LOHMEYER

SMART·WOOD·WORKING

BAZ 8 IQ

Horizontal Panel Saw Sliding Table Saw CNC Machining Center Edgebander

EN


RELEASE
LOCK

Wood IQ is your smart choice

A good foundation means everything

We are Lohmeyer

Lohmeyer Smart Wood Working stands for the value chain in panel processing. Cutting, edge banding, drilling and routing - these are our specialities. We want to support your success as an industrial manufacturer of panel materials and as a professional supplier with standardized best-practice machines paired with fast and reliable service. A team of specialists with many years of experience in panel processing is making this possible.

Our smart product lines of the 3, 5, 7 and 8 series combine proven quality with a price-performance ratio that is unmatched. This is possible because we intelligently combine different components. Experienced German and Chinese engineers consistently implement European technical standards in machine technology. The machines are produced in China in one of the most advanced production facilities for woodworking machines.

Our European service network guarantees the continuous availability of our machines and systems as well as technical support at any time.

BAZ 810 IQ • BAZ 810D IQ

Travel distances / travel speeds

- X axis: 2.540 mm 50 m/min
- Y axis: 940 mm 50 m/min
- Z axis: 150 mm 20 m/min
- high quality servo motors for accurate movement in each axis
  - BAZ 810 IQ: 2 in X, 1 in Y, 1 in Z
  - BAZ 810D IQ: 2 in X, 1 in Y, 2 in Z
- guide systems mounted on linear guides:
  - ball screw (Z)
  - rack and pinion (X und Y)

Dual drilling block in BAZ 810D IQ

- drill equipment:
  - 2 x 14 vertical drills
  - 2 x 10 horizontal drills
- individually selectable spindles
- drilling blocks can be positioned separately in Y direction
- drilling from five sides in a single set up
- direction of rotation: clockwise and anticlockwise

Worktable

- table with six supports and two vacuum cups each
- panel lifting device for easy positioning of the workpieces
- alternating processing to reduce auxiliary times

Suction cups

- diverse suction cups can be easily adjusted to fix panels of different shapes and sizes
- min. panel width 50 mm

Electrical equipment

- separate electrical cabinet with air conditioning
- selection of workstations via the control panel
- Syntec control
- IPC with Windows operating system
- USB port
- 17" screen

Separate dust extraction for each drilling block

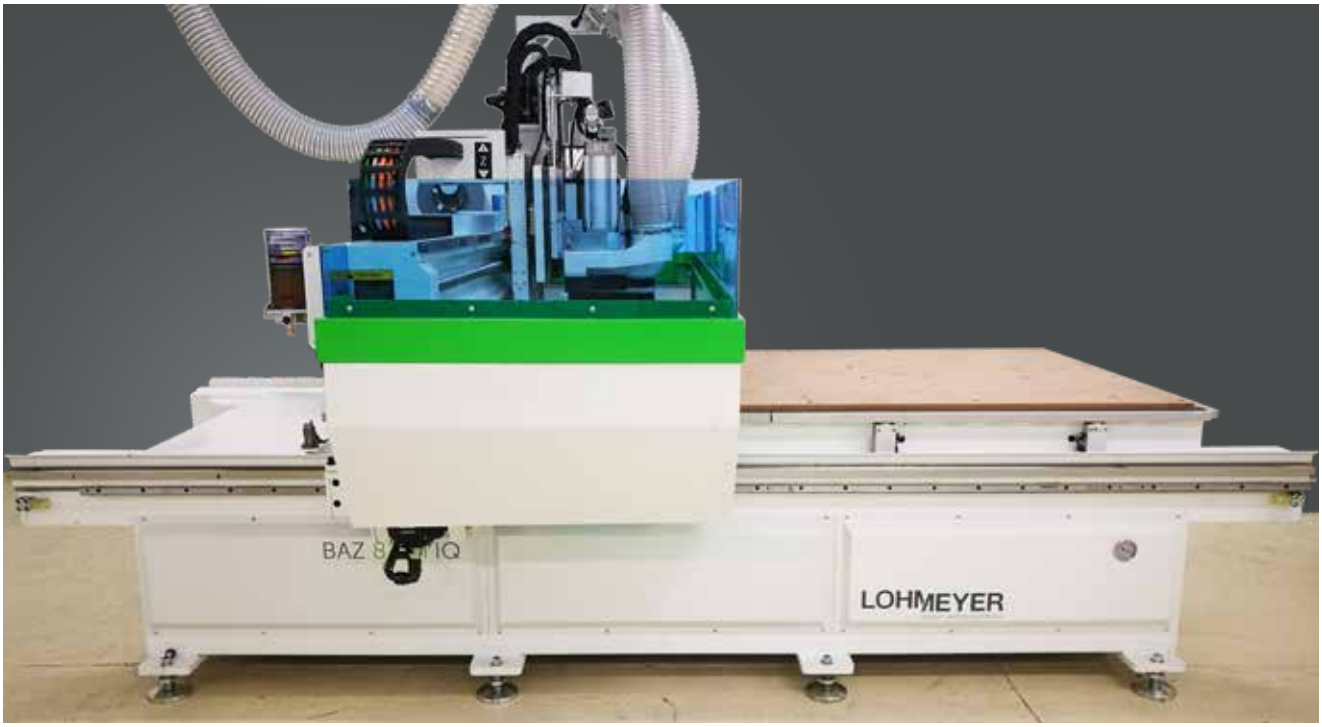
BAZ 810 IQ • BAZ 810D IQ

Facts & figures in a nut shell

		BAZ 810 IQ	BAZ 810D IQ
Working range	X axis	2,500 mm	
	Y axis	900 mm	
	max. workpiece thickness	50 mm	
Work table		5 movable benches with 2 suction cups each	6 movable benches with 2 suction cups each
Min. workpiece width		50 mm	
Max. travel speeds	X axis	50 m/min	
	Y axis	50 m/min	
	Z axis	20 m/min	
Main router spindle	amount	1	-
	speed	18,000 RPM	-
	power	6 kW	-
	collet	ER32	-
Drilling block 1	power	1.7 kW	
	speed	4,000 RPM	
	vertical drills	12	14
	horizontal drills (X)	2 + 2	3 + 3
	horizontal drills (Y)	2 + 2	2 + 2
Drilling block 2	power	-	1.7 kW
	speed	-	4,000 RPM
	vertical drills	-	14
	horizontal drills (X)	-	3 + 3
	horizontal drills (Y)	-	2 + 2
Vacuum pump	power	5.5 kW	5.5 kW
	suction flow rate	160 m³/h	160 m³/h
	cooling	air cooling	
Dust extraction	pipe diameter	2 x 200 mm	
	speed	min. 28 m/s	
	extraction connection	Ø 250 mm, height 2,400 mm	
	extraction capacity	min. 4,950 m³/h	
	pressure loss	min. 2,200 Pa	
		Note: Weight relief at extraction hose!	
Compressed air	required air pressure	7 bar	
Power supply	power	26 kW/68A	15 kW/68A
	frequency	50 Hz	
	voltage	400 V, 3 phases	
Machine dimensions	length x width *	4,000 x 2,010 mm	4,000 x 2,010 mm
	height	1,970 mm	
	weight	2,600 kg	2,600 kg

* Note: plus safety devices depending on local conditions

Flat table machines of the series BAZ 824n IQ



Work tables

- BAZ 822n IQ 2,500 x 1,250 mm
- BAZ 823n IQ 3,000 x 1,600 mm
- BAZ 824n IQ 3,000 x 2,100 mm

Equiment

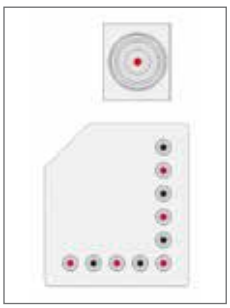
- Worktable: grid table divided into four areas
- side alignment device for exact positioning of the panels
- main spindle and drilling block on separate Z axes
- automatic tool changer with 8 positions, servo driven, with empty space detection to crashes in case of incorrect operation
- central lubrication system for the linear guide systems of X, Y and Z axis
- tool measuring probe and holder for measuring the workpiece length
- handwheel for an easy set up of new parts

