

## LISY-DVOŘÁK length splicing machines

FX 160

The machine consists of a welded gearbox with a sliding milling head with a lifting device and an electric motor with a pulley. The spindle speed is fixed adjusted. Spindle lifting by half a tooth is adjustable during every second working cycle from 0 - 10 mm. The robust guide rods with SKF linear antifriction bearings for accurate seating and guideway of the carriage are fixed on the frontal part of the gearbox. The carriage travel is electric driven, with adjustable speed of operation by means of a rack, a pinion and an electric gearbox, controlled by a frequency converter. The bench is equipped by a retracting device with a pneumatic retracting the workpiece from the tool during the reverse run of the bench. The electric equipment enables a semi-automatic milling cycle. The spindle lift, retracting the workpiece and clamping the material are controlled by pneumatic cylinders.

### Operation:

The dimension goods are placed and shaped on the bench. Then the operator presses the buttons "CLAMP" by both hands. If clamping is OK, the operator presses the button "START" and the carriage sets in the motion. At the end of the carriage feed the workpieces are unclamped for a short time and retracted from the tool. The carriage returns back to the starting point. At the same time the height adjustment of the tool changes by half a tooth. The operator presses the button "UNCLAMP", the material is unclamped and it can be swivelled through 180°. Then the material is clamped again and the following working cycle can be started as above described. During this working cycle the other ends of the dimension goods are cut.



- Motor input: 5,5-11 kW
- Spindle revolutions: 6000 rpm
- Dimensions of the bench (operating): 500\*500 mm
- Travel of the bench: 650 mm
- Travel speed: 2-10 m/min
- Rebound of the bench: 1-10 mm
- Adjustable height of the tool: 0-10 mm
- Tool diameter: 160 mm
- Milling height: 120 (150) mm

## LNV

The press consists of a welded frame, a thrust beam, an inserting bar, a pressing unit, a back stop, a revolving ruler, a cross cut saw, a hydraulic aggregate and a control unit. The press ram and the thrust beam are operated by hydraulic cylinders, the other working motions are operated by pneumatic cylinders.

The pressing cycle is controlled by a programmable automatic unit. The cycle starts by pressing the double-hand button "PRESSING" and stops automatically after finishing all operations.

The operator matches the lipped and with cogs provided dimension goods on the front part of the bench. Then the dimension goods are inserted step by step into the working part of the bench, bounded at the both longer sides by an inserting bar and a revolving ruler. The lipping is carried out by a glue applicator, that is a part of the machine. The end of the lamella is supported on a fixed or adjustable stop and the button "START" is pressed by both hands. The inserted material is shortened, the inserting bar inserts the dimension goods under the thrust beam up to the back stop. The lamella is locked before and during the pressing against buckling. From above by a thrust beam, lengthwise by an inserting bar and a back stop. The pressing in the longitudinal axis is carried out by means of a press ram that is pressed by the hydraulic cylinder on one end of the lamella while the other end is supported on a fixed or adjustable stop. After the pressing has been finished the lamella is slid out on the run-out table and the machine is positioned in the starting position.

Adjusting and cleaning are given in the instruction book, delivered with the machine.



- Cross section of the bar – width: 20-150 mm
- Cross section of the bar – height: 16-50 mm
- Length of the bar: 3-6 m\*
- Press power is continually adjustable from 0-5 t
- Atmospheric pressure for control of auxiliary functions: 0,4-0,6 MPa
- Pressure in the hydraulic circuit – max. 25 MPa
- Input of the saw motor: 1,1 kW
- Input of the motor of the hydraulic aggregate: 1,5 kW
- Input of the programmer: 0,1 k
- Pressure: 0,4-6 t
- Length is adjustable according to customer's needs