

# Tenoner & Mortiser



For high production tenoning and mortising, you can get the right machine at the right price. HOLYTEK's mortiser and tenoner series feature speed and ruggedness of design, ensuring years of efficient operation and accurate jointing. Easy to operate and maintain. HOLYTEK's uncompromising commitment to quality is a tradition. This guarantees performance you can count on.

**HOLYTEK**

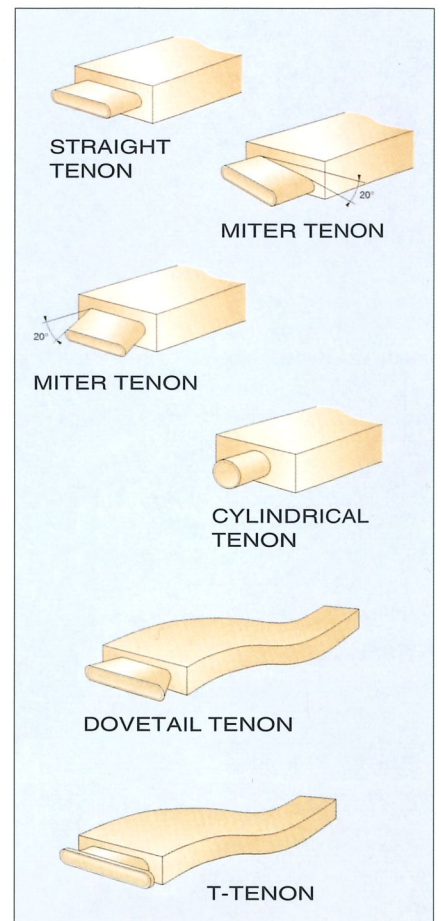
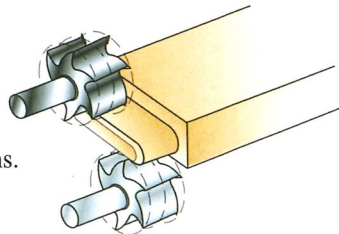
# RECTANGULAR TENONER YRT-115

*Quality Machine for Perfect Jointing Performance*

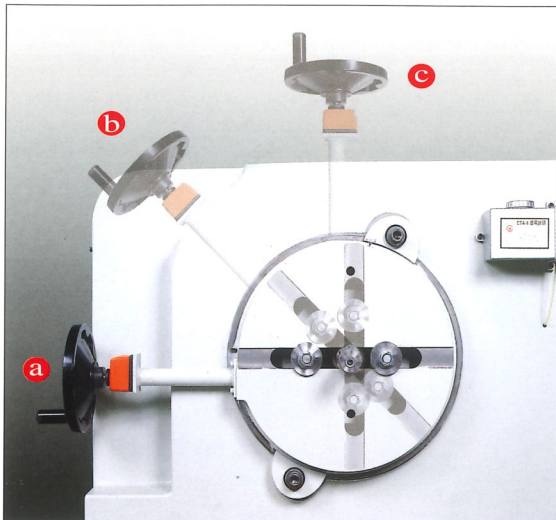


## **Outstanding Features:**

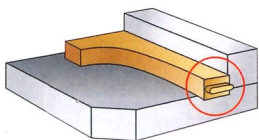
- Built with two tables for higher efficiency operations.
- Pneumatically operated table longitudinal traverse.
- Adjustable tenoning width.
- The tenon depth can be conveniently adjusted without moving the door.
- Table tilts 20°.
- Movable table saves time, and speed can be variably adjusted.
- Convenient setup of tenon directions at horizontal, vertical and 45°.
- Miter gauge provided on table allows for cutting bevel tenons.
- Oil bushings on the table support and the disk.
- Centralized control panel provides convenient operations.
- Designed for producing various types of tenon.
- Variable cutter feed speeds to suit all types of wood material.



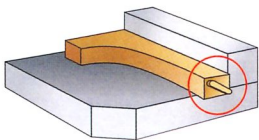
## CONVENIENT SETUP OF TENON DIRECTION



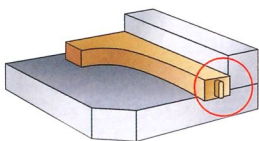
Three tenon directions at horizontal, vertical and 45° can be quickly changed by turning the positioning disk. A mechanical meter is provided for high accuracy adjustment of tenon sizes.



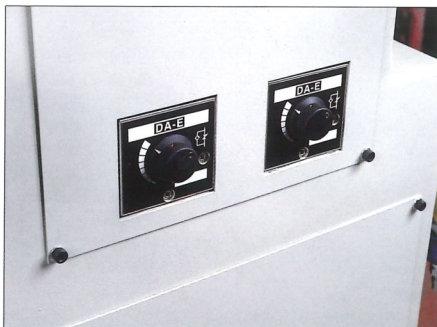
**a** Horizontal



**b** 45°

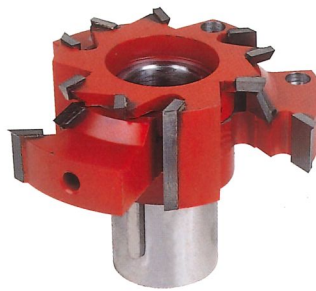


**c** Vertical



### VARIABLE CUTTER FEED SPEED

The machine employs two speed regulator knobs to adjust the table feed forward and backward speeds. Variable feed speeds make the machine ideal for cutting hard and soft wood.



