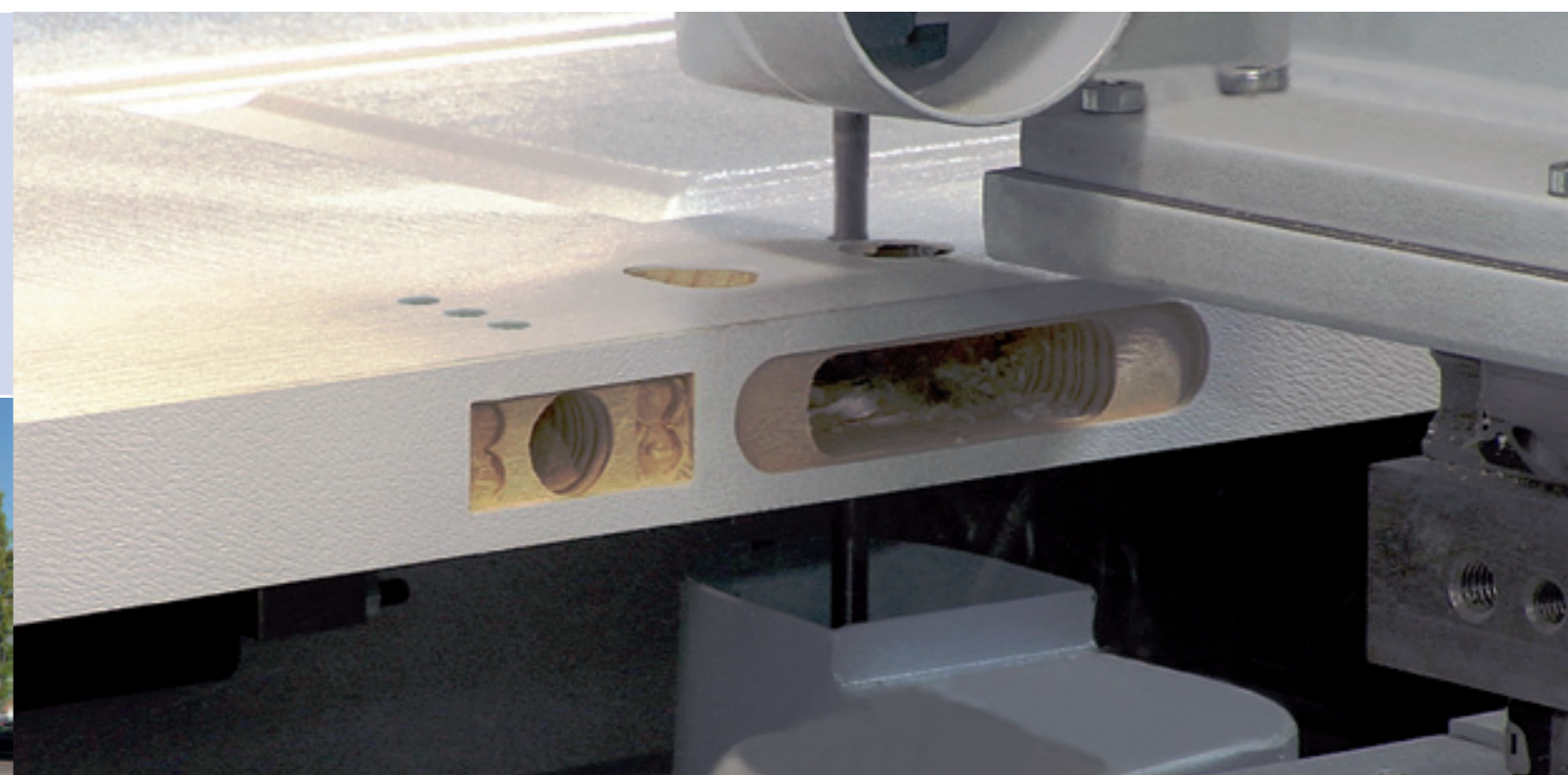


## Door leaf production and processing



A company of the HOMAG Group



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# TORWEGGE – Your system supplier for the door sector

TORWEGGE as system supplier in the door sector offers individual solutions for the production and processing of different door leaves, such as flush doors, rebated doors etc. for interior, exterior, flat and functional doors. The machines and plants are equipped with modern control technology and the high level of automation allows a large variety of efficient and flexible processing. TORWEGGE provides future-oriented stand-alone solutions for small batch sizes as well as fully automatic lines for high capacities. The TORWEGGE machines meet the sophisticated customer requirements regarding high efficiency combined with maximum flexibility and first-class quality.

