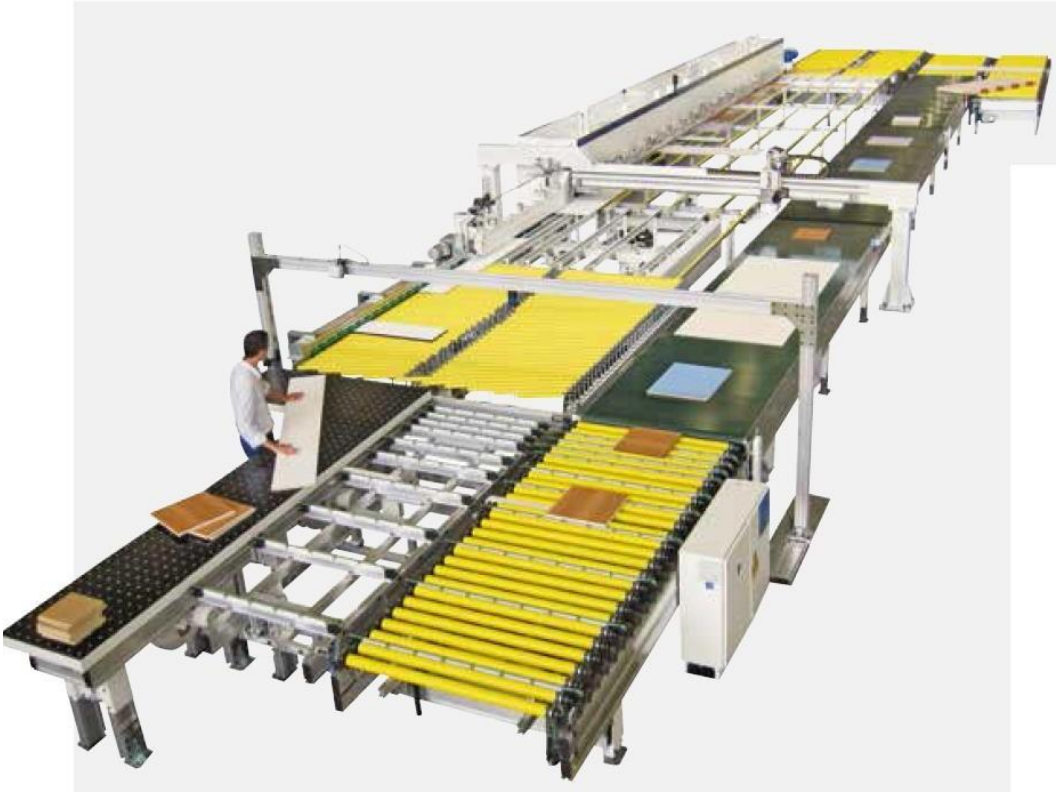
STEFANI CELL



Panel dimension:

Lenghtwise feeding (min/max)	250 /3000 mm
Crosswise feeding (min/max)	130/1200 mm
Panel Thickness (min/max)	10/60 mm

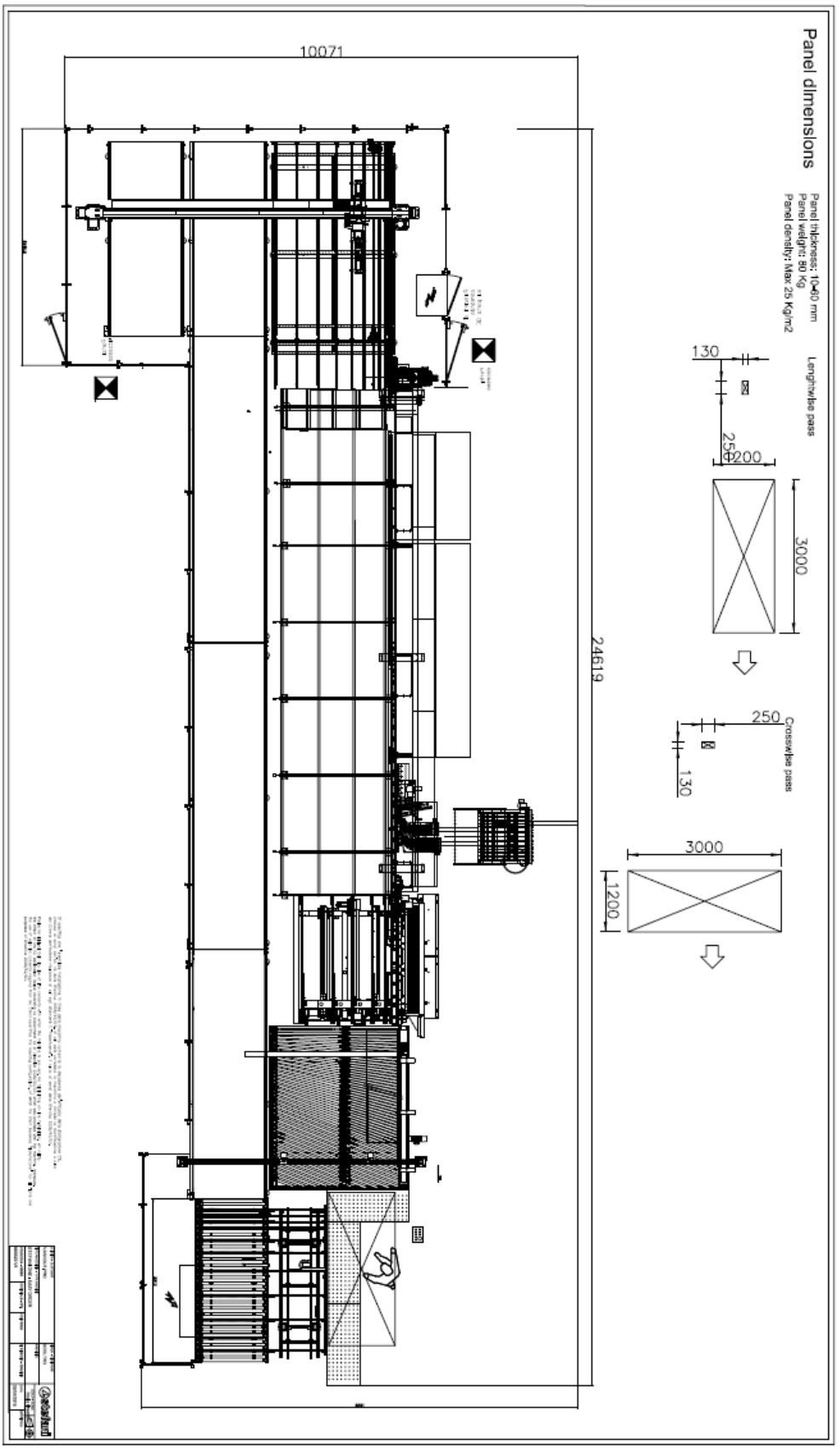
Type of edge:

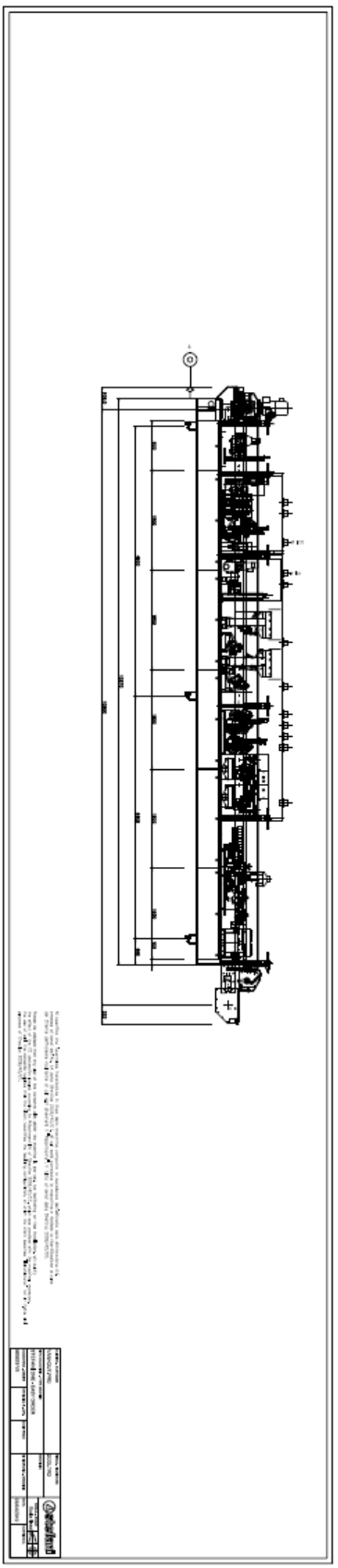
Egde in coils with bevel 20°	0,3 – 0,8 mm
Egde in coils with radious°	1 - 1,5 - 2 mm

Type of glue:

PUR	Pre melter Nordson ALTA PUR 4 HO+SGP Glue POT

General Layout





MAESTRO WATCH - SUPERVISOR

MAESTRO WATCH SUPERVISOR

Connecting all the command and control information into a production line in real time is extremely simple thanks to the new, powerful supervisor MAESTRO WATCH by SCM, perfect for controlling and managing the entire process from a single, convenient position .

