

Combined sizing and edge banding machines KF 10 - KF 20

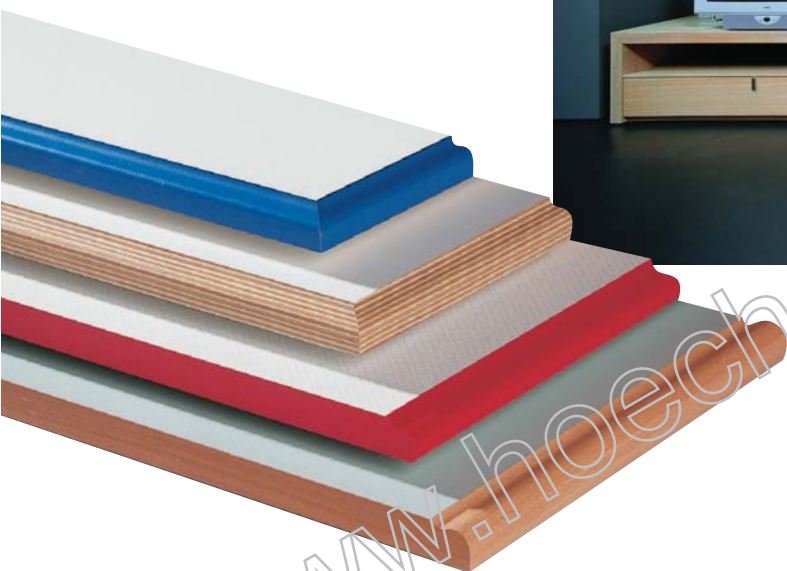


Optimat | profi line | power line



Extreme profitability – for large series production or batch size 1

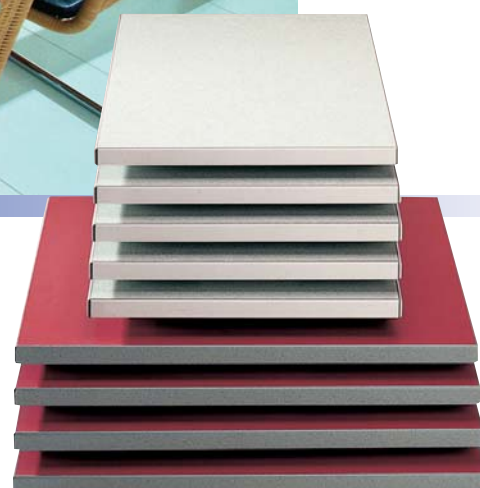
Modern panel furniture production is inconceivable without the use of high-performance combination machines for sizing and edge banding. These flexible machines are also at home with a wide range of specific applications such as the manufacture of doors, or wall and ceiling panelling. One of their outstanding strengths lies in their extreme economy - for every different scale of manufacture from large or small series production right down to batch size 1.



The security of the world market leader

With many thousands of sizing, edge banding and combination machines to its name, Homag has become the world's number one manufacturer of machines for the panel furniture industry. Homag is a name you can place your trust in.





Precision in throughfeed

These combination machines provide the assurance of high-precision workpiece guidance in continuous through-feed operation – as well as extreme finish processing accuracy. The result: optimum quality. Compared to individual machines, combinations also mean dispensing with transfer and interlinking devices. You save in terms of laborious resetting work and a lower space requirement – and your workpieces benefit from minimal handling stress.

Homag combination machines: big solutions for a big output

Homag combination machines offer an impressively high technical standard, pin-point precision and operating convenience:

- Generally configured with PLC and line control
- Easy-action, fast width adjustment due to linear guidance and recirculating ball screw technology
- Direct travel to the width dimension
- Powered height adjustment of the top pressure beam by means of maintenance-free cardan drive
- Unit carriers with linear guidance and digital counters
- High degree of dimensional and repeat accuracy through low-backlash adjustment gear