## Custom-made door leaf production

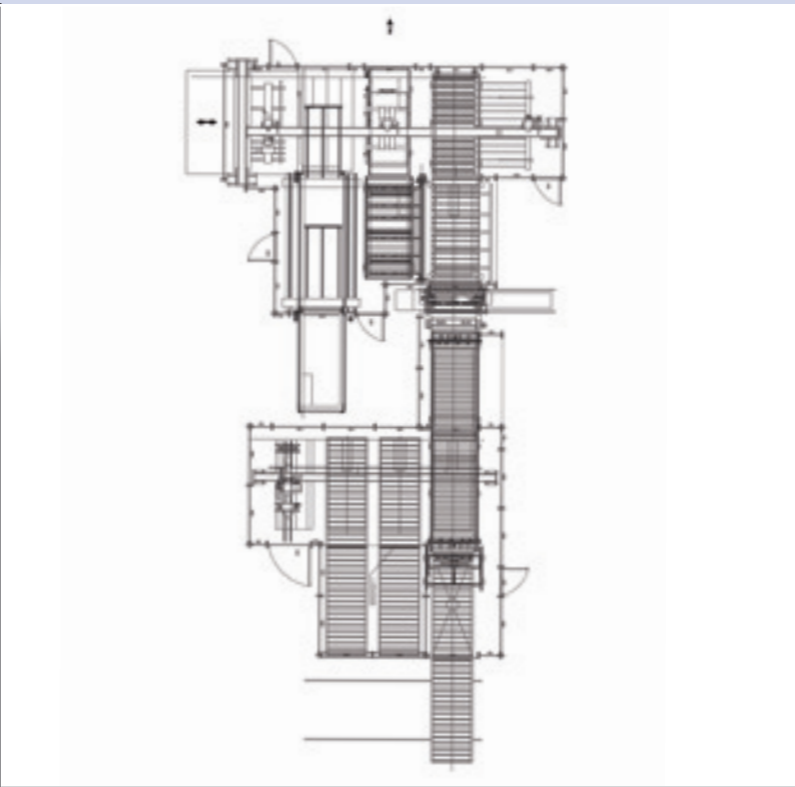
For the door leaf production TORWEGGE completes their own machines by solutions from the HOMAG Group and offers the complete door leaf production from one source.

## Possible components for the door leaf production:

- Storage systems
- Feeding device top/bottom/intermediate layers
- Feeding of length- and crosswise rails by robots
- Sizing of central layers
- Frame presses
- Automatic infeed of central layers
- Feeding of special central layers
- NC-controlled rail magazine
- Positioning range for top/bottom layers, central layers and surfaces



Single-sided solution for a door processing plant  
for lock/hinge processing



Concepts for TORWEGGE door leaf production



# TORWEGGE – your system supplier for the door sector

For the door processing, TORWEGGE offers many individual customized machine concepts. Our machines provide a comprehensive range of performances and functions for your requirements for flush as well as for rebated doors. More and more flexibility is required today – TORWEGGE provides this flexibility by tailor-made solutions within the scope of the complete process chain. Moreover, the customer benefits from the perfect consultation and support by specialists of the door and frame industry, from planning to after sales service. For the customer this means high quality standards and economic, individual solutions from just-in-time to serial production.

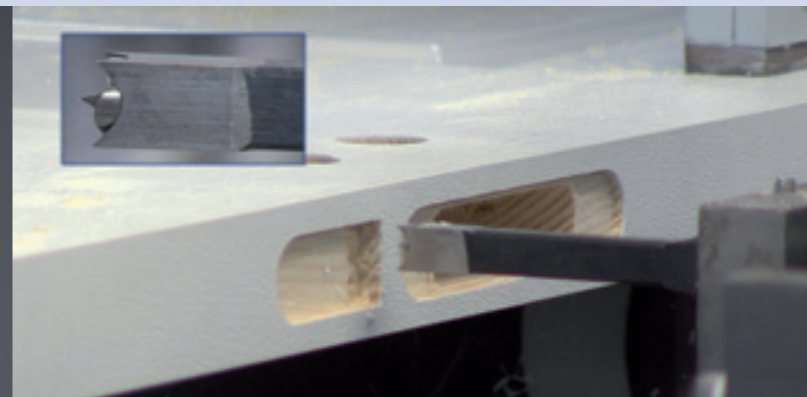
Apart from the production of front, object and room doors the TORWEGGE machines are perfectly suitable for the production of high-quality functional doors, such as for example fire doors, burglary-resistant doors, wet-area doors, smokeproof, sound-proof and bulletproof doors.

