2013 STREAM B1/5.5 Edgebander

N0000001 SINGLE-SIDED EDGE BANDING MACHINE STREAM B1/5.5

TECHNICAL DATA

Description	Um	Min	Max
Panel overhang (fixed)	mm	35	
Panel thickness	mm	10	60
Chain advance speed	meters / min	10 – 25 Variable	
Work table height	mm	950	
Panel working width	mm	100 - 3200	
Panel length	mm	150 - 3200	

NOTE : Maximum machine capabilities (work speed, edge thickness, adjusting ranges) are conditioned by the capabilities of the single units installed.

BASE MACHINE STANDARD EQUIPMENT

Top Belt pressure beam with Double "V" profile
Electronic pressure beam height adjustment
Inverter for track speed adjustment
Separate Inverter on every work unit
PC operator interface; Windows XP
Statistic software with export system on Excel file. Infinite Log file
Base frame dust extraction

INPUT/OUTPUT

Feeder guide adjustable according to the machining edge being used, with mechanical digital display.

BASE

Base made of electro-welded elements stabilised to form a single, monolithic, high-rigidity structure.
It rests on the ground on a suitable number of cross-bars, each of which is fitted with adjustable feet and set up to be anchored to the floor.
Auxiliary suction and dust collection system along the base, with D.160 suction mouth on one side of the machine.

DRIVE CHAIN

The drive chain comprises a high precision, minimum distortion chain (50.8 mm links). Free, straight advance is guaranteed by the presence of guides, which are round on one side and flat on the other, both tempered and
rectified, housing slide blocks made of techno-polymer and self-lubricating material .
The panel rests on high grip, rectified, stain-proof rubber tables.
The speed of the drive chain is continuously adjustable from 10 to 25 m/min. by INVERTER controlled directly from the NC, with rapid braking function.
The drive pinions are made of heat tempered, high-strength steel.

TOP BELT PRESSURE

The top presser comprises a rubber belt with a stain-proof coating. The thrust exercised on the panel is provided by springs housed on technopolymer connecting rods. The whole assembly is fitted on a extruded aluminium structure, whose section guarantees high rigidity .

SOUND-PROOF CABIN FOR EDGEBANDING SECTION

All the units fitted with rotating tools are located inside cabins coated with sound-proofing material.
During machining, the units can be viewed through wide, transparent polycarbonate windows.
If the doors are opened at unauthorised times this will trigger an emergency and shut down the machine.
Internal lighting provided by anti-glare neon lights.
Suction hoods of each unit are connected through pipes to individual exits placed in the upper part of the cabin.

MECHANICAL PANEL SPACER FOR B1
Device allowing manual introduction of panels only when the distance between
panels is enough for working.
Distance between panels is set up on NC.

AUTOMATIC TRACK LUBRICATION B1

PANEL PIECE SUPPORT
Side piece support supporting the panels as they pass through the machine.
Fixed supports, nr. 1 manually adjustable roller bar.

PC FLAT SCREEN NUMERICAL CONTROL COLOR GRAPHICS
Multiple axis numerical control with PC interface for management of single edgebanding machines or complete
edgebanding lines.

Main SOFTWARE characteristics:
Windows XP Professional Operating System
SINTRA machine control software, based on Windows XP like interface
Electronic axes positioning (machine set-up)
Electronic feed chain speed adjustment
Electronic pressure height adjustment according to panel thickness
Automatic management of edge banding coils exchange device.
Management of machining list
Automatic management of coil magazine by codes
Cascade type motor start-up
Management of diagnostics
Video capable

CE SAFETY FEATURES
The machine is manufactured to comply with EC safety regulations.

N0000015 NC Y AXIS FOR FEEDER GUIDE
The kit includes motorised movement of the machine feeder guide and relevant NC management

N0000136 SPRAYING LIQUID APPLICATION UNIT
Device for the application of liquid using nozzles located above and below the panel.
It can be used with the following liquid types:
- Anti-adhesive liquid
- Anti-static liquid
- Cleaning liquid

Manual adjustment of nozzle direction.

