

# PREMIUM-EDGE BANDERS





## FORMAT-4 Mechanical engineering

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Top quality and long-lasting precision, made in Austria

## An edgebander from the Felder-Group will help ensure the success of your business!

Our experience – means that you can be confident in your decision! For more than 50 years, we have committed ourselves to developing, producing and selling first-rate woodworking machines. Today, Felder-Group machines are amongst the bestselling in the world.

Our concepts will help you to increase your profits!

Tailor-made machine specifications and high quality service are the Felder concepts that will help to improve the productivity and revenue of your business. Whether it be in the field of cabinet-making, crafts workshop or high-end industry, we are the right partner for you!

The quality and precision of our machines will guarantee long-term satisfaction!

Felder and Format-4 products are designed and manufactured exclusively in the Felder factory in Hall in Tirol in Austria. Highly qualified employees, modern manufacturing technologies and quality control processes according to Six-Sigma ensure the operational and long-term precision of every woodworking machine from the Felder-Group.

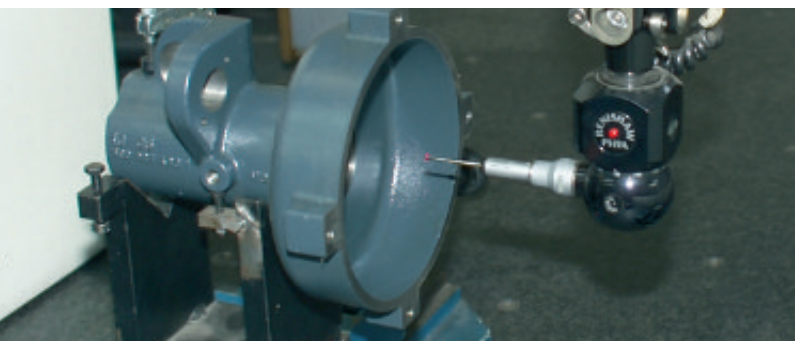
Technical advice, perfect products and service from one single provider!

The Felder-Group is your contact person, from the smallest panel saw through to an interconnected industrial machine network! Call us now, you won't be disappointed.



FORMAT-4® is a brand of Felder KG.  
We have been developing and producing first-rate woodworking machines and accessories since 1956.

# FORMAT®





**perfect 610    perfect 710**



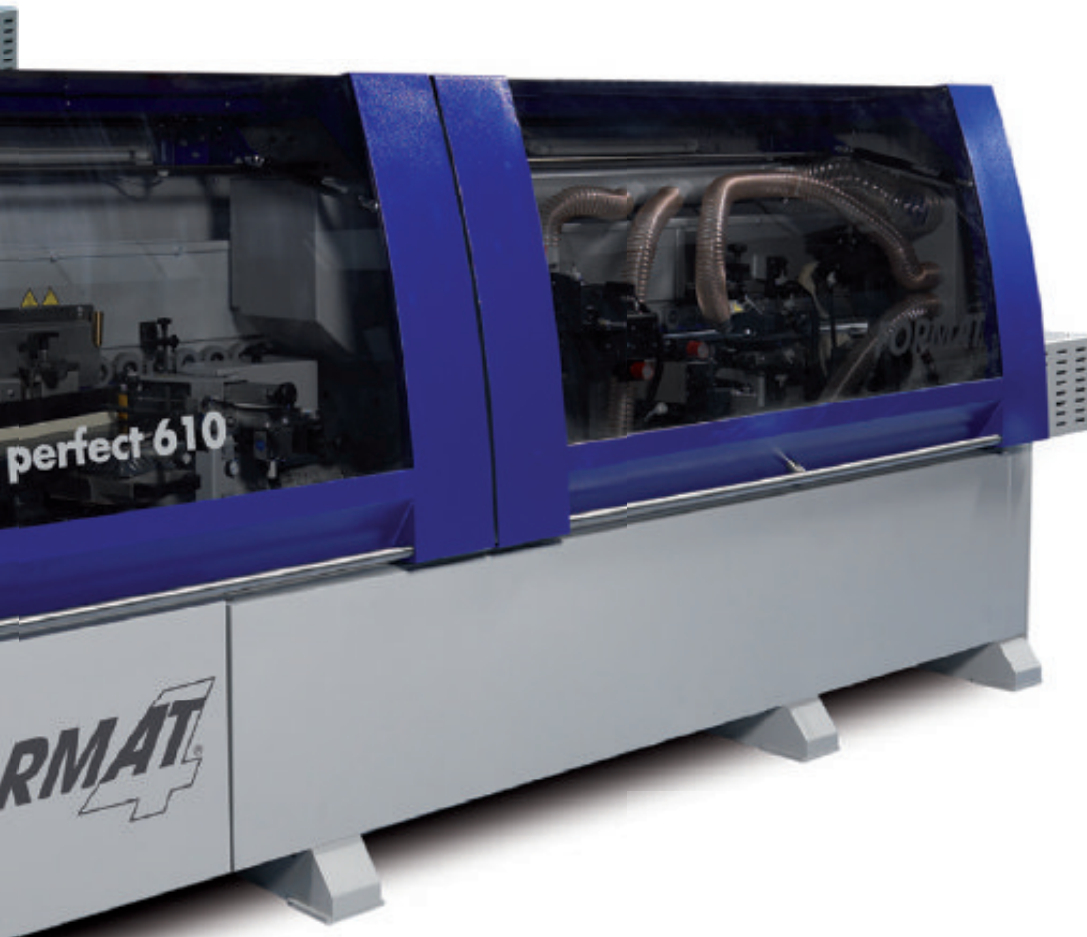
## perfect 610 and perfect 710 “PREMIUM” edgebanders

Productivity, versatility and precision in one!

