

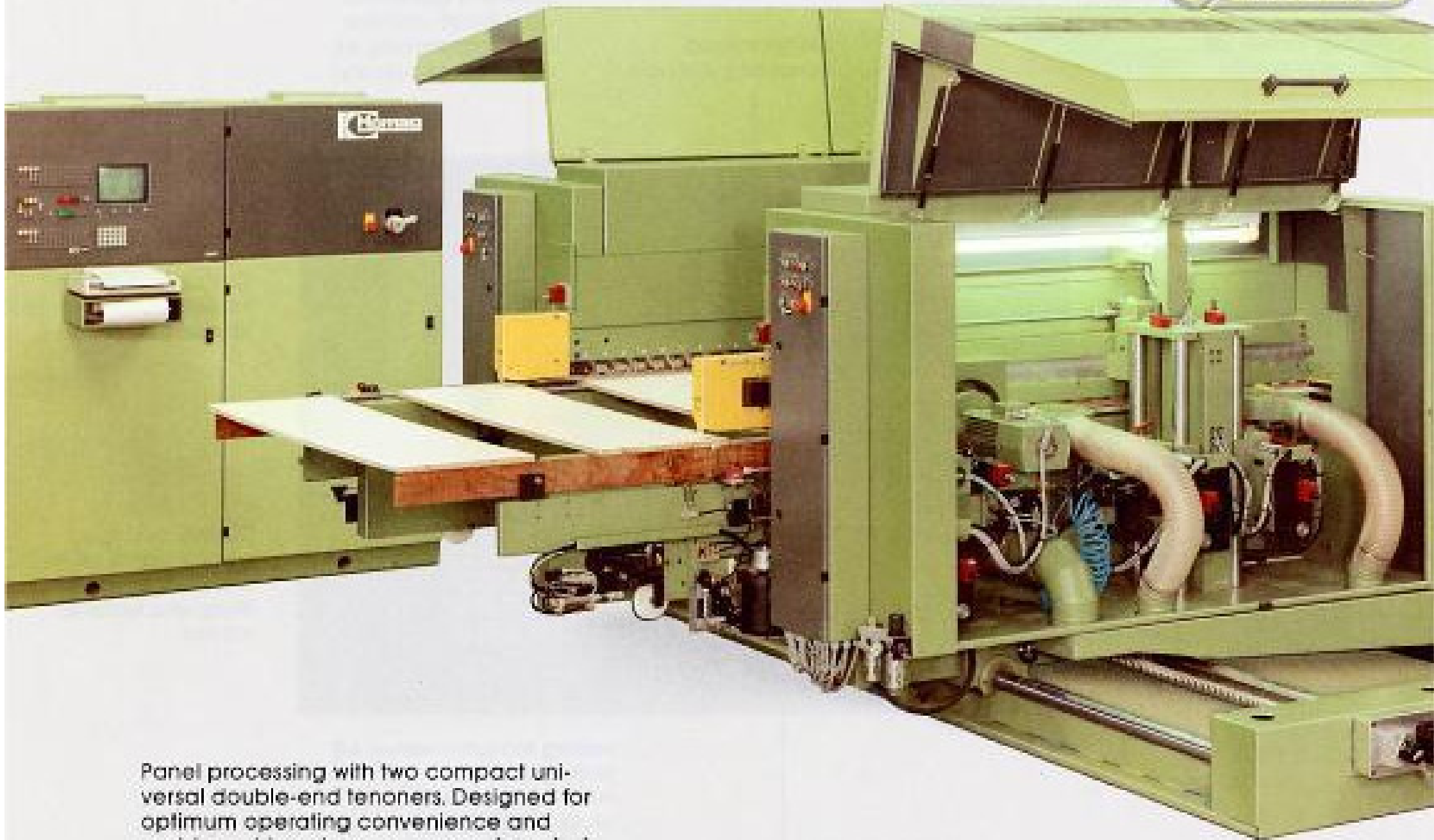
# Optimat Double-End Tenoner FLO 22 - FLO 23

X-FACTORY

The new double-sided machine generation  
for perfect sizing and edge processing.



Panel processing using two compact,  
universal double-end tenoners.  
For optimum ease of operation and fast  
manual machine resetting.



