BARBERÁN

Solutions since 1929

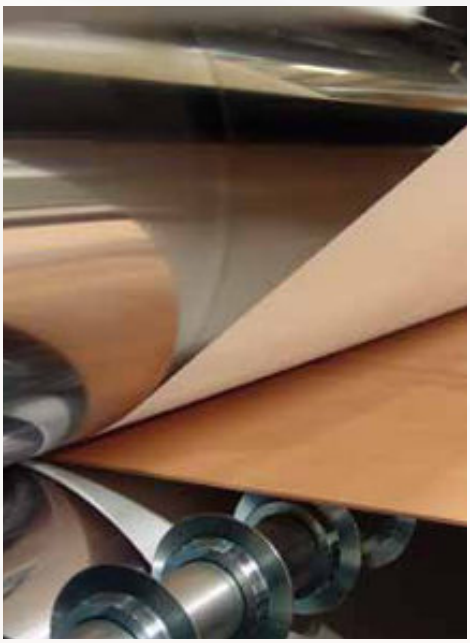
Lamination systems

LAMINATING

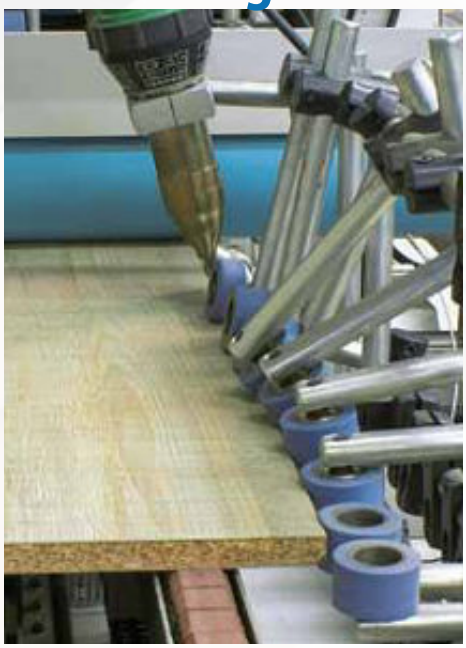
GLUING

Gluing

Lamination



Postforming



www.barberan.com

INTRODUCTION

BARBERAN delivers nowadays the best solutions in coating, printing, drying, profile wrapping, laminating, post-forming and profile sanding, as well as a wide range of complementary machines. Our machines can be found in more than 3,000 factories for furniture, doors, windows, panels, flooring, profiles, packages, boats, toys, cars, appliances, glass, etc. More than 85% of them are located outside Spain. Our lines are designed to improve productivity and reduce manufacturing costs, taking always into consideration our respect for the environment.

We have an exclusive section dedicated to produce our coating and printing machines, drying tunnels as well as complementary machines. We manufacture from single machines to the most comprehensive lines according to customer's needs.

We are the company who developed the last technology of indirect printing either for wooden packages, printing over profiles of PVC, glass, flooring, profiles, doors, PVC, etc., as well as a wide range of furniture printing systems.

Quality and Service

QUALITY. BARBERAN's first target is to offer highest quality products. According to this philosophy, each step in the production is performed under rigurous quality controls from purchase of raw material, production, machine installation up to after sales service. The iso 9001 certification guarantees our quality at international level.

Certificado del
Sistema de Gestión de la Calidad

AENOR
ER
Empresa Registrada
UNE-EN ISO 9001

ER-0109/1995

AENOR, Asociación Española de Normalización y Certificación, certifica que la organización

BARBERAN, S.A.

dispone de un sistema de gestión de la calidad conforme con la Norma UNE-EN ISO 9001:2008

para las actividades: El diseño y la producción de maquinaria para el acabado de superficies. El montaje, la puesta en marcha y el servicio posventa de la instalación.

que se realizan en: Pl. CAMI RAL CL GALILEO, 3-9, 08860 - CASTELLDEFELS (BARCELONA)

Fecha de emisión: 1995-04-19
Fecha de renovación: 2012-07-18
Fecha de expiración: 2015-07-18

Avelino BRITO MARQUINA
Director General de AENOR

AENOR Asociación Española de Normalización y Certificación | Génova 6, 28004 Madrid, España Tel. 902 102 201 - www.aenor.es

Entidad de certificación de sistemas de gestión de la calidad acreditada por ENAC con acreditación Nº 2/C-SC033

IQNet — AENOR es miembro de la IQNet (Red Internacional de Certificación)

IQNet

THE INTERNATIONAL CERTIFICATION NETWORK

CERTIFICATE

IQNet and
AENOR
hereby certify that the organization

BARBERAN, S.A.

Pl. CAMI RAL, CL GALILEO, 3-9
08860 - CASTELLDEFELS (BARCELONA)
España

for the following field of activities

The design and production of machinery for surface finishing.
The assembling, commissioning and servicing of the installation.

has implemented and maintains a

Quality Management System

which fulfills the requirements of the following standard

ISO 9001:2008

Issued on: 1999-08-01 Renewed on: 2012-07-18 Validity date: 2015-07-18

Registration Number: ES-0109/1995

IQNet

AENOR

Michael Drechsel
President of IQNet

Avelino BRITO
Chief Executive Officer

IQNet Partners*:
AENOR Spain AFNOR Certification France ABS Quality International Belgium ANCE Mexico APCER Portugal CCC Cyprus
CISQ Italy CQC China CQM China CQS Czech Republic Cro Cert Croatia DQS Holding GmbH Germany EIS Denmark
ELOT Greece FCAV Brazil FYROM/ORMA Venezuela ICONTEC Colombia IMNC Mexico INNORPI Tunisia
Inspecta Certification Finland/IMANT Argentina IQA Japan KFQ Korea MSZT Hungary Nemko AS Norway NYAS Poland
PCBC Poland Quality Austria Austria RR Russia SII Israel SIQ Slovenia SIRIM QAS International Malaysia SQS Switzerland SRAC
Romania TEST St Petersburg Russia TSE Turkey YUQS Serbia
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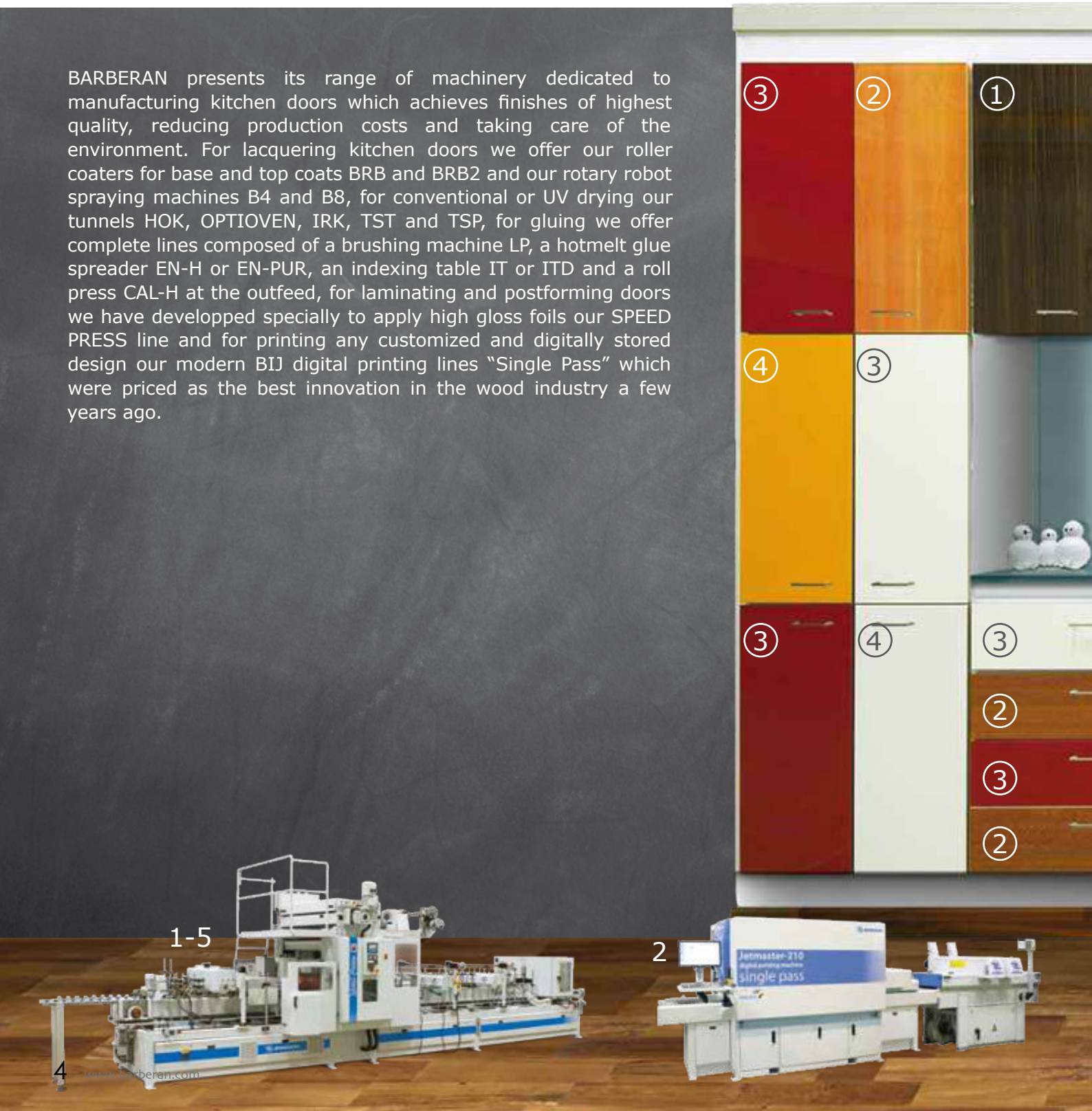
Kitchen doors

Materials, machines and processes

1- Acrylic foil (0.22 mm thickness): Laminating and postforming line.
2- Methacrylate (2 mm thickness): Jetmaster digital printer, BRB roller coater for white base color application, HOK UV drying tunnel and PUR gluing and indexing line.
3- High pressure foil (1 mm thickness): PUR gluing and indexing line.
4- High pressure foil (0.7 mm thickness): PUR gluing and indexing line.
5- PVC foil (0.35 mm): Laminating and postforming line.
6- Glass: Roller coater BRB for white base color application, UV drying tunnel HOK and PUR gluing and indexing line.
7- Profile wrapping.
8- Engraved roller printing or digital printing line.

BARBERAN presents its range of machinery dedicated to manufacturing kitchen doors which achieves finishes of highest quality, reducing production costs and taking care of the environment. For lacquering kitchen doors we offer our roller coaters for base and top coats BRB and BRB2 and our rotary robot spraying machines B4 and B8, for conventional or UV drying our tunnels HOK, OPTIOVEN, IRK, TST and TSP, for gluing we offer complete lines composed of a brushing machine LP, a hotmelt glue spreader EN-H or EN-PUR, an indexing table IT or ITD and a roll press CAL-H at the outfeed, for laminating and postforming doors we have developped specially to apply high gloss foils our SPEED PRESS line and for printing any customized and digitally stored design our modern BIJ digital printing lines "Single Pass" which were priced as the best innovation in the wood industry a few years ago.

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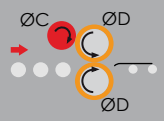
PUR Hotmelt glue spreader

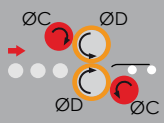
EN-PUR

Glue spreader for PUR hotmelt application on flat surfaces (panels, gypsum plates, insulators, etc.). Flexibility and high production capacity. Model EN-PUR-4 with silicone application rollers and metallic doctor rollers heated up to 165 ºC. Premelter + connections to be determined. Mod. EN-PUR-2, only single side application.

EN-PUR-2



EN-PUR-4

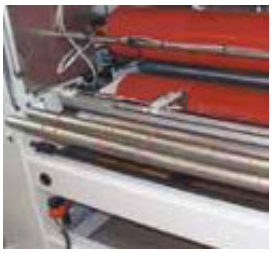


MOD.	A mix	∅ C	∅ D	kW
EN-PUR-2-800	700	248	248	8
EN-PUR-2-1100	1000	248	248	9
EN-PUR-2-1400	1300	248	248	12
EN-PUR-2-1800	1700	248	248	13
EN-PUR-2-2200	2050	305	305	19
EN-PUR-2-2400	2200	305	305	23
EN-PUR-2-2800	2600	305	305	24
EN-PUR-2-3200	3000	358	358	30
EN-PUR-4-800	700	248	248	12
EN-PUR-4-1100	1000	248	248	14
EN-PUR-4-1400	1300	248	248	22
EN-PUR-4-1800	1700	248	248	25
EN-PUR-4-2200	2050	305	305	36
EN-PUR-4-2400	2200	305	305	38
EN-PUR-4-2800	2600	305	305	40
EN-PUR-4-3200	3000	358	358	50

EN-PUR 300

PUR Glue spreader for small panels up to 300 mm width. Option: fast and precise motorized application head raising.

Gluing of both sides of the panels.



Infeed conveyor rollers and outfeed.

Applicator roller coated with silicone rubber.

Glue grammage adjustment by speed variation.

Cleaning system turning oppositely to the application sense.

Level detectors for the glue supply control.

Machine with variable frequency geared motors.

Metallic dosing roller with internal heating by thermal oil.

Upper head lifting system on 4 columns.

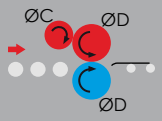
Upper protection with total visual access and prepared for gas extraction

EVA/PUR Hotmelt glue spreader

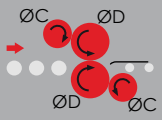
EN-H-2 EN-H-4

Glue spreader for EVA/PUR hotmelt application on flat surfaces (panels, gypsum plates, insulators, etc.). Flexibility and high production capacity. Model EN-H-4 for doublesided gluing with metallic application and dosing rollers heated up to 210 ºC. Premelter + connections to be determined. Mod. EN-H-2 for single side application only.

EN-H-2



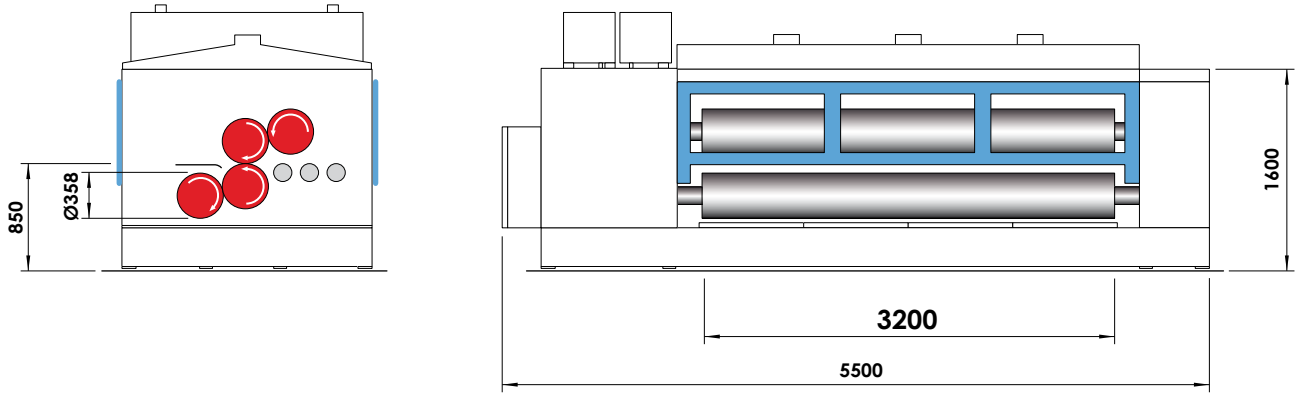
EN-H-4



MOD.	A max	Ø C	Ø D	kW
EN-H-2-800	700	248	248	12
EN-H-2-1100	1000	248	248	14
EN-H-2-1400	1300	248	248	20
EN-H-2-1800	1700	248	248	23
EN-H-2-2200	2050	305	305	34
EN-H-2-2400	2200	305	305	36
EN-H-2-2800	2600	305	305	38
EN-H-2-3200	3000	358	358	44
EN-H-4-800	700	248	248	21
EN-H-4-1100	1000	248	248	25
EN-H-4-1400	1300	248	248	38
EN-H-4-1800	1700	248	248	43
EN-H-4-2200	2050	305	305	65
EN-H-4-2400	2200	305	305	69
EN-H-4-2800	2600	305	305	73
EN-H-4-3200	3000	358	358	85

EN-H-3200

Gluing machine for hotmelt application on flat surfaces (Panels, gypsum plates, insulators, etc.) prepared for its fast finishing.



GS-4-PVAc

Gluing machine for the application of PVAc glues on flat surfaces.
Support and elevation system of the application head through 4 columns which guaranties a precise application. Independent speed regulations for top and bottom application and dosing rollers. Reverse turning of dosing rollers for cleaning and maintenance purposes. Buttons and controls with IP-55 electric protection, readout of application head lifting up to 80 mm. Application rollers with quick-change system and adjustment of the dosing roller between 0 and 80 mm. Rollers with protection covers at the infeed and outfeed with security system. Security protection system which detects the thickness of the pieces entering the machine, lateral plates for glue between the rollers, removable table for cleaning the lower rollers.

Compact line

Compact laminating machine for the application of paper foil, PVC and low pressure laminates (CPL) on panels made of MDF or particleboard using EVA or PUR hotmelt glues. The machine is composed of a single bedframe with a tiltable infeed table with panel guides, an applicator and a doctor roller, both made of steel and heated by means of heating elements in oil bath, a counter-pressure roller made of silicon rubber, two pressing rollers made of steel (one upper and one lower) to apply a pressure up to 10 Kg/cm2 on both, foil and panel, and a tiltable outfeed table. The glue is supplied by an independent melting unit with heated hose that can be purchased from a specialized supplier.

Spreader for HotCoating®

MEN-H

Hotmelt product application-smoothing machine developed specially for the product Hot Coating® from the brand Kleiberit® in melamine board lacquering processes to achieve a maximum quality, high gloss finish or in wood flooring finishing processes, where an abrassion resistance starting from level AC2 up to AC5 is achieved depending on the grammage applied with the MENH.

The model MENH is equipped with:
-Independent motors for each roller
-Heating of dosing and smoothing roller through heating elements in thermal oil bath
-Maximum heated roller temperature: 200ºC
-Silicon rubber applicator roller

High Gloss

HIGH GLOSS ON MELAMINE

High Gloss lacquered melamine boards with HotCoating®.
In this new developed technology, products from the company KLEBCHEMIE M.G.Becker GmbH "KLEIBERIT®" are used in order to achieve a perfect adhesion on melamine, avoiding the usual problems that often appear in conventional processes like bad adhesion or other problems during cutting and drilling, etc.
The special designed roller technology BARBERAN is capable of applying a High Gloss UV finish, which was, up to now, only possible by the use of spraying guns or curtain coaters.

Characteristics

-"**Mirror** Finish" quality with best values in transparency and depth.
- Perfect adhesion of the UV High Gloss products on melamine.
- Extremely economic system with an overall cost lower than using traditional systems.
- Excellent properties to be cut.
- Immediate manipulation of finished boards.
- Flexibility; allows to be postformed.

FINISHED ON MELAMINE BOARD, ROLLER OR DIGITAL PRINTED.

High Gloss

COMPLETE PROCESS FOR HIGH GLOSS OR MATT ROLLER FINISHING OF MELAMINE:

- Cleaning
- HotCoating® application
- Cooling
- Application of UV base coat 1
- UV Curing
- Application of UV base coat 2
- Conditioning in controlled environment
- UV Curing
- Sanding and cleaning
- UV High Gloss top coat application
- Conditioning in controlled environment
- UV High Gloss top coat curing

THIS PROCESS IS ALSO SUITABLE FOR DIFFERENT TYPES OF SUBSTRATES AS:

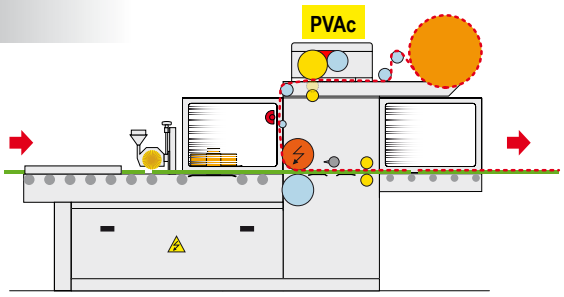
- Printed boards
- Jetmaster Digital printed boards
- Cork
- Wood veneer
- Decorative paper
- HPL/CPL

SUITABLE ALSO FOR:

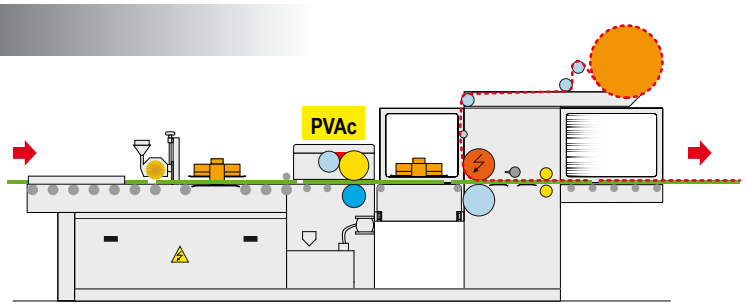
-Printed boards
-Digital printed boards
-Cork
-Wood veneer
-Decorative paper
-HPL/CPL

PVAC glue lamination

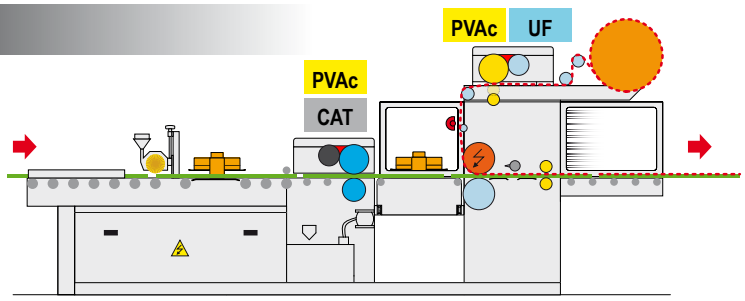
KL-F



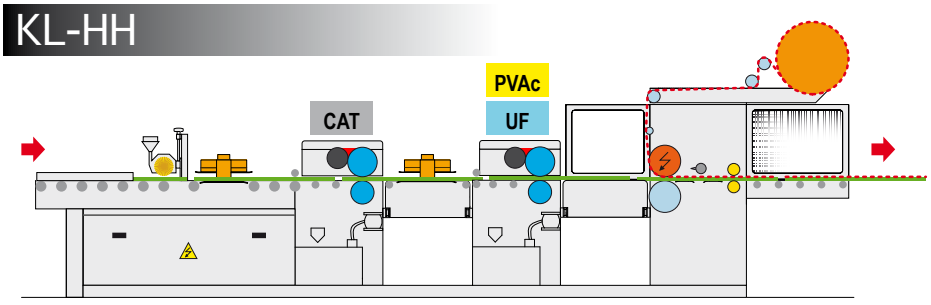
KL-P



KL-FP



KL-HH



			KL-F	KL-P	KL-FP	KL-HH
Aplicación de cola sobre Glue application on Leimauftrag auf Application de colle sur Applicazione colla su Нанесение клея на	FOLIO	PVAc	●		●	
		UF			●	
	PANEL	PVAc		●	●	●
		UF				●

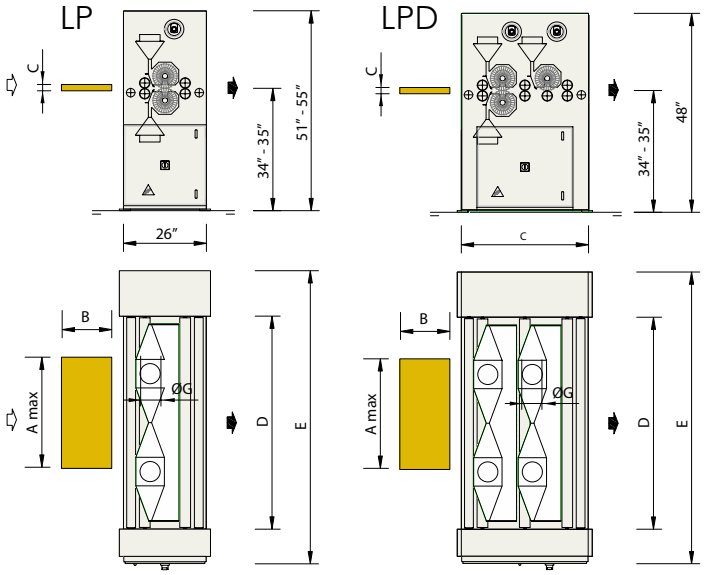
KL Series

Laminating machine KL Series, for paper or PVC foil using PVAc glues (all models) or paper foil using urea formaldehyde glues (model KL-FP and KL-HH) on PB or MDF boards for the door, furniture industries, etc. Two versions available for foil widths up to 1350 mm (panel 1310 mm) and 1550 mm (board 1510 mm).