A0.05.83 **MAESTRO WATCH G01: SOFTWARE FOR LINE CONSISTING OF SINGLE MACHINE WITH LOADING AND UNLOADING SYSTEMS OF THIRD-PARTY** **N. 1**

Control and supervision software "MAESTRO WATCH" that integrates into a single point of command / control all areas of the edgebanding / squaring-edgebanding cell for quick and easy management of various functions and sends the processing programs to all machines according to the production list.

It optimizes production changes and reduces times of set up and machine programming.

It allows to receive support and remote assistance.

"MAESTRO WATCH" is developed and implemented by SCM.

Features:

- **User-friendly operator interface**, with intuitive and immediate use, with real-time visualization of the production flow of the line production, the work zones and process / machine available data (ID panels, quantity of workpieces ..). The plant interface corresponds to the plant layout and allows to define and check its conditions of each zone.

- **The entire production cycle management** ensures the analysis to get maximum flexibility for both large batches that for small orders (custom analysis in function of the architecture of the cell and the equipment of each machine).

- **Programming management with Program Editor/ processing cycles** to be performed on the plant. The programs can be imported (manually or with optional Bar Code), created, edited, saved, deleted, renamed and moved. The data for the programs can be imported from SQL or XML database, even by the company management system; the Editor can also manage lists or mix of processing that is the sequences of programs to be generated in order to reuse and launch them running. The lists or mix can be queued or launched running entirely or partially, with a selection of the necessary processing. The lists or mix can be called up / queued / run running even through Bar Code option. The validation function is also available for the check of the feasibility of the configured program/list/mix in function of the plant parameters. There is no limit to the number of programs/list/mix the system can handle.

- **Diagnostics management** which allows the display of all messages / alarms / warning system of the plant with assignment of the priority / severity. For each alarm, an additional management window is configurable where information (images and text) can manually be added and saved as history for the operator.

- **Report management** that allows the viewing, exporting, printing of statistical data referring to messages, states, productivity, and performed production (for each product with date-time start-end and relative amounts). The information are filterable per time set by the operator. The reports are available for each machine or the whole plant.

- **Shift management**for setting of the shifts of plant utilization, breaks, time slots in the 24 hours and weekly. The shift change operation can be done automatically or by user request.

A7.80.43 MAESTRO WATCH O01: SOFTWARE FOR BAR CODE READER N. 1

Optional (or additional function) that allows the use of a Bar Code Reader connected to MAESTRO WATCH. It enters the programs read by the bar code reader in the execution list or in the list management according to the insertion sequence, before sending to the execution.

There is also a "Strip" mode. The reading of the code opens a corresponding file arranged by the customer in a pre-defined disk location. From this file a list of program codes are drawn and queued to the execution list .

A0.04.60 FREESTANDING CONSOLLE FOR THE LINE SUPERVISOR N. 1

It allows to use the line supervisor from a comfortable position that can be chosen according to the length of cable provided, instead of the standard position of the machine.

It includes:

- vertical structure movable thanks to pivoting wheels and manual brake for the positioning of the consolle;
- keyboard and mouse shelf (included);
- main command buttons;
- Panel PC with screen and integrated PC;
- 8 m long cable for connecting the consolle to the machine (longer cable must be managed separately).

Main features:

It is equipped with an industrial PC with "fanless" construction and IP53 grade protection (IP65 on the front side). This robust solution grants the highest durability even in the worst environmental conditions which an industrial site may present.
The 21,5" LCD color display through a 16/9 sized touch screen grants an unbeatable easiness and efficiency in controlling the main functions of the machine, also through:

* Full HD display resolution 1920x1080
* LED background lighting
* Capacitive multi-touch screen – 10 points of contact
* Wide visual angle 176° Horizontal / 160° Vertical

- "Zero Pixel Defect" quality
- Intel Core I7-6700T CPU 2,8 GHz
- Ram: **8GB, DDR4**
- Hard disk: 500GB – 7200rpm
- O.S. Windows Embedded Standard 7 – 64bit
- QWERTY keyboard with English layout
- Wired mouse – 3 functions
- Ethernet port RJ45
- USB port 3.0 protocol supported.
- Nominal operating temperature: +5°C / +35°C

Remote diagnostics web / based allows connection via Internet of the machine supervisor PC to SCM Group Service.

<u>Software equipment:</u>

TEAMVIEWER®

Software for remote diagnostic control of the machine via internet. It allows:

- view of operator interface
- signal diagnostic.
- on-line checking and editing of the configuration, parameter and program status of the machine.
- data backup and file transfer
- upgrade of the machine logic and operator interface

The Buyer shall prepare Internet access on the PC machine.

SINGLE-SIDED EDGEBANDER

R1.08.50 STEFANI ONE N. 1

Single-sided edge bander with fixed working side on the left for lengthwise and crosswise panel processing.

Designed to edge-band straight and soft-formed panels with coil and strip materials depending on machine configuration.

The large steel basement with high degree stiffness represents an optimum support for the working units and ensure no vibrations.

The **feed track** consists of 70 mm wide, self-lubrication nylon sliders, coated with wearproof vulcanized rubber with a high coefficient of friction to ensure the maximum panel holding and precision of working.

The conveyor track consists of one flat guide and one round guide made of ground steel to ensure the straightness of movement and the holding on lateral loadings. **Lubrication is automatic.**

The industrial chain is made of sintered steel links and special reinforced bearings.

The track pinion has 9 teeth with a tempered and ground profile.

The **top pressure beam** is made of thick steel with double trapezoidal profile belt and is complete with **automatic positioning** according to the panel thickness by **NC**.

Manual in-feed panels system with widely dimensioned guide and oversized bearing surface to make easy the inserting operations even of panels of big dimensions.

The **fixed side panel support 1100** consists of a flat surface with idle wheels; it is suitable also for the processing of big dimensions and weight panels.

The **sound proof cabin** is coated with noise-reducing material and it is **illuminated inside with LED lamps**. The cabin is closed and connected to the suction plant in accordance with the required specifications.

Top suction system with suitable inlets for each unit.

The standard supply voltage is **400 V EU (+/- 10%) 50 Hz (+/- 1%) (with neutral)**.
In the case of different voltages, the adaptation to the voltage of the destination country must be provided by means of an optional transformer or a transformer supplied by the customer.

Conditions for the correct operation of the machine:
- Humidity: max 90%
- Temperature when the machine is in operation: min 10 ° C / 35 ° C max

The machine is in conformity with the following directives:
- Directive **2006/42/EC** ("Machine")
- Directive **2014/30/UE** ("electromagnetic compatibility")

A machine completes with set-up for I/O line consents in order to ensure interfacing with any upstream and/or downstream machines.
The use of the aforementioned consents in the context of line installation annuls the effectiveness of the EC declaration, issued under Attachment IIA of Directive 2006/42/EC, provided with the machine, and requires recertification at the Client's expense and responsibility of the resulting set of equipment of which he will become "manufacturer" under the provisions of Directive 2006/42/EC.
When inserted in a line, the machine must not be commissioned until the line it is inserted into is declared conformant with Directive 2006/42/EC.

Each unit has its own inverter. Instruction booklet

attached.

Standard paint finish: Grey RAL 9002.

TECHNICAL DATA

Variable track feed speed	m/min 10-40

The working speed depends on the combination of the working units.
For soft forming processing the feed speed can vary according to the type of profile and the edge.

<u>Overhang panel from the track: fixed.</u>

Standard straight processing	mm 35
with YA	mm 75
soft forming processing	mm 55

Panel dimensions:

Panel thickness (depending on the applied edge)	mm 8-60
with 2M 100, R, RSU, RCS	mm 10-60
Minimum panel width: Standard	
straight processing	mm 95
with YA	mm 135
Soft forming processing	mm 115
Maximum panel width	mm 1200

Minimum panel dimensions with manual infeed: Lengthwise:

width x length	mm 95x220
Crosswise: width x length	mm 220x135

Minimum panel dimensions with automatic infeed (code W07157): Lengthwise:

width x length	mm 95x320
Crosswise: width x length	mm 320x320

Data refer to the panel before the edge application.

Attention! for the processing line consisting of machines and transport machines, the data of the minimum and maximum dimensions of the panel to work in the line have to be considered greater than the data of each stand alone machine/automation in the processing line.

Variable working height: mm 960 (+/-10 mm)

The performance in the quotation may vary depending on the types of processing, especially it can change according to the speed, to the processed materials and removed material.

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R1.08.58 STEFANI ONE-108 **N. 1**

Machine total length: mm 11550

OF.02.81 "MAESTRO PRO EDGE" CONTROL SYSTEM N. 1

PC control unit for fast and easy handling of the main machine functions.

Main features:

- Creation of "**Just in Time**" programs.
- Possibility of management by means of a production list.
- Possibility of management by means of a Bar Code Reader (option).
- **Flexible program change**: the selection of the new working program does not require the "free of panels" machine. The machine optimises the distance between panels automatically selecting the necessary space to carry out the set up.
- Working units ON/OFF control.
- Clear and guided diagnostic information for fast resolution of any problems.
- Working statistical data: number of worked pieces and meters, employed hours used.
- Management for automatic and immediate selection of the edge coil (when the multi-coil magazine is present).
- Rapid **selection** of all main functions from the main page.
- Unit of measurement in mm.
- Operator interface in the following languages: Italian, French, English, Spanish, German (Portuguese and Russian are optional);
- **Unlimited number of working programs.**
- Programming of turning on the glue pot, for the timed switch-on of the pre-heating unit inside the glue tank.

