

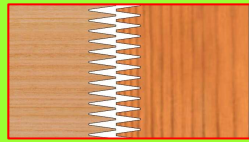
Finger jointing line

ECONOMIK 4

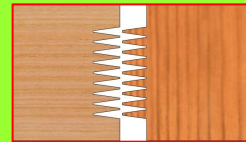
Capacity: 24 m/min

Board length: : Min. 1000 mm up to Max. 6100 mm

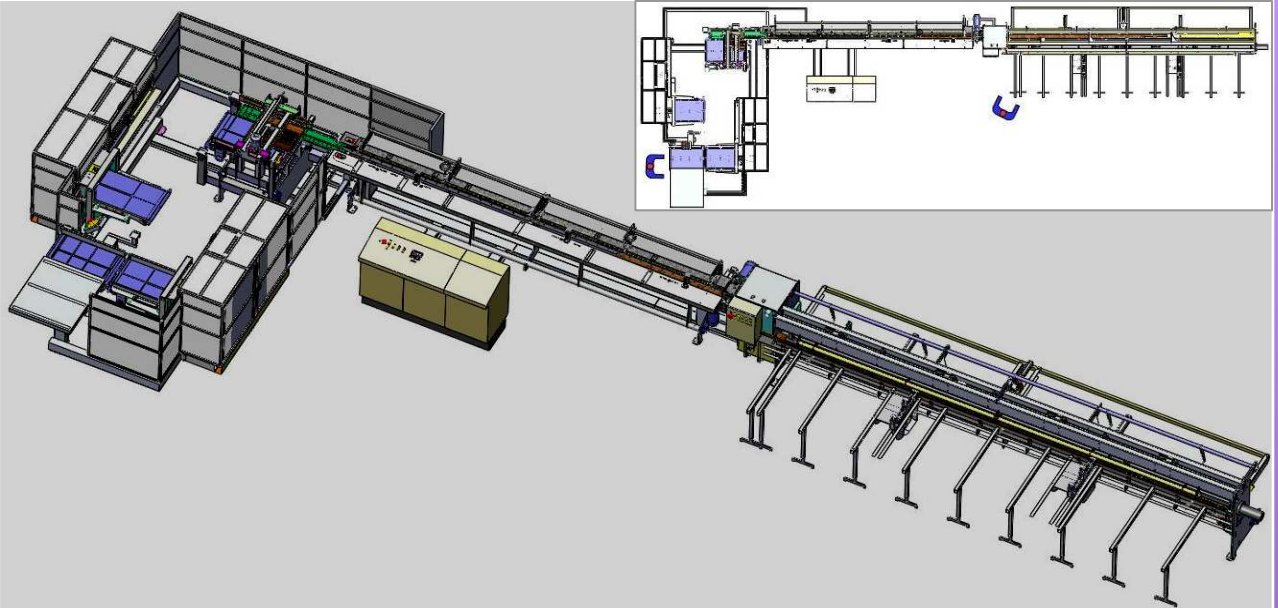
JOINT
TYPE



V Vertical



H Horizontal



THE LINE CONSISTS OF THE FOLLOWING UNITS

- Shaper unit A and B
- Dumper unit chain conveyor
- Press unit – two canals for automatic filling using rolls and cutting after pressing with movable saws at the exit of the the press. Max. length using one cut is 6100 mm or 3x cutting of the board to pieces of the same or different length

DESCRIPTION OF WORKING

On the setting table the package is prepared. The operator then places the package of elements on the band conveyor. After pressing key cycle the package goes on the carriage of t shaper unit A. Here it is automatically arranged and pressed using pneumatic cyinders. After pressing the carriage is moved to final position. While moving the package is first done on one side. When in final position the package goes to carriage of the shaper unit B. After exporting the package the carriage A goes to initial position where new package can be inserted. In the mean while the package on the shaper unit B is automatically arranged and pressed using pneumatic cylinders. After pressing the package the carriage goes to final position. While moving the package is done on the other side and glue is applied. When in final position the package is done and exported to input conveyor of the wood handling over mechanism. Carriage of shaper unit B goes back to initial position. On the wood handling over mechanism the package is arranged. Dumper unit pushes the package to output band conveyor. Here the elements are dumped on the belt. Elements go one by one to band conveyor where they are loosly and correctly assembled. The bord is then pushed under the rolls filling the press, using chains. When the press is full, the cutting of the board is made and the upper system then shifts it to the pressing place. After shifting the press is refilled. In the mean while the pressing of the board is being performed. When the pressing is done the lower system pushes the board under the scoring saws, which were previously set to desired length. The boards are then put on the dumping forks and then they are manually put on the pallet.