

SPECIFICATION

Date : 27.11.2023 / DW

Device number : 0-261-71-2123

P.00 EDGETEQ S-380 Profiline
(KDF 650)MODEL: 1650 HF

Single-sided edgeworking machine for machining straight edges of workpieces and for gluing and finishing various edge materials. In longitudinal and transverse pass.

1. BASIC MACHINE:

Continuous column machine for assembly of machining units

Painting of the machine and security fence posts in RAL 9003 Signal White Decorative slats, security fence panels, security door and pillar in RAL 7021 black-gray Noise protection equipment with individual extraction for connecting sections and units
Working height | 950 mm
Pneumatic connection | min. 6bar Overall length | 5760

Conditions on the floor must be in accordance with the plan floor and lift plan: 5701805424

Technical data refers to the standard version.

Options lead to changes in the connected loads of power supply, extraction and air consumption.

The machine operator is responsible for using the appropriate materials (boards, adhesives, edging, cleaners, varnishes, etc.).

When using the edging material with high-gloss surfaces, painted surfaces, matte surfaces and pressure-sensitive materials, we recommend using a suitable protective film on the edging material.

2. WORKPIECE AND EDGE PARAMETERS:

- Workpiece width min:
 - Workpiece thickness 8-22 mm | 70 mm*
 - Workpiece thickness 23-40 mm | 120 mm*
 - Workpiece thickness 41-60 mm | 150 mm*

- Workpiece protrusion | 38 mm
- Workpiece thickness ∇ 60 mm
- Maximum edge height = workpiece height | + 5 mm
- Roll of edge material0 .4 - 3 mm
 - Edge cross-section max.
 - For PVC | 135 mm²
 - For veneer | 100 mm²
 - Max. roll diameter 830 mm
- Strips of edge material0 .4-12.0 mm
 - Edge cross-section max.
 - For belt | 600 mm²

- Manual loading of workpieces
 - Hinge holes
 - Through holes
 - Cross grooves
 - Recesses and notches in the workpiece larger than the diameter or width of the groove 8 mm and are within the range of the upper pressure mount, must not be introduced into the machine for safety reasons.

3. ELECTRICAL EQUIPMENT

- Operating voltage 400 V - 3 Ph - 50 Hz
- Electronic frequency converter with motor brake function
- Surge protection for machines with electronics
- Country-specific adjustment of operating voltage with transformer (optional)
- Electrical equipment with modular control system for greater operator comfort
- If the mains voltage fluctuates more than +/- 10%, a voltage stabilizer should be installed at the point of use.
- Recommended ambient temperature:
+ 10 to + 40 °C

If the device deviates from the standard 400 V connection voltage, use an isolation transformer from the list of options for a particular device.

4. SAFETY AND SECURITY DEVICES

- EC conformity (CE) according to the current Machinery Directive for single machine operation
- Tested TRK value of wood dust max. 2 mg/m³, if the extraction capacity provided by the customer is in accordance with the installation plan.
- As a condition of our warranty/product liability, you must fully comply with the original instruction manual supplied with the machine, including safety regulations.

5. HOMAG GROUP QUALITY PACKAGE

- TÜV certified in accordance with DIN EN ISO 9001:2000
- The machine is commissioned and delivered according to Homag Group's standard program.

P.02001 Number : 06691 x right
LOOPTEQ O-300 DLA 1600/1800 interface -.
Electrical and mechanical preparation of
the edgebanding machine for mounting the
HOMAG AUTOMATION LOOPTEQ O-300 TO
workpiece feeder
Provide safety functions in accordance with
regulations

EQUIPMENT PACKAGES

P.03004 Number : 4876 1 x right
set tools R = 2 MM

P.03007 Number of 4166 x right
PAKET 1650 HF

It consists of:

Automatic height adjustment Automatic

inlet ruler adjustment Automatic

pressure zone adjustment

pneum. 2-point pneum adjustment pads. 2-
point vertical adjustment.

MF50 multifunctional rollforming milling
machine

Glue joint scraper

WORKPIECE HANDLING

P.04004 Number : 15051 x RIGHT
FREE-STANDING CUSHION TABLE
1275 mm x 650 mm with blower
including a roller element on the front

Only in combination with:

Extension of the inlet by 300 mm

P.04007 PROGRAM ADJUSTMENT FEED RULER
- Includes motorized single-axis adjustment of the adjustable inlet guide on machines with an articulated milling unit for chip removal.

Included in the kit is the PAKET 1650 HF.