N0001294 ANTIADHESIVE LIQUID
Avoids the adherence of any glue waste on the panel surfaces.

N0000669 PRE-MILLING UNIT RT20
Milling unit comprising two vertical axis motors with timed pneumatic drive. The unit can be adjusted manually according to the panel overhang, by digital position indicator.
Maximum workpiece thickness with standard tool : 40 mm. For panels with thickness up to 60 mm, it is necessary to use diamond tool with height
63 mm, code N0000336.

TECHNICAL DATA

Description	Um	Min	Max
Tool rotation speed	RPM	9000	
Motor size	kW	3,5 + 3,5	
Shaft (diameter x length)	mm	30 x 50	
Tool dimensions (diameter x height x bore)	mm	125 x 43 x 30	
Pneumatic drive stroke	mm	10	
2 dust hoods	mm	80	
Inverter		Included	
Tools provided		DIA included	

N0000336 SUPPLEMENT PAIR DIAMOND MILLING CUTTERS FOR H=60 ON RT UNIT
Pair of diamond milling cutters 125x63x30 to replace the standard ones 125x43x30.

N0000469 GLUING UNIT SP20
Gluing unit used to glue:
- straight edges in coils: in melamine resin, ABS, PVC, PP, veneer
- edges in strips: solid wood, HPL

Use of EVA-based thermoplastic adhesives.
The glue is spread on the edge of the panel using a knurled roller.

Main characteristics:
- HighMelt patented system with separated glue and pot applications.
- Patented system for quick frontal extraction of glue pot, by rotating device.
- Patented High-Melt pre-melting device
- Shafts ans reducers for the top handling
- Pair of infra-red lamps, top and bottom, used to heat the panel
- Glue pot and head teflon coated.
- Guillotine type batching device for glue roller, accessible from the operator side
- Copier to optimize the glue quantity spread on the panel
- Sensor to detect the glue level inside the bowl
- Automatic start-up of the glue spreader roller on reaching optimum working temperature
- Automatic disabling of the glue spreader roller on stoppage of the machine.
- Glue spreader roller rotation speed electronically synchronised with the feed chain speed
- Granule tank with vertical magazine fitted directly on the pre-melting device
- Edge presence detection device (using photocell)
- Independent edge insertion/clamping device for each position (only with codes N0000682, N0000683, N0000804).
- Pin rollers driving the wooden strips (up to 20 mm)
- Strip magazine (thickness up to 20 mm) with pre-loading side pusher device.
- Suction cup strip loading device.
- Horizontal edge magazine for one coil
- Ability to change edge automatically (NC managed) (only with codes N0000682, N0000683, N0000804).
- End of roll indicator light, with stoppage of movement if a panel is signalled and there is no edge (only with codes N0000682, N0000683, N0000804).
- Horizontal cutter to cut material in rolls: this is suitable for edge materials in: melamine resin, PVC, ABS, PP, veneer up to 3 mm thickness
- NC Y axis for presser section: The kit includes motorised edge banding strip presser section drive and relative NC management

The pressing area includes:
- No. 1 presser roller D.150 driven by inverter
- No. 6 idle presser rollers D.65
- Nr.1 additional panel presser device

TECHNICAL DATA

Description	Um	Min	Max
Edge thickness in malamine and plastic	mm	0,3	3
Maximum cutting section cutter	mm		135 (3 x 45)*
Wooden edge thickness	mm		20
Panel thickness	mm	10	60
Edge height	mm	15	65
Edge in coils length	mm	150	
Edge in strips length	mm	200	
Solid wood length for B1 MDS	mm		1950
Glue pot capacity	kg		1,3
Tank capacity	kg		7
Spreading capacity	Kg/h		7
Coil diameter	mm		800

*Maximum cutting section is guaranteed on PVC edges, for different edge materials, this value could be lower.

