

Kantenanleimmaschine einseitig  
Typ Profiline KDF 660 Edition  
Gebrauchtmachine - Baujahr 2007  
Maschinennummer: 0-261-06-5030



**PROFILINE KDF 660**

Edge banding machine Profiline KDF 660

Single-sided edge banding machine in right-hand version for hot melt adhesive bonding.

Quick-change gluing part for hot melt adhesive.

Processing of PU adhesive granulate possible in compliance with the adhesive processing regulations.

Glue supply leak-proof under the glue roller.

Finely dosed glue application to the workpiece using the glue roller, no adjustment to the workpiece thickness required.

Glue roller rotation direction optionally in the same or opposite direction. Glue temperature monitoring using an electronic thermostat.

Automatic glue temperature reduction during work interruptions.

Infrared hot melt adhesive activation.

Automatic edge magazine for rolled goods and fixed lengths, including roller plate diameter 800 mm.

Equipped with reinforced pre-cutting shears for thick PVC/ABS max. 3 x 45 mm.

Standard equipment with edge and workpiece distance monitoring using an optical display.

Heavy pressure zone with driven, pneumatically actuated main pressure roller and 3 free-running pressure rollers.

Standard equipment with automatic central lubrication for the transport chain.

Motor-adjustable top pressure.

Control panel at the machine inlet.

Electronic control PC 20+

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BRANDT control system with color graphic user interface for simple and convenient operation and programming.

Technical details:

- Swiveling control panel at the machine inlet
- Durable short-stroke membrane keyboard
- Color graphic flat screen
- Industrial PC with compact flash disk as

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mass storage

- Unit function keys with LED status display
- Support for operator guidance using color pictograms
- Online language switching between various foreign languages
- Display of the main machine target and actual states
- Status messages in plain text
- Simple selection and correction of the route point
- Simple option for axis adjustment (with

corresponding unit version)

- Online help in plain text through help window that can be called up at any time
- Production data recording for production time, edge length and number of workpieces, as daily and total value
- Inspection and maintenance interval display
- Remote service option using integrated

modem and installed service software

- Saving of machining programs
- Production according to machining programs
- Data backup of machining programs.

Electrical equipment with modular control system for increased operator comfort.

Modem for remote service and remote maintenance of the machine via the public telephone network.

For this, an on-site analog telephone connection on the machine is required.

Outside the warranty period, remote service and maintenance services are used at our valid remote service rates.

Noise protection panel including central suction nozzle diameter 160 mm and chip box for scraper chips with suction nozzle diameter 100 mm. For machines with a joint milling unit (KDF machines), additional suction nozzle diameter 120 mm.

Permissible ambient temperature min. +5 degrees / max. +35 degrees Celsius, for the electrical and mechanical functionality of the machine.

The processing guidelines of the glue and edge manufacturers must be observed.

If the mains voltage fluctuations are greater than +/- 10%, a voltage stabilizer must be installed at the place of use. Machine deliveries for EU countries are carried out in accordance with EC Directive 98/37/EC, Annex I.

Technical data

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- Edge thickness 0.4 - 12 mm
  - Roll separation max. 3 x 45 mm  
or 0.8 x 65 mm
  - Workpiece thickness 8 - 60 mm
  - Feed rate max. (\*) approx. 16 m/min.

(\*) When the form milling machine is selected, the

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automatic switchover to 11 m/min occurs. Electrics 400 V - 3 Ph. - 50 Hz

Pneumatic connection min. 6 bar  
Connection value approx. 15.5 kW

Total length 6,360 mm

Number 4876 1 x right

TOOL SET R = 2 MM

1 x right

GUIDE RAILS

for moving the entire machine sideways

by 500 mm (3 guide rails firmly dowelled to the floor, working height of the machine 1,050 mm)

1 x right

HOLDER ROLLER PLATE CRANKED

new total machine width: 1,150 mm

- free of charge -

Number 0041 1 x right

ADJUSTABLE INPUT RULER

in conjunction with front-mounted joining part.

Number 0047 1 x right

EXTENSION OF INLET RULER BY 300 MM

Number 0941 1 x right

EXTRA COST FOR PROGRAM ADJUSTMENT OF INLET RULER

Includes the motorized single-axis adjustment of the adjustable inlet ruler on

KDF machines for chip removal.

Number 0933 1 x right

MOTORED HEIGHT ADJUSTMENT OF TOP PRESSURE

by input via PC 20+, movement

of the top pressure to the workpiece thickness.