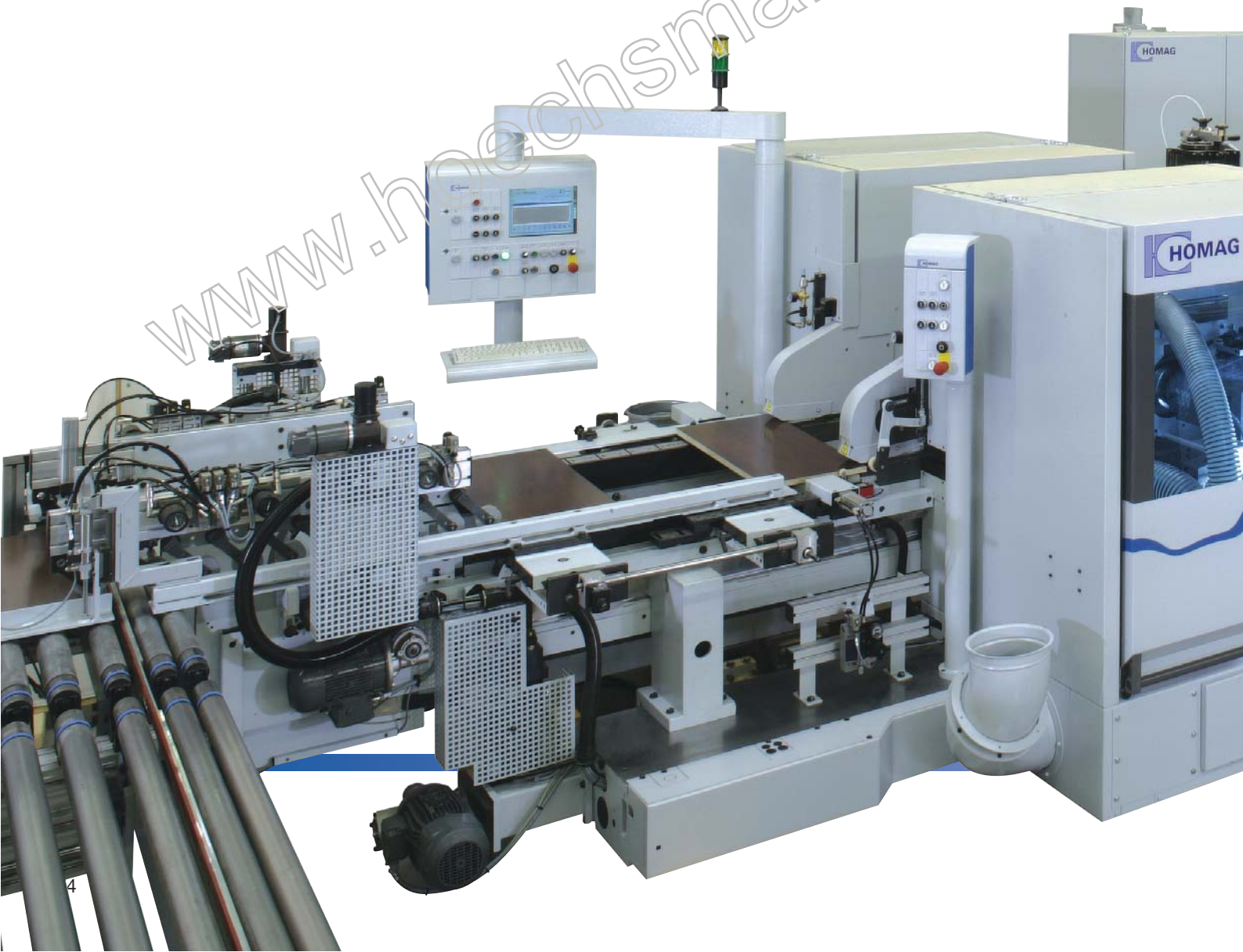
Single-sided machines – the ultimate in flexibility

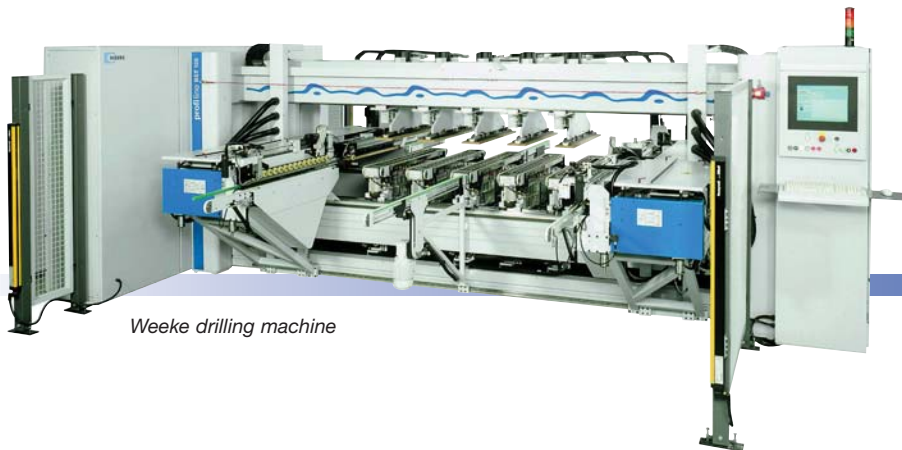
These machines are used predominantly for just-in-time processing production. Every processing operation calls for a separate pass. As these machines operate on a width-independent basis, they are extremely flexible in their application. If the workpieces are already rough sized to an unfinished fixed or finish measurement, they are capable of achieving high capacity production in combination with a workpiece feed system. Units can even be reset in throughfeed given the necessary degree of automation. This not only enhances flexibility but increases volume output too.

A perfect starting point for a production line

Single and double-sided machines can easily be upgraded to create production and high-performance production lines. This is where you can benefit from a perfectly coordinated product range and the solid foundation of Homag Group expertise. The necessary components and machines from the different Homag Group members can be seamlessly interlinked with the utmost simplicity.

A typical example: Integration of Weeke automatic throughfeed dowel drilling machines for complex drilling patterns and automation with Bargstedt feeding and stacking plants.





Weeke drilling machine



Feeding of big-sized board



profi line KF 20

Unlimited material and processing versatility

Homag combination machines permit the sizing, profiling, rebating and grooving of panel shaped workpieces such as chipboard, MDF, core board, solid wood, plastic etc. These can then be banded using hot melt glue or PU adhesive with all popularly used edging types: Solid wood, coil or fixed length material, melamine, PVC, ABS or veneer edges.

Variety through softforming

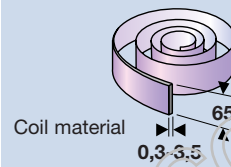
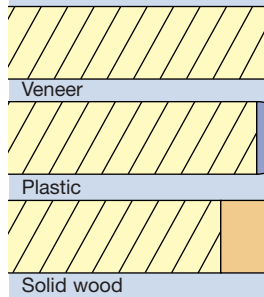
Homag combination machines also offer a range of interesting options for creative edge design using softforming technology. The profile shapes range from roof and drum to S or inlay profiles.

Variable working widths

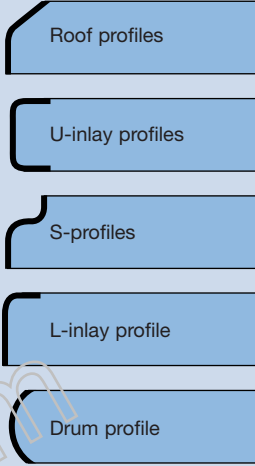
Homag supplies its combination machines ideally adapted to the width of your own specific workpieces: Variable working widths from 1000 to 3500 mm - in graduations of 500 mm. The minimum working width is 210 mm.

