

K 320 edge banding and combination machines



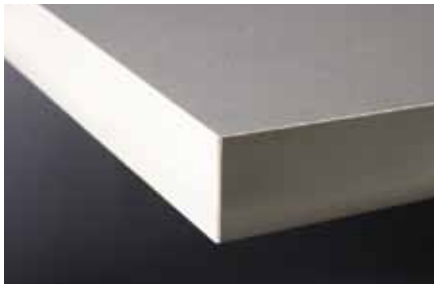
Top quality at an affordable price

Is top class quality a priority to you? Then you have come to the right address with HOMAG!

In today's world, good is simply no longer good enough. Only by delivering furniture in absolute premium quality can you be sure of staying out in front of your competitors. An item of furniture tells its own story about how and on which machine it was produced. The edge progression and joint quality must be just right every time – and by producing with plants and machines from HOMAG you know they will be. The use of high-performance HOMAG machines also guarantees outstanding efficiency. A high level of machine availability and top-class quality make for satisfied customers.

The production of premium-quality furniture demands premium-quality machines. Machines of the calibre made by HOMAG.





0.4 mm melamine



0.6 mm veneer



2 mm PVC

For more information, go to:

www.homag.com

www.youtube.com/homaggroup



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K 320 – The new standard in edge banding

The K 320 is the culmination of many years of accumulated expertise tried and tested in our high-performance machine ranges. As a result, the K 320 can be used for practically any type of edging material, ensuring that you can work with the utmost efficiency and flexibility. Like its predecessors, this series has all the hallmarks of HOMAG quality and reliability. Choose between a KAL 320, which processes pre-sized workpieces in unfinished fixed dimensions or the KFL 320, which is capable of panel sizing, edge application and finish processing.

Edge banding machine KFL 326 – truly professional cost-to-performance ratio for your series production.



**The secret behind precision edges:
The K 320**

Series K 320 edge banding machines offer an affordable price tag, durability and excellent availability.

They do it all: Sizing, profiling, edging, processing, rebating and grooving a wide range of different workpieces. These include chipboard, MDF, coreboard panels, solid wood and plastics.

Just as flexible: Edge banding. Using hot-melt and PU adhesive, melamine, PVC, ABS or veneer edges can be applied in coil or fixed length material form.

Benefits of the basic machine

- Permanent equipment with high-performance units
- A high standard of production quality coupled with a long service life
- Optimum trimming results
- Extremely smooth running and high workpiece quality due to roller transport chains



The HOMAG K 320 series – as variable as your production needs

When it comes to processing your workpieces, another key factor alongside quality is flexibility. Which is why the machines of the HOMAG K 320 series are adjusted precisely to the varying widths of your workpieces. Choose from a wide selection of working widths from 1 000 to 3 500 mm in steps of 500 mm, with facility for reducing the minimum longitudinal working width to 195 mm. If you are processing wide workpieces, we recommend using the automatic central support.



Lengthwise processing with KFL/KAL 320

Precise guidance: The workpieces are guided into the machine along the infeed fence, after which they can be cut precisely to size.



Crosswise processing with KFL/KAL 320

The steplessly adjustable dogs of the transport chain form the workpiece stop. This allows even softforming parts or profiled components to be reliably transported through the machine without damage. Depending on workpiece length, the dogs can be extended to different distances between workpieces.

Greater economy due to a long service life and optimum availability

With their sturdy design and with optimum care and maintenance, K 320 machines will go on working for generations. The optimized chip and waste piece disposal enhances machine availability and service life.



Roller block link chain

All machines of the K 320 series are equipped with roller block link chain. This progressive technology ensures that all workpieces are transported with pinpoint precision and processed with extreme dimensional and repeat accuracy. Experience shows that the HOMAG block link chain is far less susceptible to wear than block link chain types with semi-circular rod.

