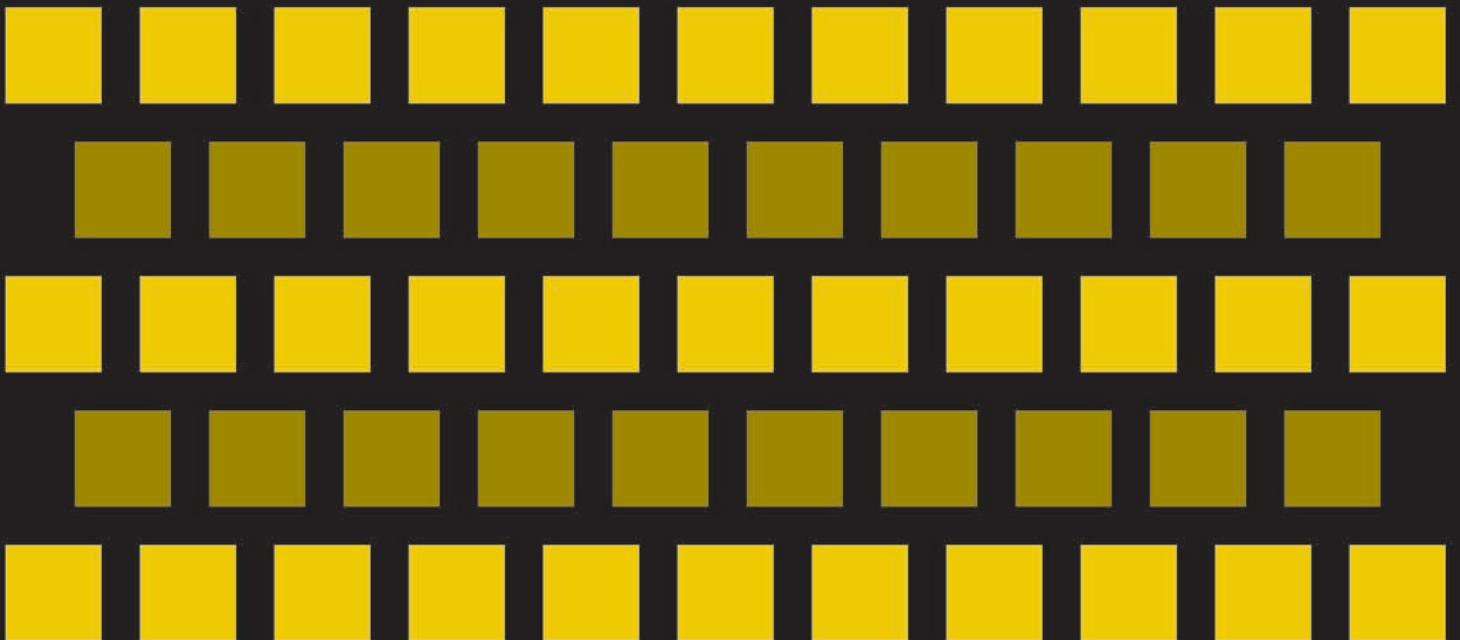


COMPARISON OF FEM STORAGE/RETRIEVAL MACHINE DOCUMENTS TO THE ASME B30.13 SPECIFICATION



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**COMPARISON OF FEM
STORAGE/RETRIEVAL
MACHINE DOCUMENTS TO
THE ASME B30.13
SPECIFICATION**

Prepared by:

Paul K. Gines
Independent Consultant



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FOREWORD

The consumer activity that is present in the North American market creates the need for guidelines to facilitate safe design, maintenance and operation of Automated Storage and Retrieval System (ASRS) and the included SR Machines. The intent of this document is to provide a broad perspective on the major differences between the FEM and ASME standards that can be used for consideration to maintain the technical relevance of ASME Codes and Standards products.

Established in 1880, the American Society of Mechanical Engineers (ASME) is a professional not-for-profit organization with more than 127,000 members promoting the art, science and practice of mechanical and multidisciplinary engineering and allied sciences. ASME develops codes and standards that enhance public safety, and provides lifelong learning and technical exchange opportunities benefiting the engineering and technology community. Visit www.asme.org for more information.