For wide workpieces, we recommend using an additional central support.

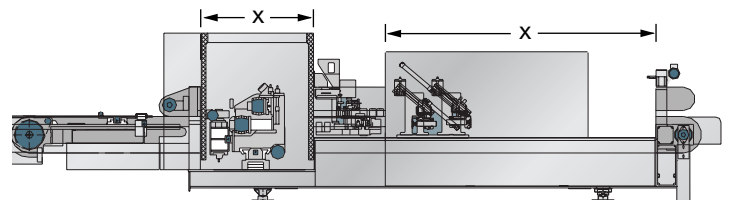
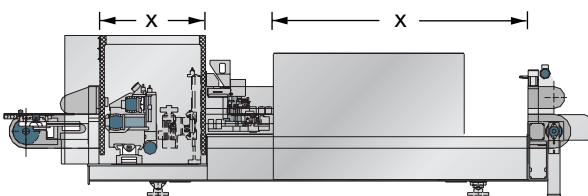
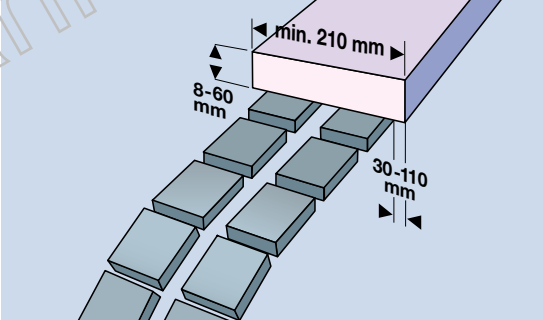
Straight edges



Softforming profiles



Minimum workpiece dimensions



The machine length - just the way you need it

The length of your Homag combination machine depends directly on the functions you need it to perform.

Because the required finish processing operations determine the number of units you need - and so the length of the basic machine.



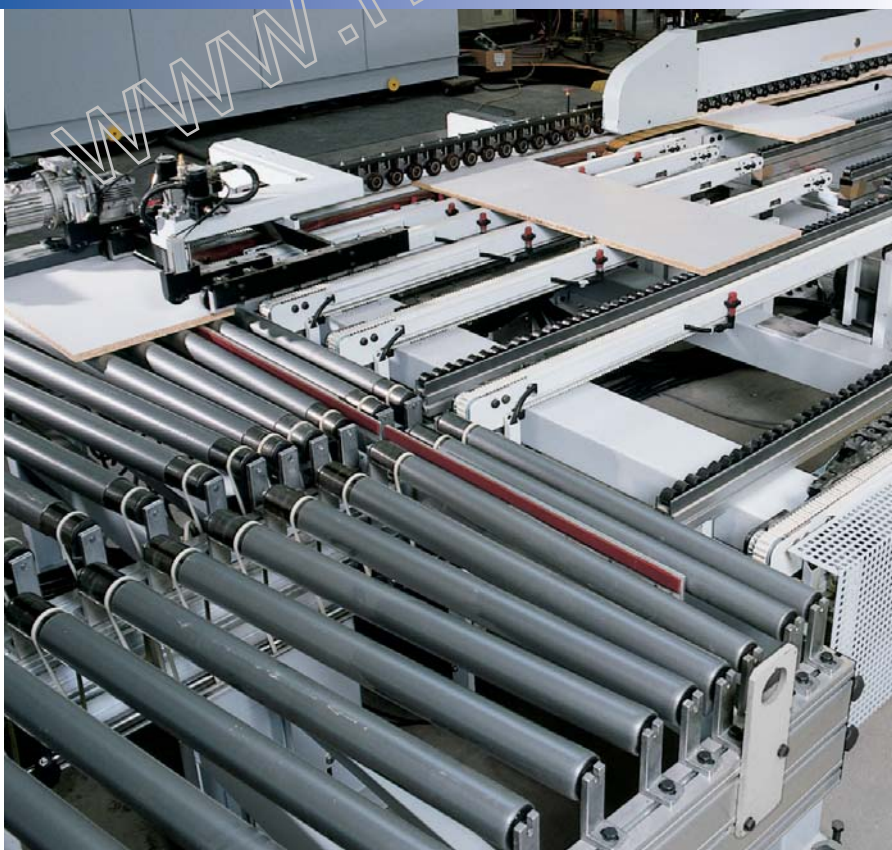
Longitudinal processing

The workpieces are inserted at the infeed fence and precisely cut to size.



Transverse processing

Here, the workpieces rest against the dogs of the transport chain. The stop dogs are steplessly adjustable, and are capable of transporting even profiled or softforming parts reliably and without damage through the machine.



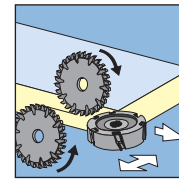
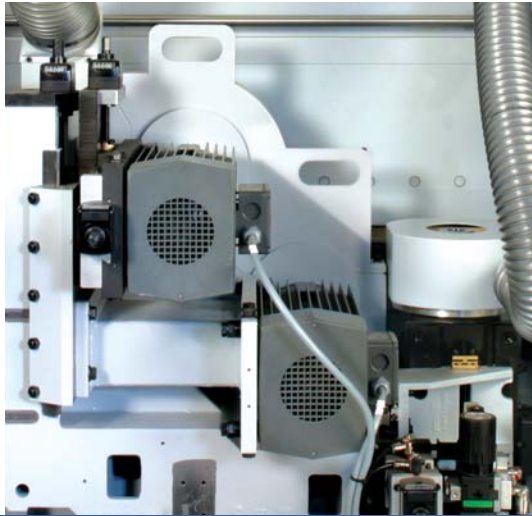
Flexible longitudinal and transverse processing

If the workpieces are already sized to an unfinished fixed or finish dimension, they can be fed, independently of their width, in fast optional sequence using the workpiece feed system WZ 10. This concept of multiple-sided processing in consecutive passes guarantees high capacity, even for order-related production with continuously changing dimensions.

