

SPECIFICATION

Machine number : 0-261-97-3206
Customer number : 48479
YEAR OF PRODUCTION : 2013

G.00 PROFILINE KDF 440

SINGLE-SIDED EDGEBANDING MACHINE BRANDT
MODEL:HIGHFLEX 1440

Single-sided edgbanding machine for machining straight workpiece edges and for gluing and finishing various edging materials in longitudinal and transverse feed.

OVERVIEW OF EQUIPMENT OF THE UNIT:
CONNECTION UNIT 2 X 2.2 KW 200 HZ
STICKING UNIT A8
INCLINED/STRAIGHT MILLING UNIT 2 X 0.18 KW
PNEUMATIC ADJUSTMENT
MILLING UNIT INCLINED/STRAIGHT MILLING
UNIT 2 X 0.55 KW 0 DEGREES 2-POINT
PNEUMATIC ADJUSTMENT
MULTIFUNCTIONAL FORMING UNIT 2 X 0.4 KW PROFILE
SCRAPER WITH QUICK-CHANGE HEADS PNEUMATIC
ADJUSTMENT ADHESIVE JOINT SCRAPER
PURIFICATION UNIT

1. BASIC MACHINE:

- Continuous machine column, for clamping of machining units
- Fixed stop right side
- Grey lacquer RDS 240 80 05
- Motorised, adjustable infeed ruler
- Pneumatically operated inlet locking device
- Top pressure:
 - Single rollers in 2 rows, alternately
 - Motorised height adjustment
 - Display and entry of positions centrally by control
- Workpiece transport device:
 - Transport chain with rubber pad, 80 mm wide
 - Precise running and guiding surfaces
 - Standard equipment with automatic central lubrication of the conveyor chain
 - Workpiece support with roller rail, extendable by approx. 600 mm
- Noise abatement equipment with individual extraction for jointed parts and aggregates, as well as a chip container for the scraper.

- Feed rate | 8 - 14 m/min
- Max. feed rate with shaped cutter | 14 m/min
- Working height : 950 mm
- Pneumatic connection | min. 6 bar
- Overall length : 5,270 mm

Ground conditions must be in accordance with the site plan and mining plan, no: 5-701-80-1645

The technical data refers to the standard version.

The options lead to changes in the connection values for power, suction and air consumption.

2. WORKPIECE AND EDGE PARAMETERS:

- Workpiece width min:
- For workpiece thickness 8-22mm : 70mm*.
- For workpiece thicknesses 23-40mm : 120mm*.
- For element thicknesses 41-60mm : 150mm*.

*Depending on the length of the workpiece

- Workpiece protrusion \varnothing 38 mm
- Workpiece thickness
- Edge height max.= | 8 - 60 mm
- height of workpiece M
- Roll of edge material | 0.4 - 3 mm
- Edge cross-section max.
 - For PVC | 135 m²
 - For veneer | 100 mm²
 - Roll diameter max. | 830 mm
- Edge material slats | 0,4 - 8 mm
- Edge cross-section max.
 - For belts | 360 mm²

- If no radius is given, R=2 mm is drawn in and delivered

- The machine operator is responsible for using the correct materials (boards, adhesives, edge bands, cleaners, varnishes, etc.).

- When using the edging material with high-gloss surfaces, lacquered surfaces, matt surfaces and pressure-sensitive materials, we recommend using a suitable protective film on the edging material in combination with VKNR 0059 (accessory for sensitive surfaces).

3. UNIT EQUIPMENT

3.1 CONNECTION UNIT 2 X 2.2 KW 200 HZ

- For clamping in front of the gluing section, vertical spindle adjustment, horizontal electro-pneumatic control, 2 motors (1 x synchronous, 1 x counter-rotating), max. chip removal / stroke 3 mm
Cover with 120 mm diameter suction nozzle

- Including a set of grout cutters in DIA design with interchangeable cutting edges.
diameter 100 x 44 x diameter 30 mm, Z = 3

with double keyway 8 x 3 mm

max. workpiece thickness 42 mm

3.2 GLUE UNIT A8

Consisting of:

HEATING THE WORKPIECE

- Radiator for workpiece preparation for optimum bonding quality

QUICKMELT APPLICATION DEVICE

- Melting unit and quick-change, small-sized application unit Quickmelt
- The processing of PU adhesive granules with a standard Replaceable PU application unit (VKNR 2068) is possible according to the adhesive processing instructions.
- Tight glue supply under the glue roller
- Accurate metering of glue on the workpiece by means of a glue roller, no adjustment to workpiece thickness required
- Direction of glue roller rotation synchronous or opposite. Glue temperature control via electronic thermostat
- Automatic temperature reduction of the glue during breaks in operation

MAGAZINE

- Automatic edge storage for rollers and fixed lengths, with roller plate
- Equipped with reinforced pre-cutting shears
- Standard equipment with edge and workpiece distance control by means of a lock on the machine input

PRESSURE ZONE WITH MOTORISED CONTROL

- Pressure zone with driven, pneumatically actuated main pressure roller and 2 free-running pressure rollers
- Equipped with motorised, single-axis adjustment of the pressure zone to the edge thickness

3.3 CROSS-CUTTING UNIT CHAMFER/STRAIGHT 2 X 0.18 KW

- For trimming the convexity of the front and back edge material with a pull cut.

