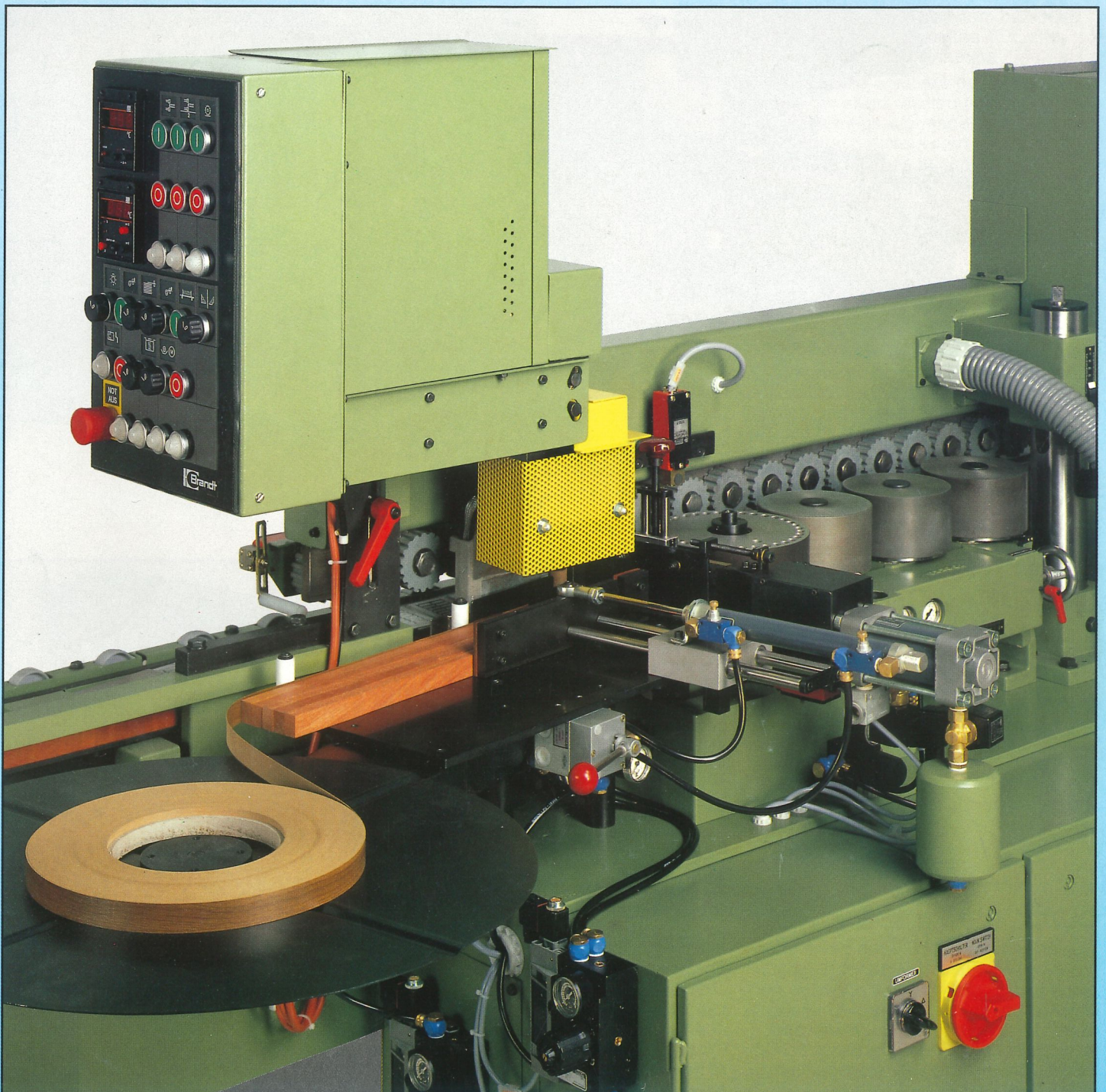


Edge Banding Machines

KE 13-22



Edge Banding Machines KE 13-22



The photograph shows the type KE 16

Control elements

The electrical control elements are clearly arranged in a desk-type switch-board on the feeding side of the machine. The electrical system has been designed according to the VDE standards or to local regulations.

All adjustable units are designed particularly for short resetting times. The essential settings are made by high precision digital counters with a precision of 0.1 mm. Workpiece thickness setting of the top pressure unit is carried out from a central point on the feeding side of the machine, the top processing units are automatically adjusted at the same time.

