

Offer

Date : 27.10.2009 / CHO

For further questions quote

Offer number : 666601

Customer :

Machine number : 0-261-66-6601

Customer number : 37050

Competent person :

G.0001 Number : 1 time 1-250-80-0057
PROFILINE KDF 880

BRANDT SINGLE-SIDED EDGEBANDING MACHINE

MODEL: HIGHFLEX 1880

Single-sided edge banding machine for processing straight workpiece edges and for gluing and post-processing different edging materials in longitudinal and cross through-feed.

OVERVIEW OF THE UNIT EQUIPMENT:

JOINT TRIMMING UNIT 2 X 2,2 KW 200 HZ

GLUING UNIT A15

END TRIMMING UNIT CHAMFER/STRAIGHT 2 X 0,35 KW

PNEUM. ADJUSTMENT END TRIMMING CHAMFER/STRAIGHT

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PNEUM. 2-POINT-ADJUSTMENT END TRIMMING
ROUGH TRIMMING UNIT 2 X 0,55 KW 0 DEGREE
PNEUM. ADJUSTMENT TRIMMING UNIT
PNEUM. 2-POINT-ADJUSTMENT
TRIMMING UNIT 2 X 0,55 KW SYNCHRONIZED
PNEUM. 2-POINT-ADJUSTMENT
PROGRAM ADJUSTMENT - LATERAL SENSING
PROGRAM ADJUSTMENT TO EDGE THICKNESS
CONTOUR TRIMMING UNIT 4 X 0,3 KW WD 60
PROFILE SCRAPING UNIT W/QUICK-CHANGE HEADS
PNEUM. ADJUSTMENT PROFILE SCRAPING UNIT
GLUE JOINT SCRAPING UNIT
BUFFING UNIT

1. BASIC MACHINE :

- continuous machine frame, for mounting the processing units
- fixed stop side on the right
- lacquering grey RDS 240 80 05
- infeed fence motor-driven adjustable
- infeed stop pneumatically controlled
- top pressure:
 - 2 single rows of staggered rollers
 - motor driven height adjustment
 - position readout and adjustable directly through control panel
- workpiece transport device:
 - transport chain with rubber coating, 80 mm wide
 - precision running and guiding surfaces
 - standard equipment with automatic lubrication of chain track
 - panel support with roller guide, extendable by approx. 600 mm
- noise protection, with individual extraction ports for the joint trimming unit and chip collection box, as well as a central extraction port for the post-processing
- indoor lighting of hood via 3 lamps

- feed speed | 8 - 20 m/min

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- feed speed max. w/cont. trim. | 20 m/min
- working height | 950 mm
- pneumatic connection | min. 6 bar
- total length | 7.260 mm

floor conditions must correspond to the
 layout and suction plan no.: 5-701-80-1392

2. WORKPIECE AND EDGE PARAMETERS:

- workpiece width min:
 - in case of workpiece thickness 12-22mm | 70 mm*
 - in case of workpiece thickness 23-40mm | 120 mm*
 - in case of workpiece thickness 41-60mm | 150 mm*
- *depends on the workpiece length
- workpiece overhang | 38 mm
- workpiece thickness | 8 - 60 mm
- edge height max.= panel thickn. | + 6 mm
- edge material coil | 0,4 - 3 mm
- edge mat. cross section max.
 - for PVC | 135 mm²
 - for veneer | 100 mm²
 - coil diameter max. | 830 mm
- edge material strips | 0,4 - 15 mm
- edge material strips when using VKNR 0020 | 0,4 - 20 mm
- edge mat. cross section max.
 - for strips, according to the selected options | 600 - 900 m²
- if no radius is indicated, R=2 mm will be installed and delivered
- the machine operator is responsible for the provision of suitable material (boards, edging material, glue)

3. UNIT EQUIPMENT

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3.1 JOINT TRIMMING UNIT 2 X 2,2 KW 200 HZ

- for jointing work in front of the gluing unit, vertical spindle adjustments, electro-pneumatic control
2 motors (1 x synchronism, 1 x reverse rotation)
max. amount of chip removal is 3 mm
(the max. cross section depends on material characteristics and feed speed)
cover with extraction port diam. 120 mm
- incl. 2 diamond joint cutter heads with fixed knives,
diam. 100 x 48 x diam. 30mm, T = 3 + 3,
with double key way 8 x 3 mm.
max. workpiece thickness : 42 mm

