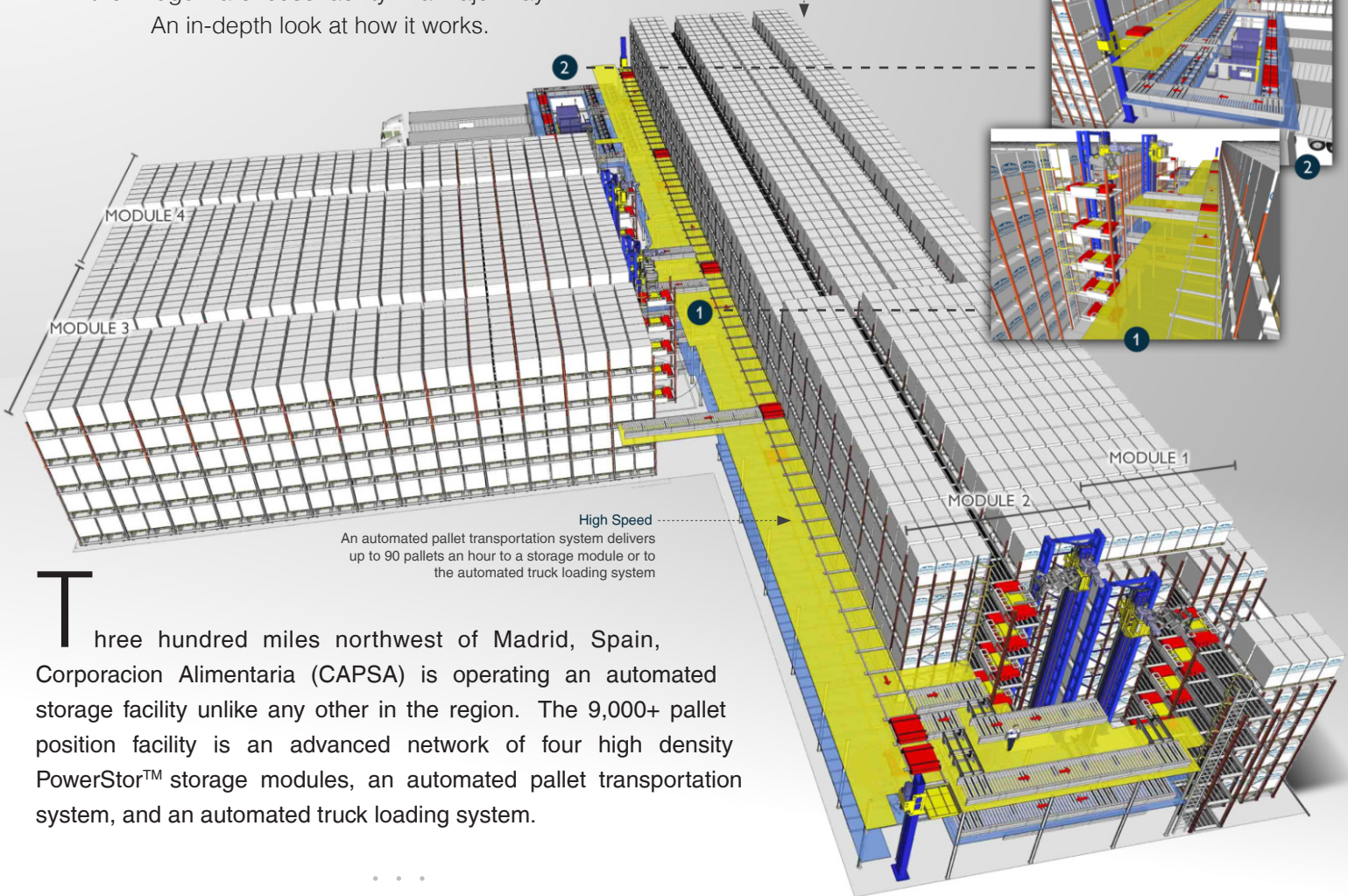


CAPSA's POWERHOUSE

Spain's dairy giant overhauled their Lugo warehouse facility in a major way. An in-depth look at how it works.



Three hundred miles northwest of Madrid, Spain, Corporacion Alimentaria (CAPSA) is operating an automated storage facility unlike any other in the region. The 9,000+ pallet position facility is an advanced network of four high density PowerStor™ storage modules, an automated pallet transportation system, and an automated truck loading system.

CAPSA commissioned **Power Automation Systems**, based in Lathrop, CA to revamp and automate their existing storage facility without constructing a new building or expanding the building's footprint. Prior to the overhaul, CAPSA was operating the warehouse space in a traditional manner; utilizing a team of forklifts and personnel to store pallets of product on conventional racking.