Processing units

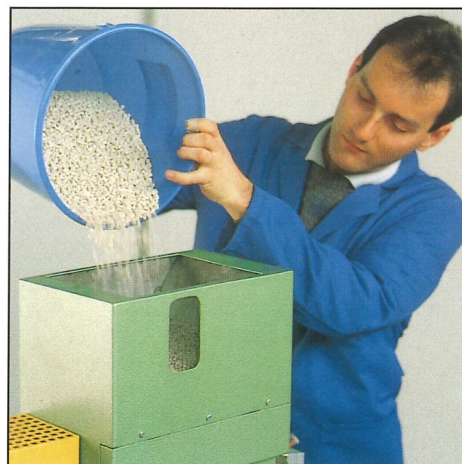
All processing units have been designed by HOMAG and have proven many thousand times in the use with high performance industrial machines. Trimming, flush cutting, and universal cutting units are only equipped with 200 Hz high frequency motors (direct drive). KE-machines are never equipped with gearmotors (low precision, high wear).

Gluing with hot melt adhesive

In practice this edge banding procedure is given preference to as it is the most cost-effective and problem-free. It ensures low energy consumption and high output with small machines, as the edge bands are pressed onto the workpiece directly after the glue application. The processing temperature is between 180 and 220 degrees C, depending on the glue type. Special hot melt adhesives are resistant to high temperatures, such as 100 degrees C and more, and therefore they are also suitable for highest quality demands.

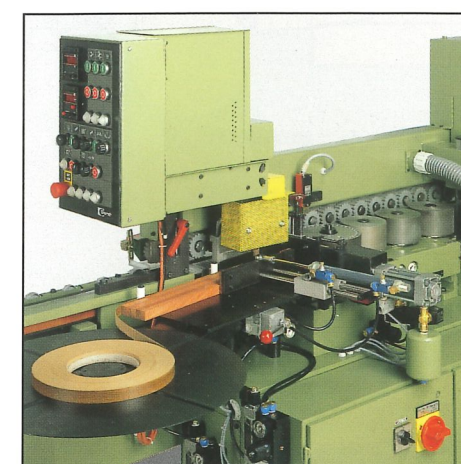
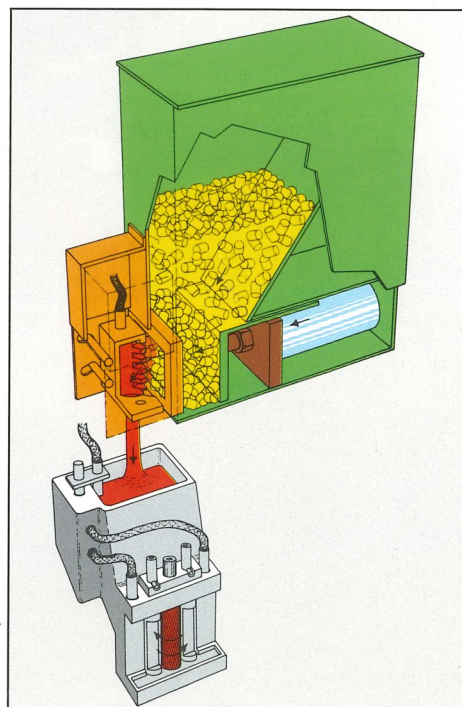
QUICK MELT-system

The proven glue-application system for all granulates usual in trade. It continuously feeds fresh hot melt adhesive, as only the immediately required quantity of adhesive is melted. Further advantages of the QUICK MELT-system: short heating time (approx. 8 minutes), low energy consumption.



Operating method

The opposite illustration shows the upper storage container for the granulate. When the granulate is needed or to be processed the cylinder presses it against the heated melting plate, and the required quantity of fresh melted glue is fed to the glue tank and glue roller beneath the cylinder.



Gluing unit

The gluing unit with the installed standard QUICK MELT-system is the main item of each KE-machine. QUICK MELT has been developed by BRANDT and is legally protected as a registered design at home and by patents abroad.

Precisely dosed glue application

The hot melt adhesive is applied to the workpiece edge in precise dosage by means of a glue roller. The glue roller can be set to run either in the same or in opposite direction, in order to adapt it optimally to the workpiece concerned. Our standard equipment includes an automatic glue roller running system.

Edge band magazine

On request the standard edge band magazine for coiled material or fixed lengths can be equipped with a special trimming device for 3 mm PVC edge bands.