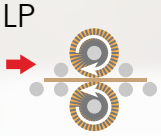
LP / LPD

Machines for cleaning flat surfaces by means of an upper and a lower vegetal fibre brush, that rotate in opposite direction to the workpieces. The lower brush is adjustable in height as well in order to compensate the weardown. The machine includes a driving roller conveyor for the transport of the workpieces.

LP



LP



LPD

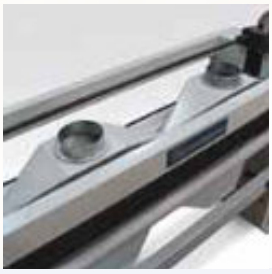
MOD.			m³/h	m/min	kW
LP-600	180	4x150	6400	5-30	1,5
LP-800	180	4x150	6400	5-30	1,5
LP-1100	180	4x150	6400	5-30	1,5
LP-1400	180	4x150	6400	5-30	1,5
LP-1600	180	4x150	6400	5-30	1,5
LP-1800	180	4x150	6400	5-30	3
LP-2000	180	4x150	6400	5-30	3
LP-2200	180	4x150	6400	5-30	3
LP-P-2400	250	4x200	10000	5-30	7
LP-P-2600	250	4x200	10000	5-30	7

MOD.			m³/h	m/min	kW
LPD-600	180	6x150	9600	5-30	2,6
LPD-800	180	6x150	9600	5-30	2,6
LPD-1100	180	6x150	9600	5-30	2,6
LPD-1400	180	6x150	9600	5-30	2,6
LPD-1600	180	6x150	9600	5-30	2,6
LPD-1800	180	6x150	9600	5-30	2,6
LPD-2000	180	6x150	9600	5-30	3,4
LPD-2200	180	6x150	9600	5-30	3,4
LPD-P-2400	250	6x200	16800	5-30	7,7
LPD-P-2600	250	6x200	16800	5-30	7,7

LPD

Machine with one upper and one lower reverse rotating brushes of vegetable bristle.

Flat top and bottom pressure rollers.



Dust exhaustion hoods with four outlets.

Raising through manual spindle with analogic indicator.

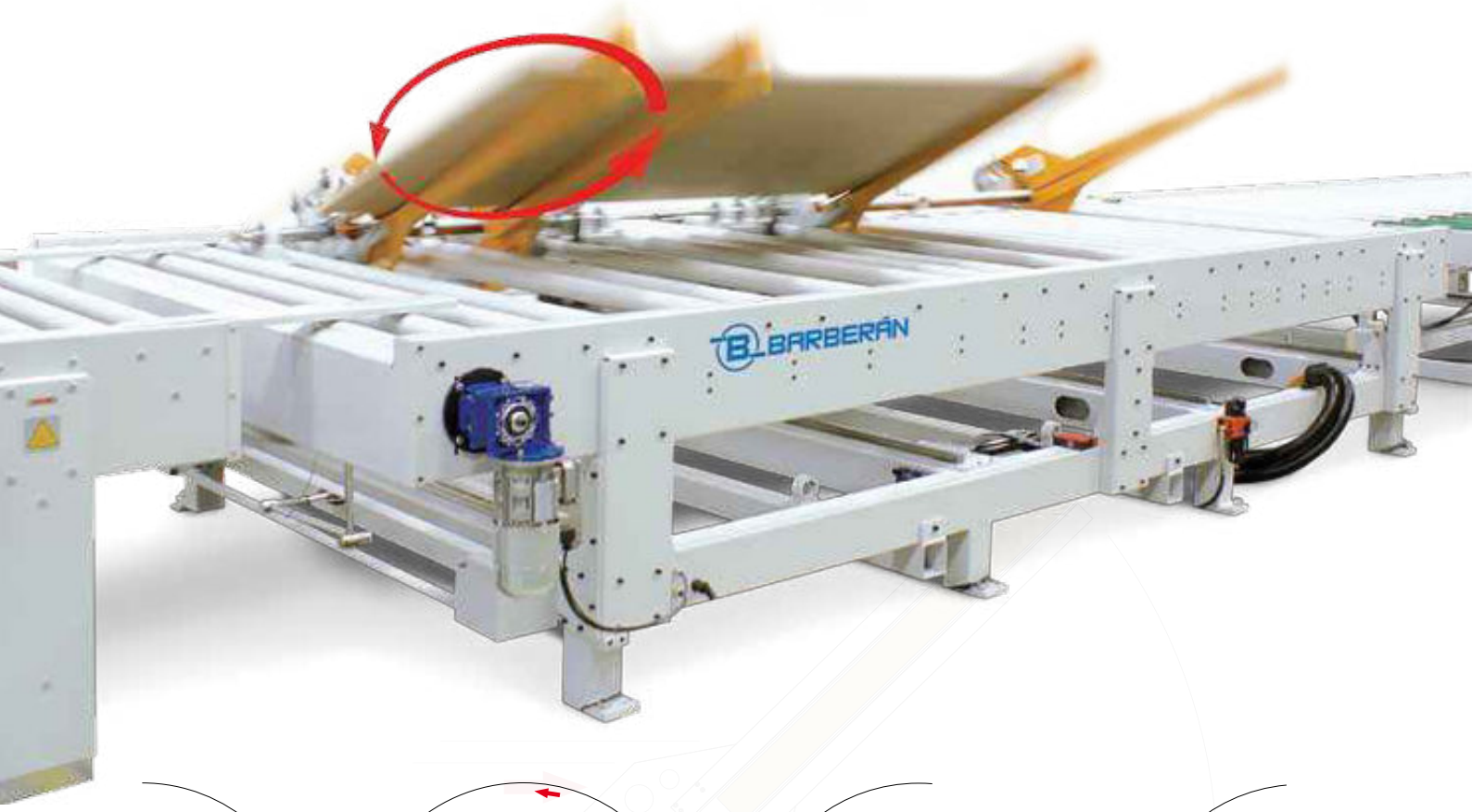
Speed regulation through inverter with digital display.

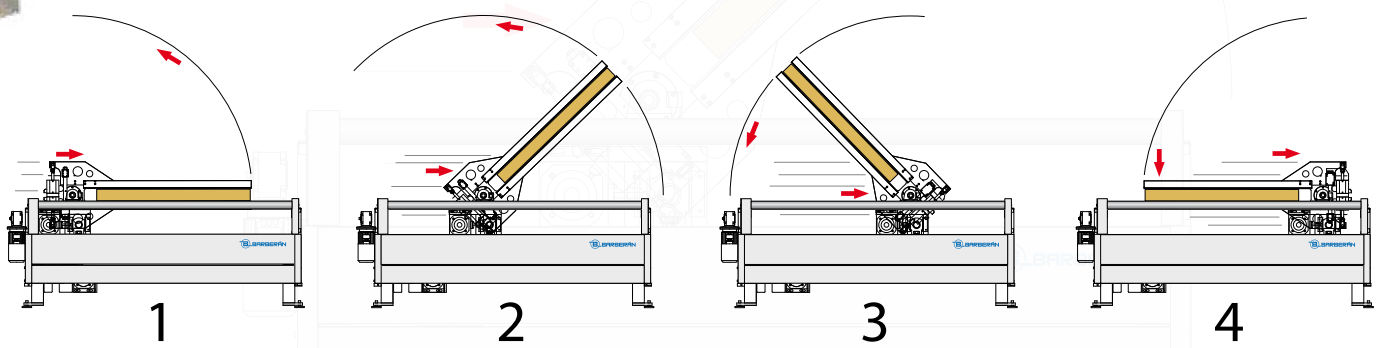
Board turning devices

VP

CLAMP TURNING DEVICE

The board enters the turning device through the roller conveyor and stops automatically in the centre of it. Four transversal clamp arms hold the board. The turning is performed because the contrary end of the arms is raised over the table to fall into the contrary side turning in this manner the board hold by the clamps. Once the operation is finished, the clamps are opened and the panel is fed out through the outfeed roller table.

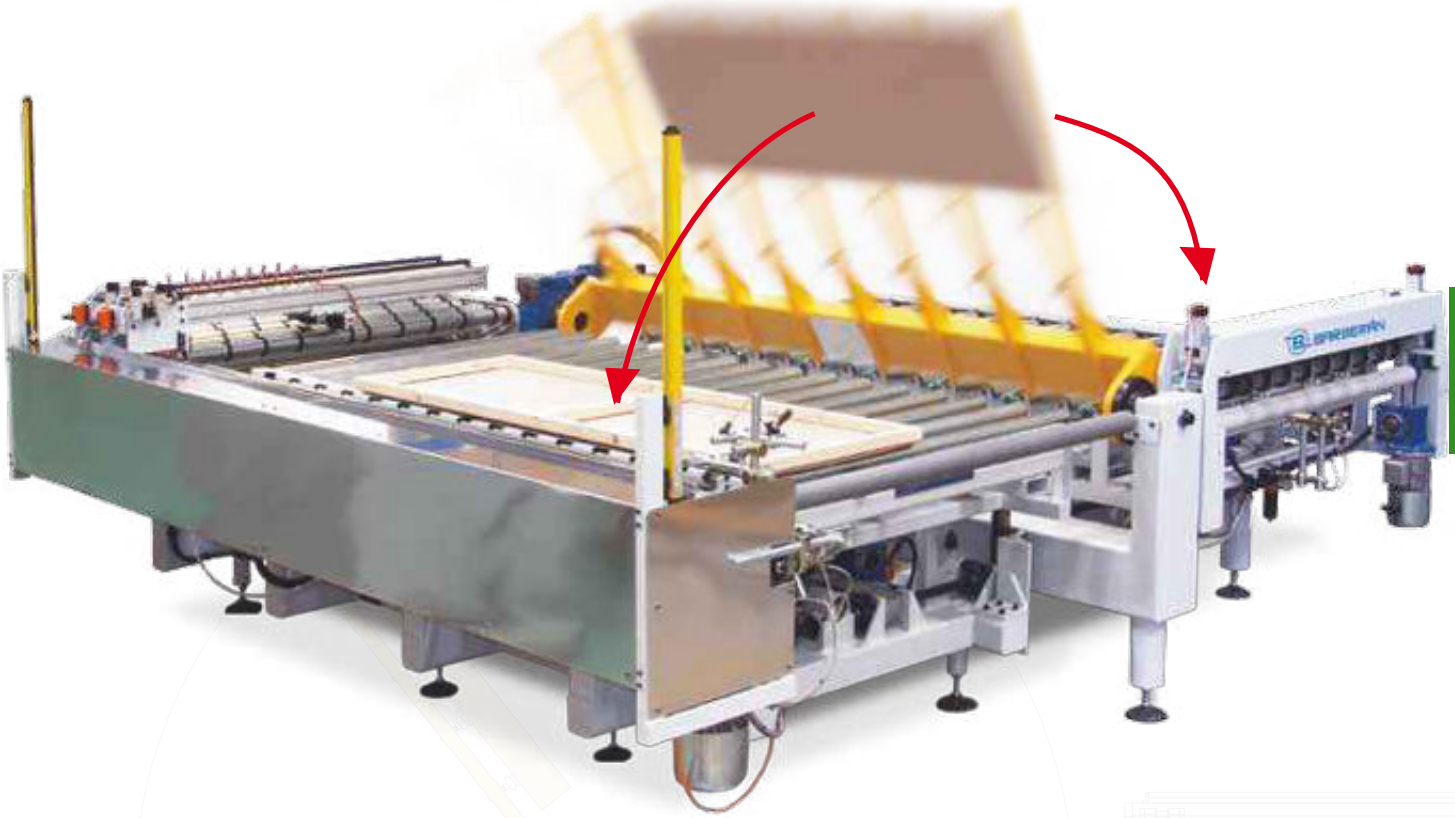


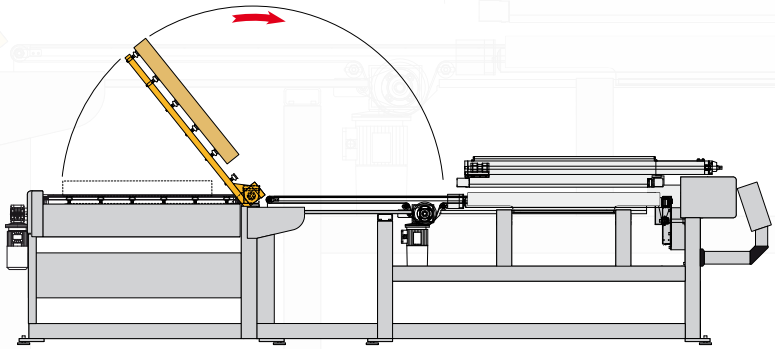


VO

TURNING DEVICE

It includes transversal arms each with a row of suction pads. These arms are placed between the rollers of the infeed table. They turn the skin top 180 º placing it onto the top of glued door frame already positioned on the door assembling table. The system is equipped with a blowing device for releasing of the skin. Once the skin is released the rotation arms return to its starting position. The turning movement is done by means of a motor-reducer of 0.75 kW.





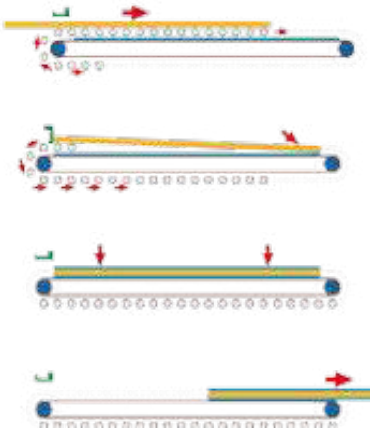
ITP-SI

INDEXING STATION FOR PANELS
Station for the application of laminate sheets on top and bottom of previously glued panels. This station needs to be operated by just one person. It is composed of a roller conveyor table, a set of pneumatic lateral presses and a tray, which allows to place the laminate sheets on and under the glued panel.

ITD-SI

TOP AND BOTTOM INDEXING STATION

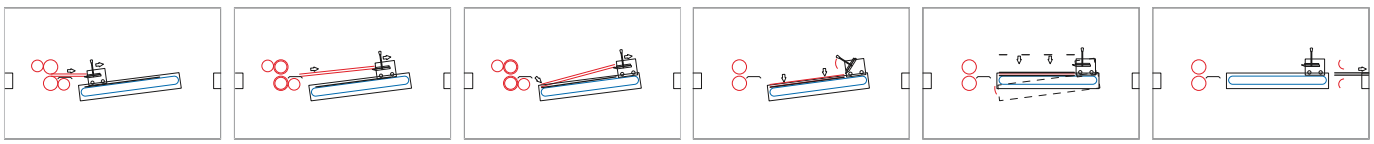
Station to cover both faces of a glued nucleus (rigid or flexible) with sheets, assembling a sandwich panel. A single operator can execute this job. The sheets may be HPL, aluminium foil, wood veneer, MDF, etc.



IT-S IT-SI

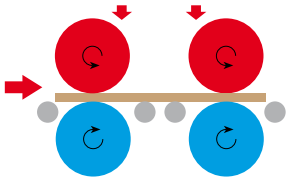
TOP AND BOTTOM INDEXING STATION

The indexing station is an assemble of two trays and a special belt conveyor that facilitate the manual placement of laminate sheets on top and bottom of glued panels in a pressing line to manufacture “sandwich” panels.



Calenders

CAL



Calandering machine with cold metallic rollers (optionally heated), for treating the surface before gluing or pressing the glued panels.

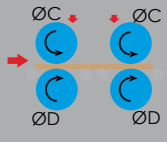
Speed regulation through INVERTER with digital display.

Foil cut at the outfeed.

4 Heated rollers (option).

CAL-2

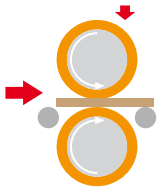
CAL-4

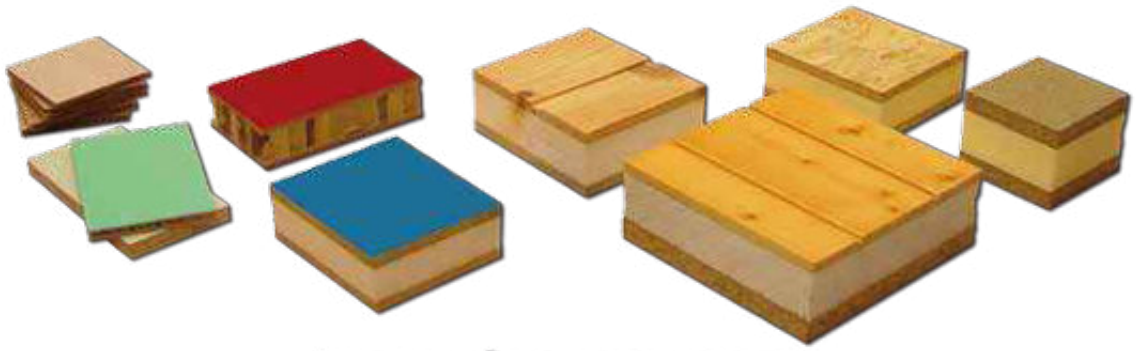


MOD.	A máx.	∅ C	∅ D	kW
CAL-2-800	700	248	248	8
CAL-2-1100	1000	248	248	9
CAL-2-1400	1300	248	248	12
CAL-2-1600	1500	248	248	13
CAL-2-2200	2100	290	290	19
CAL-2-2400	2300	290	290	23
CAL-2-2600	2500	290	290	24
CAL-2-3200	3100	358	358	30
CAL-4-800	700	248	248	12
CAL-4-1100	1000	248	248	14
CAL-4-1400	1200	248	248	22
CAL-4-1600	1500	248	248	25
CAL-4-2200	2100	290	290	36
CAL-4-2300	2200	290	290	38
CAL-4-2600	2500	290	290	40
CAL-4-3200	3100	358	358	50

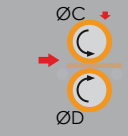
CAL-H

Calandering machine with cold rubber rollers to press, calander the panels glued with hotmelts.

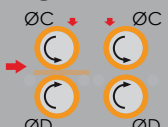




CAL-H-2



CAL-H-4



MOD.	A. mkg	ØC	ØD	kW
CAL-H-2-800	700	238	248	2
CAL-H-2-1100	1000	238	248	2
CAL-H-2-1600	1500	238	248	2
CAL-H-2-2000	1900	350	350	3
CAL-H-2-2300	2200	350	350	3
CAL-H-2-2600	2500	350	350	3
CAL-H-2-3200	3100	400	400	4
CAL-H-4-800	700	238	238	4
CAL-H-4-1100	1000	238	238	4
CAL-H-4-1600	1500	238	238	4
CAL-H-4-2000	1900	350	350	6
CAL-H-4-2300	2200	350	350	6
CAL-H-4-2600	2500	350	350	6
CAL-H-4-3200	3100	400	400	8

Option upper unwinding station.

Digital Control of the roller temperature (option).

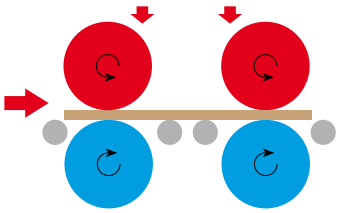
Top rollers raising through motorized spindle with analogical comparator read out.

Panel thickness Control barrier with emergency stop.

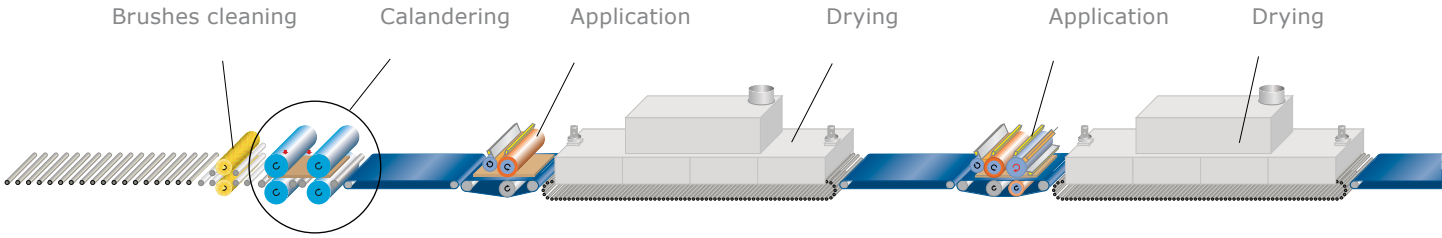
Single motor driving to the 2 or 4 pressing rollers.

CAL-4-2200

Calender machine with metallic heated rollers to improve the surface of the panels before they are glued or for pressing glued panels together. The rollers press the wood or particleboard panels so that the resin content seals their surface achieving an effect comparable to the application of filler avoiding the intermediate sanding as well.
This method achieves important savings in lacquers and sanding belts and minimizes the risk of peelings. The upper pressing rollers are made of chromed, rectified steel.



Preparation for the roller assembling. Ø500



Location of calander machine in a panel printing line.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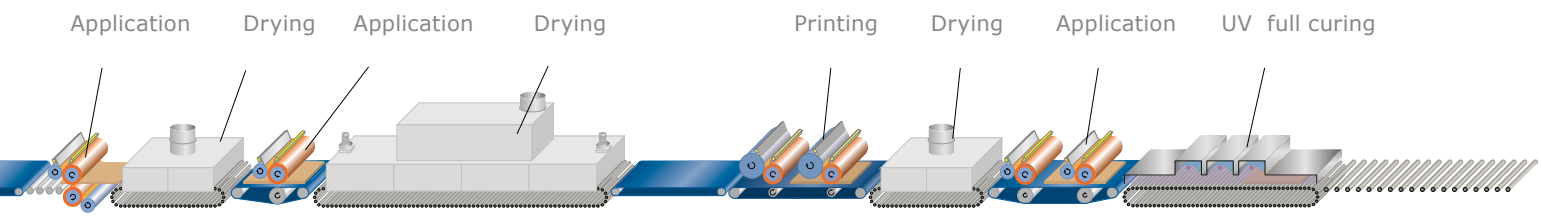
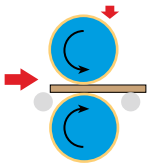
Solutions since 1929
CAL-4-2200

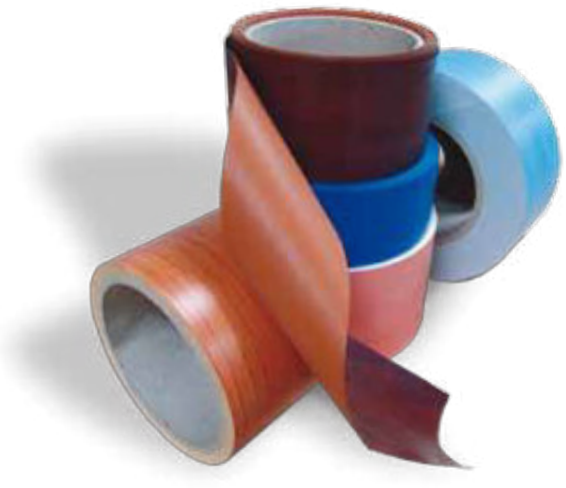

Application
Drying
Application
Drying
Printing
Drying
Application
UV full curing

Calandras

CAL-G



Embossing calandering machine
For the flat surface embossing with an engraving pressure roller.
Embossing roller driven by means of an electronic converter and with digital forward speed read-out. The counter-pressure roller has the same diameter than the embossing roller and it is made of polyamide.
It is possible to heat up the upper roller.
For paper foil or PVC.