Control

- IPC with Windows operating system
- 17'' screen
- USB port
- SYNTEC control system
- separate switch cabinet with air conditioner

Guide system

- guide systems mounted on linear guides:
  - rack and pinion (X)
  - ball screw (Y and Z)
- powerful servo motors for precise and stable axis movement:
  - 2 in X, 1 in Y, 1 in Z



BAZ 822n IQ • BAZ 823n IQ • BAZ 824n IQ

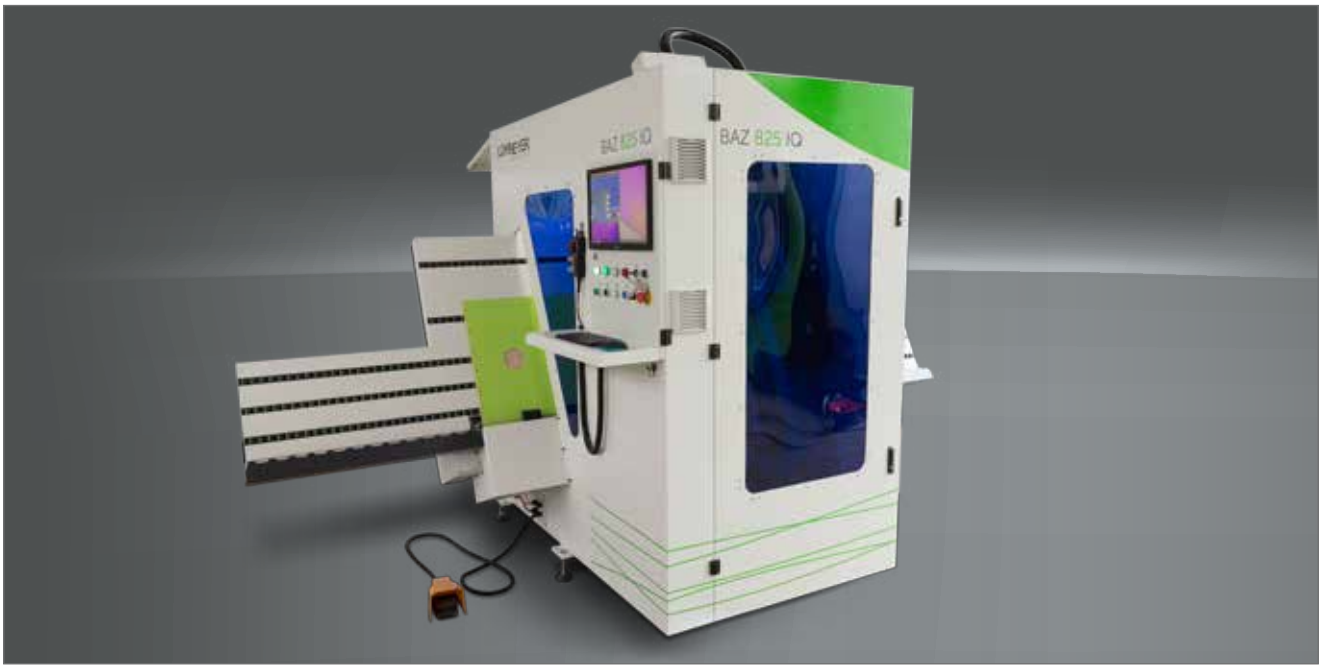
Facts & figures in a nut shell

		BAZ 822n IQ	BAZ 823n IQ	BAZ 824n IQ
Working range	X axis	2,500 mm	3,000 mm	3,000 mm
	Y axis	1,250 mm	1,600 mm	2,100 mm
	max. workpiece thickness		max. 30 mm	
Max. travel speeds	X axis		70 m/min	
	Y axis		50 m/min	
	Z axis		20 m/min	
Main router spindle	amount		1	
	speed		24,000 RPM	
	power		9 kW	
	tool interface		HSK-63F	
	collet		ER32	
Automatic tool changer	amount of tools		tool magazine with 8 positions	
Drilling block	vertical drills		10	
	max. drill diameter		35 mm	
	power		1.7 kW	
	speed		4,000 RPM	
Vacuum pump	power		2 x 5.5 kW	
	suction flow rate		2 x 160 m^3/h	
	suction pressure		0.8 kg/cm^2	
	cooling		air cooling	
Dust extraction	pipe diameter		200 mm	
	speed		min. 28 m/s	
	extraction connection		Ø 250 mm, height 2,400 mm	
	extraction capacity		min. 4,950 m^3/h	
	pressure loss		min. 2,200 Pa	
			Note: Weight relief at extraction hose!	
Compressed air	required air pressure		7 bar	
Power supply	power	27 kW/68A	27 kW/68A	27 kW/68A
	frequency		50 Hz	
	voltage		400 V, 3 Phasen	
Machine dimensions	length x width *	4,000 x 3,000 mm	4,500 x 3.450 mm	4,500 x 4,000 mm
	height		2,600 mm	
	weight	2,500 kg	2.900 kg	3.400 kg

* Note: plus safety devices depending on local conditions

BAZ 825 IQ

Vertical panel processing



Equiment

- rigid and space-saving machine due to vertical design
- 3 CNC controlled axes in X, Y and Z direction
- Delta servo motor and drive
- transparent front end
- freely positionable CNC controlled workpiece clamp with automatic and smart reclamping technology
- vacuum-free fixing of the workpiece with strong downholder in the processing area
- 17" screen
- due to a gap under the workpiece through routing and drilling are possible without any set up time

Intelligent collet system

- automatic reclamping in case of tool collision
- collet gets automatically into position after the determination of the workpiece processing
- max. workpiece thickness 60 mm

Drilling unit

- 13 individually selectable vertical spindles
- 8 horizontal spindles (3 + 3 in X, 1 + 1 in Y)
- stroke: 50 mm
- max. machining depth: 30mm

Routing aggregate

- routing motor with collet ER32
- 4.5 kW spindle
- max. 18,000 RPM

BAZ 825 IQ

Facts & figures in a nut shell

Workpiece dimensions	length	200 mm - 2,500 mm (more possible with support of the work-piece provided by the customer)
	width	70 mm - 850 mm
	height	12 mm - 60 mm
	weight	max. 40 kg
Max. travel speeds	X axis	70 m/min
	Y axis	50 m/min
	Z axis	15 m/min
Routing aggregate	supply voltage	400 V
	speed	max. 18,000 RPM at 200 Hz
	power	4.5 kW
	max. diameter tool holder	20 mm
	max. tool diameter	35 mm
	max. tool length	70 mm
	collet	ER32
Drilling block	pneumatic feed stroke (Z direction)	80 mm
	max. drilling depth	40 mm
	vertical drills (single spindles)	13
	rotating direction single spindles	right
	horizontal drills (double spindles)	3+3 in X, 1+1 in Y
	rotating direction double spindles	right / left
	speed	3,000 RPM
	power	2.2 kW
	drill holder diameter	10 mm
	max. drill diameter	35 mm
Compressed air	operating pressure	7 bar
Dust extraction	pipe diameter	100 mm, connection directly at the processing unit
	min. dust extraction speed	28 m/s
	extraction connection	Ø 250 mm, height 2,400 mm
	extraction capacity	min. 4,950 m³/h
	pressure loss	min. 2,200 Pa
		Note: Weight relief at extraction hose!
Power supply	connected load	30 kW/68A
	total load	12.2 kW
	frequency	50 Hz
	voltage	400 V, 3 phases
Machine dimensions	length x width x height *	3,720 x 1,690 x 2,056 mm
	weight	2,500 kg