EXTENSION OF THE INLET RULER BY 300 MM

P.04012 Number 0035 x right
Workpiece support
- Supporting the workpiece along the entire length of the chain conveyor on the operator's side
- Guide on the legs of the machine

STANDARD EXTENSION LENGTH

Working width:

400 series min 140 mm - max. 520mm600 /

800 series: min. 140mm - max. 550mm

The workpiece support is guided in 2 linear guides attached to the machine feet

P.04017 Number 0097 x right
support rollers for 1600/1800 roller parts
To guide narrow parts, support rollers are mounted at the top and bottom of the chain guide.

4 rollers each on the chain rail in the cross-cutting unit area. 3 rollers each on the chain guide and top pressure in the cutter unit area. 3 rollers each on the chain guide and top pressure in the scraper unit area.

P.04023 Number 0175 x right
SPEED 8 - 18 M/MIN.
- Variable feed rate 8 - 18 m/min

P.04026 Number 0937
xAUTOMATIC CENTRALIZED CHAIN
LUBRICATION
The conveyor chain is lubricated
automatically with an adjustable pulse
generator.

P.04034 Number 0933 x right
ELECTRONIC UPPER PRESSURE REGULATOR
- After data input by the control
system, the movement of the upper
pressure to the thickness of the
workpiece.

Included in the kit is the PAKET 1650 HF.

P.04043 Number : 2215 1 x right

SPRAY UNIT OF THE WORKPIECE

- Release agent indicator on top and
bottom for easy removal of glue
residue from the workpiece
- Manual adjustment of workpiece projection
change
- Without a release agent, it must
be provided by the customer

P.04046 Number 1512 x right
Milling AGREGT 2 X 2.2 KW 200 HZ
For mounting in front of the gluing section
Vertical height adjustment
Horizontal electropneumatic control
2 motors (1x concurrent, 1x counter-rotating)

Masking cover with suction nozzle diameter
120 mm Maximum shredding cross-section
depends on the material and feed rate.

Workpiece thickness for max chip
removal (MDF) at

- 11 m/min Feed speed
 - 8 - 60mm = approx. 3.0 mm
 - 18 m/min Feed speed
- 8 - 40 mm = approx. 3.0 mm
- 41 - 60 mm = approx. 2.4 mm
- 20 m/min
 - 8 - 22mm = approx. 3.0mm
 - 23 - 40 mm = approx. 2.6 mm
 - 41 - 60 mm = approx. 2.2 mm

P.04049 Number : 4792 1 x
40MM RIGHT-MOUNT FAN KIT
For use with 2 X 2.2KW 200 combination unit
2 WPL cutting heads for DIA bonding
Dia. 100 x 44 x dia. 30 mm, Z = 3 +
3 with double groove
keyed 8 x 3 mm max.
workpiece thickness 42 mm

P.04055 Number of 2135 x right
HEATING IR RADIATOR
- Radiator for workpiece preparation for
optimum bonding quality

P.04058 Number 2081 x right
EVA MELTING UNIT - KDX 1600/1800
- EVA melting unit
- Filling volume of about 4 l of hot melt adhesive granules
- Temperature control
- Melting capacity max. 8 kg/h in
depending on the adhesive
- Flushing function with key switch
- laterally movable

P.04061 Number : 42841 x RIGHT

MOUNTING MODULE QA65 N 1600-1800

- QA65 N application unit for manual or automatic hot melt adhesive filling
- Special coating of the application unit for all types of glue, including PUR glue
- with pneumatic device for quick exchange of application unit
- Precise adjustment of the amount applied glue with a nonius
- Glue application in synchronous or counter-rotating mode with pneumatic adjustment of dispensing sliders
- Glue roll with a diameter of 34 mm
- Heated glue roller
- 2 different levels of hot melt adhesive adjustable via control unit
- The order unit is filled manually or automatically
- Flexibility to use different hot melt adhesives such as EVA, PUR or polyolefins.

During the processing of PUR, isocyanates are formed, which lead to exceeding the MAK value.

Therefore, in any case, measures should be taken to remove the vapors, such as by appropriate extraction.

Follow the safety data sheets of the hot melt adhesive manufacturers!

PNEUMATIC ADJUSTMENT OF THE GLUE CONTAINER

The application unit can be pneumatically removed from The working area can be driven

GLUE CONTAINER HOLDING THE WORKPIECE ACTUATED

Pneumatic clamping of the glue container at a distance determined by the workpiece to avoid glue dripping on the back edge.

LEVEL CONTROL QA 65 N
2-fold glue level detection

Probe to detect 2 levels of glue in the
application unit

P.04068 Number : 15531 x RIGHT

MOUNTING MODULE QA 65 N (REPLACEABLE)
Additional QA65 N quick-change application
unit for manual filling with hot melt
adhesive as a replacement unit.