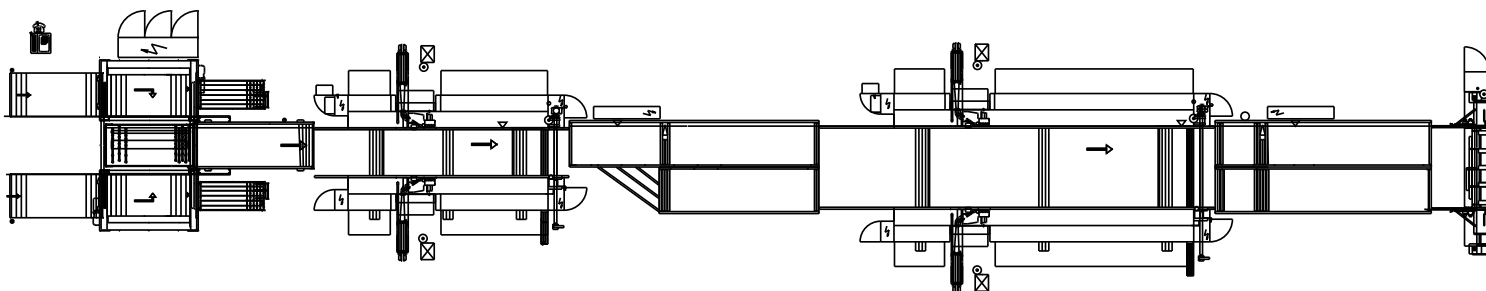
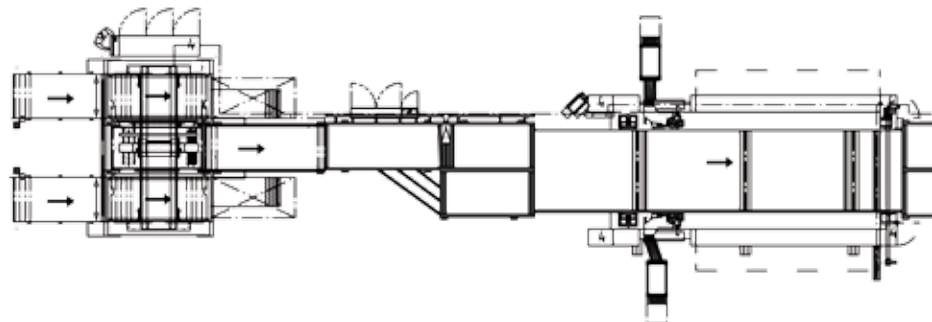
The proof: Outstanding performance over a feed distance of more than 200 m even in dusty and abrasive environments.

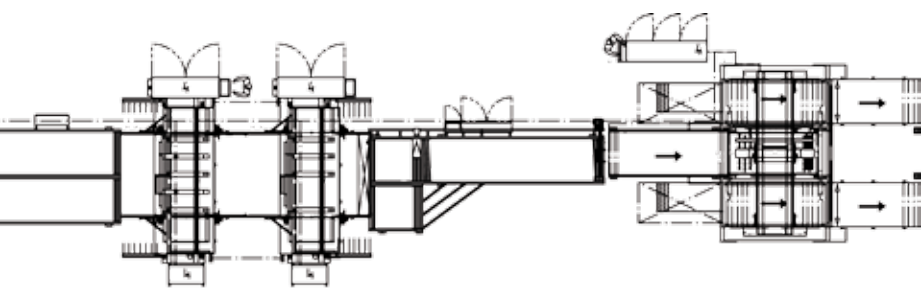
Efficiency through series production

The classical application for double-sided machines and type K 320 machine lines: medium to large-scale series production. These machines are distinguished by optimum output where minimal resetting processes are involved. The reliable technology of the high-performance K 320 makes for more efficient panel furniture production. We provide the ideal solution to match your requirement.

How you use the K 320 is determined by the capacity

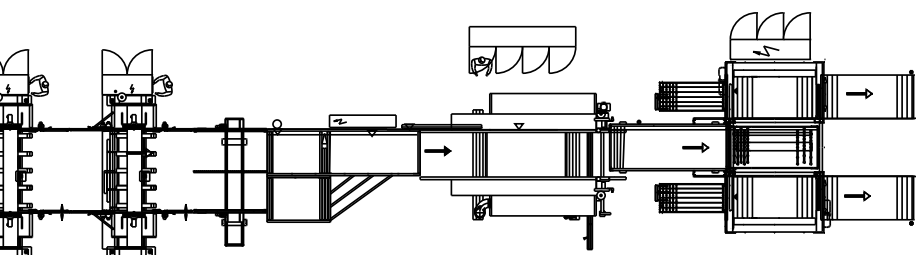
At HOMAG, production lines are specifically designed, installed and commissioned for you. Because the networking of individual processing machines and material flow systems is a complex task in which the support and expertise of your HOMAG Engineering team is invaluable.





1) Short machine line – for medium capacities

In this example, the workpieces are processed longitudinally and transversely in two work steps, with return transport of the stacks. Feeding and stacking systems as well as rotary stations to change from longitudinal to transverse format or vice versa permit an automatic production process.