* Note: plus safety devices depending on local conditions

CNC machining center BAZ 830n IQ (nesting)

Routing and shaping of half size panels

Work tables

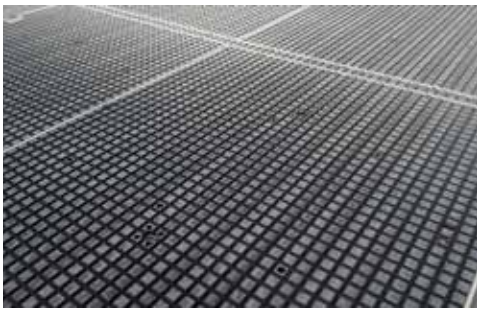
- BAZ 830n IQ 4,000 x 2,100 mm
- BAZ 829n IQ 3,000 x 2,100 mm
- BAZ 828n IQ 3,000 x 1,600 mm
- BAZ 827n IQ 2,500 x 1,250 mm

Guide system

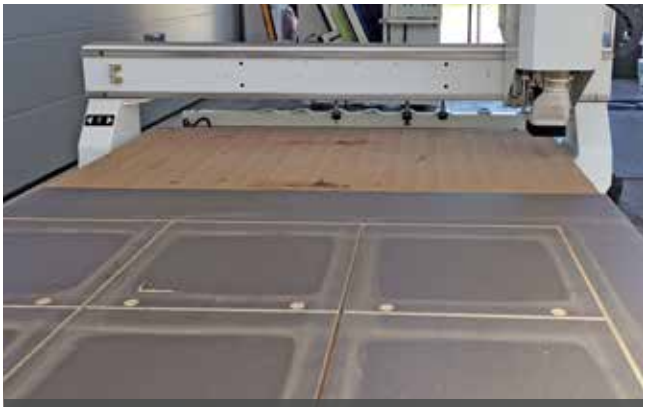
- guide systems mounted on linear guides:
  - double rack and pinion in X direction
  - rack and pinion in Y direction
  - ball screw in Z direction
- powerful servo motors in three axes:
  - 2 in X axis, 1 in Y axis, 1 in Z axis

Table configuration

- grid table for excellent vacuum suction effect
- vacuum table divided into six manually adjustable sections including two vacuum pumps each 160 m^3/h



Powerful, proven 9 kW main spindle SK30



Highest accuracy in cabinet and contouring processing

High-quality equiment for diverse applications

Application example

Manufacture of bicycle frames

Processing unit

- automatic tool change spindle 9 KW, 24,000 RPM with magazine for 6 tools (ISO30 cone and ER32 collet)
- automatic pickup tool changer with 6 positions
- tool length sensor and device for manual tool change

Excellent operational reliability thanks to high-quality electronic components

Control

- WEIHONG
- hand wheel with 14 positions to control X, Y, Z, U and V axes

Electrical cabinet

- separate electrical cabinet
- high-quality electronic components
- machine status light
- USB port

Automatic lubrication system

- linear guides (X, Y, Z) are lubricated automatically

Drag chain

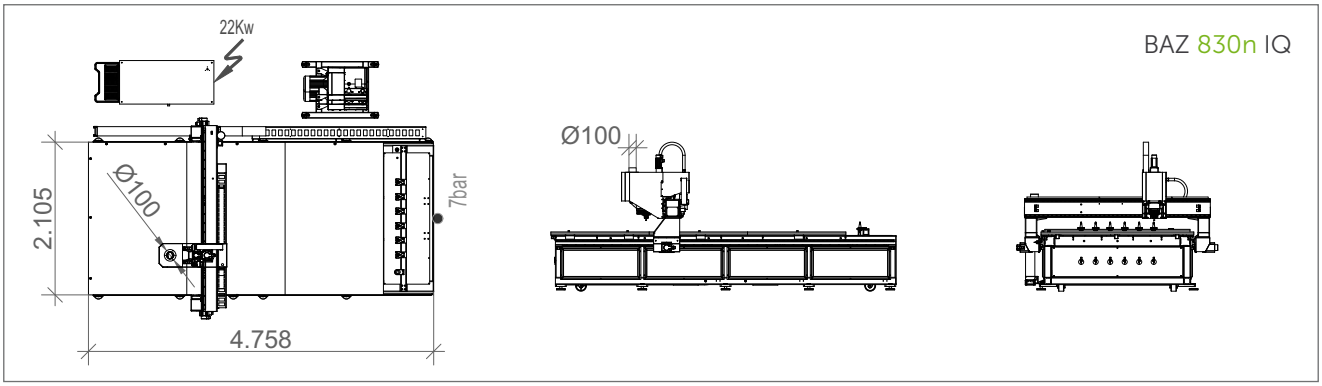
- high-quality cable chain for the protection of electric cables and compressed air lines during machine movement in X, Y and Z direction

BAZ 827n IQ • BAZ 828n IQ • BAZ 829n IQ • BAZ 830n IQ

Facts & figures in a nut shell

		BAZ 827n IQ	BAZ 828n IQ	BAZ 829n IQ	BAZ 830n IQ
Working range	X axis	2,500 mm	3,000 mm	3,000 mm	4,000 mm
	Y axis	1,250 mm	1,600 mm	2,100 mm	2,100 mm
	max. workpiece thickness	50 mm			
Max. travel speeds	X axis	50 m/min			
	Y axis	50 m/min			
	Z axis	20 m/min			
Main router spindle	amount	1			
	speed	24,000 RPM			
	power	9 kW			
	tool interface	SK30			
	collet	ER32			
	linear tool changer	6 positions			
Vacuum pump	power	2 x 5.5 kW			
	suction flow rate	2 x 160 m³/h			
	suction pressure	0.8 kg/cm²			
	cooling	air cooling			
Dust extraction	pipe diameter	100 mm			
	speed	min. 28 m/s			
	extraction connection	Ø 250 mm, height 2,400 mm			
	extraction capacity	min. 4,950 m³/h			
	pressure loss	min. 2,200 Pa			
		Note: Weight relief at extraction hose!			
Compressed air	required air pressure	7 bar			
Power supply	power	22 kW/68A			
	frequency	50 Hz			
	voltage	400 V, 3 phases			
Machine dimensions	length x width *	3,300 x 2,000 mm	3,800 x 2,300 mm	3,800 x 2,800 mm	4,800 x 2,800 mm
	height	1,820 mm			
	weight	2,500 kg	3,000 kg	3,200 kg	3,500 kg

* Note: plus safety devices depending on local conditions



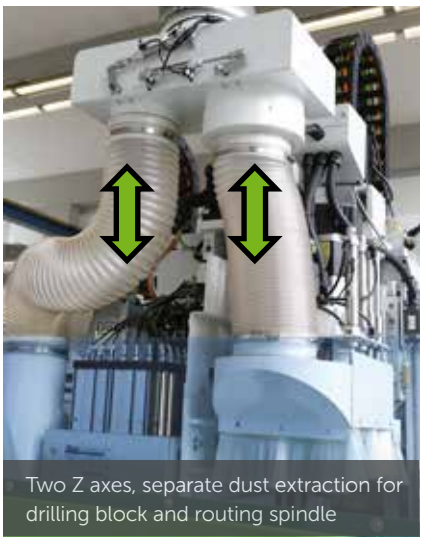
CNC machining center BAZ 875 IQ

The all-rounder for interior construction

The BAZ 875 IQ leaves nothing to be desired in terms of application technology. Cabinet making, door production and the entire range of panel processing are covered by our all-rounder.

