

Brandt single-sided edge banding machine  
Type: KDF 430C Ambition 1430 FC  
M-nr: 0-261-20-4355  
Usedmachine - year 2009

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OPTIMAT KDF 430 C

Single-sided edge banding machine for processing straight workpiece edges and for applying and finishing various edge materials in longitudinal and transverse feed.

OVERVIEW OF THE MACHINE EQUIPMENT:

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Joining Milling Unit 2 x 2.2 kW 200 Hz  
Gluing Unit A8  
Cap Milling Unit Chamfer/Straight 2 x 0.18 kW  
Milling Unit 2 x 0.55 kW Counter-rotating  
Form Milling Unit 1 x 0.35 kW WD 40  
Profile Pulling Blade  
Free Space Glue Joint Pulling Blade  
Flattening Unit

1. BASIC MACHINE:

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- Continuous machine stand
  - Fixed stop on the right
  - Top pressure:
  - Individual rollers in 2 staggered rows
  - Top pressure height adjustment with digital counter
  - Workpiece transport system:
  - Transport chain with rubber pad, 80 mm wide
  - Precision running and guide surfaces
  - Workpiece support with Roller rail, extendable approx. 600 mm
  - Noise reduction equipment, with individual extraction for the joining part and aggregates

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- Feed rate | 11 m/min
  - Max. feed rate with form milling attachment | 11 m/min
  - Working height | 950 mm
  - Pneumatic connection | min. 6 bar
  - Overall length | 4,770 mm

2. WORKPIECE AND EDGE PARAMETERS:

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- Minimum workpiece width: \*Depending on workpiece length
  - For workpiece thickness 12-22 mm | 70 mm\*
  - For workpiece thickness 23-40 mm | 120 mm\*
  - For workpiece thickness 41-60 mm | 150 mm\*
  - Workpiece overhang | 38 mm
  - Workpiece thickness | 8 - 60 mm
  - Max. edge height = workpiece height | + 6 mm
  - Edgebanding material roll | 0.4 - 3 mm
  - Edge cross-section max.
  - For PVC | 135 mm<sup>2</sup>
  - For veneer | 100 mm<sup>2</sup>
  - Roll diameter max. | 830 mm
  - Edgebanding material strips | 0.4 - 8 mm
  - Edge cross-section max.
  - For strips | 360 mm<sup>2</sup>

3. EQUIPMENT

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### 3.1 JOINTING MILLING UNIT 2 x 2.2 kW 200 Hz

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- For joining before the gluing part, spindle adjustment vertical,

electro-pneumatic control horizontal, 2 motors

Cover with extraction port diameter 120 mm

- Includes jointing cutter set in DIA design

Diameter 100 x 48 x Diameter 30 mm, Z = 3 + 3

### 3.2 GLUING UNIT A8

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Consisting of:

WORKPIECE PREHEATING

- Radiant heater for optimal bonding quality

STANDARD APPLICATION UNIT

- Quick-change application unit.

MAGAZINE

- Automatic edge magazine for roll stock

and fixed lengths, including roller table

PRESSING ZONE

- Pressure zone with driven, pneumatically actuated

main pressure roller and 2 free-running pressure rollers

### 3.3 CAPLET UNIT BEVELED/STRAIGHT 2 X 0.18 KW

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Swivel range straight to beveled caps 0-15 degrees

- 2 motors, each 0.18 kW, 200 Hz, 12,000 rpm; Equipped with  
one miter saw blade each, diameter 100 x 32 x 2.6 mm, Z = 30

### 3.4 Milling Unit 2 x 0.55 kW Counter-rotating

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- For milling the upper and lower edge material overhang,

2 working positions: flush and radius/chamfer milling

- All axes with digital counters for quick adjustment

- 2 motors, each 0.55 kW, 200 Hz, 12,000 rpm

### 3.5 Shape Milling Unit 1 x 0.35 kW WD 40

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- For shape milling of the front and back edges with different profiles

1 motor, each 0.35 kW, 200 Hz, 12,000 rpm

- Edge thickness max. 3 mm

Workpiece thickness max. 40 mm

Workpiece length min. 250 mm

Feed rate max. 11 m/min.

### 3.6 PROFILE DRAWING BLADE

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- Scanning from above, below, and the side.

### 3.7 SWIVEL PLATE UNIT 2 MOTORS

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- 2 motors, 0.09 kW each, individually suspended,  
tilt and height adjustable

- 2 molton discs, diameter 120 x 20 mm

### 4.0 ELECTRONIC CONTROL EASY CONTROL EC 10+

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BRANDT control system with LCD display for  
easy and convenient operation and  
programming.

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#### 5.0 ELECTRICAL EQUIPMENT

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- Operating voltage 400 volts - 3-phase - 50 Hz
- Control cabinet according to European standard EN 60204
- Electronic frequency converter with motor brake function
- Overvoltage protection for machines with electronics

#### 6.0 SAFETY AND PROTECTIVE DEVICES

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- CE marking according to EC Machinery Directive 98/37/EC, Annex IIa
- Wood dust tested

#### 7.0 HOMAG GROUP QUALITY PACKAGE

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- TÜV certificate according to DIN EN ISO 9001:2000

#### 8.0 DOCUMENTATION

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- Documentation on CD-ROM
- Operating and maintenance instructions also available in printed form

TOOL SET R = 2 MM  
MOTOR HEIGHT ADJUSTMENT UPPER PRESSURE  
QUICKMELT APPLICATION UNIT  
RELATING AGENT WORKPIECE SPECIFICATION

AUTHORIZATION PACKAGE consisting of:

ELECTRONIC CONTROL POWER CONTROL PC 20+  
3175 - PNEUMATIC ADJUSTMENT CAPS CHAMFER/STRAIGHT  
5762 - PNEUMATIC ADJUSTMENT PULLING BLADE  
4211 - PROGRAM - ADJUSTMENT SIDE ROLLERS  
4199 - PNEUM. 2-POINT ADJUSTMENT VERTICAL TENSIONER

Standard equipment with automatic  
central lubrication for the conveyor chain.

Automation package for single-milling machines,  
equipped with the flush trimming cutter 4150 or 4155.  
Automatic switching between thin edges with a 13-degree chamfer,  
radius PVC/ABS and solid wood edges up to 8 mm.

Multiple roller probing flush trimming motor  
for use with acute-angled workpieces or single-sided  
hinge drilling.

Additional attachment: Pointed workpiece puller blade 5765/5766

Glue joint puller blade

Cleaning agent specification for workpiece

Electrical/mechanical interface ZHR01 Ambition 1400  
Electrical and mechanical preparation  
for mounting the Ligmatech workpiece return unit ZHR 01