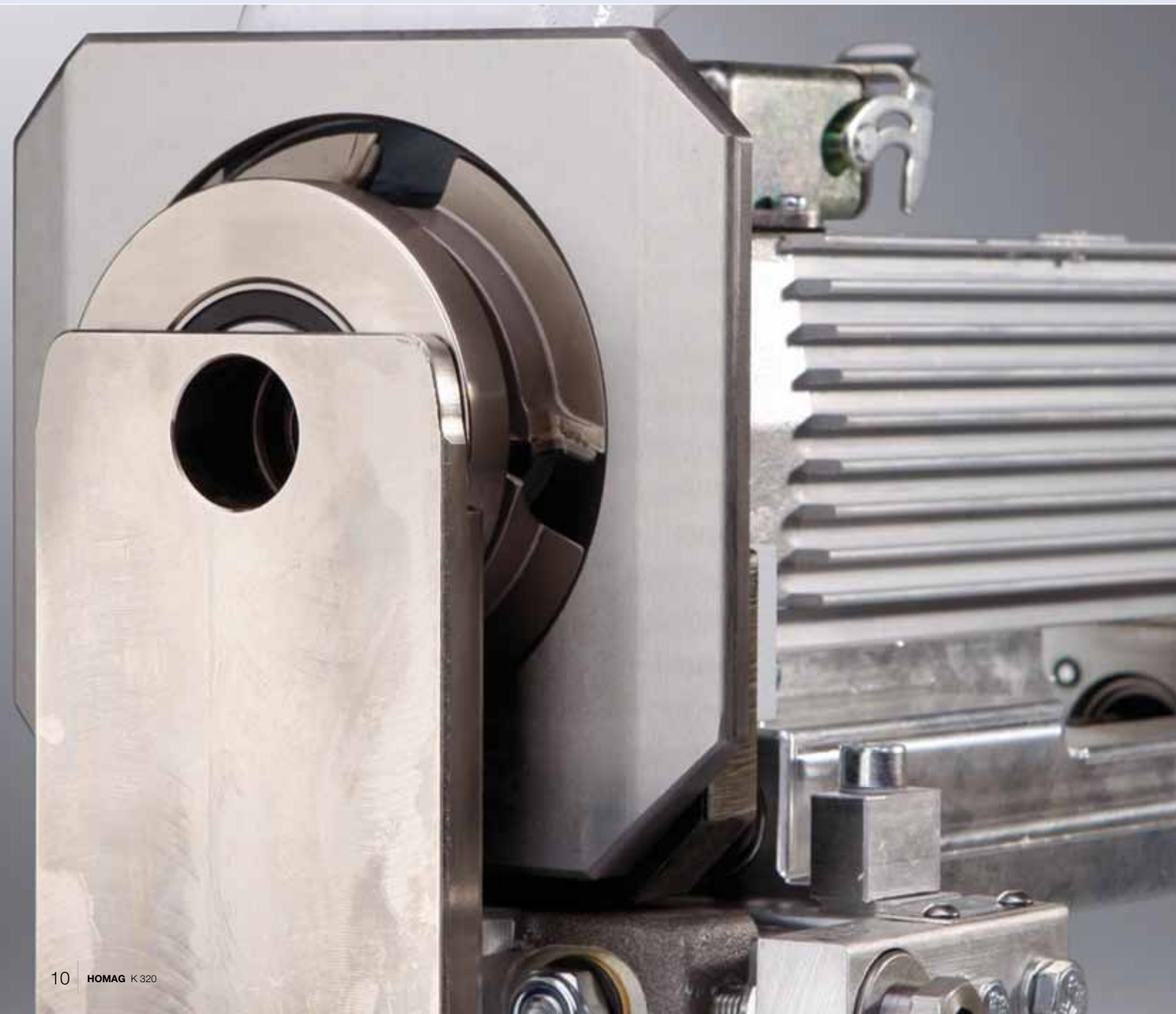


2) Production line – how your production plant could look tomorrow

For the longitudinal and transverse processing of workpieces in a single pass for medium to large-scale series. Including feeding and stacking systems, automatic throughfeed drilling machines and dividing saw.

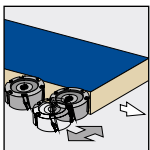
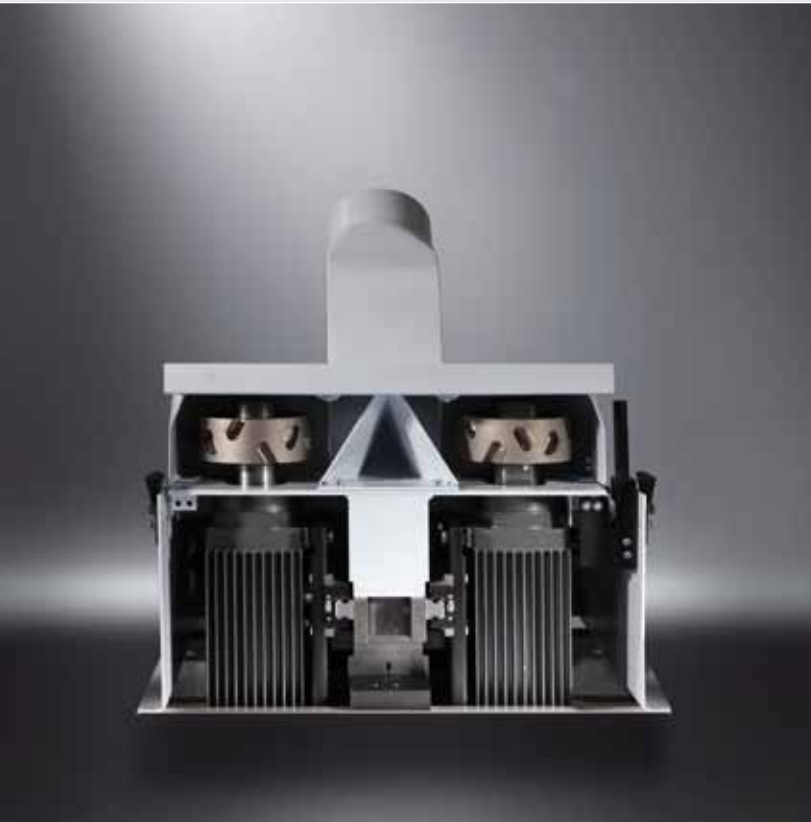
Our range of modular units – always effective

A versatile range of different units is necessary to cope with varied processing operations. By continuously extending the offered functions, we ensure that you have the right solution available to cope with changing trends.



