### System Operation

**Indexer** – Evenly spaces cases for presentation to the Infeed Conveyor

**Infeed Conveyor** – Angled roller belting moves case to left side. Conveyor then transports cases onto conveyor scale; belt speed is matched exactly to belt speed of Conveyor Scale.

**Conveyor Scale** – Weighs cases and sends weight to the SDS Controller

**Outfeed Conveyor & Pusher** – Cases run into product stop where label will be applied. Pusher will then activate to push the case onto the angled Roller Belting Conveyor.

**Printer/Applicator 1** – Prints weight and other information on label; then applies to side of case (red line indicates label placement)

**Scanner 1** - Verifies readable label barcode on the side

**Angled Roller Belting Conveyor** – Transports cases to the opposite side for label application

**Labeling Conveyor** – Transports cases past printer/appliactor 2, scanner 2 and divert.

**Printer/Applicator 2** – Prints weight and other information on label; then applies to side of case

**Scanner 2** - Verifies readable label barcode on the side

**Divert** – Removes unscannable cases from product line for rework