

Edge Banding Machine Homag  
Type Edgeteq S-200 Optimat KDF 130C  
Used machine – year 2020  
Machine number: 0-261-73-2803



**EDGETEQ S-200**

**Optimat KDF 130 C**

HOMAG SINGLE-SIDED EDGE BANDING MACHINE

Single-sided edge banding machine for processing straight workpiece edges and for gluing and reworking various edge materials in longitudinal and cross-passage.

MODEL: Model 1130 FC

**1. BASIC MACHINE:**

Continuous machine stand for setting up the processing units

Painting of the machine and safety fence posts in RAL 9003 signal white

Design strips, safety fence panels, safety doors and stele in RAL 7021 black gray

Noise protection equipment, with individual extraction for

joining part and units

Working height | 950 mm

Pneumatic connection | min. 6 bar

Machine length | 4605 mm

Floor conditions must correspond to the floor plan and extraction plan: 5701805400

Technical data refers to the standard version.

Options lead to changes in the connection values for electricity, extraction and air consumption.

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

When using edge material with

high-gloss surfaces, painted

surfaces, matt surfaces and

pressure-sensitive materials, we recommend

using suitable protective film on the edge material

**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 overhang | 38 mm

- Workpiece thickness | 60 mm

- Edge height max.= workpiece height | + 5 mm

- Edge material roll | 0.3 - 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 | 0.4-5.0 mm

- Edge cross-section max.

- For strips | 135 mm<sup>2</sup>

- When processing workpieces or edge materials

- without protective coating or

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- with matt surfaces or
- High-gloss surfaces can have shiny marks.

### 3. ELECTRICAL EQUIPMENT

- Operating voltage 400 volts - 3Ph - 50 Hz
  - 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
  - If mains voltage fluctuations exceed +/- 10%, a voltage stabilizer must be installed at the place of use
  - Specified ambient temperature: + 10 to + 40 °C
- If the machine drops below the standard connection voltage of 400 volts, an isolating transformer must be switched from the socket  
option list of the respective machine must be used.

### 4. SAFETY AND PROTECTIVE DEVICES

- EC conformity (CE) according to the currently valid Machinery Directive for

single machine operation

- Wood dust tested TRK value max. 2mg/m<sup>3</sup> when complying with the extraction performance to be provided by the customer

according to the installation plan

- The prerequisite for our warranty/product liability is the unrestricted compliance with the original operating instructions supplied with the machine, including the safety regulations.

### 5. 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

STANDARD NAME PLATE  
EQUIPMENT PACKAGES  
TOOL SET R = 2 MM  
BASIC PACKAGE V

- PNEUMATIC 2-POINT ADJUSTMENT OF PRESSURE ZONE

for electro-pneumatic adjustment of the

pressure zone to 2 different positions.

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Automatic adjustment to the different edge thicknesses preset by the digital counter.

- PNEUMATICS MILLING CHAMFER / RADIUS / STRAIGHT for electro-pneumatic conversion of the milling unit from chamfer to radius or straight.

Automatic adjustment to the different edge thicknesses preset by the digital counter.

- PNEUMATIC ADJUSTMENT form milling unit for electro-pneumatic lateral movement of the form milling unit to radius/chamfer

#### WORKPIECE HANDLING

##### INLET RULER

Stop side right

##### INLET RULER MANUALLY ADJUSTABLE

in connection with attached joining part

##### WORKPIECE SUPPORT BALL SLEEVE

- Continuous workpiece support on the operator side, which is guided in the chain track, in ball sleeves. Extension length:

S-200 series: min. 85mm - max. 310mm

S-240 series: min. 120 mm - max. 390mm

##### CONSTANT FEED 11M/MIN.

- Constant feed 11 m /min.

##### CHAIN TRACK CENTRAL LUBRICATION MANUAL

- Manual central lubrication of the chain track, consisting of 2 lubrication points on the chain track.

