

Edge banding machine Homag – single side
Type: KAL 211 Edition 2262 + ZHR 05
Used machine - year 2012
Machine number: 0-200-22-7648



KAL 211 Edition 2262

HOMAG SINGLE-SIDED EDGE BANDING MACHINE

OVERVIEW OF THE UNIT EQUIPMENT:

- RELEASE AGENT SPRAY UNIT
- JOINTING MILLING UNIT
- GLUING PART A6 WITH 2 ROLLERS
- PREPARATION FOR LASERTEC ACTIVATION UNIT
- TRIMMING UNIT HL81
- PRE-MILLING UNIT BF10
- SHAPE MILLING UNIT FK11 MANUAL
- PROFILE DRAWING BLADE PN10
- FINISHING UNIT

1. BASIC MACHINE:

- Continuous machine stand for setting up the processing units
- Fixed stop side on the left
- Painted in gray RDS 240 80 05
- Adjustable infeed ruler
- Pneumatically controlled infeed lock
- Top pressure:
- Driven by composite V-belt
- Height adjustment manual
- Digital position display
- Workpiece transport device:
- Transport chain with rubber pad, 80 mm wide
- Hardened precision running and guide surfaces
- Magnetically braked transport chain
- Workpiece support with roller rail, extendable by approx. 800 mm
- Noise protection for joining and aggregate parts with individual extraction
- Feed rate | 18 - 25 m/min
- Max. feed rate with FK11 | 20 m/min
- Working height | 950 mm
- Pneumatic connection | 6 bar
- Total length | 7845 mm
- Floor conditions must correspond to the floor plan and extraction plan, no.: 5-026-01-4000

2. WORKPIECE AND EDGE PARAMETERS:

- Workpiece width without edge min:
- For workpiece thickness 12-22 mm | 60 mm*
- For workpiece thickness 23-40 mm | 105 mm*

*Depending on the workpiece length

- Workpiece projection | 30 mm
- Workpiece thickness | 12 - 40 mm

(workpiece thickness optional) | 8 - 60 mm

- Edge height max.= workpiece thickness | + 4 mm

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- Edge material roll | 0.3 - 3 mm
 - Edge cross section max: |
 - For PVC | 135 mm²
 - For veneer | 100 mm²
 - Roll diameter max. | 830 mm
 - Edge material strip | 0.4 - 6 mm
- If no radius is specified, R=2 mm is retracted and delivered.
- The machine operator is responsible for the use of suitable materials (panels, adhesives, edges, cleaning agents, paints, etc.)

3. EQUIPMENT

RELEASE AGENT SPRAYING UNIT TOP/BOTTOM:

JOINING MILLING UNIT:

- 2 motors each 4 kW, 200 Hz., 12000 rpm
 - Electro-pneumatic control of both motors
 - Workpiece blow-off device
 - Tools included:
- 2 I-DIA joining cutter heads D=100 x 48 x 30 mm,
KN, Z=2+2+2+2

GLUING UNIT A6 WITH 2 ROLLERS:

Consists of:

WORKPIECE PREHEATING

QUICKMELT APPLICATION UNIT

MAGAZINE 2 ROLLS MANUALLY

PRESSURE ZONE C

- 1 driven pre-press roller, diameter 150 mm
- 6 post-press rollers, diameter 70 mm

PREPARATION FOR LASERTEC ACTIVATION UNIT

CUTTING UNIT HL81 BEVEL/STRAIGHT 0.8 KW:

- 2 motors each 0.8 kW, 200 Hz., 12000 1/min
 - Pneumatic adjustment for converting from bevel to straight cutting
 - Tools included:
- 2 HM cutting saws with HSK25, diameter. 120 mm

PRE-MILLING UNIT BF10 0.55 KW:

- Tools included:
- 2 I-HM milling cutters 70 x 25 mm, HSK25, Z=4

FORM MILLING UNIT FK11 MANUAL:

I-INTERCHANGEABLE HEAD SET MANUALLY ADJUSTABLE
- 2 interchangeable heads

- Tools included
- 2 I-DIA chamfer/radius milling cutters base diameter

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62 mm, Z=4 with integrated chip collection
for chamfer 15° and R=.. mm

PROFILE DRAWING BLADE PN10:

- Tools included:
- 2 quick-change heads with WPL profile knife for R=.. mm

FINISHING UNIT:

- GLUE JOINT DRAWING BLADE
- BUFFING UNIT

powerControl PC22:

Modern control system based on
Windows PC

Hardware:

- PLC control according to international standard IEC 61131
- Integrated path control for contactless control of the processing units
- Modern industrial PC with operating system Windows XP and Intel CPU
- 17 inch TFT flat screen with touch screen
- 1 hard drive permanently installed
- 1 hard drive for data backup (option)
- USB connection

Software:

