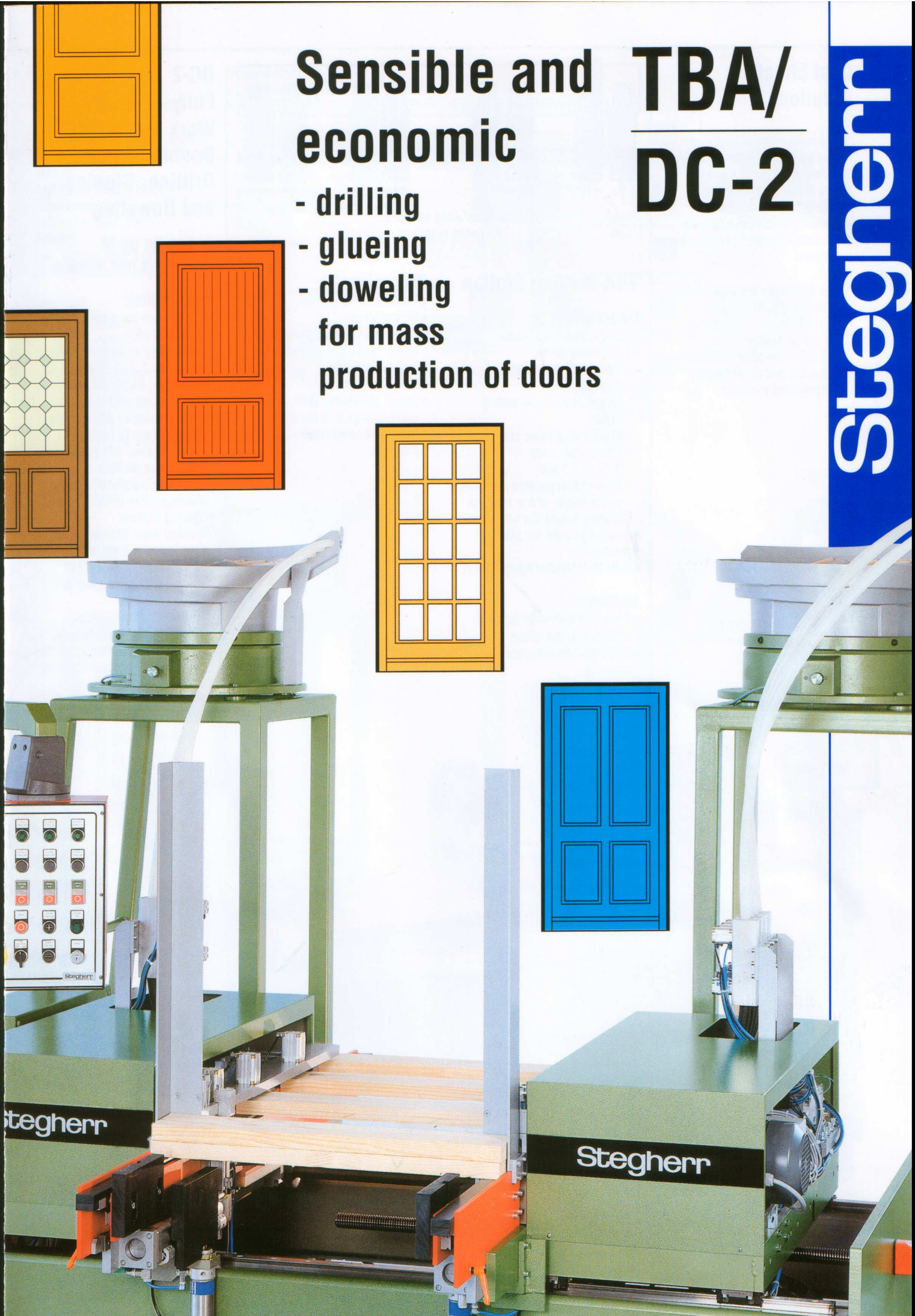


**Sensible and
economic**

- drilling
 - glueing
 - doweling
- for mass
production of doors**

**TBA/
DC-2**

Stegherr



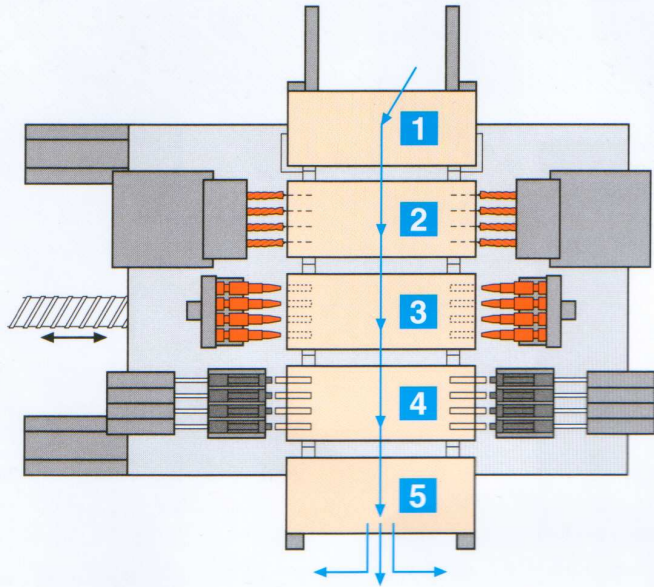
- Glueing and Doweling separately possible
- Graduated ruler for precise positioning
- Accommodates a wide range of piece sizes:
Width:
min. 50 to max. 240 mm
Thickness:
min. 40 to max. 55 mm
Length:
min. 300 to max. 1,000 mm
(other measures on inquiry)

Options:

- Automatic infeed
- Automatic outfeed
- Backward transport of finished workpieces (for one-person operation)
- Electronic glue sensor
- Cross-Cut Saw
- Counter Profiling Machine

Procedure:

- Load Magazine **1**
- Press Start button
- Bottom piece in Magazine is conveyed to Drilling Station **2**, clamped, drilled (1 to 4, option: 6 holes, depending on piece width) and released
- Piece is conveyed to Glueing Station **3**, clamped, glued and released
- Piece is conveyed to Dowel Insertion Station **4** and clamped; dowels are inserted; piece is released
- Piece is conveyed to Unloading Station and manually or automatically unloaded **5**



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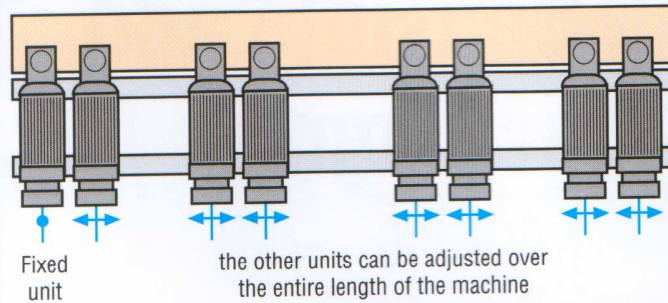


Cost Effective Solutions

The development of these new, highly practical machines for the sensible mass production of doors is the culmination of STEGHERR's long years of experience in the development and manufacture of woodworking machines.

These machines are user friendly, simple and sturdily built.

They are controlled by STEGHERR developed electronics and can be quickly and easily retrofitted and modified.



TBA Drilling Station

Description:

- Sturdy, non-twist frame
- 2-8 Drilling units:
 - Integrated pneumatic clamping
 - Single or multiple drilling heads
 - Maximum stroke: 100 mm
 - Power (per unit): 0.75 or 1.1 kW
 - Each unit adjustable over the entire length of the machine
 - Drilling height set with spacers
- Graduated ruler for precise positioning
- Also to customer specification

Options:

- Table extensions to facilitate drilling into end piece
- Automatic conveyance and stacking

Procedure:

- Position drilling units
- Mount piece
- Press Start button (Drilling units clamp in place pneumatically.)
- Drill and release
- Unload piece
- Speed (clamping, drilling, unclamping): c. 5 seconds
- Central vacuum cleans up wood shavings