Regardless of whether you are using coiled or strip materials, the new Format-4 “perfect” models deliver extremely impressive machining results.

The solid machine chassis and heavy duty units combined in an attractive design ensure the highest level of precision. An absolute highlight of every “perfect” model is the accuracy of the position settings of the individual units. The e-motion is equipped with individual machining programs that can be stored and reused, ensuring precise results especially when you require a quick changeover of material or edging.

A wide choice of optional units are available, to enable you to perfectly adapt your machine to your production requirements.



# 4 Machines – 2 Series – 2 Control Systems



## perfect 610 x-motion

- Control panel with 5.7" colour touch screen
- Manual unit adjustment
- Tape thickness 0.4–10 mm
- Workpiece height 8–60 mm
- 12 m/min feed speed
- 4 free spaces for additional machining units
- Part automation possible



## perfect 610 e-motion

- Control panel with 10.4" colour touch screen
- Electronically positionable units
- Tape thickness 0.4–10 mm
- Workpiece height 8–60 mm, position-guided
- 12 m/min feed speed
- 4 free spaces for additional machining units



## perfect 710 x-motion

- Up to 60 mm height with the corner rounding unit
- Control panel with 5.7" colour touch screen
- Manual unit adjustment
- Tape thickness 0.4–10.0 mm
- Workpiece height 8–60 mm
- 12 m/min feed speed
- 4 free spaces for additional machining units
- Part automation possible



## perfect 710 e-motion

- Max 60 mm corner rounding unit capacity
- Control panel with 10.4" colour touch screen
- Electronically positionable units
- Tape thickness 0.4–10.0 mm
- Workpiece height 8–60 mm, position-guided
- 12 m/min feed speed
- 4 free spaces for additional machining units

**MODEL**                      **CONTROL SYSTEM**

**ALL UNITS AT A GLANCE!**

perfect 610 x-motion




Control panel with 5.7" colour touch screen


perfect 610 e-motion



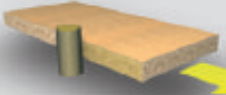

Control panel with 10.4" colour touch screen

STANDARD UNITS - perfect 610 x-motion and e-motion

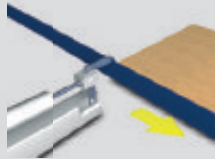
Edging feed for coiled and strip material



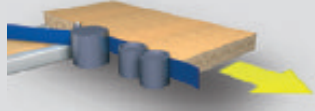
Glue applicator unit with quick change glue pot



Guillotine - Pneumatic trim up to 60 mm in thickness




Heavy pressure unit with 3 contact rollers



OPTIONS

Spraying equipment release agent for PUR glue





Premilling unit incl. diamond cutters



Infrared heater lamp





perfect 710 x-motion

Control panel with 5.7" colour touch screen


perfect 710 e-motion

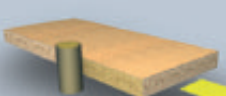
Control panel with 10.4" colour touch screen

STANDARD UNITS - perfect 710 x-motion and e-motion

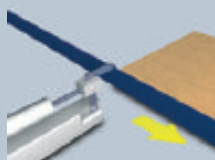
Edging feed for coiled and strip material




Glue applicator unit with quick change glue pot



Guillotine - Pneumatic trim up to 60 mm in thickness




Heavy pressure unit with 3 contact rollers




OPTIONS


Spraying equipment release agent for PUR glue



Premilling unit incl. diamond cutters

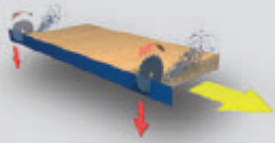


Infrared heater lamp

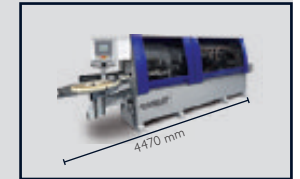




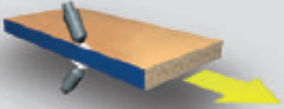
End trimming saw unit with 2 independent units



Multifunctional trimming unit



Spraying equipment for antistatic coolant agent and lubricant for sensitive edging materials



Radius scraping unit



Flush scraping unit



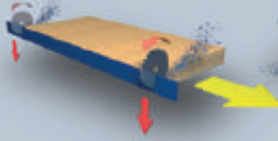
Spraying equipment for cleaning and polishing agents



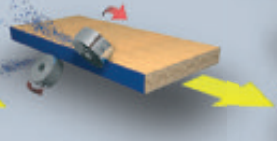
Buffing unit



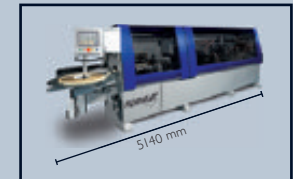
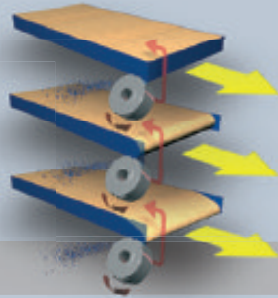
End trimming saw unit with 2 independent units



