

Headquarter Hall in Tyrol

A - 6060 Hall in Tirol · KR-Felder-Str. 1 · Austria
Tel + 43 (0)5223 5850 0 · Fax + 43 (0)5223 585066 0
www.felder-group.com · info@felder-group.com

FORMAT

Commission:		Hall	15/03/2013
Your offer number:		Your reference:	
Machine Type:	PER 710E	Our reference:	1KC

OFFER

Dear Mr. Happ,

We thank you for your inquiry and have pleasure in quoting the following machine:

FORMAT-4 EDGEBANDING MACHINE perfect 710 E

Maximum ease of use and highest precision with unrivalled value for money.



Image may be pictured with additional options.

Product advantages

An edgebanding machine from FORMAT-4, ensuring the success of your company

Our vast experience means that you can be sure of your investment!

For more than 55 years, we have committed ourselves to developing, producing and selling the highest quality woodworking machines. Today, Felder-Group machines are amongst the best selling in the world.



Format-4 - the first choice for those looking to increase production and revenue.

We will work with you on an individual basis to establish a revenue-orientated solution to improve production. We will integrate your current production processes into a new, optimised concept. You can then use the suggestions we put forward to develop your own ideas and plans on how you will make your company the most profitable in your market.



We can simulate your operation, an indispensable decision-making reassurance for you.

Come and have a look at the most interesting production package in one of our exhibition centres. We will simulate your operation and production process with the Format-4 woodworking machines. This will help you to make a decision that will help your operation for many years to come.



Format-4, the right decision. A perfect combination of durable quality and precision.

Format-4 machinery is one of Austria's top products. Modern production processes and machinery as well as continuous quality assurance checks, guarantee the quality, precision and reliability of your new Format-4.



Standard Equipment

perfect 710 machine centre frame:

The machine frame of the perfect 710 edgebander is made of thick-walled, arc-welded steel. Ribbing within the frame ensures high stability.



e-motion control:

- With adjustable 10.4" touch screen control panel
- Unlimited data memory for user-defined edge banding programs
- Fine adjustment of the distance parameters
- Simple and self-explanatory display of the units and their functions
- Aggregate selection, enable and disable function, exact fine adjustment of the motor positionable aggregates (accuracy of up to 1/100 mm) all from the main control panel
- Glue temperature setting, automatic temperature reduction of the glue whilst in stand by mode
- Choice of contact pressure of the pressure rollers
- Optimisation of the edge overhang when precutting at both the front and back
- Plain text error messages
- Maintenance schedule, Odometer for total metres of material used
- Two step safety control of the machine access doors, guarantees quick changeover times with the highest process reliability



Pneumatic perfect 710:

Bus controlled central pneumatic valve unit. Optimised maintenance unit with pressure sensor. Extra air supply control and pressure build-up valve.

perfect 710 chain feeder:

Feed rate	12 m/min
Drive motor	1,5 kW (S6)
Precision runner and guiding surface	
Minimum workpiece length	140 mm
Min. workpiece width	60 mm
Segmented, rubber covered support pads with quick change system	



Upper pressure bar perfect 710:

Pressure beam made of welded torsionally resistant steel. Adjustable workpiece height from 8 to 60 mm motor controlled with the e-motion control. Grooved, double-row staggered double-acting rollers distribute pressure evenly.



perfect 710 extendable frame:

Pull out workpiece support extendable to 850 mm with rollers to assist in the processing of larger workpieces.



Rotary tape coil unit for tape coils 0.4-3 mm:

Rotary tape coil unit supported by ball bearings. Rotary plate diameter 770 mm. Edge band thickness between 0.4-3 mm.