OF.02.82 SWINGING CONSOLLE WITH INTEGRATED PC "eye - M" N. 1

The swinging control panel is placed at panel infeed zone. It is adjustable for an easy and ergonomic use from the operator's working position.

It allows the usage of the supplied software's.
The integrated LED light bar allows the operator to check in real time the state of the machine (emergency, operative, etc.) without the need to be on the console itself.
It is equipped with an industrial PC with "fan less" construction and IP53 grade protection (IP65 on the front side). This robust solution grants the highest durability even in the worst environmental conditions which an industrial site may present. The 21,5" LCD color display through a 16/9 sized touch screen grants an unbeatable easiness and efficiency in controlling the main functions of the machine, also through:

* Full HD display resolution 1920x1080
* LED background lighting
* Capacitive multi-touch screen – 10 points of contact
* Wide visual angle 176° Horizontal / 160° Vertical
* "Zero Pixel Defect" quality

And furthermore:

- Intel Pentium – 2,9 Ghz
- RAM 4GB – DDR4
- Hard disk: 500GB – 7200rpm
- O.S. Windows Embedded Standard 7 – 64bit
- QWERTY keyboard with English layout
- Wired mouse – 3 functions
- Ethernet port RJ45
- USB port 3.0 protocol supported.
- Nominal operating temperature: +5°C / +35°C

Remote diagnostics web / based allows connection via Internet of the machine supervisor PC to SCM Group Service.

Software equipment:

TEAMVIEWER®

Software for remote diagnostic control of the machine via internet. It allows:

- view of operator interface
- signal diagnostic.
- on-line checking and editing of the configuration, parameter and program status of the machine.
- data backup and file transfer
- upgrade of the machine logic and operator interface

A9.90.00	**EUROPEAN SAFETY REGULATIONS (EC NORMS)**	**N. 1**
93.07.31	**Volt 400 EU**	**N. 1**
93.12.01	**Frequency 50 Hz**	**N. 1**
B0.91.00	**400V/50HZ POWER SUPPLY WITH NEUTRAL**	**N. 1**
A1.70.08	**FREESTANDING CONSOLLE WITH INTEGRATED PC INSTEAD OF STANDARD**	**N. 1**

It allows the use of software for the operation of the machine from a convenient movable position that can be chosen according to the length of the cable supplied.

In place of the standard swinging console.

It includes in addition to the standard:

- vertical structure movable thanks to pivoting wheels and manual brake for the positioning of the console.
- keyboard and mouse shelf (included);
- main command buttons.
- Panel PC with screen and integrated PC.
- 8 m long cable for connecting the console to the machine (longer cable must be managed separately).

Main features:

It is equipped with an industrial PC with "fan less" construction and IP53 grade protection (IP65 on

the front side). This robust solution grants the highest durability even in the worst environmental conditions which an industrial site may present.
The 21,5" LCD color display through a 16/9 sized touch screen grants an unbeatable easiness and efficiency in controlling the main functions of the machine, also through:

* Full HD display resolution 1920x1080
* LED background lighting
* Capacitive multi-touch screen – 10 points of contact
* Wide visual angle 176° Horizontal / 160° Vertical
* "Zero Pixel Defect" quality and

furthermore:

- Processor: Intel Pentium 2,9 GHz
- Ram: 4GB, DDR4
- Hard disk: 500GB – 7200rpm
- O.S. Windows Embedded Standard 7 – 64bit
- QWERTY keyboard with English layout
- Wired mouse – 3 functions
- Ethernet port RJ45
- USB port 3.0 protocol supported.
- Nominal operating temperature: +5°C / +35°C

Remote diagnostics web / based allows connection via Internet of the machine supervisor PC to SCM Group Service.

<u>Software equipment:</u>

TEAMVIEWER®

Software for remote diagnostic control of the machine via internet. It allows:

- view of operator interface
- signal diagnostic.
- on-line checking and editing of the configuration, parameter and program status of the machine.
- data backup and file transfer
- upgrade of the machine logic and operator interface

W0.14.01 **SINGLE-SIDED EDGE BANDER EXECUTION WITH WORKING UNITS FITTED ON RIGHT SIDE** **N. 1**

The machine is executed with the working units machining the right side of the panel (considering the feed direction of the machine) instead of the left side.

W0.14.55 **CABIN AIR RE-CIRCULATION FOR SHOULDER** **N. 1**

Cabin locking system for internal air re-circulation with suction setting from external to working environment.

A3.55.13 **KIT "SAV€NERGY PACK PLUS"** **N. 1**

Equipment for energy saving.

Extraction system with automatic outlets
Optimized exhaust system: only the exhaust outlets of the operating units in operation are opened by means of **opening/closure automatic system**

"ECO" pushbutton
The machine in stand-by is manually controlled pressing the "ECO" pushbutton from control panel.

Automatic stand-by
Machine in stand-by in case of temporary non-usage
Compressed air optimization system
It automatically disconnects the pneumatic air supply when the machine is switched-off.
Optimized management of the glue pot
Activation of the glue pot pre-heating in stand-by mode

A9.54.77 OUT-FEED TRANSFER N. 1

A3.32.33 "AAP" CLEAN PACK FOR PROTECTED EDGES - ONE SHOULDER N. 1

Suitable to protect delicate edges or without protective film with the risk of detachment, in contact with feelers and/or tools of the same film.

Complete with a spraying gun, and tank for the anti-adhesive liquid RIEPE NFLY.

B8.10.52 GUN-SHAPED BAR CODE READER N. 1

The bar code reader reads the program to be run and the panel thickness value.

B2.52.85 CONTINUITY UNIT FOR SINGLE-SIDED EDGEBANDER N. 1

In case of voltage lack, this unit feeds the control unit for some minutes. The unit also works as stream stabilizer.

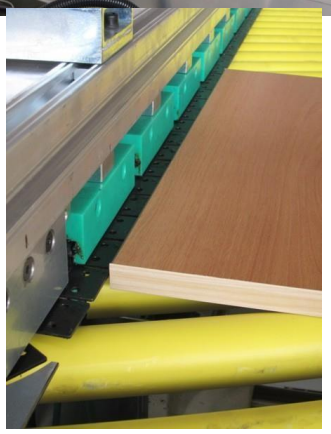
A1.70.40 **MOTORIZED ROLLER CONVEYOR FOR THE "EASY ORDER BN+ / EASY ORDER AC" INFEED DEVICE** **N. 1**

Roller conveyor for manual feeding of edge banders equipped with the automatic infeed devices Easy Order BN + / Easy Order AC.

The roller conveyor can be loaded manually, and, thanks to the tilted rollers, the panels are driven towards the left reference guide for a correct working position.

- dimensions:
  length of the roller conveyor: 3200 mm, useful width of rollers: 2500 mm.
- tilted rollers, 46 mm diameter, PVC coated, for the self-aligning of the panel on the reference guide;

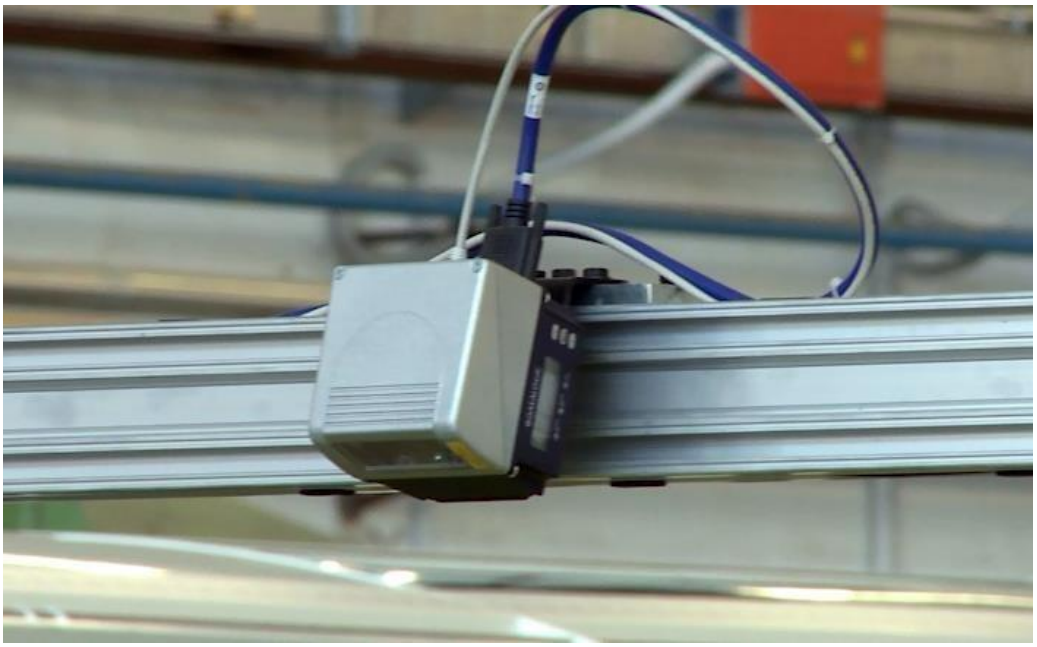
- NC mobile reference guide, for the adjustment to the working line of the infeed device.