### SOLID TYPE CUTTER (STANDARD)

The machine is furnished standard with a solid Tungsten carbide tipped (TCT) cutter for cutting tenons.



### THROW-AWAY TYPE CUTTER (OPTIONAL)

When requested, a throw-away type cutter is available. It is fitted with four-edge Tungsten carbide knife inserts to considerably reduce cutter sharpening time.



### OILLESS BUSHINGS

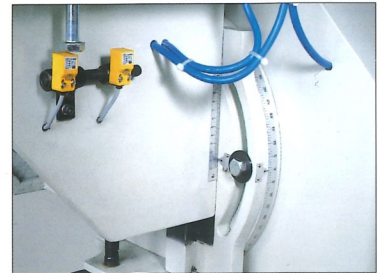
Eliminates the use of lubricator, the table support and the disk are equipped with oil-less bushings. Manufactured from high tensile copper alloy for long service life, these bushings also feature impact resistance and maximum wear resistance.

## SPECIFICATIONS:

MODEL	YRT-115
Spindle speed	6,000 R.P.M.
Maximum tenon width	115 + 2R mm
<b>Minimum tenon depth</b>	
with standard tool	10 ~ 45 mm
with special tools	6 ~ 90 mm
<b>Table tilt</b>	
upward	0 ~ 15°
downward	0 ~ 30°
side	0 ~ 20°
Spindle motor	5 HP
Cutter cycle motor	1 HP
Net weight	1100 kgs
Gross weight	1200 kgs
Machine size	1,760 x 1,150 x 1,320 mm
Packing size	1,840 x 1,210 x 1,530 mm

# OSCILLATION MORTISER YOM-120

*Quality Machine for Perfect Jointing Performance*



#### TILTING TABLE

The table tilts 20° right and left for bevel mortising.



#### STEEL ROD SLIDEWAY

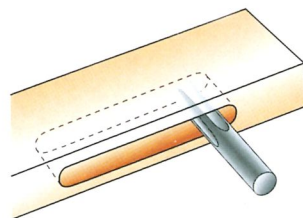
The cutterhead travels on steel rods, ensuring maximum wear resistance and smoothness.

#### ACCURATE MORTISE LENGTH ADJUSTMENT

Mortise length adjustment mechanism is equipped with a mechanical meter for high accuracy.

#### Outstanding Features:

- Two tables built in the front and back of the machine provide highly efficient mortising operations.
- Air clamps provide convenient workpiece handling.
- Mortising width is adjustable.
- Mortising depth is adjustable.
- Table can be tilted 20°.
- Table surface is precision ground.
- Centralized control panel provides convenient operations.
- Mortising depth is accurately controlled.
- Table height is adjustable.
- Mortising bit oscillation speed is variable.



#### SPECIFICATIONS:

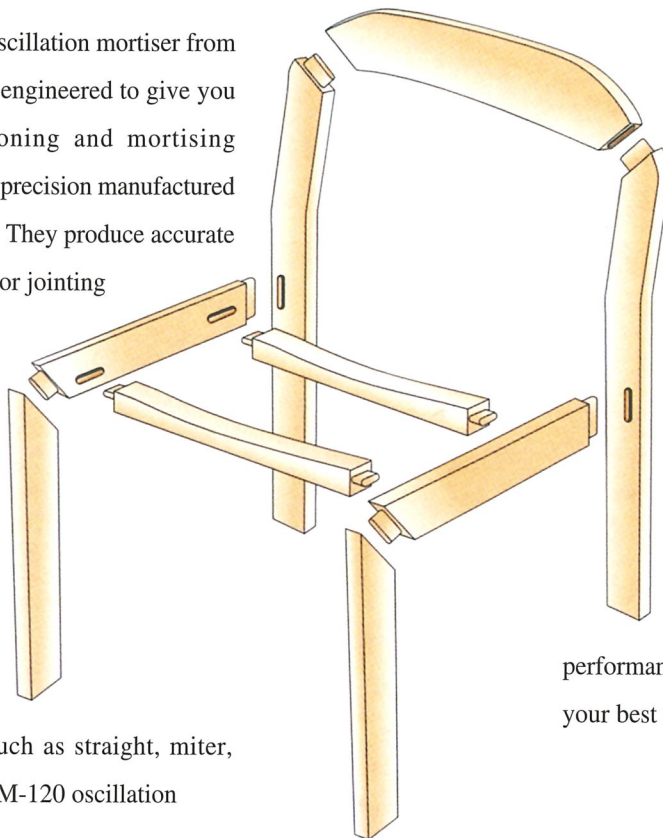
MODEL	YOM-120
Maximum width of mortise	120 mm
Maximum depth of mortise	50 mm
Oscillation rate	6.6~400 stroke/min
Table vertical adjustment	3"
Cutter speed	9,500 R.P.M.
Maximum clamp thickness	4"
Spindle motor	2 HP
Oscillation motor	1/2 HP
Air pressure	5~6 kg/cm <sup>2</sup>
Machine size	1,300 x 1,200 x 1,200 mm
Packing size	1,430 x 1,340 x 1,410 mm
Net weight	700 kgs
Gross weight	800 kgs

