



Order confirmation

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G.00 OPTIMAT KDF 440 C

SINGLE-SIDED EDGE BANDING MACHINE BRANDT

MODEL: AMBITION 1440 FC

Single-sided edgebanding machine for machining straight edges of workpieces and for gluing and machining various edge materials with longitudinal and transverse feed.

<u>OVERVIEW</u>	<u>EQUIPMENT</u>	<u>EQUIPMENT:</u>
CONNECTING UNIT 2 X 2.2 KW 200HZ ADHESIVE UNIT A8		
CUTTING UNIT INCLINED/STRAIGHT 2 X 0.18 KW MILLING UNIT 2 X 0.55 KW COUNTER GEAR FORMING UNIT 2 X 0.35 KW		
PROFILE SCRAPER WD 60 WITH QUICK-CHANGE HEADS		
FREE-STANDING GLUE JOINT SCRAPER POLISHING UNIT		

ADRES

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REGON

121433805

1. BASIC MACHINE:

- Continuous machine stand for assembling processing units
- Fixed stop on the right side
- Grey paint finish RDS 240 80 05
- Manually adjustable infeed guide
- Pneumatically controlled inlet stop
- Highest pressure:
 - Single rollers in 2 rows, offset
 - Height adjustment with digital counter for manual adjustment of top pressure to the panel thickness
- Workpiece transport device:
 - Transport chain with rubber pad, 80 mm wide
 - Precision 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 protection equipment, with individual extraction for the parts and assemblies being joined, and Chip container for scraper

- Feed rate | 11 m/min
- Max. feed rate with moulding cutter | 11 m/min
- Maximum feed rate with cutter VKNR 4809 w combined with
with VKNR 0014 | 14 m/min
- Working height | 950 mm
- Pneumatic connection min . 6 bar
- Overall length | 5,273 mm

Floor conditions must be in accordance with the floor plan and suction plan, no: 5-701- 80-2261

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:
 - Workpiece thickness | 8-22 mm | 70 mm*

- For a workpiece thickness of 23-40 mm ; 120 mm*
- Workpiece thickness 41-60 mm ; 150 mm*
- *Depending on workpiece length

- Workpiece protrusion ; 38 mm
- Workpiece thickness \varnothing 8 - 60 mm
- Max. edge height = workpiece height ; + 6 mm
- Edge material roll0 .4 - 3 mm
 - Edge cross-section max.
 - For PVC; 135 mm²
 - For veneer ; 100 mm²
 - Roll diameter max. 830 mm
- Edge material strips0 .4 - 8 mm
 - Edge cross-section max.
 - For 360 mm² belts

- If no radius is provided, R=2 mm is reversed and delivered

- The machine operator is responsible for using the correct materials (panels, adhesives, edging, cleaners, paints, 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 (additional device for sensitive surfaces).

3. A G R E G A T I O N S

3.1 JOINT MILLING UNIT 2 X 2.2 KW200 HZ

- For bonding in front of the glued part, vertical Spindle adjustment, horizontal electro-pneumatic control, 2 motors (1 x synchronised, 1 x counter-rotating), max. chip removal / stroke 3 mm (maximum

chip cross-section depends on material and feed rate) Cover with suction nozzle with diameter 120 mm

- Including DIA joint milling kit

with exchangeable cutting edges.
Dia. 100 x 44 x dia. 30 mm, Z =
3 with double groove
keyed 8 x 3 mm. max.
thickness of workpiece
42 mm.

3.2 LIGHTING UNIT A 8

It consists of:

WORKPIECE HEATING

- Emitter for workpiece preparation for optimum bonding quality

STANDARD ORDER UNIT

- Quickly interchangeable application unit
- Processing of PU adhesive granulate with standard exchangeable PU application unit (VKNR 2068) possible according to adhesive processing instructions
- Tight glue supply under the glue roller
- Precisely adjustable glue application to the workpiece by means of a glue roller, without the need for adjustment to the workpiece thickness
- Glue roller rotation direction synchronised or opposite. Glue temperature monitoring via electronic thermostat
- Automatic temperature reduction of the glue during breaks in operation

MAGAZINE

- Automatic edge stocking for roll goods and fixed lengths, including roller discs
- 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

PRINT ZONE

- Pressure zone with driven, pneumatically pressurised main pressure roller and 2 freely rotating pressure rollers
- Equipped with a digital counter for manual pressure zone control to the edge thickness

3.3 SLANT/STRAIGHT CUTTING UNIT 2 X 0.18 KW

- For trimming front and rear overhangs edges with trailing edge
2 motors, each fitted with a crosscut saw blade. Pivoting range from
straight edge to bevelled edge 0-15 degrees
- 2 motors, 0.18 kW each, 200 Hz, 12,000 rpm.
- 2 HM saw blades, diameter 100 x 32 x 2.6 mm, Z = 30
- Feed rate: 11 m/min.

3.4 MILLING UNIT 2 X 0.55 KW COUNTER-ROTATING

- For top and bottom milling of edge material projection, vertical and horizontal tracking. Height adjustment of the upper unit with top pressure
- Functionality selectable from the control panel:
2 working positions: Flush milling and radial/angled milling
- All positioning axes with digital counters for rapid adjustment
- 2 motors, 0.55 kW each, 200 Hz, 12,000 rpm.
- Equipped with DFC combination cutters for chamfering, radius milling and in-plane milling.
Edge thickness max. 8 mm

3.5 FORMING UNIT 2 X 0.35 KW WD 60

- For forming the front and back edges of various profiles
 - Wooden edges possible to a limited extent, depending on edge material.
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- Restrictions for loose middle layers on post/soft moulded parts and very thin melamine/foil edges and surface materials. Includes pneumatic 2-point adjustment bevel/radius.
Delivery with 2 radial tools
2 motors, 0.35 kW each, 200 Hz, 12000 rpm.
- Edge thickness 3 mm Workpiece thickness max.60 mm Workpiece length min. 160 mm Feed speed. 11 m/min.

