

Edge Banding Machine  
Type Profiline KDF 650 HF 1650  
Used Machine - year 2010  
Machine number: 0-261-20-5328



## PROFILINE KDF 650

BRANDT SINGLE-SIDED EDGE BANDING MACHINE  
MODELL: HIGHFLEX 1650

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

OVERVIEW OF THE UNIT EQUIPMENT:  
JOINING MILLING UNIT 2 X 2.2 KW 200 HZ  
BONDING UNIT A12  
CUTTING UNIT BEVEL/STRAIGHT 2 X 0.35 KW  
PNEUMATIC ADJUSTMENT CAPS BEVEL/STRAIGHT  
PNEUMATIC 2-POINT ADJUSTMENT CAPS  
MILLING UNIT 2 X 0.55 KW COUNTER-ROOT  
PNEUMATIC 2-POINT ADJUSTMENT  
PROGRAM ADJUSTMENT OF SIDE ROLLERS  
EDGE THICKNESS ADJUSTMENT PROGRAM  
FORM MILLING UNIT 2 X 0.35 KW WD 60  
PROFILE PULLING BLADE WITH QUICK-CHANGE HEADS  
PNEUMATIC ADJUSTMENT OF PULL BLADE  
GLUE JOINT PULLING BLADE  
BLACKING UNIT

### 1. BASIC MACHINE:

- Machine stand throughout, for setting up the Processing units
- Fixed stop side on the right
- Paint gray RDS 240 80 05
- Motorized inlet ruler adjustable
- Inlet lock pneumatically controlled
- Upper pressure:
- Single rollers in 2 rows, arranged staggered
- Motorized height adjustment
- Position display and input centrally via the control
- Workpiece transport device:
- Transport chain with rubber pad, 80 mm wide
- Precision running and guiding surfaces
- Standard equipment with automatic Central lubrication for the transport chain
- Workpiece support with roller rail, extendable to approx. 600 mm
- Noise protection equipment, with individual extraction for the part to be joined
  - Collective extraction for aggregates and chip collection box for
  - Scraper chips - feed ; 8 - 18 m/min
- Feed max. with form milling machine ; 11 m/min
- Feed max. with form milling machine in conjunction with VKNR 4839 ; 14 m/min
- Working height ; 950 mm
- Pneumatic connection ; min. 6 bar
- Total length ; 5,760 mm

### 2. WORKPIECE AND EDGE PARAMETERS:

- Workpiece width min:
- For workpiece thickness 12-22mm ; 70 mm\*

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- 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; + 6 mm
- Edge 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
- Edge material strips ; 0.4 - 12 mm
- Edge cross section max.
- For strips ; 600 mm<sup>2</sup>
- If no radius is specified, R=2 mm is retracted and delivered
- For the provision of suitable materials  
(boards, edges, glue) the operator is responsible

### 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 horizontal, 2 motors (1 x constant, 1 x counter rotation), max. chip removal / stroke 3 mm
- Including jointing cutter set in DIA version

#### 3.2 BONDING UNIT A12

Consisting of:

WORKPIECE PREHEATING

QUICKMELT APPLICATION UNIT

- Melting unit and quick-change, small-volume Quickmelt application unit
  - Processing of PU glue granules with standard application units
  - Glue roller direction of rotation either synchronous or counter-rotation.
- Glue-  
temperature monitoring using an electronic thermostat

ADHESIVE REACTIVATION

- Infrared emitter to maintain the ideal adhesive temperature

MAGAZINE

- Automatic edge magazine for rolled goods and fixed lengths, including roller plates

PRESSURE ZONE WITH MOTOR ADJUSTMENT

- Pressure zone with driven, pneumatically operated main pressure roller and 3 free-running pressure rollers
- Equipped with motorized single-axis adjustment

#### 3.3 CUTTING UNIT BEVEL/STRAIGHT 2 X 0.35 KW

- For trimming the front and rear edge material overhang with a pulling cut.  
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 PNEUMATIC 2-POINT ADJUSTMENT CAPS

#### 3.6 MILLING UNIT 2 X 0.55 KW COUNTER-ROOT

- For milling the upper and lower edge material projection, vertically and horizontally groping.
- selectable from the control panel:  
2 working positions: flush and radius/chamfer milling

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- All actuating axes with digital counters for quick adjustment
- 2 motors each 0.55 kW, 200 Hz, 12,000 rpm.