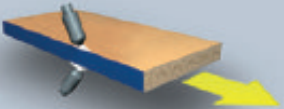
Multifunctional trimming unit



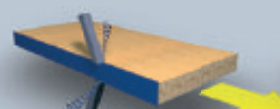
Corner rounding unit



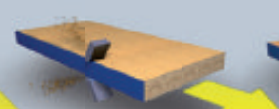
Spraying equipment for antistatic coolant agent and lubricant for sensitive edging materials



Radius scraping unit



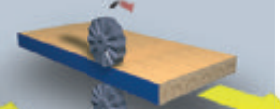
Flush scraping unit



Spraying equipment for cleaning and polishing agents



Buffing unit



# x-motion control system

perfect 610/710 x-motion:

Control panel with 5.7" colour touch screen



Functions:

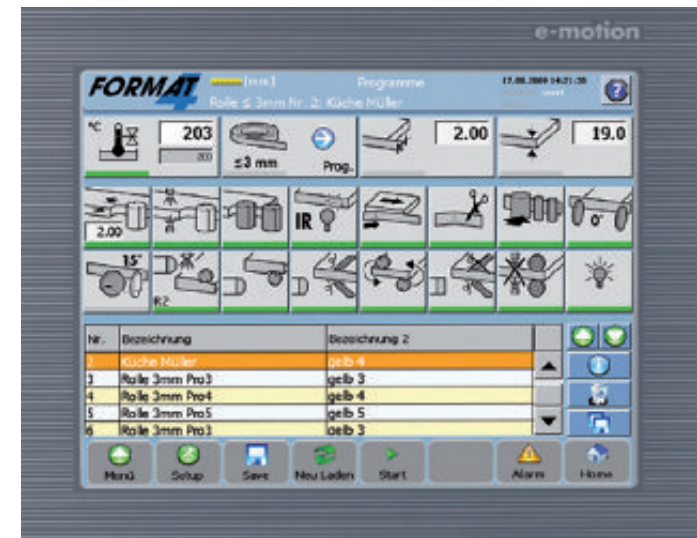
- 4 operational programs for a quick selection of the materials
- Easy, self-explanatory representation of the units and their functions
- Glue heating parameters settings (temperature, idle and operating)
- Unit selection
- Selection of the contact pressure of the pressure rollers
- Fine adjustment of the distance parameters
- Setting adjustment of the trimming length of the protruding edges at the front and the back of the workpiece
- Plain text error messages
- Maintenance schedule
- Odometer for total meters of material used and much more...

# e-motion control system

perfect 610/710

perfect 610/710 e-motion:

Control panel with 10.4" colour touch screen



Functions:

- User-defined program storage
- Control of the electronically positionable units
- Fine adjustment of the units to 1/100 mm from the control panel
- Easy, self-explanatory representation of the units and their functions
- Glue heating parameters settings (temperature, idle and operating)
- Unit selection
- Selection of the contact pressure of the pressure rollers
- Fine adjustment of the distance parameters
- Setting adjustment of the trimming length of the protruding edges at the front and the back of the workpiece
- Plain text error messages
- Maintenance schedule
- Odometer for total meters of material used and much more...

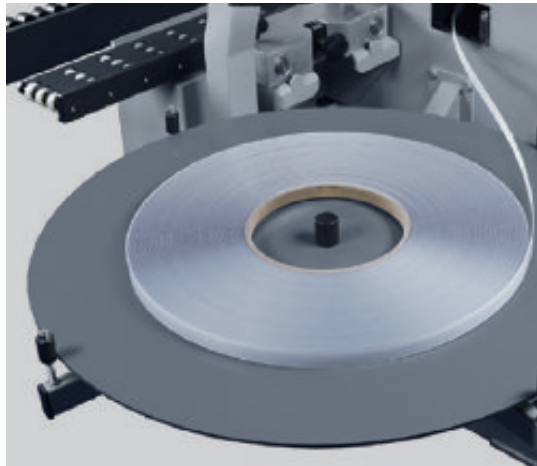
# Highlights

Edging feed and guillotine scissors for coiled and strip material up to 60 mm thick



Depending on the requirement, coiled material 0.4 to 3.0 mm thick and strip material up to 10 mm thick can be used for workpieces up to 60 mm in thickness. An infrared sensor recognises whether edging material is available to be machined. The guillotine scissors, to cut the coil material, are set to the maximum of 3x 64 mm.

The magazine, which automatically feeds the strip material via the pin grip roller has a holding capacity of 120 mm. The height settings on the pressure bar and the contact pressure manometer placed next to the edge infeed ensure quick changeover times.