2 motors, each fitted with a cross-cutting disc. Swing range from straight to bevel 0-15 degrees

- 2 motors, 0.18 kW each, 200 Hz, 12,000 rpm.
- 2 TCT saw blades, size 100 x 32 x 2.6 mm, Z = 30
- Feed rate: 8 - 14 m/min.

3.4 PNEUMATIC ADJUSTMENT SLANT/STRAIGHT CUT

- for electropneumatic conversion of the cross-cutting unit from straight to mitre cuts

3.5 PRE-MILLING UNIT 2 X 0.55 KW 0 DEGREES

- For flush milling at top and bottom edges of material. 2 motors positioned one above the other, vertical tracking, manual lateral travel 30 mm.
- Height adjustment of the upper motor for with the help of the upper clamp
- Digital totalizers for quick adjustment
- Edge thickness max.8mm
- Workpiece thickness 8 - 60 mm
- 2 motors, 0.55 kW each, 200 Hz, 12,000 rpm.
- Standard equipment with 2 pcs. HM cutters diam.70x20x16 mm Z = 4

3.6 PNEUMATIC 2-POINT ADJUSTMENT

- vertical copy rollers to change from milling (with overhang) to flush milling

3.7 MULTIFUNCTIONAL MOULDING MACHINE 2 X 0.4 KW

For machining edge projections on the top and bottom edges of the workpiece and for copying corners on the front and back edges.

- Servo-controlled movement sequence with soft touch function
- 2 motors, each 0.4 kW, 200 Hz, 12000 1/min with HSK 25 toolholder
- Constant speed of motors milling machines for a perfect finish
- Compact milling head with integrated chip evacuation system
- Set of quick-change heads for manual profile changes

- Longitudinal milling or corner copying, freely selectable by the machine control system
- Servo motor adjustment for different edge thicknesses
- Feed rate 14 m/min
- Workpiece length min. 160 mm
- Workpiece thickness 12 - 60 mm
- Edge thickness max. 3 mm
- A separate replacement head is required for each profile (option VKNR 4838).
- Shape milling of veneer and solid edges is only possible to a limited extent (preliminary tests)

3.8 PROFILE SCRAPER WITH QUICK-CHANGE HEADS

- Scraping from the top, bottom and side. For chamfering or rounding pre-milled PVC edges.
- Max. Edge thickness 3 mm. Height adjustment of the top unit by means of top clamp.
- 2 quick-change heads for easy radius changes, with 2 WPL profile blades

3.9 SCRAPER WITH PNEUMATIC ADJUSTMENT

- For electropneumatic axial movement scraper assembly

3.10 GLUE JOINT SCRAPER

- For removal of glue residues in the glue joint area
- Scraping from above and below. Height adjustment with top clamp
- Equipped with 2 reversible knives WPL
- with suction

3.11 POLISHING UNIT 2 MOTORS

- To capture the edges at the top and bottom
- 2 motors, each 0.09 kW, individually suspended, tiltable and height-adjustable
- Height adjustment of the upper motor for with the help of the upper clamp
- 2 molleton discs, diameter 120 x 20 mm

4.0 ELECTRONIC CONTROL SYSTEM POWER CONTROL PC 20+
BRANDT control system with colour graphic
user interface for easy and convenient
operation and programming.

Technical data:

- Swivelling control panel on the machine infeed
- Durable short-stroke foil keyboard
- Colour graphics 12-inch flat screen
- Industrial PC with compact flash drive as storage device
- Device function keys with LED status indication
- Support for operator guidance via coloured pictograms
- Acquisition of commission-related production data, for the accurate determination of production data by direct assignment of commissions and orders. Data retrieval using the supplied Brandt Browser software via network (Ethernet) to an existing computer.
- Changing language online between different foreign languages
- Presentation of the target and actual state of the basic machine
- Status messages in plain text
- Easy selection and correction of waypoints
- Simple change of axle (with suitable aggregate design)
- Context-sensitive help function, detailed information on machine operation and functions directly on the control unit
- Inspection and maintenance interval indicator
- Storage of processing programmes
- Production according to machining programmes
- Data backup for processing programmes
- Fan for electronic controller. Module built into the control panel for ventilation of the electronic control unit
- The machine is equipped with the TeleServiceNet function for remote maintenance via the Internet. For TeleServiceNet (TSN), a suitable network connection is required.