Panel processing with two compact universal double-end tenoners. Designed for optimum operating convenience and rapid machine changeover – **automated (electronic)**



## Perfect sizing the Homag way

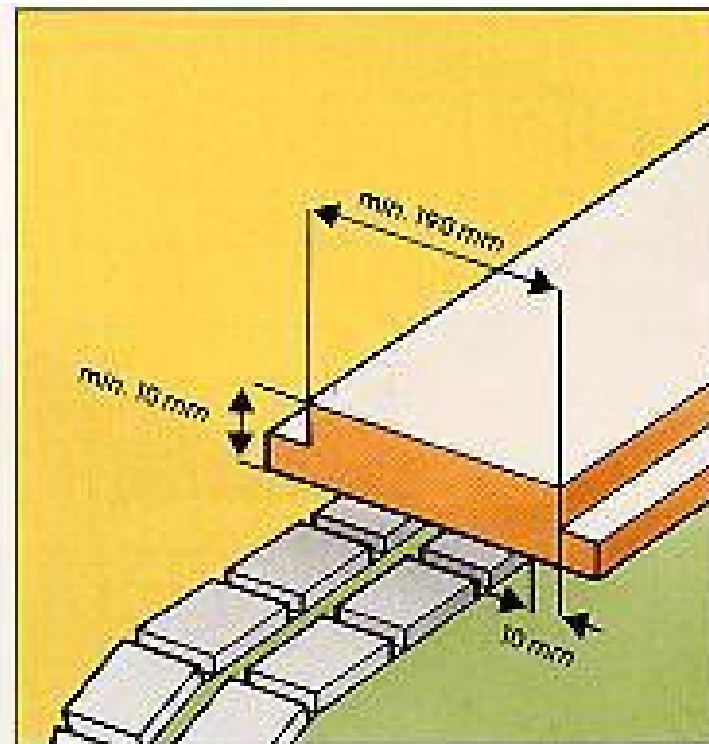
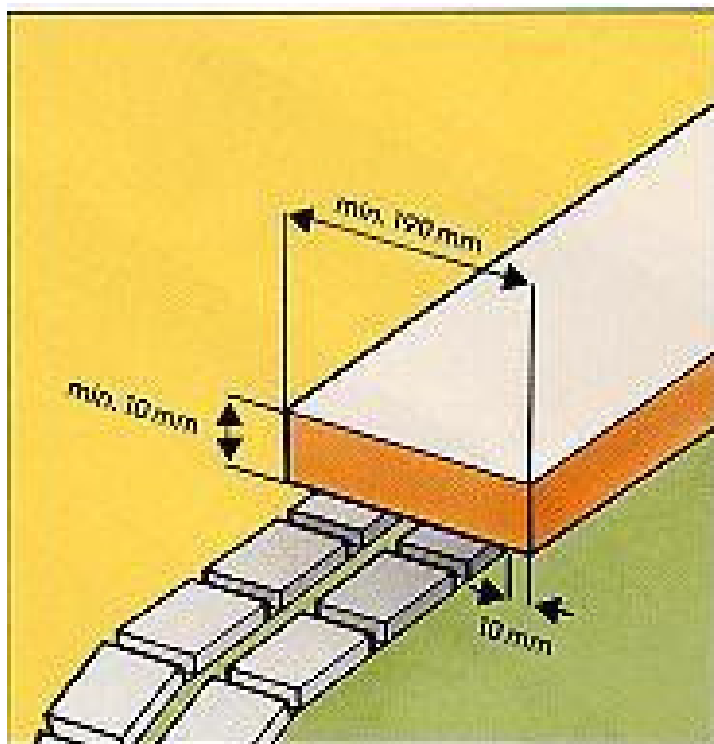
A decisive factor in the development of this new sizing machine generation was the demand for increased operating convenience and rapid machine changeover alongside maximum operating reliability. The result is a **compact basic machine** with a heavy central machine bed. The two sides of the machine mounted on the central bed are made of a single casting and also incorporate the supports for the individual units. The **chain tracks**, 80 mm wide and the top pressure, distortion-resistant, guarantee reliable and exact workpiece guidance.

**Adjustment of the top pressure** is carried out at the machine infeed, and positioning is effected using two mechanical digital counters.