## ***HOLYTEK Machines are superior in operation***

The rectangular tenoner and oscillation mortiser from HOLYTEK are designed and engineered to give you precision accuracy in tenoning and mortising performance. Each machine is precision manufactured using the finest craftsmanship. They produce accurate tenons and mortises for superior jointing effects. Ruggedly constructed throughout for maximum stability while in high speed operations.

The HOLYTEK YRT-115 rectangular tenoner is designed with two work tables for efficient operations.

It produces various tenons such as straight, miter, dovetail and T shape. The YOM-120 oscillation

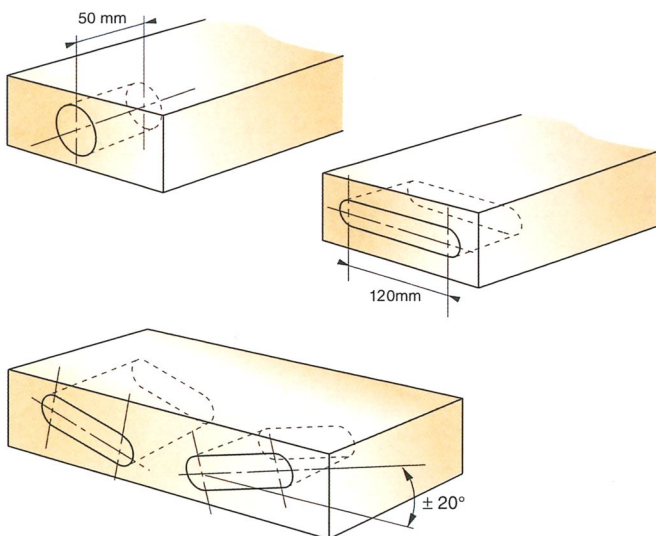


mortiser is built with two work tables at front and back side of the machine, giving high production capacity.

All HOLYTEK machines are subject to rigorous quality inspection before shipment to ensure years of dependable operation performance. So, for superior tenoning and mortising operational

performance, HOLYTEK machines are your best choice.

## ***THE YOM-120 IS CAPABLE OF PRODUCING VARIOUS OSCILLATION MORTISES***



*HOLYTEK's outstanding engineering capability combined with advanced service concepts gives you the competitive edge in tenon and mortise machining.*

***Accurate Machinery,***

***Quality Construction***

***High Efficiency***

***All these describe the dependable machines from HOLYTEK***

### Outstanding Features:

- This highly productive mortiser is designed for producing various mortises simultaneously.
- Flexible head combinations to meet specific job requirements.
- Double tables on front and back sides, permitting both sides operation for increased efficiency.
- Cutter speeds are frequency inverter controlled, providing variable speed change.
- All operation motions are conveniently controlled by pressing a foot switch.
- Each carriage is adjusted independently.
- Two speed cutter oscillation permits high/low speed change.
- Carriages slide on large steel rods. High speed cutter oscillation features maximum stability.
- Mortise width and depth are adjustable.
- The machine is designed for both mortising and drilling functions.
- Carriages are well constructed for adjusting mortise width independently.

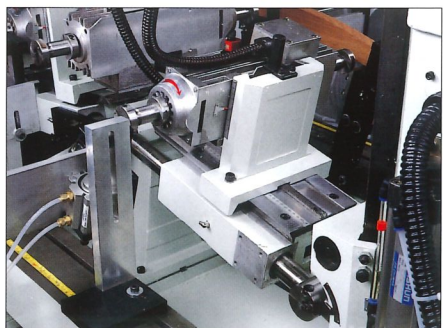


#### CONTROL PANEL

All machine motions are grouped in one control panel for operational convenience, including cutter oscillation, motor ON/OFF control, clamping cylinder control, etc.

#### VARIABLE CUTTER SPEED

The cutter running is controlled by a high performance frequency inverter, permitting for variable speed adjustment. Wide speed range is from 6,000 to 12,000 RPM.