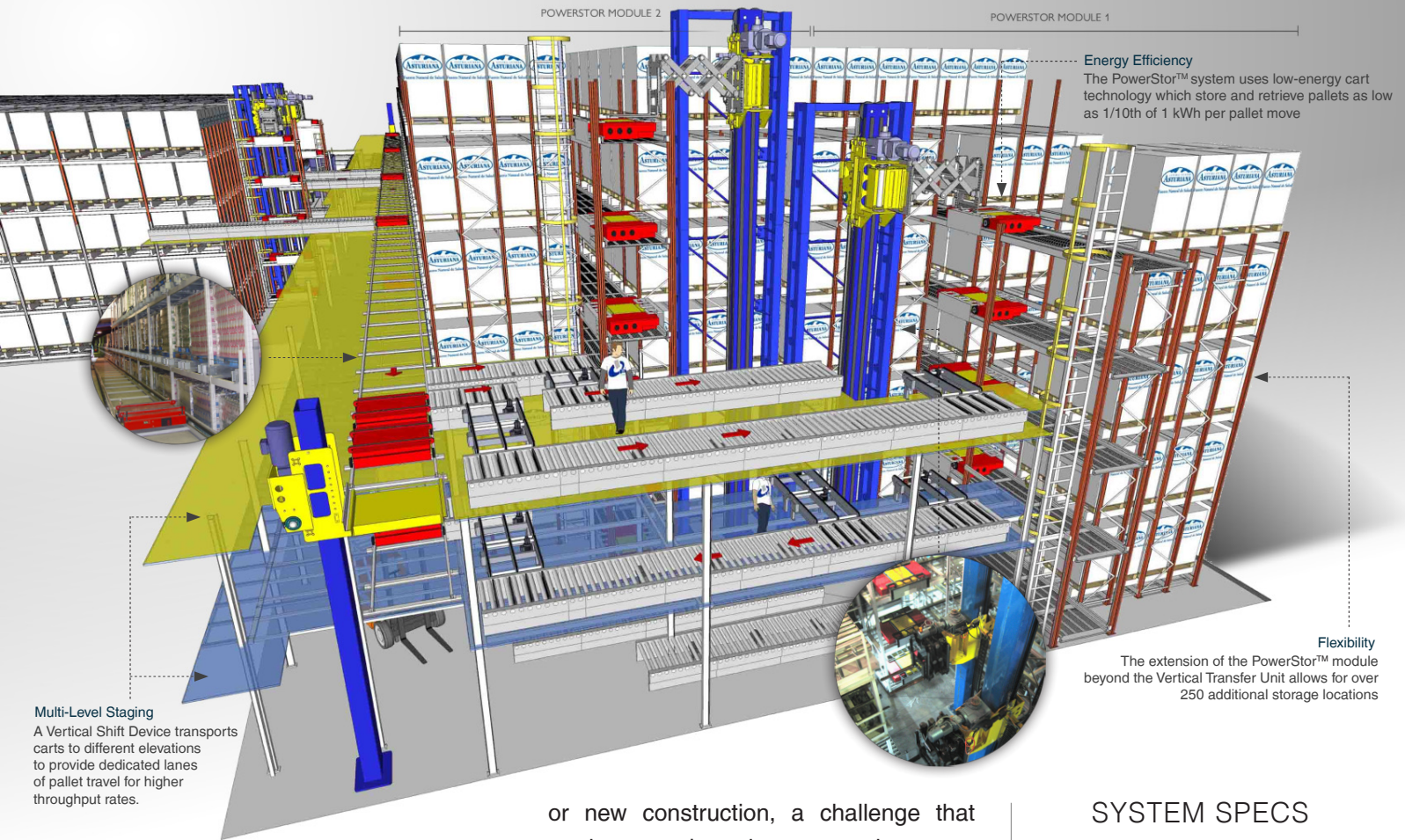
With the PowerStor™ and PowerStage™ systems now in place, pallet movement is completely automated, utilizing a combination of intelligent inventory tracking software, PASWare™, and robust handling equipment that manages pallets from production to truck loading.



Lugo, Spain
The Lugo facility is a key establishment for CAPSA, distributing a wide range of dairy products to Spain's heavily populated northwestern regions

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Multi-Level Staging
A Vertical Shift Device transports carts to different elevations to provide dedicated lanes of pallet travel for higher throughput rates.

Energy Efficiency
The PowerStor™ system uses low-energy cart technology which store and retrieve pallets as low as 1/10th of 1 kWh per pallet move

Flexibility
The extension of the PowerStor™ module beyond the Vertical Transfer Unit allows for over 250 additional storage locations

A TALE OF TWO OPERATIONS

Previously, the existing t-shaped warehouse had reached maximum capacity at 4,800 Euro-sized pallets. A team of 20 forklift operators were manually storing, retrieving, staging, and loading pallets onto trucks at three truck docks. With a recent increase in volume from their 8 production lines operating 24 hours per day, the manual storage operation at the Lugo facility was a logistical strain, ultimately forcing them to limit their production schedule.

Facing the increase of volume, high outside storage lease cost, and an outdated storage operation, CAPSA contacted PAS to completely modernize their facility. CAPSA knew the answer to their storage problem was automation, but the technology had to accommodate their 40 foot high existing facility without expansion

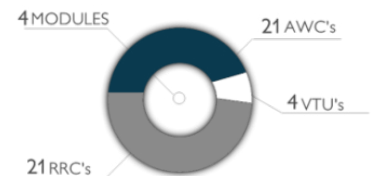
or new construction, a challenge that made crane-based automated storage unjustifiable.

PAS installed four PowerStor™ automated storage modules that increased their overall pallet capacity to over 9,000 locations. PAS also installed a multi-level automated pallet transportation system, the PowerStage™, to automatically receive pallets from production and deliver it to a storage module or to the automatic truck loading system.

The four PowerStor modules are designed to store over 360 pallets per day at energy efficient rates of less than .1 kWh per pallet move.

CAPSA also has 100% pallet tracking thanks to PASWare™ - the proprietary software that directs pallet movement, collects inventory information, and reports back to the operator for complete management and control.

SYSTEM SPECS



PERFORMANCE

Capacity	9000+ locations
Throughput	360 / hour
System Uptime	Over 98%
Energy	< .1 kWh /move

SAVINGS

Labor Cost	80% Reduction
Utility Cost	Over 50% Reduction
CO2	Over 50% Reduction

FUTURE

CAPSA has commissioned PAS to automate another existing facility in Vidreras, Spain. The project kicks off later this year.