

Edge Banding machine Brandt
Type Profiline KDF 220 / Highflex 1220
Used machine - year 2015



BRANDT EDGE BANDING MACHINE MODELL: KDF 220 HIGHFLEX 1220

MODELL: 1220 HF

Single-sided edge banding machine for processing straight edges workpiece edges and for gluing and reworking of different edge materials in longitudinal and transverse passes.

OVERVIEW OF THE UNIT EQUIPMENT:

JOINING MILLING UNIT 2 X 2.2 KW 200 HZ
BONDING UNIT A6
PNEUMATIC 2-POINT ADJUSTMENT PRESSURE ZONE
CUTTING UNIT BEVEL/STRAIGHT 2 X 0.18 KW
PNEUMATIC ADJUSTMENT CAPS BEVEL/STRAIGHT
MILLING UNIT 2 X 0.27 KW COUNTER ROTATION
PNEUMATIC MILLING BEVEL / RADIUS / STRAIGHT
FORM MILLING UNIT 1 X 0.35 KW WD 40
PULLING BLADE WITH QUICK-CHANGE HEADS
PNEUMATIC ADJUSTMENT OF PULL BLADE
BLACKING UNIT

1. BASIC MACHINE:

- Continuous machine stand for setting up the processing units
- Fixed stop side on the right
- Paint gray RDS 240 80 05
- Inlet ruler manually adjustable
- Upper pressure:
 - Single rollers in 2 rows, arranged staggered
 - Height adjustment with digital counter for manual adjustment of the top pressure on plate thickness
- Workpiece transport device:
 - Transport chain with rubber pad, 80 mm wide
 - Precision running and guiding surfaces
 - Standard equipment with pneumatic central lubrication for the transport chain, manually operated by buttons
- Workpiece support with roller rail, extendable to approx. 500 mm
- Noise protection equipment, with individual extraction for parts to be joined and aggregates,
 - as well as a chip catcher for scraper chips
- Feed | 11 m/min
- Feed max. with form milling machine | 11 m/min
- Working height | 950 mm
- Pneumatic connection | min. 6 bar
- Total length | 4,153 mm

2. WORKPIECE AND EDGE PARAMETERS:

- Workpiece width min:
 - For workpiece thickness 8-22mm | 70 mm*
 - For workpiece thickness 23-40mm | 120 mm*
 - For workpiece thickness 41-60mm | 150 mm*
- *Depending on the workpiece length
- Workpiece projection | 38 mm
- Workpiece thickness | 8 - 60 mm
- Edge height max. = workpiece height | + 5 mm
- Edge material roll | 0.4 - 3 mm
- Edge cross section max.
 - For PVC | 135 mm²
 - For veneer | 100 mm²
- Roll diameter max. | 830 mm
- Edge material strips | 0.4 - 6 mm

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- Edge cross section max.
- For strips | 165 mm²
- If no radius is specified, R=2 mm is retracted and delivered
- For the use of suitable materials (plates, glue, edges,
The machine operator is responsible for cleaning agents, paints, etc.).
- When using edge material with high-gloss surfaces,
painted surfaces, matt surfaces and pressure-sensitive surfaces
materials, we recommend the use of suitable protective film
The edge material

3. A G G R E G A T E P I E C E

3.1 JOINING MILLING UNIT 2 X 2.2 KW 200 HZ

- For attaching in front of the gluing part, spindle adjustment vertically,
electro-pneumatic control horizontally, 2 motors (1 x DC,
1 x counter rotation), max. chip removal / stroke 3 mm
- Including jointing cutter set in DIA version

3.2 BONDING UNIT A6

Consisting of:

WORKPIECE PREHEATING

- Contact heating shoe to prepare the workpiece for a
Optimal bonding quality

STANDARD ORDER UNIT

- Quick-change application unit
- Processing of PU glue granules with standard application units
changeable PU possible
- Leak-proof glue supply underneath the glue roll
- Finely dosed glue application to the workpiece using a glue roller,
no adjustment to workpiece thickness required
- Glue roller rotation direction either synchronous or counter-rotation.
Glue temperature monitoring using an electronic thermostat
- Automatic glue temperature reduction during work interruptions

