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RIPPING • CROSS-CUTTING • OPTIMIZING • FINGER JOINT ING • GLUING  
PLANING AND PROFILING • WINDOW PRODUCTION • SINGLE PART MANUFACTURING • AUTOMATION

## Order Confirmation

Optimizing cross-cut saw OptiCut S 90

**Michael Weinig Inc.**  
124 Crosslake Park Drive  
Mooresville, NC 28117  
USA



## Order Confirmation

GRECON DIMTER HOLZOPTIMIERUNG SÜD GMBH & CO. KG

**Michael Weinig Inc.**  
**124 Crosslake Park Drive**  
**Mooresville, NC 28117**  
**USA**

File:	<b>193403/1</b>	Order:	<b>4855.14</b>	Customer:	<b>0011779/08</b>
Your phone no.:	<b>+1 704 799 0100</b>	Your fax no.:	<b>001 704 799 7400</b>	Date:	<b>02.08.2010</b>
Your e-mail:	<b>SALES@WEINIGUSA.COM</b>			Our ref.:	<b>DIM/RR</b>
Your ref.:	<b>PO No. 65203-OW, 22.07.2010</b>				

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### Optimizing cross-cut saw OptiCut S 90

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Timber ingoing length max. 4.5 m

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**GRECON DIMTER HOLZOPTIMIERUNG SÜD GMBH & CO. KG**

Rudolf-Diesel-Straße 14-16, 89257 Illertissen, Germ any  
Phone +49 (0) 7303/15-0, Fax +49 (0) 7303/15-199, E-Mail [info@dimter-weinig.de](mailto:info@dimter-weinig.de), Internet [www.weinig.com](http://www.weinig.com)

## **Commercial terms and conditions**

### **Payment terms**

FOB [Free On Board], freight prepaid German maritime port, according to Incoterms (latest edition) loaded in container incl. seaworthy packaging on wooden boards, with VCI foil and transport insurance up to German maritime port, without customs clearance. Without installation and commissioning.

### **Delivery time**

Despatch in September approx. end of week 38 / 2010  
in 1 container with machine no. 4856.14 (order "Riverhead Building Supply")

### **Payment**

100 % net 3 months from invoice / delivery date

### **Warranty**

The warranty period for this machine is  
12 months for single shift operation,  
6 months for two shift operation and  
3 months for more than 2 shifts.

### **Technical modifications**

Data for dimensions, weight and technical details are without obligation. We reserve the right for technical modifications in the client's interest.

### **Tools for machine operation / Mounting material**

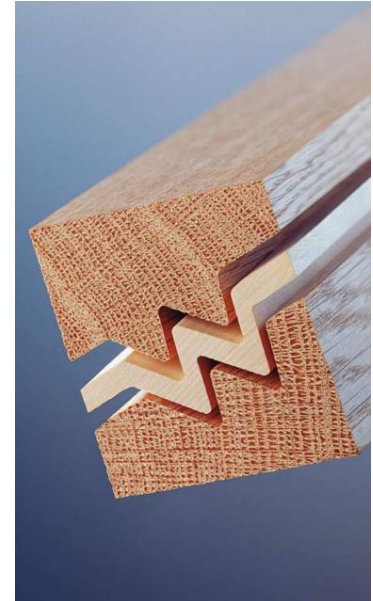
Tools for the setting of the plant are supplied free of charge. The parts necessary for mounting like shims, dowels, concrete screws, etc. are included in the delivery.

### **Not included in our delivery**

In general all machines, lines, equipments and services not indicated in the abovementioned conditions.

### **Technical documentation**

2 x in English with delivery of the machine  
Operation Manual as well as further technical documentation in English



## Technical Specification

### Optimizing cross-cut saw OptiCut S 90



Integrated system consisting of cross-cut saw and motoric positioning pusher for automatic cutting. Quick and reliable cutting of single parts or packets. Inclined machine design in order to allow the alignment of the workpieces at the guide ruler. The heavy, welded saw body as well as the saw aggregate are the basis for precise cuts.