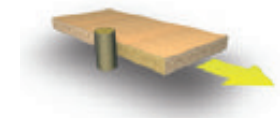


Glue application unit  
Short heating time, quick change system



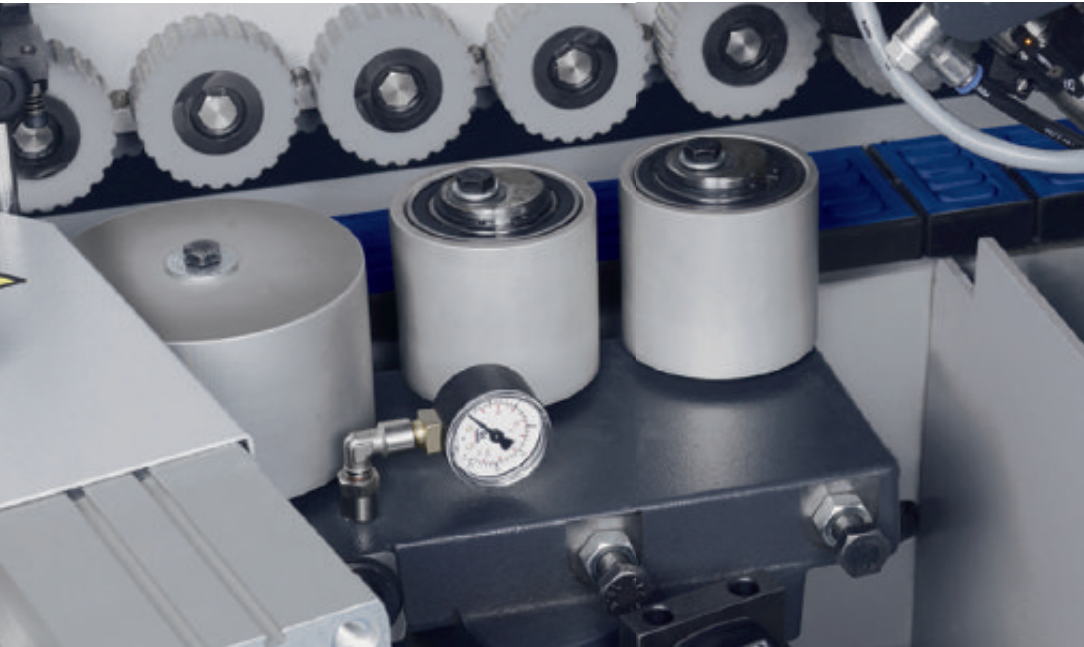
The "perfect" edgebander requires only 8 minutes to reach operating temperature! The Teflon coated glue pot and its tool-free quick change system is suitable for EVA (ethylene vinyl acetate copolymers) and PUR (Polyurethane resin) hot melt adhesive granulates.

The fine adjustable glue cylinder ensures that the correct amount of the glue required is applied and can adapt perfectly to different edging materials.

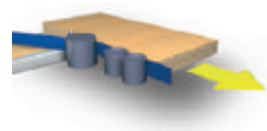


### Contact zone

Almost invisible glued joints

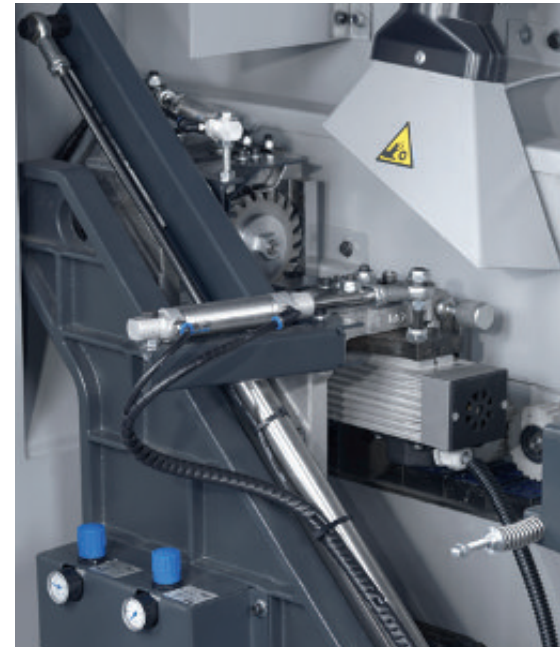


The first pressure roller, which is solid and adjustable, presses the edging material to the workpiece. The adjustable control prevents the glue from smearing and the edging tape from being "squashed". The two conical moulding pressure rollers complete the glue bond at the top and bottom. Two contact pressure settings can be selected from the control panel: less pressure for when strip material is processed and higher pressure for processing coiled material. All e-motion models have an electronically positionable pressure roller unit as Standard.

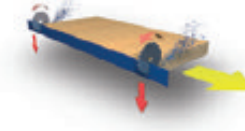


### End trimming unit

Precise cuts for each application



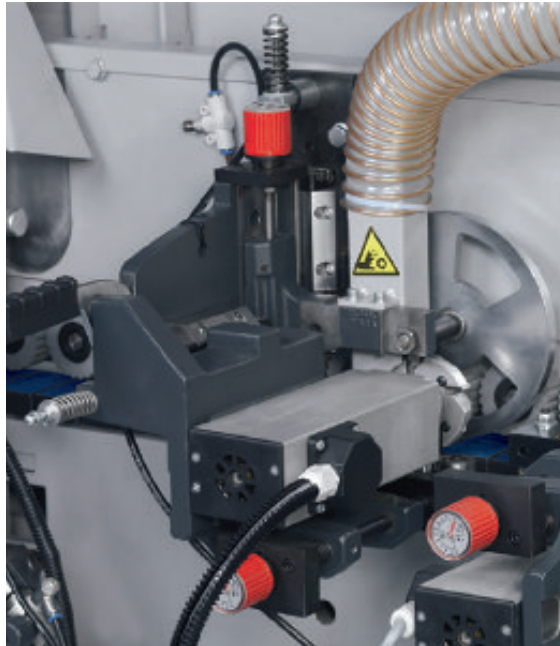
The end cutting unit consists of 2 independent saw units, each with high frequency motors running at 12,000 rpm. Linear guidance ensures the highest level of precision. The units can be tilted between 0°–15° - either manually or pneumatically, controlled via the control panel depending on the build options chosen. You have the option of cutting the front edge only at 15°, the rear edge only or both edges.