3.2 GLUING UNIT A15

Consisting of:

WORKPIECE PRE-HEATING

- panel pre-heater for achieving optimal bonding quality

QUICKMELT APPLICATION UNIT

- Quickmelt melting unit and quick change Quickmelt application unit
- processing of PU adhesives is possible with standard application unit changeable PU glue (VKNO 2068) in compliance with the processing prescriptions
- glue reservoir underneath the glue roller
- glue application to the workpiece by means of a glue roller
no adjustment of the glue roller is required when changing the workpiece thickness
- the glue roller can be selected to rotate with or against the workpiece feed direction.
Glue temperature control by means of electronic thermostat
- automatic reduction of glue temperature upon interruption of the working process

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- glue applicator lift-off in case of feed stop
- glue applicator clamping workpiece actuated

GLUE REACTIVATION

- infrared heater to maintain the ideal glue application temperature

MAGAZINE

- automatic edge magazine for coiled material and fixed lengths, incl. roller plate
- equipped with heavy duty guillotine for cutting
- pneumatically controlled hard stop to prevent premature panel feeding into the machine works in conjunction with magazine edge monitoring system

PRESSURE ZONE WITH MOTOR DRIVEN ADJUSTMENT

- pressure zone with driven, pneumatically actuated main pressure roller and 4 idle post pressure rollers
- equipped with a digital readout for manual adjustment of the pressure zone to edge thickness

3.3 END TRIM. UNIT CHAMFER/STRAIGHT 2 X 0,35 KW

- for end trimming of the front and rear edge material overhang with drawing cut
- 2 motors, equipped with one saw blade each, swivelling range from chamfer to straight cutting 0-15 degrees
- equipped with an optimization package for reducing the workpiece gaps subject to the workpiece thickness and the feed speed
- increase in productivity with the same energy consumption
- Shorter machine running times with the same production capacity
- 2 motors 0,35 kW ea., 200 Hz, 12.000 rpm
- 2 saw blades diam. 100 x 32 x 2,6 mm, T = 24
- feed speed: 8 - 20 m/min
- 0,4 - 3 mm edge thickness max. 20 m/min
- 3 - 15 mm edge thickness max. 14 m/min

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3.4 PNEUM.ADJUST. END TRIMMING CHAMFER/STRAIGHT

- for the electro-pneumatic adjustment of the end trimming unit from chamfer to straight

3.5 PNEUM. 2- POINT- ADJUSTMENT END TRIMMING

- for flush end trimming or end trimming with overhang
- when end trimming with overhang the final finish is done by the contour trimming unit

3.6 ROUGH TRIMMING UNIT 2 X 0,55 KW 0 DEGREE

- for top and bottom flush trimming of the edge material overhang. 2 motors running in reverse rotation, mounted upon each other, vertically sensing, lateral manually movable by 30 mm
- height adjustment of the upper motor with the top pressure beam
- digital readouts for fast adjustment
- edge thickness max. 15 mm
workpiece thickness 8 - 60 mm
- 2 motors 0,55 kW ea., 200 Hz, 12.000 rpm equipped with:
- 2 cutters diam. 70 x 20 x 16 mm, T = 4

3.7 PNEUM. ADJUSTMENT TRIMMING UNIT

- for the electro-pneumatic movement in and out of the trimming unit

3.8 PNEUM. 2- POINT-ADJUSTMENT

- of the vertical copy wheel for either flush trimming or trimming with overhang

3.9 TRIMMING UNIT 2 X 0,55 KW SYNCHRONISM

- for trimming the top and bottom edge material overhang, vertically and horizontally sensing.
Height adjustment of the upper motor with the top pressure beam
- Functions to be chosen on the control panel:
2 working positions: Flush and radius/chamfer

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trimming

- all spindles equipped with digital readouts for fast adjustment
- 2 motors 0,55 kW ea., 200 Hz, 12.000 rpm equipped with DFC combination cutters for flush, chamfer and radius trimming edge thickness max. 12 mm

3.10 PNEUM. 2-POINT-ADJUSTMENT

- of the vertical copy wheel for either flush trimming or trimming with overhang

3.11 PROGRAM ADJUSTMENT - LATERAL SENSING

- motor driven and continuous axis-adjustment of the lateral sensing rollers to edge thickness of the banding
- automatic adjustment from thin tape with 13 degree chamfer, radius PVC/ABS or solid wood edges up to 12 mm