Sizing units – your requirement, our solution

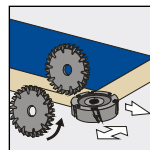
HOMAG hogging units are true professionals when it comes to workpiece sizing. Whether coreboard panels, surface layer overhang or transverse veneer – HOMAG plants are happy to cope with whatever you throw at them.



Jointing trimming

This unit permits a high level of processing precision, is extremely hardwearing and is also designed to ensure an above-average service life. The tool diameter is 125 mm.

Standard feature of KAL.



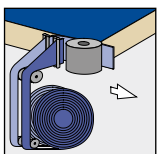
Compact double hogger KD11

High-performance 6.6–11 kW motors permit the safe, splinter-free hogging of greater processing allowances. The KD11 unit performs sizing operations in the longitudinal and transverse direction with three motors. The tool diameter is up to 250 mm.

Standard feature of KFL.

Gluing units – reliable hot melt glue application

HOMAG gluing units are ideal for a fast, positive-locking glue bond. The standard gluing unit uses the pre-melt system. The heated glue roller ensures an optimum gluing temperature, while magazine height adjustment offers scope for processing wide-ranging different workpiece heights. A simple, toolless quick changeover of the application unit allows changeover to other hot melt glue colors with a minimum delay.



Hot-melt gluing unit

For optimum glue application on the narrow surface. In case of changes to workpiece thicknesses, there is no need for resetting of the glue application roller.

Quick-release clamping system for application unit (option)

For fast changeover of hot melt glue colors. This prevents mix-up of different hot melt glue colors.



Standard feature of KFL.

Optional feature of KAL.



Melting unit with granulate tank

With a melting rate of 18–35 kg/h, there is always plenty of hot-melt glue available.

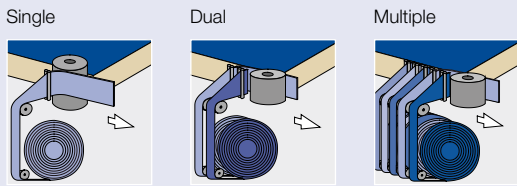
Optional: Even quantities of up to 45 kg/h pose no problem.

PU melting unit

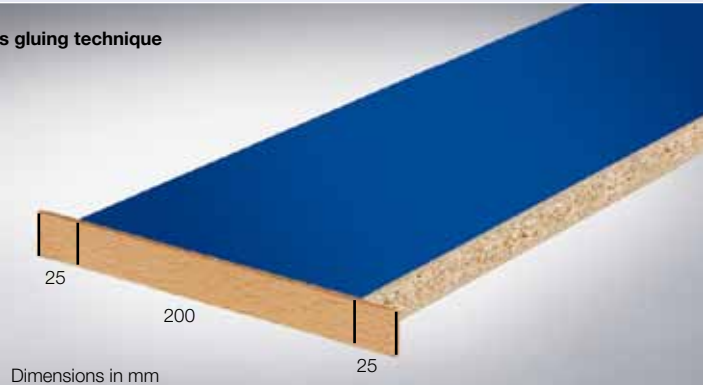
A range of possibilities are available for melting PU. Ask us.

Edge feed: Versatile and precise

Servo edge feed does more than just sound impressively high tech – it actually cuts out edging waste and so tangibly reduces unit costs. We have actually patented this precisely dimensioned edge feed system with its ultra-minimal workpiece corner overhang – after all, it was invented by HOMAG. HOMAG offers you a wide edge feed spectrum, from single and dual-slot magazines right through to a changer with 6 slots.

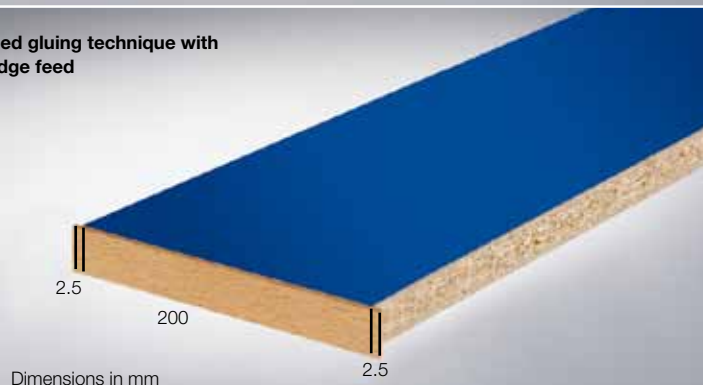


Previous gluing technique



Dimensions in mm

Optimized gluing technique with servo edge feed



Dimensions in mm

Multiple edging magazine

The spectrum ranges from single and dual-slot magazines right through to changers with 6 slots, allowing edges ranging from 0.3 to 3 mm to be processed with ease.

