

Weeke BHX 500 with hedgehog buffer in the inlet

Used machine: built in 2007

Machine number: 0-250-04-2890

Available: approx. March 2024

G.00 HEDGEHOG BUFFER

Horizontal hedgehog buffer system, for manual
Inserting workpieces

Workpiece dimensions:

- Length: 250 - 3,000 mm
- Width: 100 - 1,000 mm
- Thickness: 12 - 80 mm

Technical details:

- Number of buffer spaces: 30
- Length overall: approx. 5,700 mm
- Usable width: approx. 2,000 mm
- Transfer height: approx. 950 mm
- Removal height / receipt height: approx. 1,120 mm
- Pitch: approx. 125 mm
(clear width between the bars: 103 mm)
- Pads with brushes
- Number of rods per holder: 7
- Inclination of bars: 5°
- Drive: geared motor 400 V/50 Hz
- Brush strip as a support along the removal
or receipt page.
- Paint: Robustik textured paint gray

RDS 240 80 05

G.0001 1 piece

MANUAL PROCESSING UNIT HEDGEHOG BUFFER

-consisting of stable subframes with 4
mounted flanged wheels for manual

Moving from the working position lengthways to the
Direction of conveyance.

- Displacement distance approx. 1,500 mm
- Running rails suitable for dowelling on the
Floor
- Mechanical locking of the working position

G.00 OPTIMAT BHX 500

CNC controlled machining center

1 BASIC MACHINE

- stable steel frame construction
- 2 workpiece collets with integrated stop system
- Separate movement of the collets
Rack drive in X direction
- Digital AC servo motors
- Position of the collets on the workpiece is program-controlled

- Gripping the workpiece collets between each one
Editing steps in the editing area are possible
- Automatic workpiece thickness measurement in the collet
Integrated

1.1 EDITING SUPPORT BELOW

- Stable cast aluminum construction
- Integrated three-part support table
with switchable air cushion
- Side stop system
- Movement of the axes in the Y and Z directions
- Ball screw (Z direction) and rack drive (Y direction)
- Digital AC servo motors
- Designed for the addition of different equipment variants

1.2 EDIT SUPPORT ABOVE

- Stable cast aluminum construction
- Integrated triple-divided pressure bar
with switchable air cushion
- Movement of the axes in the Y and Z directions
- Ball screw (Z direction) and rack drive
(Y direction)
- Digital AC servo motors
- Designed for the addition of different equipment variants

1.3 WORKPIECE DIMENSIONS

Min. workpiece length: 200 mm
max. workpiece length: 2500 mm
Min. workpiece width: 70 mm
max. workpiece width: 1000 mm
Min. workpiece thickness: 4 mm
max. workpiece thickness: 80 mm
Max. workpiece stacking: 2 pieces.

1.4 WORKPIECE AREA

- Air cushion table made of stable frame construction
- Hornite plate surface with touch valves
- integrated fan

1.5 WORKPIECE REMOVAL AREA

- Cross belt conveyor made of stable frame construction
- 8 transport belts driven with frequency control
- 8 electro-pneumatically controlled lifting wings
with integrated universal wheels

2 CE SAFETY AND PROTECTION DEVICE

- Protective grille in the side and rear areas
- Safety mats in the insertion area

3 DOCUMENTATION

- Documentation in printed form and on CDROM
including spare parts catalog and circuit diagram

4 PAINT

- Paint gray RDS 240 80 05

5 CENTRAL EXTRACTION

- For connection to an extraction system
- Refer to the technical data sheet for connection dimensions

6 ELECTRICAL EQUIPMENT

- Free-standing control cabinet
- Refer to the technical data sheet for connection dimensions

7 ELECTRONICS

7.1 HARDWARE

- CNC control including drive modules
- Intelligent control system while the CNC control the Processing controls, new data can be created independently on the PC be entered
- PC (personal computer) for operator guidance
- Intel Pentium compatible
- English operating system Windows XP embedded
- 15 inch TFT graphic monitor
- at least 512 MB of RAM memory
- at least 40 GB of hard disk space (different partitions)
- 3 1/2 inch floppy drive
- Network (EtherNet) is optionally available onboard. Additional PCI slots enable additional network cards
- Serial interface for barcode, modem or ceiling laser
- Parallel interface for printer connection
- CD-ROM drive for reading and writing Suitable for CDs (no guarantee of dust protection)
- USB port on the control panel
- HAND TERMINAL
Hand terminal with potentiometer and emergency stop switch.

7.2 SOFTWARE FOR POWERCONTROL SYSTEM

WOODWOP - Version 5.0

woodWOP is the workshop-oriented one Programming system (WOP) from the Homag Group. A uniform data format enables exchange between all CNC machines in the HOMAG Group.

MACHINE DATA COLLECTION (MDE)

Information about maintenance intervals

PRODUCTION LIST

Creation of production processes in list form
Active list items can be parallel or be processed serially.
Definition of up to 10 variables for the Variant production.

7.3 SOFTWARE FOR EXTERNAL PC

WOODWOP

Installation for an external PC
e.g. in work preparation.

7.4 PROVISION OF TELESERVICE, MODEM

Activating the teleservice capability of a machine.
Includes a modem as well as the free
Use of teleservices within the guarantee period.
For use after the warranty period has expired
a teleservice contract is required.