##### ROLLER TOP PRESSURE

Individual rollers in 2 rows, arranged offset

##### SMOOTH PU ROLLERS S-200-S-300

Instead of the standard grooved rubber top pressure rollers, smooth PU top pressure rollers are installed.

Used for particularly sensitive workpiece surfaces.

##### HEIGHT ADJUSTMENT MANUAL X10 - X70

- Top pressure with digital counter for manual adjustment of the top pressure to plate thickness.

##### APPLY FLUID AND PROCESS FORMAT

##### JOINING MILLING UNIT 2 X 1.4 KW 200 HZ

For attaching in front of the glued part

Height adjustment vertically

Electro-pneumatic control horizontally

2 motors (1 x synchronous, 1 x counter-rotating)

The maximum cutting cross-section depends on the material and

feed speed

Cover hood with suction nozzle diameter 80 mm

Max. workpiece thickness 60 mm

Workpiece thickness for max. chip removal

##### JOINING MILLING CUTTER SET 40MM

For use on jointing milling unit 2X0.75KW 200HZ

Joining milling set in DIA design

Diameter 100 x 44 x diameter. 25 mm, Z = 2

with double keyway 8 x 3 mm

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#### GLUING THE EDGE

##### STANDARD APPLICATION UNIT, SYNCHRONOUS

- Quick-change application unit
- Glue supply leak-proof underneath the glue roller
- Finely dosed glue application to the workpiece using the glue roller,  
no adjustment to workpiece thickness required
- Glue roller rotation direction in synchronous motion
- Glue temperature monitoring using an electronic thermostat
- Automatic glue temperature reduction when work is interrupted

##### BASIN COATING FOR EVA/PU HOT MELTS

- Special coating of the application unit for all types of adhesive, including PUR adhesive

##### Safety instructions:

When processing PUR, isocyanates are produced which lead to the OEL value being exceeded.

Therefore, measures must always be taken to remove the vapors, e.g. by means of suitable extraction.

The safety data sheets of the hot melt adhesive manufacturers must be observed!

##### GLUE CONTAINER ADJUSTMENT MANUAL

The application unit can be manually pulled out of the work area

##### EDGE MAGAZINE FOR ROLLS, FIXED LENGTHS

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

##### EDGE THICKNESS UP TO 3 MM

##### PRESSURE ZONE WITH 2 POST-PRESSURE ROLLERS S-200

- Pressure zone with driven main pressure roller and 2 free-running post-pressure rollers

- Equipped with digital counter for manual adjustment of the pressure zone to edge thickness

##### ADJUSTMENT TO EDGE THICKNESS PNEUMATIC

for electro-pneumatic switching of the pressure zone to 2 different positions.

Automatic adjustment to the different edge thicknesses preset by digital counter.

Included in the Basic package

#### POST-PROCESSING OF WORKPIECE

##### CUTTING UNIT 2 X 0.22 KW

- Equipped with 2 motors, 0.22 kW each, 200 Hz, 12,000 rpm, each equipped with a cutting saw blade.

- Saw blade diameter 100x32x2.6mm, Z=30

- Max. edge cross-section 360 mm<sup>2</sup>

##### PNEUMATIC ADJUSTMENT CUTTING BEVEL/STRAIGHT

For electro-pneumatic conversion of the cutting unit from bevel to straight.

#### MILLING UNIT

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- For milling the upper and lower edge material overhang.
- Height adjustment of the upper unit with the upper pressure
- 2 working positions: flush and radius/chamfer milling

MOTOR POWER 0.27 KW

- 2 motors with 0.27 kW each, 200 Hz, 12,000 rpm.
- Edge thickness max. 6 mm

COUNTER-ROTATION

MANUAL AGGREGATE ADJUSTMENT

- Manual unit adjustment to different edgethicknesses.
- For profiling MDF boards or already glued edges
- Manual adjustment with digital counter
- Individually adjustable at the top and bottom

PNEUMATIC ADJUSTMENT OF WORKING POSITIONS

for changing the milling unit from chamfer to radius or straight.