Powered coil trolley

Prevents edge breakage at high feed rates.

Edging coil length management (optional)

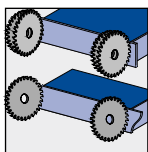
Reduced standstill periods resulting from missing edging material due to display and management of residual coil length.

Lower waste, fewer costs

The servo edge feed system feeds the edging material precisely dimensioned to the workpiece corner with only the barest minimum overhang. It permits leading and trailing edge precision of +/- 2–3 mm.

Snipping units – the perfect preparation for trimming operation

The snipping units prepare the workpieces perfectly for subsequent trimming operation. The face side can be snipped either straight or with chamfer.

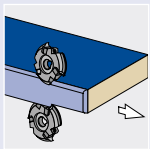


Snipping unit HL84

For snipping the edge overhang at the leading and trailing workpiece edge with stationary snipping stop to protect sensitive workpieces from damage. Drawing snipping cut for optimum snipping saw cutting quality.

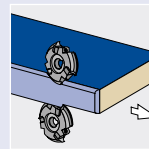
Flush trimming – the solid basis for edge processing

HOMAG trimming units give the workpiece edge its required shape. Even using our basic units, practically-oriented solutions are guaranteed.



Rough trimming unit BF20

For rough trimming the upper and lower edge overhang.



Trimming unit PF20

For trimming edge chamfers or radii.
Options: Stepless or pneumatic adjusting devices for the trimming motor. Trimming motor exchange using exchange units.



Automation to suit every need

For automatic changeover from flush trimming to trimming with edge overhang.

Solid strips



ABS, PVC, PP



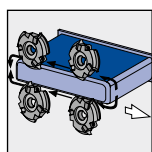
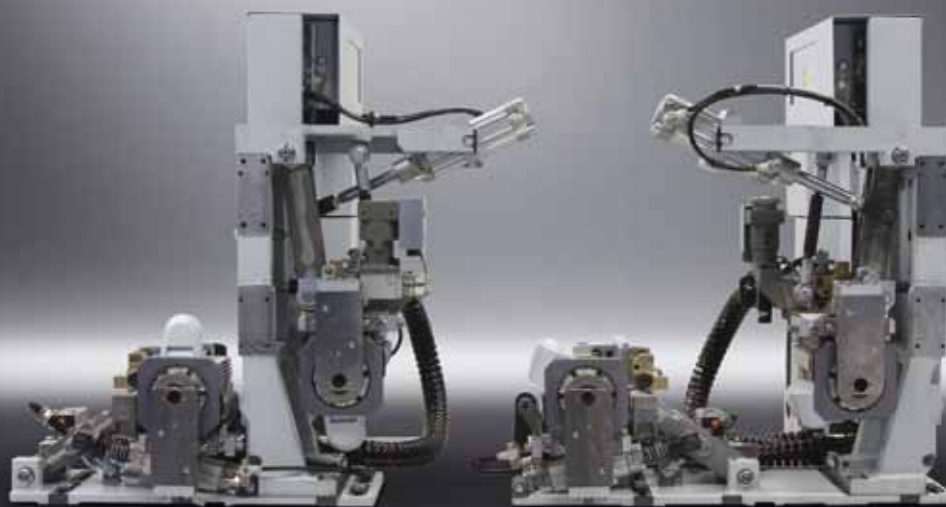
Automation to suit every need with multi-trimming unit MF21

For automatic changeover between different profiles, e.g. chamfer 20°, R2 and R3.



Four-motor profile trimming units take anything easily in their stride

The four-motor HOMAG profile trimming units ensure reliable corner rounding even when processing veneer. Are you looking for a unit for flush trimming the upper and lower workpiece surface? Then you have come to the right place.



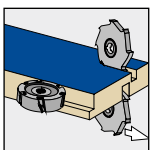
Profile trimming unit FF32

For rounding top and bottom edges on the leading and trailing workpiece edges. By dividing the cut over four motors, each corner can be processed in synchronous rotation. This lends corners a perfect trimmed finish for every edging type – even with veneer.



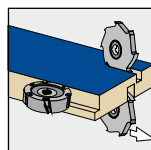
Trimming operations – a tidy performance

The output speaks for itself: HOMAG trimming units allow you to rebate, groove and profile – optionally also with tracing.



Standard trimming SF22

The standard trimming unit SF22 with two motors permits simultaneous grooving on the upper and lower surface of the workpiece.



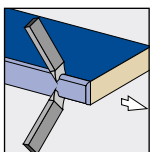
Universal trimming unit UF11

The UF11 unit comes with axes for programmed horizontal and vertical adjustment. It also traces the workpiece from above or from the side for precise edge profiling.