Rodillo de presión grabado.

Características técnicas (sin opcionales)
Technical features (without options)

Ancho útil de aplicación / *Working width* ..... 550 mm
Grueso de trabajo / *Board thickness* ..... 0,5÷80 mm
Altura de trabajo ajustable / *Adjustable working height* ..... 880÷920 mm
Rodillo gofrador y de contrapresión / *Engraving and counter-pressure roller* ..... Ø 293 mm
Velocidad de trabajo / *Working speed* ..... 3÷18 mm
Potencia motor / *Motor power* ..... 1,5 kW
Presión hidráulica / *Hydraulic pressure* ..... 50 kg/cm

CAL-P

LOW-PRESSURE PRESS
Designed for pressing sandwich-panels that contain nucleus with a low compressing strength and/or wavy or curved top/bottom skins.

CAL-P-3200/1600

Gluing lines

LSE-1

MMV

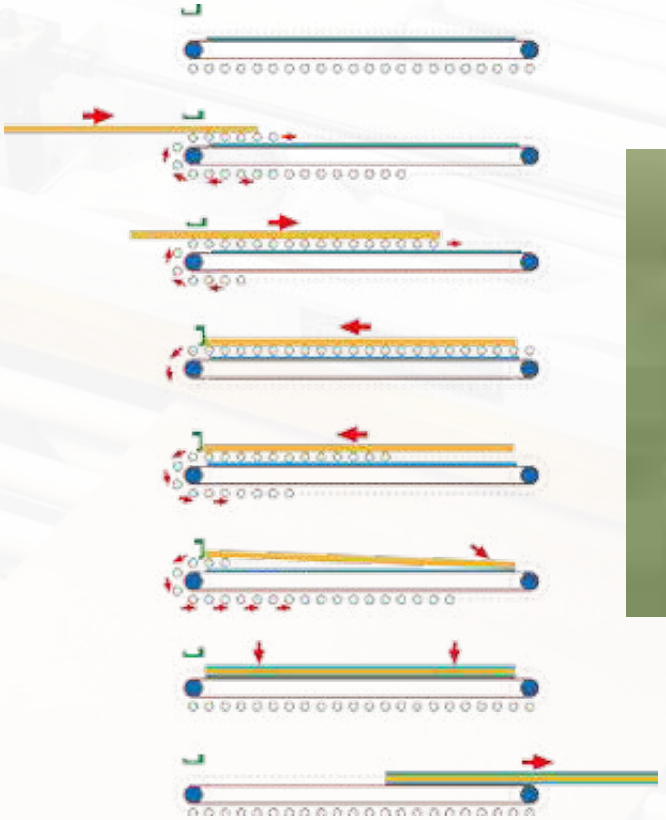
EN-4

Semi-automatic metallic panel gluing and laminating line composed of a brush cleaning machine, an infeed table with a deionisation barrier, primer application module, IR screen, hot melt glue spreader (singlesided), a pressing calander with foil unwinding station, an indexing table, a pressing calander with foil unwinding station and an outfeed table.

MMV

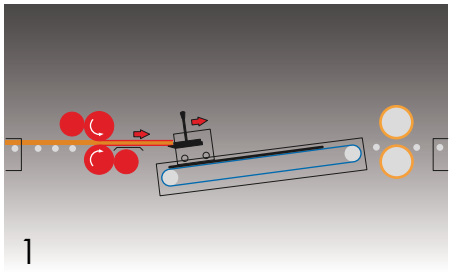
ITD

CAL

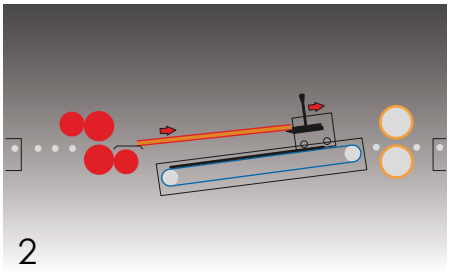


LSE-2

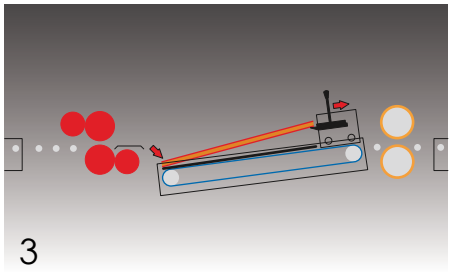
The semi-automatic panel gluing lines are composed of brush cleaning machine, deionizer table, primer table, table with lamps IR for preheating, hot melt glue spreader (double sided), pressing calender, working station composed of table, indexing station, transversal trolley for panel movement, pressing calender, outfeed table.
The table lowers so that the trolley can take the head of the double sided glued panel and place it on the lower laminate that is already on the table.
The table has a lateral motorised movement in order to be able to work on the line with a centred workpiece.



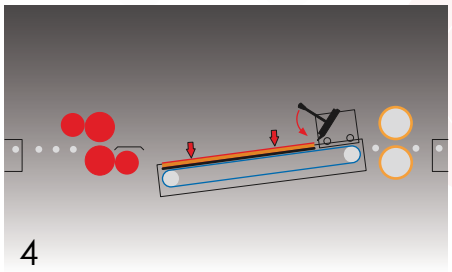
The table lowers so that the trolley can take the head of the double sided glued panel.



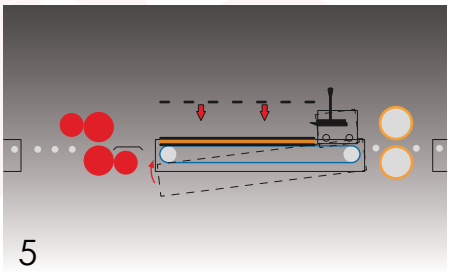
The trolley brings the double sided glued panel over the lower laminate, which is placed on the table beforehand.



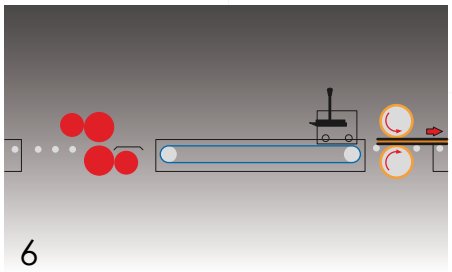
The rear head of the panel falls with accuracy on the same end of the laminate.



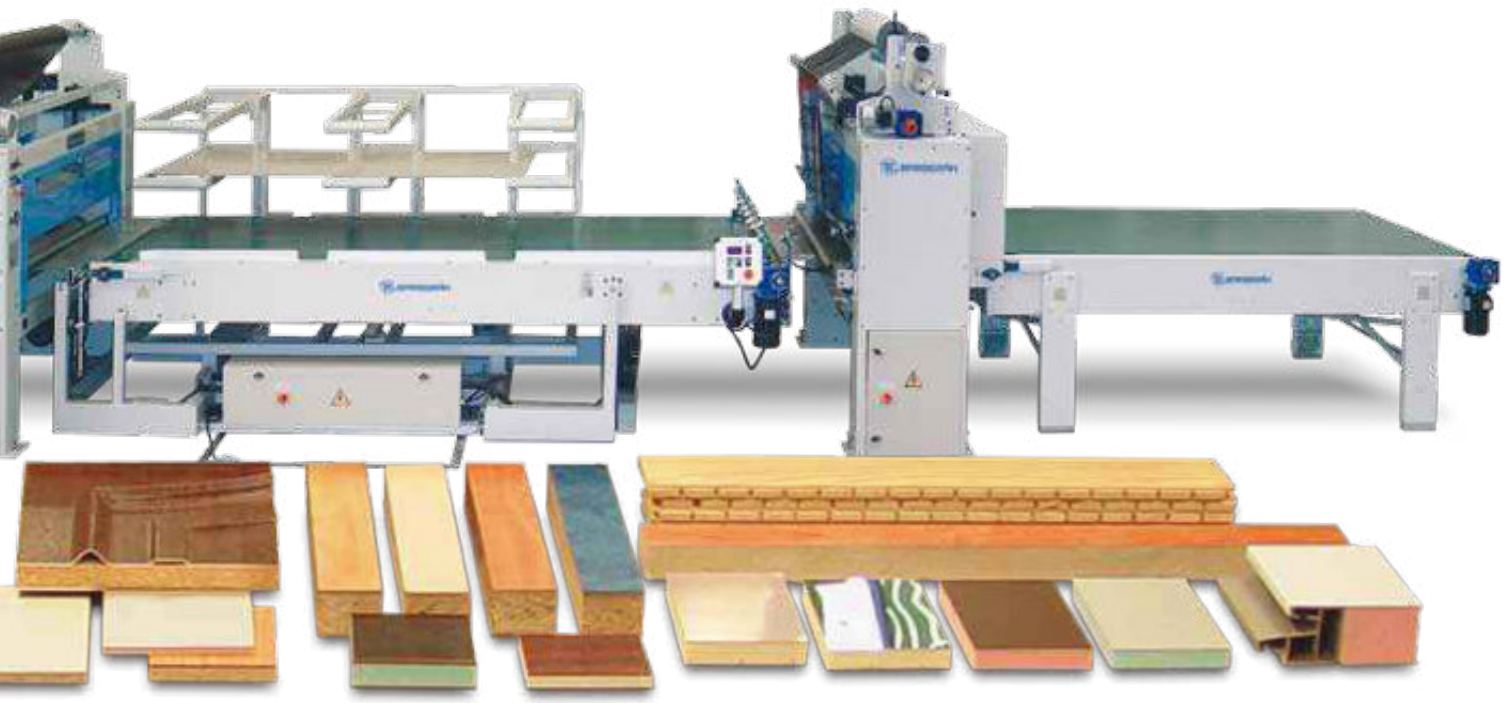
The operator releases the other end of the panel and it falls on the lower laminate.



The table is lifted up and the laminate stocking rack unit comes nearer to the operator in order to place the laminate on the upper face of the panel.



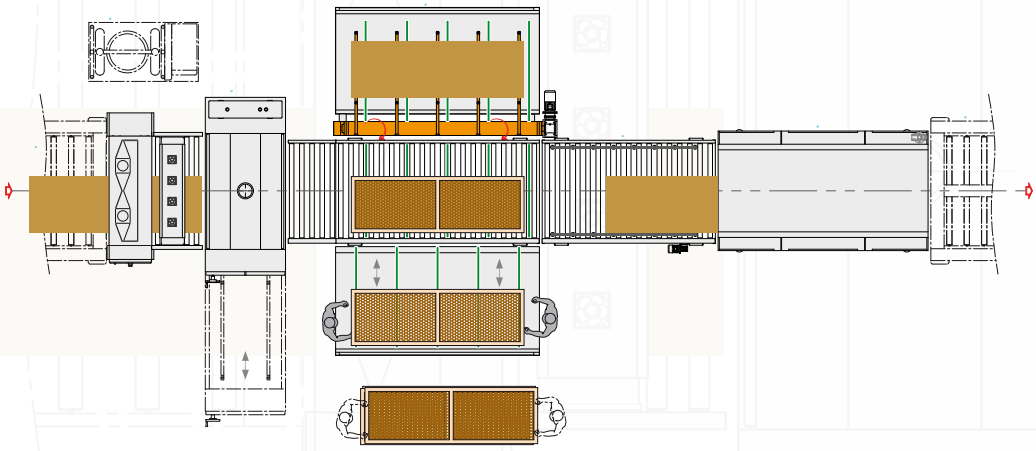
Once the operator has positioned the laminate onto the panel, it moves forward to be pressed by the calander.



Gluing line for honeycomb doors

LSE-5

Installation for the assembly of doors with honeycomb consisting of a door skin infeed table, a PUR glue spreader that applies glue on top of the skins, a transport system that transfers alternating glued skins to the right, where the table for door frame manual positioning is placed, and to the left, where a table with a suction cup turning device is placed to put the glued skin onto the frame once it is mounted on the bottom skin - it works on two levels: the first level is used for the distribution of the skins and the second one is used for the final placement of the upper skin onto the frame - and finally a press, that retains the assembled door for a few seconds before it is fed out of the line.

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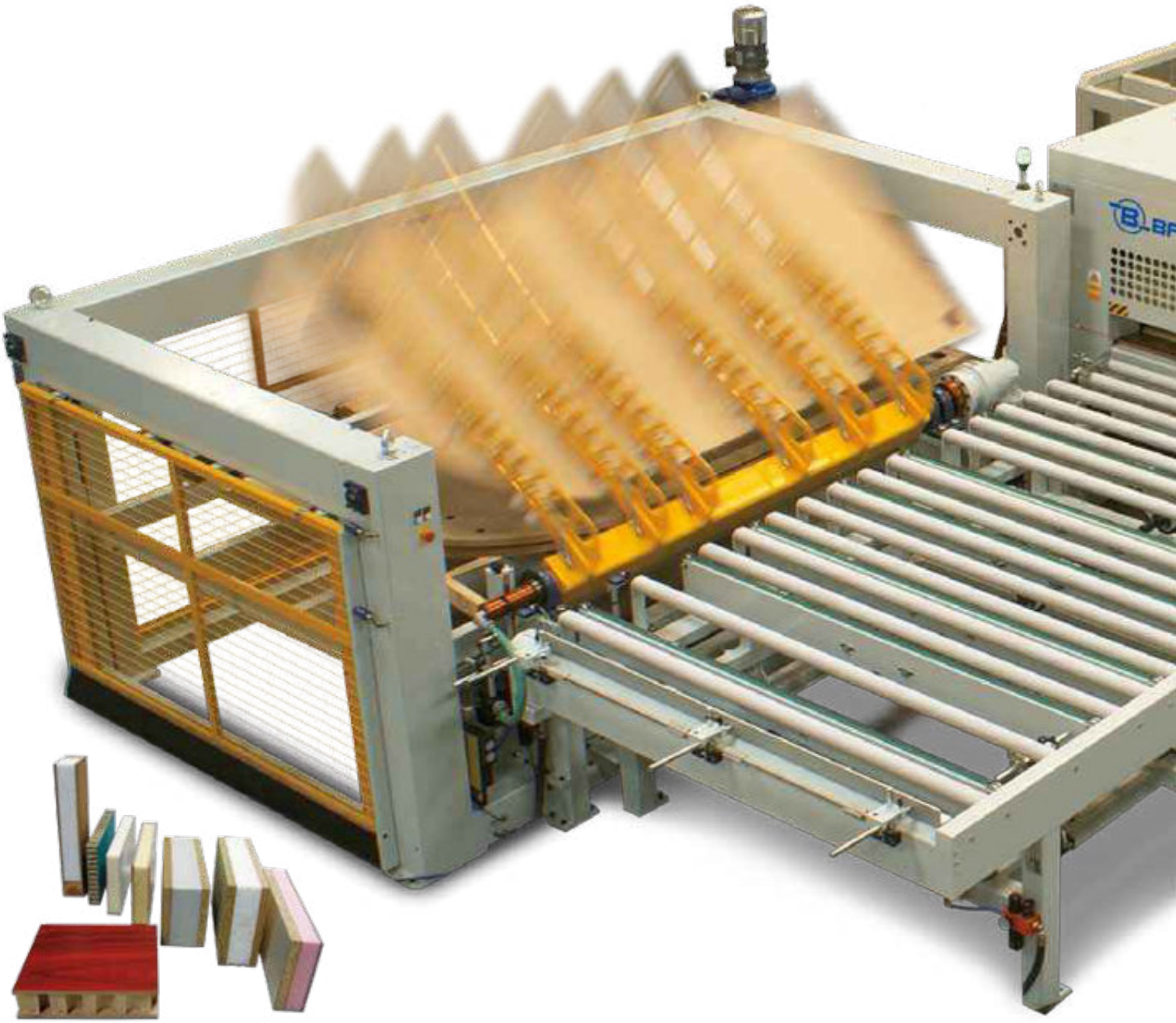
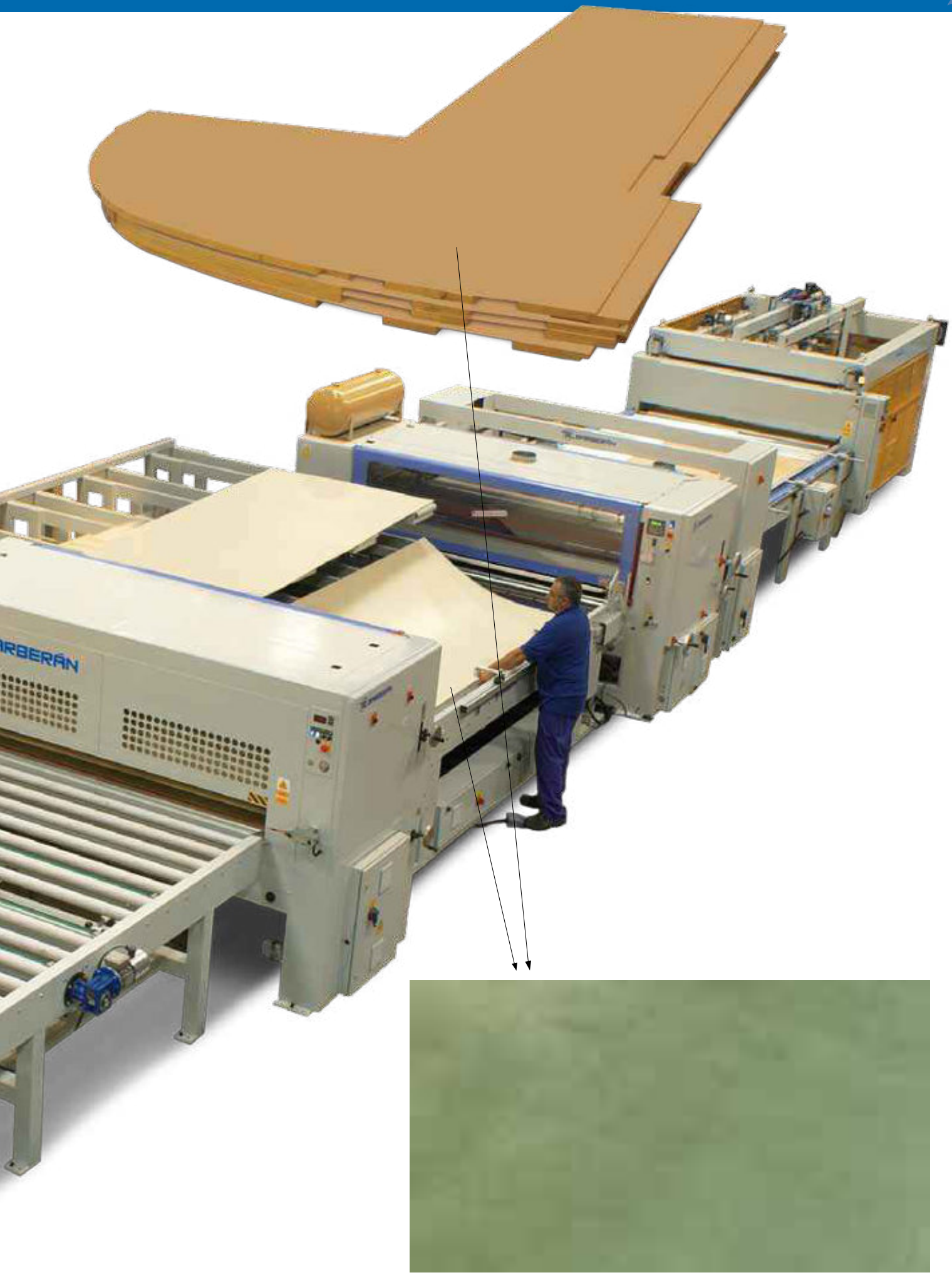
Gluing line for heavy panels

LSE-6

Indexing line for large heavy panels consisting of a suction cup panel feeder, a conveyor table, a brushing machine, an infra-red lamp zone IR lamp for panel preheating, a PUR glue spreader for the application of glue onto both sides of the panel, an indexing table for panel top and bottom side, a pressing calender, an outfeed table with a suction cup turning device and a panel stacking area.

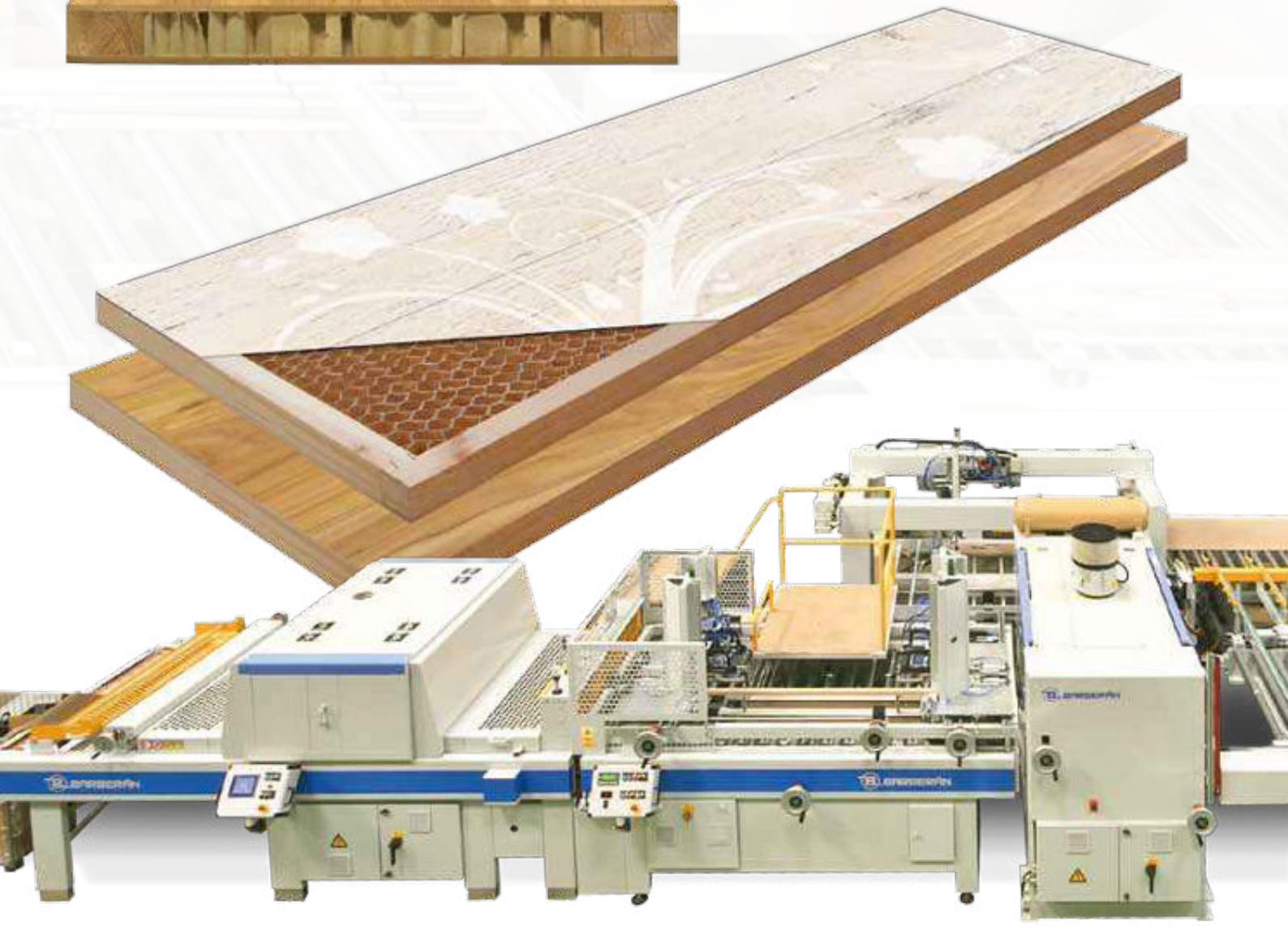




Honeycomb door gluing lines

LAE-1

Automatic line for manufacturing honeycomb doors. The line is composed of one module for expanding honeycomb doors, one frame assembling station, one skin feeder, two tables for positioning the upper and lower skin, one belt press and an unloading station for the finished doors. The maximum speed of the line is 6 doors per minute.