# Highlights

## Multifunctional trimming unit

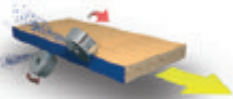
Innovative precision with quick setup



The multi-functional flush, radius and bevel trimming of thin edges unit consists of two independent trimming units with high frequency motors (12.000 rpm). Linear guides guarantee the highest possible precision with little maintenance required. The easy adjustment and setup of the unit, means that it is extremely quick to change between different edge thicknesses and profiles. Depending on the build option chosen, the multi-function unit can either be adjusted manually or pneumatically, controlled via the control panel.

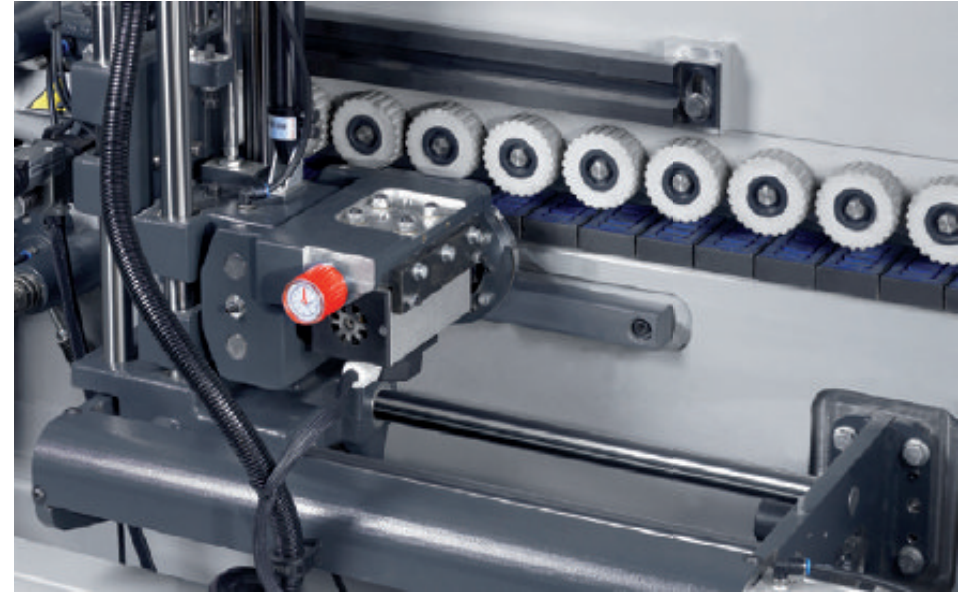


Precise dial gauges on the x-motion models ensure that all the units are set up quickly and precisely. On all of the e-motion models, the setting of the electronically positionable units is carried out on the colour touch screen.

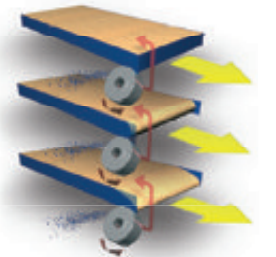


## Corner rounding unit

An indispensable level of productivity



No more time consuming post processing of the workpiece! The Format-4 corner rounding unit "finishes" workpiece corners (incl. soft forming and post forming materials) for edging materials 0.4 to 3.0 mm thick and up to 60 mm in height, without reducing the feed rate. The solid cast iron construction, linear guides and HW cutters ensure long-term precision. The corner rounding unit is controlled from the control panel.



# Options for available slots

perfect 610/710

## Premilling unit

Ensuring a perfect finish



The two diamond tipped spindle heads rotate in opposing directions, ensuring a perfectly straight workpiece edge, to which before the edge material can be glued. The premilling unit guarantees that chipped or torn edges are a thing of the past, each and every time.

After entering the exact dimensions, the premilling unit executes a perfect edge cut to your panels.

Special V cut, manual setting of the depth of cut 0–3 mm on the x-motion models. The depth of cut can be electronically positioned on all of the e-motion models as standard.



## Radius scraping unit

The “perfect” finish - a quality option

The radius surface receives a light scraping removing any remnants from the trimming process, ensuring a smooth finish. The fine adjustment is manual. The radius scraper unit can be disengaged either manually or pneumatically from the control panel, depending on the model.

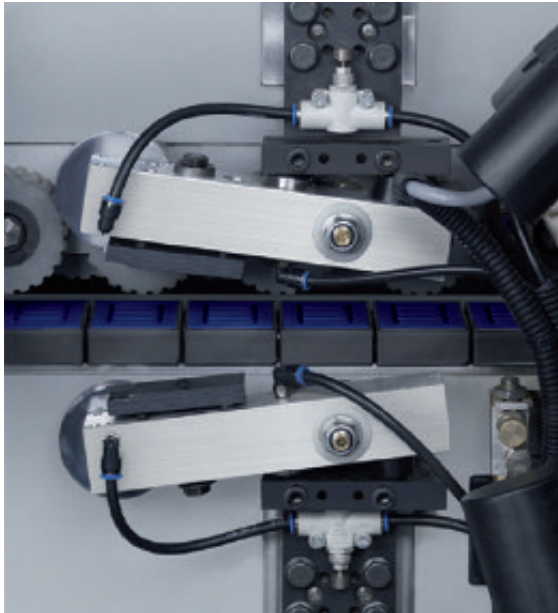
On all of the e-motion models, the fine adjustment is carried out on the colour touch screen.