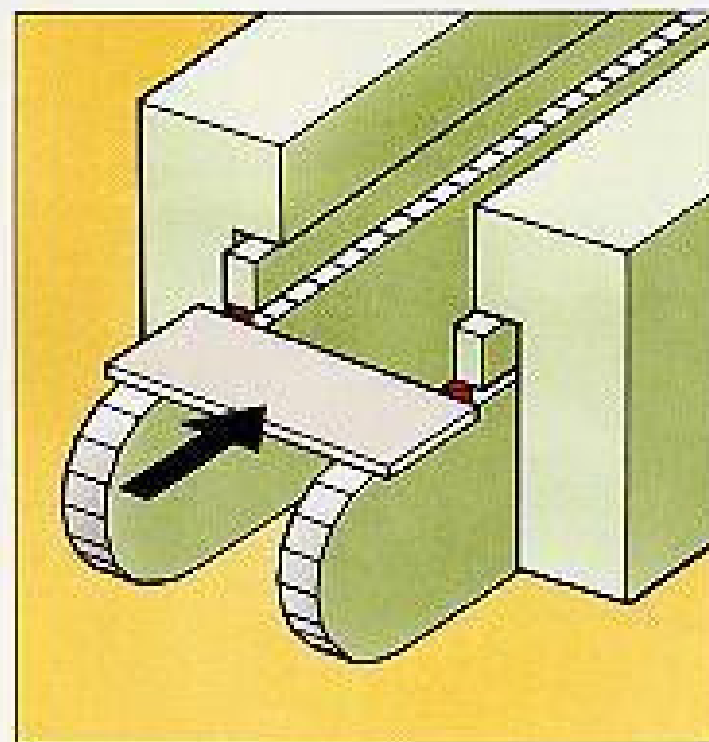
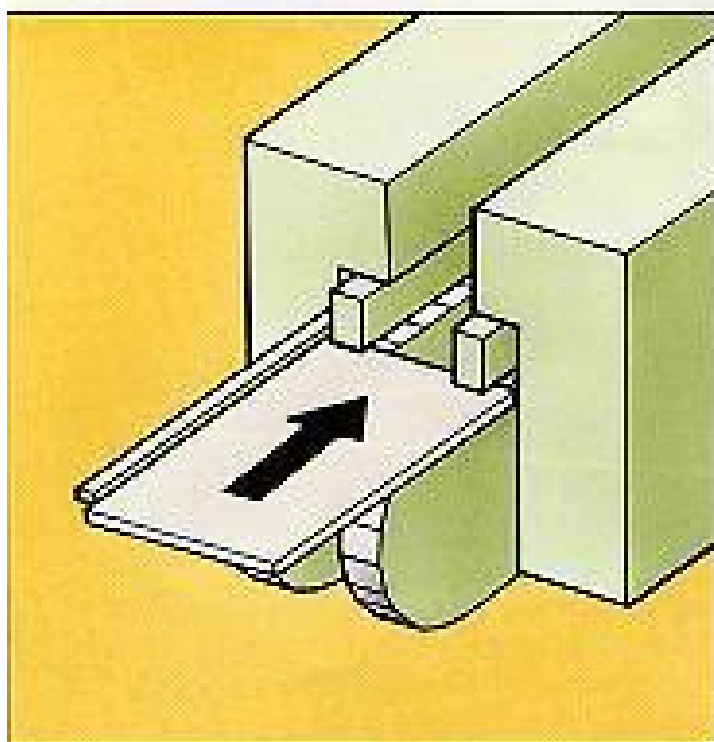
The **cams** are infinitely adjustable to four height positions up to a maximum of 20 mm, and can be automatically lifted and lowered using selector switches. The FLO 22 has a cam spacing of 900 mm, the FLO 23 of 1000 mm.

The **feed speed** is 5–25 m/min.

In the standard version, the **switch cabinet** including the entire control panel is mounted on the left-hand side of the machine.