#### MORTISING HEAD

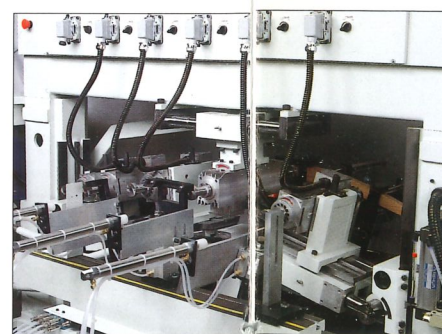
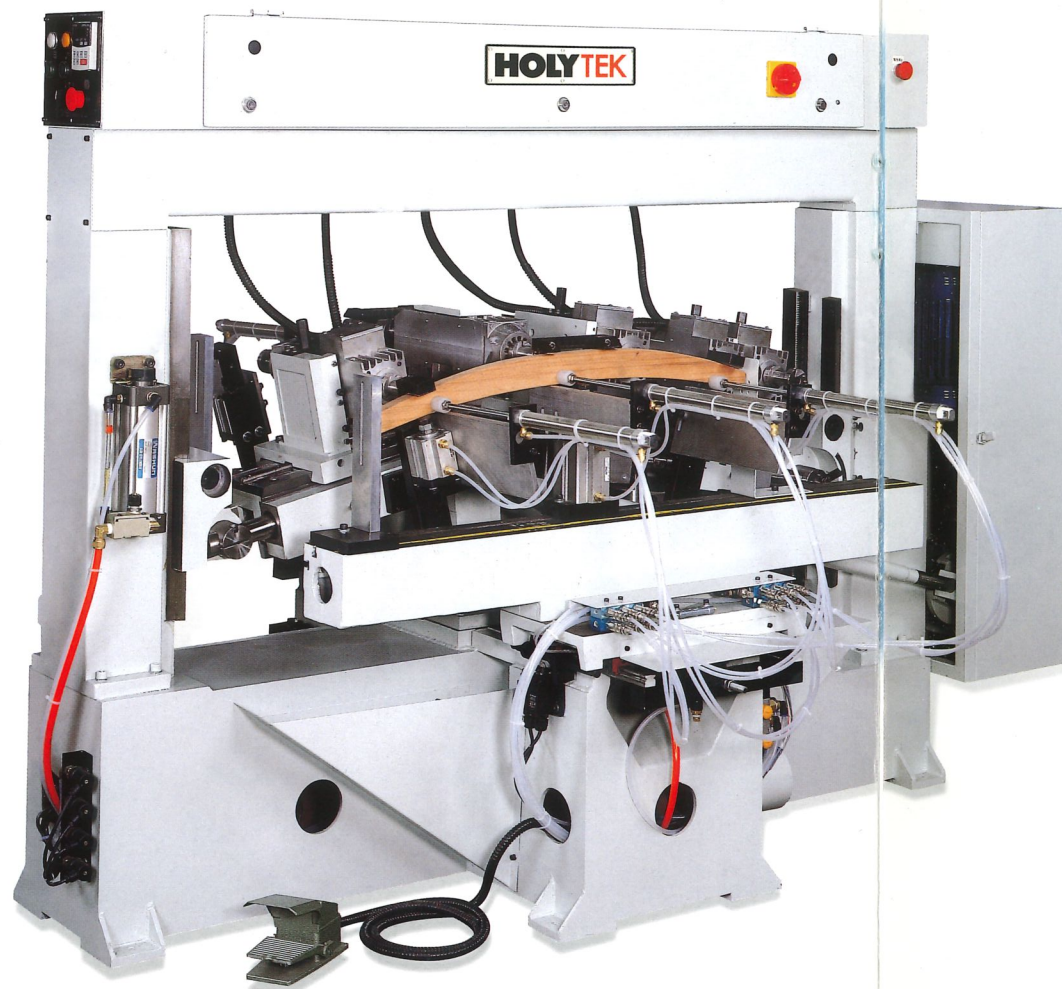
Mortising head is directly driven by a 1.8 HP motor. Two cutters fitted on both ends of spindle perform both sides mortising simultaneously.

Mortising head position can be adjusted in right/left and up/down directions.

Collet chuck clamps/unclamps the cutter for quick tool change.

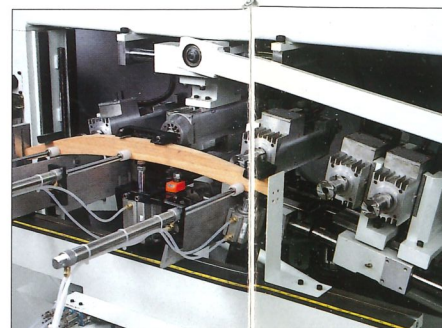
## 3~6 Head Configuration YOM-3

*MULTIPLE SPINDLE OSCILLATION MORTISER  
with 3 Sets of Tilting Carriages*



#### INDEPENDENT MORTISING HEAD CONTROL

Each mortising head is controlled by an independent switch. The operator may adjust mortise position as desired for maximum flexibility.