Included as standard:

- powerful 12 kW HSK 63F tool change spindle
- tool changer with 8 positions driven by servo motor
- 14 vertical spindles, horizontal spindles 2+2 in X/Y, grooving saw in X
- 6 servo drives: X / Y / 2 x Z / C axis and tool changer
- chip conveyor belt
- barcode reader
- replaceable suction system
- clearly arranged switch cabinet with air conditioning system
- workshop-oriented DDX programming software with CAM module
- central lubrication



Two Z axes, separate dust extraction for drilling block and routing spindle

Covered linear guides

Automatic tool length measurement

Configuration of the work table

Table configuration

- 6 aluminum benches
  (4 benches with panel lifting device,
  1,250 mm long)
- hold down device for narrow pieces
  (optional)
- LED positioning system (optional)

Stop system with electronic stop sensor

- panel lifting device for easy workpiece positioning
- 6 rear stops, moveable with support
- 6 stops front/centre, moveable with support
- 2 side stops

Chip conveyor belt

- integrated in the frame
- for the removal of chips and residues out of the machine frame

Suction cups

- flexible suction system with LED indication (optional)
- 50 mm height
  - 10 suction cups - 125 x 140 mm
  - 8 suction cups - 125 x 75 mm
  - 6 suction cups - 125 x 50 mm

CNC machining center BAZ 875 IQ

Configuration of the processing units

8 positions tool changer

Servo motor driven

Servo driven tool changer with 8 positions

- HSK 63 F tool interface
- powerful 12 kW spindle, 18,000/24,000 RPM
- touch probe for tool length measurement
- digital AC servo motors
- dust-protected

Empty space detection prevents a crash in case of incorrect operation

Empty space detection

- empty space detection prevents a crash in case of incorrect operation

Drilling block configuration

- 14 individually selectable vertical spindles
  (8 in X axis / 6 in Y axis, 32 mm grid)
  8 horizontal drilling spindles Ø 8 mm
  - 2 + 2 in X direction
  - 2 + 2 in Y direction
- integrated grooving saw 1.7 kW, 4,000 RPM
  (inner Ø saw blade 35 mm, max. Ø 120 x 5.5 mm)

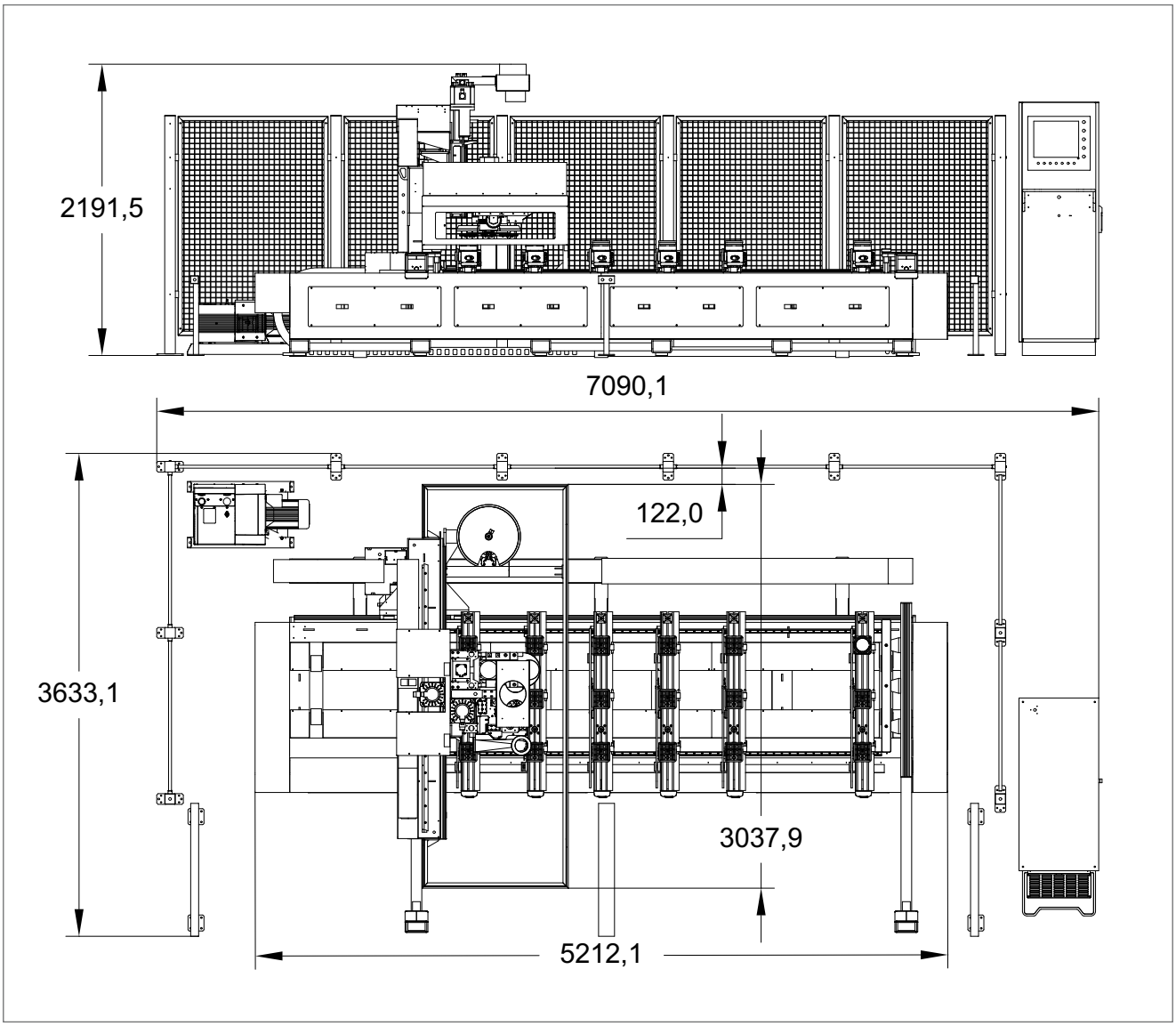
CNC machining center BAZ 875 IQ

Facts & figures in a nut shell

Working range Routing spindle	X axis	3,000 mm
	Y axis	1,250 mm
	max. workpiece thickness	80 mm (depending on tool setup length)
Working range Drilling block	X axis	3,000 mm
	Y axis	X row 1,500 mm, Y row max. 1,690 mm
	max. workpiece thickness	80 mm
Work table		6 moveable benches with 4 suction cups each
Max. travel speeds	X axis	80 m/min
	Y axis	80 m/min
	Z axis	20 m/min
Main router spindle	amount	1
	speed	24,000 RPM
	power	12 kW
	tool interface	HSK-63F
	tool changer	8 positions
Drilling block	vertical drills	14 (8 in X, 6 in Y)
	horizontal drills	8 (2 + 2 in X, 2 + 2 in Y)
	grooving saw	integrated grooving saw in X (120 mm diameter)
	power	1.7 kW
	speed	4,000 RPM
Vacuum pump	power	5.5 kW
	suction flow rate	140 m^3/h
	suction pressure	0.8 kg/cm^2
Compressed air	required air pressure	7 bar
Dust extraction	pipe diameter	200 mm
	min. dust extraction speed	28 m/s
	extraction connection	Ø 250 mm, height 2,400 mm
	extraction capacity	min. 4,950 m^3/h
	pressure loss	min. 2,200 Pa
		Note: Weight relief at extraction hose!
Power supply	power	26 kW/68A
	frequency	50 Hz
	voltage	400 V, 3 phases
Machine dimensions	length x width *	7,100 x 3,700 mm
	height	2,200 mm
	weight	4,800 kg

* Note: plus safety devices depending on local conditions

Layout



The series BAZ 890n IQ

Nesting lines

Nesting lines with integrated software and application modules for:

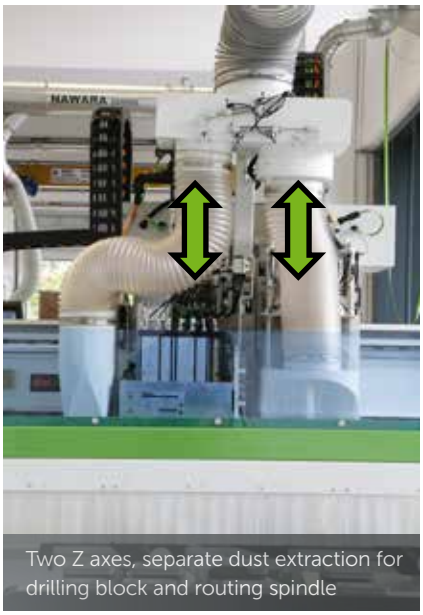
- cabinet making / furniture fronts
- frame furniture / upholstery furniture
- caravan construction
- facade construction

Intuitive operation and highly efficient dust extraction ensure highest productivity.