After having been inserted, the workpieces are automatically positioned for cutting by a strong and precise pusher, pneumatically clamped and cut. Thus, very high daily capacities are achieved. The cutting area is spaciouly encased. Good view onto the cutting material due to large windows. The OptiCut S 90 is very ease to operate and can be upvalued by options (many of them also lateron).

46320\*  
Timber ingoing length max. 4.5 m

KT 1001254  
Layout drawing A.4855.14

### Timber dimensions to be treated

Saw aggregate	
Sawblade diameter	Ø 500 mm
TCT-sawblade, Z (tooth)=144, alternating tooth 20°	
Sawblade bore	30 mm
Speed of sawblade max.	3600 rpm
Widths min./max.	approx. 20 - 300 mm
Thicknesses min./max.	approx. 10 - 100 mm
Nominal cross sections (without board bend)	
min.	approx. 20 x 10 mm
max.	approx. 300 x 100 mm

KT 1001253\*

Permitted bend of the boards in all directions max. 3 mm per meter length resp. max. 10 mm over the whole length.

Final length with sorting min. approx. 80 mm

Timber species: Soft- and hardwood / Timber material

The timber must be appropriate to be treated with the machine.

34443\*

Shorter way of stroke of down-holder

After the automatic detection of the thickness of the workpiece the down-holder passes only a small way of stroke to shorten the saw cycle.

### Capacity / Positioning

44198\*

Traversing speed of positioning pusher, infinitely adjustable max. approx. 60 m/min.

Cutting time / cutting height adjustable

129938\*

Strong drive of pusher, nominal output 2.1 kW  
(transient upto 5 kW for acceleration)  
Weight of workpieces max. 100 kgs

44199\*

Accuracy of positioning dependant on weight of workpiece,  
max. accuracy of positioning +/- 0.5 mm.  
The workpiece is pushed along the table, inclined by 10°, against the fence.

34428

Lateral pressure device

Alignment of the workpiece in the cutting area to the stop edge (guide ruler) in order to reach a greatest possible rectangular cut. Positioning accuracy without precision kit +/- 1 mm. Necessary for sorting without reduction of capacity.

34435

Automatic width measuring of the workpieces

Registration of the width of the workpiece, contactless by ultra sound sensors. After the measuring of the workpiece width, the cutting list that was defined before in connection with the measured width is chosen automatically.

Timber thickness necessary for measuring min. 15 mm

Measurable timber width 40 - 300 mm

Timber width that can be run without measuring max. 330

mm Measurement accuracy max. +/- 2 mm

Software for max. 16 widths per per product group

34430

Swivelling positioning pusher for higher capacity due to continuous feeding with pneumatic equipment for lifting and lowering, Sliding block of 180 mm width

34432

Laser photo-eye at swivelling positioning pusher

Automatic identification of the raw timber length at alternating ingoing length by aid of a laser photo-eye mounted on the swivelling positioning pusher. Maximum timber bend in width 15 mm, others upon request.

34433

Automatic removal of defects and cutting of fixed lengths (defect removal + optimizing) with 1 grade

Luminescent sensor for installation on the swivelling positioning pusher in addition to the laser photo-eye, extensive software package for optimization.

During the return stroke of the pusher, the raw timber length and the positions of the marked defects are determined. The board is already placed in feeding position, the pusher is lifted to top.

After measuring during return stroke, the pusher is lowered and transports the board to the cross-cut saw. The OptiCut removes automatically the marked defects and cuts the suited lengths according to the cutting list from the remainders.

34434

Optimization with 4 grades

Splitting-up/optimization of the boards is made out in 4 different timber grades. Marking of the grade to be done by the operator.

Manual adjustment of the sensory mechanism according to timber thickness. Maximum timber bend in height 25 mm.

### Working height

363577\*

Support for workpieces

approx. 1000 mm

### Motor

46322\*

Strong saw motor of 7.5 kW

### Basic frame / infeed

34340

OptiCut in left-hand execution

The machine is fed from the left-hand side

Supporting arms for preparation of the workpieces installed laterally at the infeed table, for more regular working at the OptiCut.

Preparation of the workpieces or justification of quality and marking of defects is possible independently of the processing of the preceding workpiece in the saw.

