

**Ligmatech
Panel Return Conveyor,
Model ZHR-01
(for machines up to 9.6 meters)**

The return conveyor, Model ZHR-01 makes it possible to operate a single-sided through-feed edgebanding machine with only one person.

After each workpiece exits the edgebanding machine, a roller conveyor takes it over. When the trailing edge of a workpiece exits the processing machine, a cross transfer grid picks up the panel, transfers it across and lowers it onto a second roller conveyor. The second roller conveyor feeds each workpiece towards the infeed of the processing machine. A subsequent belt conveyor transfers the workpiece to a non-driven roller conveyor at the infeed of the processing machine.

All workpieces are transferred and returned without being turned.

The working height of the second roller conveyor is 60 mm below the level of the first roller conveyor.

Panel Specifications

length*	300 mm to 2500 mm	11-3/4" to 98-3/8"
width	50 mm to 1450 mm	2" to 57"
thickness	8 mm to 60 mm	5/16" to 2-3/8"

*Length is defined as the side of the part being edge banded on any given pass.

Product Gapping Specifications

Machine Operating Speed	Required Gap Between Parts
10 m/min (33 fpm)	500 mm (19-3/4")
15 m/min (49 fpm)	750 mm (29-1/2")
20 m/min (65 fpm)	1000 mm (39-1/2")
25 m/min (82 fpm)	1250 mm (49-4")
30 m/min (98 fpm)	1500 mm (59")
32 m/min (105 fpm)	1600 mm (63")
35 m/min (115 fpm)	1750 mm (68-7/8")

Machine Specifications

Working Speed	min.	8 m/min (26 ft/min)	max.	40 m/min (131 ft/min)
Length of edgbanding machine			machines up to 9.6 m (31.5')	
Color			gray RDS 240 80 05	

Utility Requirements

Electrical	
Operating Voltage**	460 Volts / 3 Phase / 60 Hz
Amperage Service	5.43 Amps @ 460 Volts
Control Voltage	24 Volts
Total Connected Load	2.5 kW
Compressed Air	
Connection Size(s)	ID 13 mm (1/2") / OD 19 mm (3/4")
Pressure Required	6 bar 87 psi
Consumption / Volume	50 l/min 1.77 cfm
Ambient Temperature	
Operating Range	5° - 35° C (min/max) 41° - 95° F (min/max)
Foundation Requirement	
Concrete Thickness	125 mm (min) 5" (min)

**Voltage must be balanced phase-to-phase and phase-to-ground.

Note: The stated values are only applicable to the machine as specified. Adding or deleting optional equipment may change service connection requirements.