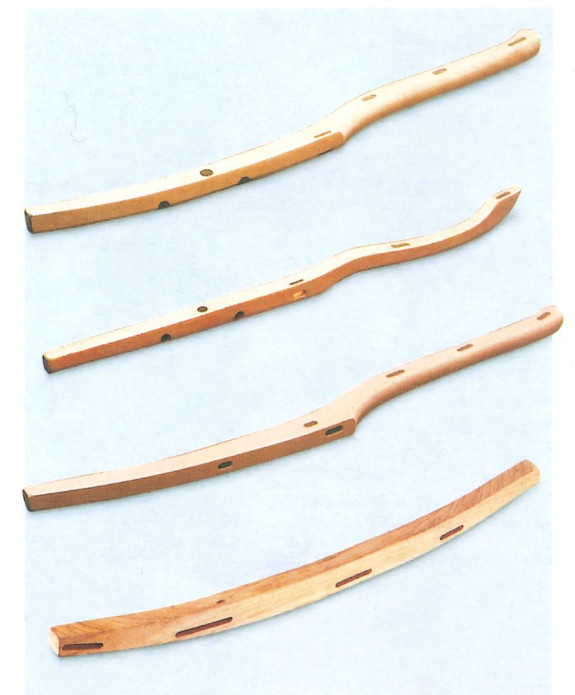
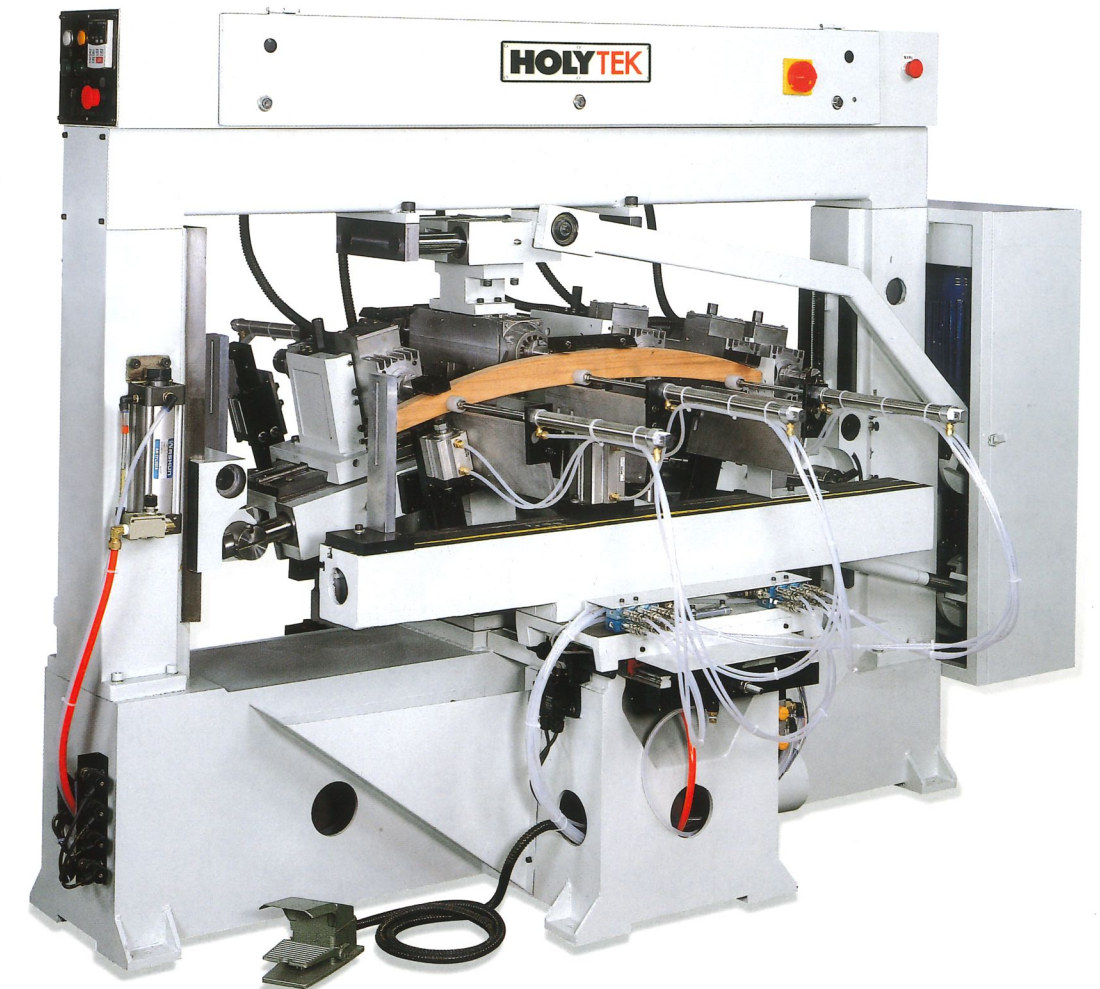
#### CARRIAGE

The machine is constructed of three tilting carriages and one horizontal carriage. Each carriage can be fitted with one or two mortising heads as per customer's requirements. Each carriage can be tilted independently. Maximum tilting angle is 20°.

Picture shown model YOM-4 is equipped with three tilting carriages and one horizontal carriage.