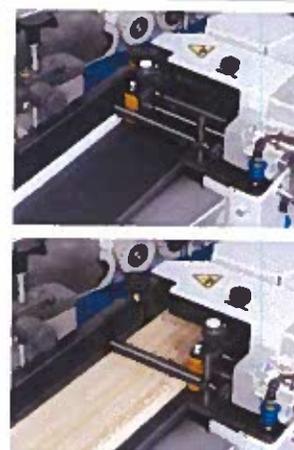


Edge feed for coiled and strip edges:

A motor driven rubber feed roller guides the coiled material on to the workpiece. The roller ensures a synchronised feed of both the edge band and workpiece and ensures a minimum amount of unnecessary edge overhang and avoids glue spilling over the workpiece edge.

When processing strip material, the rubber roller can be quickly replaced with a spike roller without the need for tools. The strip edge magazine has a capacity of 120 mm. An infra-red edge sensor registers that the machine is ready to go as soon as the edge material is loaded.

Edging thickness 0.4 to 10.0 mm



Guillotine scissors for tape coil with thickness between 0.4 to 3 mm:

Workpiece feed and feed guide:

The surface on which the panel is fed in to the machine, is equipped with rollers which protect delicate panels. The solid infeed surface has a total length of 700 mm. The depth of cut of the premilling unit is electronically position controlled and can be set between 0-3 mm from the control panel with a readout on the display screen.



1.1 kW Premilling unit with 2 diamond cutters:

Premilling unit with entry control diamond cutters, 12000 rpm, 1.1 kW (1.5 hp), max depth of cut 3 mm, max workpiece height 60 mm, premilling unit with diamond cutters Z2+2, D-60 x 64 mm; ensures a perfectly square edged workpiece free of chips.

Teflon coated glue unit for 1.5 kg of EVA or PUR granulate:

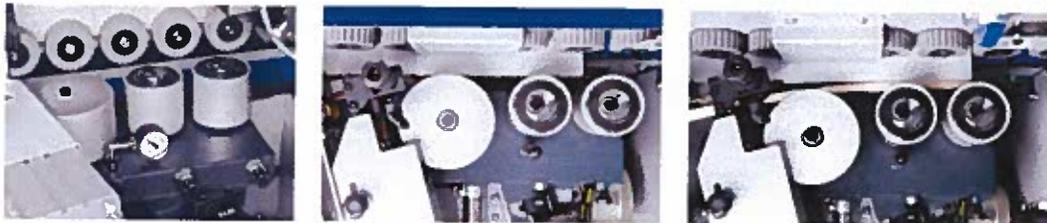
Ready for operation after only 8 minutes heat up time. The tool free quick change system, guarantees quick cleaning and changeover of different glues or glue colour. The synchronised fine adjustable glue roller ensures the right application of glue. Also suitable for edge banding with PUR glue when following the processing guidelines.



e-motion pressure roller unit application pneumatically controlled:

1 motor driven and 2 conical rollers make up the pressure unit. Depending on the edge band material being used, the amount of pressure can be set from light (solid strip material) to strong (coiled material).

The entry control of the unit protects the ends of workpieces from damage. The motor driven roller ensures a synchronised feed of the workpiece and edge and ensures that there a minimum amount of edge overhang and glue spillage on both sides of the panel. The entry and exit point of the the glue roller as well as the amount of pressure from the pressure rollers can be set from the control panel using the e-motion control.



e-motion end trimming unit with 2 high frequency motor:

0.5 kW (0.7 hp), 12000 rpm, HW-saw blade/24, D-100 x 20 x 3.2 mm, pneumatically controlled tilt of 0°-15° adjustable from the control panel



Upper combination trimming unit e-motion, flush and radius trimming unit position controlled:

1 high-frequency motor, 0.75 kW (1 HP); 12000 rpm. The motor-driven 2-axis position control of both height and depth ensures 100 % repeatability and makes a fine adjustment accurate to 1/100 mm possible. A change in the trimming profile can be done from the control panel, without having to stop the production.



Lower combination trimming unit e-motion, flush and radius trimming unit position controlled:

1 high-frequency motor, 0.75 kW (1 HP); 12000 rpm. The motor-driven 2-axis position control of both height and depth ensures 100% repeatability and makes a fine adjustment accurate to 1/100 mm possible. A change in the trimming profile can be done from the control panel, without having to stop the production.



