



**SPLICER WITH AUTOMATIC FEED
AND PRE-FEEDING UNIT**



- Model:	F 34-MF	
- Total heated length:	3.45 <i>11.3</i>	m <i>ft</i>
- Knife length:	3.4 <i>11.1</i>	m <i>ft</i>
- Veneer thickness:	0,4-3 <i>1/60 – 1/8</i>	mm <i>in</i>
- Min. veneer width:	55 <i>2.5</i>	mm <i>in</i>
- Transport speed:	adjustable from 0 to 60 <i>adjustable from 0 to 196</i>	m/min <i>ft/min</i>
- Width of heating plates:	85 <i>3.3</i>	mm <i>in</i>
- Press beam stroke:	10-120 <i>0.4 – 4.7</i>	mm <i>in</i>
- Working temperature:	adjustable from 100 to 230 <i>adjustable from 212 to 446</i>	°C <i>°F</i>
- Splicing pressure:	3-16 <i>43 – 230</i>	bar <i>PSI</i>
- Installed heating power:	22	kw
- Heating-up time:	10	min

FEZER S.A. INDÚSTRIAS MECÂNICAS
Rua Gerhard Fezer, 865
89500-000 Caçador - SC
BRASIL

Fone: +55-49-3561-2222
Fax: +55-49-3561-2250
www.fezer.com.br
fezer@fezer.com.br



- Total installed power:	27				kW
- Power demand:	16				kW.hr
- Compressed air demand: (4 bar - 60 psi)	aprox.	50			l/min
	≈	2			cf/min

- Net weight:	3.200	3.160	4,250	5,200	kg
		6,900	9,400	11,000	lb

Main Features:

- **The splicer** is delivered for assembly on good factory level over shock absorbers with leveling screws which are included in the delivery.

- **Pre-feeding unit**, of special use with narrow veneer, allowing three pieces of veneer to be pre-positioned for splicing operation:

- one piece inside the machine, undergoing the splicing action against the mat already formed;
- a second piece already aligned by the pre-feeding unit, stopped by a photocell at an intermediate position, before going into the machine;
- the third piece already in position against the squaring pins of the pre-feeding unit.

- **Drives** of pre-feeding and internal transport system is made with electric motors and speed selection with frequency inverters, to allow constant speed and precise stopping.

- **Automatic feed of the first component.** The first component is automatically aligned and carefully transported to the splicing position, waiting for the next component to come in to start the splicing operation. This feature is very important when splicing in a balanced match, counting the components and finishing the sheet when the required splice lines have been made. The feeding of veneer will not be interrupted when starting a new sheet, no different from splicing in a running match.

- Splicing modes

1. Continuous run. For book or slip match, with the use of the clipper when the desired width programmed on the control screen of the pLC is reached by a counter. With the help of the pre-feeding unit, or without the pre-feeding if working with very wide components.

2. Balanced match. The number of components is programmed on the PLC, the machine will splice from first component up to the programmed number, will transport the sheet out and will be ready to receive the first component of the next run. The clipper is not active.

The machine can be prepared to splice balanced match of furniture size components, for example 4 components 4 inches wide by 20 inches long.

- **Automatic sheet alignment.** In continuous splicing, with the use of the clipper for dimensioning of the sheet, after every cut the machine will automatically place the remaining veneer parallel to the pins. The operation is fast and does not disturb the splicing time.

- **Built-in clipper** with hydraulic command. The anvil is a large driven roll covered with special plastic. With most veneers, only after years of service it is required to remove the knife for resharpening. The clipping command is given by a programmable controller from an encoder coupled to the outfeed shaft.

- **Stainless steel heating elements** inside hardened aluminium heating plates, independently fed and monitored by the PLC. Outstanding long life, due to precise spacing of heating element inside the heating plate.



- **Front table** made of stainless steel with recess for operator.
- **Infeed wheels** with adjustment of height above the belts and with adjustment of pressure.
- **Built-in hydraulic low pressure** unit with Bosch components. Low pressure means splicing can be performed with pressure as low as 50 psi on pushers. General setting of pressure on the hydraulic system is 360-400 psi depending on the size of the machine. Nippon accumulator is used to increase hydraulic movement speeds. Hydraulic shock absorber reduces noise on end of run.
- **Easy operating controls**, easy electric diagram and worldwide known components (Siemens) for easier maintenance. Main operating functions are still kept on easy to command switches. General settings, read-outs and maintenance supporting features are shown on a color touch screen.
- **Safety features include:**
 - a. protection of operator by means of photo-cell which blocks pressure beam operation and a physical barrier with plastic shields.
 - b. safety shields protect back part of the machine, not permitting access to the knife or under the machine.
 - c. a safety valve is installed in the hydraulic circuit to allow blocking the oil flow to the knife cylinder and prevent movement of knife during maintenance.
- **Delivery of veneers** on a delivery table with 2 m width, covered with "Formica" set up inclined on a independent structure, height of the lowest part 0.9 m above floor.



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