

G.00**OPTIMAT KDF 210**

BRANDT SINGLE-SIDED EDGE BANDING MACHINE

MODEL: AMBITION 1210 F

Single-sided edge banding machine for processing straight workpiece edges and for gluing and finishing various edge materials in longitudinal and cross-feed operations.

OVERVIEW OF THE UNIT EQUIPMENT:

Jointing and Milling Unit 2 x 2.2 KW 200 Hz
Gluing Unit A3
Cross-Cut Unit Chamfer/Straight 2 x 0.18 KW
Milling Unit 2 x 0.27 KW Counter-Rotating
Scratch Blade with Quick-Change Heads
Swabbing Unit

1. BASIC MACHINE:

- Continuous machine stand for mounting the processing units
 - Fixed stop on the right
 - Paint finish: Gray RDS 240 80 05
 - Manually adjustable infeed guide
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 - Top pressure:
 - Individual rollers in 2 rows, offset

 - Height adjustment with digital counter for manual adjustment of the top pressure to the panel thickness
 - Workpiece transport device:
 - Transport chain with Rubber pad, 80 mm wide
 - Precision running and guide surfaces
 - Standard equipment with manual central lubrication for the conveyor chain
 - Workpiece support with roller rail, extendable by approx. 500 mm
 - Noise protection equipment, with individual extraction for the workpiece and units, as well as a chip collection box for scraper chips
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- Feed rate | 11 m/min
- Working height | 950 mm
- Pneumatic connection | min. 6 bar
- Total length | 3,653 mm

Floor conditions must comply with the floor plan and extraction plan, No.: 5-701-80-3078

Technical data refers to the standard version.

Options result in changes in the connected loads for power, extraction, and air consumption.

2. WORKPIECE AND EDGE PARAMETERS:

- Minimum workpiece width:
 - For workpiece thickness 8-22 mm | 70 mm*
 - For workpiece thickness 23-50 mm | 120 mm*
- *Depending on the workpiece length

- Workpiece overhang | 38 mm
- Workpiece thickness | 8 - 50 mm
- Max. edge height = workpiece height | + 5 mm
- Edge material: roll | 0.4 - 3 mm
- Max. edge cross-section
- For PVC | 135 mm²
- For veneer | 100 mm²
- Max. roll diameter | 830 mm
- Edge material: strip | 0.4 - 3 mm
- Max. edge cross-section
- For strip | 165 mm²

- If no radius is specified, R=2 mm installed and delivered

- The machine operator is responsible for the use of suitable materials (panels, adhesives, edges, cleaning agents, paints, etc.).

- When using edgebanding materials with

high-gloss surfaces, painted surfaces, matte surfaces, and pressure-sensitive materials, we recommend the use of a suitable protective film on the

edge material in conjunction with VKNR 0059 (additional device for sensitive

surfaces).

3. EQUIPMENT

3.1 JOINTING MILLING UNIT 2 x 2.2 KW 200 HZ

- For joining in front of the gluing part, vertical spindle adjustment, horizontal electro-pneumatic control, 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 extraction nozzle diameter 120 mm

- Includes jointing cutter set in DIA design with interchangeable cutting edges.
Diameter 100 x 44 x diameter 30 mm, Z = 3
with double keyway 8 x 3 mm
max. workpiece thickness 42 mm

3.2 GLUING UNIT A3

Consisting of:

WORKPIECE PREHEATING

- Contact heating shoe for preparing the workpiece for optimal bonding quality

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Gluing Unit A3

STANDARD APPLICATION UNIT

- Quick-change application unit
- Processing of PU adhesive granules with

Standard applicator unit, replaceable PU
(VKNR 2068) possible in compliance with the adhesive
processing instructions

- Leak-proof glue reservoir below the glue roller
- Finely adjustable glue application to the workpiece
via glue roller, no adjustment required for

work thickness

- Glue roller rotation direction synchronized
- Glue temperature monitoring via
electronic thermostat
- Automatic glue temperature reduction during
work interruptions

MAGAZINE

- Automatic edge magazine for roll material
and fixed lengths, including roller plate
- Equipped with reinforced pre-cutting shears

PRESSURE ZONE

- Pressure zone with driven main pressure roller
and two free-running pressure rollers
- Equipped with a digital counter for

manual adjustment of the pressure zone
to the edge thickness

3.3 2 x 0.18 kW CHAMFER/STRAIGHT TRIMMING UNIT

- For trimming the front and rear edge material overhang with a pulling
cut.

2 motors, each equipped with a
trimming saw blade. Swivel range from straight to
bevel trimming 0-15 degrees.

- 2 motors, each 0.18 kW, 200 Hz, 12,000 rpm.
- 2 carbide saws, diameter 100 x 32 x 2.6 mm, Z = 30
- Feed rate: 11 m/min.

