Between two lines of stacks and at the back of each is a permanent set of live rolls driven by light chains. Stacks are pulled down on to the live rolls, and proceed to a portable grading and tallying table. These tables consisting of a length of controlled rollers on to which the timber is directed from the live rolls. At the end of these is a goose saw generally working from underneath pulled up with the right hand. The rollers are controlled by pressure of the left hip against spring-loaded friction. Timber is square ended and docked both ends if necessary, grade and length marked, from a tally rod extending from the goose saw. Timber is then conveyed direct to barge, where it is stacked and end branded in accordance with grade marking.

Pulling down	1 man.
Goosing	1 man.
Grade, marking and tallying	1 man.
Stacking in barge	1 man.
Branding	1 boy.

It is claimed that four men and one boy handle—

16,000	per eight hours in	$4 \times \frac{3}{4}$.
24,000	,,	6×1.
30,000	,,	9×1.
40,000	,,	9×3.

In the same yard nine men are filleting 80,000 per day average, with the use of an electric straight-lift stacker, and taking delivery from sorting chain.

Delivery from the sorting chain with tractor	1 man	1	1
Two electric stackers, each loading straight from the truck	2 men	$2 \times 2 = 4$	
Unloading from stacker and filleting	2 men	$2 \times 2 = 4$	
		$+ 2$	
		9	9

An attempt has been made to sketch this layout on the following page.

At other operations mechanical methods are used such as—

Boxholms AB.

Complete load from kilns is lifted by overhead electrically operated purchase block to above the grading and tallying table.

Unstacked by hand and load lifts as stack reduces. Placed for trimming one end	1 man.
Automatic transfer across. Placed for trimming other end. Graded and tallied	1 man.
The grader sets one finger lever for grade, one for length, and timber is automatically stamped both ends with paint mark. Miller's brand. And both ends hammer branded with length, and tally is recorded.	
Reject timber is pulled off on to belt transfer by grader. Stacking to truck	1 man.

These men claim to handle 40,000 ft. b.m. of 6×2 per day.

Korsnas

Kiln loads on kiln trucks are run over an hydraulic lift similar to garage greasing-hoist. Timber is automatically unstacked layer by layer, and fillets dropped on to the belt, the hoist lifting as each tier is discharged on to grading-table.

Two men trimming, grading, and tallying, as previously described.