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ABSTRACT

The content of this report evaluates variances between Federation Europeenne de la Manutention (FEM) Automated Storage and Retrieval System (ASRS) standards and ASME B30.13 2003 Storage/Retrieval (S/R) Machines and Associated Equipment [1]. The intent of this document is to provide a broad perspective on the major differences between the FEM and ASME standards that can be used for consideration to maintain the technical relevance of ASME Codes and Standards products.

This document compares thirteen FEM ASRS documents that are outlined below to the ASME B30.13 specification.

- FEM 9.001 Terminology - Dictionary, Storage and Retrieval Machines
- FEM 9.101 Terminology - Storage and Retrieval Machines - Definitions
- FEM 9.221 Performance Data of SR Machines - Reliability/Availability
- FEM 9.222 Standards of the Acceptance and Availability of Installations with Storage Retrieval Machines and Other Machinery
- FEM 9.223 Basic Data and Criteria for the Construction of Automatic High Bay Warehouses with Distribution Systems
- FEM 9.311 Rules for the Design of Storage and Retrieval Machines - Structures
- FEM 9.512 Rules for the Design of Storage and Retrieval Machines - Mechanisms
- FEM 9.754 Safety Rules for Automatic Mini-Load Storage and Retrieval Machines
- FEM 9.831 Calculation Principles of Storage and Retrieval Machines - Tolerances, Deformations and Clearances in the High-Bay Warehouse
- FEM 9.832 Basis of Calculation Principles for SR machines - Tolerances, Deformations and Clearances in Automatic Small Parts Warehouses (not silo design)
- FEM 9.851 Performance Data of SR Machines - Cycle Times
- FEM 9.871 Logbook for Storage and Retrieval Machines and Transfer Devices
- FEM 9.881 Project Planning Data for Selection of Drives for Storage and Retrieval Machines

European ASRS equipment suppliers and consumers follow FEM standards while the ASME B30.13 specification is focused on applicability to the North American market. FEM standards cover a broad spectrum including project planning, equipment simulation and throughput, design standards, safety, defined operating clearances, etc. The ASME B30.13 specification is primarily directed to outlining safety and safe practices as it relates to equipment design, inspection, maintenance and operation. As a result, variances in the FEM and ASME B30.13 specifications exist. These variances could create opportunities for enhancements to the ASME B30.13 specification (if the safety directive of B30.13 was expanded) or new document development opportunities.

1 INTRODUCTION

The ASRS Market in North America was nearly \$268 million dollars in 2008 as reported by the Material Handling Institute of America (MHI). Comprised in this figure are 37 systems which consist of 185 Storage Retrieval (SR) Machines. A few statistics are worthy of consideration in defining North American ASRS consumers.

- 65% of companies that purchased systems in 2008 did not have prior ASRS systems
- 76% of companies that purchased ASRS systems in 2008 used them as a component of a larger automated material handling process
- 84% of companies who purchased ASRS in 2008 were not Fortune 500 companies

MHI reports categorize the North American ASRS market in four basic areas:

- Unit-Load Equipment: SR Machines handling load weights in excess of 1000 lb.
- Mini-Load Equipment: SR Machines handling load weights between 250 and 1000 lb.
- Micro-Load Equipment: SR Machines handling load weights up to 250 lb.
- Aftermarket: Post-warranty parts and service, equipment replacement and refurbishment and existing system expansions.

Over the past seven years, the ASRS industry in North America has experienced steady growth at an annual average rate of 15%. The MHI defined market segments have seen varying annual average rates in support of this figure.

The Unit-Load market during this period has been volatile with individual annual volumes being erratic from year to year. However, the Unit-Load market over the past seven year period has declined by nearly 3% per year.

Mini-Load equipment has experienced a cyclic market that overall has had steady growth. The average growth rate over the past seven year period has been just over 17% per year.

The Micro-Load market has seen rapid growth since 2002 as individual case and tote handling has become more widely accepted in the United States. This market has increased at an average rate of nearly 40% per year during the past seven year period.

The Aftermarket segment has also seen rapid growth during the past seven year period with an annual average rate of nearly 44%.

The consumer activity that is present in the North American market creates the need for guidelines to facilitate safe design, maintenance and operation of ASRS and the included SR Machines. The ASME B30.13 document is a necessary specification to ensure the basic aspects of consumer safety. The FEM documents outlined in this report cover a much broader spectrum than consumer safety which includes other topics that help guide manufacturers and consumers in system design and implementation.