## Possible working units for lock/hinge processing

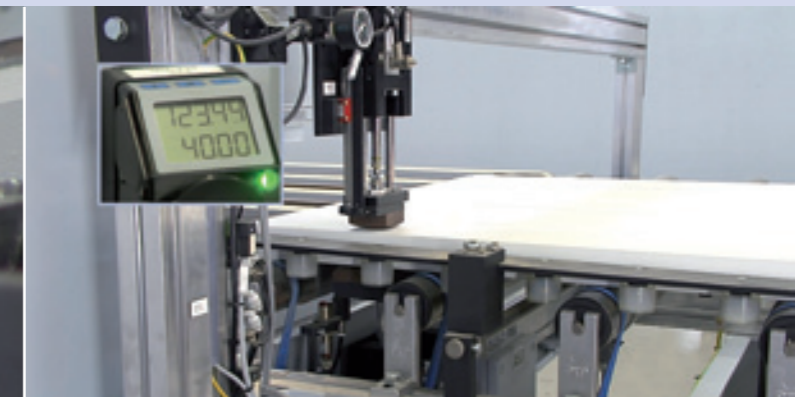
- Lock-case cutter
- Face plate cutter
- Vertical cutter for lock/handle holes from top and bottom
- Pilot drill for fixing screws
- Square hole drill for rectangular fittings
- Milling units clockwise/counter-clockwise rotation for book hinge processing
- Tilttable hinge drilling unit (Anuba/drill-in hinges)
- Hinge screw-in unit (single)
- Hinge screw-in unit with 6-fold changer



Individual door processing for sophisticated customer requirements



Top picture: Square hole drilling unit for the use of rectangular fittings  
Bottom picture: Concealed hinge



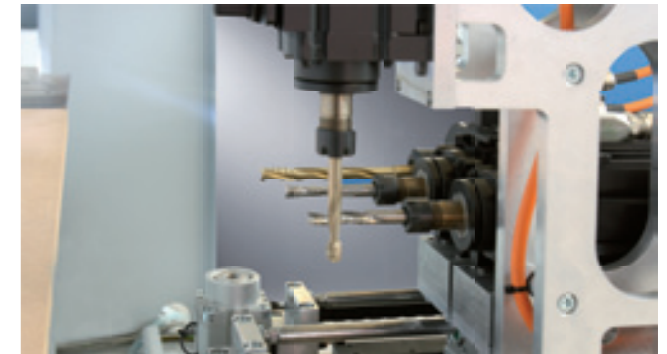
Top picture: Upstream thickness measurement for more efficient processing  
Bottom picture: Processing of door handle, keyhole and lock-case

## SBT 100 – All-rounder for small and medium batch sizes

The complex and heavy-duty door leaf processing machine SBT 100 carries out the complete milling and drilling processing for door locks as well as the hinge processing: whether book hinges, drill-in hinges or concealed hinges in varied design – the processing of all these hinge types belong to the standard features of the SBT 100. The all-rounder is suitable for the production of small and medium batch sizes so that small and medium-sized companies as well as industrial companies producing different batch sizes can benefit from the flexibility of the SBT 100.



Processing of lock-case and handle/keyhole



Processing units of the SBT 100

Door leaf processing machine SBT 100



Depending on the equipment and technical requirements, this CNC-controlled machine reaches a capacity of up to 120 - 150 door leaves per shift. There are various equipment possibilities of the machine. The lock-case unit belongs to the standard equipment as well as the face plate, keyhole and handle hole cutter. Free capacities for additional working units provide nearly unlimited possibilities for the processing of fittings.

Technical data	
Workpiece thickness	25 - 70 mm
Workpiece width	300 - 1.300 mm
Workpiece length	1.600 - 2.500 mm
Working height	935 mm

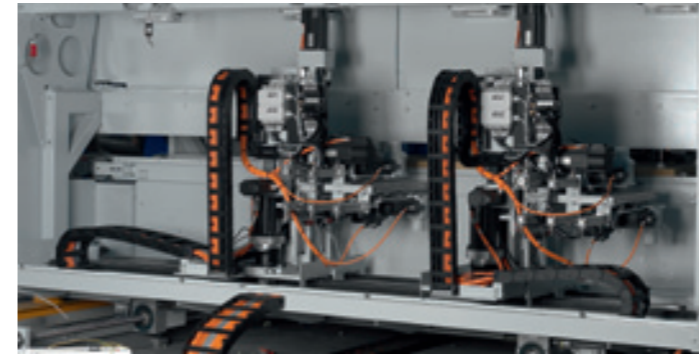
Technical data are not binding in every detail. We specially reserve the right to modifications in the course of further developments.