Pneumatic release function of the combination trimming unit:

The control pneumatically removes the unit from the working area. Disabling of the aggregates without stopping the production.

perfect 710 machine packaging:

perfect 608/710 tools:

Operating manual perfect 608/710 English:

Requirements for machine transport into the customer's workshop:

For unloading the lorry either a crane with carry straps with a capacity of 5 t or a fork lift with 1500 mm forks and lifting capability of 2.5 t must be made available. The unloading assistance (crane or fork lift) must be available at the agreed delivery time, on the first day of installation.

Assistance by the customer in transporting the machine into the workshop:

The customer must provide two employees to assist with the transport of the machine from the lorry to the installation site of the machine. Any doorways or gangways on the way to the installation site must be at least 1,200 mm wide and 2,000 mm high. The installation site of the machine must be concrete or equally stable industrial flooring.

Machine foundation preparation by the customer:

A machine foundation must be prepared at the installation site as in the layout in the Appendix and with the following specifications: level foundation; min. concrete quality C20/25 tension-compression resistant.

Customer preparation of pressurised air connection:

A pressurised air connection as per the attached layout with the following specifications must be made available at the installation site: air quality as per ISP 8573-1: permanent minimum pressure of 7 bar, 1/2" connection, compressed air requirement 250 NL/min, compressed air hose must have a minimum internal diameter of 10 mm.



Customer preparation of power connection 3x 400 V:

A power connection as per the attached layout with the following specifications must be made available at the installation site: Operating voltage 3x 400 V +/- 5%; 50 Hz; connection current max approx. 11 kW; recommended fuse of 32A. In the event of frequent voltage fluctuations a stabilisor is recommended. A trained electrician must carry out the connection of the machine on the installation date.

Customer preparation of extraction:

An extraction connection as per the attached layout with the following specifications must be made available at the installation site: extraction connection according to the layout; extraction performance of 3000 m³/h; air speed of 20 m/sec; pressure loss of 300 Pa; the supplier must connect the extractor on the day of delivery.



Chosen specification

Number @262

1

Electric 3x 230 V 60 Hz - CE - total power consumption 11.0 kW

Number 11

1

2-axis, motor-driven, position-controlled radius trimming unit incl. pneumatic reverse function
perfect 710 e-motion upper and lower radius scrapers for the processing of 2 mm plastic edge material. Positioning of both the height and radius is motor driven and accurate to 1/100 mm and controlled from the control panel. Enabling and disabling is done pneumatically without having to stop the machine. Delicate touch of the sensor rollers; a separate shaving collection box of the radius scraper removal protects the extraction from damage.



Number 20

1

Glue scraping unit, pneumatically controlled
Upper and lower glue scrapers pneumatically controlled. Removes any glue residue. A compressed air blast nozzle and extraction ensures trouble free production. Delicate touch because of a large sensor roller.



Number 30

1

Buffing unit with 2 motors
Upper and lower buffing unit ensures a perfect finish on the edge radius and removes any colour irregularities.



Number 32

1

Spraying unit for cleaning fluids situated before the polishing units
The cleaning fluid cleans the surface of the workpieces and edges and prevents the buffing pads from becoming blocked up with glue too quickly.



Number 42

1

Spraying unit for separation solution positioned at the front of the machine
(PUR-Glue)

The separation solution prevents glue from sticking to the workpiece surface. The separation solution is particularly important when using PUR-glue and ensures a high quality finish without post processing.



Number 43

1

Infrared heat lamp for pre-heating board edges
The infra-red lamp warms the edge of the panel. The workpiece edge therefore does not cool the applied glue too quickly. This ensures optimal requirements for edge banding of the highest quality. A sensor automatically switches the lamp off between workpieces.



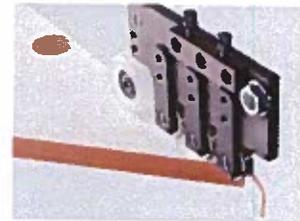
Number 51

1

Multi-functional trimming unit with vertical reference rollers for the processing of workpieces with hinge bores

Multiple sensor rollers for the processing of workpieces with hinge bores.