Automation to suit every need.

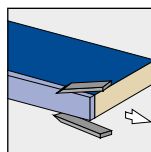
Finish – all's well that ends well

The quality of your products is increased by the use of perfectly coordinated finishing units. Leave the finish to HOMAG.



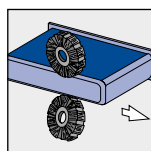
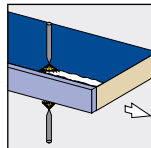
Profile scraper blade PN10

For smoothing trimmed edges to achieve an optimum appearance.



Finish processing unit FA11

Comprising a glue joint scraping unit, cleaning agent application and buffing for disposal of glue residues on PVC edges.



To ensure simple operation and control, we have invested the time that you don't have

HOMAG machines are designed to make simple operation and reliable control a matter of course. Manual intervention in the machine's operation is reduced to a minimum.

Control with powerControl PC22

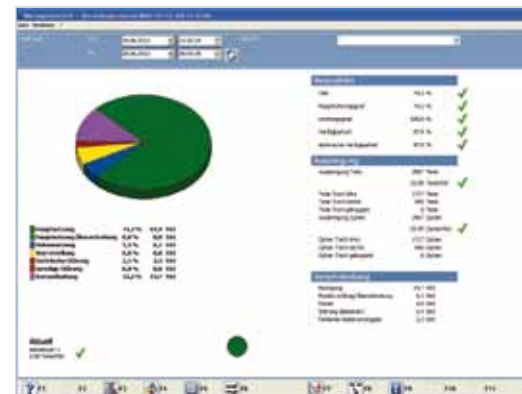
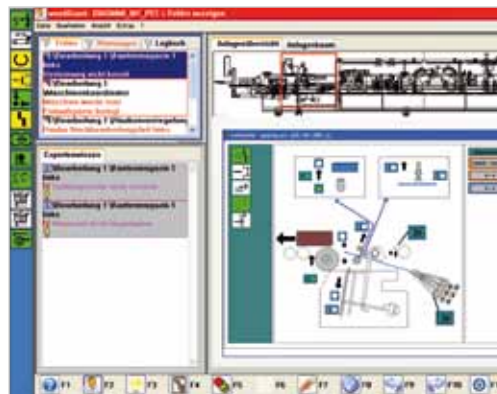
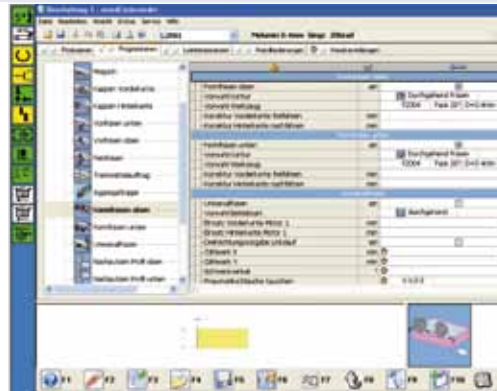
- User-friendly menu prompting using the Windows standard
- 17" display, optional 19" touchscreen for maximum operating convenience
- Easily understandable plain text messages in the local language
- USB port

Programming with woodCommander

The programming system for all HOMAG throughfeed machines. Extreme user convenience due to input screens with graphic support – for simple navigation and menu prompting.

Evaluation with MMR Basic

The MMR – Machine Monitoring and Reporting software evaluates the productivity of your machine. The number of produced workpieces, machine deployment time and running meters of edging are all logged. The utilization-dependent maintenance instructions ensure optimum execution of maintenance work.



Support via TeleServiceNet Soft

High-speed servicing and help through targeted fault analysis and support over the Internet.

Option: Diagnostic system woodScout

Alongside error messages in plain text, woodScout also provides a graphic representation of the error location. In addition to the system's expert knowledge database, users can store their own troubleshooting solutions.

Option: MMR Professional

The MMR Basic upgrade additionally evaluates shifts, analyzes error messages and permits a link to be created to the data evaluation center in the office. You are provided with productivity key indicators, support in problem analysis and an overview of optimization potential.

You invest, we reduce:

Life cycle cost management and ecoPlus

It is not the investment costs which decide the economic success of your production, but the capacity utilization and unit costs. This is why our primary objective is to combine top class production with higher productivity and consequently lower unit costs. With the new ecoPlus technology package from the HOMAG Group, you will also be helping to conserve precious energy, time, material and personnel resources.