- Guide for the correct positioning of the panel consisting of a motorized chain and a thin foil for the processing of overhanging veneer.

TECHNICAL DATA:
Length: min-max 250 – 3200 mm
Width: min-max 130 – 1200 mm
Thickness: min-max. 8 – 60 mm Max panel weight: 80 Kg.
Panel overhang: Right Working height: adjustable
Voltage supply: like the edge bander

SPEC02 **Mantis 23429** **N. 1**
Number 2 additional fixed Bar Code Reader (Tot. 4 BCR)

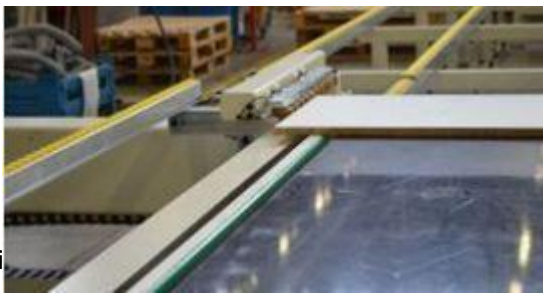


A1.70.13 **"EASY ORDER BN+" AUTOMATIC IN-FEED DEVICE BY BELTS FOR LENGTHWISE AND CROSSWISSE PASS – PANELS FORMERLY SQUARED** **N. 1**

Automatic device for lengthwise and crosswise feeding of the panel inside the edgebander without any manual intervention. It consists of a mobile carriage, retractable dog pushers and panel centering devices.

In the lengthwise feeding the device works as a simple transfer. In the crosswise feeding it facilitates the panel insertion with correct orthogonality inside the edge banding machine.

The panel is moved by special belts and before being introduced under the pressure beam of the edge bander is placed in the correct working position by lateral centering devices, **with Brushless movement.** These centering devices are divided into 4 zones to ensure an optimal productivity even with different panel dimensions.

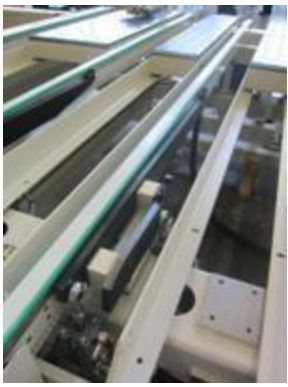


For the processing of crosswise sides, a mobile carriage and appropriate dogs intervene and ensure the orthogonality of panel i compared to the edge banding machine.
The dog intervention is optimized to ensure the correct insertion of panels with different dimensions.

A lateral pusher, consisting of a solid base and a right reference guide movable by NC by means of Brushless motorization, guarantees a perfect and unchanged position of the panel at the entry of the pressure device.

A frontal pusher system allows a perfect adhesion of the panel to the driving dogs up to the grip with the pressure device.

An additional upper pressure area, consisting of several independent segments of idle wheels, ensures perfect adhesion of the panel to the transport belts.



A double-dog system always ensures minimum gap according to the panel size in adaptive mode.

Data and technical features:

- Self-adaptive movement of carriage and dogs by means of Brushless motor. The stroke of the carriage is self-regulating depending on the panel dimensions.
- Adjustment of the working position of the centering devices managed by supervisor by means of Brushless positioning devices. Pneumatic intervention.
- Panel thickness adjustment managed by supervisor.
- Automatic selection of the dogs (pushers) according to the panel size.
- Number of cycles / min: from 10 to 14 depending on the type of passage and the size of the panel. This value is related to the mode of work of the right guide for sizing if present. The minimum number of cycles occurs in case of processing of panels with different dimensions and with the maximum stroke of the reference guide at each cycle. Conversely, the maximum number of cycles occurs when the right reference guide has not to make any movement in different cycles.
- Panel dimensions: (not considering other limits given by the working units of the machine composition):
  Lengthwise processing:
  length x width: 250x130 mm min; 3000x1400 mm max (with working line at 30 mm)
  Crosswise processing:
  length x width: 130x250 mm min; 1400x3000 mm max (with working line at 30 mm)
- Max. panel weight: 60 Kg.

A3.56.96 FIXED LATERAL PANEL SUPPORT 2600 (108-153) N. 1

In replacement of the fixed lateral support 1100. Max. panel width: mm 3200.

D5.01.64 "AAR" SPRAY ANTI-ADHESION UNIT - FIXED WORKING LINE, R.H. N. 1

To avoid deposits of glue on the top and bottom surface of the panel.

It is completed with 2 spray-guns fed by two anti-adhesive liquid containers.

D3.32.60 "RT-H" PREMILLING UNIT, 4 KW, R.H.

It trims the panel obtaining a perfect uniform surface for the glue application and a perfect junction line with the edge.

It includes:

- **two high frequency motors with automatic time intervention** to avoid chipping on the panel
- precise motor movements on **linear** ball recirculating **guides**
- possibility of machining **with copying/without copying** by HMI automatic change
- possibility of exclusion of the first feeler
- exhaust hoods for chip suction.
- timed air blower for the cleaning of the machined panel surface
- panel edge trimming with a variable removal, adjusting the infeed fence position by means of knob and numerical readout.
- height adjustment of the motors to vary the cutter working point.

Technical Data:
Including no. 2 "ED-SYSTEM" diamond tools D=100 H=49 Z=3+3 Max removable section mm² 90
Max removable thickness mm 3
Max variable track feed speed m /min 10-30 Motor power kW 4
Tool rotating speed rpm 9000

A3.32.62 ELECTRONIC POSITIONING FOR 1ST COPYING DEVICE INSTEAD OF THE MANUAL ONE FOR "RT-H" N. 1

It allows to adjust by NC the position of the first feeler by means of a positioner.

A7.14.20 NR.2 DIAMOND TOOLS "ED-SYSTEM" D=100 H=64 (Z=3+3) INSTEAD OF H=49 N. 1

Panel thickness: 10 – 60 mm

ID 22960: **New premilling unit "RT-X" at the entry** **N. 1**

For the panel premilling with sizing and squaring processing.

It obtains an optimal surface for the application of the glue for a perfect junction line with the edge.

It includes:

-
- **two high frequency motors with automatic time intervention** to avoid chipping on the panel.
- precise motor movements on **linear** ball recirculating **guides**
- possibility of machining **with copying/without copying** by HMI automatic change
- possibility of exclusion of the first feeler
- exhaust hoods for chip suction.
- timed air blower for the cleaning of the machined panel surface
- panel edge trimming with a variable removal, adjusting the infeed fence position by means of knob and numerical readout.
- height adjustment of the motors to vary the cutter working point.
- NC positioning of the feeler on the first motor by HMI

Technical data:

Including no. 2 "ED-SYSTEM" diamond tools D=125 H=64 Z=3+3 with HYDRO connection

Max removable section 160 mm²

Max variable track feed speed_ 10 -30 m /min Motor power:
4 kW

Tool rotating speed: 9000 rpm

A1.70.87 "HM 3002 PU" GLUING UNIT FOR STRAIGHT PROCESSING N. 1

For the gluing on straight profiles of edges in coils and strips with polyurethane glue spread on the panel.

It includes:

Movement of the glue spreading roller, the first pressure roller and the feeding roller syncronized with the speed of the feed track by inverter.

"SGP" glue pot:

It allows a quick changeover of the glue type/color. The glue pot is fed by the pre-melting device for PUR glue (device not included).

Features:

- specific compact design reduces to a minimum the melted glue before the application to maintain the best quality characteristics.
- anti-adherent treatment for EVA or PU glue *(the PU glue can only be used with specific dedicated options not included);*
- spreading roller with optimized graining and PLASMA ant adherent treatment.
- manual emptying cycle with collection of the residual glue on a removable tank.
- automatic locking of glue loss with the machine stopped (SCM GROUP patent).
- manual dosing adjustment graduated indicator.
- glue roller reverse rotation.
- quick release device for the removal and easy replacement of the glue pot.
- simple and quick access for the internal cleaning with the possibility to all parts.
- short time of heating the glue during the starting of the machine thanks to its small dimensions.
- double thermo-regulation system for an easy use of two types of glue with different melting.
- "I Glue" device which includes:
  * automatic locking of glue pot copying operation in the last panel sections; it avoids a glue excess quantity on the panel rear side.
  * automatic glue pot exclusion.

Premelting device:

Not included.

Edge loading:

- sash-shear device for coiled edges.
- automatic edge loading system for material in coils and strips which allows to change the type of the applied edge in a short time.
- **3 interchangeable feed rollers:** needle roller for solid wood and knurled roller for thin and plastic edges, rubber roller for delicate edges.
- edge detecting sensor for the check of the correct presence and position of the edge (sensor not available when the machine is equipped with Air Fusion+ device or its prearrangement);
- precision edge feeding and rear cut consisting of:
  * dragging roller driven by motor which gives the necessary acceleration to bring the edge to the correct working position.
  * special software support for the shear.
- pushing device to lock the edge in the correct position in the feed track.

Edge pressure rollers:
Pressure area with independent pneumatic pressure adjustment consisting of:

- first driven roller of large diameter (150 mm). It is clutched and coated with Teflon;
- **6 idle rollers**, with timed intervention, 100 mm diameter; the first and the second with opposite conicity
- mechanical position indicator.