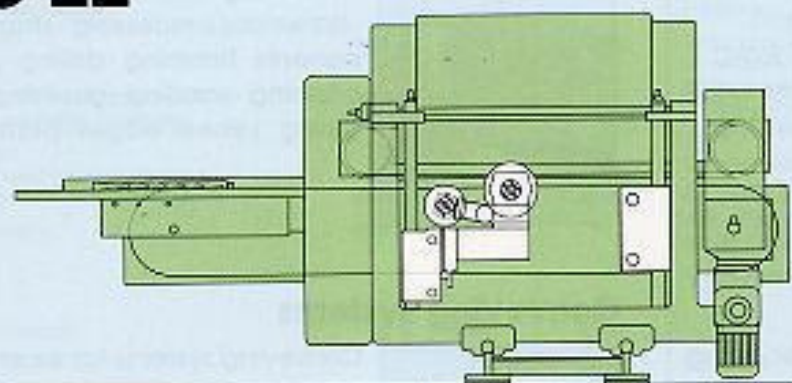
The maximum working width is fixed at 2600 mm. Width adjustment is motor-driven and operates at a rate of approx. 3 m/min in rapid gear. The working width is indicated on an LED display.



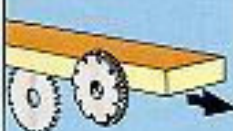
**The working method:**  
**Lengthwise processing:** Without cams – guidance at the infeed fence.  
**Crosswise processing:** Workpieces are pushed from behind against the cams and aligned at right angles.



# FLO 22



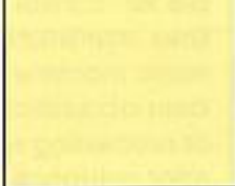
Scoring/Hogging



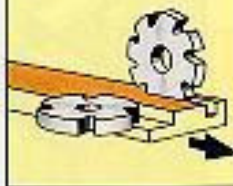
Free space for one optional unit



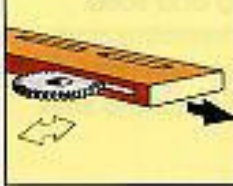
Options



Standard trimming unit

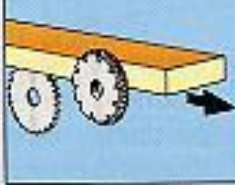


Controlled standard trimming unit

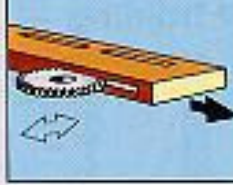


# FLO 23

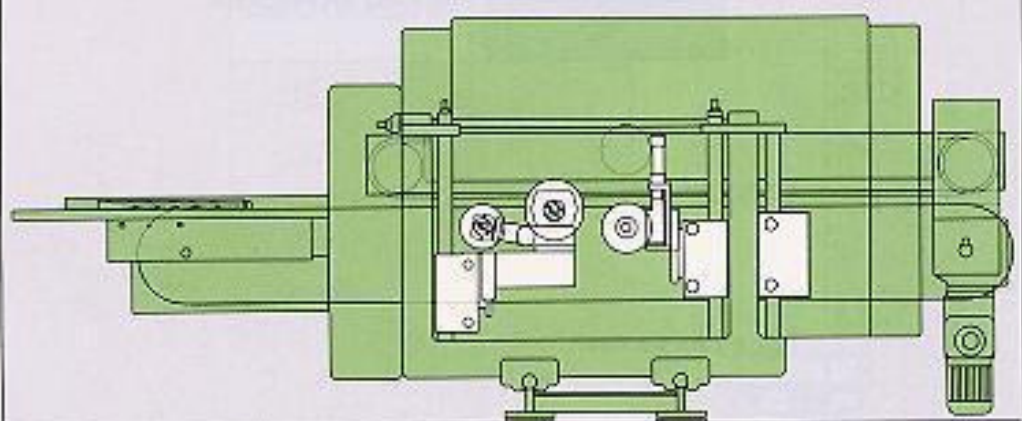
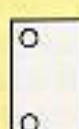
Scoring/Hogging



Controlled standard trimming unit



Free space for one optional unit



## The processing units:

The units were developed with a view to achieving the following criteria:

- Rapid machine changeover
- User convenience
- Ease of maintenance
- High resistance to wear

## Scoring/Hogging

Sizing unit for processing veneer and plastic coated panel materials free of tearing, even with banded crosswise edges. The entire unit can be swivelled to permit processing of inclined edges.

Prescoring unit:

Capacity: 1.5 kW, 100 Hz, speed 6000 rpm, motor shaft dia. 30 mm KN.

Hogging unit:

Capacity: 4.5 kW, 100 Hz, speed 6000 rpm, motor shaft dia. 35 mm KN, 15° swivel range with 60 mm workpiece overhang.