It is even possible for units to be reset in throughfeed.

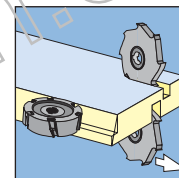
The modular processing units – always up to date

A versatile choice of units is available to address wide-ranging processing requirements. The range of modular processing units is being upgraded and extended all the time. We recommend getting in touch with us for details.



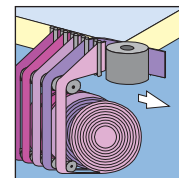
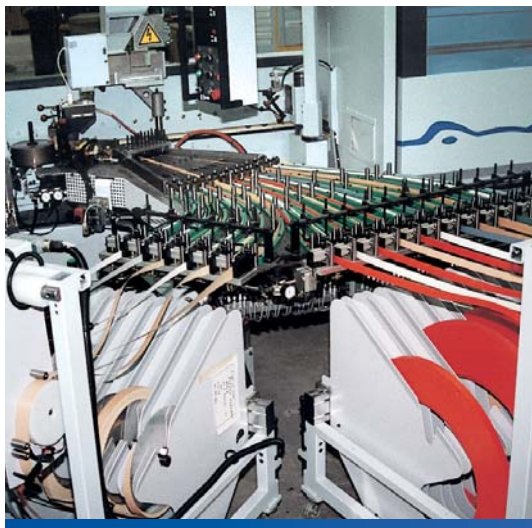
Compact double hogger KD 11 longitudinal/transverse, 6.6 kW

Simply the best method of sizing: This efficient, modern double hogger system guarantees optimum splinter-free quality, a long service life and even tool wear. Optional: I-system for optimum chip-removal



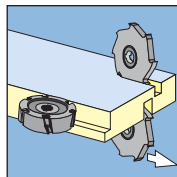
Standard trimming unit

Trimming motor 4.5 up to optionally 6.6 kW, 100 Hz, 6000 rpm, scope for automation with stepless horizontal/vertical axes and swivel axis.



Multiple edge magazines

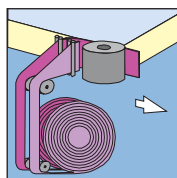
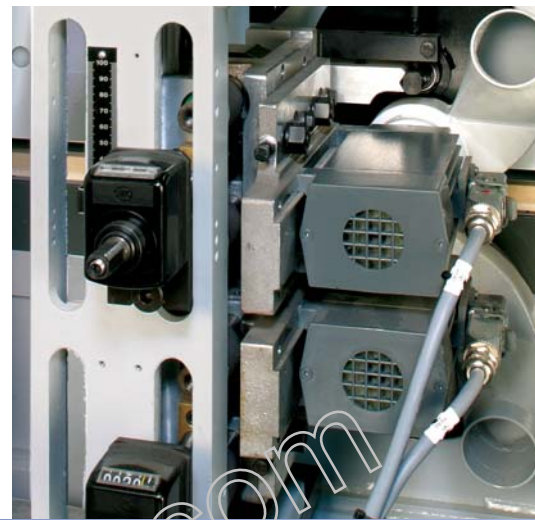
These are almost an indispensable option in coping with today's production variety. The spectrum ranges here from the 2-slot magazine through to the 36-slot changer or more, allowing the effortless processing of edging material from 0.3 mm to 3.5 mm.



SF 62 trimming unit with automatic 8-slot tool changer

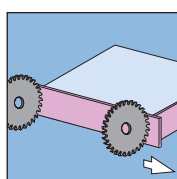
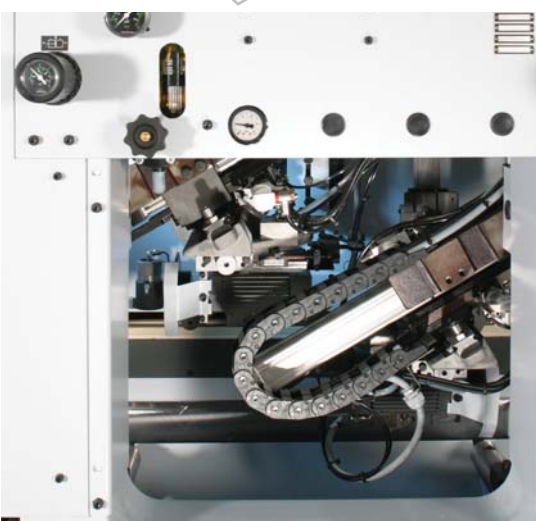
Tool clamping operations are solved by the control

system. With a maximum diameter of 200 mm and two profiles per exchange slot, tools are automatically exchanged using the 8-slot plate changer. This allows 16 different profiles to be exchanged. The processing motors of the tool changers are fitted with HSK 63 F interfaces. All motor and changer movements are controlled by servo axes.