Work tables

- BAZ 890n IQ 2,500 x 1,250 mm
- BAZ 891n IQ 3,000 x 1,600 mm
- BAZ 892n IQ 3,000 x 2,100 mm
- BAZ 895n IQ 4,000 x 2,100 mm

Automatic loading with integrated barcode labelling as well as intelligent workpiece removal ensure smooth operation.



Two Z axes, separate dust extraction for drilling block and routing spindle

Covered linear guides

Two synchronized digital servo motors in X direction

Loading table

Automatic loading

- hydraulic lifting table with load capacity 3,000 kg
- lifts the workpiece stack sensor-controlled to the processing height
- when a workpiece is transferred to the processing machine, the lifting table automatically moves to the correct processing height
- recesses for loading with forklift
- BAZ 892n IQ and BAZ 895 IQ: double scissor lift table
- CNC-controlled beam with pneumatic alignment unit positions the uppermost workpiece with pin-point accuracy (only in conjunction with labelling)

Note:

- maximum stacking height 290 mm
- maximum stacking height when using a pit 1,000 mm

Pneumatic alignment unit

Side alignment

Length positioning

Option
Labelling

Automatic labelling device

- error-free labelling
- high efficiency: nesting and labelling of the following workpiece takes place simultaneously
- identification of each workpiece supports the further production process

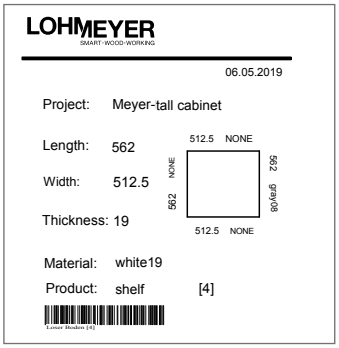
Barcode connection

- barcode scanner and barcode software
- supported barcodes: 1D barcode, 2D data matrix code

Ink jet printing for plywood

Label

- label contains the following information: workpiece dimensions, barcode, customer name, order number, information on edge processing, reference point for subsequent processing including all important information for production
- format can be adapted to customer requirements
- QR code can be used

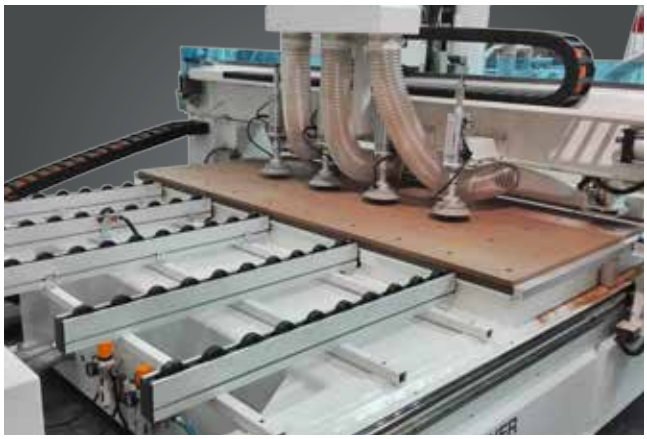


The series BAZ 890n IQ

Workpiece feeding

Loading station

- vacuum suction cups safely pick up and transport the workpiece to the work table
- a compact roller table transports the workpieces gently - thanks to low-friction rollers

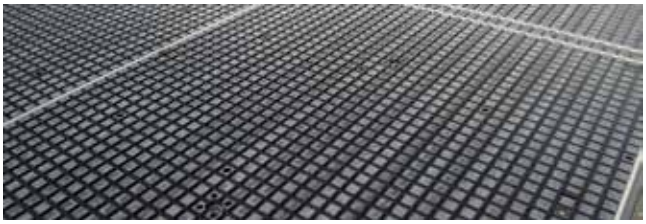


Work table

- grid table for mounting the MDF softboard (panel dimensions 2,070 x 2,800 mm)
- grooves and chamfers in the grid table provide an optimized vacuum
- manual control of the vacuum range
- option: Activation/deactivation of the vacuum depending on the X position of the gantry

Side positioning device

- stop fence left and right for a trouble-free feeding of the workpieces
- side alignment cylinder for precise positioning of the infed panel



The series BAZ 890n IQ

Drilling and routing

The high-quality Z slide with two separate CNC axes ensures optimum dust extraction, protects the ball screw and guarantees the best routing quality. The weight of the machining units is evenly distributed over two axes. This ensures stability and a higher machining quality.

Main spindle

- power: 12 kW, 18,000/24,000 RPM
- tool interface: HSK-63F
- air cooling, highly precise, stable and durable

Drilling block

- 10 vertical drills, grid 32 mm
- drill shank diameter: 10 mm
- max. drill diameter: 35 mm

Servo driven tool changer with 8 positions

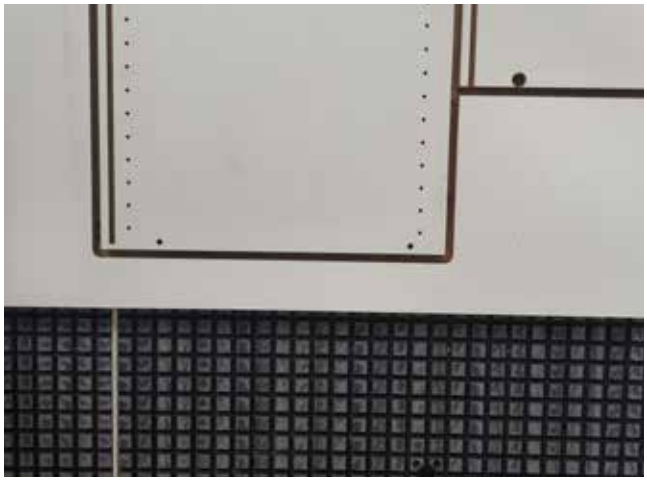
- HSK-63 F tool interface
- touch probe for tool length measurement
- digital AC servo motors - designed for mounting various equipment options
- empty space detection prevents a crash in case of incorrect operation

Drilling and routing

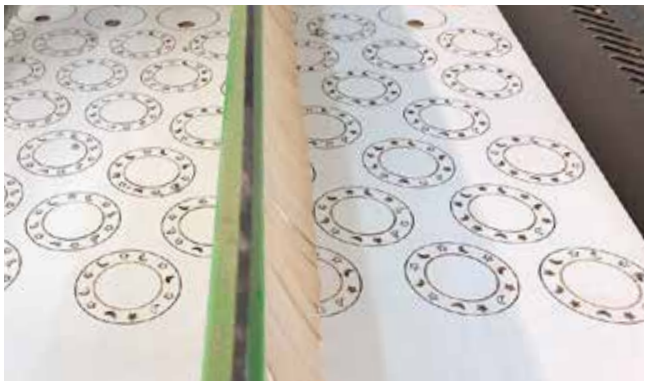
Tool sensor and tool holder

- tool sensor for an efficient tool setting
- tool change device allows easy tool change
- tool length is read after change and compared with the integrated tool database