Makes the processing of Nesting workpieces possible

**Number 54**

1

Horizontal multiple reference rollers instead of scanning head combination milling cutter unit for sensitive edge materials

For a nice finish of delicate panels.

**Number 60**

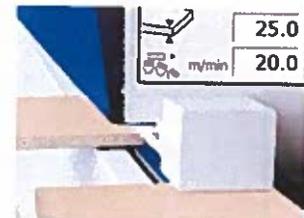
1

Chain feeder with a speed of 12 and 20 m/in and rubber grip pads for maximum grip on the workpiece (only available with Pos. 75)

Feed rate 12/20 feet/min automatic central lubrication of the chain feeder and rubber grip pads Precision runner and guiding surface Drive motor 2,2 kW (S1) Minimum workpiece length 140 mm Minimum work piece width 70 mm Segmented, rubber covered support pads with quick change system

Premilling unit with immersed controlled diamond cutters. speed 12000 rpm /1.5 kW, (2hp), max depth of cut 3mm, max. workpiece height 60 mm, premilling cutter with Z2+2,D-60 x 64mm diamond cutting, provides an angled edge and an edge with no chip out. Cushioning for end cutting unit

Limitations at a speed of 20 m/min: edging thickness: 3 mm, panel thickness: 25 mm, no corner rounding

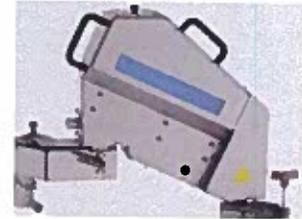


Number 66

1

Premelter for glue granulate, 3.5 kg capacity; 0.4 kg glue pot with glue level sensor and quick change system, heated glue rollers

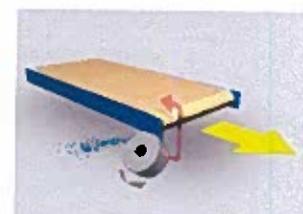
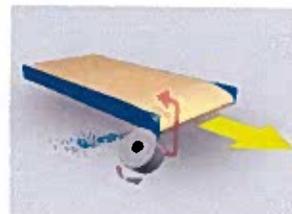
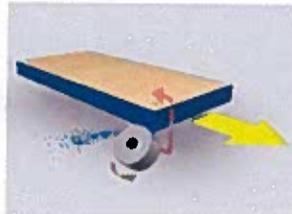
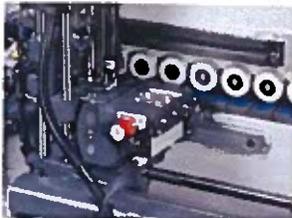
Glue aggregate for 0.4 kg of EVA granulate with glue level sensor for use with the premelting unit; can be used after only 10 minutes warm up time. The teflon coating and the tool free quick change system guarantees quick cleaning and change over times when changing the glue or colour of the glue. The synchronised, fine adjustable and heated infeed roller ensures the right application amount of glue. Premelting unit for EVA glue granulate, capacity of 3.5 kg The premelting unit with a maximum capacity of granulate of 3.5 kg is situated above the gluepot. The glue level sensor on the gluepot gives a signal to the premelter that more glue is required. The granulate is then pressed through a heavy duty heating plate and flows as liquid glue into the gluepot. The premelter ensures that there is always enough glue available and that there is no down time waiting for the glue to heat up. The colour and quality of the glue is also not lost through overheating of the glue..

**Number 69**

1

Corner rounding unit for soft- and post forming pieces for processing edges of between 0.4 and 3.0 mm in thickness and 10-60 mm in height

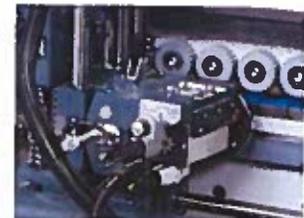
Edge processing unit for post and soft form profiles Controlled corner rounding unit for the processing of front edges. Piece Width 10-60 mm Tape thickness: 0,4-3 mm Diamond miller with 4 blades Copy roller with starting clutch to avoid damage when being used Setting of the edge thickness via digital clock; suitable for straight workpieces as well as post- and soft forming profiles. Min. workpiece length 270 mm (at 19 mm) height Restrictions with loose central sections and on post- and soft forming workpieces with a large radius. Solid wood edges, extremely thin melamine/foil edges or thin surface materials can be used sometimes.