- woodCommander software package
- Operator control system (BDL)
- Error message in plain text
- WoodScout diagnostic system (option)
- Schuler MDE Basic for machine data acquisition

TeleServiceNet

ELECTRICAL EQUIPMENT:

- Operating voltage 400 volts, 50/60 Hz.
- Electronic frequency converter with motor brake function

SAFETY AND PROTECTIVE DEVICES:

- EC conformity (CE)
- Wood dust tested TRK value max. 2 mg/m³

HOMAG QUALITY PACKAGE:

- TÜV certificate according to DIN EN ISO 9001:2000
- Energy saving function:
- ECO Plus button to start stand-by

operation,

- Modern, decentralized control system with passive cooling

DOCUMENTATION

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SLIDING CARRIAGE

- For inserting the workpieces at right angles

WORKPIECE THICKNESS 8 MM KAL200/300/KFL500

REMOTE CONTROL FOR AMBITION/EDITION

The following functions can be selected

- Setup mode
- Feed start
- Emergency stop switch

PRE-INSTALLATION FOR BOOMERANG ZHR05

CLEANING AGENT SPRAY UNIT TOP/BOTTOM

AUTOMATION PACKAGE 1: AMBITION/EDITION 2262

- Pneumatic adjustment of the cutting motors for flush or overhang cutting
- Pneumatic adjustment FA11 for lateral

moving away from the work area

AUTOMATION PACKAGE 2: AMBITION/EDITION 2262

- Automatic adjustment of pressure zone
- Pneumatic adjustment of the cutting motors for flush or overhang cutting
- Pneumatic adjustment of pre-milling unit for flush or overhang milling
- I-replacement head set automatically adjustable for FK unit instead of manual Interchangeable head set

ELECTRONIC HEIGHT FPR/L260+EDITION

BACKUP HARD DRIVE USB 2.0

- external mobile hard drive with USB 2.0

DIAGNOSTIC SYSTEM WOODSCOUT FOR VENT./AMBI./EDITION

DOCUMENTATION AND CONTROL TEXTS: GERMAN

Workpiece return ZHR05/L/075

Return ZHR05 - BOOMERANG (R) - Optimat

for standard parts

Layout: Standard 5-012-70-0182

Technical data of the basic machine

Make: Homag
Type: KAL210 Ambition2262
Machine length: 7,845 mm
Stop side: left
Working height: 950 mm
Feed: 18 - 25 m/min

Function:

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Workpieces coming out of the machine are taken over by driven chain booms with the support of a driven roller and guided onto an air table. The workpiece slides onto a conveyor belt using a pusher and the inclination of the air table and is then transported further. At the end of the return path, the workpiece is fed to the operator on a non-driven roller conveyor. For flexible use, the machine can be operated in four working modes as standard: - Air table always lowered without pusher operation - Air table always lowered with pusher operation - Air table in lifting mode (when taking over from above, then lowering) with pusher operation - Air table always at the top for manual removal (no return of parts) Design: ----- Air table: L=2500 mm, W=1000 mm (inclined with height difference of approx. 65 mm) Conveyor belt: W=900 mm Undriven roller conveyor: L=2500 mm, W=900 mm Workpiece parameters: ----- Length: 300 ... 2500 mm Width: 60 ... 800 mm or Length: 300 ... 800 mm Width: >800 ... 2000 mm

- Thickness: 8 ... 60 mm
- 4-sided processing:
- min. part size: 300 x 300 mm
- max. part size: 2000 x 800 mm
- Weight: max. 50 kg

Technical parameters:

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- Working height: 820 to 980 +/- 30 mm
 - Feed: 8 - 30 m/min
 - Automatic feed adjustment integrated:

Pneumatics:

Operating pressure: 6 bar
Air consumption: 50 Nl/min

Electrics:

Control: Moeller micro control
Remote control from the inlet of the base machine.

Operating voltage: 400 V, 50 Hz
(Different voltage must be specified!)
Control voltage: 24 V DC (according to VDE)
Total connected load: approx. 2.2 kW
Specified
ambient
temperature: +5 ... +35 degrees Celsius

Paint: Robustik structural paint
----- gray RDS 240 80 05
(see option 4500, 4502)

Floor requirements:

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- Tensile/compressive load
 - Normal concrete C16/20 XC1
 - Minimum thickness 180 mm

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Certification:

Machine with CE mark in accordance with EC Machinery Directive 2006/42/EC.

The machine complies with the statutory
accident prevention regulations (UVV).

Number 0052 11 x left
WIDENING OF RETURN DISTANCE TO 1100 MM

- Conveyor belt ZTB200
- Frame width 1200 mm

Extension of the working width from 800 to 1100mm

ROLLER BAR, CANNOT BE LOWERED

BELT CLEANING (EASY)

DOCUMENTATION AND CONTROL TEXTS: GERMAN