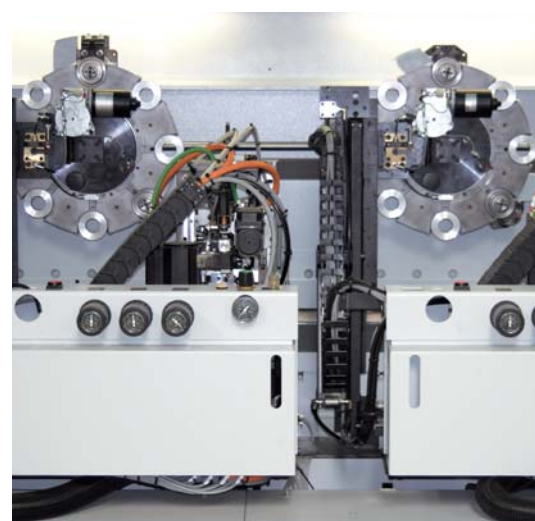
Gluing unit for straight edges

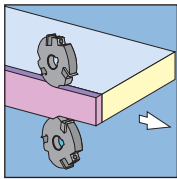
For gluing veneer, fixed length or coiled plastic material, or solid wood strips. The pressure zones are available in different lengths depending on quality and performance requirements.



Snipping unit HL 04 chamfer/straight

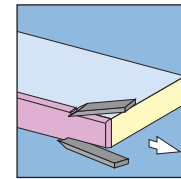
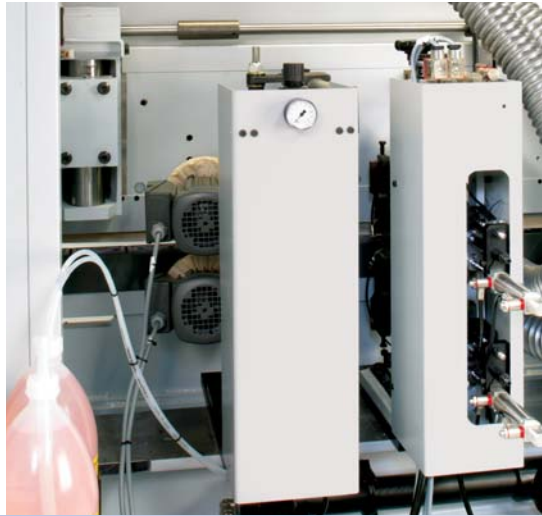
Snipping unit for chamfer and straight snipping of overhanging edges.





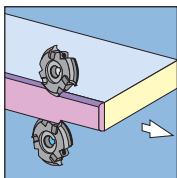
Rough trimming unit

For rough trimming the upper and lower edge overhang.



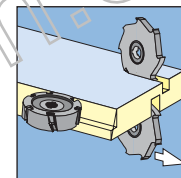
**Finish processing
FA 10 + FA 11**

Comprising a glue joint scraping unit, cleaning agent application and buffing unit for glue residue removal at the top and bottom of PVC edges.



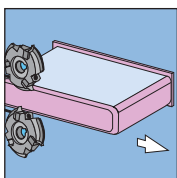
**Multiple trimming unit
MF 21 automatic**

For finish processing edging material of different thicknesses.



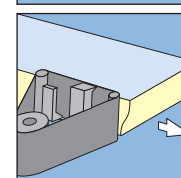
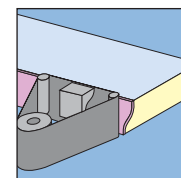
**Universal trimming
unit UF 11**

For grooving, rebating and profiling with swivel-mounted, controlled motor.



Profile trimming unit FK 23

For all-round finish trimming of workpieces, also for transverse processing of postforming and soffforming profiles.



**Profile sanding unit
PS 10/PS 20**

For sanding profiles and straight edges. PS 20 using dual-pad technology.

The production lines – custom tailored to address every need

To achieve optimum performance with the best possible solution for complex, customer-specific processing assignments, the man-material-machine system must be meticulously coordinated. Particularly when the individual processing machines and material flow systems have to be interlinked for overall production. Just the sort of challenge at which the Homag Project Team excels.

Homag project processing: pooled expertise, concentrated know-how

Project processing by a team of experts from Homag offers a series of decisive benefits. Close links between the Homag Group members, for instance, guarantees direct access to the expertise of the other companies - which enhances the overall effectiveness of the project team and permits troublefree processing link-up between all individual components (also of other makes) and their integration into higher-level systems. An impressive portfolio of completed production line projects for automatic complete processing testifies to the outstanding competence of the Homag project team.