Installed as standard in KDX 500/600 from length from X80, in KDX 700/900 from length X60.

Number 0943 1 x right

EXTRA COST FOR PROGRAM ADJUSTMENT OF PRESSURE ZONE

Includes the motorized single-axis adjustment of the pressure zone to the edge thickness.

Number 2215 1 x right

RELEASE AGENT INDICATION WORKPIECE

Release agent indication at the top and bottom, for better removal of glue residue from the workpiece being processed.

Manual adjustment when the workpiece protrusion changes.

Only in conjunction with joint milling machines!

Number 2620 1 x right

AUTOMATIC EDGE FEED

for quickly changing different roll edges up to 3 mm thick. The edge material is

motor-driven from the roller plate to the working position.

No manual magazine adjustment required if the edge height is adjusted to the respective workpiece thickness.

Number 2035 1 x right

QUICKMELT - GLUING PART

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Additional charge for pre-melter and quick-change, small-volume glue unit instead of the standard glue unit.

Number 2068 1 x right  
GLUE CONTAINER STANDARD CHANGEABLE PU GLUE  
Additional quick-change standard glue unit, with electrical plug connections.

With special Chemcoat inner coating for simplifying glue pot cleaning.

Number 4722 1 x right  
JOINING MILLING UNIT 2 X 2.2 KW 200 HZ FG 3500  
For joining in front of the gluing part, spindle adjustment vertical, electro-pneumatic control horizontal, 2 motors (1 x synchronous, 1 x counter-rotating), max. chip removal / stroke 3 mm (The maximum chipping cross-section depends on the material and feed rate)  
Cover hood with suction nozzle diameter 120 mm.  
Equipment without joining tools

Number 4792 1 x right  
JOINING MILLING CUTTER SET 48 MM DIA (FOR VKNR 4722/4730)  
for use on the jointing milling unit VKNR 4722 and VKNR 4730. 2 permanently fitted DIA joining cutter heads diameter. 100 x 48 x diameter 30 mm, Z = 3 + 3 with double keyway 8 x 3 mm  
max. workpiece thickness 42 mm

number 4174 1 x right  
AUTOMATION PACKAGE II FOR 2-MILLING MACHINE  
consisting of:  
3175 - PNEUMATIC ADJUSTMENT OF TRIMMING BEVEL/STRAIGHT  
5762 - PNEUMATIC ADJUSTMENT OF DRAWING BLADE  
for the 1st pre-milling machine VKNR 4062 or BF 6240 / VKNR 4150:  
4189 - PNEUMATIC ADJUSTMENT OF MILLING UNIT  
4199 - PNEUMATIC 2-POINT ADJUSTMENT VERTICAL TACTILE  
for inserting/removing and for switching from pre-milling (with overhang) to face milling.

for the 2nd flush milling machine BF 6245:  
4189 - PNEUMATIC ADJUSTMENT OF MILLING UNIT  
4199 - PNEUMATIC 2-POINT ADJUSTMENT OF VERTICAL SENSOR  
4211 - PROGRAM ADJUSTMENT OF SIDE SENSOR ROLLERS  
for insertion/removal.  
Automatic switching from thin edge with 13 degree bevel, radius PVC/ABS and solid wood edges  
up to 12 mm.

Number 3130 1 x right  
TRIMMING UNIT BEVEL/STRAIGHT 2 X 0.35 KW HL 6110  
For trimming the front and rear edge overhang with a pulling trim cut for high accuracy.  
Edge dimensions: max. 12 x 40 mm  
max. 3 x 65 mm  
2 motors each 0.35 kW, 200 Hz, 12,000 rpm.  
Swivel range straight to bevel cuts 0-15 degrees  
Equipped with 2 miter saws diameter 100x32x2.6 mm

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Z = 30  
Feed speed:  
up to 4 mm edge thickness max. 16 m/min.  
from 4 mm edge thickness max. 14 m/min.  
Space required: 760 mm

Number 4062 1 x right PRE-MILLING UNIT 2 X 0.55 KW 0 DEGREES VF  
6210 for flush milling in COUNTER-TURN of the upper and lower edge  
material overhang. 2 motors  
arranged one above the other, vertically scanning,  
manually movable 30 mm to the side.  
Height adjustment of the upper motor with the  
upper pressure.

Edge thickness max. 15 mm  
Workpiece thickness max. 8 - 60 mm  
2 HM milling cutters diameter 70 x 14.3 x 16, Z = 4

Space requirement: 432 mm

Number 4155 1 x right

MILLING UNIT 2 X 0.55 KW SYNCHRONOUS BF 6245

For milling the upper and lower edge material overhang, vertically and  
horizontally  
tactile. Height adjustment of the upper unit  
with the upper pressure.