# Optional additional finishing units

## Electronically controlled glue scraping unit

The “perfect” finish - a quality option



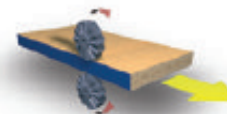
For a perfect surface finish. The light scraping function of the surface scraper knives removes all glue residues from the glue bond on the workpiece surface. One more step towards the perfect and completely finished workpiece.

## Buffing unit

The “perfect” finish - a quality option



Super finish for ABS and PVC edging material. The machine can, on request, be equipped with spraying equipment to apply polish onto the workpiece.



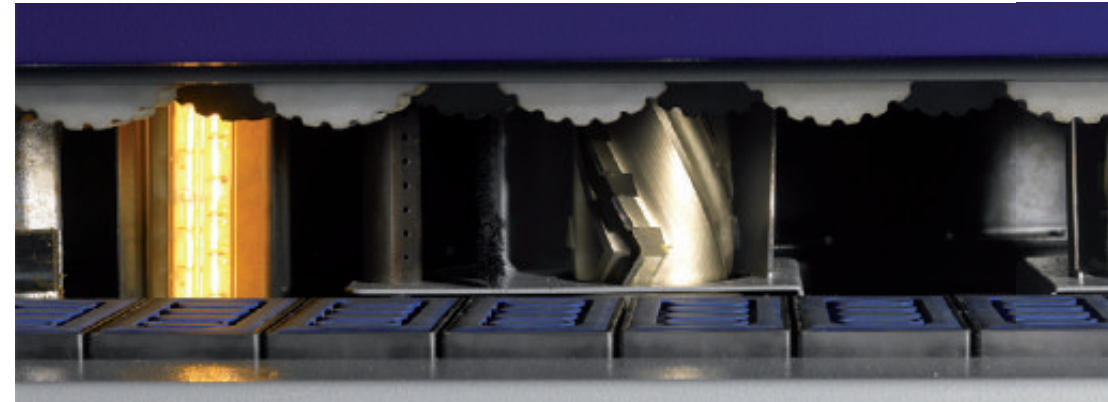


Spraying equipment and spray for the perfect “finish”, leaving a workpiece requiring no further processing



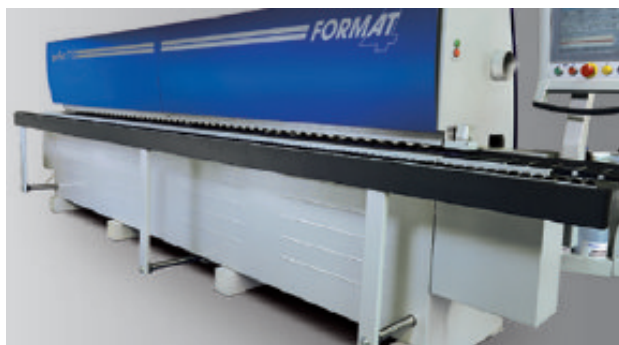
Low consumption guaranteed due to application controlled spray nozzles to apply separation solution for PUR glue, antistatic solution and lubricant for sensitive edging materials and cleaning agents and polish for clean workpieces and a perfect finish.

Infrared lamp so the edging adheres better onto cold workpieces



The operation controlled, high quality quartz infrared lamp warms the edge surface in front of the glue unit. This guarantees that the edging adheres to cold workpieces.

Extendable workpiece support for easy and comfortable machining



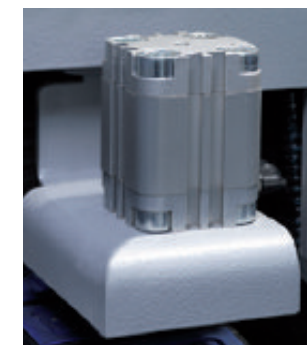
Stable workpiece support, extendable up to 800 mm without floor supports; an important factor especially if your workshop floor is not totally flat.

For workpieces with predrilled hinge bores (Nesting)



Perfect solution: Processing of workpieces with predrilled hinge bores (Nesting).