Pressure Zone

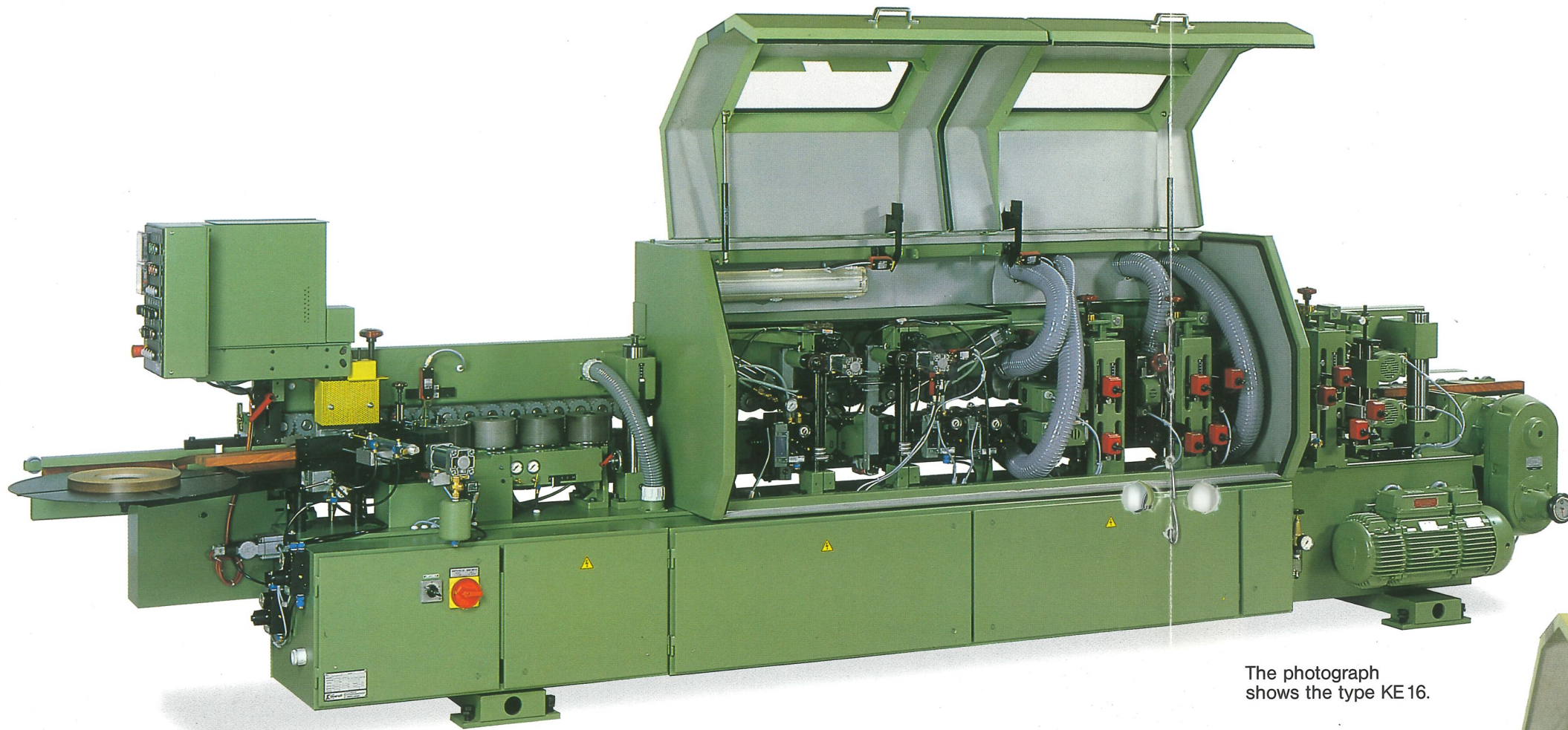
The heavy-duty pressure zone, equipped with a driven main pressure roller (diameter 200 mm) as well as with 3 idle post-pressure rollers (diameter 150 mm) can be controlled pneumatically and therefore be adapted optimally to all working conditions.



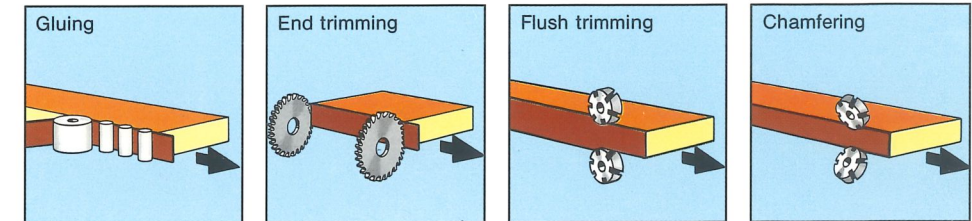
Edging materials

All edging materials usual in trade can be processed: veneer edges both in coils and strips, PVC, melamine and polyester edges, laminated plastics, thick PVC edgings, solid wood edgings up to max. thickness of 20 mm.