For more information, go to:

www.homag.com/services



Unit cost reduction through

Optimum financing

- HOMAG Finance offers optimized financing concepts based on individual business administration requirements
- The outstanding value stability of HOMAG machines offers benefits in terms of leasing and subsequent replacement investment

High level of processing quality "without" finish processing

- Perfectly coordinated machine configuration

Practically oriented training

- Selective and targeted training will help you quickly achieve full productivity
- Your employees will be prepared for safe, efficient HOMAG machine operation

Reduced unit labor costs

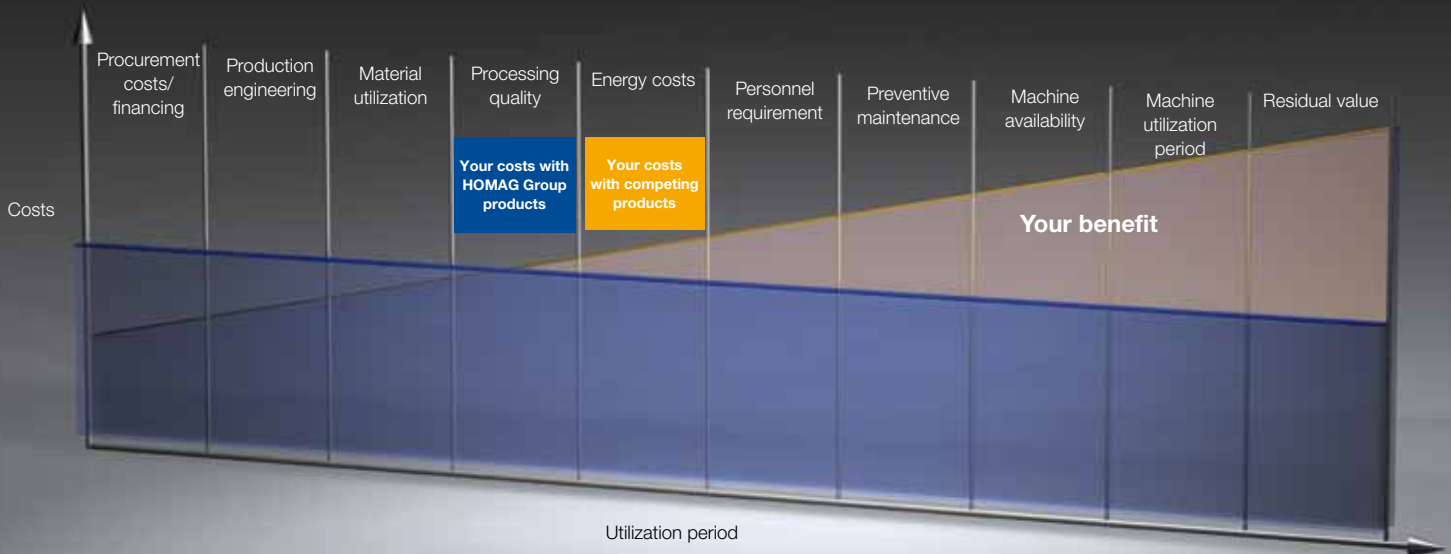
- Fast, simple operating capability of machines
- Simple resetting processes

High degree of machine availability

- Worldwide servicing minimizes downtime
- TeleServiceNet – our "eye" into the machine avoids costly on-site services
- woodScout diagnostic software – intelligent self-help for all machine operators

Fast achievement of productivity

- To get you quickly up to your targeted high shift output, our employees will visit your company to ease you into the start of production. This will take you faster to your targeted production output



Minimal energy costs with ecoPlus*

- Intelligent stand-by operation reduces energy costs during break periods by up to 90 %
- A valve control system switches the extraction on only for units which are actually operational. This reduces extraction costs by up to 20 %
- I-tools reduce the necessary extraction speed per individual I-tool. Current consumption per machine is reduced in this way by around 1 250 kWh. This does not take into account savings due to room air which requires no extraction (heating / air conditioning)
- The PC22 control switch cabinet is cooled using cool plate technology. This passive cooling system requires no energy. No filters require changing and maintenance costs are saved. The system also remains closed. No dust is able to penetrate
- All drive systems comply with energy efficiency category IE2
- Optional measurement and visualization of current consumption data from compressed air extraction and flow to optimization of overall energy consumption

Material savings with ecoPlus

- Servo edge feed systems cut material consumption by reducing the edging used per workpiece



Preventive maintenance

- MMR software provides the machine operator with an indication of required maintenance
- Regular inspections and preventive maintenance help avoid faults and prolong the service life
- The worldwide HOMAG servicing network with over 500 technicians provides support when you need it

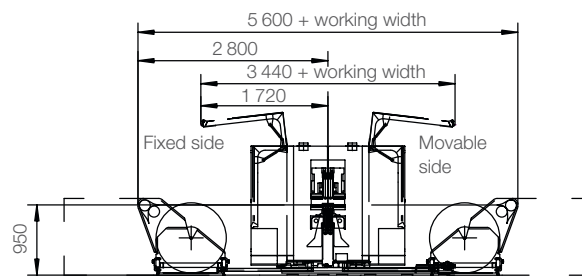
Machine utilization period

- Continuous expansion of functionality ensures compliance of the machines with the requirements of tomorrow
- The HOMAG conversion department offers solutions to address major conversion requirements, ensuring a high degree of investment security over years

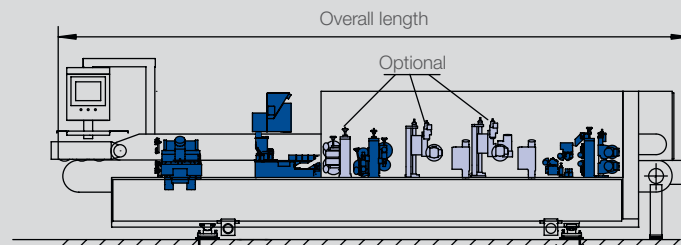
* Depending on equipment configuration, service period and workpiece spectrum.