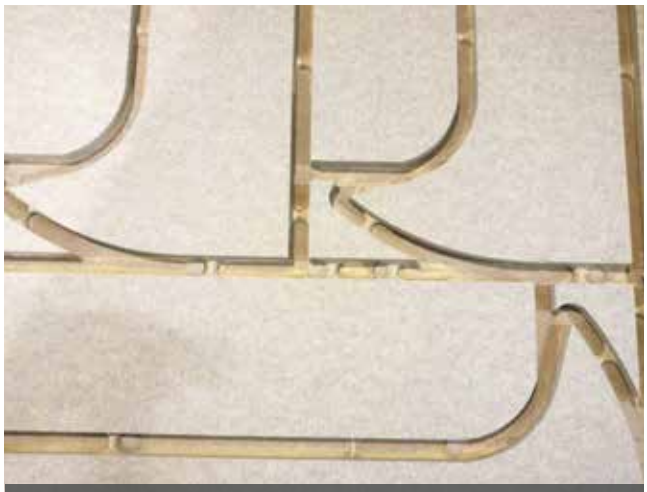
Automatic tool length measurement



Powerful proven 12 kW main spindle, HSK-63F



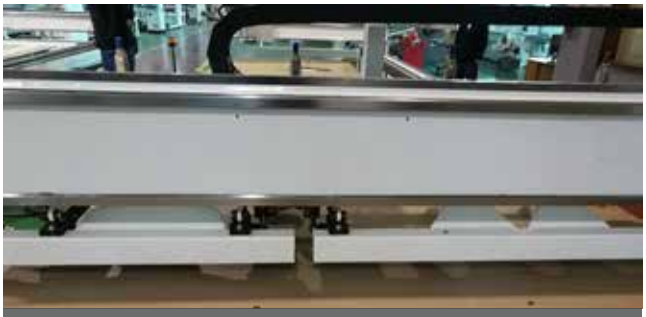
Integrated blowing nozzles swirl the chips in the routing groove and ensure a clean nest / higher extraction efficiency (option)



Automatic setting of workpiece bridges for small formats, even small scrap pieces, for safe processes

The series BAZ 890n IQ

Unload station and dust extraction



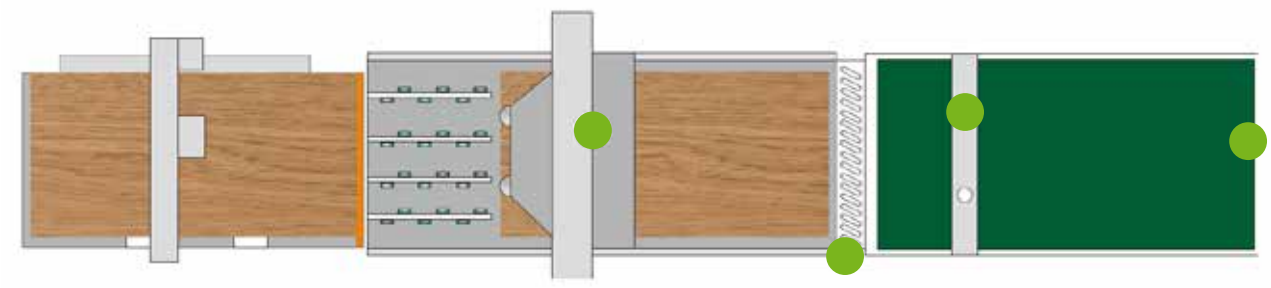
Separate discharge unit (option), when using different raw panels (e.g. raw panel width 1,250 mm and 2,070 mm)

Automatic unloading station

- conveyor belt for conveying workpieces
- optoelectronic sensor ensures that workpieces do not fall down at the end of the belt
- 4 dust extraction points

Dust extraction

- four central extraction points for clean workpieces
- dust extraction at the work table when removing the workpiece and transporting it to the unloading table
- upper and lower dust extraction for efficient dust removal after the machined workpiece has left the worktable
- program controlled suction nozzles



BAZ 890n IQ • BAZ 891n IQ • BAZ 892n IQ • BAZ 895n IQ

Facts & figures in a nut shell

		BAZ 890n IQ	BAZ 891n IQ	BAZ 892n IQ	BAZ 895n IQ
Working range	X axis	2,500 mm	3,000 mm	3,000 mm	4,000 mm
	Y axis	1,250 mm	1,600 mm	2,100 mm	2,100 mm
	max. workpiece thickness	max. 30 mm			
Max. travel speeds	X axis	50 m/min			
	Y axis	50 m/min			
	Z axis	20 m/min			
Main router spindle	amount	1			
	speed	24,000 RPM			
	power	12 kW			
	tool interface	HSK-63F			
	collet	ER32			
Automatic tool changer	amount of tools	tool magazine with 8 positions			
	control	servo			
Drilling block	vertical drills	10			
	max. drill diameter	35 mm			
	power	1.7 kW			
	speed	4,000 RPM			
Vacuum pump	power	2 x 5.5 kW			2 x 7.5 kW
	suction flow rate	2 x 160 m^3/h			2 x 250 m^3/h
	suction pressure	0.8 kg/cm^2			
	cooling	air cooling			
Dust extraction	pipe diameter	1 x 200 mm, 1 x 125 mm			
	dust extraction speed	min. 28 m/s			
	extraction connection	Ø 250 mm, height 2,400 mm			
	extraction capacity	min. 4,950 m^3/h			
	pressure loss	min. 2,200 Pa			
		Note: Weight relief at extraction hose!			
Compressed air	required air pressure	7 bar			
Power supply	power	26 kW/68A		31.4 kW/68A	35 kW/68A
	frequency	50 Hz			
	voltage	400 V, 3 phases			
Machine dimensions	length x width *	10,000 x 3,500 mm	12,850 x 4,500 mm	12,850 x 5,000 mm	15,850 x 5,000 mm
	height	2,600 mm			
	weight	6,000 kg	7,600 kg	8,160 kg	9,000 kg

CNC throughfeed drilling machine N2508

Industrial drilling lot size 1

Four individually movable drilling blocks arranged on two gantries ensure maximum productivity. Simultaneous machining of long workpieces or parallel machining of two short workpieces guarantee a highly efficient machining process.
A robust machine frame with integrated workpiece transport system controlled by 16 servo motors forms a reliable basis for precise workpiece positioning.
The panels are fed via a roller conveyor with inclined rubber rollers. Automatic loading allows the machine to be integrated into automated production lines. A conveyor belt system with four separately controlled areas and two simultaneously operating stations as well as an unloading station ensure reduced auxiliary times. The two workstations are driven by frequency-controlled servo motors, which allow fast starting and stopping. The workpieces are positioned separately in each work station.
The work table 3,000 mm x 800 mm made of robust phenol in combination with the vacuum clamping system ensures maximum accuracy, especially for horizontal drilling.

Vacuum clamping system

- vacuum cups are activated automatically depending on the panel size

Two independent gantries with four drilling blocks

- master/slave drive system for the gantries
- four separate drilling blocks (Y axis / Z axis) for simultaneous machining of two short panels or one long panel
- cross layout of the four drill heads allows for a minimum hole spacing

Drill head configuration

- in total 100 drills:
  - vertical: 21 x 4
  - horizontal: 3 x 4 in X; 2 x 2 in Y
- additional pressure system for maximum precision in horizontal drilling

Guide ruler

- adjusts the panel in Y direction
- moves up and down in X direction to secure horizontal pressure