Coil-holder magazine:
Not included (compulsory choice)

Technical data:
Maximum feed speed: 40 m/min
Maximum feed speed with solid wood: 12 m/min Thickness of edge in coil (plastic material): 0,3-3 mm Thickness of edge in coil (wooden material): 0,3-2* mm Thickness of ready-cut veneer strips (opt.): 0,3-1 mm Maximum thickness of solid wood edge: **mm 12**
Note: in case of panel shorter than 1000 mm and solid wood thicker than 15 mm, the counter shoulder is compulsory.

Panel thickness: 8 – 60 mm
Edge height: min/max 14 - 65 mm
Edge height (with 6 or 12 roller magazine): min/max 16-65 mm Minimum edge length (coiled, strips, solid wood): 230 mm Maximum section of edge in coil (plastic material): 135 mm² (mm 3x45)
Maximum section of edge in coil (wood material): 95 mm² (2x45) Excess of edge compared to the panel thickness: 2+2 mm.
Capacity strip package in the presence of 1 or 2 coil magazine: 200 mm
Capacity strip package in the presence of 6 coil magazine: 200 mm

SGP glue pot:
Power of glue pot resistances: 2,05 kW Heating time from environment T°: <10 min Heating time from pre-heating T°:<5min Installed power: 2,5 kW.
Glue pot capacity: 0,5 Kg.

** Note: in case of wooden edges in coil, the horizontal 1-coil magazine is compulsory. The use of wooden coiled material specific for edging is also mandatory (edge supported, not dry wood stored in suitable environment, 50 mm minimum curvature on the side opposite to that of wrapping).*

A5.01.52 **"RPS" HEATING DEVICE, FOR MAX. 60 MM THICK PANELS (300 mm)** **N. 1**

Complete with no. 2 shot wave lamps 1500W set before the gluing unit to pre-heat the side of the panel.

A1.70.58 **"SGP" GLUE POT WITH NC DOSAGE INSTEAD OF STANDARD** **N. 1**

It allows the **dosage adjustment by NC,** according to the glue and / or the type of panel and finish quality. It replaces the manual adjustment.

A1.70.59 **ADDITIONAL "SGP" GLUE POT WITH NC DOSAGE – MANUAL FEEDING** **N. 1**

Interchangeable with the "SGP" glue pot installed on the machine.

A7.23.25 **CARRIAGE FOR THE PRE-HEATING OF 1 GLUE POT** **N. 1**

Free-standing device movable on pivoting wheels and useful for the storage of max no. 1 glue pot.

It includes:

- lock-unlocked mechanism with manual lever.
- electrical connection for heating at a pre-set temperature.
- motorization of the glue roller for easy and manual cleaning operations.

A7.23.23 ELECTRONIC POSITIONING OF EDGE GUIDE **N. 1**

Positioning of the edge guide by nc motorized axis to set the correct position at the edge height changeover.

A7.23.22 ELECTRONIC POSITIONING OF THE PRESSURE ROLLERS **N. 1**

Motor driven positioning of the pressure roller conveyor by numerical control to set the position when the edge thickness changes.

A1.70.89 KIT FOR DISABLING THE SOLID WOOD MACHINING ON "HM 3002" GLUING UNIT **N. 1**

It **disables** the standard function of processing precut strips in veneer and solid wood in the "HM 3002" gluing unit.

Technical data:
Thickness of edge in coils: as standard
Thickness of precut strips in veneer (opt): NOT AVAILABLE Thickness of solid wood edge: NOT AVAILABLE

A8.16.17 "AAG" ANTI-ADHESIVE DEVICE FOR THE FIRST PRESSURE ROLLER N. 1

It prevents the glue sticking to the first roller of the pressure zone of the gluing unit during the straight processing. It's complete with a spraying gun, and tank for the anti-adhesive liquid.

A3.30.29 "AAB CLEAN PACK" FOR EDGE EXCEEDING ZONE N. 1

Anti-static and cooling device **ASR** for edge exceeding zone that prevents the glue sticking of the exceeding edge made by the end trimming unit to the machine by means of electrostatic effect. It helps the tool cleaning with lowering of temperature of the possible glue remaining on the edge after the gluing unit. It allows to maintain a high machine productivity. Complete with a spraying gun, and tank for the anti-adhesive liquid RIEPE LP289/99.

A1.72.24 "AltaPUR 4HO" PREMELTER FOR GLUE POT FILLING N. 1

For the pre-melting and use of PUR glue with the edge bander. It includes:

Pre-melting device for Polyurethane glue slugs with **Melt On Demand** technology.
The glue slug (which can be inserted in the melting tank with the protective film) is pushed through a pneumatic pusher on a heated grid that melts only the first glue layer and leaves the characteristics of the remaining glue unchanged, to safeguard the quality. In case of partial use, the glue slug can be removed.
The device **automatically checks** the quantity of adhesive in the drum and gives an appropriate indication / alarm.
The premelter is equipped with an intuitive HMI on board for a **convenient use and a monitoring of the system.**
The device can be interfaced with the main control of the edge bander.
Electronic temperature control. Under-/over-temperature monitoring.
Pump with variable rotating speed to adjust the glue capacity supplied directly from the control interface.
0.75 Kg melted glue stock under the melting tank area. It allows sufficient duration to substitute the ended cartridge without stopping the machine time.
The area of the melting chamber and the grid is easily accessible with quick release openings for easier and **faster cleaning and maintenance.**

Heated hose to fill the glue pot with the melted glue. Reinforced Inox steel, thermo-isolated hose, with quick release connection to the melter and the "H20 LBS" type valve. Temperature sensor Nickel RTD.

System for opening / closing the conduit of the heated hose with "H20 LBS" type valve which allows the glue to pass from the heated hose to the glue pot.

Technical data:
Melt capacity: up to **6 Kg/h**
Operating temperature range: 40°C - 190°C
Glue slug: cylindrical type, 2 Kg with external protective material in aluminum, 130 mm diameter.
Prearrangement for a subsequent installation of the melting chamber for 3 Kg cylindrical slugs, with protective material in aluminum, 150 mm diameter
It does not require inert gas for the functioning. IP54
protection degree
Viscosity range: up to 45000 cps Temperature sensor
Nickel RTD

A7.22.94 VERTICAL 12 COIL MAGAZINE WITH AUTOMATIC EDGE CHANGEOVER WITH PLIERS (MAX. H=65) **N. 1**

Edge feeding system with 12 stations for the automatic infeed of material in coil with the possibility of inserting thin strips or thin solid wood in package:

- 12 coil-holders vertically placed.
- automatic infeed system of the edge with automatic change-over for pairs 1-4/2-5/3-6/7-10/8-11/9-12, or with changeover in sequence and programmable logic controller
- warning indicating the end of the roll.

Recommended for edges up to 3 mm and for frequent changes of material and/or color.

Technical data:
Maximum roll Ø: mm 800 Max.
edge thickness
- in plastic material: mm 3
- in wood material: mm 1

Max. height:
- for thin edges up to 1 mm: mm 65 (4 central coils)
- for edges up to 3 mm: mm 45 (8 lateral coils) Distance between panels:

at 18 m/min: 290 mm
at 25 m/min: 340 mm
at 30 m/min: 390 mm
at 40 m/min: 470 mm

A1.71.21 "YU/SP-1000" UPPER END TRIMMING UNIT, 0,5 kW N. 1

For the cut of the exceeding edge from the front and back of the panel (for soft/post-formed panels too)

- unit installed on the top pressure beam.
- 0°-22° independent automatic tilting of blades (front/rear).
- horizontal sliding of motors on ground round bars.
- lateral and front feelers to adjust the cut point of blades on the panels.
- independent automatic exclusion of motors for machining non- orthogonal panels (ex. rhombic) and for end-trimming one side only.
- 5 mm automatic exclusion of the unit when motors are off.

Technical data:
Motor power: 2 x 0,5 kW
Blade rotation speed: 12000 rpm
Maximum track speed (depending on edge thickness): 25 m/min Maximum removable edge section: 1.300 mm².
Minimum distance between panels (end/beginning): 120 mm Minimum distance between the beginning (end) of one panel and the beginning (end) of the following at 25 m/min: 600 mm Blade stroke: 40 mm
Edge thickness: 0,4-25 mm Straight panel thickness: 8-60 mm
Shaped/soft forming panel thickness: 10-36 mm Minimum panel length:
80 mm (at 12 m/min on double sided machine and manual infeed)
120 mm (at 12 m/min)
280 mm (at 25 m/min)
Tools installed: no. 2 blades Ø150 mm Z=24+24

A5.05.71 AUTOMATIC HORIZONTAL BLADE TILT FOR "YU" N. 1

D5.07.49 "R-E" TRIMMING UNIT, 1,8 KW, R.H. N. 1

For the rough trimming of thin and thick edges or for the finishing of veneer edges and solid wood.

It consists of:

- closed and highly stiff monolithic supporting structure.
- two overlapped motors with **quick release** of the motor bloc + tool for a fast and precise change
- vertical movement on linear ball recirculating guides with manual lubrication
- top motor connected to the pressure beam for the automatic adjustment of the working position according to the panel thickness.
- "ED-SYSTEM" high efficiency exhaust hoods
- copying system by vertical disc-shape feelers of large diameter
- motor+tool position manually adjustable with numerical indicators
- device for the **automatic vertical positioning by HMI** on 2 positions with manual adjustment of stops by numerical indicators.