Technical data K 320

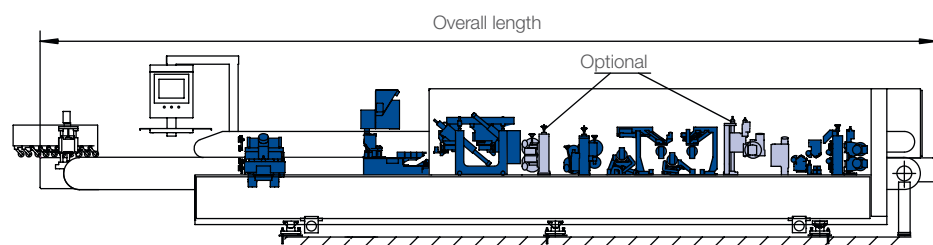
Width dimensions
KAL 325/326
KFL 325/326



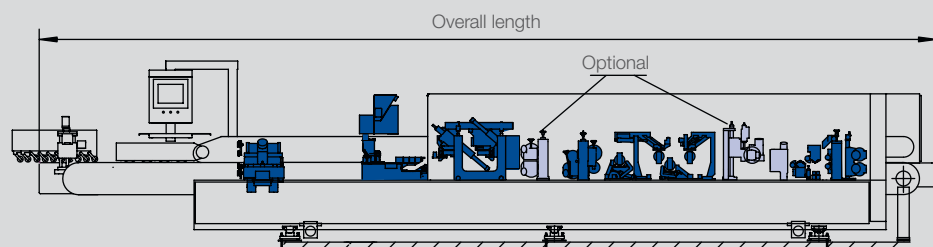
KAL 325/M1/C



KAL 326/M2/C



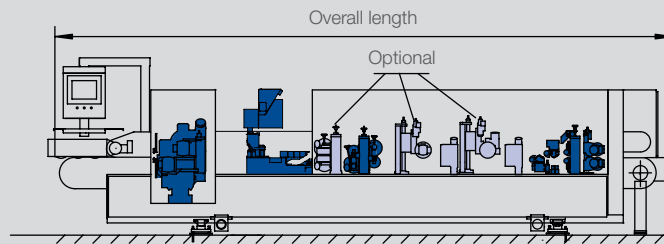
KAL 326/C



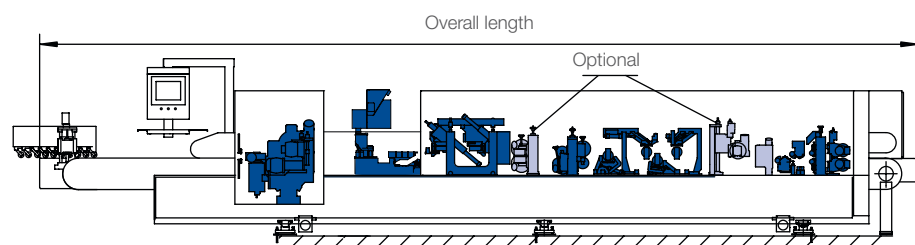


K 320 Type	Free space	Overall length			Length of transport chain
		Line execution machine I	Line execution machine II	Single machine	
KAL/KFL 325/M1/ C	-	7 650	-	-	15 000
KAL/KFL 326/M2/C	-	-	10 880	-	21 000
KAL/KFL 326/C	-	-	10 880	10 650	21 000

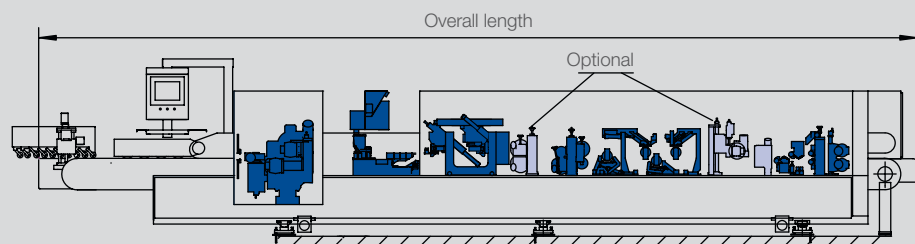
KFL 325/M1/C



KFL 326/M2/C



KFL 326/C



Content, technical data and photos are not binding in every detail. We reserve the right to make changes.



**Choose the Original
Choose Success!**

For the Success of Original Technology
A VDMA campaign



Member of the HOMAG Group



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