## Standard trimming unit

Sizing unit for grooving, rebating and profiling on top and bottom surfaces of veneered and plastic coated panel materials. Also for processing solid wood components and producing tongues on panel edges. The molar with reversing switch can be swivelled up to 90° for optional horizontal or vertical processing.

Capacity: 4.5 kW, 100 Hz, speed 6000 rpm, motor shaft dia. 35 mm KN, max. tool dia. 200 mm.

## Controlled standard trimming unit

Sizing unit for intermittent trimming of grooves and rebates on panel edges and surfaces, as well as all other functions of a fixed trimming unit. Swivel range up to 90° possible.

Capacity: 4.5 kW, 100 Hz, speed 6000 rpm, motor shaft dia. 35 mm, max. tool dia. 200 mm, intermediate support with round guides.

Note: All motors with motor brake.

**Optional extras  
FLO 22-FLO 23:**

	Function and description	
<b>FLO 22 and FLO 23</b>	● Basic electronic equipment*	<p>*Electronics are the most important elements in case of additional options and consist of:</p> <ul style="list-style-type: none"> <li>● Basic electronics with programmable control (SPS)</li> <li>● Monitor input</li> <li>● Line control</li> <li>● Electronic width adjustment (3 m/min)</li> <li>● Software for 3 programs</li> </ul> <p>The described facilities for automation offer optimum adjustment of the machine to flexible production systems, for example as part of a Just-In-Time production set-up for interior work.</p>
	● Servo axis for width adjustment	
	● Electronic height adjustment	
	● Stepless vertical axis	
	● Stepless horizontal axis	
	● Customer-specific software	

**The advantages of the monitor input NC 20:**

Display lamps for processing units

Rapid error detection with error signal display

Easy recognition of motor status

Standardized operating symbols

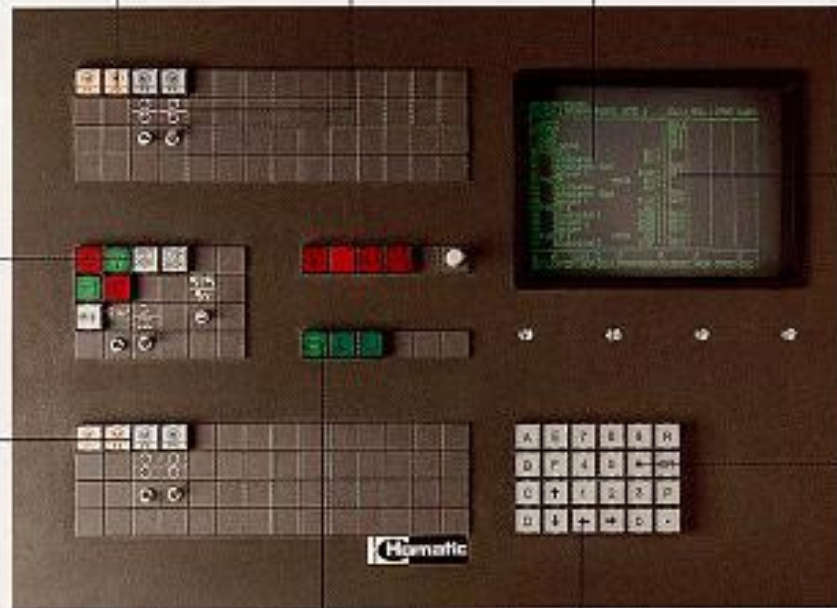
Operator guidance on a 9-inch monitor (no programming experience necessary)