G.0001 Number: 0025 1 piece
CONFIG 2V32, 2H8X/2Y, N2 X-Y 90, F2-ETP-6 KW

2V32 HIGH SPEED 7500

Vertical drilling unit arranged in each case
upper and lower machining support with each
32 drilling spindles (can be controlled individually with
variable speed range).
Spindle clamping to safely reach the drilling depth.
Advance stroke Z direction: 60 mm
Drilling depth: max. 38 mm
Direction of rotation: right/left
Speed: 1,500 - 7,500 1/min frequency controlled
Drive: 2 x 2.7 kW
Drill holder: d = 10 mm
Total drill length: 70 mm
Spindle distance: 32 mm
Spindle type: individually controllable

2H8X/2Y

Horizontal drilling unit arranged in the upper
and lower processing support with 10 over each
Program for drilling spindles that can be accessed individually.
8 drilling spindles each: in the X direction
2 drilling spindles each: in Y direction
Drilling depth: max. 38 mm
Drilling height Z direction: 38 mm from the top edge of the
workpiece
Direction of rotation: right/left
Speed: 1500 - 7500 1/min frequency controlled
Drill holder: d = 10 mm
Total drill length: 70 mm
Spindle type: individually controllable
Note: Horizontal drilling spindles in the Y direction only for
drilling into the workpiece edge opposite the machine zero line.

N2 X-Y 90°

Groove saw unit arranged in the upper and lower machining supports
for machining
Can be swiveled 90° in the X-Y direction.
Cutting depth: 30 mm
Cutting cross section: max. 70mm²

Speed: 1,500 - 7,500 1/min frequency controlled
Tool diameter: 125 mm
Saw blade thickness: max. 5 mm

F2-ETP-6 KW

Milling unit arranged in the upper and lower machining supports suitable for holding shaft tools.

Manual tool change.

Tool holder: for shaft diameter $d = 25$ mm

Tool weight: max. 2.5 kg

Tool feed: manual, hydro quick clamping system ETP 25

Direction of rotation: right/left

Speed: 6,000 - 18,000 1/min continuously programmable

Drive: frequency-controlled three-phase motor

Max. power on the tool: up to 5/6 kW in continuous/
Intermittent operation (S1/S6-50%)

G.0004 1 piece

SUPPLEMENT TO THE GROOVE SAW BLADE

The saw blade width can be 8.4 mm.

The cutting cross section must not exceed 70mm^2 .

The saw blade must correspond to the standard mounting flange.

G.0007 Number: 3934 1 piece

EXTRA PRICE EXPANSION PACKAGE VERTICAL DRILL SPINDLES
FOR EQUIPMENT VKNO. 0025

4 additional drilling spindles that can be accessed individually
lower processing unit

4 additional drilling spindles that can be accessed individually
upper processing unit

G.0010 1 piece

EXPANSION OF THE PROTECTIVE GRID SYSTEM,
including additional safety mat.

G.0013 Number: 3407 1 piece

INSERT TABLE WITH AUTOMATIC WORKPIECE FEEDING AND POSITIONING

- Cross belt conveyor made of stable frame construction

- Transport belt driven with frequency control

- Insertion table divided into two sections in terms of control
technology

- first section suitable for manual or automatic
Inserting workpieces

- second section equipped with integrated alignment unit
for the longitudinal and transverse edges of the workpiece

- The placed workpieces are automatically removed from the first
Transfer section to the second section. Through the integrated

The workpieces are fed to the clamping system using the alignment
unit

and aligned with the machine stop system

- The first section can be used while machining a workpiece
be loaded with another workpiece.

- Workpiece width and length control +/- 5 mm

- The maximum width of the workpieces in the processing area and is to be reloaded, must not be 1000 mm exceed. The workpiece dimensions from the basic machine change as follows:

Item:

Workpiece length: min. 250 mm

Workpiece width: min. 100 mm

max. 1000 mm

- with machining restrictions: 1300 mm

Double part: Workpiece length: min. 300 mm

Workpiece width: min. 150 mm

max. 1000 mm

- with machining restrictions: 1300 mm

E.0001 1 piece

INTEGRATION INTO THE MACHINE CONTROL

- Integration of another system element into the machine control.

E.0004 1 time

LENGTH MEASURING IN THE MACHINE.

Components are secured using a torque/longitudinal stop
Measuring length.

The result is included in the length-dependent processing.

E.0007 Number: 6500 1 piece

MOVABLE OPERATING TERMINAL ON A 10M LONG CABLE

Length up to 20 m on request (see installation plan)

E.0010 Service: 6625 1 time

BARCODE SOFTWARE (BARCODE CONTROL)

The software 'Woodscan' for scanning the processing program name connects a scanner from Datalogic to the
Sales no. 6620

Other requirements can be agreed upon
and effort can be realized. The hardware is
not included in this item.

This can be done by customer-specific agreement
Software can also be used in stationary machines.

E.0013 1 time

CUSTOMIZATION OF WOODSCANN

Data structure

D.0007 Service: 8321 1 time

DOCUMENTARY AND CONTROL TEXT: GERMAN

Scope of delivery:

1. Operating instructions
consisting of operating and maintenance instructions
on DIN A4 paper and CD-ROM
2. Screen operating texts
for machine operators, for the controls
IPC, MCC and BST control surfaces

3. Spare parts names
consisting of CAD drawings and circuit diagrams
on CD-ROM
- Delivery time: With machine delivery