



	Article	Quant.
1.38	Operation manual English Translation to national language is effected by . Machine inscription: English	1
1.39	Machine documentation in English. Company will translate the manuals to national language. Machine inscription: Machine labels and warning signs in English or as symbols. Language of control: In English. Texts which have to be translated will be sent to .	1
1.40	Electric supply Electric connection 460 V, 60 Hz, 3 phases Voltage fluctuations max. + 6 % to - 10 % If the fuse protection by F1 protective switch is effected by the customer, an A.C.-D.C. sensitive (R CCB, type B) F1 protective switch with rated residual current ≥ 300 mA has to be used. Pneumatic connection 7 bar Air speed of dust extraction min. 30 m/sec. The dust extraction diameters are given in the floor plan. The indicated values have to be re-confirmed by Koch before the extraction device is installed by the customer. Ambient temperature at the place of installation min. 10° C (50° F) max. 35° C (95° F)	1
1.41	Warranty The warranty period for this machine is 12 months or 1920 operating hours (whatever comes first).	1
1.42	Lacquer machine RAL 9002 grey-white protective hoods RAL 3001 red control cabinet RAL 7035 grey security fence, gratings RAL 9005 black security fence, stays RAL 3001 red applications RAL 2004 orange	1

Optional Equipment and Services

Surge Suppressor

Surge suppressors will prevent voltage surges, spikes, and electrical noise from damaging the sensitive electronic components of your equipment. Note: surge suppressors are not to be used as voltage regulators.

- Surge suppressor for 480 V, 3 Phase equipment (#70-650-00148)

ADD \$ 1,075.00

Note that the surge suppressor does not include installation and is shipped F.O.B., Place of Inventory.

CML Multi Rip Saw with Infeed E350 2R Moving Blade Ripsaw



Picture is for reference only. Machine options & accessories may change the look of the final product.

Series Overview

CML is the industry leader in rip to width technology. With innovative patents incorporated as standard on many machines, you are sure to find a solution that meets your unique production needs. The E series offers economic machining solutions without sacrificing quality, efficiency, or reliability. Available in either fixed or moving blade solutions, the E series is perfect for small to medium shops and industrial manufacturers alike.

E Series Offers

Economic Innovation

The same high-performance technology and innovation that has earned CML their strong reputation is now available in the E series at an economic value. With standard patented features designed to dramatically increase accuracy and efficiency, the E series is an affordable solution that stands up to even the most challenging applications.

Long-Lasting Performance

CML's advanced roller chain design greatly increases the life expectancy of the chain carpet mechanisms, offering two to three times the life expectancy of a traditional prism design. This is accomplished by dramatically reducing the operating friction within the transport carpet mechanism for the work piece.

Advantages

The Roller Chain Design Has Distinct Advantages:

- The chain rollers ride across the hardened rails with dramatically less friction than traditional slat and prism designs. Less friction results in longer life and much, much less chain oil needed.
- Each slat is independent. If accidentally damaged, they can be easily removed and replaced. Several chain slat patterns are possible so upgrading from waffle to rubber slats is easily accomplished.
- Top press rollers provide adequate pressure as needed to control the work piece without fear of exerting more friction on the chain carpet. If not, enough downward pressure exists, the work piece can move resulting in inaccurate width cutting. So, with slat and prism designs, it is often required to use pin type spikes to hold the work piece so that light top pressure can be used.
- The open slat chain design advantage over closed designs is the slat and prism system. Whereas care must be taken to keep wood debris from fallen through onto the prisms as it will collect increasing the wear factor and bog down the feeding capacity. With the CML open chain roller design, the wood debris can fall through the slats freely. The rollers do not drag across the rails and therefore do not collect the debris.
- Feed belt/slat width is a generous 350 mm while allowing a pass thru width of 650 mm.

34.1 Steel Feed Belt, Roller Chain Carpet Transport * 52 pcs

The roller chain design is maintained by an automatic table lubrication pump. The pump is in operation when the chain is in operation. Low level warns are provided and the chain is interlocked to the pump so when it is out of oil, the chain will stop.

66.1 Automatic Table Lubrication Pump

The pump keeps oil to the chain system to ensure long lasting performance. The pump includes sensors for low/no oil levels.

Rip to Width Solutions

CML E Class rip saws offers several solutions dependent on the application.

Moving Blade: Moving blade solutions allow for each board to have its own, unique setup. Therefore, a yield savings of 3-10% is achievable. When combined with optimizing infeed systems, yield and capacity increases are achievable.

The moving blade solutions are CML's heavy duty design. The technology is taken from the primary saw industry. Heavy duty oversized rail and bearing blocks provide long life and trouble-free operation. Over-sized balls screws promote precision. Brushless servo motors benefit with fast and accurate blade positioning.