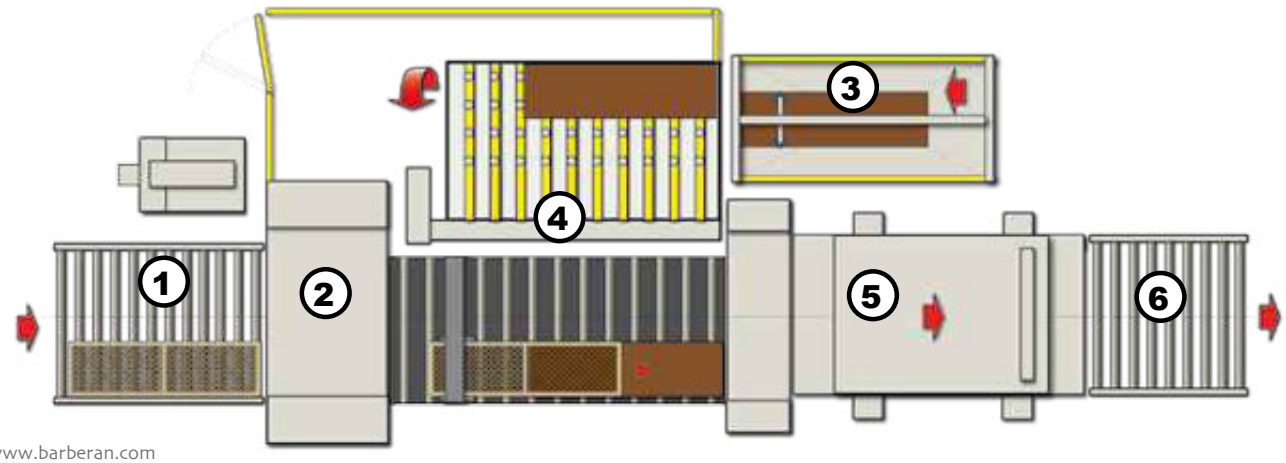
Honeycomb door gluing lines

LAE-2

The automatic door assembly installation is composed of:

1) Infeed table
2) Hotmelt glue spreader
3) Automatic front plate feeder with scisor lift
4) Panel indexing station composed of:
   -Infeed table.
   -Transversal shifting belts for lower front plate.
   -Turning device for front plates to place the upper piece.
   -Panel holding chariot.
   -Panel indexing table.
5) Pressing calender.
6) Outfeed table.

The automatic station give the signal to the feeder. The lower panel will enter the station. Once there, the tranversal shifting belts bring it to the indexing table. The automatic station gives the order to feed in one core. At the glue spreader's outfeed, the chariot takes the core and forward it to be placed upon the lower front panel. Thge chariot leaves to go to the initial position. The turning device places the front panel upon the lower panel. Once the panels are together the are forwarded to the calender to be pressed. Finally the cyclus starts again.

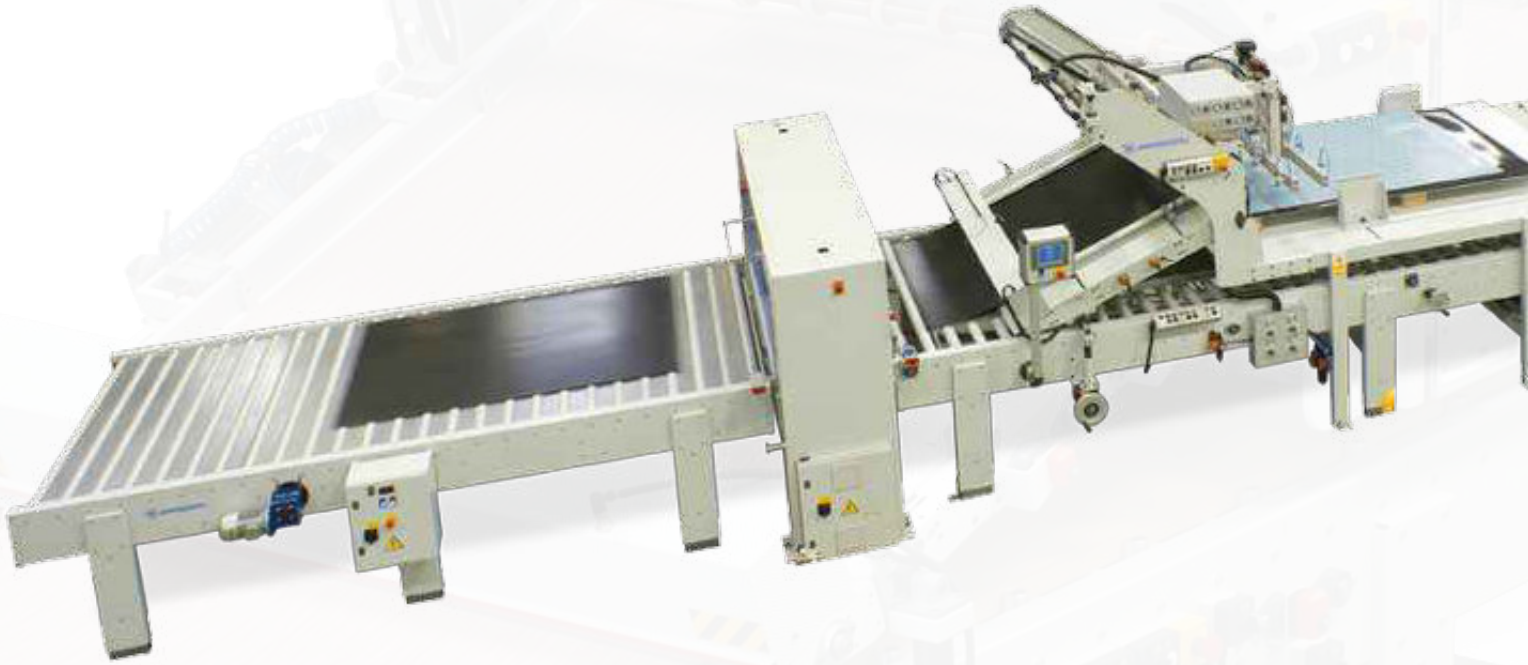


Maximum 240 doors per hour

ITL

AUTOMATIC INDEXING STATION

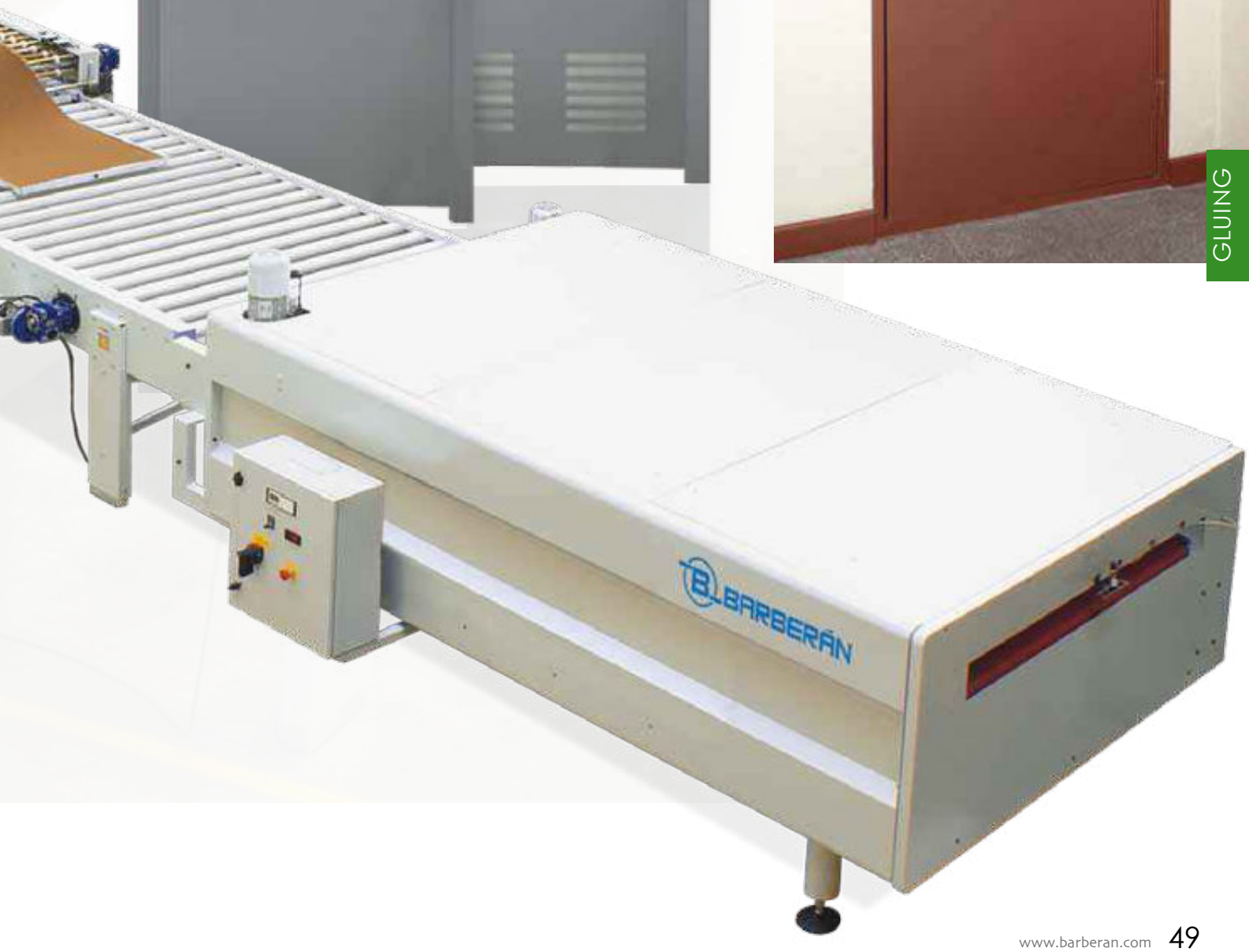
This station is composed of a belt conveyor for the panels, a laminate sheet feeder with suction pad feeding system, a manually height adjustable ramp and motorized guides for the laminate width adjustment. Synchronized indexing of the laminate on the panel's surface, which has been previously glued with a glue spreader. A nip roller presses the laminate against the panel afterwards.



Honeycomb door gluing line

LAN-1

Línea automática para el estirado, encolado y prensado del nido de abeja.
Automatic line for honeycomb expanding, gluing and pressing.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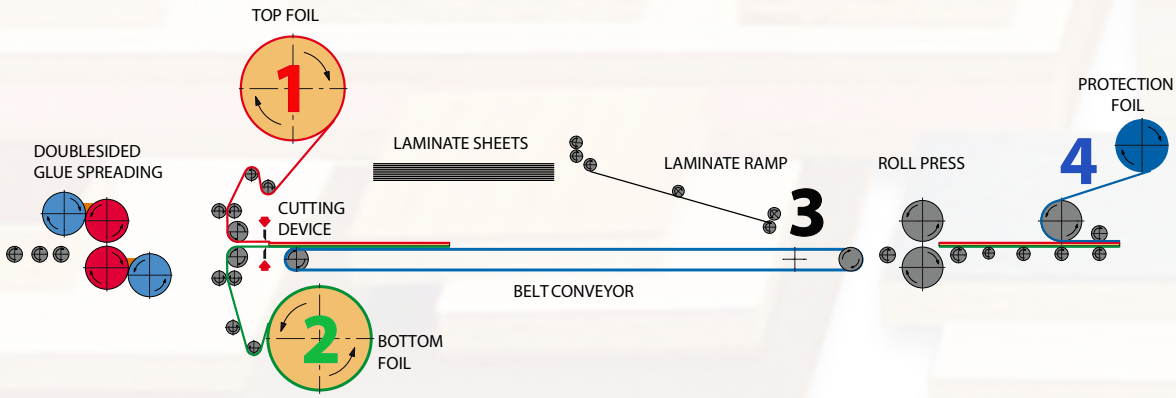
PUR Hotmelt laminating system

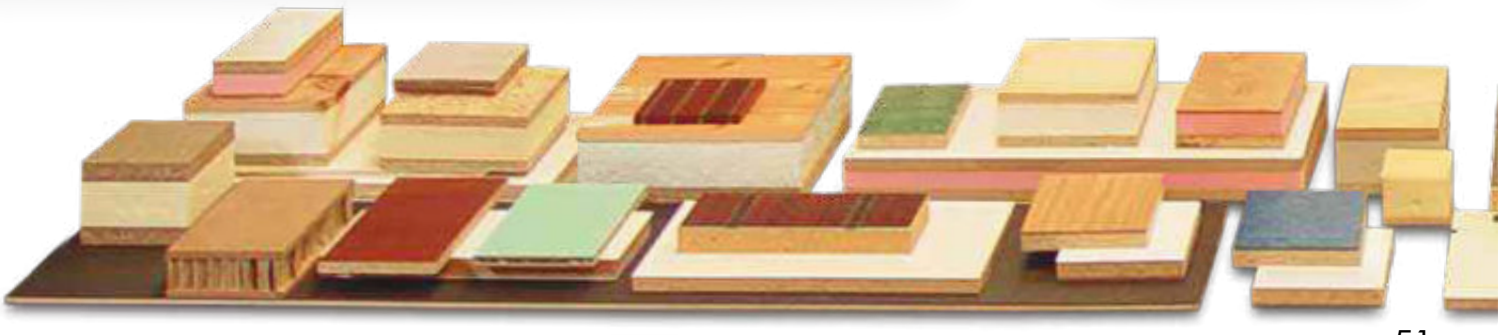
ITL-2

Laminating line model ITL2 for the doublesided application of paper foil or PVC foil, low pressure laminates and singlesided application of High pressure laminate sheets on boards made of particleboard or MDF.
The line applies PUR hotmelt glue on one or both sides of the panel by roller and is equipped with a protection film application machine at the outfeed.

POSSIBILITIES

Paper or PVC foil on top	1	
Paper or PVC foil on top and bottom	1 2	
HPL on top	3	
HPL and protection foil on top	3 4	
HPL on top and foil on bottom	3 2	
HPL and protection foil on top and foil on bottom	3 2 4	





Hotmelt laminating machine

LC-1400

The laminating machine model LC has been specially developed to replace urea formaldehyde (UF) glues for hotmelt glues.

Characteristics:
- Glue application head that allows to work applying low glue quantities (30 gr/sqm) distributed perfectly along the board's surface. It applies not only polyolefine (PO, APAO) hotmelt glues but also the brand new polypropylene (PP) glues.

- Board separation cutting system which does not generate any type of waste. No gap between boards is necessary. The innovative high precision self-sharpening knife performs the cut with extreme accuracy between the boards fed in butt to butt.

- Foil tracking system that almost eliminates the foil surplus at the production start.

ecoating®
technology

Roll diam. / Diam. bobina .....max. 600 mm
Roll width / Ancho bobina .....max. 1300 mm
Board width / Ancho panel .....max. 1250 mm
Board length / Longitud panel .....min. 1200 mm
Appl. temp. /Temp. aplic .....max. 210 ºC
Speed / Velocidad .....5-30 m/min

Feeding and stacking systems

AP

AUTOMATIC BOARD FEEDER

It is composed of a motorized lift table and a motorized longitudinal loader. The lift table raises until it detects the upper board. The lift table stops. The pneumatic loader pushes the board to the first conveyor table of the line and returns to the start position allowing the raising of the lift table to load a new board. The process is full automatic. Platform of the lift for board loading. Centralized manipulation from the control board. Protection fence incorporated. When opening the access gates, the whole system stops as per EC standards.

APD

AUTOMATIC THIN BOARD FEEDER

It is composed of a motorized lift table, a longitudinal pneumatic loading device with suction cups and a group of driven introduction rollers. The lift table raises until the loading device detects the upper board. The lift table stops. The suction cups raise the board and insert him in the driven introduction rollers. They load the board at the first conveyor table of the line. The feeding rhythm is adjusted from the control board. Protection fence incorporated. When opening the access gates, the whole system stops as per EC standards.

DPD

AUTOMATIC THIN BOARD STACKER

It is composed of a lift table with 2 pneumatic adjustable centring devices and pass detector for the motorized descend of the table, board by board. A pinch roller placed upon the last driving roller of the prior table introduces the board in the lift table. The centring devices act automatically before the board is stopped. Incorporated protection fence and photocell barrier.

When opening the access gates, the whole system stops as per EC standards. Unloading from the platform through forklift. Centralized adjustments from control board.

ATT

AUTOMATIC SCISSOR STACKER FOR BOARDS

It is composed of a scissor lift table with adjustable guides including a photocell with reflector to level the table and board detector to start the motorized lowering of the table, board by board. A pinch roller placed on the last driving roller of the table before introduces the boards fully inside the lift table. Table of the raising device with driving rollers to unload the pile with boards.

Examples of panel gluing lines

LAE-5

LSE-3

LAE-3

EN-4-PU

ENS-PUR

Panel wrapping machine

PUR-101-L-C

Machine with conveyor chains, designed for the gluing and application of rolled material on panels, made of MDF, particleboard, low quality wood, etc. (optionally PVC and/or aluminium), by means of a slot nozzle for PUR or EVA hot melt glue.

Rubber chain conveyor

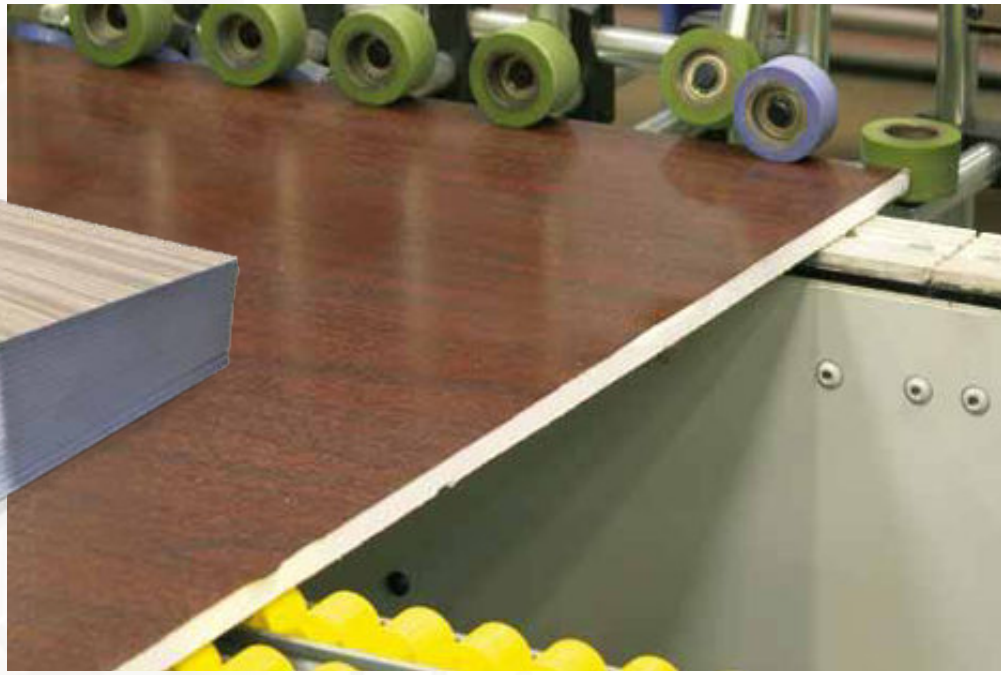

BARBERÁN

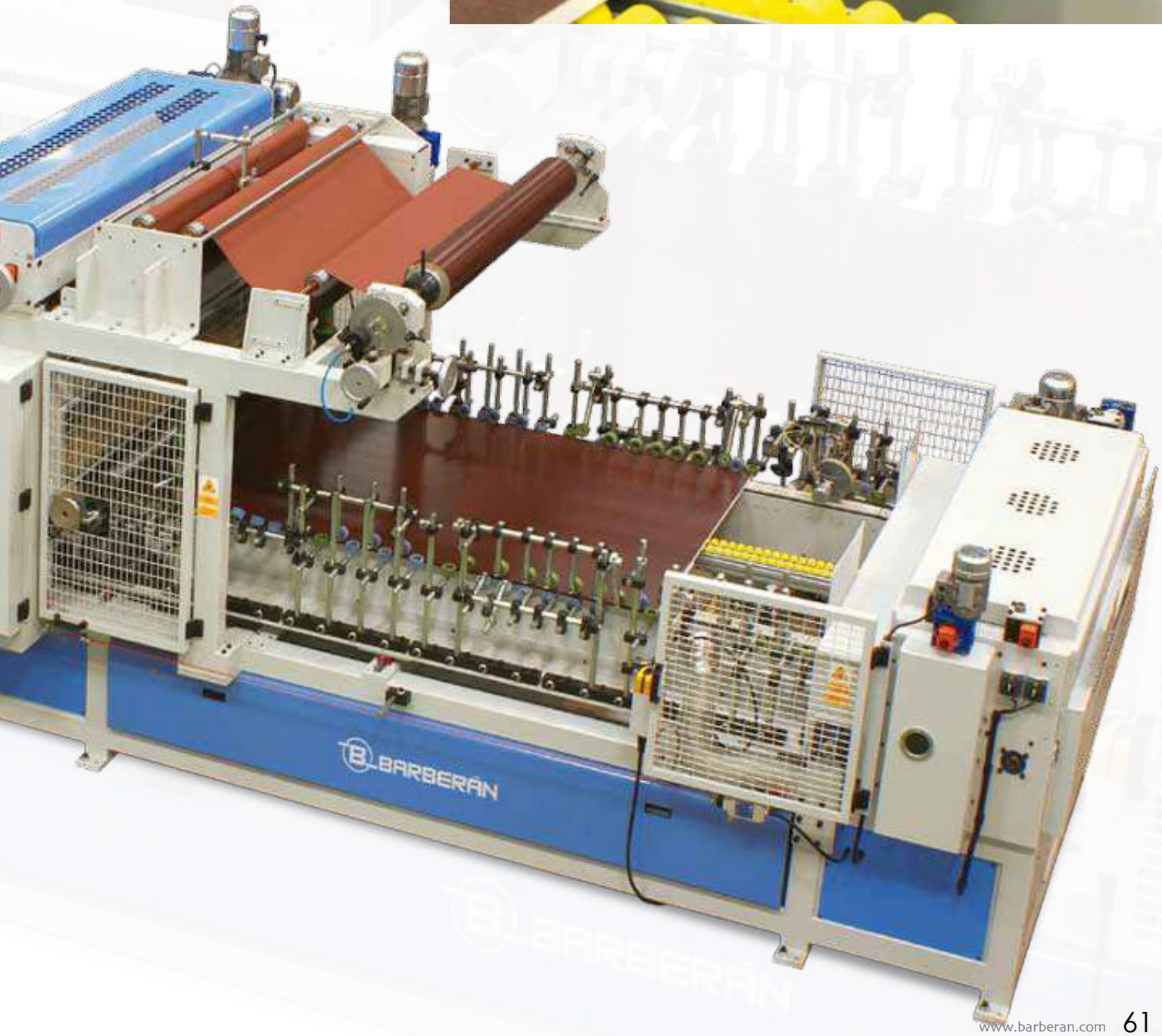
Lamination using PVAc glue

GYPSUM PANELS

SP-1000

Machine for laminating and postforming paper or PVC foil on **gypsum panels** previously overlayed with paper. These panels are used mainly in the indoor construction and decoration branches.