Edge Banding Machines



The photograph shows the type KE 16.



10 Machines – one successful concept

The large-scale standardization of units and construction groups as well as the resulting large production series make it possible to present with the types KE 13-22 an edge banding machine series which does not only meet with the high demands of sophisticated interior design but also with those of series production.

Basic machines in 10 different lengths

Standard KE-machines are generally designed for right-hand operation as used in craftsmen's workshops. On request we can, however, also deliver the industrial type for left-hand operation.

10 different basic machines with total lengths from 4500 to 9000 mm – in size intervals of 500 mm – are offered for many different unit combinations. The installation of additional units at a later date is possible without problems, provided that the necessary space has been left when installing the main machine.

Optimal workpiece guide

The workpiece transport is effected by the 80 mm wide heavy-duty chain conveyor (from KE 18 onwards standard central lubrication of chain conveyor). The top pressure unit with the double-row rubberized specially toothed pressure rollers ensures an optimal and safe guide of the workpieces in the through-feed. Even with thick solid edges a counter pressure device is not necessary.



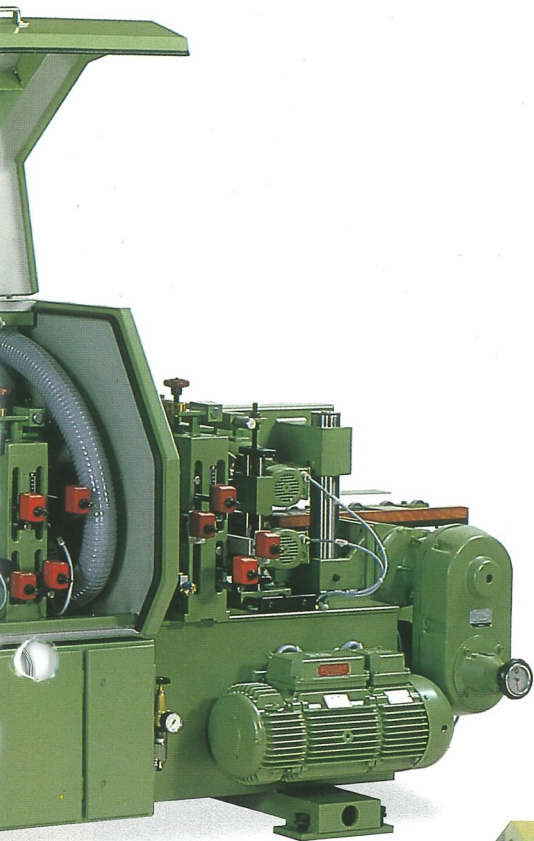
The photograph shows the type KE 22

The illustrated KE 22 is equipped with an electronic line control. For this you need a separately installed control desk with data input unit (with standard units

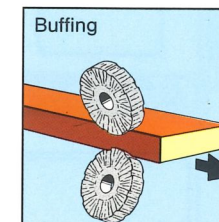
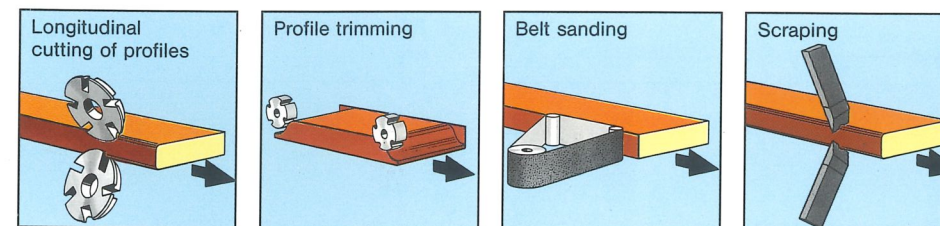
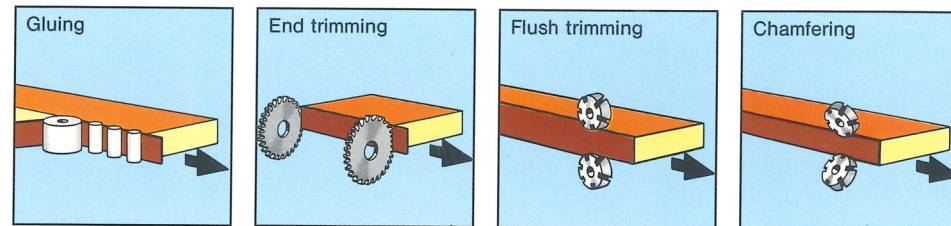
the control panel is mounted on the feeding side of the machine). The electronic line control replaces the usual limit switches to control the work

units. Advantage: higher operation safety and higher operating comfort.