Customer-specific screen lay-out in four languages

Clearly arranged control panel for the monitor's programming and function modes

Enables displays for the machine's main functions

Rapid program modification with cursor keys





### Basic Equipment:

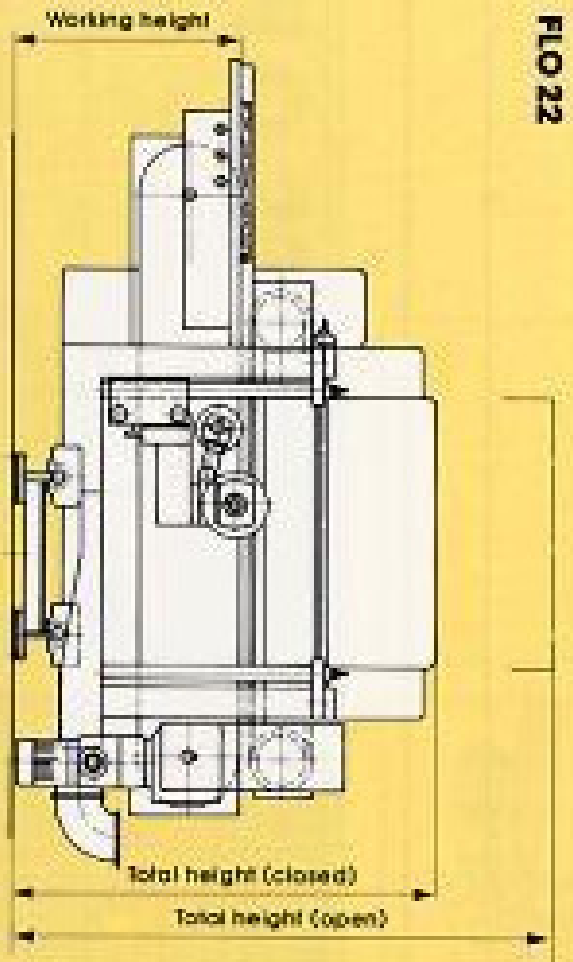
	Function	Description
FLO 22	Scoring/Hogging	<ul style="list-style-type: none"> <li>● Manual positioning</li> <li>● Free from backlash vertical and horizontal adjustment</li> <li>● 15 degree swivel facility</li> </ul>
	Free space	for one unit without pre-installation
	Noise protection	with central extraction suction
	Width adjustment	motor-driven, rapid and slow gear with LED display

FLO 23	Scoring/Hogging	<ul style="list-style-type: none"> <li>● Manual positioning</li> <li>● Free from backlash vertical and horizontal adjustment</li> <li>● 15 degree swivel facility</li> </ul>
	Controlled standard trimming	<ul style="list-style-type: none"> <li>● Manual positioning</li> <li>● Free from backlash vertical and horizontal adjustment</li> <li>● 90 degree swivel facility</li> </ul>
	Free space	for one unit without pre-installation
	Noise protection	with central extraction suction
	Width adjustment	motor-driven, rapid and slow speed with LED display