Technical data
Panel thickness min/max 8-60 mm Edge thickness min/max 0,3-25 mm Motor power 2 x kW 1,8
Motor rotation speed rpm 12000 Separate vertical automatic exclusion
Tools installed: head with HM cutters to throw Ø 80x30.

A5.05.03 EXHAUST HOODS WITH TEFLON COATING INSTEAD OF STANDARD ONES FOR "R-E" UNIT N. 1

A5.06.73 NO. 2 "ED-SYSTEM" TOOLS INSTEAD OF STD. FOR "R-E" N. 1

A1.71.38 "RSU-E 2P NC" FINE TRIMMING UNIT, 1 kW N. 1

For the finishing of thin edges, wood or for the rough trimming of the radius on plastic edges (PVC/ABS/PP):

- closed and highly stiff **monolithic** supporting structure.
- motors moving on **linear** ball recirculating **guides** with manual lubrication.
- two motors tilted at 20°.
- manual device for the **quick release** of the motor bloc + tool for a fast and precise change of processing or tool
- top motor connected to the pressure beam for the automatic adjustment according to the edge thickness.
- **vertical copying system** by means disc-shape feelers of large diameter.
- **horizontal copying system** by means of lateral disc-shape feelers of large diameter with independent adjustment.
- numerical indicators for the horizontal and vertical shifting/adjustment of motors and for the shifting/adjustment of lateral feelers
- separate vertical and horizontal automatic exclusion of motors.
- **automatic exclusion** of the lateral feeler for max 25 mm solid wood passage.
- **kit for machining with HMI automatic changeover between 1 thin edge and 1 rounded edge, for machining infinite thin edges** or for micro-adjusting rounded edges according to the installed or selected tools. It includes:
  ***** device for the automatic vertical and horizontal movement on 2 working positions of the motor + tool with numerical indicators for the manual adjustment of the stops.
  ***** servo-assisted positioners for the vertical motor movement, useful for the machining of infinite thin edges

TECHNICAL DATA:
Panel thickness min/max 8/60 mm with max 1 mm thick edge Panel thickness min/max 10/60 mm with max 2 mm thick edge Panel thickness min/max 12/60 mm with max 3 mm thick edge thickness min/max: 0,3/3 mm
Motor power: 2 x 1 kW Motor
speed 12000 rpm
Front/vertical feelers: disc/disc.
Tools installed: no.2 straight/R2 tools.

A1.71.41 **"HI-DRIVE" NC MULTIEDGE KIT FOR STRAIGHT/R/R/R MACHINING WITH "RSU-E 2P CN" UNIT** **N. 1**

Kit for the processing **up to 3 rounded edges + infinite thin edges** or wood edge (specific tool to be chosen separately), with setting directly from NC without manual adjustments.
Particularly convenient in cases of flexible machining with frequent processing changes.

It replaces the "RSU-E 2P NC" unit, with the "**RSU-E NC MULTIEDGE**" unit.

- closed and highly stiff **monolithic** supporting structure.
- 2 motors tilted at 20°.
- manual device for the quick release of the tool-holder block/tool for a fast and precise change of processing or tool
- upper motor connected to the pressure device for the automatic adjustment depending on the thickness of the panel.
- motors moving on linear ball recirculating guides with manual lubrication.
- vertical copying system by disc-shape feelers of large diameter
- horizontal copying system by disc-shape feelers of large diameter with independent adjustment
- Brushless power assisted positioners for the vertical and horizontal automatic movement of the tool-holder carriage + tool.
- Brushless power assisted positioners for the horizontal automatic movement of the lateral feeler on infinite working positions.

Technical data:
Panel thickness: min / max 8/60 mm with max 1 mm thick edge Panel thickness: min / max 10/60 mm with max 2 mm thick edge Panel thickness: min / max 12/60 mm with max 3 mm thick edge thickness: min/max 0,3/3 mm
Separate vertical and horizontal automatic exclusion of motors Automatic exclusion of the lateral feeler for the passage of max 25 mm solid wood
Tools straight/R/R/R not installed *(compulsory choice)*.

A5.09.88 **EXHAUST HOODS WITH TEFLON COATING INSTEAD OF STANDARD FOR "RSU-E"** **N. 1**

A7.73.47 NO. 2 "ED SYSTEM" HM TOOLS R=2/R=1,5/R=1/STRAIGHT N. 1

D7.38.01 CORNER ROUNDING UNIT "ROUND 4" RH N. 1

To carry out the **front and rear rounding** of shaped panels or PVC/ABS edges and thin solid wood with high finishing quality.

It consists of:

- 4 motors supported by a parallelogram kinematic motion which allows the unit to follow the head (end) of the panel in sequence, independently from the geometry of the profile.
- manual device for the **quick release** of the motor block + tool for a fast and easy change of processing
- motor+tool position manually adjustable with decimal readout
- "**ED-SYSTEM**" high efficiency exhaust hoods
- separate processing sequences to avoid the simultaneous working which could cause vibrations of the panel, provided with oscillating motion to follow the panel
- copying system by frontal **rolling** feelers and lateral **slide** feeler.

Technical data:
Panel thickness:
with max. 1 mm thick edges: mm 8-60 with
max. 2 mm thick edges: mm 10-60 with max. 3
mm thick edges: mm 12-60 Edge thickness
min/max: 0,3/3 mm Motor power: x 0,35 kW
Motor speed: rpm 12.000
Max track feed speed: 25 m/min.
Concave profile radium: 36 mm
Working line: 35 mm
Panel gap at 25 m/min: 500 mm
Minimum panel length: 120 mm (for single sided edge bander)
Minimum panel length: 80 mm (for double sided edge bander)
Max automatic exclusion: 25 mm
Tools not included.

A7.38.12 MULTIEDGE KIT FOR 4 AUTOMATIC POSITIONS STRAIGHT/R/R/R **N. 1**

Kit for the processing of **1 thin edge + 3 rounded edges** with NC automatic changeover.

It includes, in addition to the standard, the device for the automatic changeover of the working tool position.
Tool straight/R/R/R not installed.

A7.38.13 NC LATERAL FEELER/TOOL POSITIONING **N. 1**

It allows the NC processing of infinite thin edges or the micro- adjustment of the rounded edges according to the installed or selected tools.

It includes a NC positioner for each working head, for the positioning of the Tool+motor carriage with respect to the lateral feeler. It ensures an optimal adjustment/setting of the finish precision.

A7.38.60 NO. 4 DIAMOND TOOLS STRAIGHT 20° MAX 0,8 MM/R=1/R=1,5/R=2

D7.46.33 **"MX80" HSK MILLING UNIT, WITH THE SAME ROTATION AS THE FEED DIRECTION, KW 10, R.H.** **N. 1**

For through or timed grooves on the top, bottom and sides of the panel:

- solid structure directly installed on the machine base for vibration free operation.
- electro spindle motor with HSK 63F quick release device, tiltable up to 90°.
- double direction of tool rotation for vertical or horizontal motor positioning selected from the controller.
- time-entry device on linear ball recirculating guides with high degree precision of intervention assured by the special software support.
- decimal numerical indicators for the horizontal, vertical positioning and rotation of the motor.
- tool-holder flange for cup-shaped cutter.
- automatic adjustment of time-entry.
- 3 quick change exhaust hoods for top, bottom and lateral machining.
- vertical manual cut-off.

Technical data:

Intervention precision at 20 mt/min	**mm +/- 2 mm**
Intervention precision at 30 mt/min	**+/-3**
Speed	rpm 12000
Motor Power	kW 10
Tool not installed:	
Ø min./max.	mm 125
max. weight	kg 7
max. height	mm 63

Cones not included.

A1.71.45 **"HI-DRIVE" KIT FOR "MX80" - ELECTRONIC VERTICAL, HORIZONTAL POSITIONING AND 0-90° MOTOR ROTATION** **N. 1**

It includes:

- electronic horizontal and vertical positioning of the unit driven by **Brushless** motor and sliding on recirculating ball screws.
- 0-90° motor rotation by means of **Brushless** driver
- electronic management of tool stroke.

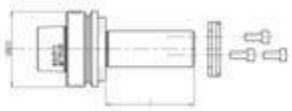
A9.01.14 ADDITIONAL EXHAUST HOOD FOR GROOVING MILLING UNIT N. 1

It improves the suction of the material removed by the grooving milling unit. In addition to the hood, it includes a blower for the groove cleaning.

A1.70.52 NO. 1 HSK 63 F CONE, D=30 L= 55 MM FOR "MX80 HSK" N. 1

Tools, assembly and balancing not included.

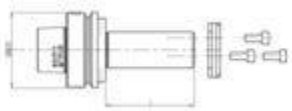
When used together with 160 mm diameter tools for wood profiling, the rotation speed changes from 12,000 to 9,000 rpm. With standard blades, the speed remains unchanged.



A1.70.52 NO. 1 HSK 63 F CONE, D=30 L= 55 MM FOR "MX80 HSK" N. 1

Tools, assembly and balancing not included.

When used together with 160 mm diameter tools for wood profiling, the rotation speed changes from 12,000 to 9,000 rpm. With standard blades, the speed remains unchanged.