Outside the guarantee period, the use of services remote service and maintenance is

ADRES

ul. Doktora Józefa Putka 9
34-123 Wadowice

NUMER TELEFONU

+48 512 750 000

E-MAIL

biuro@strefacnc.pl

NIP

6832065214

REGON

121433805

at our current rates for
remote services

5.0 ELECTRICAL EQUIPMENT

- Operating voltage 400 Volt - 3Ph - 50Hz
- Control cabinet installed in accordance with Euronorm EN 60204
- Electronic frequency converter with motor braking function
- Surge protection for machines with electronics
- Adaptation of operating voltage to national conditions via transformer (optional)
- Electrical equipment with modular control system for increased operator comfort
- Electronic internal stabilisation 24 V - control voltage
- Permissible ambient temperature min. +15 degrees/ max. +35 degrees Celsius, for electrical and mechanical efficiency of the machine.
- If the mains voltage fluctuates by more than +/- 10 %, a voltage stabiliser should be installed at the point of use.

6.0 SAFETY AND PROTECTION DEVICES

- EC conformity (CE) in accordance with the currently applicable Machinery Directive for single machine operation
- For interconnected machines (cells), an additional EC conformity assessment (on site) is required.
Execution by the user (client) itself.
- Wood dust tested TRK value max. 2mg/m³ according to the extraction capacity to be provided by the client in accordance with the installation plan.
- It is a condition of our guarantee/responsibility for the product that the original operating instructions accompanying the machine, including safety regulations, are fully complied with.

7.0 HOMAG GROUP QUALITY PACKAGE

- TÜV certified in accordance with DIN EN ISO 9001:2000
- The machine is supplied in accordance with Homag Group-.

Standard programme introduced and delivered

8.0 DOCUMENTATION

- Documentation as CD-Rom
- Operating and maintenance instructions additionally in printed form

G.0001 Number : 4876 1 x right
set R tools = 2 MM

G.0004 Number : 0052 1 x right
STANDARD PU rollers 1110 - 1400

- Instead of the standard ribbed rubber pressure rollers, smooth PU pressure rollers are fitted.
- Use for particularly sensitive detail surfaces

Can be applied to
The following machines Ambition /
Highflex 1110 - 1400

G.0007 Number : 2215 1 x right
SEPARATION MECHANISM

- Indication of the release agent at the top and bottom for easy removal of glue residue from the workpiece
- Manual override adjustment
- Without a separating agent, it must be supplied by the customer

Can only be used in the 1200 - 1800 series

N.01 Number 4845 x right
CHANGE OF VKNR 4062 BEDS TO VKNR 4150 BEDS
Replacement of the standard VKNR 4062 roughing cutter with the VKNR 4150 face milling cutter.

VKNR 4150
MILLING MACHINE 2 X 0.55 KW COUNTER-ROTATING

- For routing top and bottom edge material, vertically and horizontally

- . Height adjustment of the upper unit by means of a top clamp
- Functionality selectable from the control panel: 2 working positions: Flush milling and radius/bevel milling
- All control axes with digital counters for rapid adjustment
 - 2 motors, 0.55 kW each, 200 Hz, 12 000 rpm.
- Equipped with DFC combination cutters for chamfer, radius and plane milling. Edge thickness max. 12 mm

Edge thickness max. 8 mm (Ambition 1400) Edge thickness max. 12 mm (Ambition 1600- 1800)

N.0101 Number 4211 x right
PROGRAM - SIDE ROLLER ADJUSTMENT
 Includes motorised axis adjustment of the lateral gears of the milling units.
 Allows stepless adjustment of the side touch rollers to the edge thickness via machine control.

It can be used with the following machines: Ambition/Profiline 1600-1800 Highflex 1440

N.0107 Number 4901 x RIGHT
 MULTIPURPOSE FREQUENCY DETECTION
 - for use on components with sharp angles or components with one-sided holes for clamping.

- Can be used on Fein milling machines with VKNR 4120, 4128, 4150, 4155

This position is required twice for the entire unit (e.g. for components with sharp angles).

- N.04 Number 5767 x right-
hand quick-change kit for R - 1 MM
- Additional set of quick-change heads up and down for scrapers 5760, 5765 and 5766 complete with 2 WPL R - 1 mm profile blades.

 - Can be used on the following machines:
 - Ambition 1110, Ambition1110 F
 - Ambition 1200 - 1800
 - Highflex 1220 - 1800
 - Profiline KDN/F 1600 - 1800
-
- N.0401 Number 5798 x right
SPECIAL PURPOSE FOR THE PROFILE DRAWING KEY
- for use on components with sharp angles or components with one-sided holes for clamping.

 - Can be used for scraper with interchangeable heads
 - Price per top or bottom head treatment. This position is required twice for the entire unit (e.g. for components with sharp angles).
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- N.07 Number : 22201 x right
aggregate cleaner
- A device that sprays cleaning agents onto the top and bottom edges of workpieces.
 - For removing release agents and adhesive residues.
 - It is recommended to use in combination with a polishing device.
 - Without a cleaning agent, it must be provided by the customer
- Can be used in the 1200 - 1800 series