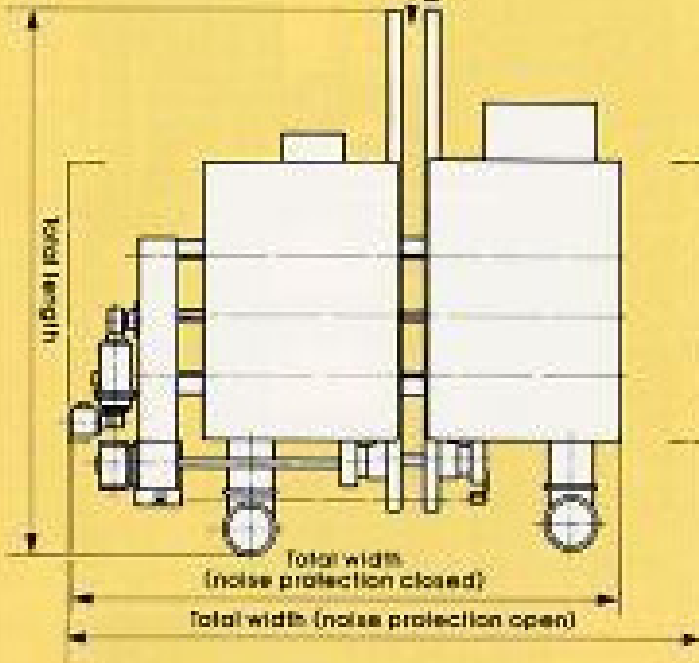
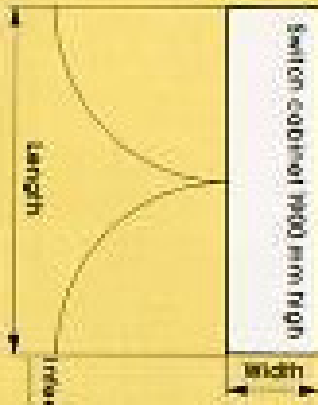
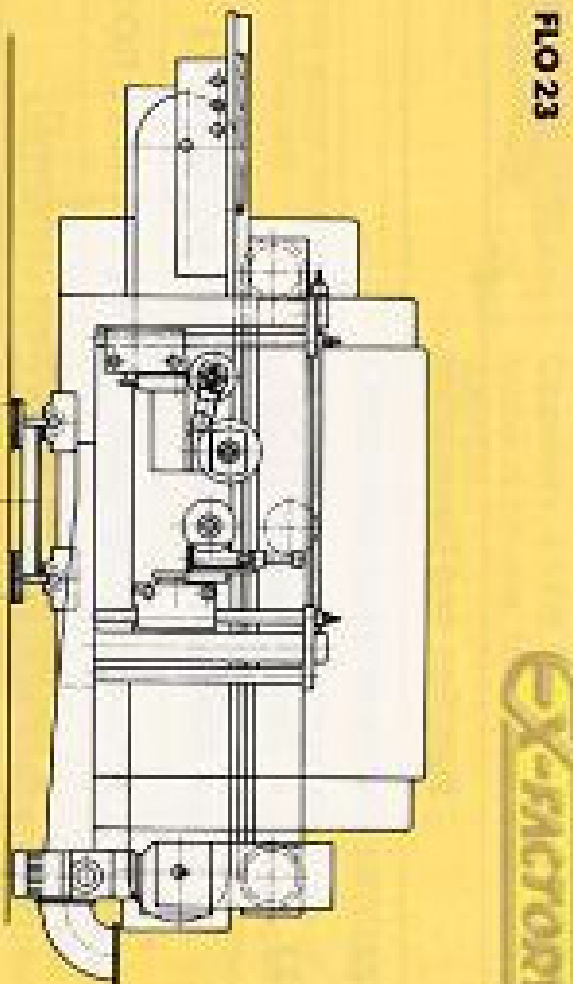
### Options:

	Function and Description
FLO 22 and FLO 23	● Central support FLO 22
	● Central support FLO 23
	● Standard trimming unit 4.5 kW FLO 22-FLO 23
	● Controlled standard trimming unit 4.5 kW FLO 22-FLO 23
	● Electronic width adjustment (3 m/min)
	● Adaptation to local installation and safety regulations

FLO 22



FLO 23





Technical data		Homag Machine Model	
		FLO 22	FLO 23
<b>Machine dimensions</b>			
Total length	mm	3435	4245
Total width			
a) with closed noise protection	mm	5115	5115
b) with open noise protection	mm	6350	6350
Total height			
a) with closed noise protection	mm	1715	1715
b) with open noise protection	mm	2320	2320
Working height	mm	905	905
<b>Weight</b>			
Total gross weight	kg	5820	6960
<b>Working dimensions</b>			
Workpiece width	mm	min. 190 max. 2600	min. 190 max. 2600
Workpiece thickness	mm	min. 8 max. 90	min. 8 max. 90
Workpiece overhang	mm	min. 10 max. 120	min. 10 max. 120
<b>Connected loads</b>			
Operating/control voltage/frequency	V Hz	380, 220 50	380, 220 50
Total electrical connected load	kW	35	45

Technical data		Homag Machine Model	
		FLO 22	FLO 23
Frequency changer free-standing	Hz	100	100
Switch cabinet			
a) Mounted on the machine			
b) Free-standing	Height mm	1900	1900
(for automated versions)	Length mm	1800	1800
	Width mm	500	500
Total extraction capacity at 28 m/sec	m <sup>3</sup> /h	6400	8000
Extraction port mm dia.	mm	200	224
with noise protection			
central extraction at the outfeed			
Compressed air connection	bar	6-8	6-8
		R <sup>1</sup> / <sub>2</sub> "-interior thread	R <sup>1</sup> / <sub>2</sub> "-interior thread
Feed line		1"	1"
<b>Miscellaneous</b>			
Feed	m/min	5-25	5-25
Width adjustment speed			
a) Standard machine	m/min	3	3
b) Machine with servo axis	m/min	20	20
Cam spacing	mm	900	1000
<p>Note:            Technical data and photographs may not be considered binding in all details. Subject to modifications in the interests of further development.</p>			