Workpiece feed protection



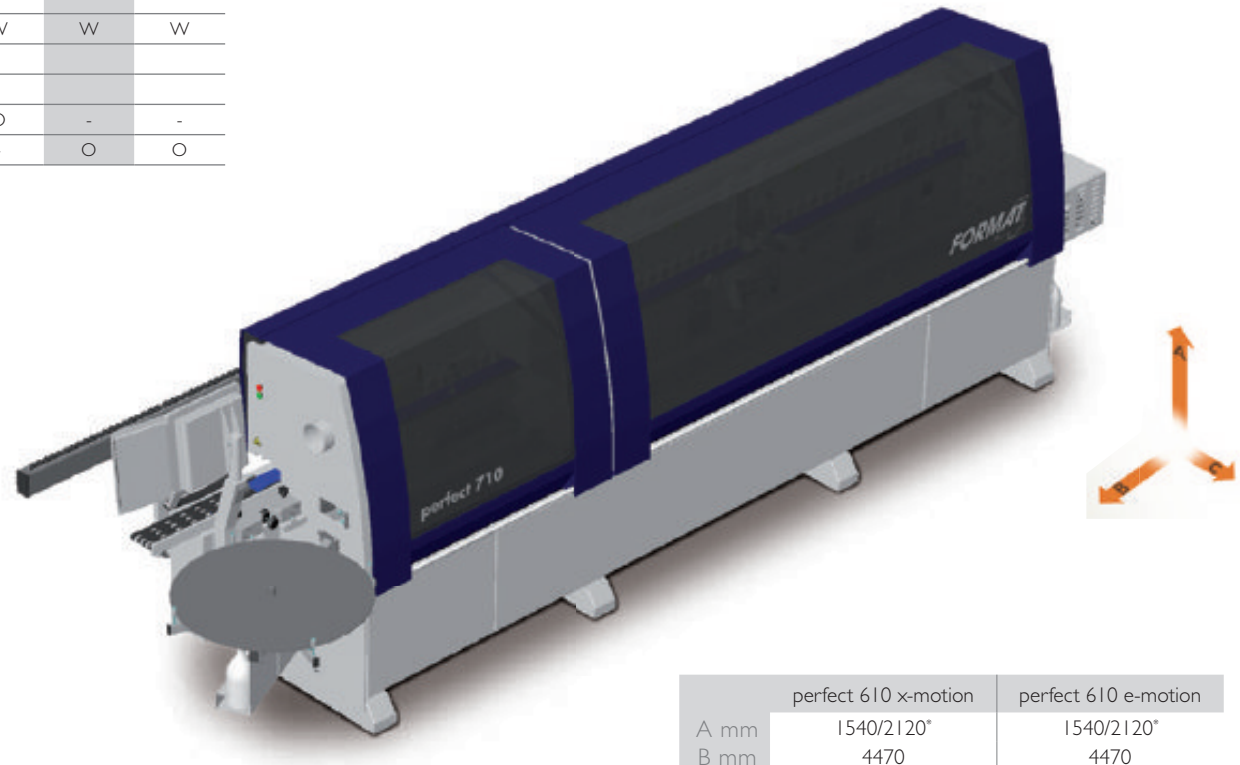
A pneumatic cylinder on the feed side releases workpieces into the machine one after the other. The user does not need to pay attention to light signals. This workpiece feeding system ensures maximum production reliability.

## Technical data – Equipment options to suit your personal needs:

		perfect 610 x-motion	perfect 610 e-motion	perfect 710 x-motion	perfect 710 e-motion
<b>POS</b>	<b>Electrics</b>				
001	3x 400 V motor voltage, 50 Hz motor frequency	S	S	S	S
002	3x 230 V motor voltage, 60 Hz motor frequency	O	O	O	O
	<b>Working dimensions</b>				
	Min. workpiece width (mm)	70	70	70	70
	Min. workpiece length (mm)	140	140	140	140
	Min. workpiece height (mm)	8	8	8	8
	Max. workpiece height (mm)	60	60	60	60
	Processing of 0.4–3.0 mm coiled material	S	S	S	S
	Processing of 0.4–10 mm strip material	S	S	S	S
	<b>Standard equipment</b>				
	Control panel with 5.7" colour touch screen	S	-	S	-
	Control panel with 10.4" colour touch screen	-	S	-	S
	Solid steel machine chassis	S	S	S	S
	Fixed workpiece support along the full length of the machine	S	S	S	S
	Manual height adjustment of the workpiece feed pressure rollers with 2 offset lines of rollers for equal pressure distribution on the workpiece	S	-	S	-
	Motor driven adjustment of the workpiece feed pressure rollers with 2 offset lines of rollers for equal pressure distribution on the workpiece	-	S	-	S
	Chain feeder with a speed of 12 m/min and rubber grip pads, for maximum grip on the workpiece	S	S	S	S
	770 mm diameter workpiece support roller, running on ball bearings	S	S	S	S
	Feeding guide with rollers for processing fragile material	S	S	S	S
	Edge feed for coiled and strip material 0.4–10 mm thick, with edge thickness recognition via an infra-red sensor	S	S	S	S
	Guillotine trimming unit for the precutting of PVC/ABS edgeband material 0.4–3.0 mm thick	S	S	S	S
	Teflon coated 1.5 kg capacity glue pot with quick change system, glue application via an adjustable glue roller	S	S	S	S
	Manually controlled pressure unit with 1 large motor driven roller and 2 conical rollers operating pneumatically	S	-	S	-
	Motor driven positioning of the pressure unit with 1 large motor driven roller and 2 conical rollers operating pneumatically	-	S	-	S
	End trimming unit with 2 independant motors, each with 0.50 kW and 12,000 rpm, both manually tiltable between 0°–15°	S	-	S	-