MAGAZINE

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

PRESSURE ZONE

- Pressure zone with driven main pressure roller
and 2 free-running pressure rollers
- PNEUMATIC 2-POINT ADJUSTMENT PRESSURE ZONE
for electro-pneumatic switching of the pressure zone to 2 below
different positions. Automatic adjustment to the per
Digital counter preset different edge thicknesses.

3.3 CUTTING UNIT BEVEL/STRAIGHT 2 X 0.18 KW

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

3.4 PNEUMATIC ADJUSTMENT CAPS BEVEL/STRAIGHT

3.5 MILLING UNIT 2 X 0.27 KW COUNTER-ROOT

- For milling the upper and lower edge material projection,
- Aggregate manually adjustable between 3 different working conditions
positions: flush milling straight
Milling with overhang
Radius/chamfer milling

3.6 PNEUMATIC MILLING BEVEL / RADIUS / STRAIGHT

for electro-pneumatic switching of the milling unit
from chamfer to radius or straight line.

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3.7 MOLDING UNIT 1 X 0.35 KW WD 40

- For shaping the front and rear edges with different profiles
1 motor each 0.35 kW, 200 Hz, 12,000 rpm.
- Edge thickness max. 3 mm

3.8 PULLING BLADE WITH QUICK-CHANGE HEADS

- For chamfering or rounding pre-milled PVC edges

3.9 PNEUMATIC ADJUSTMENT OF PULL BLADE

3.10 GLUE JOINT PULLING BLADE

- Instead of the standard VKNR 5455 buffing unit
The VKNR 5820 glue joint scraper is assembled.
- 5820 - GLUE JOINT PULLING BLADE
- To remove adhesive residue in the area of the glue joint.
- Scanning from above and below. Height adjustment with the top pressure.
- Equipped with 2 WPL reversible knives.

4.0 BRANDT CONTROL SYSTEM EASYTOUCH With touch display in widescreen format, for simple and comfortable operation and programming.

Technical details:

- Control panel on the machine inlet
- Clear 7" touch display for easy navigation and for intuitive operation of the machine
- Presentation of the essential machine target and actual states
- Integrated route control for contactless control of Editing functions.
- Easy selection and correction of route points
- Intelligent production readiness display via traffic light function
- Online language switching between various foreign languages
- Machine data acquisition to display important production data
key figures such as number of pieces, production time and edge consumption
- Status message in plain text
- Up to 20 editing programs can be saved

5.0 ELECTRICAL EQUIPMENT

- Operating voltage 400 volts - 3Ph - 50Hz

6.0 SAFETY AND PROTECTION DEVICES

- EC conformity (CE) according to the currently valid machine directive
Single machine operation

7.0 HOMAG GROUP QUALITY PACKAGE

- TÜV certificate

8.0 DOCUMENTATION

1. Operating instructions consisting of
Operating and maintenance instructions on DIN A4 paper and data carrier.
 2. Spare parts names and circuit diagrams on data carrier
 3. Help texts integrated in the machine control
 4. Operating system dialogs in English
- LANGUAGE SELECTION GERMAN
- Screen operating texts for machine operators
German

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TOOL SET R = 2 MM

AUTOMATIC EDGE FEEDER KDX 1210 F/KDX 1440

EXTRA PRICE FORM MILLING 4802 CONSTRUCTION FLOORS

- For vertical corner processing of construction/insert shelves,

MULTIPLE ROLLER FINE MILLING

- for use with acute-angled workpieces,
or for workpieces with pot hinge holes on one side.

QUICK CHANGE HEAD + SPECIAL KEYING R 2.0

- Additional quick-change head for scraper blade
including WPL profile knife R: 2.0