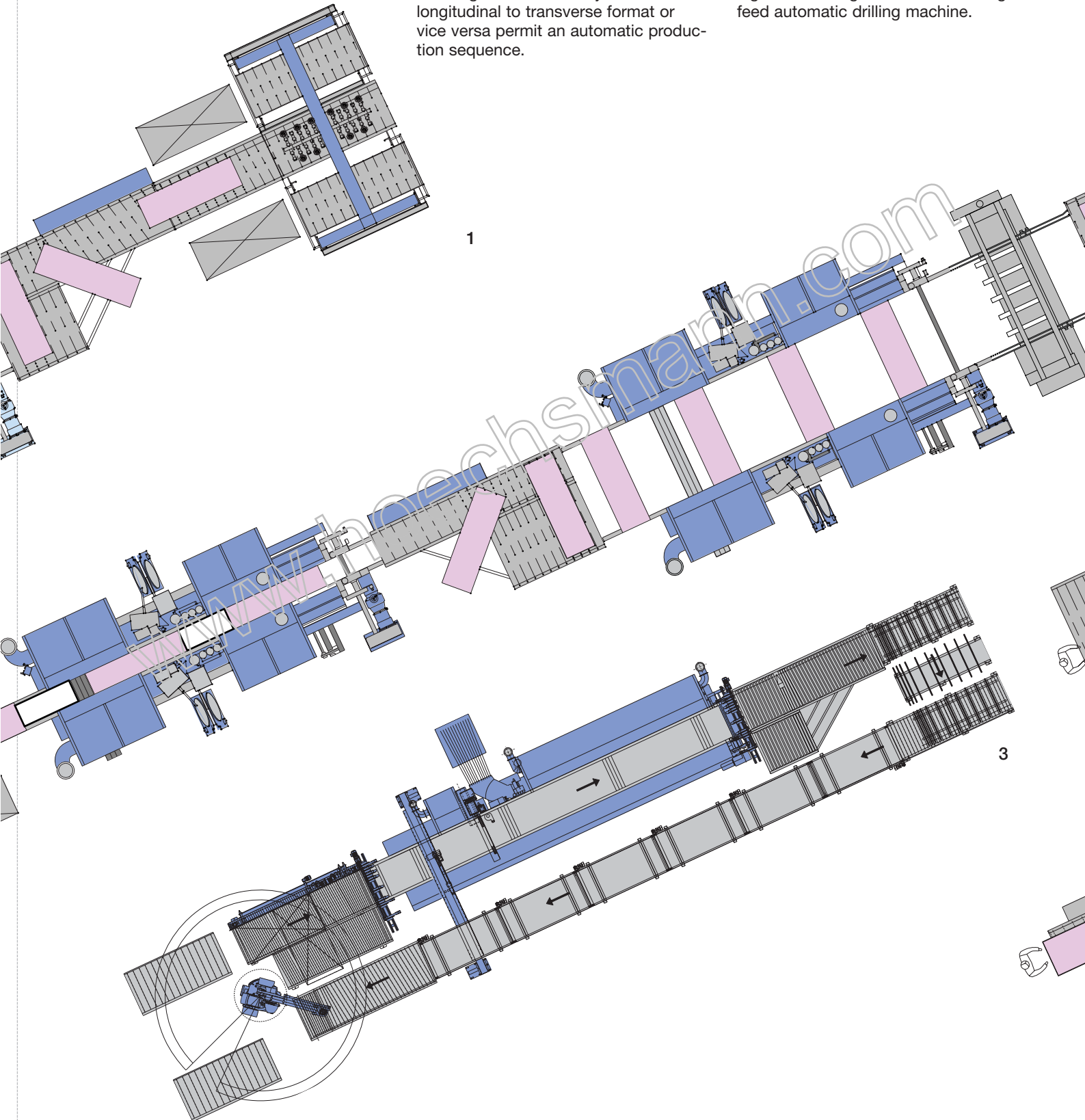
One partner covers every requirement

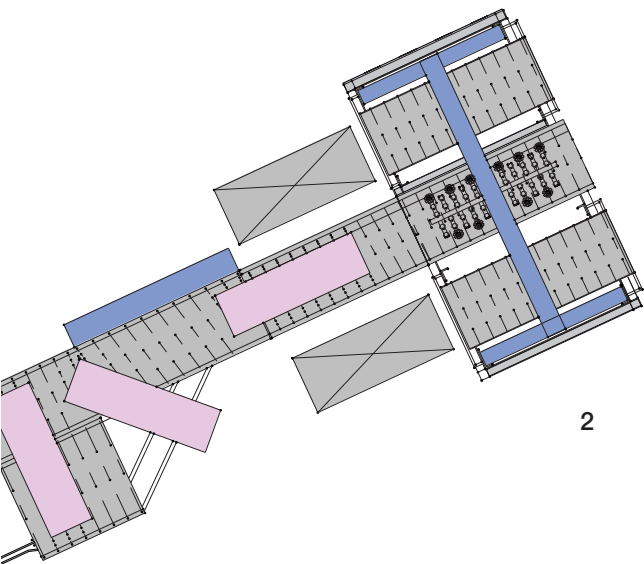
- Concretization and formulation of the terms of reference
- Elaboration of concepts
- Installation and commissioning
- Regulation of commercial, legal and technical arrangements

In effect, you purchase the entire plant from a single manufacturer. And if it suits you, you can even lease personnel from us – to help familiarize your own staff during production, for instance.

1) Short line for medium capacity requirements. In two work stages, the workpieces are longitudinally and transversely processed. Feeding and stacking as well as rotary stations from longitudinal to transverse format or vice versa permit an automatic production sequence.

2) Production line for longitudinal and transverse processing of workpieces in a single pass for medium to large series production. Including feeding and stacking stations and through-feed automatic drilling machine.





2

3) Batch size 1

Production plant for longitudinal and transverse processing of minimal batch sizes down to just 1.

4) U-line for flexible extremely small series production. The workpieces are sized on two sides. Edge and finish processing takes place independently of workpiece width on single-sided machines.



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The control system – fast, reliable and easy-to-operate