3.12 PROGRAM ADJUSTMENT TO EDGE THICKNESS

- motor driven and continuous axis-adjustment to edge thickness, suitable for chamfer and radius trimming of the outer edge of the applied edge material

3.13 CONTOUR TRIMMING UNIT 4 X 0,3 KW WD 60

- for contour trimming of front and rear edges at different profiles
- wood edges conditionally possible, depending on edge material
 restrictions are low density post and softformed panels and extremely thin melamine/foil edges or surface material
- incl. motor driven adjustment to edge thickness for processing of different edge thicknesses, combined with pneumatic 2-point adjustment radius/chamfer
- incl. 4 radius tools
- 4 motors 0,3 kW ea., 200 Hz, 12.000 rpm
- edge thickness max. 3 mm
- workpiece thickness max. 60 mm

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workpiece length min. 120 mm
 feed speed max. 20 m/min

3.14 PROFILE SCRAPING UNIT W/QUICK-CHANGE HEADS

- Sensing from top, bottom and laterally, for rounding off roughly trimmed PVC-edgings
- Edge thickness max. 3 mm. Height adjustment of the upper unit with the top pressure beam
- 2 quickly changeable scraping heads for a simple change of radii, equipped with 2 reversible profile knives

3.15 PNEUM. ADJUSTMENT PROFILE SCRAPING UNIT

- for the electro pneumatic lateral movement of the scraping unit

3.16 GLUE JOINT SCRAPING UNIT

- for removal of adhesive residues in the area of the glue joint
- sensing from top and bottom. Height adjustment with the top pressure beam
- equipped with 2 reversible cutter knives

3.17 BUFFING UNIT 2 MOTORS

- for smoothing the edges top and bottom
- 2 Motors ea. 0,18 kW, individually suspended, tiltable and height adjustable
- height adjustment of the upper motor with the top pressure beam
- 2 cloth buffing discs diam. 150 x 20 mm

4.0 ELECTRONIC POWER CONTROL PC 20+

BRANDT electronic control system with graphic user interface for simple and comfortable operation and programming of the machine

Technical data:

- tiltable control panel at machine infeed
- long life foil keyboard
- LCD flat screen 12 inch
- industrial PC with Compact-Flash-Disc for data storage
- unit selection touch buttons with status LED

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- operator's support by colour icons
 - commission-based operating data acquisition for the exact calculation of the production data by means of the direct allocation of commission and order. Data transfer with the included Brandt browser via network (Ethernet) to an existing PC
 - online change between various languages
 - visual readout of the essential set values and actual machine values
 - clear text information about the machine status
 - simple choice and adjustment of line points
 - simple axis adjustment (only if the machine is equipped with axis adjustment)
 - context-related help function with detailed information for the operation and function of the machine, directly on the screen
 - indicator for machine inspection and maintenance reminders
 - storage of processing programs
 - production access to processing programs
 - backup of processing programs
 - ventilating fan for the electronic controller in the control cabinet
 - modem for remote diagnostics via a public telephone line, which requires an analog connection to the machine.
- At the end of the warranty period, the remote system can be used on the basis of our usual terms and conditions

5.0 ELECTRIC EQUIPMENT

- operating voltage 400 Volt - 3Ph - 50Hz
- switch cabinet installed at the machine accord. to European Norm EN 60204
- frequency convertor, electronic, with motor braking function
- overvoltage protection for machines with electronic components
- country-specific adaption of operating voltage by transformer (optional)

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- electric equipment with a modular control system for increased operator comfort
- electronic stabilization of the internal control voltage of 24 V
- admitted temperature tolerance min. +15 degrees max. +35 degrees C, for the electrical and mechanical operations of the machine.
- in case of main voltage fluctuations of more than +/- 10 %, a voltage stabilizer must be installed at customer's site

6.0 SAFETY AND PROTECTION FACILITIES

- all machines destined for EC member countries are fitted with CE-plate in accordance with EC-Machine Directive 98/37/EC, Appendix IIA
- wood dust protection max. 2mg/m³, subject to the required extraction capacity being provided by the customer according to the suction plan.