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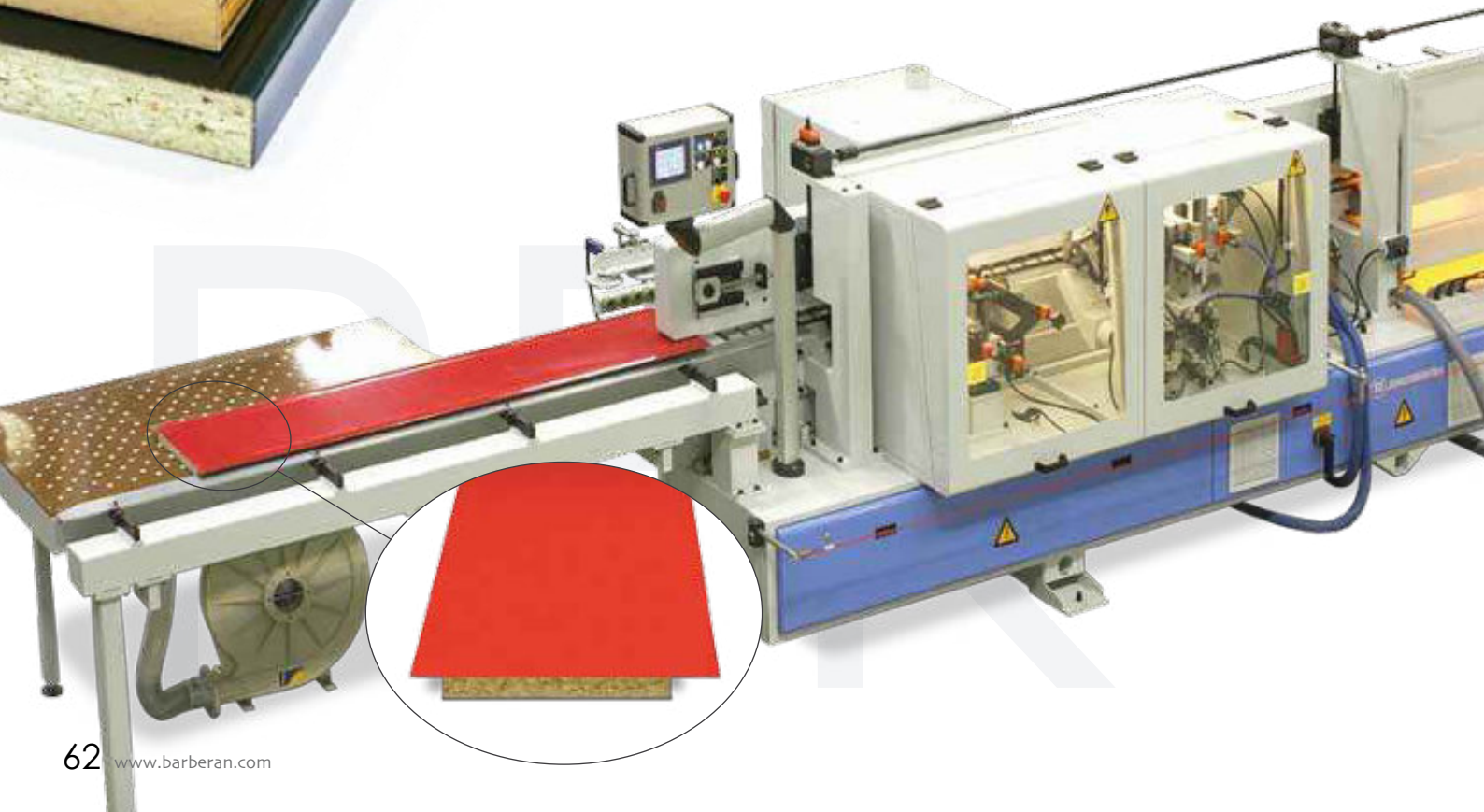
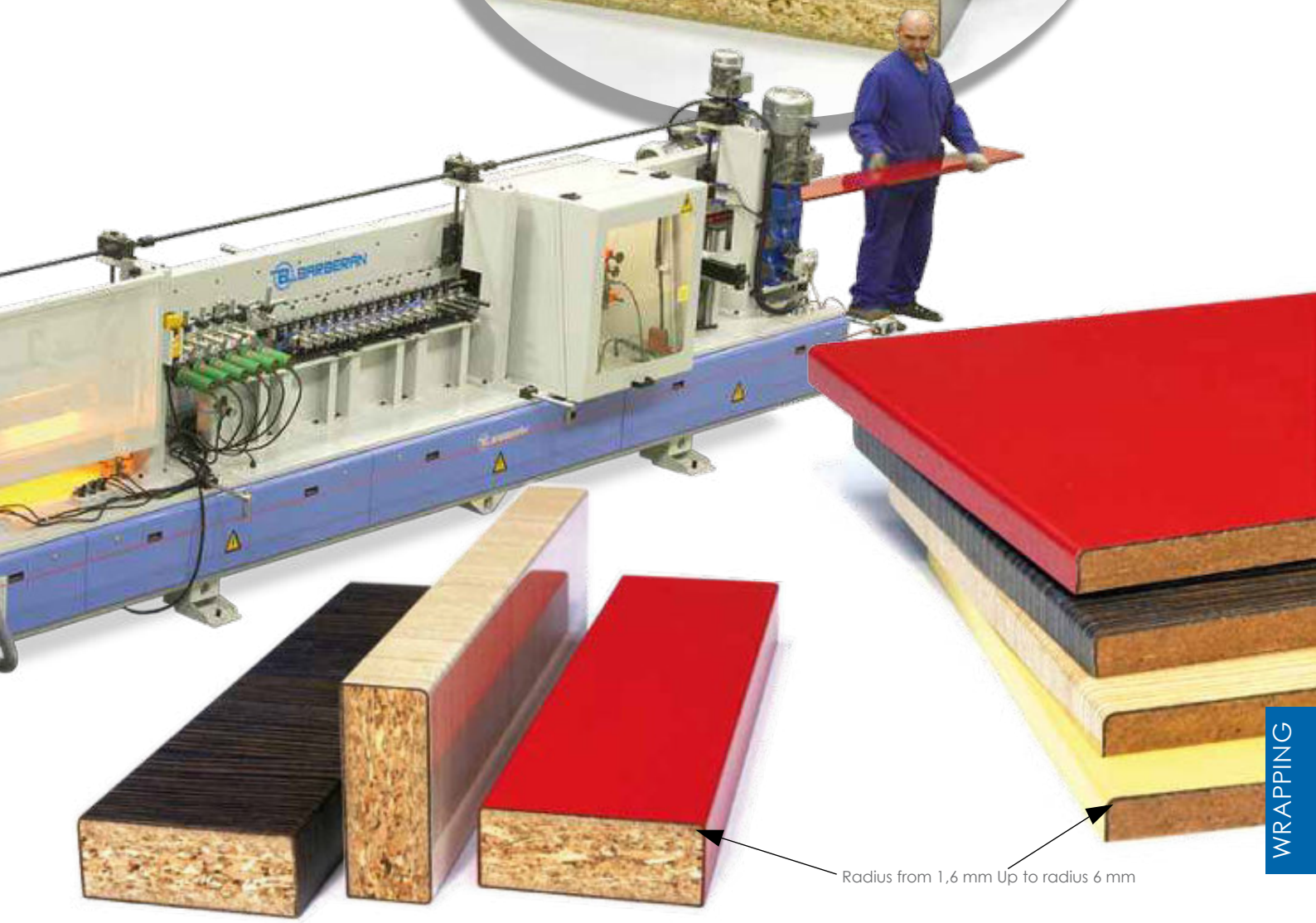
Single sided postforming machine

PFK

Machine designed to postform edges with a minimum radius of 1,6 mm and a maximum radius of 6 mm. The postforming panel must have straight, unshaped edges, and the postforming laminate already glued to the top surface.



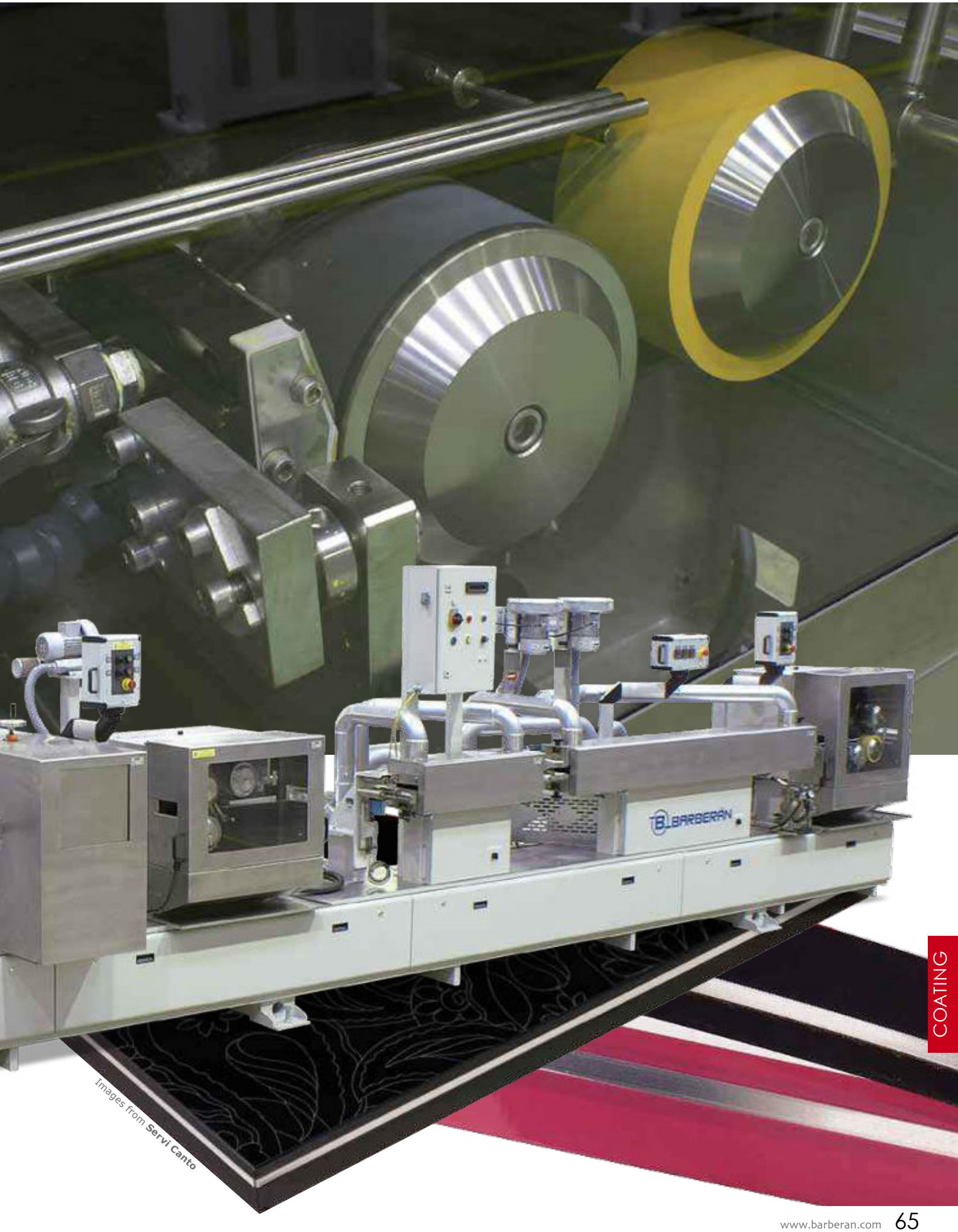

Radius from **1,6 mm** Up to radius 6 mm


Radius from 1,6 mm Up to radius 6 mm

Lacquering of edgebanding foil

MBC-150/2

Line for the application of primer and lacquer and wood grain printing through inkjet or engraved roller on PVC foils for edgebanding.

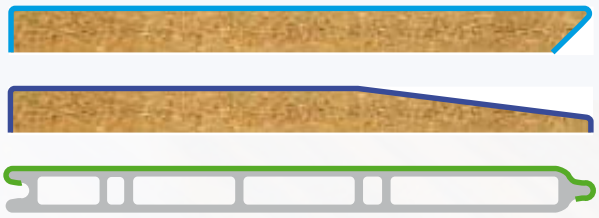


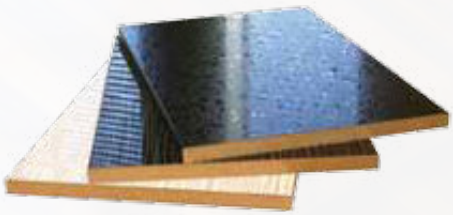
Images from **Servi Canto**

Laminadora-posformadora

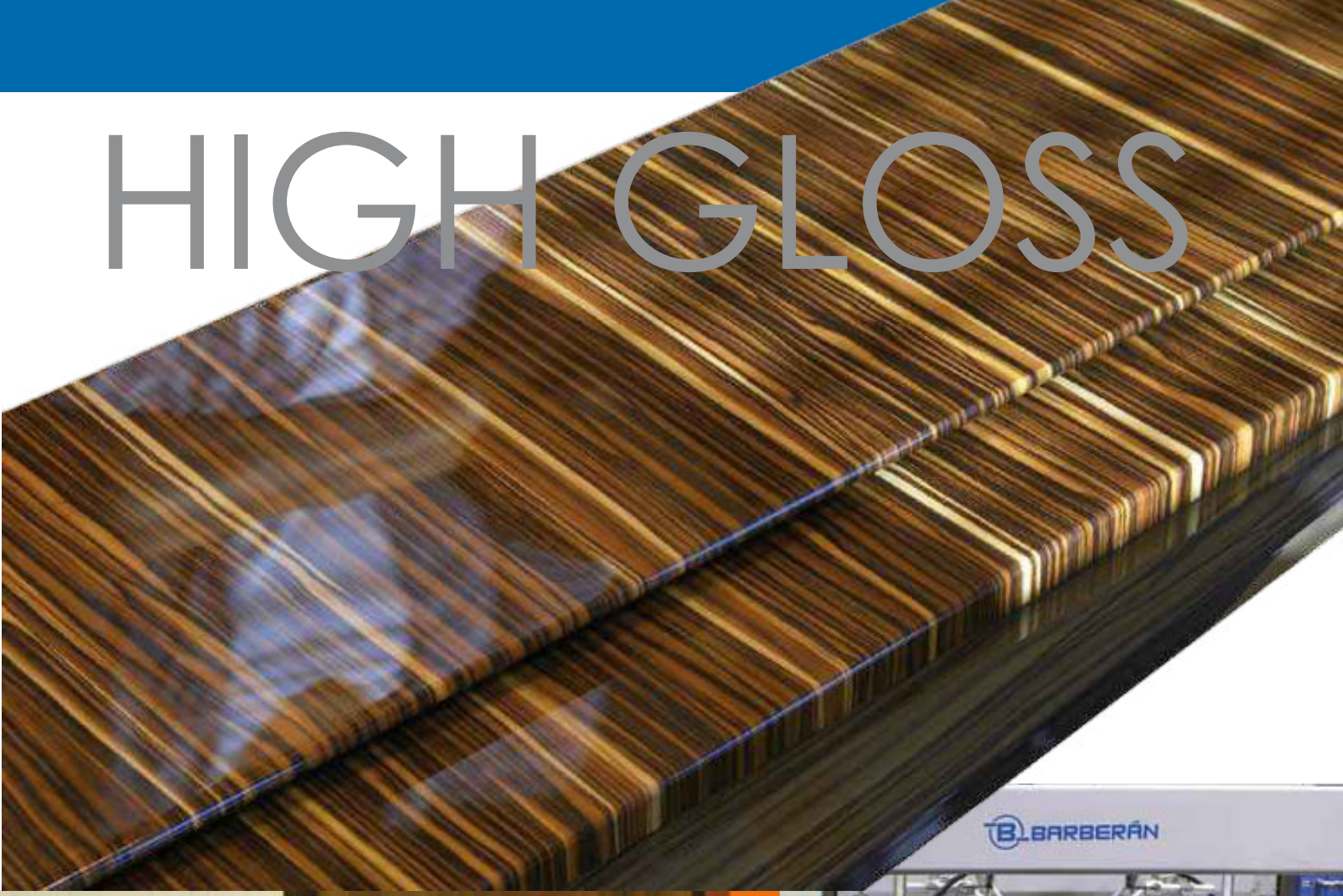
SPEED PRESS 1000
HIGH GLOSS

Laminating & postforming machine model SPEED PRESS 1000 for the application of high gloss or matt decorative foils onto the top side of panels made of particleboard or MDF and postform one or both sides. The panels can have different shapes and a maximum width of 950 mm. The machine uses PUR hotmelt glue and the speed can be adjusted from 5 up to 25 m/min.





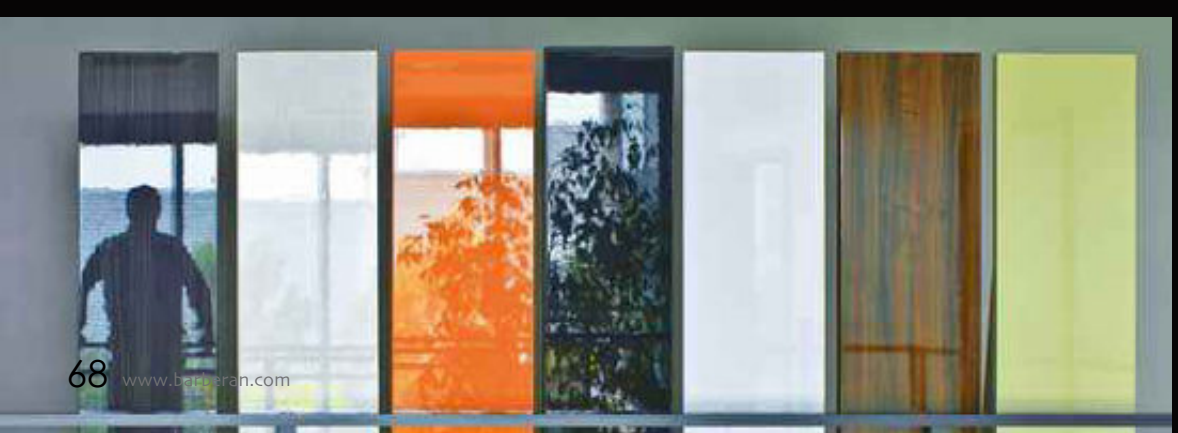
HIGH GLOSS



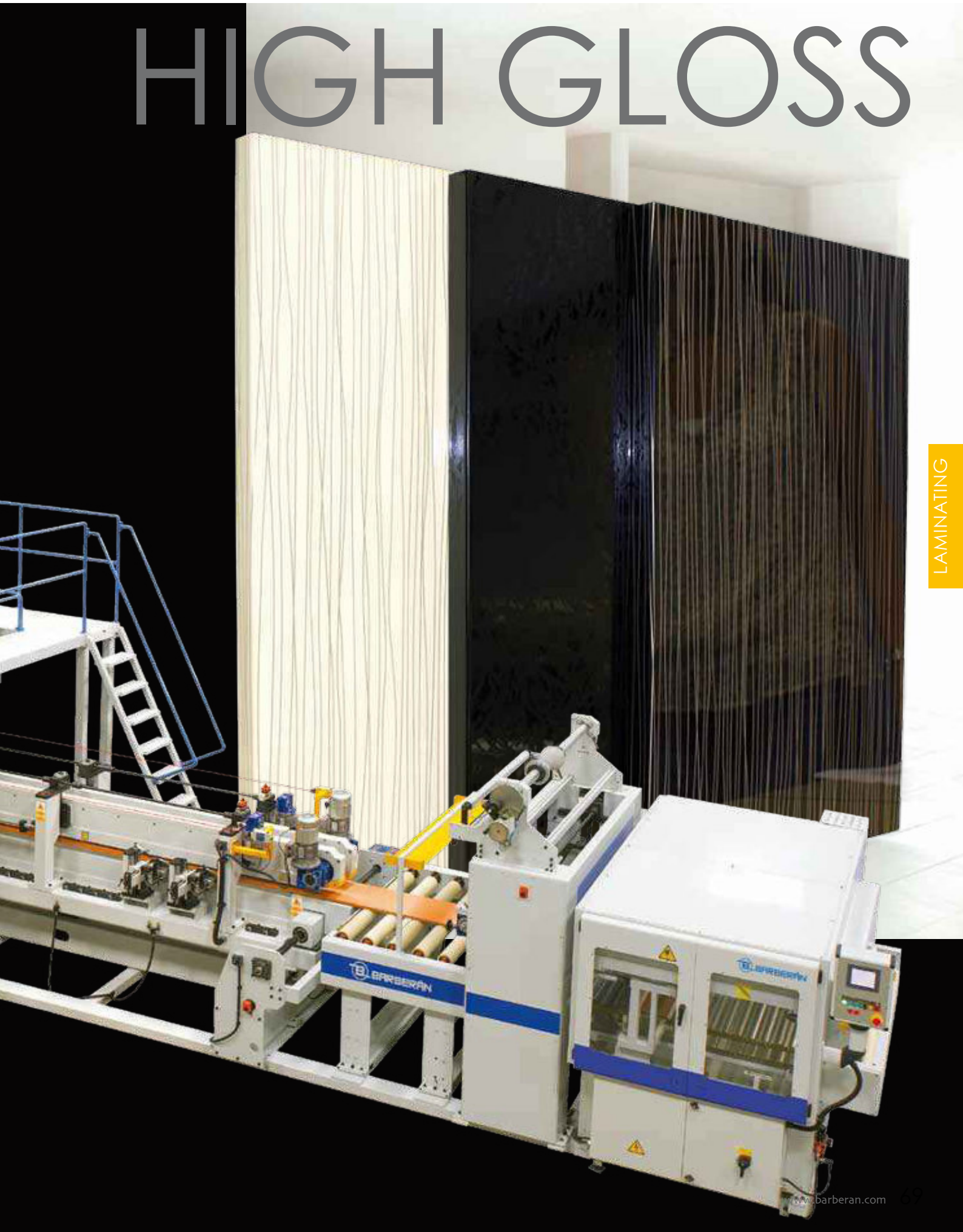
Rubber chain conveyor

HIGH GLOSS
SPEED PRESS

Double sided compact laminating & postforming machine for high gloss paper foil or PVC foil on panels using hot melt glues (EVA, PUR, etc).