3.6 PROFILE SCRAPER WITH QUICK-CHANGE HEADS

- Top, bottom and side scanning. For chamfering or rounding pre-milled PVC edges
- Max. edge thickness 3 mm. Height adjustment of the upper unit by means of upper clamping pressure
- 2 quick-change heads for easy radius changes, with 2 WPL profile blades

3.7 POLISHING UNIT 2 MOTORS

- For easier gripping of the top and bottom edges
- 2 motors, 0.09 kW each, individually suspended, adjustable in inclination and height
- Height adjustment of the upper motor with top pressure
- 2 molleton discs, diameter 120 x 20 mm

4.0 ELECTRONIC CONTROL UNIT POWER CONTROL PC 20+

The BRANDT control system with its colour graphic user interface provides simple and convenient operation and programming.

Technical details:

- Rotary control panel on the machine infeed
- Robust short-stroke membrane keyboard
- 12-inch colour flat-screen graphic display
- Industrial computer with compact flash drive as mass storage device
- Function buttons of the power unit with status LED display
- Operator guidance supported by coloured pictograms
- Acquisition of production data related to the order, in order to accurately determine production data by direct assignment of the order and the order. Downloading data using the supplied Brandt Browser software via the network (Ethernet) to an existing PC.
- Switching the language online between different foreign languages
- Visualisation of key target and actual machine states
- Status messages in plain text
- Simple selection and correction of waypoints

- Simple axle adjustment option (with appropriate unit design)
- Context-sensitive help function, detailed information on operation and functions of the device directly on the control unit
- Display of inspection and maintenance intervals
- Saving editing programmes
- Production in accordance with processing 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. A suitable network connection is required for TeleServiceNet (TSN).
Outside the warranty period, remote service and maintenance services are provided at the applicable remote service rates

5.0 ELECTRICAL EQUIPMENT

- Operating voltage 400 V - 3Ph - 50Hz
- Control cabinet installed according to European standard EN 60204
- Electronic frequency converter with motor brake function
- Surge ~~protection~~ for machines with electronics
- Country-specific operating voltage adjustment via transformer (optional)
- Electrical equipment with modular control system for greater operator convenience
- Electronic internal stabilisation
24 V - Control voltage
- Permissible ambient temperature min. +15 degrees / max. +35 degrees Celsius, for electrical and mechanical functionality of the unit
- If the mains voltage fluctuates by more than +/- 10%, a voltage stabiliser must be installed at the point of use.

6.0 SAFETY AND PROTECTION DEVICES

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- Manual adjustment for convexity changes workpiece
- Without release agent, must be supplied by the customer

Only in combination with cutters!
Can only be used with 1200-1800 series

N.01 No. 4171 x right
PNEUMATIC KIT FOR CUTTING BRACKETS AND CUTTING PARTS

It consists of:

3175 - PNEUMATIC DIAGONAL/STRAIGHT ADJUSTMENT SOCKETS
For electropneumatic switching of the cross-cutting unit from diagonal to straight.

5762 - PNEUMATIC SCRAPER BLADE ADJUSTMENT
for the electropneumatic lateral movement of the scraper.

Can only be used in
conjunction with control unit
EC 10+

It can be used in the following appliances:
Ambition 1200 (only in combination with VKNR 5766)

N.05 Number : 48471 x right
exchange mill 4150 / shapemill 4803

Replacement of the standard milling unit
VKNR 4150 on 1-cut milling machines by the
pre-milling unit VKNR 4062 and the moulding
cutter
VKNR 4803 compared to the VKNR 4809 milling machine

VKNR 4062
PRE-MILLING UNIT 2 X 0.55 KW COUNTER-ROTATING

For trimming in the opposite direction to
the top and bottom overhang of the edge
material. 2 motors positioned one above the
other, vertically, can be moved manually by
30 mm laterally.

Height adjustment of the upper motor for
with the help of top pressure.

Digital counters for quick adjustment.
Edge thickness max. 15 mm Workpiece
thickness max. - 60 mm

2 WPL cutters with diameters 70 x 20 x 16 mm, d = 4

Edge thickness max. 8 mm (Ambition 1400)
Edge thickness max. 15 mm (Ambition 1600 - 1800)
(Highflex 1600 - 1800)

VKNR 4809

MULTIFUNCTIONAL SHAPING MACHINE 2 x 0.4 KW

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

- Servo-controlled movement sequence with soft-touch function
- 2 motors, 0.4 kW each, 200 Hz, 12000 rpm.
- Equipped with diamond cutting blades and integrated suction technology
- Constant speed of milling motors for perfect finish
- Compact milling head with integrated chip extraction system
- Quick-change head set for manual profile changes
- Longitudinal milling or corner copying, freely selectable via 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 interchangeable head is required for each profile (option VKNR 4838).
- Veneer and solid edge moulding is only possible to a limited extent (preliminary tests).

It can be used with the following equipment:

Ambition 1440 FC
Ambition 1650 C
Ambition 1650 FC
Ambition 1660 FGC

N.08 Number 5820 x right-
hand glue stripping blade
- For removal of glue residues in the
glue joint area

Special net price Polish Edition €00

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