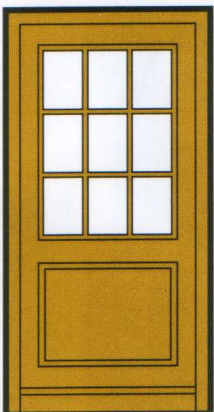
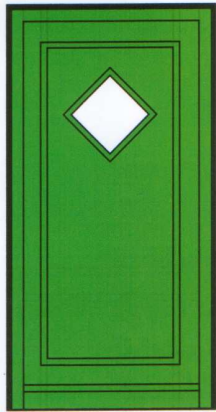
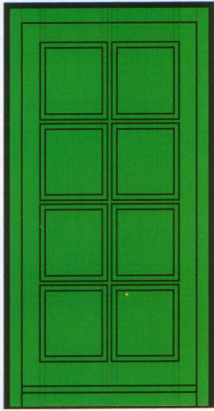
DC-2 Fully Automated Work Station for Double Sided Drilling, Glueing, and Doweling

Capacity: up to 20 pieces per minute

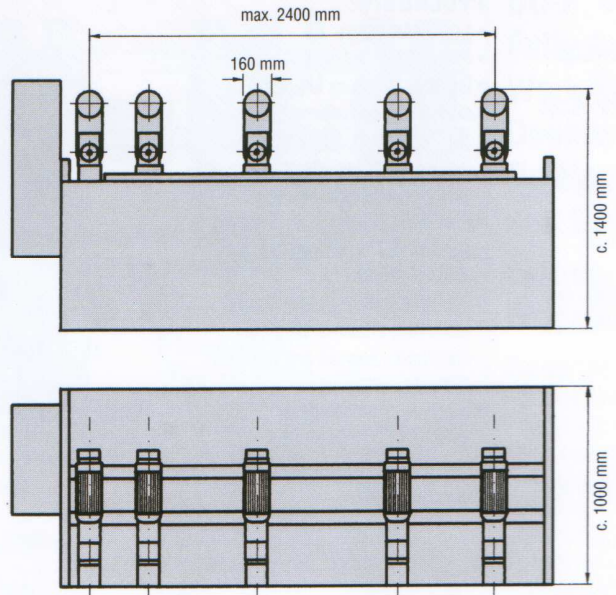
Description:

- Sturdy, non-twist frame
- Drilling Station:
 - One horizontal Drilling Unit on each side: 2.2 (4.0) kW, 2800 rpm, 50 Hz, linear bearings, adjustable drilling depth, equipped with multiple drilling heads to customer specifications, drill guides for drilling into profiles
- Lateral air nozzle to blow shavings from drilled holes
- Glueing Station:
 - Refined steel, high pressure Glue Injection Unit, fully adjustable up to c. 50 bar pressure, 1 to 4 (option 6) nozzles per side
- Dowel Insertion Station:
 - Dowels per side: 1 to max. 6
 - Dowel diameter: max. 16 mm
 - Dowel length: max. 130 mm
- Two dowel conveyors
- Digital control displays
- SPS control

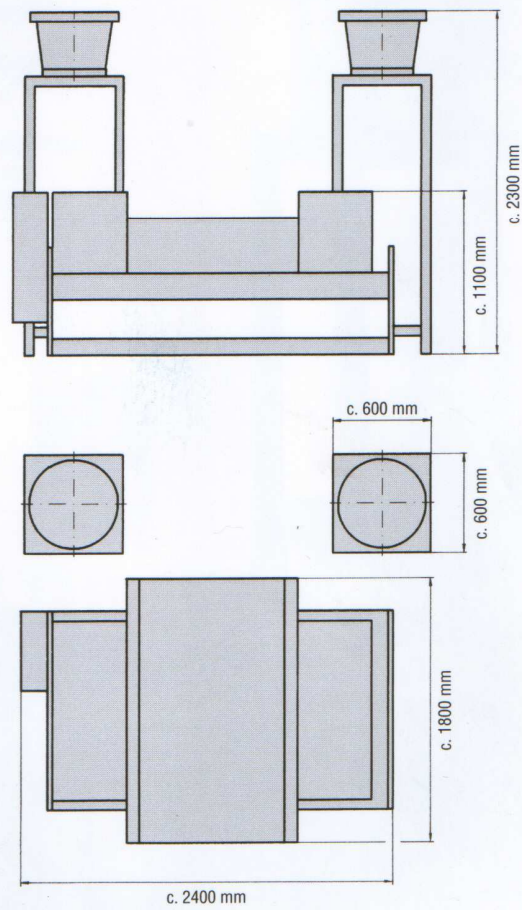




Measure diagram TBA



Measure diagram DC-2



Subject to technical alterations

3/96 K+R

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