7.0 HOMAG GROUP QUALITY KIT

- TÜV certificate accord. to DIN EN ISO 9001: 2000
- the machine will be installed and delivered accord. to Homag Group standard program

8.0 DOCUMENTATION

- documentation on CD-ROM
- operator instruction and maintenance manual additionally in printed form

G.0004 Number : 2620 1 x left
AUTOMATIC EDGE INFEEED DEVICE
for the fast change-over of different edgings on coils, up to max. 3 mm thickness. The edge material transport from the roller plate to the working position is motorized. No manual adjustments of the edge magazine is necessary if the edge material height is suitable to the panel thickness.

To be used on the following machines:
Ambition/Highflex/Profiline 1600-1800

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G.0007 Number : 0057 1 x left
PU-TOP PRESSURE ROLLERS INSTEAD OF RUBBER ONES
Top pressure beam to be equipped with PU-Top
pressure rollers instead of rubber rollers,
for extremely sensitive workpiece surfaces.

G.0010 Number : 0083 1 x left
WORKPIECE SUPPORT - EXTENSIBLE 1500 MM - 3 FEET
incl. support rollers.
For machine length Ambition/Profiline xx60.

G.0013 Number : 2074 1 x left
EXTRA GLUE POT

G.0016 Number : 2732 1 x left
DOUBLE COIL SUPPLY SYTEM
Variable system for locating coiled edge
material with a max diam of 800 mm and 65 mm
max edge height, for a quick edge material
change.
2 edge material coils are disposable at the
same time for further processing. The unit is
placed space-efficient in front of the edge
bander.

G.0019 Number : 2091 1 x left
AUTOMATIC GRANULATE FEED SYSTEM
for Quickmelt melting unit VKNR 2035.

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G.0022 Number : 4784 1 x left
SURCHARGE 1 SET DIAMOND JOINT CUTTER HEADS 60MM
- instead of the standard set diamond joint
 cutter heads,
 for joint trimming unit VKNO 4722
 diam. 100 x 65 x diam. 30 mm, T = 3 + 3,
 with double key way 8 x 3 mm
 max. workpiece thickness: 60 mm

G.0025 Number : 4829 1 x left
EXTRA COST COMBINED CUTTERS WITH DIAMOND KNIVES
instead of the standard combined cutter heads.

G.0028 Service: 8322 1 time
DOCU. AND CONTROL TEXTS: ENGLISH
Includes:
1. Production instructions, consisting of
 starting, operating and maintenance instruc-
 tions on DIN A4 paper and CD-ROM
2. Screen operating texts for machine operators
 for PC 20+ controls
3. Replacement part descriptions on CD-ROM
Delivery time: With machine delivery
(Only for machines from delivery year 2003)

G.0031 Number : 6108 1 x left
50000 VA ISOLATION TRANSFORMER AS A SUBPACKAGE
Isolation transformer to connect to deviating
network forms or line voltages for 50 or 60 Hz
Primary connection to 200V / 208V / 230V / 440V
480V / 600V, secondary 400V +/- 10%, installed
in an IP23 casing. Delivery is made as a
subpackage with the machine.
The installation and fuse protection of the
isolation transformer are the customer's
responsibility, in accordance with
local ordinances.

Application with the following machines:

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Ambition 1870 FC
Ambition 1880 F2C
Ambition 1880 FGC
Highflex 1880
Highflex 1890
as well as corresponding Profiline machines

G.0034 Number : 2215 1 x left
SEPARATING AGENT SUPPLY
Antiadhesive agent top and bottom, for better
release of glue residue of already processed
panels. Manual adjustment of panel projection
differences is necessary.

Only in combination with a joint trimming unit.
Can be used on series 1400 - 1800 only

G.0037 Number : 2220 1 x left
DETERGENT SPRAY UNIT WORKPIECE
Detergent spray for workpiece top and bottom
edge in order to eliminate antiadhesive agent
and glue residues from workpiece edge.
To be mounted in front of the buffing unit.

Can be used on series 1400 - 1800 only

G.0040 Number : 0128 1 x left
SPECIAL VOLTAGE USA/CAN. AMBITION 1200-1800
For 60 Hz electricity networks
Switchboard according to UL/CUL(CSA) standard
It's compulsory to apply an isolating
transformer from the option list of the
corresponding machine.
In case of Profiline machines the corresponding
isolating transformer will be determined by the
Brandt sales manager.