		perfect 610 x-motion	perfect 610 e-motion	perfect 710 x-motion	perfect 710 e-motion
070	End trimming unit with 2 independant motors, each with 0.50 kW and 12,000 rpm, both pneumatically tiltable between 0°–15°	O	S	O	S
	Multi functional trimming unit for radius and flush trimming and bevel trimming of thin edges with 2 independant motors, each with 0.75 kW and 12,000 rpm, manual edge thickness adjustment and manual disengage function via an eccentric handle	S	-	S	-
	Multi functional trimming unit for radius and flush trimming and bevel trimming of thin edges with 2 independant motors, each with 0.75 kW and 12,000 rpm, motor driven positioning of the edge thickness adjustment and pneumatic disengage function via the control panel	-	S	-	S
	Corner rounding unit for soft- and post forming pieces for processing edges of between 0.4 and 3.0 mm in thickness and 10–60 mm in height	-	-	S	S
	4 free spaces for additional processing units	S	S	S	S
	<b>Units</b>				
010	Radius scraping unit for R= 2 mm, mechanically controlled	O	-	O	-
011	Motor driven positioning of the radius scraping unit incl. pneumatic disengage mechanism	-	O	-	O
012	Pneumatic disengaging mechanism of the radius scraping unit	O	-	O	-
020	Glue scraping unit, pneumatically controlled	O	O	O	O
030	Buffing unit with 2 motors	O	O	O	O
031	Buffing unit with 2 motors incl. mechanical disengage mechanism	O	O	O	O
032	Spraying unit for cleaning fluids situated before the polishing units	O	O	O	O
040	Premilling unit with two 1.1 kW independant motors running at 12,000 rpm and diamond tipped cutters, depth of cut manually adjustable between 0–3 mm, 2 diamond tipped cutters included (Ø= 60 mm, H= 64 mm, Z 2+2)	O	-	O	-
041	Premilling unit with two 1.1 kW independant motors running at 12,000 rpm and diamond tipped cutters, motor driven positioning of the depth of cut between 0–3 mm, 2 diamond tipped cutters included (Ø= 60 mm, H= 64 mm, Z 2+2)	-	O	-	O
042	Spraying unit for separation solution positioned at the front of the machine (PUR-Glue)	O	O	O	O
043	Infrared heat lamp for pre-heating board edges	O	O	O	O
050	Pneumatic disengage mechanism of the multi-functional trimming unit	O	-	O	-
	<b>Edging of hinge bores (Nesting)</b>				
051	Multi-functional trimming unit with vertical reference rollers for the processing of workpieces with hinge bores	O	O	O	O

		perfect 610 x-motion	perfect 610 e-motion	perfect 710 x-motion	perfect 710 e-motion
<b>Tailor made equipment options</b>					
062	Pull-out workpiece support – to assist in the processing of larger workpieces	○	○	-	-
063	Pull-out workpiece support – to assist in the processing of larger workpieces	-	-	○	○
064	Pneumatic-mechanical infeed gate, to prevent the premature feeding of the workpiece	○	○	○	○
W	Tool preparation R= 3 mm instead of R= 2 mm	W	W	W	W
<b>Transport, installation and training</b>					
229	Container packing	○	○	-	-
230	Container packing	-	-	○	○



	perfect 610 x-motion	perfect 610 e-motion
A mm	1540/2120*	1540/2120*
B mm	4470	4470
C mm	1070-1330	1070-1330
	perfect 710 x-motion	perfect 710 e-motion
A mm	1540/2120*	1540/2120*
B mm	5140	5140
C mm	970/1070-1330	970/1070-1330

\* With the access cover open

# Machines + tools for woodworking

## Panel Saws and Circular saw



## CNC Machining Centres



## Edgebanders



## Beam saw



kappa automatic

## Vertical Panel Saw

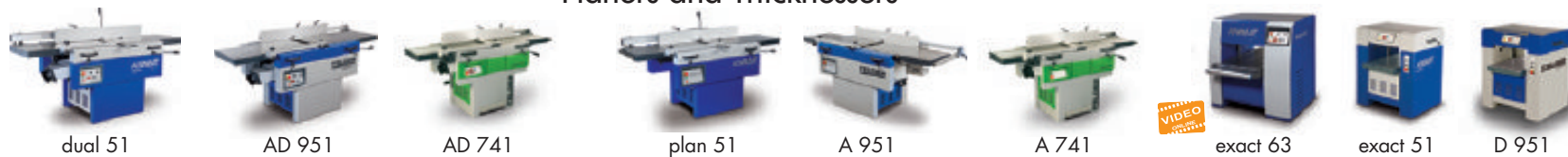


kappa V60

## Spindle Moulders



## Planers and Thicknessers





### Combination Machines



CF 741 S Pro

CF 741 S

CF 741 Pro

CF 741

CF 531 Pro

CF 531

### Saw Spindle Moulders



KF 700 S Pro

KF 700 S

KF 700 Pro

KF 700

KF 500 Pro

KF 500

### Dust Extractors



RL 300

RL 250

RL 200

RL 160

RL 125

AF 22 Stationary

AF 22 Mobile

AF 22 Stand

AF 14

AF 10

S1

RL 200 BP

### Wood Chip Briquetting Press

### Wide Belt Sanders



finish 1302

finish 1102

FW 1102

FW 1100

FW 952

FW 950

### Stroke Sanders



FS 722

### Edge Sanders



FS 900 KF

FS 900 K

### Bandsaws



FB 840

FB 740

FB 640

FB 540

FB 600

FB 500

FB 400

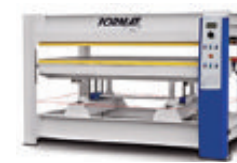
### Mortising Machines



FD 921

FD 250

### Heated Veneer Press



HVP

### Vacuum press



MVP

