

## DATA SHEET

# BL Twin

## BLOCKHAUSFRÄSE



Double end Log cabin milling machine Blockhausfräse BL Twin for serial production of components for garden log Cabins.

The corner joint „CHALET“ will be done on both ends of the log at the same time.

Optionally can be cut in the same step the chamfer on both end of the log.

Also optionally is possible to calibrate the exact length of the Log by sectional trimmers

The hydro pneumatic feeding system with an express traverse, allows the creation of a four- fold corner joint only in a few seconds! High performance spindle drives and climb milling ensures a clean cut milling contour without being frayed.

**process flow:** The left and the right machine should be adjusted to the required workpiece dimension (Both machines synchronic). The operator inputs the required length of the workpiece to the display by the numeric keyboard, and with “START” the right, movable unit goes to the proper position.

If length calibration is required, the raw material should be pre cutted 2 - 3 cm longer (For example with cross cutter machine). If length calibration is not required, the logs have to be cutted exactly.

The operator puts the Log from the front onto the machine table. To find the right workpiece position in relation to the working unit is installed one workpiece stop face at each unit.

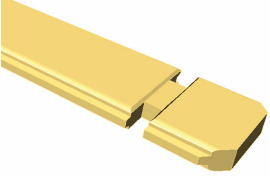
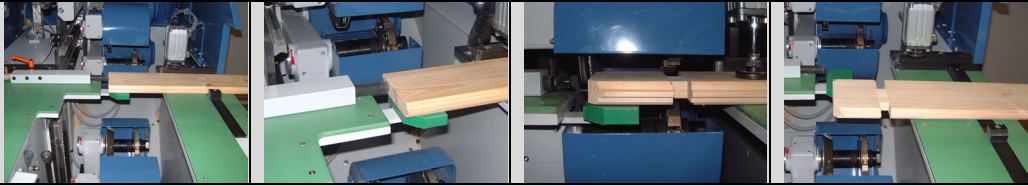

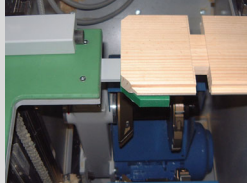
With the foot switch the operator starts the cycle: The cabin close automatically - the working units horizontal and vertical are doing the milling process - the workpiece will be released and pushed out from working position - the cabin opens automatically. The operator applies the next log to the table, takes the finished away and starts the next working cycle...

Both machines can also be used independent for shorter single jointed pieces.

The working cycle for processing the workpiece on both sides with chamfering and length calibration takes 12 – 15 seconds!



## TECHNICAL DATA:

	<b>Working dimensions:</b>			
	Wall thickness x log height	min.: max.:	28 x 100mm 70 x 160mm  50 x 160mm	without length calibration & without chamfering with length calibration & with chamfering
	Workpiece length min. Single joint:		300mm	
	Workpiece length min. Double joint:		1000mm	
	Workpiece length max.:		6000mm	
<b>Workingunits:</b>				
				
Drives	Hor.: (2 + 2) x 3kW Vert.: (2 + 2) x 3kW			
Spindle speed	4200 U/min			
Milling shaft Ø	30mm			
Milling shaft length	175mm			
Tool Ø max.	Hor.: 160mm milling tool / 250mm sectional trimmer Vert.: 220mm			
Tool width max.	60mm			
Feed	Hydro pneumatic infinitely variable with express traverse			
Adjustment milling support	Trapezoid spindle with digital counter			
Workpiece- holder	Upside: 1 + 1 pneumatic pressing cylinder Frontside: 1 + 1 pneumatic pressing cylinder with pusher for finished workpiece			
Suction	under floor suction (hole) central 2x D=120mm, 30m/min			
Pneumatic supply	Euro coupler, compressed air - dried and cleaned 8 bar, ca. 300l/min			
Current supply	Eurocurrency 400V+N+PE, 21kW			
Weight	ca. 2600kg			
<b>Accessories:</b>				
Calibration of length	Sectional trimmers for length calibration. The raw material should be pre cutted 2-3cm longer. The sectional trimmer on upper spindle of horizontal unit cuts the exact length.			
Chamfer on end of log	Additional tools at front and back vertical spindle for chamfering the ends of the log on both sides. To get a clean cutting surface is mountable a additional small table as support and contra profile.			
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