Special dimensions on demand.

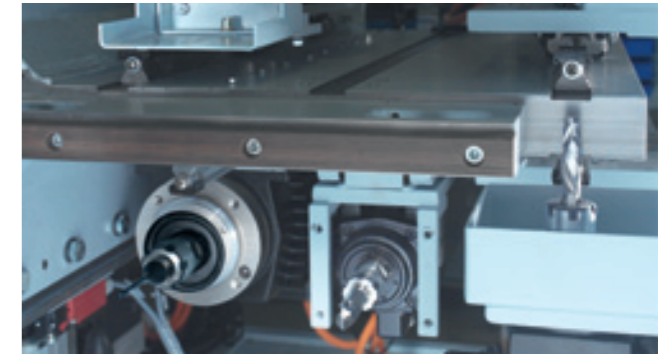
## SBL 520 – Flexible lock/hinge processing

The lock/hinge processing machine SBL 520 is a very flexible machine to process fittings at door leaves. A flexible production with a capacity of up to 650 doors per shift are standard. This all-rounder feels comfortable in the stand-alone sector as well as in automated throughfeed lines. The parallel processing of the lock and hinge side is carried out in one clamping. The machine is equipped with an electronic width adjustment. Prior to the processing, the width of the door leaf is automatically measured – thus a precise hinge finish at the surface is possible.

In order to meet the sophisticated customer requirements, this machine is available as single-sided and as double-sided solution. In the single-sided solution SBL 510 there is one machine for the lock and one machine for the hinge processing required for the complete processing of the door leaf. The double-sided version SBL 520 allows this processing parallel in one machine.



Milling units for parallel hinge processing



Working units for lock-case and face plate

Lock/hinge processing machine SBL 520



### Technical equipment:

- Fast belt conveyors to transport the workpieces
- Pneumatically controlled fences to align the door leaves in longitudinal direction
- Lock processing side with up to 2 unit carriers with up to 5 working units
- Hinge processing side with max. 2 unit carriers each with max. 5 motors for hinge bores and cuts
- Unit carriers moveable in 3 axes

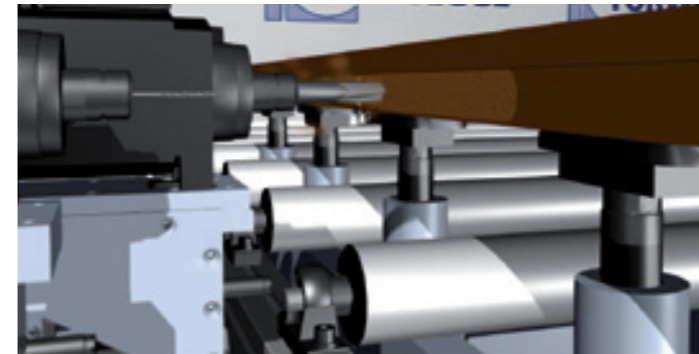
Technical data	
Workpiece thickness	30 - 65 mm
Workpiece width	380 - 1.300 mm (option: 500 - 1.800 mm)
Workpiece length	1.500 - 2.500 mm (option: 3.500 mm)
Capacity	up to 4 doors/min (depending on equipment)
Working height	approx. 1.000 mm

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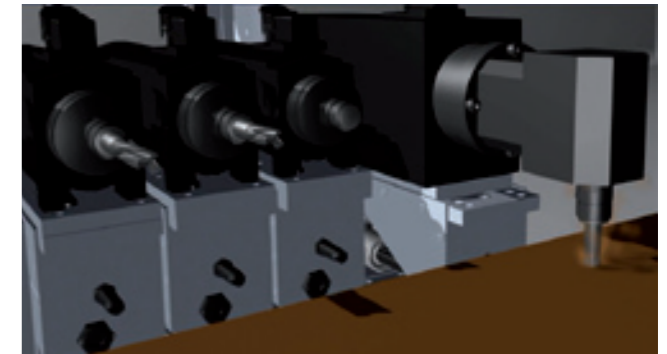
Special dimensions on demand.