D5.12.13 "RCS-E" EDGE SCRAPER UNIT, R.H. N. 1

For the finishing/smoothing of rounded plastic edges PVC/ABS/PP:

It consists of:

- closed and highly stiff **monolithic** supporting structure.
- manual device for the **quick release** of the tool holder bloc + tool for a fast and precise change of the tool
- upper tool holder carriage connected to the pressure beam for the **automatic adjustment** according to the edge thickness.
- tool holder carriages moving on **linear** ball recirculating. **guides** with manual lubrication
- **vertical copying system** by disc-shape feelers of large diameter
- **horizontal copying system** by lateral disc-shape feelers of large diameter with independent adjustment
- numerical indicators for the horizontal and vertical shifting/adjustment of tool holder carriages and for the shifting/adjustment of lateral feelers
- suitable cleaning and nebulizing blowers for each tool
- suction of the edging cuts-off with suitable external container for plastic chips

Technical data:
panel thickness min/max 8/60 mm with max 1 mm thick edge panel thickness
min/max 10/60 mm with max 2 mm thick edge panel thickness min/max 12/60
mm with max 3 mm thick edge thickness min/max 0,3/3 mm
separate vertical and horizontal automatic exclusion of tool-holder carriages and for the passage of max 25 mm thick solid wood
Tools not included.

A1.71.50 KIT FOR "HI-DRIVE" NC MULTIEDGE, STRAIGHT/R/R/R N. 1

For machining up to 4 edges, 3 rounded edges + 1 straight edge with setup directly from NC without manual adjustments.

Particularly suitable for flexible machining with frequent changes.
It replaces the "RCS-E" manual unit with the "**HI-DRIVE RCS-E NC MULTIEDGE**" unit.
It includes in addition to the standard:

- **Brushless** power assisted positioners for the vertical and horizontal automatic movement of the tool-holder carriage + tool.
- **Brushless** power assisted positioners for the horizontal automatic movement on infinite working positions of the lateral feeler.

Tools straight/R/R/R not installed.

A5.12.36 WASTE PRODUCT DETACHMENT SYSTEM N. 1

It helps the waste product suction.

A5.13.00 WASTE PRODUCT EXTRACTOR N. 1

To increase chip removal efficiency.

A7.73.88 NO. 2 PLATES 2/1,5/1/STRAIGHT N. 1

D5.13.70 "GT" SANDING UNIT FOR STRAIGHT PROCESSING, RH N. 1

For finishing and preparing for the painting of wood edgings with straight or inclined profile:

- inclination can be manually adjusted from -5° to +15°
- oscillation of the unit for a uniform usage of the complete length of the abrasive tape and of the pad
- safety in case of broken tape with immediate ejection of the pad and motor stop
- pad pneumatic intervention run by control to protect the front and rear edgings of the panel.
- pad equipped with rapid release.
- blowers for the cleaning and cooling of the abrasive tape, timed intervention simultaneously with pad entry
- numerical indicators for the horizontal and vertical shifting and for the inclination of the unit
- automatic disabling of the pad.

Technical specifications:
Max height of surface to be sanded: mm80 Motor power: kW 1.34/1.78.
Abrasive tape speed: m/sec 7/14 Abrasive tape dimensions: mm 90x2500 Straight pad installed.

A5.13.71 TAPE SPEED ADJUSTMENT BY INVERTER FOR "GT-GTU" N. 1

For sanding, referred to the feeding speed and to the type of abrasive tape.

Technical specifications
Motor power: 2,23 kW

D5.12.11 "RCA/2C" GLUE SCRAPING UNIT, R.H. N. 1

It eliminates possible excess of glue on the top and bottom side of the panel:

- completed with two cutter-tools of Widia.
- vertical feelers.
- two blowers which allows the cutters to be always clean.
- pneumatic intervention to assure the best processing of the starting and the ending side of the panel.
- automatic cut-off.

A5.16.10 ANTI-ADHESIVE DEVICE FOR "RCA/2C" CUTTER CLEANING

To avoid deposits of glue on the cutter tools of the scraping unit in order to improve panel quality and cleaning from glue residue.

It includes:

- 2 spraying guns, feed by 2 RIEPE LP 163/93 liquid boxes

Note: if used together with code A51451, the brightness of some particular types of edges (poor pigmentation) can be of lower quality than that obtainable with blowing brightening units (Phon type).

D5.12.11 "RCA/2C" GLUE SCRAPING UNIT, R.H. N. 1

It eliminates possible excess of glue on the top and bottom side of the panel:

- completed with two cutter-tools of Widia.
- vertical feelers.
- two blowers which allows the cutters to be always clean.
- pneumatic intervention to assure the best processing of the starting and the ending side of the panel.
- automatic cut-off.

A5.16.10 ANTI-ADHESIVE DEVICE FOR "RCA/2C" CUTTER CLEANING N

To avoid deposits of glue on the cutter tools of the scraping unit in order to improve panel quality and cleaning from glue residue.

It includes:

- 2 spraying guns, feed by 2 RIEPE LP 163/93 liquid boxes

Note: if used together with code A51451, the brightness of some types of edges (poor pigmentation) can be of lower quality than that obtainable with blowing brightening units (Phon type).

D8.15.76 "SP/F" OVERLAPPED BRUSHING UNIT, R.H. N. 1

For the cleaning and finishing (shining) of plastic edges:

- two overlapped motors manually with inclination completed with two cloth brushes.
- top motor connected to the pressure beam for the automatic adjustment according to the thickness panel.
- manual cut-off

Technical data:
Speed: rpm 1500
Max. horizontal inclination: 5° Max.
vertical inclination:
- with 8 mm panel: 4°
- with 60 mm panel: 8° Motor

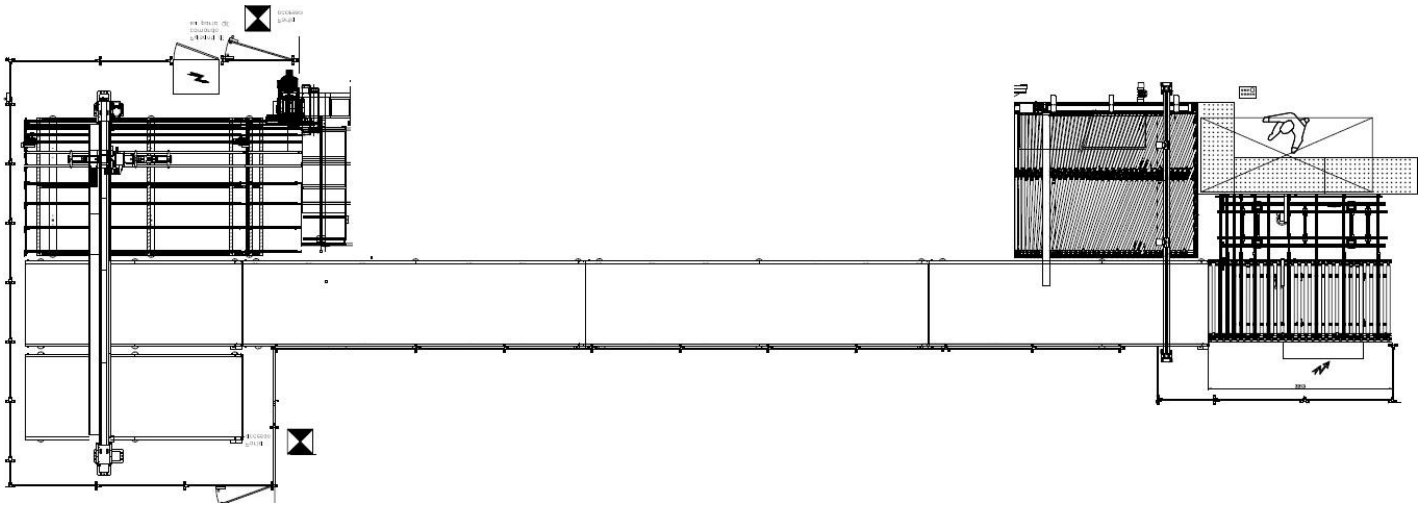
power: kW 0,29+0,29
Brush dimensions: mm 150x50x33

A8.15.77 PNEUMATIC CUT-OFF AND OSCILLATION FOR "SP/S", "SP/F" N. 1

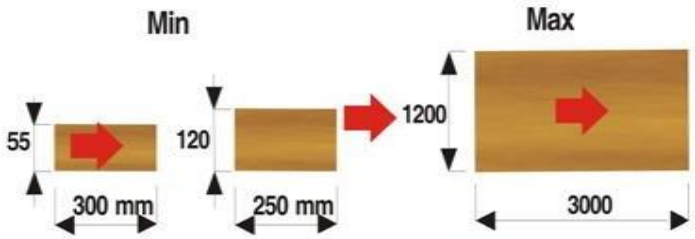
A5.14.51 NO. 2 RIEPE BRUSHES FOR PLASTIC EDGES FOR EDGE BRIGHTING FOR SP/F N. 1

Two specific cloth brushes for shining effect of the plastic edges in addition to the pair of cloth brushes included in the unit.

