roller centers
- VFD controlled AC motor on roller drive
- Conveyor width configurations from 2' up to 5'
- Conveyor length configurations from 6' up to 13'

DA 1002 Belt/Beam Conveyor

The DA 1002 is designed to laterally convey material or to use with the DA 1001 powered roller conveyor to convey the material.



DA 1003 Bunk Conveyor

The DA 1003 is designed for loading and unloading areas for bunk material.



Standard Features

- Heavy duty welded frame
- 9, 11 and 13 foot lengths
- 4 and 5 foot widths
- 3.5" diameter heavy wall steel rollers with dual #60 sprockets and chain
- VFD controlled AC motor on roller drive

Optional Equipment

- Heavy duty welded forklift pockets
- Side squaring posts

DA 1001 Jump Powered Roller Conveyor

The DA 1001 is ideal for conveying single sheet material and can be used with the DA 1002 for lateral transfers.



Standard Features

- Heavy-duty welded frame
- Line shaft roller conveyor driven with 1/4 diameter laser welded urethane belts
- 1.9" or 2.5" diameter steel or vinyl sleeved rollers
- Customer specified roller centers
- VFD controlled AC motor on roller drive
- Conveyor width configurations from 2' up to 5'
- Conveyor length configurations from 6' up to 13'
- Pneumatic lift cylinders with air valve

Conveyor

Convey single sheet material
or jump conveyor to cross convey



Standard Features

- Heavy-duty welded frame
- Conveyor length configurations from 2' up to 18'
- Conveyor width configurations from 6' up to 12'
- Customer specified belt beam spacing
- Belt beam conveyor with B-section link belts
- VFD controlled Ac motor on belt conveyor drives

DA 1001 Powered with DA 1002 Side Shift Belt Conveyor

The DA 1001 can be combined with the DA 1002 to create a customized conveying system to fit the customer's specific requirements.

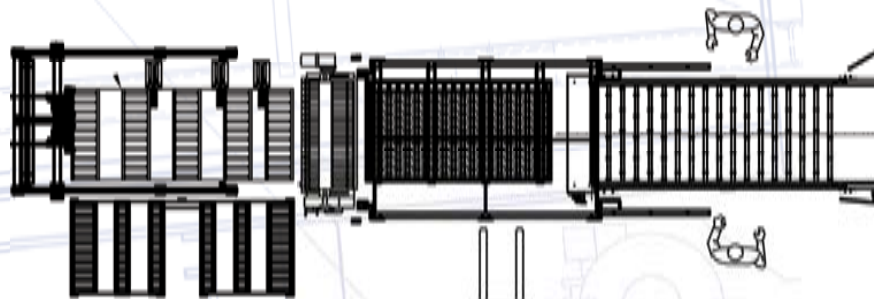


Factory Automation Solutions!



Built for an architectural plywood manufacturer, this system is a great example of how [Midwest Automation](#), [ORMA•Midwest](#) and [Dakota Automation](#) combine resources to provide "turn-key" solutions for meeting specific laminating, edgetrimming, sanding, and material handling requirements.

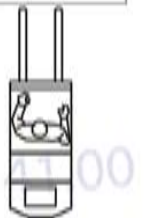
The end result is improved throughput with less scrap and reduced labor cost!

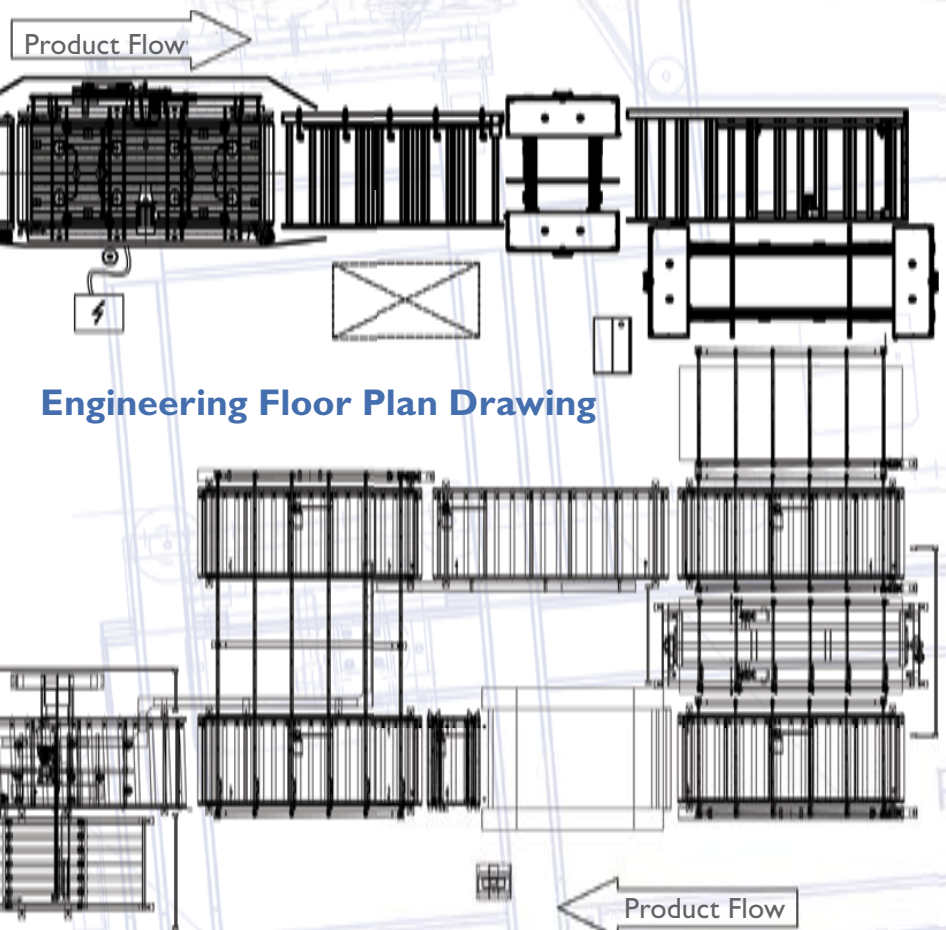


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Engineering Floor Plan Drawing

Dakota Automation inc.

Dakota Automation, Inc. was founded in 1999 with the goal of providing high quality, expertly designed and cost competitive solutions for industrial automation and material handling equipment. The investment group is comprised of four engineers with 75+ years of combined experience, located in Watertown, South Dakota. Dakota Automation has partnered with Midwest Group One to provide factory automation solutions for the woodworking industry worldwide.

Innovative Products for Innovative People. **midwest GROUP ONE**

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