- QA65 N application unit for manual or
automatic hot melt adhesive filling
- Special coating of the application unit
for all types of glue, including PUR glue
- with pneumatic device for quick change
of application unit
- Precise adjustment of the amount applied
glue with a nonius
- Glue application in synchronous or counter-
rotating mode with pneumatic adjustment of
dispensing sliders
- Heated glue roller
- 2 different levels of hot melt adhesive
adjustable via control unit
- The order unit is filled manually or
automatically
- Flexibility to use different hot melt
adhesives such as EVA, PUR or
polyolefins.

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are formed, which lead to exceeding the MAK
value.

Therefore, in any case, measures should be
taken to remove the vapors, such as by
appropriate extraction.

Follow the safety data sheets of the
manufacturers of hot melt adhesives! After
processing PUR adhesives, clean the
container, especially the applicator
roller, to prevent glue buildup.

AUTOMATIC ADJUSTMENT OF EDGE THICKNESS
Includes single-axis adjustment of the
printing zone to edge thickness.

Included in the kit is the PAKET 1650 HF.

Material processing

P.04085 Number 4422 x right

CUTTING UNIT -CAP 2 X 0.35 KW

- Equipped with 2 motors of 0.35 kW each,
200 Hz, 12,000 rpm, each
Equipped with cross-cutting balls.
- Soft-touch function for
sensitive edges.
- File diameter 125x32x2.4mm, Z=24
- max. edge cross-section 600 mm²
- Edge thickness 0.4 - 15 mm
- Workpiece thickness 8 - 100 mm

PNEUMATIC DIAGONAL/STRAIGHT ADJUSTMENT CAPS
For electropneumatic switching of the cross-
cutting unit from bevel to straight.

PNEUMATIC 2-POINT ADJUSTMENT PADS
For flush mounting or with additional
material.

After the material is added, the protruding
edges are finished with a mold milling
machine.

Included in the
kit is the PAKET
1650 HF.

P.04093 Number 4461 x right

MULTIPLE MILLING AGENCY

- For milling the top and bottom
projection of edge material.
- Adjusting the height of the upper unit
with top clamping
- 3 working positions:

Item 1 - profile milling Item
2 - profile
milling profile
milling Position 3 - face
milling
Position 1 or position 2 is also used for
beveling thin edges.

MOTOR POWER 0,55 KW

- 2 motors with a power of 0.55 kW and a frequency of 200 Hz each,
12,000 rpm.
- Edge thickness max.12 mm FORWARD

MANUAL ADJUSTMENT OF THE DEVICE

- Manual adjustment of the
device for different edge
thicknesses.
- For profiling MDF or already
glued edges
- Manual adjustment with digital counter
- Individual adjustment at top and bottom

WORKING POSITIONS OF PNEUMATIC ADJUSTMENT

for changing the milling unit
from chamfering to radial or
straight.

PROGRAM - ADJUSTMENT OF SIDE ROLLERS

Includes motorized lateral axis adjustment
The gears of the milling units. Allows
infinite adjustment of the side pressure
rollers to the edge thickness via the
machine control system.

PNEUM. 2-POINT ADJUSTMENT OF VERTICAL TENSION ROLLERS

For single-plane milling or edge milling of
plastic with an allowance of material for
scraper machining.

Included in the
kit is the PAKET
1650 HF.

1 TOP AND BOTTOM ROLLER LOCKING DEVICE

Standard equipment with 1 roller latch for
upper and lower side

ADRES

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REGON

121433805

P.04131 Number of 2220 x right
WASHING AGGREGATE OF MACHINED MATERIAL
- A device that sprays cleaning agents
onto the top and bottom edges of
workpieces.
- For removing release agent and
adhesive residue.
- Without a cleaning agent, it must be
provided by the customer

P.04134 Number 5330 x right
BUFFER UNIT 2 MOTORS
- To grab the edges at the top and bottom.
- 2 motors of 0.18 kW each, individually
suspended, tilted and height-adjustable
- Height adjustment of the upper motor
with top pressure
- 2 molton discs with a diameter of 150 x 20 mm

P.09013 Number : 07821 x
proper DOCUMENTATION ON PAPER
(Folder, DIN A4 paper)
- User manuals consisting of operating and
maintenance instructions

Net price00 ,000.00 **EUR**

B.23 FCA DELIVERY
Free carrier, manufacturer's plant/packaging plant
/ storage location packed,
uninsured Incoterms 2010 ICC

If applicable:
Customs fees and/or import taxes shall be
borne by the buyer.

B.26 PAYMENT

B.29 MONTAGE

B. 32 DELIVERY TIME

B.38 GUARANTEE