Precision Cut Quality

The high-performance patented roller chain is a CML standard across all models. When combined with the CML patented central guide block system, width accuracy is dramatically improved from ± 0.3 mm per meter to ± 0.1 mm per meter.

The unique guide system, exclusive to CML, features an industrial nylon guide block on alternating chain slats that provides an extremely accurate width tolerance cutting as needed for maximum material yield as well as superb glue line cutting accuracy*. The industrial guide block rides between steel rails so the contact point is lateral, not vertical as with prism designs. This results in longer life expectancy. After several years of hard production, the wearable blocks are replaced so that cutting tolerance can be improved again. When so, it is very easy and affordable solution to replace the blocks by the operator. With slat and prism designs, the entire chain and prism system would be replaced which could be as much as half the entire value of the machine.

35.1 Central guide system designed to reduce axial run-out of the chain carpet. Improved axial accuracy from ± 0.3 mm to ± 0.1 mm per 1M

**Glue line cutting quality is directly proportional to the quality of the timber being processed. Timber that has heavy character, shape, roughness, may not result in a quality glue able surface. For glue able surface quality, timbers must be planed top and bottom. Timbers also should not be with excessive bend, shape, twist, etc.*

Enhanced Safety Features

One thing that CML never compromises on is safety. That's why the E series comes standard with multiple rows of heavy-duty anti-kickback fingers for increased safety to both the machine and the operator. CML takes its safety features a step further with the inclusion of a bottom row of anti-splinter fingers to further prevent kickback of splinters that try to ride under work pieces while being processed.

CML's standard stops the kick back as soon as possible. It doesn't allow the ejection of the work piece to travel further than necessary. CML provides anti-kick-back fingers between the pair of top press rollers before as well as after the saw box. These two-additional row of safety devices combined with the heavier sets at the infeed provide the maximum protection for operator, machine, and tooling.

CML rip saws are complaint with Europe's CE safety standards as well as ISO (International Standards). In North America, the CML rip saws are compliant with UL and CSA regulations.

- 1pc Heavy Duty Top Anti-Kick Back Fingers
- 1pc Bottom Row of Anti-Splintering Fingers Protection
- 1pc Row of Anti-Kick Back Fingers between Top Infeed Press Rollers
- 1pc Row of Anti-Kick Back Fingers between Top Outfeed Press Rollers





Top Pressure Rollers

Top pressure rollers securely hold the workpiece to the feeding chain during operation. The machine features four adjustable independent rollers: two before and two after the saw box which spans the length of the feed belt, providing optimal pressure across the entire workpiece.

The height adjustment of the top rollers is a motorized adjustment.

A double bearing guide on each roller end shaft allows them to pivot to the thickness of the workpiece, distributing even pressure throughout production. This design is far superior to fixed rollers that cannot maintain contact with the workpiece always, resulting in poor cut quality and safety risks.

The roller chain can support higher pressure from top rollers than traditional prism systems, which can only handle light pressure without risking damage and wear. However, under lighter pressure, the workpiece can move, requiring chain spikes to keep the workpiece in place. With the CML roller chain design, no spikes are needed, providing better performance, safer operation, and lower cost of ownership.

Efficient Main Motor

The saw arbor is powered by a premium IE3 rated main motor. The motor includes soft starting, which adds to energy savings. Power is transferred from the motor to the arbor via belts to isolate motor vibration from the cutting area and achieve cleaner cuts.

The feeding carpet speed is regulated electronically by a frequency inverter for precise speed control and efficiency.

An electrically interlocked sound enclosure seals the machine's working area during production to prevent access to the machine.

Electric Components According to UL/CSA Regulations:

460-volt, 3-phase, 60 cycles

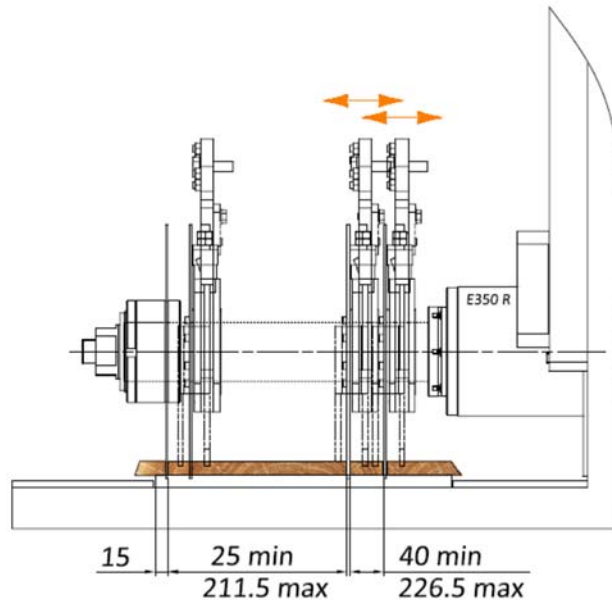
Note: Allowable voltage fluctuation +5%/-5%

Left Fixed Pocket Integration

More ripping value can be achieved by the addition of a fixed pocket sleeve mounted on the arbor. The fixed pocket sleeve is typically for processing narrow work piece widths but can also be used for a pocket width that has a high value of production. The fixed pocket integration is within the software and intuitive in its design. The operator mechanically installs the fixed pocket sleeve and with the flip of a switch, the software redundant limits on board are preset to allow for immediate production usage.