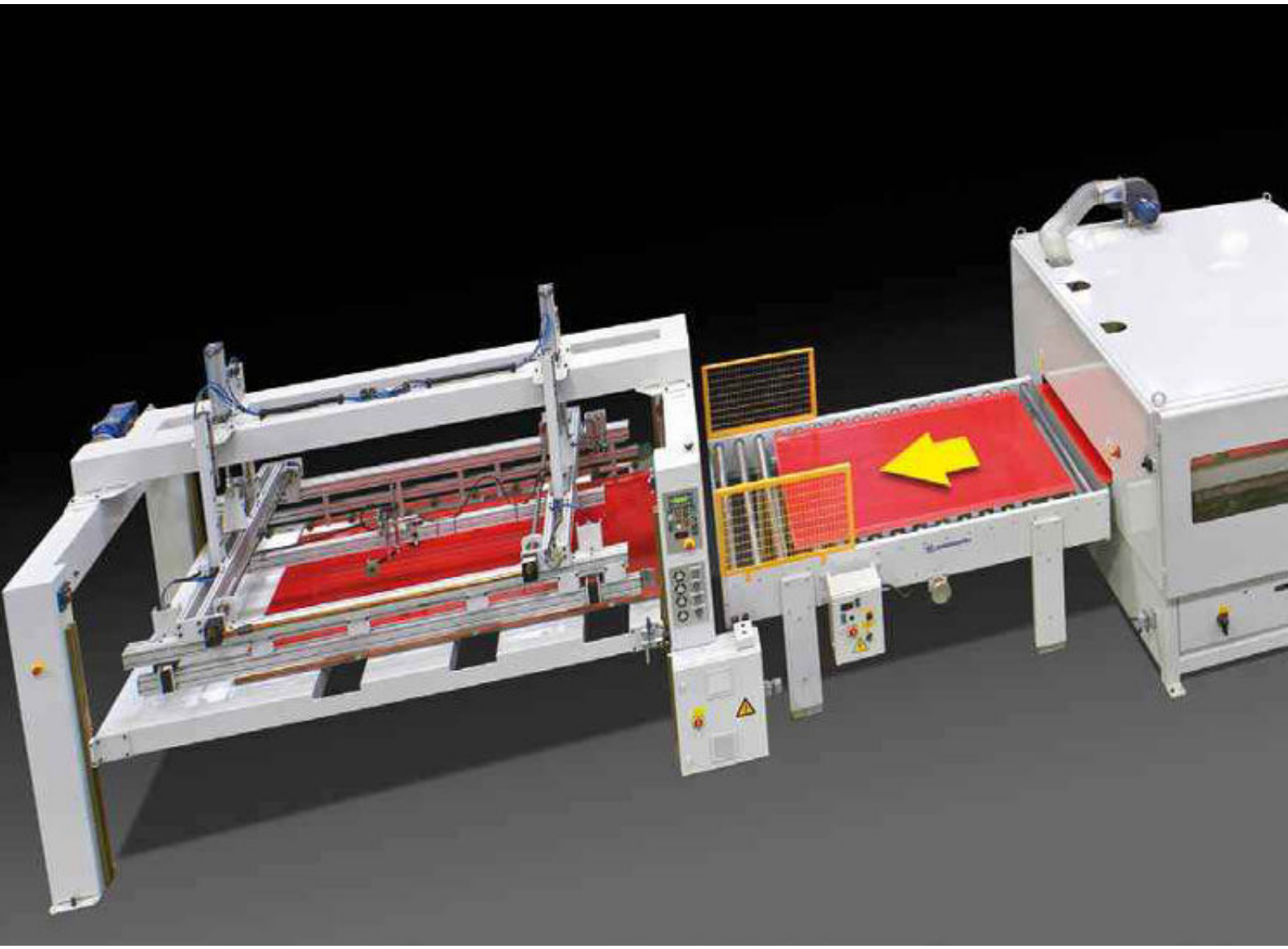
HIGH GLOSS



Laminating and postforming line

INSTALLATION FOR LAMINATING AND POSTFORMING PAPER OR PVC FOIL WITH HOTMELT GLUES

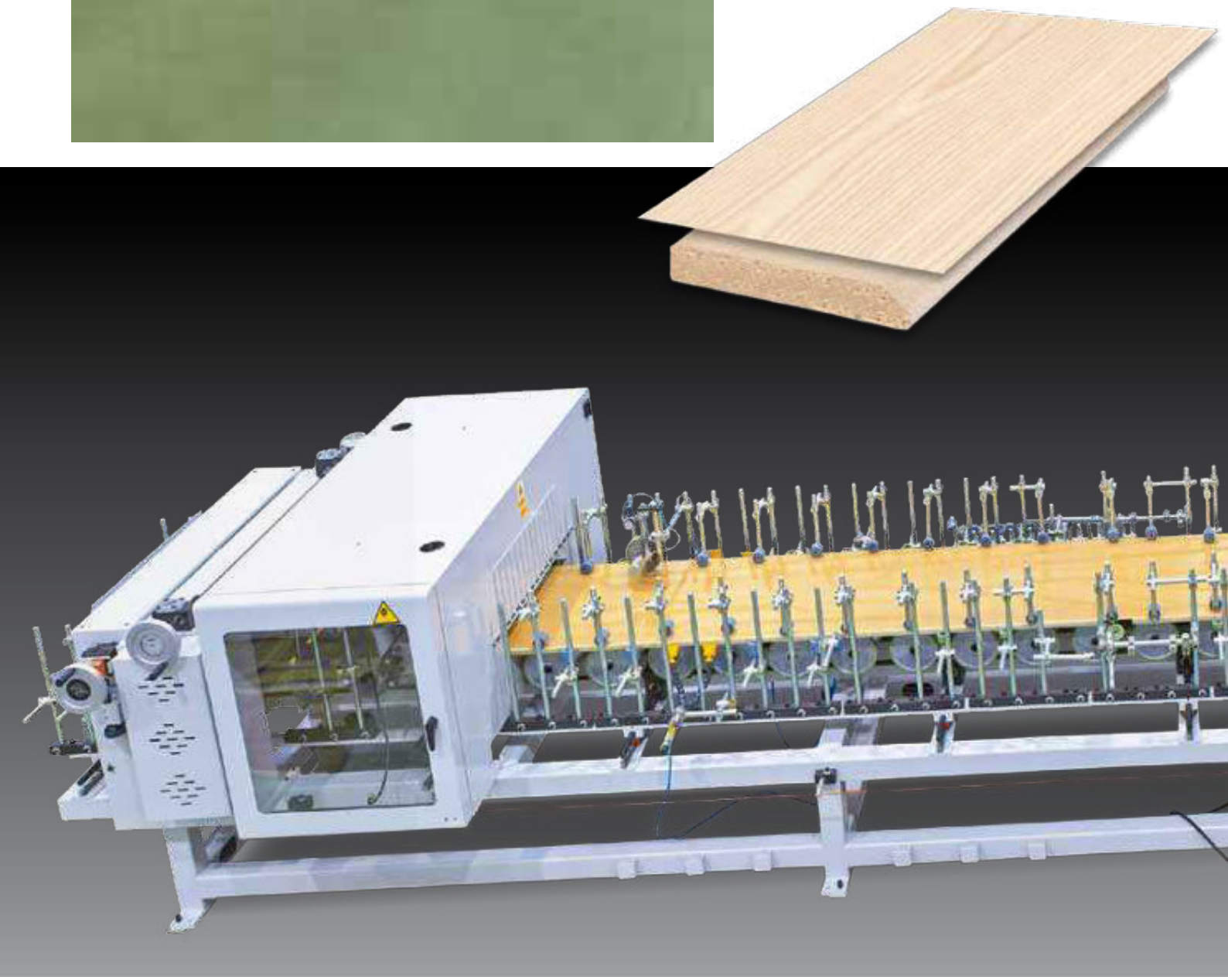
Paper and PVC foil laminating and postforming installation on panels made of particle board or MDF composed of a panel feeder with suction cups, a hotmelt glue spreader by means of slot nozzle , postforming zone with molding rollers, lateral hotmelt glue spreading guns to fill the groove where the foil ends to avoid peel offs, cutting saw for panel separation, outfeed conveyor and panel stacking device.

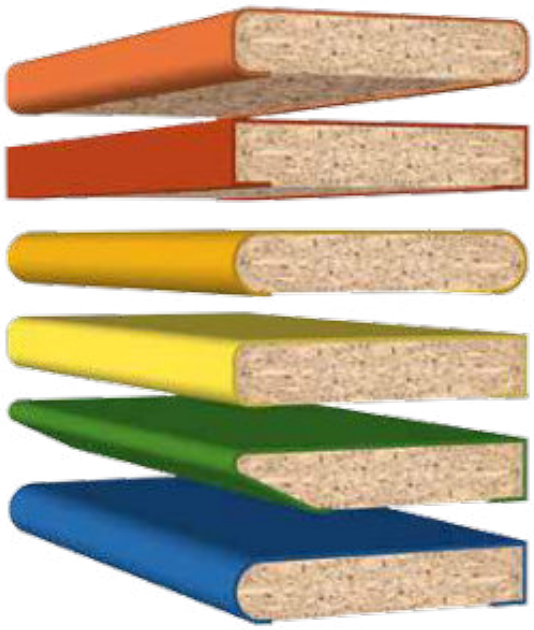


Compact laminating line

ECO PRESS-PUR

Compact laminating & postforming machine for Paper, Foils, PVC, CPL laminates, with hot melt glues (EVA, PUR, etrc) on foil.






BARBERÁN
ECO PRESS PUR

Heavy duty installations

LAMINATOR - 1400

Multi-purpose high performence laminating machine with PUR hotmelt glue spreading on the foil by means of roller and speed up to 40 m/min for the application of decorative high gloss foils from 0.15 up to 0.9 mm thickness on board's surface.

1. Double unwinding station with automatic splicing device.
2. Automatic control system for unwinding tensión.
3. Foil accumulator for automatic foil roll replacement (splicing) without decreasing the speed.
4. Corona treatment on the foil.
5. PUR glue application head for the foil.
6. Infeed conveyor table with board alignment guides.
7. Double calender and cutting device for the start and final foil surplus.
8. Laminating zone.
9. Side trimmers.
10. Board separation cutting saw with gap detection system through in-sight camera.
11. Outfeed conveyor table.
12. PUR glue melting units.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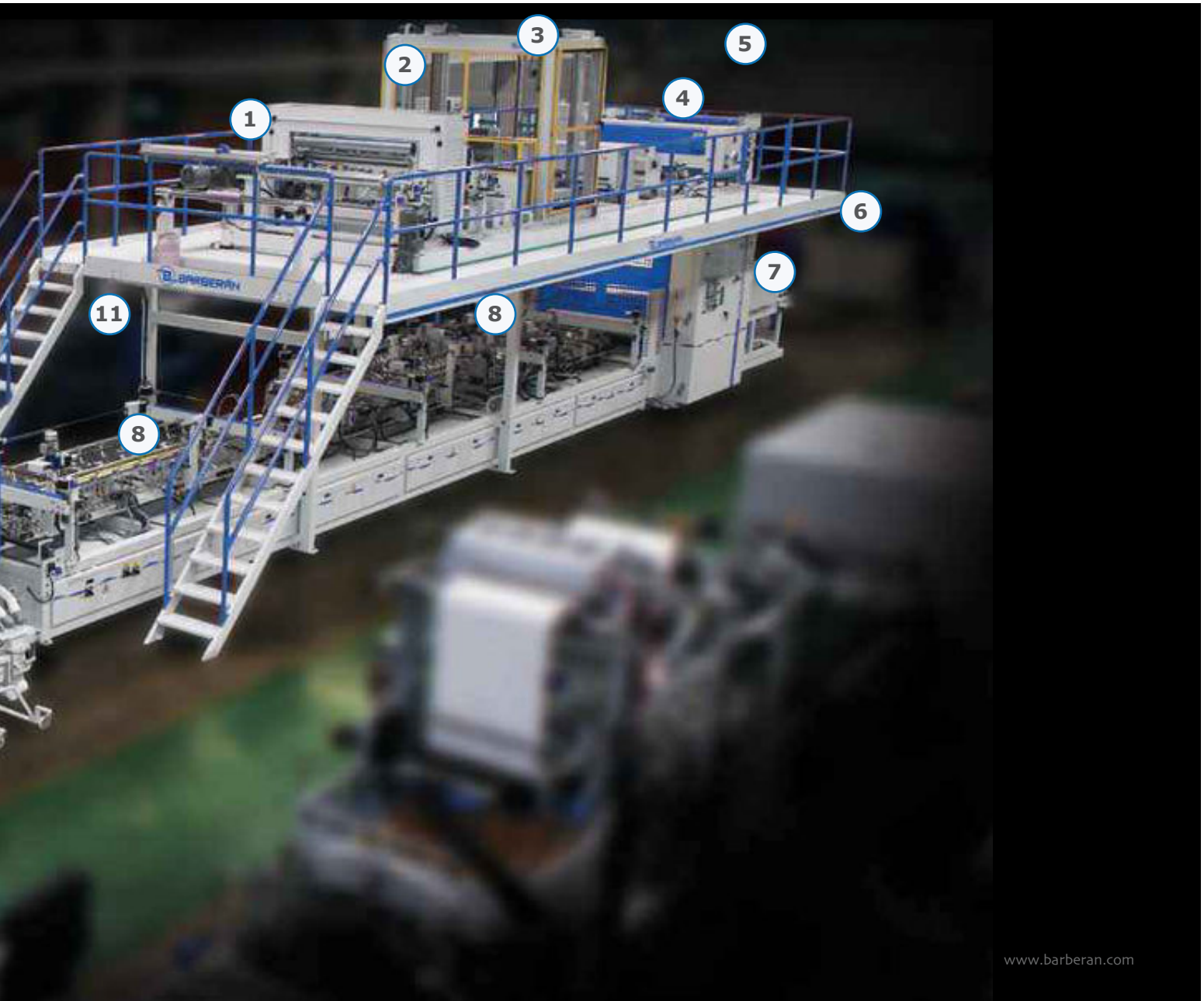
Heavy duty installations

LAMINATOR - 1400

Multi-purpose high performence laminating machine with PUR hotmelt glue spreading on the foil by means of roller and speed up to 40 m/min for the application of decorative high gloss foils from 0.15 up to 0.9 mm thickness on board's surface.

1. Double unwinding station with automatic splicing device.
2. Automatic control system for unwinding tensión.
3. Foil accumulator for automatic foil roll replacement (splicing) without decreasing the speed.
4. Corona treatment on the foil.
5. PUR glue application head for the foil.
6. Infeed conveyor table with board alignment guides.
7. Double calender and cutting device for the start and final foil surplus.
8. Laminating zone.
9. Side trimmers.
10. Board separation cutting saw with gap detection system through in-sight camera.
11. Outfeed conveyor table.
12. PUR glue melting units.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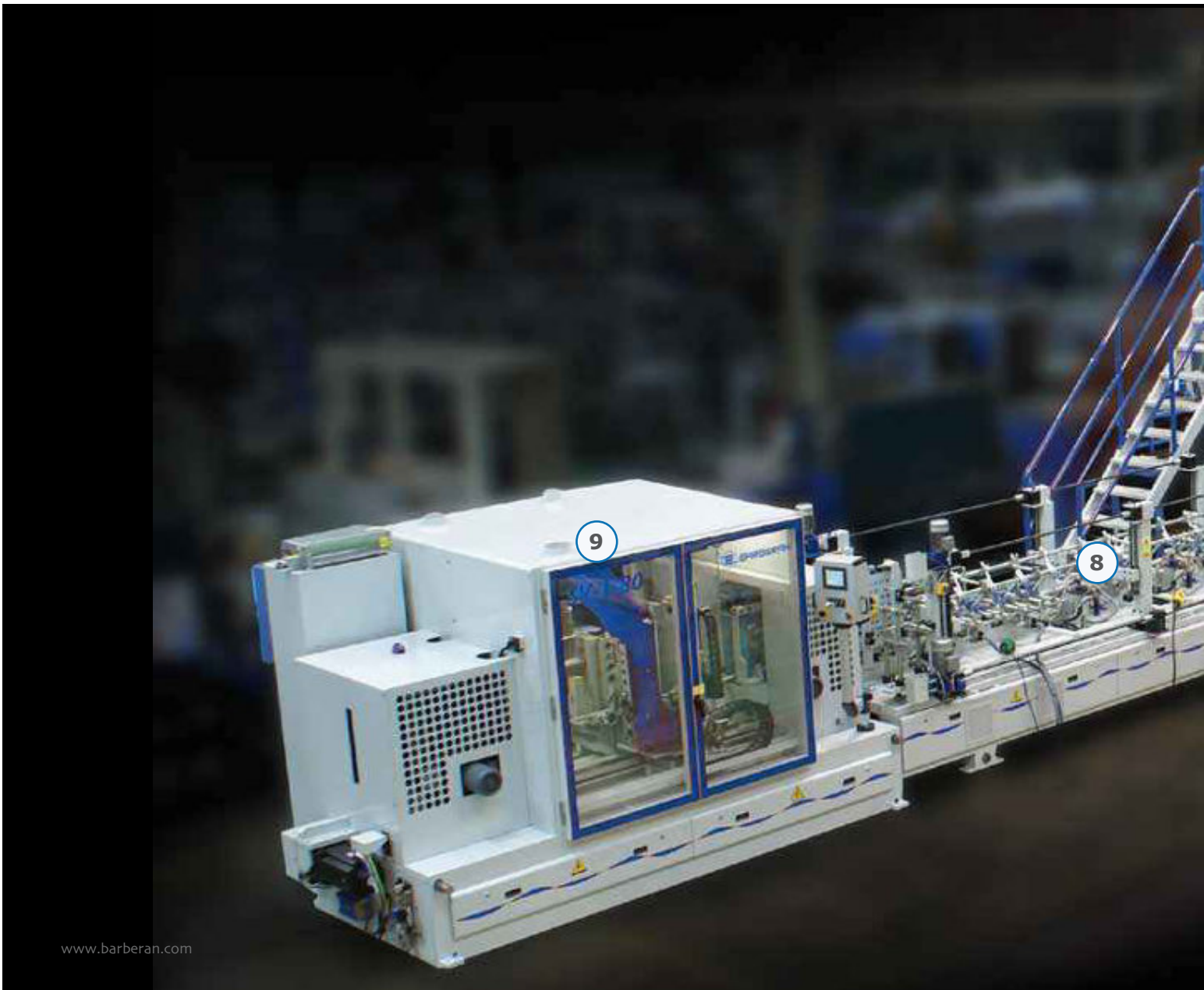
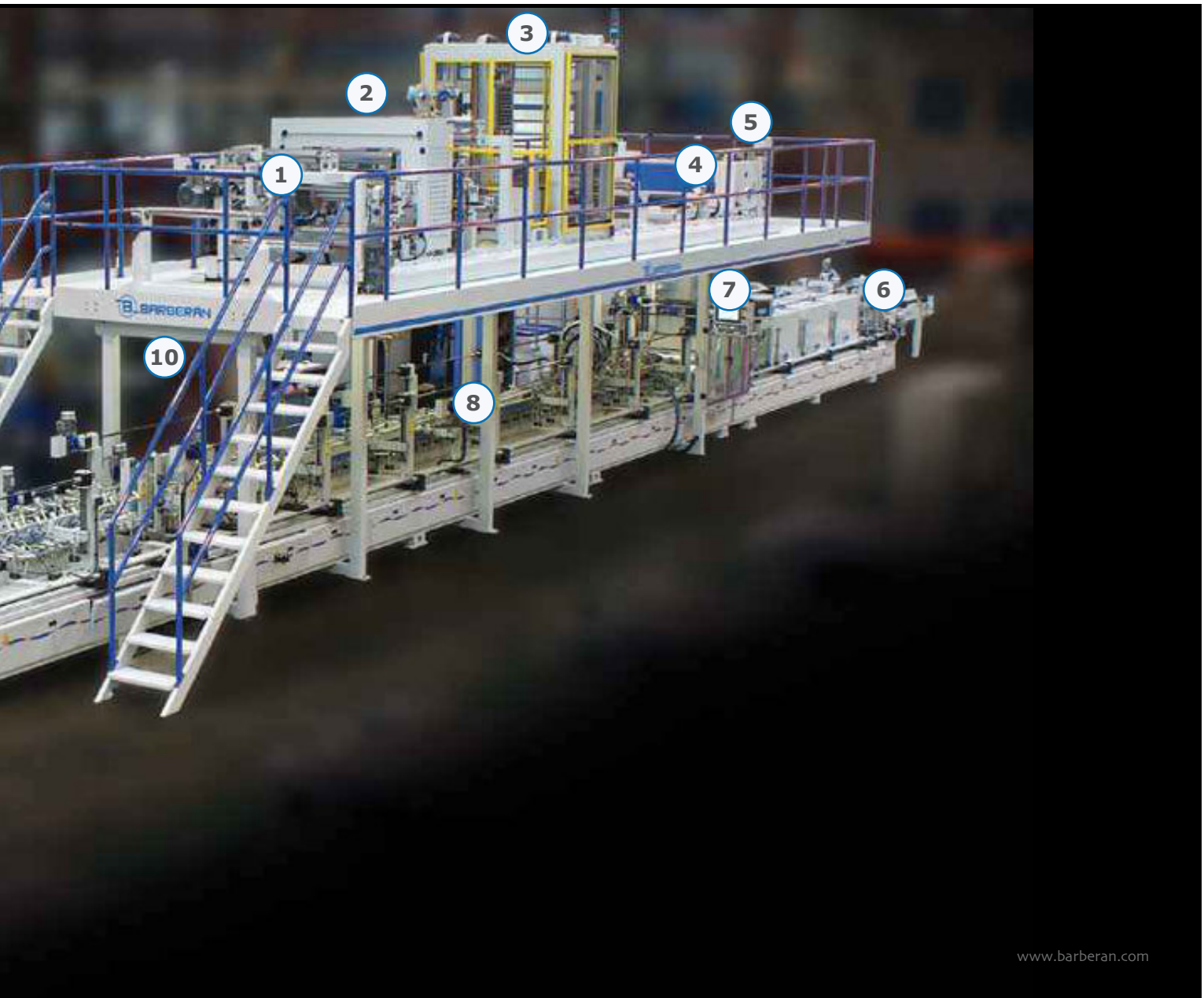
Heavy duty installations

VERTICAL BOARD WRAPPING LINE DW-80

High performace machine for wrapping drawer sides and laths in vertical position. The PUR hotmelt glue is applied by means of roller spreader on the foil. Working speed up to 70 m/min for the application of high gloss decorative foil (0.15 up to 0.40 mm thickness) all around the lath (360º wrapping).

1. Double unwinding station with automatic splicing device.
2. Automatic control system for unwinding tensión.
3. Foil accumulator for automatic foil roll replacement (splicing) without decreasing the speed.
4. Corona treatment on the foil.
5. PUR glue application head for the foil.
6. Infeed table for laths in vertical position with cleaning and heating system.
7. Double set of moulding rollers and cutting device for the start and final foil surplus.
8. Wrapping zone.
9. Board separation cutting saw with two working modes, horizontal-vertical, according to lath size and detection system through in-sight camera.
10. PUR glue melting units.