**Number 71**

1

Motor adjustment and positioning of corner-rounding cutters

The positioning of the corner rounding unit automatically sets to an accuracy of 1/100 mm to the edge height.



Number 229

1

Container packing

Number 231

1

User manual English

Amount	USD 107,790.00
Felder Special Discount	USD -9,687.00
Total amount	USD 98,103.00

Payment conditions

Total price:	FOB New Castle, DE excl. tax
Payment	10% Deposit, Subject to lease
Shipment	To Be Determined
Delivery time	To Be Determined
Validity of the offer:	28/03/2013
Warranty	See Terms & Conditions

We thank you for your interest and trust this quotation will meet your satisfaction.

The FORMAT-4 - TEAM would be pleased to assist you with any further information you may require.

With kind regards,

FORMAT-4

Quality Machinery and Tools for Woodworking

TERMS AND CONDITIONS OF TRADE**I. Contract**

- (1) The terms and conditions of trade apply to all present and future business relations.
- (2) Deviating, opposing or additional terms and conditions of trade from the customer, shall – even when acknowledged – not be part of the contract, unless they have written approval.
- (3) By placing an order the customer enters a binding agreement to purchase the good or service. Finalisation of the order will be confirmed by the seller within 2 weeks through an order confirmation or alternatively by the carrying out of the service. 2 weeks is based on the day on which the confirmation is posted, not received.

II. Prices

- (1) All pricing is ex-works, A 6060 Hall in Tyrol.
- (2) Unless otherwise stated, the total amount is shown as a brutto amount before relevant sales tax.
- (3) The prices do not include transport or shipping costs.

III. Delivery

- (1) Unless otherwise stated, all deliveries are ex-works, A 6060 Hall in Tyrol, at the risk and expense of the customer.
- (2) Should the goods be sent to or installed for the customer at their request, the customer must also carry the risk of accidental loss or damage, regardless of the origin of the goods or who carries the transportation costs.
- (3) If the transport and insurance of the goods is included in the order, the risk of accidental loss or damage of the goods is transferred with the handover of the goods.
- (4) If the customer does not collect or accept delivery of the goods within the stipulated time period nor following the additional respite, whether expressed or not, the seller can withdraw from the contract and claim for compensation. The same applies to late payment of the agreed final amount.
- (5) The seller is not required to take back packaging.

IV. Delivery schedule, force majeure, strike, lockout, suppliers

- (1) Delivery schedules are approximations.
- (2) Delivery times can only be kept to providing complete and timely deliveries from our suppliers. Unforeseeable interruptions to normal business proceedings of the seller or of their suppliers which are outside of their control such as lockouts, force majeure which are due to unforeseen or unavoidable circumstances may delay the delivery by an undetermined amount of time.
- (3) Post contract agreements, particularly when concerning technical details may influence the delivery time.
- (4) In the event of delivery delays due to circumstances outside the control of the seller, the buyer is only entitled to withdraw from the contract if they submit a written cancellation once the agreed delivery deadline has passed and the delivery does not take place within the additional respite, which starts on the day the written cancellation is received. The buyer is not entitled to claim for compensation arising from such a cancellation.
- (5) The seller is only liable for damages due to delays in delivery resulting from intention or gross negligence.
- (6) Should the delivery of the goods be made impossible as mentioned in paragraph (2) or excessively difficult, the seller must inform the buyer; In doing so the seller is exempt from a requirement to deliver the goods.

