

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 edgebanding 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 highgloss 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
 - diameter830 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 0-300 DLA 1600/1800 interface -.
Electrical and mechanical preparation of
the edgebanding machine for mounting the
HOMAG AUTOMATION LOOPTEQ 0-300 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.

- 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 $2.2 \,\mathrm{KW}$ 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 counterrotating 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 counterrotating 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.

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

It can be used in the following devices: EDGETEQ S-240 - S-390

LEVEL CONTROL PROBE For change order units

P.04072 Number 2658 STORAGE

Х

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

EDGE THICKNESS UP TO 15 MM

AUTOMATIC EDGE FEED

For quick replacement of various roll edges up to 3 mm thick. The edge material is driven by a motor from the roller plate to the working position.

No manual adjustment of the magazine is required if the edge height is adjusted to the corresponding thickness of the workpiece.

It can be used with the following devices: EDGETEQ S-380 - S-390

P.04077 Number 2719

x right

pressure zone with 3 pressure rollers

- Pressure zone with driven main pressure roller and 3 freely rotating pressure rollers
- Equipped with a digital counter for manual pressure zone regulation on edge thickness
- 1. PNEUMATICALLY OPERATED PRESSURE ROLLER In order to achieve greater pressure on the edging material for belt products, the first pressure roller is additionally equipped with a pneumatic actuator.

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 diameter125x32x2.4mm, 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 crosscutting 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:

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 $\,$

FLANGE CUTTER - RADIAL/STRAIGHT

- For switching the lower motor
 Milling from radius to straight.
 For another choice of profile between
 lower and upper milling motor.
- The lower scraper unit can be switched off via adjustment.
- P.04104 Number : 44541 x right multi-stage milling tool.....

DFC HM COMBI - 2 BEAM CUTTER In position 1, the rays /. A smaller radius can be defined.

1.0 mm 2.0 mm

P.04108 Number : 15301 x right

MULTIFUNCTIONAL MILLING UNIT 2 X 0.4 KW

- For machining edge projections on top and bottom edges of the workpiece $% \left(1\right) =\left(1\right) +\left(1\right) +$
 - and to copy the corners of the front and rear edges.
- Servo-controlled motion sequence with soft-touch function
 - 2 motors each 0.4 kW, 200 Hz, 12000 $1/\min$ with HSK 25 tool holder
- Constant speed of milling motors for a perfect finishDevice for quick manual profile change
- Longitudinal milling or copying corners, freely selectable via the machine control system
- Servomotor adjustment to different edge thicknesses
- Feed speed 14 m/min
- Workpiece length min. 160 mm
- Edge thickness max. 3 mm
 - Shape milling of veneer and solid edges is possible only to a limited extent (preliminary tests).

THICKNESS OF THE WORKPIECE UP TO 60 MM

AUTOMATIC PROFILE CHANGE Servo-motor adjustment of the shaping unit different edge profiles (radius/phase)

FLEXTRIM FOR MF50/MF60

- Functionality selectable from the control panel:
 2 working positions:
 Item 1 Mill Profile Item
 2 Profile of the mill
- Position 1 or position 2 are also used for beveling thin edges.
- equipped with 2-stage milling cutters for chamfering and radial milling
- The radius/bevel combination must be defined via VKNR 4926-4929 for items 1 + 2.

STRUCTURAL FLOORS

 For vertical corner treatment of structured or fitted shelves, where prior gluing of the transverse edge is not necessary.

- P.04115 Number 4452 x right tool kit forMF50/60
 - Equipped with diamond cutting knives and integrated suction technology
 - Compact milling head with integrated chip extraction system

R1/R2 FOR FLEXTRIM MF50/MF60

- P.04119 Number 4489 x right multistage pull clamp MZ40 AGGREGAT
 - For chamfering or rounding pre-milled plastic edges, vertical and horizontal probing
 - Adjusting the height of the upper unit with top clamping

- Functionality selectable from the control panel:
 2 working positions:
 Item 1 Drawn profile
 Item 2 Drawn profile
- It comes standard with motorized axis adjustment of side sensor rollers for edge thickness, and motorized axis adjustment of vertical sensor rollers for profile adjustment or protective film compensation.

Workpiece thickness:
with chamfer - min. 8 mm
with a radius of 3 mm - min. 12 mm
edge thickness max. 3 mm

PNEUM. ADJUSTMENT SCRAPER
For electropneumatic lateral movement of scrapers

UPPER + LOWER CASTERS
Standard equipment with sensor roll
for upper and lower side

P.04128 Number 5820 x right PROFILE CYCLINE

- For removing glue residues in the glue joint area
- Scanning from the top and bottom Adjusting the height with the top clamp
- Equipped with 2 reversible WPL knives
- including suction

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 \times 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