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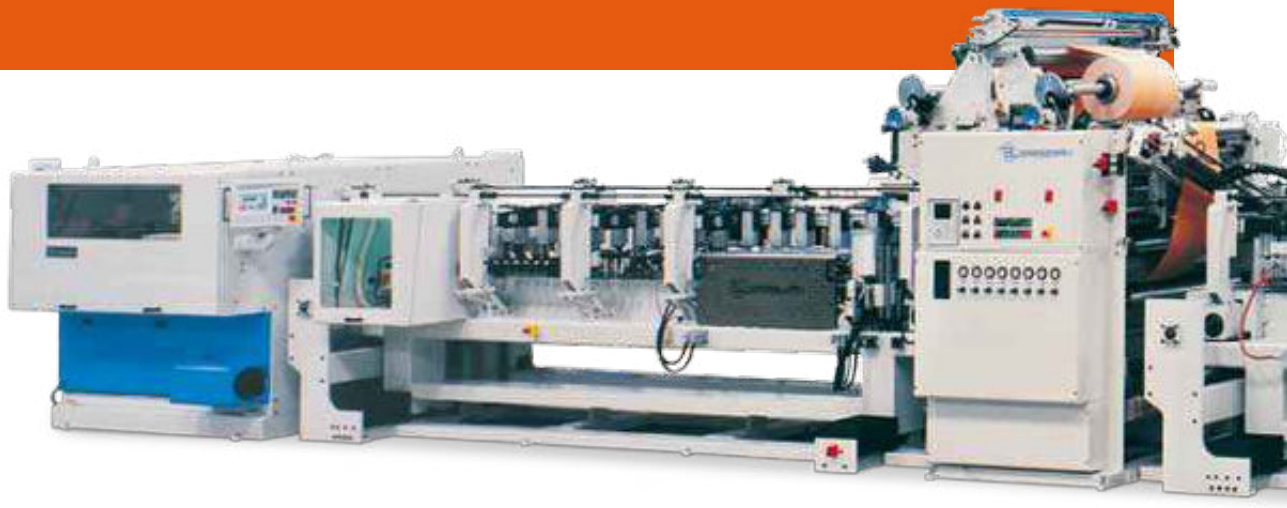
BARBERAN

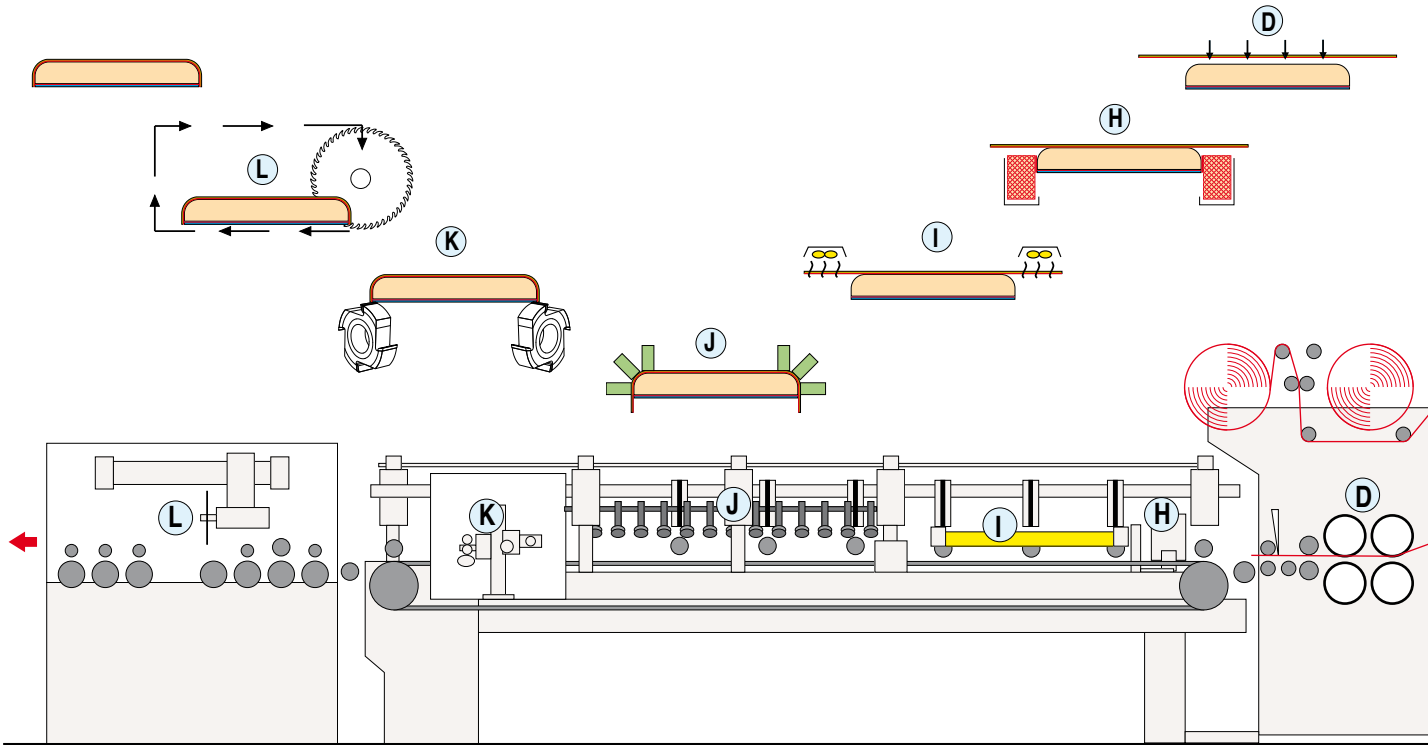
Hotmelt laminating and postforming

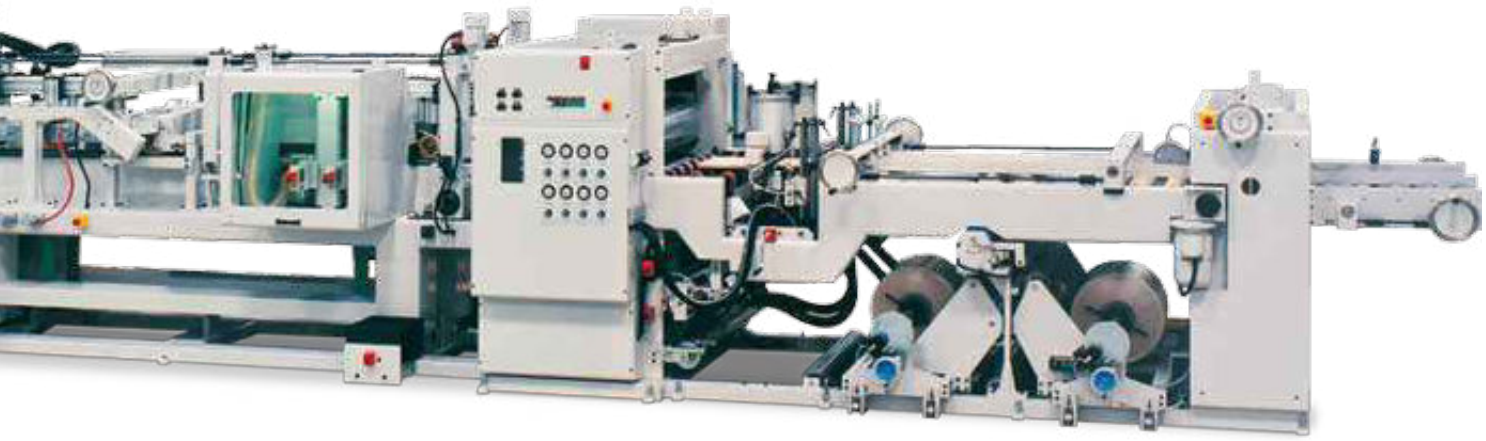


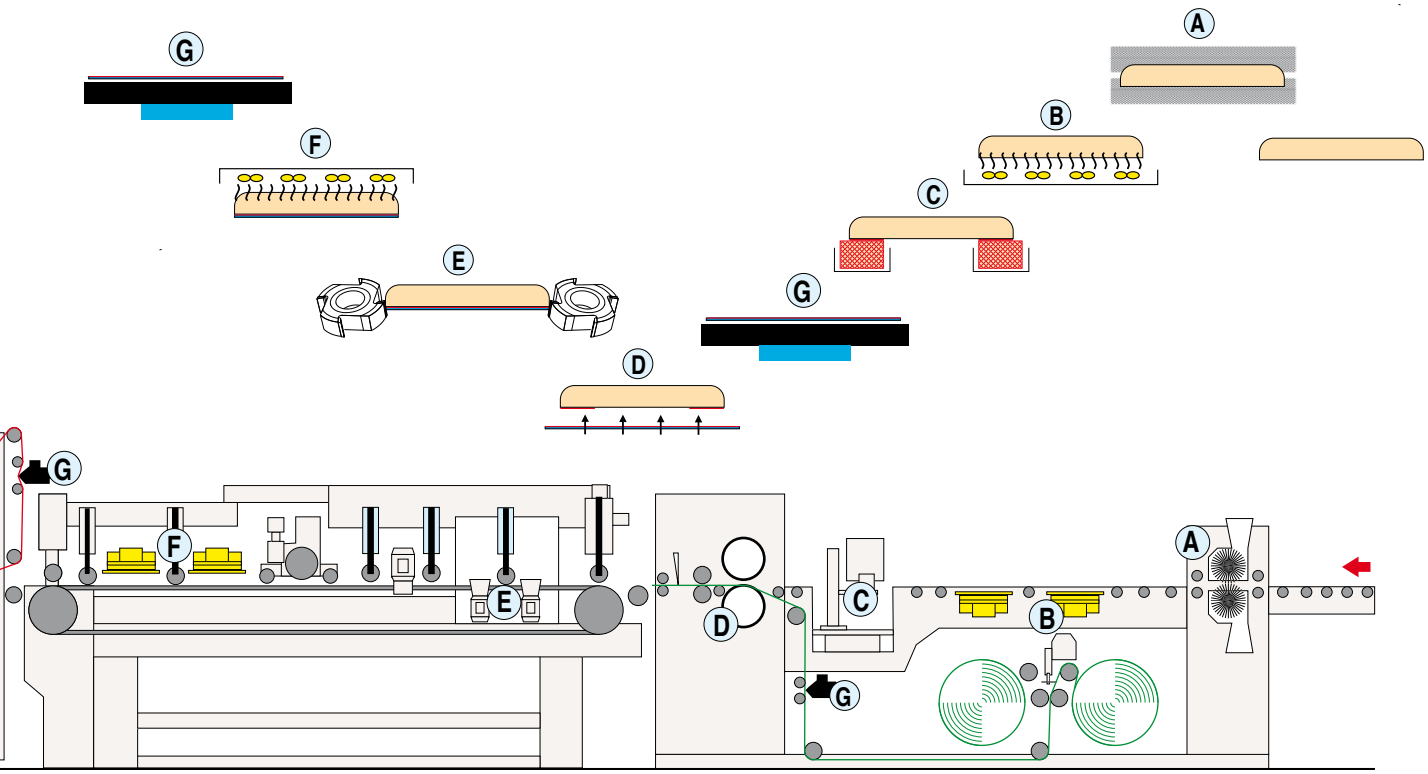
SPEED PRESS HOT MELT GLUE (CPL)

Laminating and postforming machine for foils and laminates (CPL) both side lamination using EVA and PUR glues. The great novelty in this machine is the combined use of PUR and EVA glues. The EVA glue achieves a high working speed and short drying times but less temperature and humidity resistance. In order to solve this inconvenience, BARBERÁN, S.A. has developed a system to apply PUR glue, which has an excellent resistance against temperature and humidity, on the panel ends, which are the most fragile areas. As the panel surface is the most resistant part, it will be bonded using EVA glue ,which is in addition to the above mentioned characteristics, more economic than the PUR glue.

The machine is composed of : Panel cleaning brushes, Heating system for the lower part, PUR Glue application rollers for the lower extremes (20 mm) of the panel, Lower double uncoiling station with automatic splicing, Slot nozzle for the application of EVA glue on the lower foil, Heated pressure rollers, Trimmers for the lower foil surplus, Heating system for the upper part, PUR Glue application rollers for the upper extremes (20 mm) of the panel, Upper double uncoiling station with automatic splicing, Slot nozzle for the application of EVA glue on the upper foil, Double pressure rollers, heated independently, Postforming zone, Trimmers for the upper foil surplus, cutting saw for the separation of panels.



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Machines for specific laminations

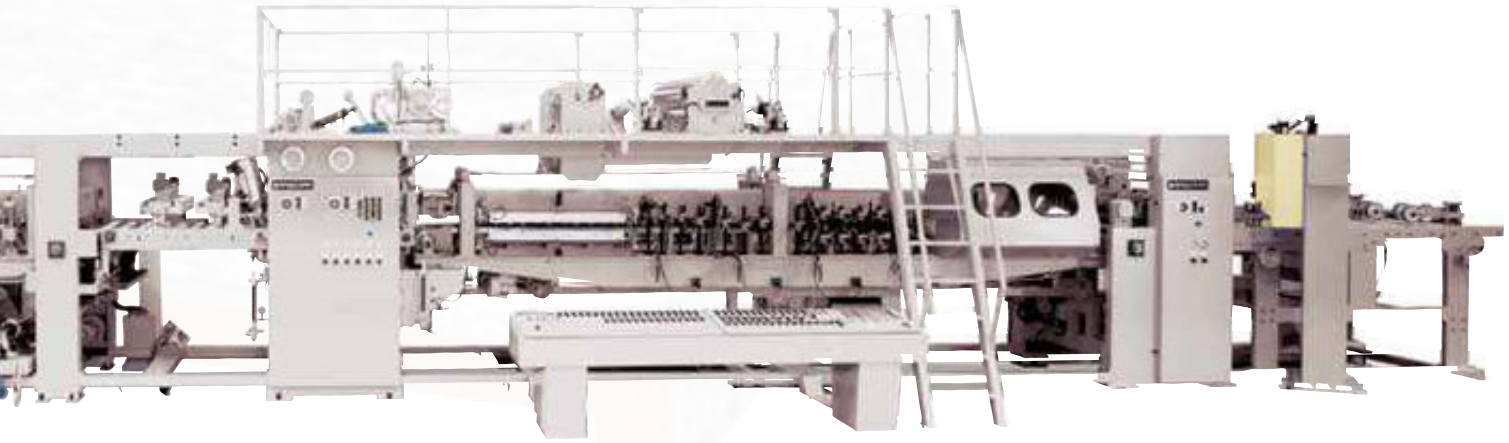
FAST-PRESS & POSTFORMING

Continuous panel wrapping system with low and high pressure laminates using pvac glue.

SOFT & POSTFORMING

Continuous panel wrapping system with low pressure laminates, paper foils, or alkorcel using pvac glue.

Continuous panel lamination the glue is applied on panel surface and on the foil zone, which will wrap the profiled edge.



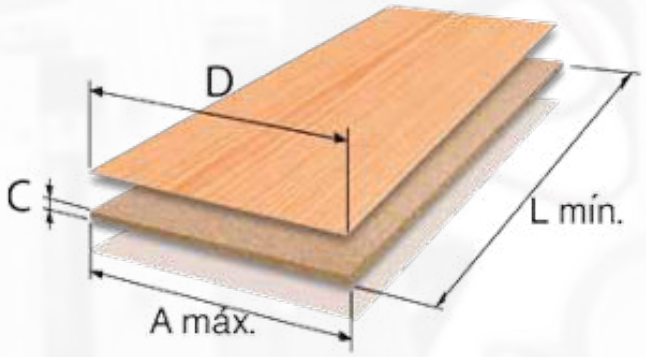
Laminating up to 1700 mm

ECOLINE-PUR

Two-side panel laminating machine over film, PVC, etc with PUR glues and rubber rollers.

ECOLINE-H

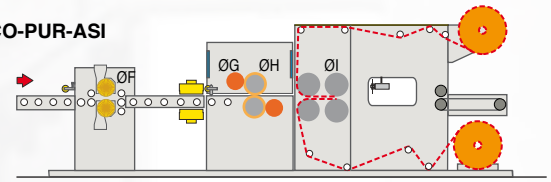
Two sides panel laminating machine over film, PVC, etc with PUR glues and metallic rollers.



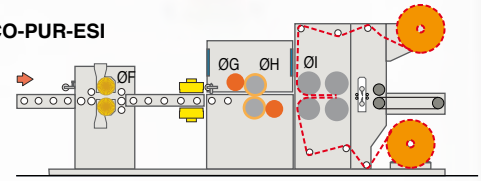
DATOS TÉCNICOS - TECNICAL DATA

Mod.	L mín.	A máx.	C	D	FØ mm	GØ mm	HØ mm	IØ mm	Vm/ mín.
ECO-PUR-1100		1000		1050	180	174	245	300	5 - 25
ECO-PUR-1400	1200	1300	3 - 50	1350	"	"	"	"	"
ECO-PUR-1700		1600		1650	"	"	"	"	"

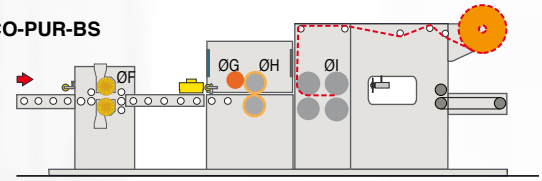
ECO-PUR-ASI



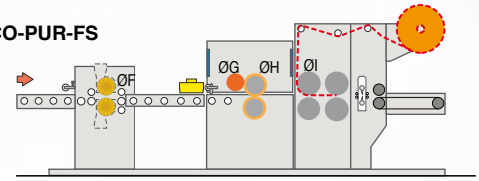
ECO-PUR-ESI



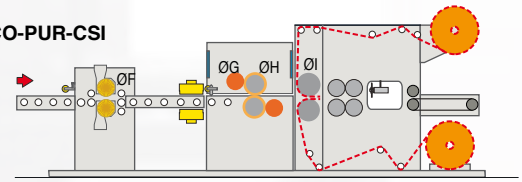
ECO-PUR-BS



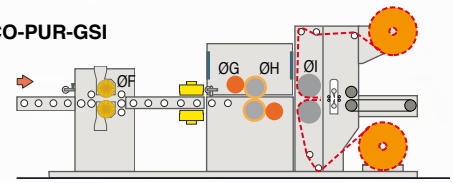
ECO-PUR-FS



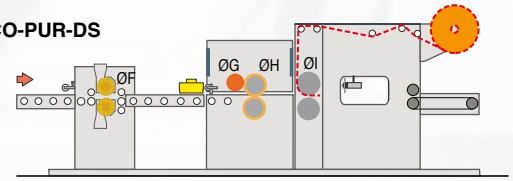
ECO-PUR-CSI



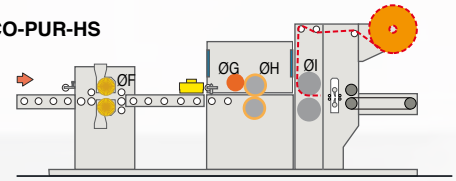
ECO-PUR-GSI



ECO-PUR-DS



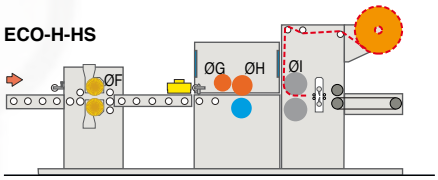
ECO-PUR-HS



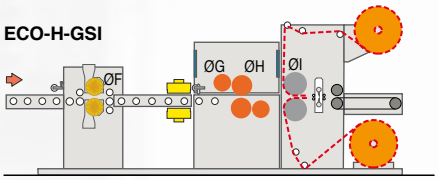
DATOS TÉCNICOS - TECNICAL DATA

Mod.	L mín.	A máx.	C	D	FØ mm	GØ mm	HØ mm	IØ mm	Vm/ mín.
ECO-H-1100		1000		1050	180	245	245	300	5 - 25
ECO-H-1400	1200	1300	3 - 50	1350	"	"	"	"	"
ECO-H-1700		1600		1650	"	"	"	"	"

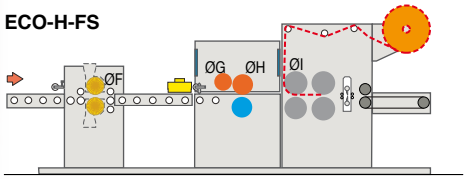
ECO-H-HS



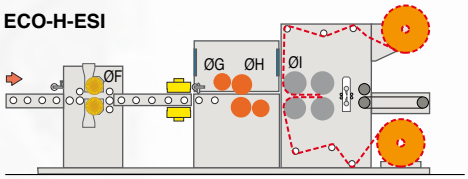
ECO-H-GSI



ECO-H-FS



ECO-H-ESI



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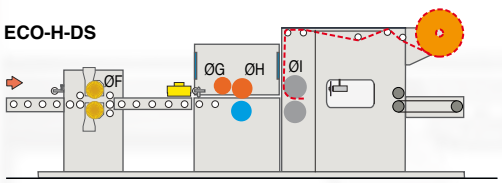

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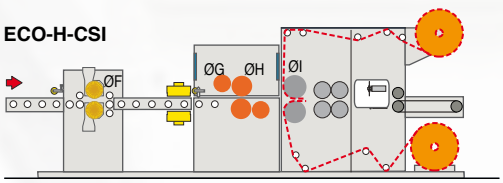
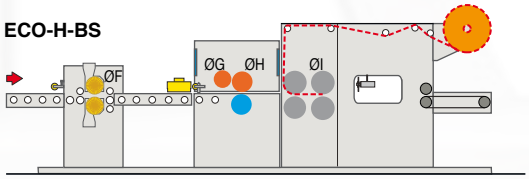
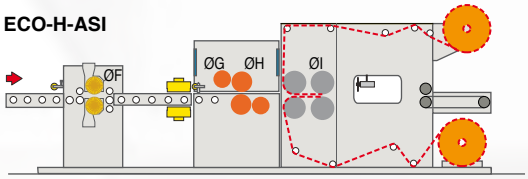


ECO-H-BS



ECO-H-ASI



Laminating up to 1700 mm

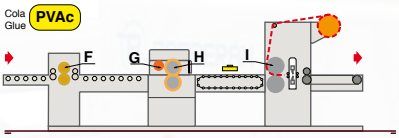
ECOLINE-S

Laminadora de panel con folio de papel o PVC a una cara, mediante colas UF y PVAc.
Panel laminating machine over film, PVC, etc with UF & PVAc glues.

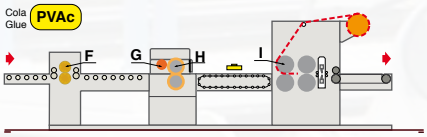
ECOLINE-SI

Laminadora de panel con folio de papel o PVC a dos caras con colas UF y PVAc.

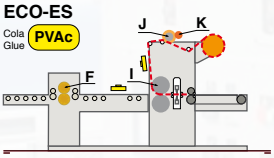
ECO-AS
Cola / Glue: PVAc



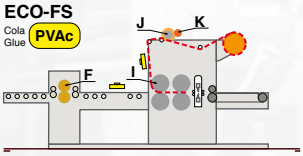
ECO-BS
Cola / Glue: PVAc



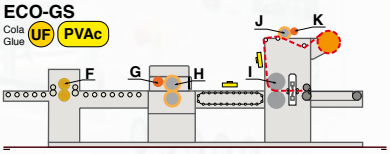
ECO-ES
Cola / Glue: PVAc



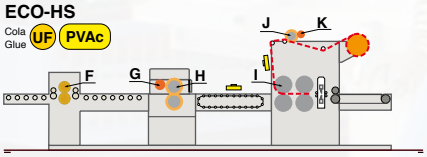
ECO-FS
Cola / Glue: PVAc



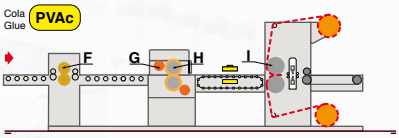
ECO-GS
Cola / Glue: UF PVAc



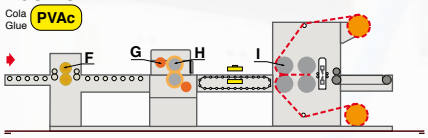
ECO-HS
Cola / Glue: UF PVAc



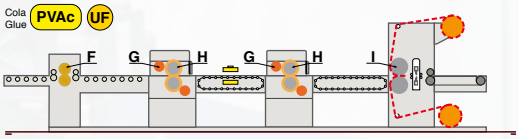
ECO-ASI
Cola / Glue: PVAc



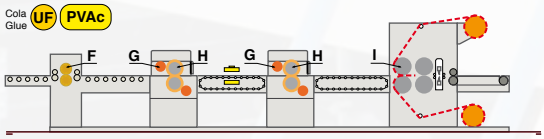
ECO-BSI
Cola / Glue: PVAc



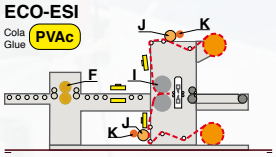
ECO-CSI
Cola / Glue: PVAc UF



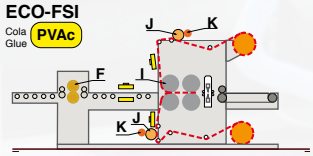
ECO-DSI
Cola / Glue: UF PVAc



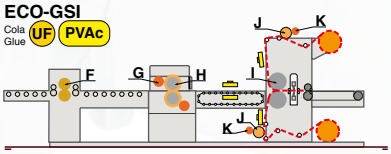
ECO-ESI
Cola / Glue: PVAc



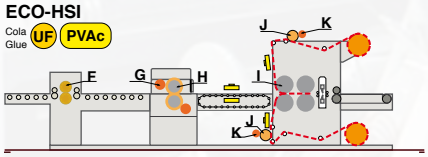
ECO-FSI
Cola / Glue: PVAc



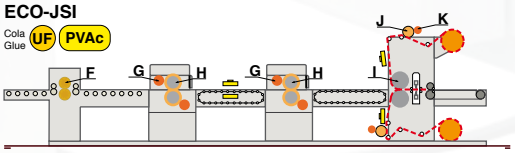
ECO-GSI
Cola / Glue: UF PVAc



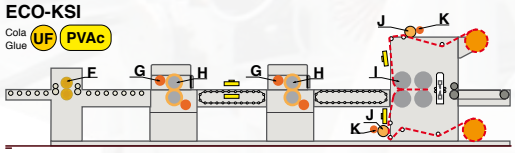
ECO-HSI
Cola / Glue: UF PVAc



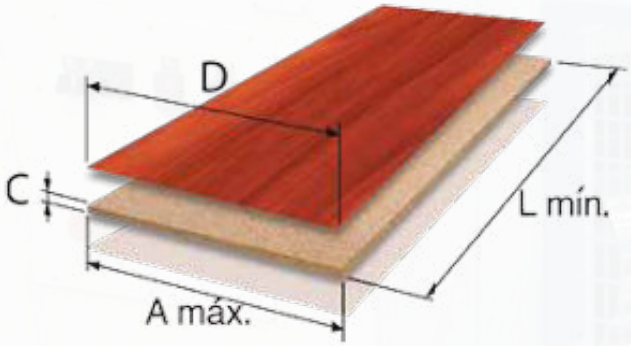
ECO-JSI
Cola / Glue: UF PVAc



ECO-KSI
Cola / Glue: UF PVAc



Con opcionales



DATOS TÉCNICOS - TECNICAL DATA

Mod.	L mín.	A máx.	C	D	FØ mm	GØ mm	HØ mm	IØ mm	JØ mm	KØ mm	Vm/mín.
ECOLINE-S-1100		1000		1050	180	174	245	300	245	174	5 - 25
ECOLINE-S-1400	1200	1300	3 - 50	1350	"	"	"	"	"	"	"
ECOLINE-S-1700		1600		1650	"	"	"	"	"	"	"

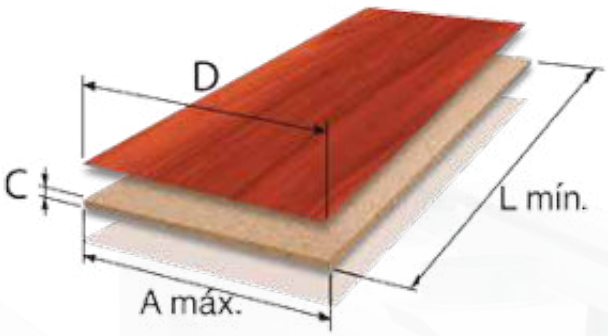
DATOS TÉCNICOS - TECNICAL DATA

Mod.	L mín.	A máx.	C	D	FØ mm	GØ mm	HØ mm	IØ mm	JØ mm	KØ mm	Vm/mín.
ECOLINE-SI-1100		1000		1050	180	174	245	300	245	174	5 - 25
ECOLINE-SI-1400	1200	1300	3 - 50	1350	"	"	"	"	"	"	"
ECOLINE-SI-1700		1600		1650	"	"	"	"	"	"	"

Laminating from 1400 - 2400 mm

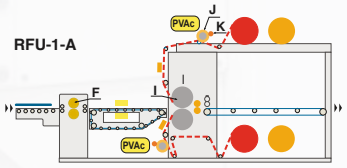
RFU-A

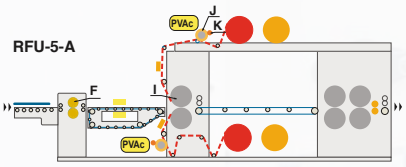
Double sided laminating line for the application of PVAc glue on the foil.