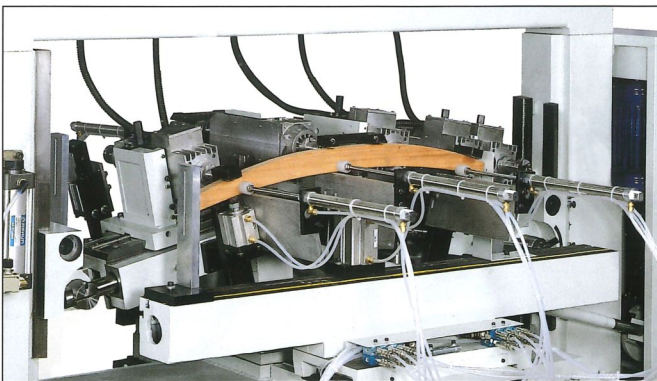
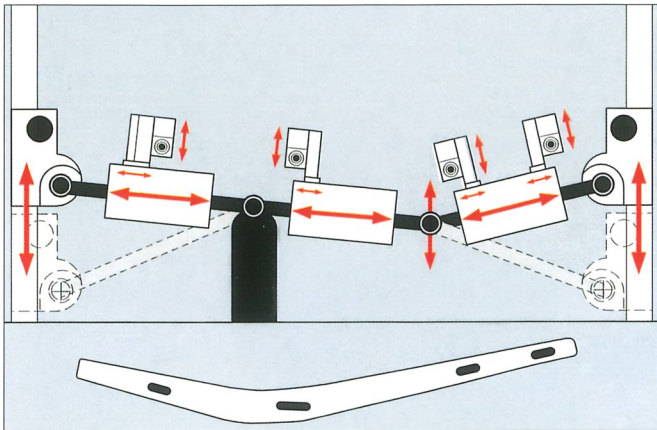
## 3~6 Head Configuration YOM-4

*MULTIPLE SPINDLE OSCILLATION MORTISER  
with 3 Sets of Tilting Carriages and 1 Set Horizontal Carriage*

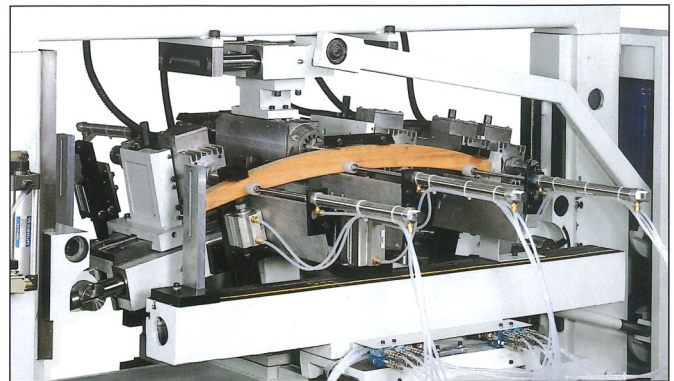
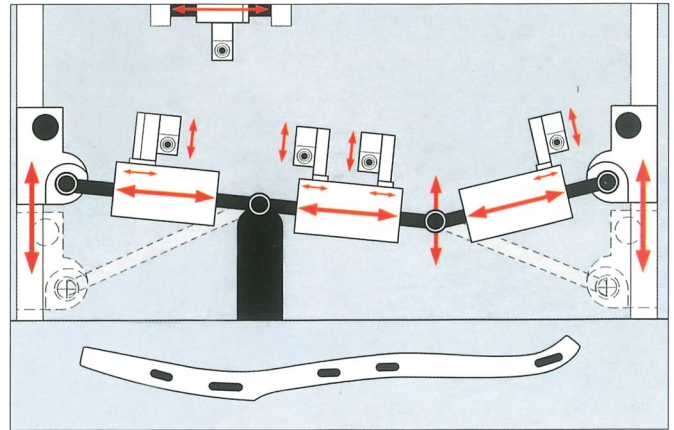


# MORTISING HEADS AND CARRIAGES CONSTRUCTION

**YOM-3**



**YOM-4**



## SPECIFICATIONS:

MODEL	YOM-3	YOM-4
Number of carriages	3 sets	4 sets
Number of spindles	3~6 spindle	3~6 spindle
Max. mortise width	100 mm	100 mm
Max. mortise depth	30 mm	30 mm
Cutter diameter	Ø6~ Ø25 mm	Ø6~ Ø25 mm
Cutter shank diameter	Ø16 mm	Ø16 mm
Min. distance between spindles	90 mm	90 mm
Oscillation speed (2 speeds)	95 / 190 strokes	95 / 190 strokes
Spindle speeds	6,000~12,000 RPM	6,000~12,000 RPM
Tilted mortise angle	20°	20°
Spindle motor	1.8 HP	1.8 HP
Oscillation drive motor	1 HP	1 HP
Working air pressure	5~6 kg/cm <sup>2</sup>	5~6 kg/cm <sup>2</sup>
Dust hood outlet diameter	Ø5"	Ø5"
Net weight	1350 kgs	1450 kgs
Gross weight	1650 kgs	1750 kgs
Machine dimensions	1,420 x 2,200 x 1,400 mm	1,420 x 2,200 x 1,800 mm
Packing dimensions	1,600 x 2,350 x 1,550 mm	1,520 x 2,350 x 1,860 mm