Outstanding economy

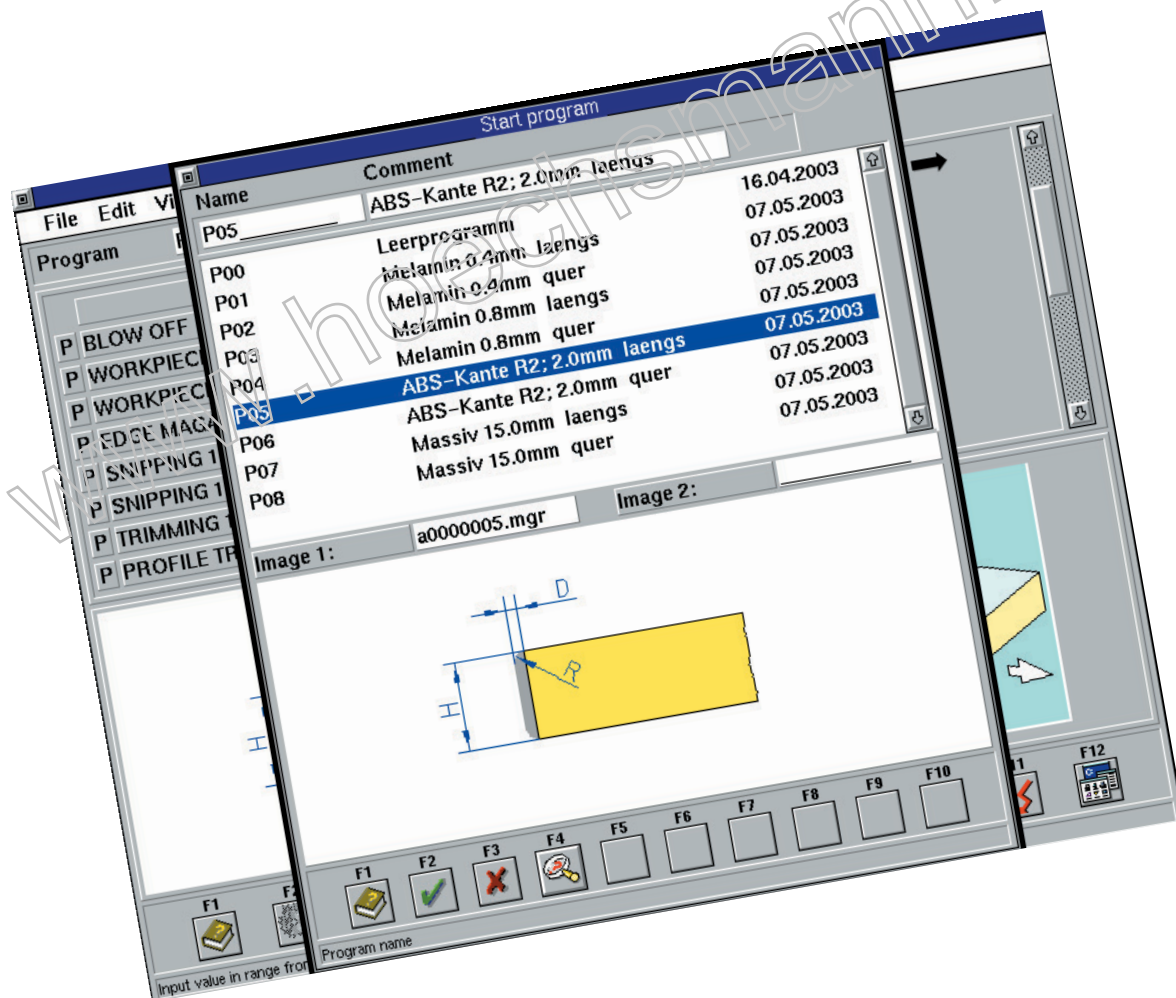
In conjunction with the wide range of available units with automation capacity, almost all resetting processes can be controlled centrally from the control desk, eliminating the issue of resetting times and paving the way for the economical production of even minimal batch sizes.

Operating convenience

Programming and operating an edge banding machine has never been so easy and convenient. The new control system with flat colour monitor and dust-proof PC keyboard offers maximum operating ease is based on the internationally established Windows standard, familiar to everyone with even minimal PC skills. The simple, self-explanatory user prompting system allows familiar thought processes and procedures to be transposed directly into the control inputs required for workpiece processing. Supplementary transport systems can be integrated without problems into the existing control system.

Remote diagnosis included

Standstill periods can be avoided by rapid response to direct error messages on screen (such as "enclosure open"). And should it ever prove impossible to solve a problem internally, the Homag remote diagnostic system can generally save the need for calling out a service technician.



HOMAG



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The Homag service program: The all-round convenience package for your machine

Because our versatile range of services has been tailored consistently to the needs of our customers, it guarantees optimum all-round support – from the project planning phase through sales to after-sales.

Planning/advice: working together towards the perfect solution

To provide you with the best and most economical solution to your requirements, we offer a sound and competent advisory service – right from the earliest planning phase of your project.

Financing/leasing: a straightforward solution at favourable rates

We also offer attractive financing arrangements to help keep your equity base intact. Benefit from our range of flexible financing offers.

Installation/commissioning: getting things moving

Our highly skilled and experienced specialists will be in charge of installation and commissioning – making sure that your production gets underway quickly without any hitches.

Practically-oriented training: Fast track to full productivity

We will prepare your staff for safe, efficient machine operation with a choice of selective training events on wide-ranging topics.

Production support/optimization: Long-term efficiency

We will provide sound on-site support and ensure that you fulfil the maximum possible potential of your machine – and so achieve continuous high productivity.

Maintenance/inspections: for maximum availability

Only machines which are producing will return a profit. By performing regular preventive inspections we can help effectively prevent machine standstill.

Modifications/overhauls: the economic alternative

We will adapt your existing machine quickly and cheaply in line with new or changed requirements – to enhance the value and output of your plant and help you make considerable savings.



Remote diagnosis/video diagnosis help reduce costly call-outs

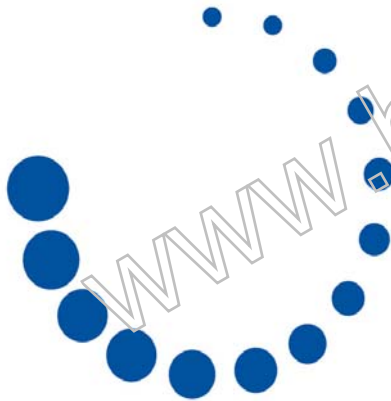
This diagnostic facility helps cut down costs spent for on-site callouts, and offers scope for selective deployment planning and spare part supplies – so providing effective support for your own staff.

Spare part processing: fast and reliable

Many of the components used in our machines are identical. This not only simplifies the stocking of spare parts and ensures fast part availability, but also simplifies operation and maintenance and reduces costs.