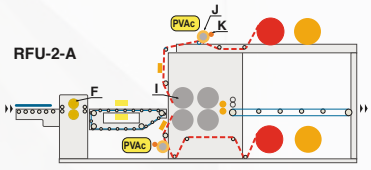


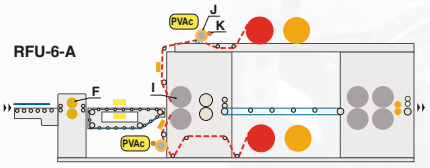
DATOS TÉCNICOS
TECNICAL DATA

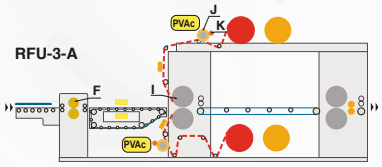
Mod. A	L mín.	A máx.	C	D	FØ mm	IØ mm	JØ mm	KØ mm	Vm/ mín.
RFU-1400		1300		1350	180	300	233	174	5 - 25
RFU-1700		1600		1650	"	"	"	"	"
RFU-2000	1200	1900	3 - 50	1950	210	500	305	240	6 - 36
RFU-2200		2100		2150	"	"	"	"	"
RFU-2400		2300		2350	"	"	"	"	"

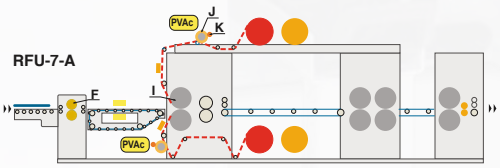


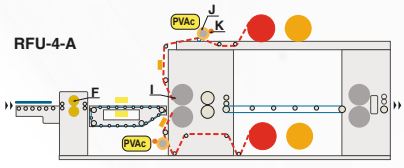


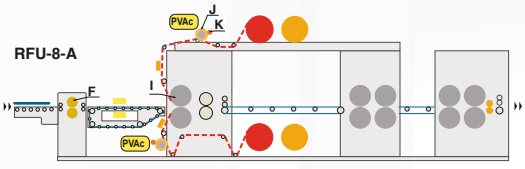






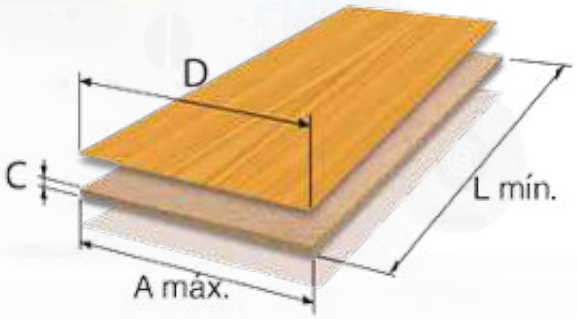






RFU-B

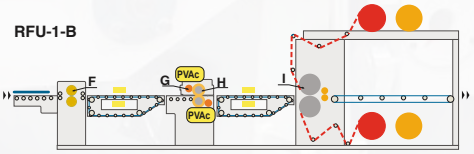
Double sided laminating line for the application of PVAc glue on the board.



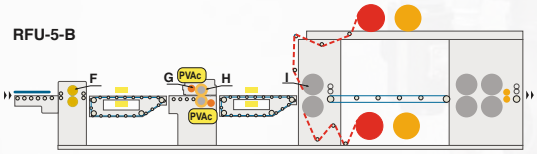
DATOS TÉCNICOS
TECNICAL DATA

Mod. B	L mín.	A máx.	C	D	FØ mm	GØ mm	HØ mm	IØ mm	Vm/ mín.
RFU-1400		1300		1350	180	174	245	300	5 - 25
RFU-1700		1600		1650	"	"	"	"	"
RFU-2000	1200	1900	3 - 50	1950	210	240	305	500	6 - 36
RFU-2200		2100		2150	"	"	"	"	"
RFU-2400		2300		2350	"	"	"	"	"

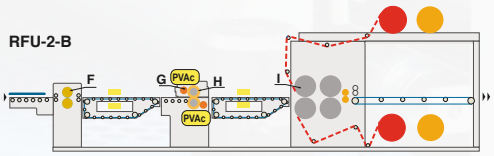
RFU-1-B



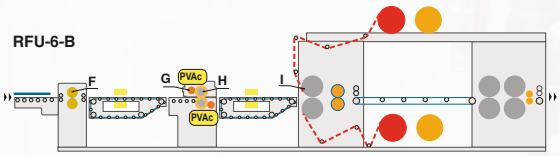
RFU-5-B



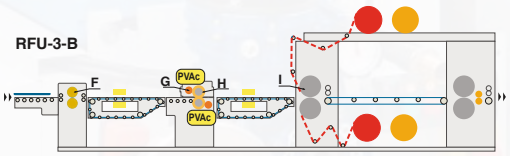
RFU-2-B



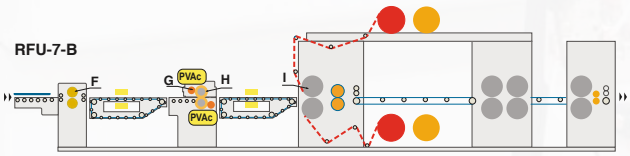
RFU-6-B



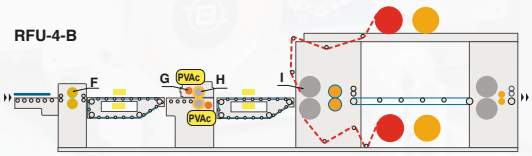
RFU-3-B



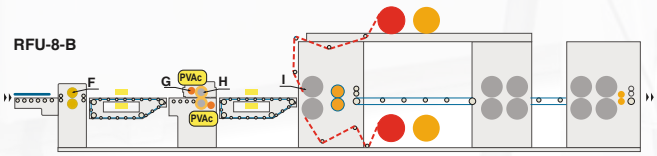
RFU-7-B



RFU-4-B



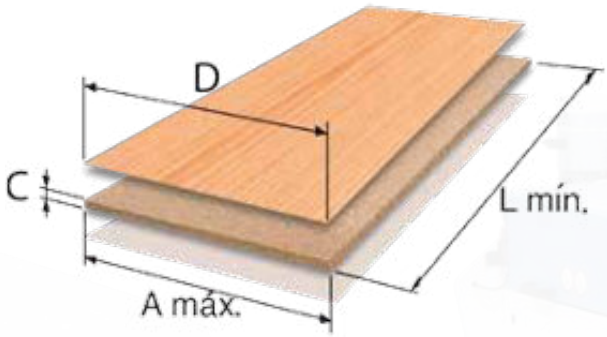
RFU-8-B



Laminating from 1400 - 2400 mm

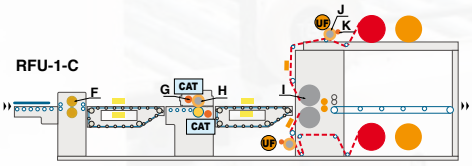
RFU-C

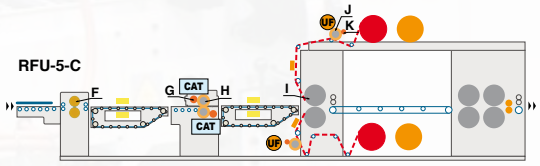
Double sided laminating line for the application of Hardener on the board and UF glue on the foil.

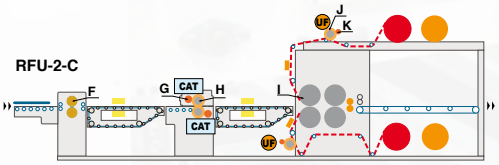


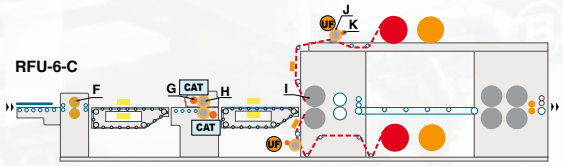
DATOS TÉCNICOS
TECNICAL DATA

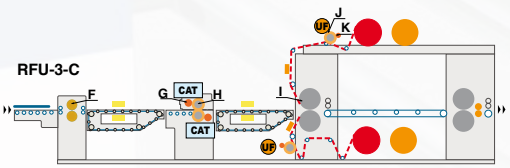
Mod. C	L mín	A máx.	C	D	FØ mm	GØ mm	HØ mm	IØ mm	JØ mm	KØ mm	Vm/ mín.
RFU-1400		1300		1350	180	174	245	300	233	174	5 - 25
RFU-1700		1600		1650	"	"	"	"	"	"	"
RFU-2000	1200	1900	3 - 50	1950	210	240	305	500	305	240	6 - 36
RFU-2200		2100		2150	"	"	"	"	"	"	"
RFU-2400		2300		2350	"	"	"	"	"	"	"

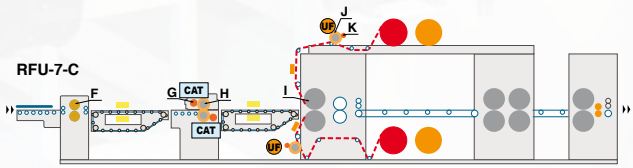


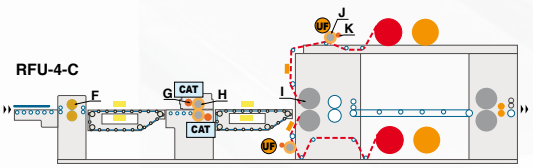


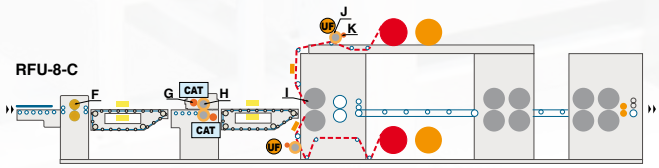






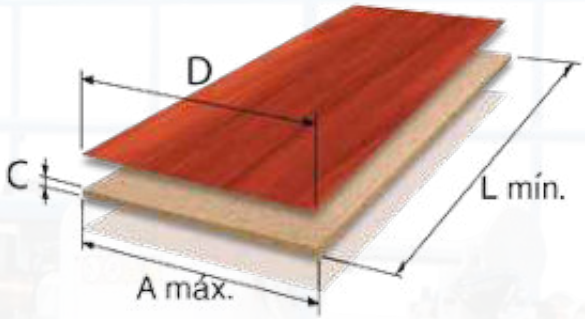






RFU-D

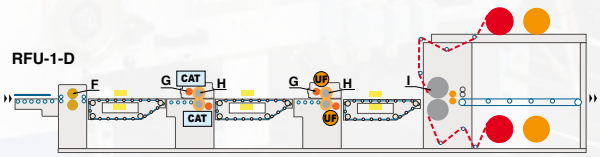
Double sided laminating line for the application of Hardener and UF glue on the board (wet on wet).



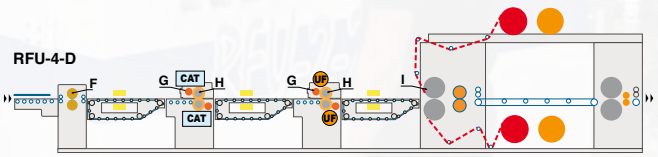
DATOS TÉCNICOS
TECNICAL DATA

Mod. D	L mín.	A máx.	C	D	FØ mm	GØ mm	HØ mm	IØ mm	Vm/ mín.
RFU-1400		1300		1350	180	174	245	300	5 - 25
RFU-1700		1600		1650	"	"	"	"	"
RFU-2000	1200	1900	3 - 50	1950	210	240	305	500	6 - 36
RFU-2200		2100		2150	"	"	"	"	"
RFU-2400		2300		2350	"	"	"	"	"

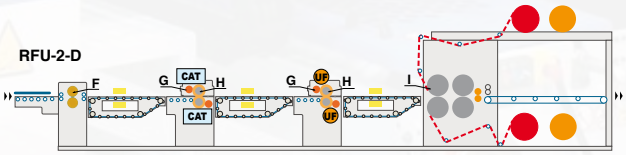
RFU-1-D



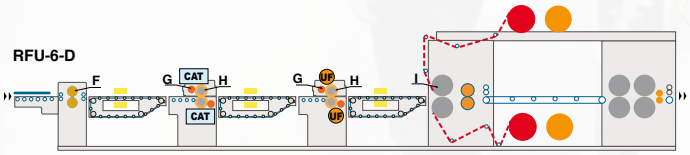
RFU-4-D



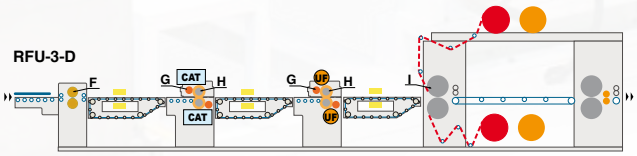
RFU-2-D



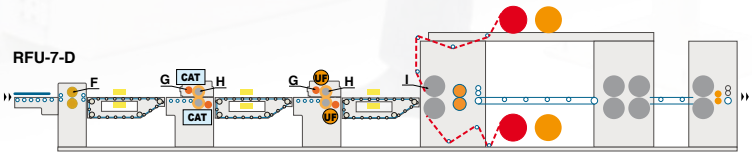
RFU-6-D



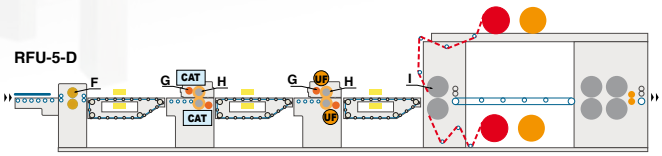
RFU-3-D



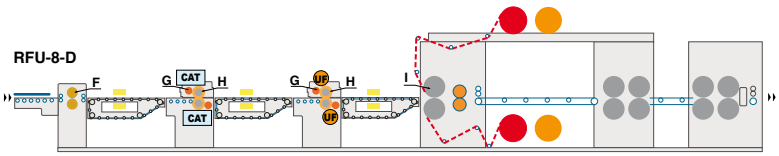
RFU-7-D



RFU-5-D



RFU-8-D

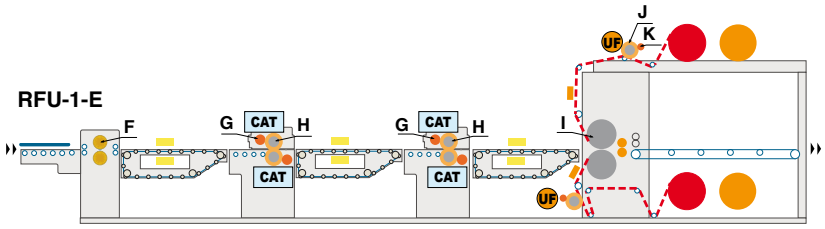


Laminating from 1400 - 2400 mm

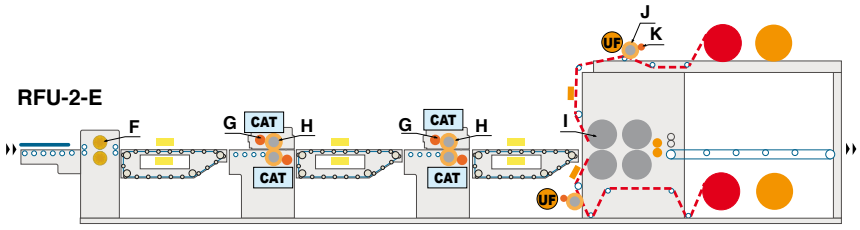
RFU-E

Double sided laminating line for first and second hardener application on the board and UF glue on the foil.

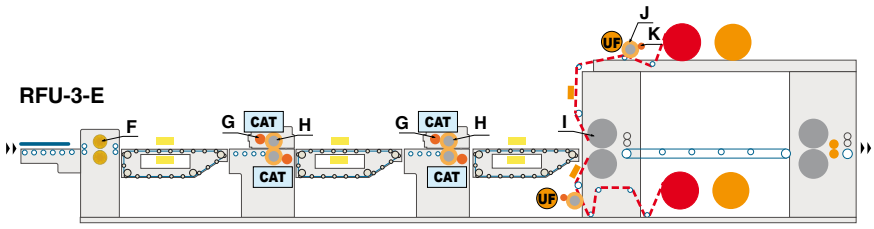
RFU-1-E



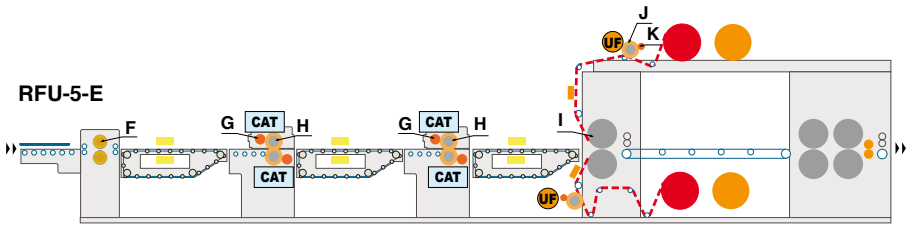
RFU-2-E



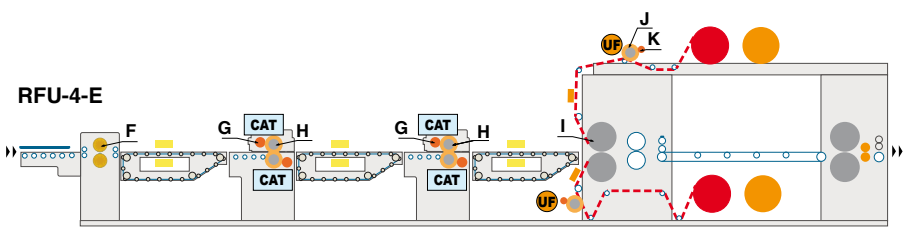
RFU-3-E

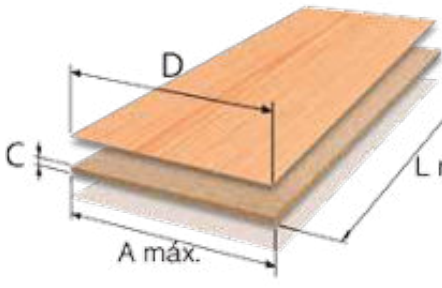


RFU-5-E

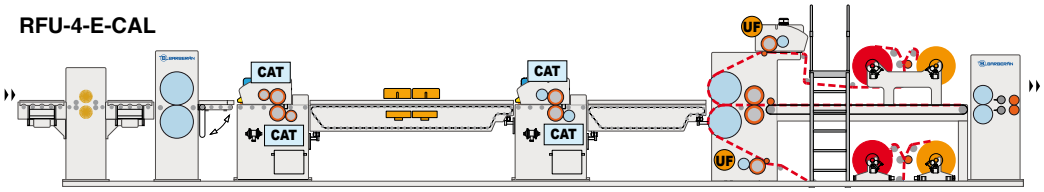


RFU-4-E

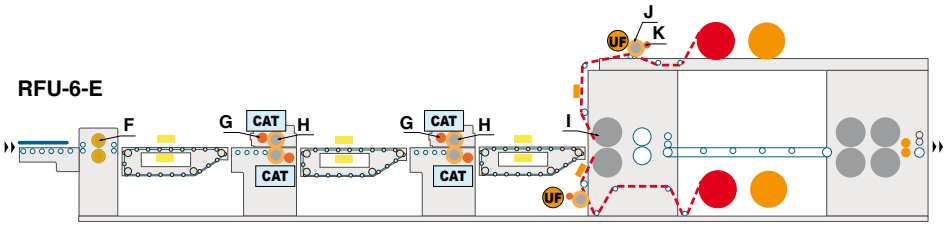




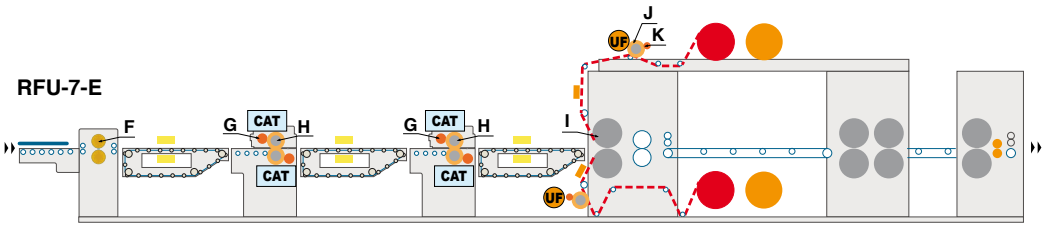
RFU-4-E-CAL



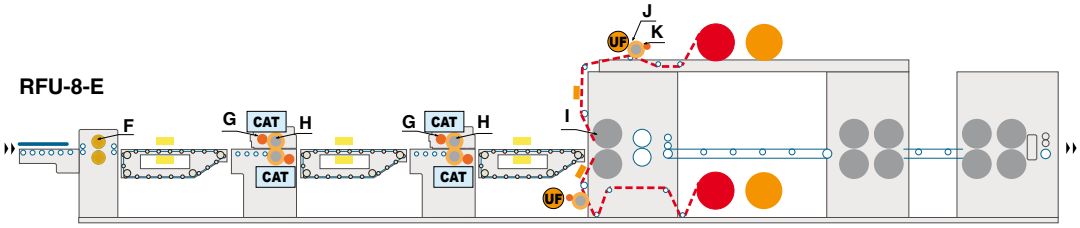
RFU-6-E



RFU-7-E



RFU-8-E



DATOS TÉCNICOS
TECNICAL DATA

Mod. E	L mín.	A máx.	C	D	FØ mm	GØ mm	HØ mm	IØ mm	JØ mm	KØ mm	Vm/ mín.
RFU-1400		1300		1350	180	174	245	300	233	174	5 - 25
RFU-1700		1600		1650	"	"	"	"	"	"	"
RFU-2000	1200	1900	3 - 50	1950	210	240	305	500	305	240	6 - 36
RFU-2200		2100		2150	"	"	"	"	"	"	"
RFU-2400		2300		2350	"	"	"	"	"	"	"

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