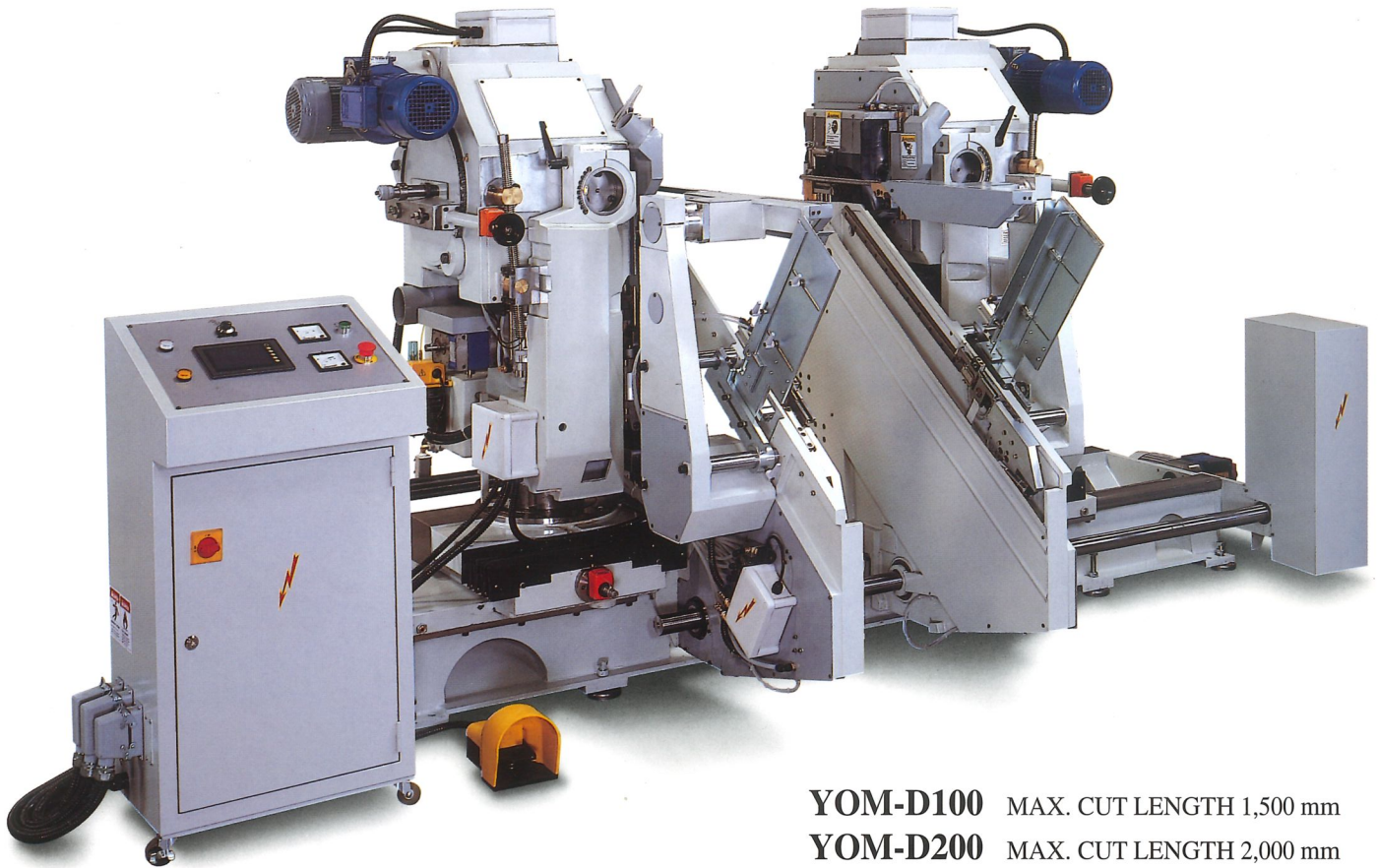
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**\* OPTIONAL: EXTRA HI-FREQUENCY SPINDLE MOTOR: 1.8 HP**

# Max. Cut Length. 1,500~2,000 mm YOM-D100 / D200

## DOUBLE END RECTANGULAR TENONER

*A Profitable Performer!*



**YOM-D100** MAX. CUT LENGTH 1,500 mm  
**YOM-D200** MAX. CUT LENGTH 2,000 mm

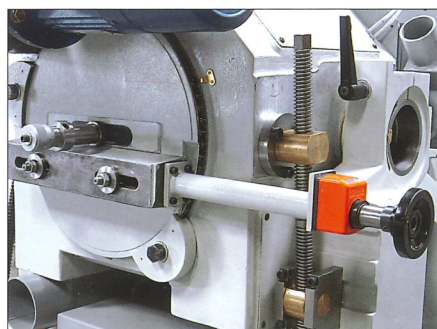
### *Outstanding Features:*

- Equipped with a PLC control combined with touch sensing screen for user friendly operation.
- Fully automatic tenoning operation greatly upgrades production output.
- Cutting tenons at both ends simultaneously for greatly increasing efficiency and productivity.
- Designed for producing rectangular and cylindrical tenons.
- The machine is suitable for producing horizontal, vertical and mitered tenons.
- Cutter feed speed is controlled by frequency inverter, allowing for variable speed change.
- Equipped with a workpiece magazine for fully automatic operation.
- Workpiece feed slideways are equipped with precision linear motion guides, ensuring fast and stable feed motions.