The new E series features a fixed pocket sleeve option on the side nearest the operator. This provides easy and fast access to pocket changes. The work piece feed rate (boards per minute) is slightly faster as the board only moves its width before processing. It does not have to travel the total distance across the table to the fence.

Cutting Specifications with Left Fixed Blade



CAPACITY (2R) TWO MOVER

Min/Max - Fixed to 1st mover	25-211mm (1" – 8.3" inch)
Min/Max - 1 st mover to 2 nd mover	40-226.5mm (1.5"-8.8" inch)

Technical Specifications

CAPACITY

Max cutting thickness (12" dia blade)*	70 mm (2.75")
Min board length	600 mm (23.6")
Min board length (w/optional short stock)	400 mm (15.7")
Feeding capacity	0 – 36M/min (120'/min)

*Max cutting thickness is restricted by height of top press rollers to maximum of 80mm regardless of diameter of saw blade. If the blade shoe is used, then the limit is 63mm

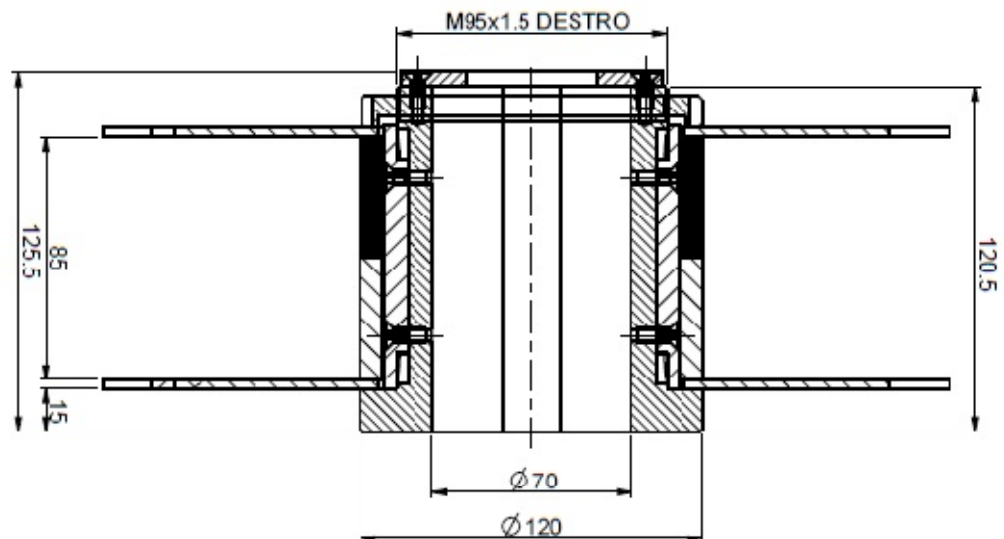
PROCESS TOOLING

Saw blade diameter range, min-max	250 mm-350 mm
Saw blade diameter included with machine	12" inch (300mm)
Mobile Saw blade bore, holes	75 mm nr, 2 keyways 6x24mm, 3.2k
Mobile Saw blades included	1pc per moving blade assembly
Fixed Saw blade bore, holes	95 nr, 2 keyways 6x20, 3.2k
Fixed Saw blades included	3pcs

FIXED POCKET SLEEVE OPTION INCLUDED

D, Bore diameter	70mm
D1, Tool sleeve diameter	95mm (with two keys 6x20mm)
L, Sleeve overall length	120.5mm
L1, Tool clamping length	85mm
L2, Face to end of arbor	105mm
Usable cutting area over chain*	69mm
Tool room setting stand	Included

* The usable cutting area is less than the total clamping area. The usable area is from the fixed pockets zero fixed blade to 15mm from the edge of the chain. The cutting area must always be within the chain area. The overall min/max blade cutting distance is reduced when the fixed pocket sleeve is used. The reduction is proportional to the fixed pocket sleeve.