World-wide service: Homag is everywhere

The global Homag Service Network guarantees customer proximity and worldwide availability of our services.



lifeline | service

Our **lifeline** | service ensures economical production over the entire life cycle of your machine. If you need us, you can rely on us to be there: From plant planning and installation through to employee training, in-process support and high-speed supply of spare parts – around the world, when and where you need us.

Specifications



Machine dimensions

Overall length	mm	depending on machine type
Working height	mm	950 (37,401")
Noise protection covers		
Overall width closed/open	mm	2300/3830 (90,551"/150,787")
Overall height closed/open	mm	1840/2480 (72,441"/97,638")

Connected loads

Operating voltage		400 V/50Hz
Control voltage		220 V or 24 V
Total electrical connected load	kW	depending on equipment
Total extraction capacity	m ³ /h	depending on equipment
Chip belt		optional
Air speed (dust extraction)	m/sec.	28 (91,863 ft.p.sec.)
Pressure loss	mm/w.g.	250 (9,842 in./w.g.)
Supply line female thread		depending on equipment
Compressed air connection	bar	6 to 8
Compressed air consumption	SL/min.	depending on equipment

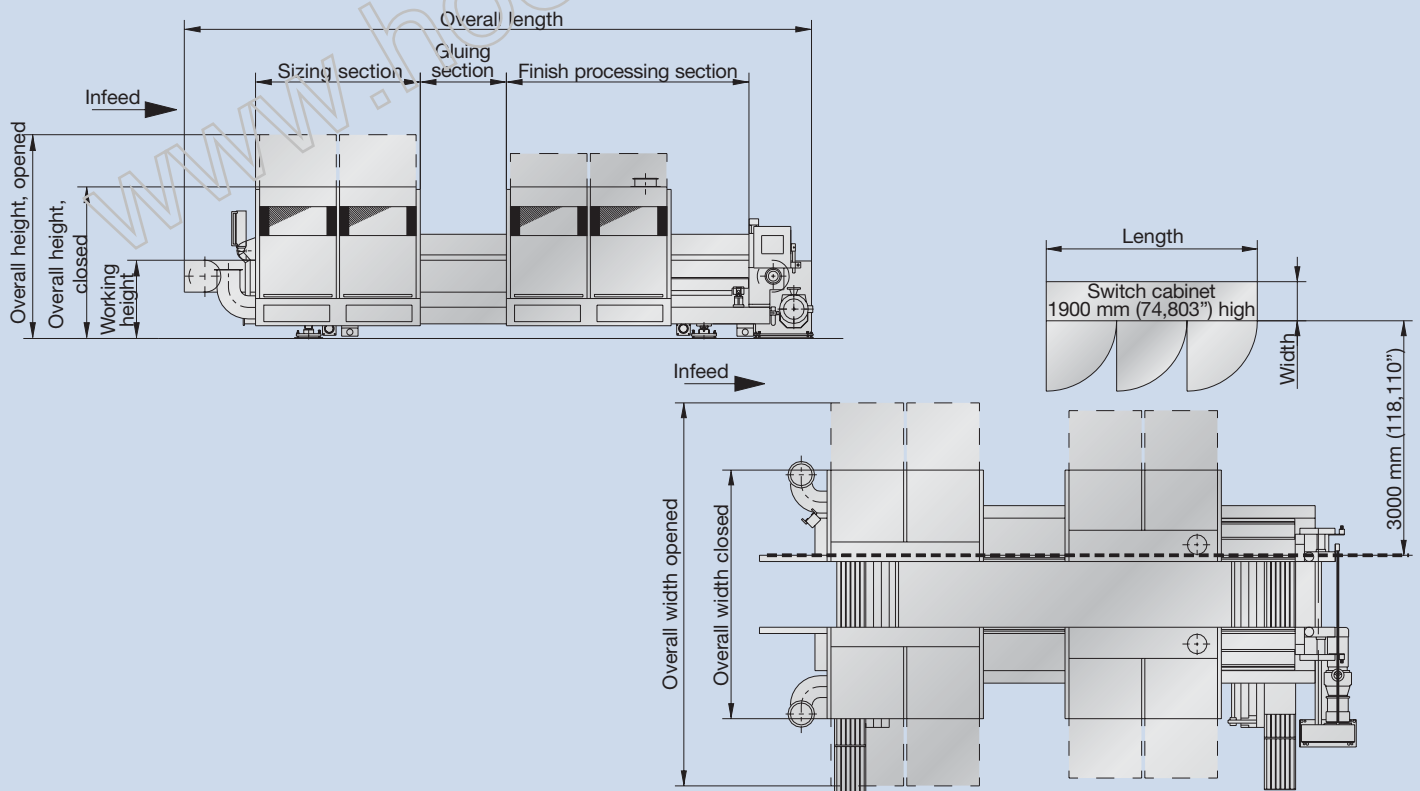
Working dimensions

Workpiece width		
min. double sided	mm	240-270 (9,449"-10,63")
max. double sided	mm	1000 bis 4000 (39,37"-157,48")
(graduations)	mm	500 (19,685")
Workpiece thickness	mm	min. 8 (0,315") - max. 60 (2,362")
Workpiece overhang		
fixed	mm	40 (1,575")
optionally adjustable	mm	30-110 (1,181"-4,331")

Miscellaneous

Feed steplessly adjustable	m/min.	10 to 40
		(32,808-131,233 ft.p.min.)
Width adjustment speed		
standard	m/min.	2,6 (8,530 ft.p.min.)
Machines with servo axis	m/min.	20 (65,617 ft.p.min.)
Dog spacing/standard	mm	1000 (39,370")
Dog height/standard	mm	11 (0,433")
Option stepless dog height	mm	to 25 (0,984")

Certain details of the provided specifications and photos may deviate from the supplied product. We reserve the right to make changes in the interest of progress.





A member of the Homag Group



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