MANUAL SIDE SENSING ADJUSTMENT

- Manual adjustment of the side sensing rollers to the tool with digital counters.
- Enables a profile shift on the edge material.

MANUAL VERTICAL TRIGGER ADJUSTMENT

- Manual vertical tracing adjustment for switching between milling with material overhang on the top and bottom and face milling

1 ROLLER TRIGGER TOP AND BOTTOM

Standard equipment with 1 roller tracing for top and bottom

SWITCHING FINE MILLING UNIT - RADIUS/STRAIGHT

- For switching the lower milling motor from radius to straight.

For a different profile selection between the lower and upper milling motor.

TOOL FOR FINE MILLING UNIT

HM COMBI - MILLING CUTTER RADIUS

2.0 mm

SHAPE MILLING UNIT 1 X 0.35 KW

- For shape milling of front and rear edges for different profiles
- Wooden edges possible to a limited extent, depending on the edge material.
- Restrictions for loose middle layers on post-/softforming parts and extremely thin melamine/foil edges and surface materials
- Edge thickness max. 3 mm
- Workpiece length min. 250 mm
- Feed speed max. 11 m/min

WORKPIECE THICKNESS UP TO 60 MM

PNEUMATIC 2-POINT ADJUSTMENT RADIUS/CHAMFER

For the 1-motor shape milling unit.

Pneumatic adjustment of the shape milling unit

to two preset working positions:

Position 1 = radius milling (e.g. PVC/ABS/PP)

Position 2 = chamfer milling (thin edge/HPL/melamine)

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Presetting of the working positions via digital counters.

#### CONSTRUCTION FLOORS

- For vertical corner processing of construction or shelves, where prior gluing of the cross edge is not necessary.

TOOL FOR FF6210

DIA COMBI - MILLING CUTTER RADIUS

2.0 mm

PROFILE DRAWING BLADE ZK6420

- For chamfering or rounding pre-milled PVC edges

- Scanning from above, below and to the side.

- Max. edge thickness 3 mm.

- Height adjustment of the upper device with the upper pressure

PNEUM. ADJUSTMENT OF DRAWING BLADE

For electro-pneumatic lateral movement

of the scraping blade units

TOP + BOTTOM FEEDER ROLLERS

Standard equipment with feeler roller for top and bottom

SET OF TOOL HEADS WITH HM DRAWING STEEL

HM DRAWING STEEL RADIUS

2.0 mm

GLUE JOINT DRAWING 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 2 WPL reversible knives

- incl. suction

BUFFERING UNIT 2 MOTORS

- For making the edges grippy at the top and bottom.

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

- Height adjustment of the upper motor with the top pressure

- 2 molleton discs diameter. 120 x 20 mm

#### ENERGY AND CONSUMABLES

INSTALLATION ACCORDING TO DIN EN 60204

- Control cabinet including control cabinet components installed according to European standard EN 60204

#### CONTROL MACHINE

CONTROL SYSTEM 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

for intuitive operation of the machine

- Display of the main machine target and actual states

- Integrated route control for

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contactless control of processing functions.

- Easy selection and correction of route points
- Intelligent production readiness display using traffic light function
- Online language switching between various foreign languages
- Machine data acquisition to display important production figures such as number of pieces, production time and edge consumption
- Status messages in plain text
- Up to 20 processing programs can be saved

#### DISPOSAL

##### CHIP COLLECTION BOX

Chip collection box for scraper chips with

suction nozzle diameter 100 mm.

#### DOCUMENTATION

##### LANGUAGE SELECTION GERMAN

- Screen operating texts for machine operators in German

##### DOCUMENTATION ON DATA MEDIUM

(Data format PDF)

- Operating instructions consisting of operating and maintenance instructions
- Spare parts designations
- Circuit diagrams

##### DOCUMENTATION ON PAPER

(folder, A4 paper)

- Operating instructions consisting of operating and maintenance instructions