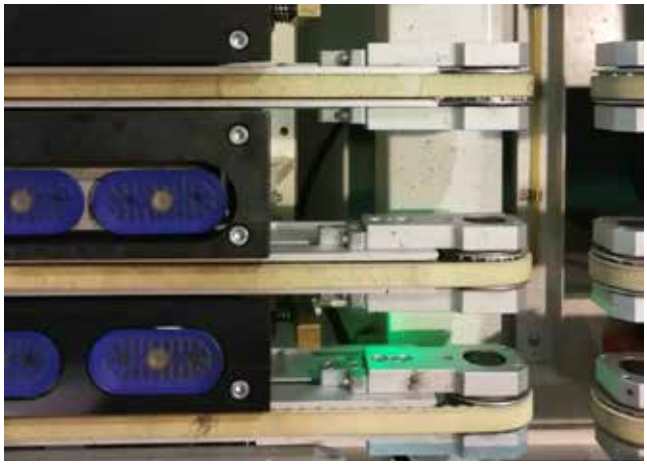
Control

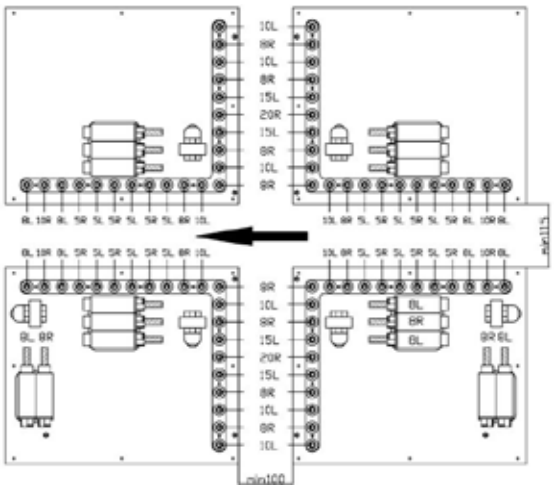
- IPC with 17" screen
- USB port
- SYNTEC control
- hand wheel for easy feeding of new workpieces

N2508

Facts & figures in a nut shell

Workpiece dimensions	length (double work station)	250 - 2,500 mm (2 x 250 -2 x 1,300 mm)
	width	120 - 800 mm
	height	12 - 50 mm
Max. travel speeds	X axis	80 m/min
	Y axis	80 m/min
	Z axis	20 m/min
Drilling block	vertical drills	21 x 4
	horizontal drills	X=3 x 4, Y=2 x 2
	speed	4,000 RPM
Vacuum pump	power	5.5 kW
	suction flow rate	160 m^3/h
	suction pressure	0.5 kg/cm^2
Compressed air	required air pressure	7 bar^2
Dust extraction	pipe diameter	4 x 200 mm
	min. dust extraction speed	28 m/s
	extraction connection	Ø 250 mm, height 2,400 mm
	extraction capacity	min. 4,950 m^3/h
	pressure loss	min. 2,200 Pa
		Note: Weight relief at extraction hose!
Power supply	power	41 kW/68A
	frequency	50 Hz
	voltage	400 V, 3 phases
Machine dimensions	space requirement	11,200 x 2,100 mm
	height	2,300 mm
	weight	5,000 kg





6-sided CNC drilling and routing centre NCB2412

Drilling, routing, grooving in one set-up

Application

- drilling and routing on six sides
- grooving on the top and bottom side with milling spindle
- X positioning with CNC controlled collets that can be moved in relation to each other
- automatic reclamping in case of collision with machining units
- no set-up times
- Windows-based control
- IPC, 17" LCD screen, 5 USB ports

Travel ranges / travel speeds

- X axis: 2,400 mm 110 m/min
- Y axis: 1,200 mm 75 m/min
- U axis: 110 m/min
- Z axis: 70 mm 30 m/min
- individual servo motors for all spindles
- linear guide systems:
  - rack and pinion (X+Y)
  - ball screw (Z)

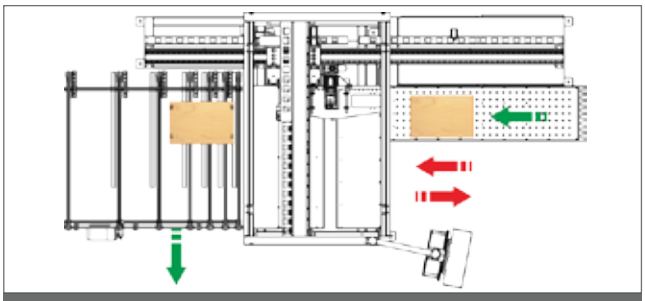
Loading and unloading

Guideway with double clamping collets

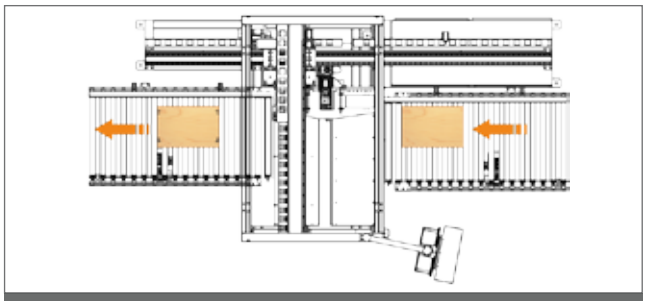
- fast moving, long guideway enables high processing speed
- double clamping collets and an automatic side alignment device guarantee high machining accuracy

Air float table (option)

- air float table made of laminate board and steel for gentle and scratch-free conveying of the panels



Loading from the front, removal from the front or side



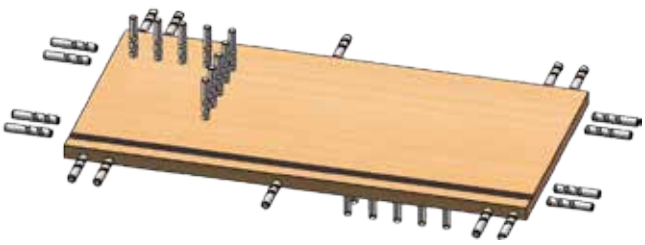
Loading from the front, unloading from the back

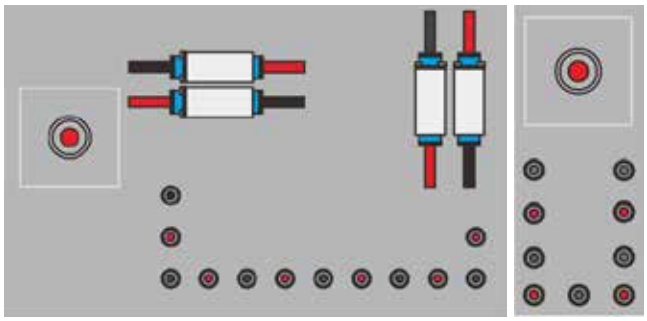
NCB2412

Processing units

Processing units

- equipped with 2 drill heads and 2 x 3.5 kW routing spindles:
  - upper processing unit:
    1 x 3.5 kW main spindle
    vertical drills: 12
    horizontal drills: 8 (X 2+2; Y 2+2)
  - lower processing unit:
    1 x 3.5 kW main spindle
    vertical drills: 9





Upper and lower processing units

NCB2412

Facts & figures in a nut shell

Workpiece dimensions	length	220-2,550 mm
	width	250-1,200 mm
	height	12-50 mm
Processing dimensions	X axis	2.400 mm
	Y axis	1,200 mm
	Z axis	70 mm
Work table	type	air float table
	material	HPL+steel
Max. travel speeds	X axis	110 m/min
	Y axis	75 m/min
	U axis	110 m/min
	Z axis	30 m/min
Main spindle	amount	2
	power	2 x 3.5 kW
	collet chuck	ER25
	speed	18,000 RPM
Drilling block	vertical drills (upper unit)	12
	vertical drills (lower unit)	9
	horizontal drills	8 (X 2 x 2, Y 2 x 2)
	max. drill diameter	35 mm
	drill grid	32 mm
	speed	4,000 RPM
	drill diameter	10 mm
Compressed air	required air pressure	7 bar
Dust extraction	pipe diameter	bottom: 125 mm x 1, top: 150 mm x 1
	min. dust extraction speed	28 m/s
	extraction connection	Ø 250 mm, height 2,400 mm
	extraction capacity	min. 4,950 m^3/h
	pressure loss	min. 2,200 Pa
		Note: Weight relief at extraction hose!
Unloading	standard	air bearing table (length 1,500 mm)
Air blower	power	2 kW
	diameter suction nozzle	60 mm
Power supply	power	19.4 kW/68A
	frequency	50 Hz
	voltage	400 V, 3 phases
Machine dimensions	space requirement	5,900 x 2,640 mm
	height	2,100 mm
	weight	3,500 kg

