Spetsyfykatsyonaya pyloproduktsyya, raspylovka, optimization, defekty, pylomateryal, billets, Cutting plan, Useful Out

Analyzed previous studies of processes of cutting timber on the workpiece size-based qualitative characteristics of timber when they crawl. The possibility of increasing volume and quality output blanks.

Specification pyloproduktsiya, cutting, optimization, defects, timber, harvesting, cutting plan, useful output

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DEVELOP RECOMMENDATIONS ON DELIVERY STORAGE AND STRAW FOR THE MANUFACTURE OF PARTICLE BOARD

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Analyzed the operation of supply and storage of raw materials for particle board. The main differences from straw woody materials and tasks for the organization of supply and storage of straw. Formed advice straw supply to the plant and its storage in warehouses for the effective organization of the process of manufacturing particle board using a straw.

Straw, supply, storage, particle boards.

Efficiency of particle board is largely dependent on the presence in the region of sufficient raw capacity of its procurement and supply [1].

Storage of wood raw material to the company's warehouses affect the quality and costs of raw materials and as a result, the quality of the finished plates [2].

The process of manufacturing particle board using straw straw provides delivery to the plant and its storage in warehouses. However, because the straw and now that the acute shortage of wood as a raw material is not considered, but only as waste, no recommendations on the straw supply to the plant and its storage in warehouses. Established same manufacturing operations and supply of wood raw material storage can not be applied to straw through significant differences in terms of their preparation, transportation and storage. Therefore, for the

production of particle board using straw develop recommendations for storage and delivery date.

Analyzing the operation of supply and storage of raw materials for particle board has been allocated the following main differences straw from woody material:

- variability volumes harvesting and transporting straw distances, due to annual recovery resources straw and focus them every year at different distances from the company;
- different ways of harvesting and storing straw and wood suppliers;
- different conditions and means of transportation;
- differences in storage straw in the company that affect its properties and size of warehouses.

Based on these differences straw from woody material has several main objectives for the organization and delivery of storage straw

- assess straw resources in the region;
- conduct logistics;
- organize the supply of straw;
- provide storage of straw on the premises.

*Resource assessment straw in the region.*Even if there is sufficient amount of straw on economic reasonable distance from the plant is important to ensure that potential suppliers actually are interested in selling the company. In other words, business and consumer should encourage the geographically close to it in farms producing grain cereal straw and marketing it.

Harvesting straw farms can be carried out by different techniques:

- after thrashing skladuvatysya in stacks and then transporting bulk;
- podribnyuvatysya box and accumulate in powdered form;
- compressed into small bales;
- compressed into large bales without crushing or shredding the previous;
- compressed into large rolls.

Given the international experience, preference should be given assembly technology straw baler, forming it into large rectangular bales weighing 300-500 kg. This technology has undeniable advantages over other technologies picking straw, so providing [3, 4]

- better performance compared with other balers, such as rolled;
- high density pressing - 1.3 times higher than in round balers;
- better capacity utilization of vehicles through rectangular shape Bale;
- higher productivity forklifts and vehicles;
- better use of storage volume;

- a significant reduction in costs to the binding twine bale;
- lowest labor costs;
- efficiency technologies with increasing distance transport bales.

Therefore, for enterprise customers, in addition to the above measures, it is important to organize the farms as possible, given the technology of harvesting straw.

*Logistics.*Large-scale harvesting straw logistics required to ensure the supply of straw in sufficient quantity, good quality and reasonable price. After forming bale loading them on vehicles is best handled using forklifts. Transportation straw bales can make all types of transport. Established that the break-even distance transportation of raw material for chipboard should not exceed150 km for road transport and 300-400 km Track [1]. However, transporting straw expedient to carry out road.

*The organization supplies straw.*Depending on the volume of production and availability of space straw supply can be made periodically during harvesting, followed by storage in the enterprise, or continuously with storage areas supplying farms. The advantage of the first method is self-provided with raw materials, but the disadvantages are significant one-time investment for the purchase of straw, organization and maintenance of large storage space. In the second case, the company-consumer concludes a contract for daily or weekly supply of straw from farms suppliers and individual farmers. This reduced one-off costs for the purchase of raw materials, reduced storage space and the cost of their services.

Upon receipt of straw on the company by its acceptance and quality control.

Unloading bales and places them in a stack loader or carried on a conveyor belt.

*Storage on the premises.*Methods for storing straw on the degree of reduction in price can be placed in the following order: storage in closed warehouses, under a canopy (the roof on poles), under a tarpaulin, in a polymer film in the open. Storage conditions affect the quality of straw. When stored in the open zamokaye large amount of straw, which requires additional costs to dry. Storage under the sheet or film is not recommended in climatic conditions with strong winds. Use awnings can also lead to deterioration of the straw, because moisture to the outer layer thickness 0.5 m it increases to 20-25% [3]. To avoid wetting canopies should be large zvisy that rainwater does not impinge on straw. It is important to ensure access to straw to simplify storage and loading and unloading. When using closed syllables very useful belts because when using front loader needs additional space to maneuver it.

Summarizing the arguments, enterprise manufacturing particle board from straw for delivery and storage of straw should observe the

following guidelines:

- business-to-consumer should encourage the geographically close to it in farms producing grain cereal straw and marketing it;
- for enterprise customers, it is important to organize the farms, if possible, harvest straw in large rectangular bales;
- transporting straw expedient to carry out road;
- provide better straw storage areas with continuously supplying farms, promoting proper STORAGE;
- the use of closed syllables automation fasting skladuvalnyh work for straw storage on the premises that will best preserve the quality of straw.

The recommendations will make it possible to efficiently organize production workflow chipboard using straw at the stage of delivery and storage.

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Done delivery operations analysis and storage of raw materials for shaving plates. Vыdelenы Main razlychyya solomы from arboreal raw materials and task organization for snabzhenyya and storage solomы. Sformyrovano recommendations on deliveries solomы in the enterprise and storage warehouses for Effective organization of technological process plates with shaving Production Using solomы.

Straw, delivery, storage, struzhechnыe stoves.

An analysis of operations supply and storage of raw material for particle boards was made. There were highlighted the main differences between straw and wood raw material and objectives for the organization of the supply and storage of straw. Were formed the recommendations for the supply of straw to the plant and storage it in warehouses for efficient process of manufacture of particle board using straw.

Straw, supply, storage, particle boards.