V. Payment

- (1) Unless otherwise stated, the total amount including any additional costs, is to be paid in full within a period of no more than 12 days from the date of the invoice.
- (2) The payment is deemed on time or late according to the date it is received by the seller.
- (3) Bank orders and cheques shall only be accepted on agreement of the seller whereby any applicable bank charges must be carried by the buyer.
- (4) The seller shall charge registered businesses 1,5% interest per month in the event of payment arrears. The seller reserves the right to charge a higher rate.
- (5) The seller shall charge private customers 5% per month above the base interest rate in the event of payment arrears.
- (6) The buyer may only challenge the claims of the seller when the buyers case is standfast or legal proof is presented. The same applies to the lien right of the buyer. Furthermore the right of lien must be justified according to the terms and conditions of the sales agreement.
- (7) In the event that the payment terms are not honoured or the customer files for bankruptcy, the seller is justified to coll in all open payments with immediate effect.
- (8) In the event that the customer owes on multiple invoices or payments the seller can stipulate that the older open amounts must first be settled before any others can be settled.
- (9) In the event of late payment, the seller is permitted to charge a notice fee (max. Euro 25,-) per notice as well as all charges incurred in the event that a legal action is taken.

VI. Warranty

- (1) The seller is entitled to choose the method by which any faults in the goods are corrected by either repair work, replacement or reduction in the selling price. Claims for compensation are not possible.
- (2) The customer must check the machine upon receiving it and immediately report any faults in writing.
- (3) If the buyer is the end user, he has the right to choose whether the correction of the defect is by means of repair or replacement. The seller is however entitled to decline the means of correction, should it involve disproportionate costs and the alternate means of correction does not result in significant disadvantages for the end user. Compensation claims are not possible.
- (4) The buyer is required to give the seller a reasonable period of time to correct the defect; otherwise the right to warranty is deemed void. Should the correction of the defect not be completed within the legally stipulated time period, the customer can withdraw from the contract or claim for a reduction in the sales price. Small defects do not give the customer the right to withdraw from the contract.
- (5) The end user must submit a written report of obvious faults within the 10 day time period which commences once the goods have been received. Otherwise the right to having the faults corrected is waived.
- (6) Faults, that are not clearly recognisable during an in depth check, must immediately be reported as per paragraph 5, once they have been identified.
- (7) Warranty claims due to non obvious faults are no longer valid, if they are not submitted to the seller within 6 weeks following the hand over of goods, regardless of whether the goods have been commissioned or not.
- (8) For registered businesses, the right to warranty claims lapses one year after the delivery of the good. For consumers, the right to warranty claims lapses two years after the delivery of the good.
- (9) Instruction manuals supplied by the seller with the machinery must be rigorously followed by the operator. The seller cannot be held responsible to any claim resulting from the instruction manuals not being followed.
- (10) The conditions to which the seller has committed to supplying the goods or service are to be taken only from the agreed contract and not from price lists, advertising

literature or catalogues. The customer does not receive a guarantee which is legally binding.

- (11) For private end users in the EU- and EEA- area the warranty for used machines is 1 year. There is no guarantee nor warranty for third party machines in an exchange. For professional end users in the EU- and EEA- region there is no warranty nor guarantee.

VII. Usage compensation of the seller

Should the buyer return a good due to breach or withdrawal from the contract, the seller has the right to compensation for the use of the good as well as processing fees. This compensation is calculated on the visual and technical condition of the returned good. The usage compensation will amount to a minimum of 30% of the net purchase price of the used good as well as a usage fee of 4% of the total purchase price per calendar month after invoicing.

VIII. Liability

The liability of the legal representatives, vicarious agents and employees of the seller vis-à-vis the customer are exempted except in the event of intention or gross negligence.