N0000683 6 POSITIONS EDGE MAGAZINE FOR SP10, SP20, SP30, SP40

Six position container for rolls of edge banding strip.
The rolls are supported by a cradle of rollers, so that they do not require any other locking devices: this makes them extremely quick to replace.
Automatic edge changement, NC managed
Edge banding strip presence detection device (using photocell), also when the one working is finishing and the other is the same edge type.
Positioning of photocells for edge detecting device and for edge magazine can control a maximum panel length of 2700 mm.
To obtain the control of the edge roll ending on a panel longer than 2700 mm it is necessary to place the edge magazine at a right distance. The distance (if different from the standard 2700) must be comunicated when ordering the machine.

N0000367 END-TRIMMING UNIT IT90-S

Edge trimming unit complete with 2 motors, for edge banding strips with a thickness of up to 3 mm.
Motors can be inclined on the vertical axis by between 0° and 25° with automatic rotation.
Device to move the trimmer away rapidly during operation.
Micrometer adjustment of side copiers.
Automatic disabling of the unit when motors are stopped.
Central lubrication of slide guides.
Pneumatic drive of two end-trimming units.

TECHNICAL DATA

Description	Um	Min	Max
Speed	Rpm	12,000	
Motor size	kW	0.3 + 0.3	
Feed chain speed	m/min		28
Edge thickness	mm	0.3	3
Panel thickness	mm	10	60
Interval between 2 successive panels	mm	350	
Inverter	Included		
Minimum panel overhang	mm	30	
Tools provided	Widia included		

N0001150 FINE MILLING UNIT RF40

Unit comprising 2 independent motors, which are complete with horizontal and vertical copiers and swings on slides.
Vertical movement of the top unit associated with the belt presser.
Continuous automatic adjustment of tool position with respect to the material using a DC motor applied

to the group drive.
The position is controlled directly by the machine control system.
In this way it is possible to use tools with a MULTIPROFILE on the unit, allowing the profile/shape to be changed without having to change the tool.
Automatic pneumatic disabling of the unit from the control panel.

TECHNICAL DATA

Description	**Um**	**Min**	**Max**
Speed	Rpm	12.000	
Motor size	kW	0,65 + 0,65	
Panel thickness	mm	10	60
Shaft (diameter x length)	mm	16 x 20	
Inverter	Included		
Tools provided	Yes, multi-profile widia cutter Bevel *25°,*		

N0001156 FINE MILLING UNIT MOTORS 2 KW RF10

N0001178 PAIR OF WIDIA CUTTERS FOR RF30/RF40 BEVEL 25° - R=1/2/3

N0001004 GLUE SCRAPER RC20
It allows to remove any glue excess from the flat surfaces of the panel close to the edges.
The unit is equipped with 3+3 vertical copiers with bearings .
Equipped with suction hoods.
Complete with spraying device for tool cleaning.
Automatic unit disabling.

N0000171 SUPERIMPOSED OSCILLATING BUFFERS UNIT SZ30
The unit includes 2 motors.
The buffer's position is adjusted by an exclusive 3D recording device by means of a ball joint.
The motors are fitted on a single column and are axially offset from one another to allow pneumatic insertion and removal of the brushes and the pneumatic swing motion that optimises wear on the brushes themselves.
Vertical movement of the top motor is coupled to the presser to provide automatic adjustment according to the thickness of the panel.
The unit is supplied complete with fabric brushes.
Automatic disabling of the unit when motors are stopped.

TECHNICAL DATA

Description	**Um**	**Min**	**Max**
Brush rotation speed	Rpm	1,400	
Motor size	Kw	0,37 + 0,37	
Shaft (diameter x length)	mm	20 x 40	
Brush dimensions (diameter x width)	mm	150 x 40	

N0000300 AIR CONDITIONING SYSTEM FOR B1

N0000225 VOLTAGE OTHER THAN 380V B1