Manual version

Functionality can be selected from the control panel:  
2 working positions: flush and radius milling.

All adjustment axes with digital counters for  
quick adjustment.

Equipped with combination milling cutters for flush and  
radius milling. Radius setting by VKNR 4876  
(r = 2 mm) or VKNR 4877 (r = 3 mm).

Edge thickness max. 8 mm (KDX 500)  
Edge thickness max. 12 mm (KDX 600 - 900)

Space required: 405 mm

Number 4215 1 x right

ADDITIONAL COST PROGRAM ADJUSTMENT TO EDGE THICKNESS

Use instead of the pneumatic adjustment  
VKNR 4189 on the flush milling machine VKNR 4155/BF 6245  
Includes the motor-driven, stepless axis adjustment, suitable for chamfering or  
radius milling  
of the outer edge of the glued edge material.

Number 4901 1 x right  
MULTIPLE ROLLER PROBE FLUSH MILLING MOTOR

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for use with acute-angled workpieces,  
or with workpieces with one-sided  
cup hinge holes.  
Price per motor.  
Not in conjunction with VKNR 4199 - Pneumatic.  
2-point adjustment of vertical feeler rollers.

Number 4916 1 x right  
CHANGING DEVICE 2 MILLING MOTORS BF6240/6245  
For milling units VKNR 4150/4155  
2 motors 0.55 kW with electrical plug connection and  
quick-change device. Including 2 WPL  
radius/straight milling cutters. Radius setting using  
VKNR 4876 (r = 2 mm) or VKNR 4877 (r = 3 mm).

Number 4832 1 x right  
EXCHANGE COMBINATION MILLING BIT SET STRAIGHT/CHAMFER 45 DEGREES  
Exchange for the standard combination milling bits  
Straight/Radius.  
Flush milling up to 12 mm edge thickness

Number 4803 1 x right  
FORM MILLING UNIT TOP+BOTTOM 2 X 0.35 KW FF 6220  
For form/flush milling of head edges on post-  
and soft-forming parts and corner roundings of  
thick PVC edges. Wooden edges possible to a limited extent,  
depending on preliminary tests. Radius or chamfer milling cutters can be  
installed as required.

Restrictions for loose middle layers on  
post-/soft-forming parts and extremely thin  
melamine/foil edges and surface materials.

2 motors each 0.35 kW, 200 Hz, 12000 rpm.  
Edge thickness max. 3 mm (radius)  
Workpiece thickness max. 55 mm  
Feed speed max. 11 m/min.  
Including pneumatic 2-point adjustment chamfer/radius.  
Equipped with 2 radius milling tools.  
Space required: 1000 mm

Number 5760 1 x right  
DRAWING BLADE WITH QUICK-CHANGE HEADS ZK 6510  
Scanning from above, below and to the side. For  
chamfering or rounding pre-milled PVC edges.  
Max. edge thickness 3 mm. Height adjustment of the  
upper device with the top pressure, including  
2 quick-change heads for easy radius changes, with 2 WPL profile knives.  
Radius determination by VKNR 4876 (r = 2 mm)  
or VKNR 4877 (r = 3 mm).

Space required: 390 mm

Number 5798 1 x right  
ADDITIONAL DEVICE DRAWING BLADE POINTED WORKPIECES  
suitable for processing PVC edges on  
acute-angled workpieces and cup hinge holes.

Can only be used for drawing blade VKNR 5760.  
Price per processing head above or below, for  
the complete unit this position is required 2 x.

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Number 5780 1 x right  
SURFACE DRAWING BLADE GLUE JOINT ZF 6600  
For removing adhesive residues in the area of  
the glue joint.

Scanning from above and below. Height adjustment  
with the top pressure.  
Equipped with 2 WPL reversible knives.

Space required: 150 mm

Number 2220 1 x right  
CLEANING AGENT ADVICE WORKPIECE  
Spray device for cleaning agent on  
the upper and lower edges of the workpiece to remove  
release agent and adhesive residues. Installed  
in front of the buffing unit.

Number 5330 1 x right  
Buffingunit 2 motors FP 6810  
For making the edges at the top and bottom grippy.

2 motors each 0.18 kW, individually suspended,  
angle and height adjustable.  
Height adjustment of the upper motor with the  
top pressure.

2 molleton discs diameter 150 x 20 mm

Space required: 230 mm