3.7 PNEUMATIC 2-POINT ADJUSTMENT

- the vertical feeler rollers for switching between milling machines (with overhang)  
or on flush milling

3.8 PROGRAM ADJUSTMENT SIDE ROLLERS - for motorized and stepless  
Axis adjustment of the side feeler rollers to the edge thickness

3.9 EDGE THICKNESS ADJUSTMENT PROGRAM

- for motorized and stepless axis adjustment,

3.10 MOLDING UNIT 2 X 0.35 KW WD 60

- For shaping the front and rear edges of different profiles  
Including pneumatic 2-point chamfer/radius adjustment.  
2 motors each 0.35 kW, 200 Hz, 12000 rpm.

3.11 PROFILE PULLING BLADE WITH QUICK-CHANGE HEADS

3.12 PNEUMATIC ADJUSTMENT OF PULL BLADE

- For electro-pneumatic axial movement of the scraper unit

3.13 GLUE JOINT PULLING BLADE

- To remove adhesive residue in the area of the glue joint

3.14 BLACKING UNIT 2 MOTORS

- 2 motors 0.18 kW each, individually suspended, tilt and height adjustable

4.0 ELECTRONIC CONTROL POWER CONTROL PC 20+

BRANDT control system with color graphic user interface

5.0 ELECTRICAL EQUIPMENT

- Operating voltage 400 volts - 3Ph - 50Hz
- Control cabinet installed according to Euronorm EN 60204
- Electronic frequency converter with engine braking function

6.0 SAFETY AND PROTECTION DEVICES

- CE mark according to EC Machinery Directive 98/37/EU member countries

7.0 HOMAG GROUP QUALITY PACKAGE

8.0 DOCUMENTATION

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

G.0001 Number: 4876 1 x right

TOOL SET R = 2 MM

G.0004 Number: 0047 1 x right

EXTENSION OF INLET RULER BY 300 MM

G.0005 Number: 0048 1 x right

ADDITIONAL DEVICE LAMINATE SUPPORT FOR 0041

Additional rail for the adjustable inlet ruler

G.0010 Number: 0312 1 x right

OPTIMIZATION OF WORKPIECE DISTANCES

G.0013 Number: 0503 1 x right

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INTERIOR HOOD LIGHTING 2 LAMPS

G.0010 Number: 2215 1 x right  
Release Agent Application

G.0011 Number: 2068 1 x right  
Standard Application Unit, Interchangeable, PU Adhesive

G.0012 Number: 4901 1 x right  
Multiple Roller Probing, Fine Milling  
for use on acute-angled workpieces,

or on workpieces with single-sided hinge holes.

G.0013 Number: 2220 1 x right  
Cleaning Agent Application  
- Spray device for cleaning agents on the top and bottom edges of the  
workpiece.

G.0016 Number: 2620 1 x right  
Automatic Edge Feed  
for quick changing of different roller edges  
up to 3 mm thick.

Item No. 0101 Number: 4839 1 x right  
ADDITIONAL PRICE MULTIFUNCTIONAL MILLING UNIT VKNR 4809  
Top + bottom milling unit 2 x 0.35 kW VKNR 4803.  
For machining edge protrusions on the  
workpiece's top and bottom edges, as well as for  
corner copying of the front and back edges.

- Servo-controlled motion sequence with soft-touch function  
- 2 motors, each 0.4 kW, 200 Hz, 12,000 rpm with HSK 25 tool holder

Item No. 0104 Number: 4838 1 x right  
CHANGEABLE MILLING UNIT VKNR 4809

- 2 motors, each 0.4 kW, 200 Hz, 12,000 rpm, including touch probes.

N.0701 Number: 5767 1 x right  
SET OF QUICK-CHANGE HEADS FOR R - 1 MM

N.0704 Number: 5798 1 x right  
SPECIAL PRESSURE FOR DRAW BLADE VKNR 5760  
for use with acute-angled workpieces,

or with workpieces with hinge holes on one side.

D.01 Number: 8323 1 time  
DOCUMENTATION AND CONTROL TEXTS: GERMAN  
Scope of delivery:

1. Operating instructions, consisting of commissioning,  
operating and maintenance instructions on DIN A4 paper and CD-ROM
2. On-screen operating texts for machine operators, for the PC 20+ control  
system
3. Spare parts descriptions on CD-ROM