IX. Reservation of proprietary rights

- (1) The good remains the property of the seller up until the complete payment is made according to the terms and conditions.
- (2) In the event of resale to a third party prior to the settlement of all open amounts, the open amounts are transferred to the third party. The customer is required to inform the seller of this transfer in writing.
- (3) In the event of intervention by third parties, in particular the repossession of the good, the buyer must inform the seller immediately in writing as well as making the third party aware of the right of ownership. The customer must foot all costs required to reverse the repossession and return the goods.
- (4) As long as the reservation of proprietary rights exists, rental, disposal, pawning or any other form of transfer of the sales good including any modification is not permitted without the expressed written permission of the seller.
- (5) Throughout the reservation of proprietary rights the customer is entitled to the possession and use of the goods.
- (6) In the event that paragraphs 1–5 are not followed the seller is entitled to withdraw from the contract.

X. Withdrawal

- (1) Regardless of other legal and contractual reasons the seller is entitled to withdraw from the contract, in the event that the buyer has made false claims regarding their credit rating, withholds payment or instalments, files for bankruptcy or the worsening of the economic conditions to the extent that the seller can no longer be expected to meet the terms of the agreement.
- (2) The seller is entitled to withdraw from the contract, in the event that conditions arise following the sales agreement that make the delivery impossible or economically unviable.
- (3) The purchaser is entitled to withdraw from the contract within 5 days. The withdrawal must be submitted in writing, either by fax or electronically. In the event of such a cancellation the seller is entitled to a cancellation fee of 30 % of the sale value incl. VAT.

XI. Place of performance and court of jurisdiction

- (1) In the event of legal disputes arising from this contract, the responsible court of jurisdiction is that of A-6060 Hall in Tyrol. A-6060 Hall in Tyrol shall be the court of jurisdiction for both sides of the dispute.
- (2) The legal relationship is subject to Austrian law. Cross references to foreign law do not apply.

XII. Other

- (1) Changes and additions must be in written form in order to be valid.
- (2) The requirement of changes in writing and additions can in turn only be annulled in writing.
- (3) In the event that a FELDER – Partner Contract exists, its terms and conditions overrule these general terms and conditions.
- (4) The seller is entitled to transfer various rights and obligations, including those stipulated in these terms and conditions to an authorised contract dealer, thereby releasing the seller from any obligations. In doing so the place of performance and court of jurisdiction are also transferred to that of the contract dealer. The customer has forthwith been informed of this and hereby agrees.
- (5) The nullity or ineffectiveness of individual terms does not influence the applicability of other terms.
- (6) In the event that individual terms stipulated by this agreement are not applicable, they should be adjusted to represent in the allowable context of this agreement.
- (7) If the good is ordered by electronic means, the seller will immediately confirm the receipt of the order. The confirmation of the receipt of the order does not represent a binding acceptance of the order. The confirmation of the receipt of the order may be combined with the acceptance of the order. In addition following an order by electronic means from the user, the contract text from the seller is saved and can be requested to be sent alongside the general terms and conditions by e-mail.
- (8) The FELDER KG Warranty terms and conditions can be found in the relevant operating manual as well as on the FELDER KG internet site www.felder-group.com.

XIII. Special terms and conditions for consumers according to the customer protection act.

- (1) Delivery charges: The delivery charges or transport charges are to be born by the buyer.
- (2) The contract terms are subject to Austrian law.
- (3) Rights of end users to withdraw from the contract in the event of a distance selling contract.
 - (3.1) The user has the right to revoke the purchase agreement with the seller within two weeks of receiving the goods. The revocation does not need to contain a reasoning and can be confirmed in writing or by returning the good to the seller; Returning of the goods is deemed to meet the required 2 weeks, if the goods are dispatched within the required time period.
 - (3.2) By executing their right to revoke, the user is required to return the good. The cost of returning the good in the event that the sale is revoked must be born by the buyer. In the event that the delivered good does not match the ordered good, the return costs must be born by the seller.
 - (3.3) The consumer is hereby informed that they are accountable for any devaluation of the good through its regular use. The devaluation caused by the mere testing of the goods and resulting in the fact that the good can no longer be sold as 'new' must be covered by the consumer.
 - (3.4) The right to revoke the contract does not apply to the delivery of machines that have been built to specification for the user or in the event that due to their nature the machine is not suitable to be returned. A machine is deemed as being built to specification when the machine does not feature in the valid program range catalogue.