

Montrose inspection and handling systems provide a complete inspection, rejection, and handling solution created just for bun/roll manufacturing lines. Receive comprehensive statistical analysis of variability while removing human involvement from inspection, rejection, and laning.

A high speed, turnkey system that allows you to:

1. Assure quality on a 100% monitoring basis.
2. Remove individual defective and non-conforming product from the line.
3. Monitor process statistics to pinpoint causes of waste.
4. Equally feed in-spec buns into each of the packaging lanes.
5. Automatically buffer in the case of bottlenecks.
6. Rapidly recognize a positive ROI by improving quality, reducing waste, and automating production - in previously labor intensive areas.



Solution Components	FocalPoint	MT Series	Autolaner
Inspection	X	X	
Bottom Color Inspection		X	
Automated Rejection		X	
Laning for Entrance to Packaging			X
In-line Accumulation / Buffering		X	X
Color Imaging	X	X	
Statistical Analysis and Reporting	X	X	
NEMA 4X	X	X	X
3A Dairy Sanitary Design		X	

> *Isolate and Eliminate Sources of Waste*

Automated inspection provides real-time and historical information on fault, and out-of-spec conditions, allowing you to isolate the issues causing the most waste by shift, product, line, and plant. The measurement results will also make it easier to reach consistent quality when developing new products or when formulation changes are made.

Analysis Type	Example Faults	Impact on Customer or Plant	Rejection Capability	Statistical Analysis
Geometrical Analysis	Too large or small	Product rejection	0 - 100% fully under plant control	SPC Analysis On-line Reporting
	Too tall or short	Customer complaints		
	Ovality	Handling problems, such as jamming at the slicer / bagger	Worst fault Pareto	
	Doubles			
	Poor symmetry			
Crushed / dented				
Color Analysis (Top and Bottom)	Under- or over-baked	Consumer complaints	0 - 100% fully under plant control	SPC Analysis On-line Reporting
	Visible debris	Product rejection		
	Blisters	Topping giveaway	Worst fault Pareto	
	Blotchy			
	Foreign material			
	Too much topping			
	Too little topping			
	Heel flour			
	White Rings			

> *Measure, Reject, Buffer, Lane*

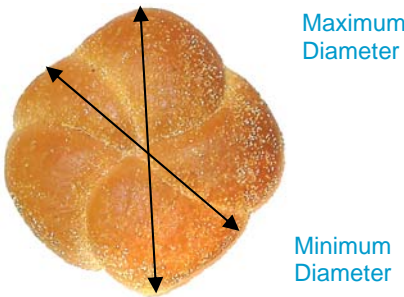
The **MT Series inspection system** may be installed immediately after the depanner for fast real-time data, or just before packaging where the system acts as the 'gate-keeper'. A vision system and Autolaner combination assures smooth flow of quality buns into the slicer, with the removal of oversized product, belt speed changes, diversion, and/or lane balancing.

> **Common Height Analysis**



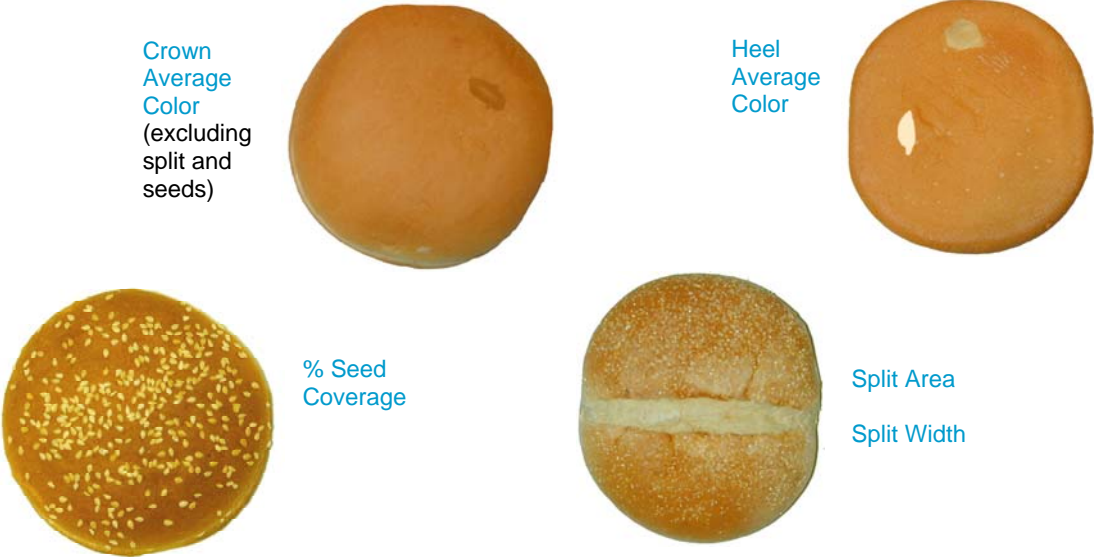
Profile height calculations are based on hundreds of individual height values gathered on every product, which leads to a measurement accuracy of $\pm 0.5\text{mm}$. **Mean Height** is another common measurement applied to buns.

> **Common 2-D Analysis**



Two dimensional calculations are based on an accurately defined perimeter, which is imaged by both overhead cameras. 2-D measurement accuracy is $\pm 0.5\text{mm}$. **Mean Diameter**, **Roundness**, **Surface Area**, and **Volume** are other common measurements applied to buns.

> **Common Color Analysis**



True color calculations, on both the top and bottom surface of the product, are measured in various units such as dbu, L, and HSB.

Plain, Seeded, Rectangular, Split Top, Kaiser....Any Roll Product

> Common Fault Analysis



Seed Voids
(regional low color deviation)



Misshaped Slope
(poor height symmetry)



Blotchy
(regional high color deviation)



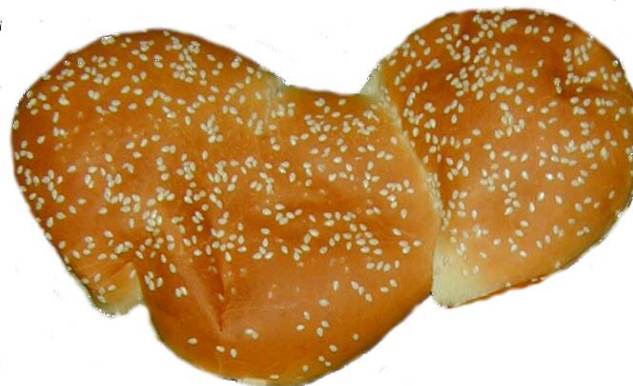
White Ring
(light area near heel perimeter)



Blisters
(dark surface area)



Heel Flour
(very light heel area)



Double / Triple
(large surface area)

Only common examples have been pictured. There are more than 100 standard measurements that can be used, individually or combined within formulae, to qualify your product. **All visible product characteristics and faults can be quantified.**