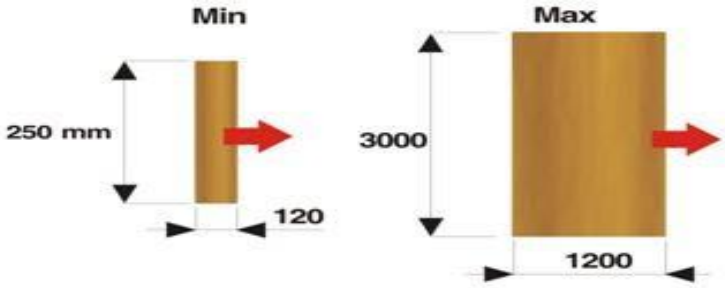
HANDLING SYSTEM



Lengthwise pass:



Crosswise pass:

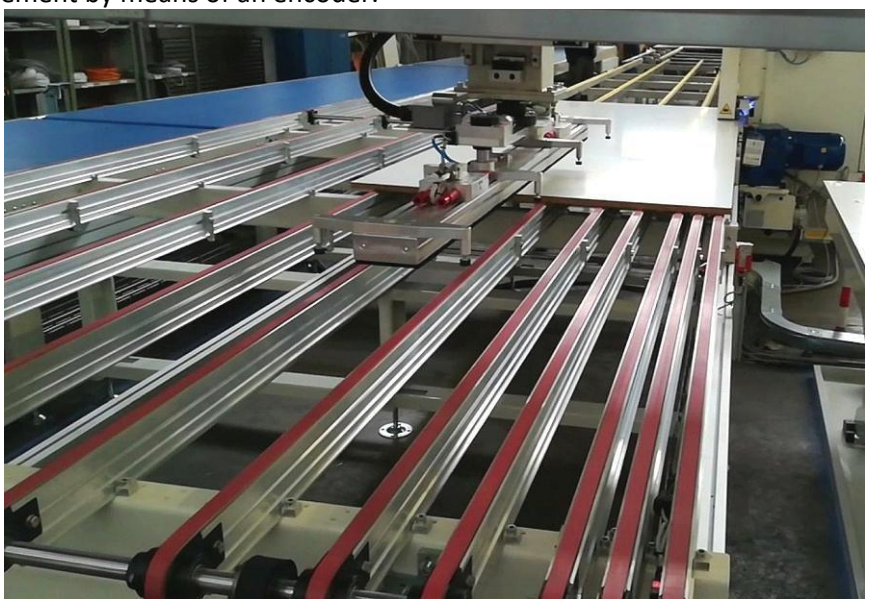


A1.72.28 **“PICKBACK” GANTRY PANEL RETURN SYSTEM** **N. 1**

For a fast and simple horizontal handling of the panel.

It automatically picks up the panels coming out from the edge bander and brings them back to the panel loading area.
It includes:

Panel extraction system by belts
For the extraction of the panels from the edge bander and subsequent fine positioning with respect to the vertical axis of the gripping head for a precise picking.
Composed of a series of toothed round belts with high grip rubber and with movement by means of an encoder.



Gantry system for panel handling
For the translation / rotation of the panel, by means of a gripping head, from the belt bench to the motorized belt on which the panel is placed, always oriented longitudinally.
It consists of:

- steel / aluminum gantry structure for the shifting of the gripping head with 3-axis BRUSHLESS movement (vertical, lateral and head rotation)
- lateral movement with toothed belt and linear recirculating ball guides
- vertical movement on linear recirculating ball guides
- device for the reading and automatic control of the panel width, for the correct positioning of the gripping head, in case the data does not arrive from the edge bander (Bar Code, production list or Supervisor) or is wrong.

Panel gripping head.
System for picking up panels with vacuum sponge-rubber technology on aluminum bar with automatic rotation by means of BRUSHLESS axis: 0°/+ 90°/-90°/180°.

Motorized conveyor belt
For moving the panels from the storage area of the gripping head to the loading area of the edge bander. Consisting of a motorized belt conveyor with 95 mm diameter rollers and PVC belt with a straight guide device of 1400mm width.
The belt is composed of several segments with independent motorization to guarantee correct buffering and homogeneity of feeding and collection. Overall length depending on the length of the edge bander.
Edge banders with interaxis longer than 6800 mm require the belt length adjustment (optional code).

Safety device
It includes lateral safety guards and access to the internal area with interlocking systems, according to the requirements of the EC rules.

HMI
The pick back system is managed directly by the edge bander's HMI A single control point can therefore manage the edge banding cell.

Technical Data:
Panel thickness: min/max 10-60 mm (10 – 80 mm when the edge bander is equipped with the appropriate optional code)
Max liftable panel weight to: 80 Kg Max weight
on the surface: 25 Kg/m2 Panel flatness
tolerance: 1 mm/m Types of panels which can
be handled:
chipboard/MDF/wood/coated hollow-core panels/with protective film Types of panels which CANNOT be handled:
panels with grooves/drilling, structured textures (ex. deep wood grain). For these panels the feasibility must first be tested by SCM on a case-by-case.

Max speed of the edge bander: 30 m/min Overall
height of the system: 2500 mm
Working table height: 970 mm (adjustable +/- 25mm) Overhang
panel: same as the edge bander
System for edge bander in left hand version
The flooring / foundation must have characteristics as per SCM technical.

Dimensions of panels which can be handled:
Lengthwise pass:
- Length min/max: mm 250 - 3000
- Width min/max: mm 120* – 1200

** Minimum width:*
- *55 mm (and 300 mm minimum length with appropriate optional code for the edge bander)*
- *140 mm when the edge bander is equipped with the adjustable panel overhang*

Crosswise pass:
- Length min/max: mm 120 - 1200
- Width min/max: mm 250* – 3000

Handling performance / cycle
- without panel rotation: 10 cycles / min
- with 90° panel rotation: 9 cycles / min

Loading composition with gripping head for translation on motorized conveyor belt:
Single panel
The device manages the movement of panels loaded in the edge bander both longitudinally and transversely, in an automatic and flexible way.

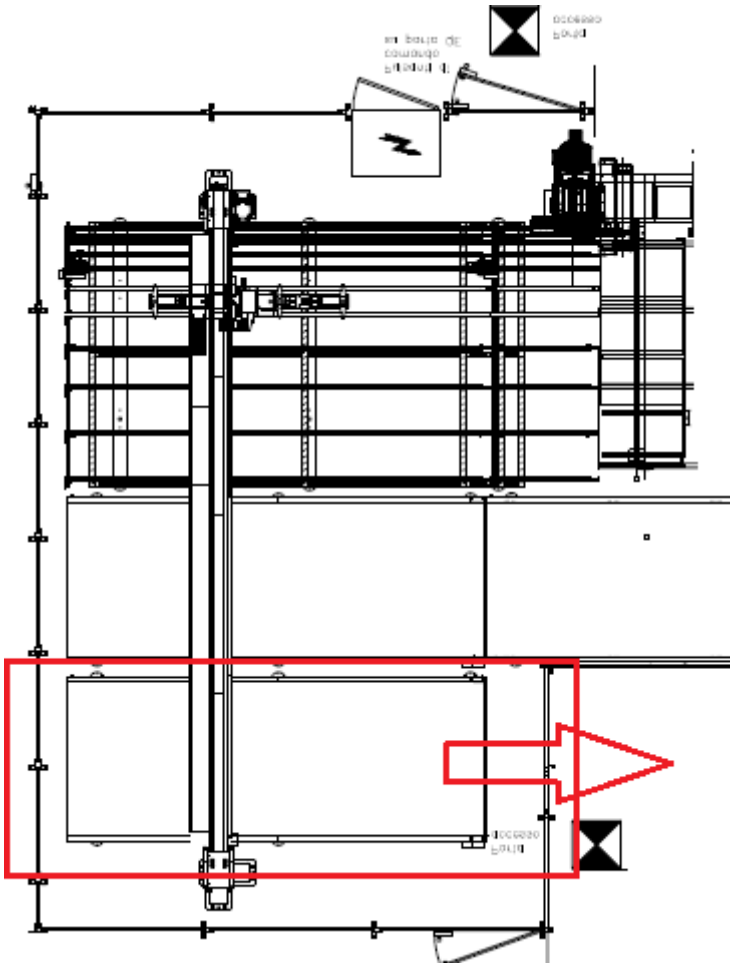
Environmental conditions of use:
The functioning of the machines is guaranteed within the following environmental conditions:
Min / max temperature: +10 ÷ +35 ° C Min / max
relative humidity: 5 ÷ 80%
Altitude: max 1000 m a.s.l. (beyond this quota consult the Manufacturer)

Note: for optimal operation, we recommend using the machines in an environment with a temperature between 18 and 30 ° C and relative humidity between 30 and 65%.

93.12.01	**Frequency 50 Hz**	**N. 1**
B0.91.00	**400V/50HZ POWER SUPPLY WITH NEUTRAL**	**N. 1**
A9.90.00	**EUROPEAN SAFETY REGULATIONS (EC NORMS)**	**N. 1**
A1.72.29	**SECOND UNLOADING STATION**	**N. 1**

Additional Motorized conveyor belt for second unloading place

For moving the panels from the storage area of the gripping head to the loading area of the edge bander. Consisting of a motorized belt conveyor with 95 mm diameter rollers and PVC belt with a straight guide device of 1400mm width.



A1.72.32 ADAPTATION OF THE MOTORIZED BELT LENGTH N. 1

For the adaptation of the motorized belt sections length and the safety guards when the edge bander has an interaxis longer than 6800mm.

A1.72.37 ZOCCOLI "PICKBACK" N. 1