34347

For ingoing length workpiece max. 4.5 m

### Outfeed / sorting

34464

Sorting basic package

Equipment package to connect the sorting station

34466

Integrated waste gate for sorting belt width 250 mm Electro-pneumatically actuated, for a secure sorting out of waste pieces, directly at rear of saw, non-driven, in connection with sorting station

Max. waste length approx. 120 mm.

Min. length of good quality 80 mm.

659009

Outfeed conveyor belt / sorting station

with energy-efficient drive motor (energy efficiency class IE2),

without ejectors,

belt width 250 mm

Width of workpiece &lt;= 300 mm

34390

Belt length 7.5 m

34399  
 3 pcs. Ejectors with squeeze protection  
 To be built-on outfeed conveyor belt (sorting station), max.  
 weight of particular lengths < 20 kgs

### Control

34404  
 Operating device OptiCom Direct  
 with large TFT colour display 12" and touch screenoperation.  
 Technical data: 500 product groups storable (16 simultaneously  
 for width measuring), 350 fixed lengths per product group, 50  
 ranges for variable lengths anyway spread over 8 grades,  
 extensive production statistics, data import / -export in ASCII  
 formate, direct connection possible to a network-capable printer  
 (statistics, data import/-export and print possible via network).

515370  
 Connection kit to customer's PC for OptiCom Direct  
 Cutting lists can be established at the office and be transfered  
 "online" to OptiCom Direct or vice versa the production status  
 can be retrieved from the statistics established by OptiCom  
 Direct. Establishment of detailed production statistics at the  
 office. OptiCom software for PC

### Electrics

34413  
 Operating voltage 440-480 Volt/60 Hz

### Connection values

514729*	
Electric connected load	See final layout
Air consumption	See final layout
Service pressure	min. 6-8 bar
Exhaust speed	approx. 30 m/sec.
Exhaust diameter	125 mm
Exhaust volume	approx. 1300 m <sup>3</sup> /h
Noise emission at idle running	<= 85 dBA

An uninterrupted electrical power supply has to be provided by  
 the customer!

Other values possible / upon request in case of  
 additional equipments!

### Colour

514726\*  
 Light grey RAL 7035  
 Blue RAL NCS 5030-R 80 B



## Safety

692328\*

The design of the machine is carried out according to particular parameters defined by Dimter relating to the appropriate use of the machine corresponding to CE conformities according to EC machinery directives.

In the case the machine is linked with other machines / facilities, it will be equipped with a "declaration of incorporation" according to annex II/B of the EC machinery directives - instead of an EC declaration of conformity.

We point out that in case of a linkage of the machine executed by the customer with other machines / facilities, the customer / operator will inherit the status of a manufacturer and is therefore competent and responsible for the safety considerations. Without taking into account the safety considerations for the overall linked line, the initial operation of the individual machine in this case must not take place. Parts supplied like protective fences, access doors, final stop fences as well as light barriers are part of the security considerations and have to be installed before initial operation. The facility must not be run without this security equipment!

## Warranty

388837\*

The warranty period for this machine is  
12 months for single shift operation,  
6 months for two shift operation and  
3 months for more than 2 shifts.

## Service

388839\*

Machine without installation and commissioning

### To be provided locally

44222\*

To be provided locally:

- Electric main power supply to switch cabinet
- Constant power supply (voltage deviations max. 5 %)  
An uninterruptible power supply has to be provided by the client
- Using RCCBs (residual current circuit breakers), please observe:  
Use all-current sensitive residual current circuit breakers, rated leakage current  $\geq 300$  mA
- Temperature range for control / processor 5 - 35°C
- Compressed air and pneumatic pipes to the maintenance units of the machine (8 bar)
- Dust exhaustion system and pipes to the connecting pieces on the machine
- Platforms, stairs and passages if necessary
- Concrete slabs and base plates, thickness min. 200 mm, reinforced at top and bottom, static load approx. 25 N / cm<sup>2</sup>  
unevenness of floor max. +/- 20 mm
- Skilled operation and maintenance personnel