# SBK 300 – Complete door leaf processing for highest demands

The complete lock/hinge processing machine SBK 300 combines the advantages of an efficient and very flexible machine with an optimum price-performance ratio. The different equipment possibilities of the machine allow, for example, the following operations: cutting and drilling of book hinges, drill-in hinges, 3D-hinges, cutting of lock-cases incl. face plate as well as cutting of keyhole/handle hole, processing of card locks, rosette bore for handle set in the surface, cut-out trimming, cutting of spyholes and air grids, front side processing e.g. for functional doors etc. – unlimited variety on one machine.

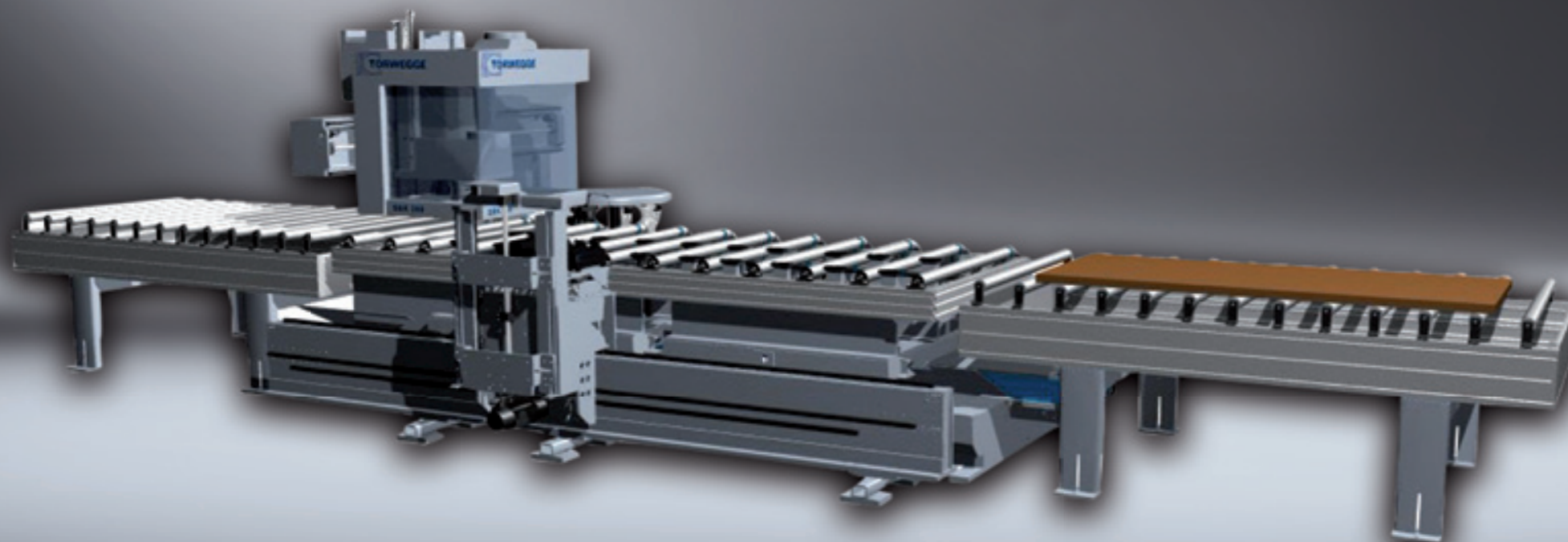


Cutting of lock-case



Horizontal and vertical milling

Lock/hinge processing machine SBK 300



### Technical equipment:

- Complete processing in one clamping
- Cycle time for a sample door max. 3 min (4-sided sizing synchronized/counter rotation, lock-case, 3 hinges, add. times for transport and clamping)
- Lowerable transport table and liftable clamping units
- Roller table as transport table to minimize set-up times for changed width
- Clamping for complete processing via vacuum
- Individually controlled vacuum suction elements, vertical selection depending on length
- Infeed with or without fixed edge alignment
- Tool change system

Technical data	
Workpiece thickness	25 - 70 mm
Workpiece width	300 - 1.250 mm (rough size: 1.300 mm)
Workpiece length	1.500 - 2.700 mm (option: 3.500 mm)
Capacity	approx. 150 doors/shift
Working height	approx. 1.000 mm

Technical data are not binding in every detail. We specially reserve the right to modifications in the course of further developments.

Special dimensions on demand.