Technical Specifications (continued)

UTILITIES	
Voltage	480V @ 60hz, 3-phase
Main motor power	50HP
Amperage	75 amps
Compressed air (clean & dry)	7 bar (100psi), 0.3348 CFM
Dust extraction	2500 CFM @ 1 port (250mm dia)
Weight	2000 kgs (4,400lbs)
Dimensions, H x W x L	175cm x 175cm x 173cm

Value Added Options Included

- Fixed pocket sleeve (Operator side), complete with spacer set and 2pc saw blade
- Motorized height adjustment of saw arbor
- Motorized height adjustment of press rollers
- Powered outfeed roller device

Kentwood AR Compact (16FT) Advantage Rip COMPACT

The AR Compact is a value oriented optimizing feeding solution for the small to medium sized rip saw. Utilizing heavy duty steel frame construction, the table is built for daily production requirements. Unique and factory leading software solutions makes its operation intuitive and highly efficient. The software is the same as used on the larger system featuring value and yield optimizations with a length consideration. The software is with web-based interfaces to allow connectivity remotely without the need of special software and/or proprietary computers.

This low maintenance system combined with quality service and support has established Stiles Machinery as the best in class solution provider for today's market place.

Kentwood Advantage Rip Compact Features

- Heavy duty steel frame table (16')
- Top press roller
- N-Depth Scanning for shape, width, and gross defect identification
- nScanRip software with reporting function
- Industrial touch screen interface

Kentwood AR Standards Include

- Value or Yield based Optimization
- Multi-point Width/Length Scanning Bar
- Ripsaw Command Interface
- Browser Based User Interface (no special office software)
- Native SQL Based Database
- Standard Order Import (XLS or CVS)
- Standard PDF Reporting

Modular Design Philosophy

The Advantage Rip (AR) series has been designed to grow with you as your production and optimization tasks increase.

From a basic system configuration tailored to entry-level production, to a high-performance system supporting advance defect scanning/optimizing, the AR series product lines offers a way to grow as you grow!

By utilizing the best in optimization software, user interface/connectivity, and hardware design the AR series allows you to grow, expand, and maintain your investment without starting over!

Value or Yield Based Optimization

The on-board optimizer supports both fixed and variable width optimization. The AR platform supports either movable blades (up to 4 or 6 depending on the model), with a single fixed pocket.

Rip Saw Command Interfaces

All AR systems provide native interfaces for CML and Kentwood movable blade rip saws. The AR units send the widths required by the specific board cutting pattern, as well as e-stop and fault detection. Additional interface options to other movable saws can be quoted separately.

Standard Software Features

All Advantage Rip systems are built on a common, full-featured, software base. Below are the standard features included with each Advantage Rip.

Browser Based User Interface

All AR units provide a full browser-based HMI interface. This allows multiple points of access by the user without the need to install custom software. Most devices (PCs, tablets, even phones) able to run a web-browser can access and use the AR1 optimizing software.

Native SQL Based Database

In addition, all AR units are built on an SQL-Lite database core using standard ODBC interfaces. This allows for external interfacing by customer systems to production data without the need for custom drivers or import/export software.

Standard Order Import

To simplify imports from spreadsheets the AR systems support remote importing (over the browser interface) of either XLS or CVS files. Several standard formats are included with the core software, and custom formats can be supported as options.

Standard PDF Reporting

The AR software uses a high-performance reporting/rendering engine with many standard reports incorporated. These include Order Yield Reports, Load Reports (incoming material), and Production Reports (footage, piece counts). Custom reports can be easily developed as options and are accessible as “drop ins” to the standard report interface.

Technical Specifications

working width, min-max	2”-18”
working length, min-max	24”-16’
working height, min-max	0.75”-3.9”
3D n-Depth	8 pcs
fence movement	6” inches
boards per minute	4-6 BPM
feed speed*	Ripsaw speed @ 120ft/min

Utility Requirements

voltage*	460 volts
rec. service req.**	TBA
compressed air (3/8”)	90 psi
weight, uncrated	TBA

* For estimating purposes only, balanced phase to phase and phase to ground.

** Recommendation only, always use local codes for sizing.

Optional Equipment and Services**Optional Software Modules****TBQ**

Since the AR platform is designed to be extendable and customizable, the following options can be quoted as part of a complete package.

Custom User Entry Screens

Often there is a need to gather additional production information for rip orders. The AR software core, since browser based, can easily be extended to support additional custom entry screens.

Examples are:

- a) Custom Load/Package Tracking
- b) Custom Grade Entry
- c) Custom Sorting/Bundling Definitions
- d) Downtime Reporting

Additional input/entry screens can be quoted on a per project basis as needed.

Custom Import/Export Support

The AR software includes standard import/export features and supports standard AR import and export formats. If custom data formats need to be supported, these can be quoted on a case-by-case basis.

Custom Reports

In addition to the standard reports provided, customized reports can be developed for specific use cases. Additional reports will be quoted per request.