### **SMOOTH FEED MOTION**

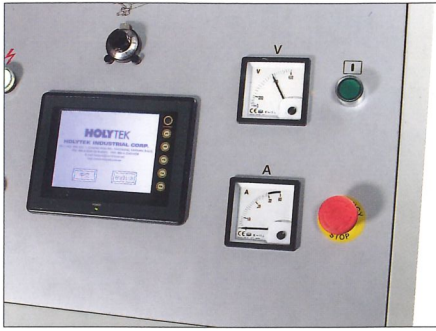
- \* The workpiece feed slideways are equipped with precision linear motion guides, providing fast and extremely smooth feed motions.
- \* Feed carriages at both sides are transmitted by a single shaft, ensuring synchronized travel.



### **CONVENIENT TENON WIDTH ADJUSTMENT**

- \* Tenon width adjustment is conveniently made by simply turning the adjustment knob. A mechanical meter is equipped for accurately indicating the width adjustment amount.

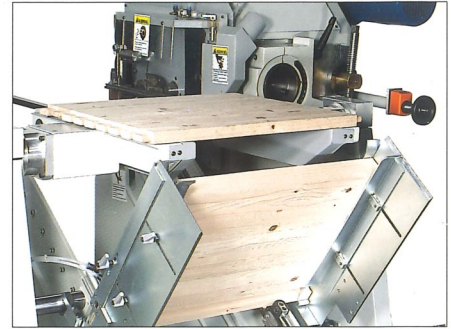




### USER-FRIENDLY CONTROL

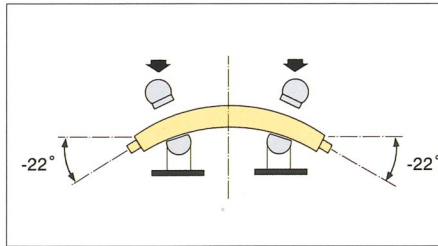
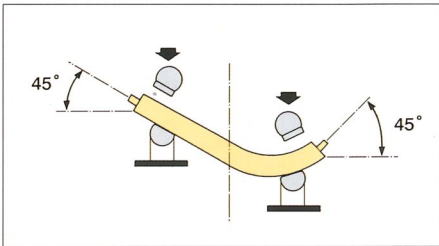
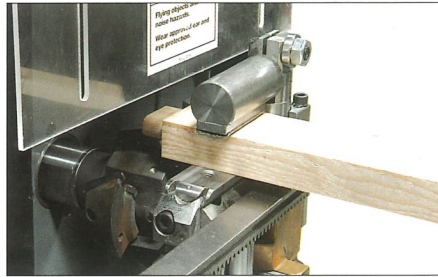
The machine is equipped with a PLC for controlling the entire motion sequences. It combines with touch sensing screen, providing maximum operational convenience. An Amp. meter is provided on the control panel for indicating the loading condition on main motors. The controller provides major functions as listed below:

- \* Chinese/English display conversion.
- \* Selections of operation mode - manual, automatic, semi-automatic and fully automatic.
- \* Malfunction indication.
- \* Timing display.
- \* Production quantity setting and display.



### WORKPIECE MAGAZINE

- \* A magazine is equipped at front of the machine. Operator simply places workpieces into the magazine. Then, the machine will automatically perform workpiece feeding and tenon cutting. This provides maximum operational convenience and upgrades productivity.
- \* The finished products will automatically outfeed to the product rest, allowing operator to take products with ease.



### WARPED WORKPIECE TENONING

- \* The workpiece clamps at both sides are adjustable to suit workpiece warping conditions. This allows the machine to perform tenon cutting on a warped workpiece.



### SPECIFICATIONS:

MODEL	YOM-D100	YOM-D200
Spindle speed	9,000 RPM	9,000 RPM
Maximum tenon width	100 + 2R mm	100 + 2R mm
Maximum tenon length	40 mm	40 mm
Maximum tenon depth	10 mm	10 mm
Maximum tenon thickness	30 mm	30 mm
Cutter drive motor	3 kw x 2 (4 HP x 2)	3 kw x 2 (4 HP x 2)
Rotation motor	0.5 kw x 2 (0.7 HP x 2)	0.5 kw x 2 (0.7 HP x 2)
Head position adjustment motor	1 kw (1.5 HP)	1 kw (1.5 HP)
Total horsepower	8 kw	8 kw
Dust hood outlet diameter	Ø60 mm x 2 / Ø100 mm x 2	Ø60 mm x 2 / Ø100 mm x 2
Net weight / Gross weight	2460 kgs / 2915 kgs	2680 kgs / 3155 kgs
Machine dimensions	4,300 x 2,600 x 2,010 mm	4,800 x 2,600 x 2,010 mm
Packing dimensions	3,770 x 2,000 x 2,000 mm	4,270 x 2,000 x 2,000 mm

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# HOLYTEK

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