3.4 2 x 0.27 kW COUNTER-FEEDING MILLING UNIT

- For trimming the upper and lower edge material overhang, vertically and
horizontally. Height adjustment of the upper unit
using the top pressure

- Unit manually adjustable between

3 different working positions:

Straight flush trimming

Overhang trimming

Radius/bevel trimming

- Lateral adjustment equipped with

digital counters for adjustment to

different edge types

- 2 motors each, 0.27 kW, 200 Hz, 12,000 rpm

- Equipped with DFC combo cutters for bevel,
radius, and flush trimming

- Max. edge thickness 3 mm

- Max. edge thickness 6 mm (only in conjunction with
VKNR 0006)

3.5 SCRAP BLADE WITH QUICK-CHANGE HEADS

- Scanning from above, below, and sideways. For

beveling or rounding pre-milled PVC

edges

- Max. edge thickness 3 mm. Height adjustment of the upper unit with the top pressure,
- 2 quick-change heads for easy radius changes, with 2 WPL profile blades

3.6 2-MOTOR BUFFERING UNIT

- For making the top and bottom edges grippy.
- 2 motors, each 0.09 kW, individually suspended, angle and height adjustable
- Height adjustment of the upper motor with the top pressure
- 2 foam pads, diameter 120 x 20 mm

4.0 BRANDT EASYTOUCH control system

With touch display in widescreen format, for simple and convenient operation and programming.

Technical Details:

- Control panel at the machine inlet
- Clear 7" touch display for easy navigation and intuitive machine operation
- Display of key machine target and actual states
- Integrated route control for contactless control of machining functions.
- Easy selection and correction of route points
- Intelligent production readiness indicator via traffic light function
- Online language switching between various foreign languages
- Machine data acquisition for displaying important production metrics such as quantity, production time, and edge consumption
- Status message in plain text
- Up to 20 machining programs can be stored

5.0 ELECTRICAL EQUIPMENT

- Operating voltage 400 Volt - 3Ph - 50Hz
 - Control cabinet installed according to European standard EN 60204

 - Electronic frequency converter with motor brake function
 - Overvoltage protection for machines with electronics
 - Country-specific operating voltage adjustment via Transformer (optional)
 - Electrical equipment with modular control system for increased operator comfort
 - Electronic stabilization of the internal 24 V control voltage
 - For mains voltage fluctuations greater than +/- 10%, a voltage stabilizer must be installed at the installation site
 - Specified ambient temperature:
+10 to +40 °C
- STANDARD APPLICATION UNIT

Spezifikation

Datum 03.09.2025
Maschinenummer 0-261-20-8363
Produktschlüssel O KDF 210

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- Quick-change application unit

6.0 SAFETY AND PROTECTIVE DEVICES

- EC Conformity (CE) according to the currently valid Machinery Directive for single machine operation

- For interlinked machine operation (cells), an additional EC Conformity Assessment (on-site) is required.

To be carried out by the user (customer).

- Wood dust tested, TRK value max. 2 mg/m³ when

compliance with the extraction performance to be provided by the customer

according to the installation plan

- Our warranty/product liability is subject to full

compliance with the original operating instructions supplied with the machine, including the safety regulations.

7.0 HOMAG GROUP QUALITY PACKAGE

- TÜV certificate according to DIN EN ISO 9001:2000

- The machine is run in and delivered according to the Homag Group standard program.

8.0 DOCUMENTATION

1. Operating instructions consisting of operating and maintenance instructions on DIN A4 paper and data storage media.

2. Spare parts descriptions and circuit diagrams on data storage

3. Help texts integrated into the machine control

4. Operating system dialogs in English

Specify language using language selection VKNR 8321 ff.

Note:

- Optional additional copies

Operating instructions with a different language code and VKNR 8383 (paper) or 8384 (digital) are available

- For VKNR 8363, 8359, 8361, 8362, 8356, 8333, 8335

(screen texts and language code)

Farsi, Hebrew, Estonian, Arabic,

Turkish, Norwegian, and Greek

the operating instructions are

supplied in English

G.0001 Number 4876 1 x right

TOOL SET R = 2 MM

G.0004 Number 2217 1 x right

LUBRICANT SPRAY UNIT FOR EDGE MATERIAL

- Spray unit for lubricant for

transferring to the edge material

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- To prevent damage to particularly sensitive edge materials.
- Without lubricant, must be provided by the customer.

Can be used on the following machines:

Ambition/Highflex/Profiline 1200-1800

N.04 Number 5784 1 x right

EXCHANGE BUFFER FOR GLUE JOINT SCRATCHING BLADE

- Instead of the standard VKNR 5455 buffing unit, the VKNR 5820 glue joint scraper is installed.

5820 - GLUE JOINT SCRATCHING BLADE

- For removing adhesive residues in the area of the glue joint.
 - Scanning from above and below.
- Height adjustment with the top pressure.
- Equipped with two WPL reversible blades.

D.01 Number 8321 1 time

LANGUAGE SELECTION GERMAN

- On-screen operating texts for machine operators in German