NCB2806

Precise panel drilling from all sides

Equiment

Panel positioning

- side positioning cylinder for workpiece positioning
- side console for support of long workpieces
- pneumatic cylinders for workpieces fixing during processing
- wear-resistant worktable (2,780 mm x 598 mm)

Transmission type

- X axis: rack and pinion
  Y axis: ball screw
  Z axis: screw thread
- servo motors 1 in X and 1 in Y

Drill spindle

- 2.2 kW; 18,000 RPM

User-friendly terminal

- 17'' screen, scanner, 6 USB ports

Automatic lubrication system

NCB2806

Facts & figures in a nut shell

Workpiece dimensions	length	50-2,800 mm
	width	50-600 mm (drilling depth: 35 mm)
	height	10-50 mm
Work table	work area	2,780 x 598 mm
	height	980 mm
Max. travel speeds	X axis	5-100 m/min
	Y axis	5-60 m/min
	Z axis	manuell
Main spindle	amount	1
	power	2.2 kW
	drilling depth	max. 35 mm
	speed	18,000 RPM
Compressed air	required air pressure	7 bar
Dust extraction	pipe diameter	75 mm
	min. dust extraction speed	28 m/s
	extraction connection	Ø 250 mm, height 2,400 mm
	extraction capacity	min. 1,500 m^3/h
	pressure loss	min. 2,200 Pa
		Note: Weight relief at extraction hose!
Power supply	power	4 kW
	frequency	50 Hz
	voltage	400 V, 3 phases
Machine dimensions	space requirement	3,500 x 2,000 mm
	height	1,500 mm
	weight	1,500 kg

General information

Electrical cabinet

- independent control cabinet with air conditioning
- clear arrangement of the electronic components
- high-quality safety modules
- cable labelling for easy fault diagnosis

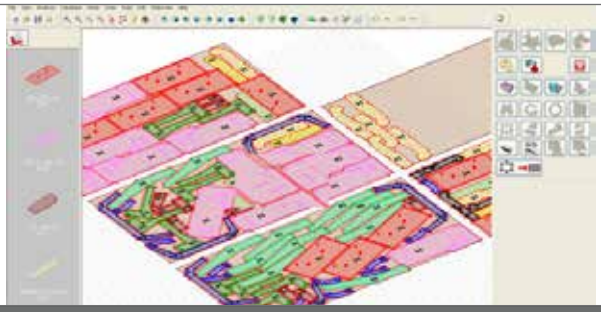
Note: The control cabinet equipment varies depending on the machine type.

DDX EasyWOOD Nest

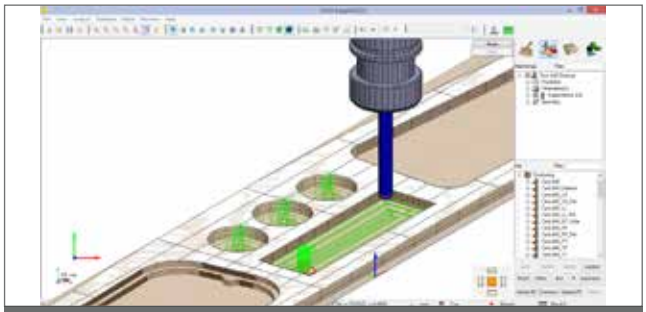
The software solution for woodworking

- EasyWOOD is a CAD/CAM software solution for woodworking and the processing of similar materials with NC controlled machines.
- EasyWOOD can control the complete production process and thereby saves additional costs:
  - free drawing and/or import of elements
  - machining with 3, 4, 5 axes
  - calculation of the processing time

Toolpath simulation

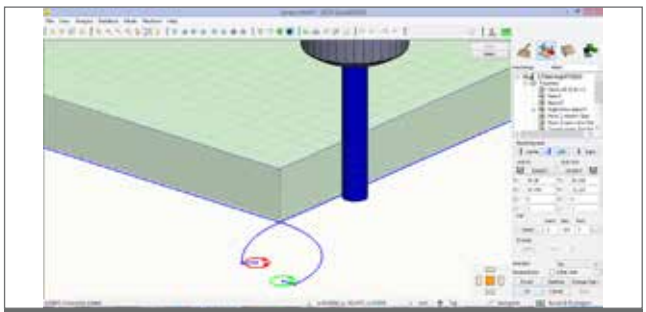


TrueShape Nesting

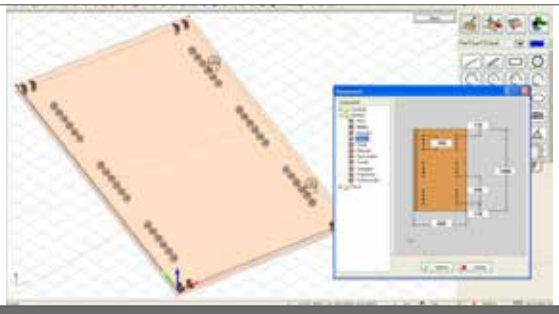


Toolpath simulation

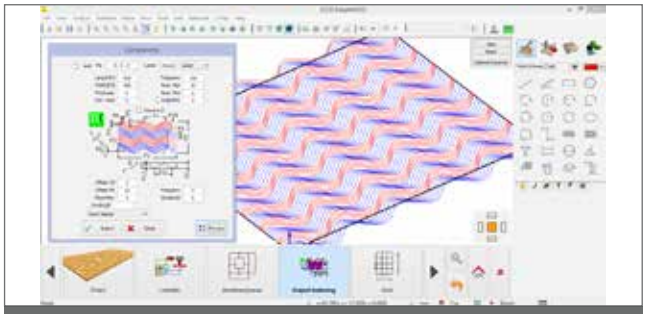
2D CAD functions (arcs, double arcs, straight lines, rectangles, squares, ellipses, circles, regular polygons, etc.)



Various contour machining operations and generation of start and stop movements



Scripting language for creating recurring parametric constructions, e.g. worktops, table forms, etc.



Structuring and modeling

C axis aggregates from Atemag

DUO Function Line

Drilling, routing, sawing

- with two tool interfaces, angle 90°
- max. drive speed 10,000 RPM
- max. tool spindle speed 15,000 RPM
- gear ratio i = 1:1.5
- rotating direction left/right
- torque max. 20 Nm
- tool interfaces ER25, ER32
- saw blade flange 30 mm
- sawblade diameter max. 180 mm

EXTRA

Drilling and routing

- with two tool interfaces
- tool spindle position 90°
- max. drive speed 10,000 RPM
- max. tool spindle speed 15,000 RPM
- gear ratio i = 1:1.5
- rotating direction left/right
- torque max. 20 Nm
- tool interfaces ER32, ER16
- spindle for omega router ER16

MONO

Drilling, routing and sawing

- with one tool interface, angle 90°
- max. drive speed 10,000 RPM
- max. tool spindle speed 15,000 RPM
- gear ratio i = 1:1.5
- rotating direction left/right
- torque max. 22 Nm
- tool interfaces ER25, ER32
- saw blade flange 30 mm, diameter max. 180 mm
- When using a saw blade or a roughing cutter, a gear reduction is recommended
- type MONO, version R: max. drive speed 12,000 RPM, max. tool spindle speed 8,000 RPM, gear ratio i = 1:0.676, torque max. 22 Nm

VARIO VISO FUNCTION LINE

Drilling, routing and sawing

- machine interface HSK-F63
- 1 output
- max. drive speed 15.000 RPM
- max. tool spindle speed 15.000 RPM
- torque max. 20 Nm
- gear ratio 1:1,00
- swivel range 0-100°
- manual angle adjustment
- digital angle readout
- tool adaptation 1: saw S1/saw S2 (K2)

Wood IQ GmbH

Our service – just smart

For detailed information on the CNC machining centers and other machines for cabinet manufacturing please refer to
www.lohmeyer-iq.com

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