Edge Banding Machines KE 13-22 – systematic flexibility



The photograph shows the type KE 16.

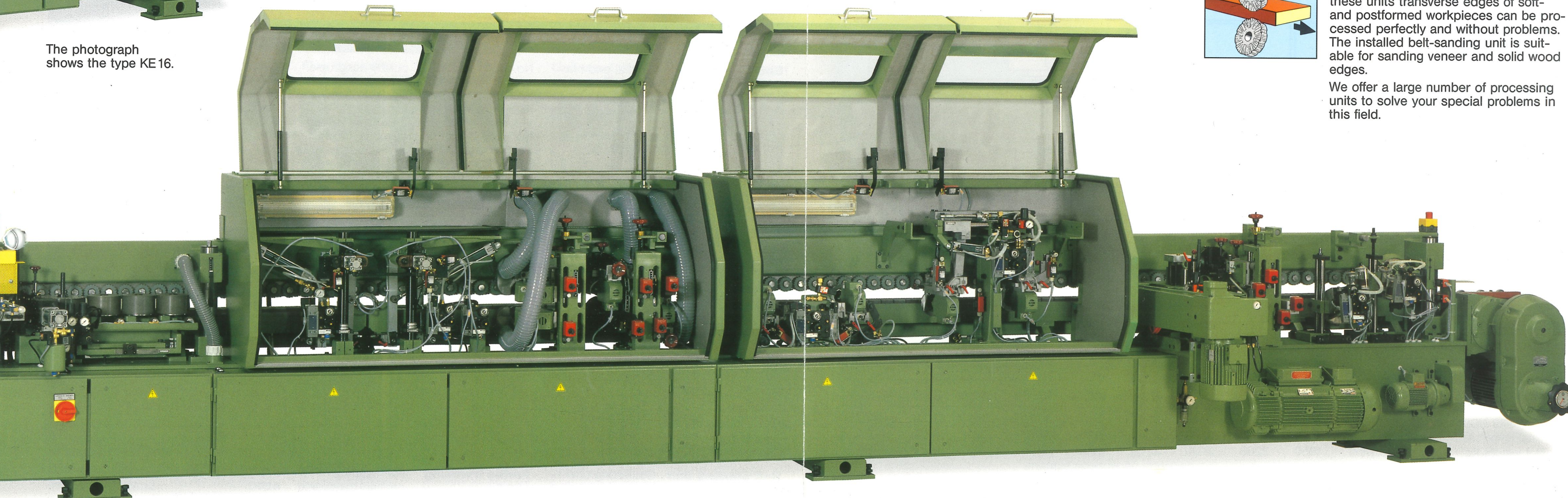


Typical work units

The two illustrated models KE 16 and KE 22 are typical examples for the equipment of the KE series. Both machines are equipped with double end trimming unit, rough trimming and chamfering unit. Furthermore the KE 16 is equipped with a scraping and buffing unit which ensures in particular the appropriate processing of thick PVC edges.

The KE 22 is also equipped with an upper and lower profile trimming unit. With these units transverse edges of soft- and postformed workpieces can be processed perfectly and without problems. The installed belt-sanding unit is suitable for sanding veneer and solid wood edges.

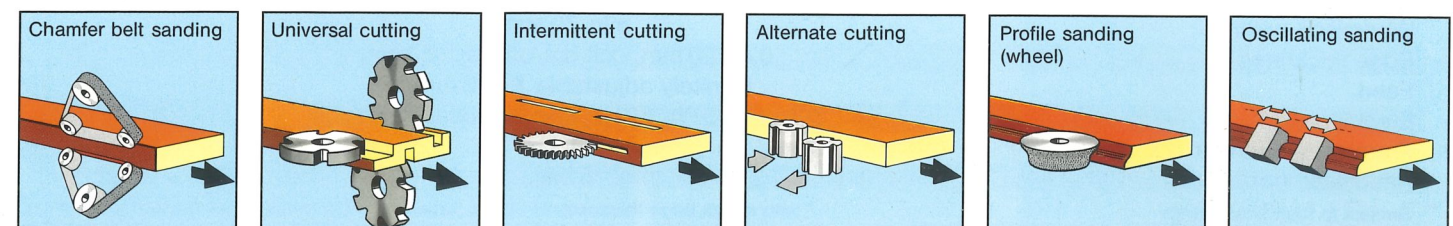
We offer a large number of processing units to solve your special problems in this field.



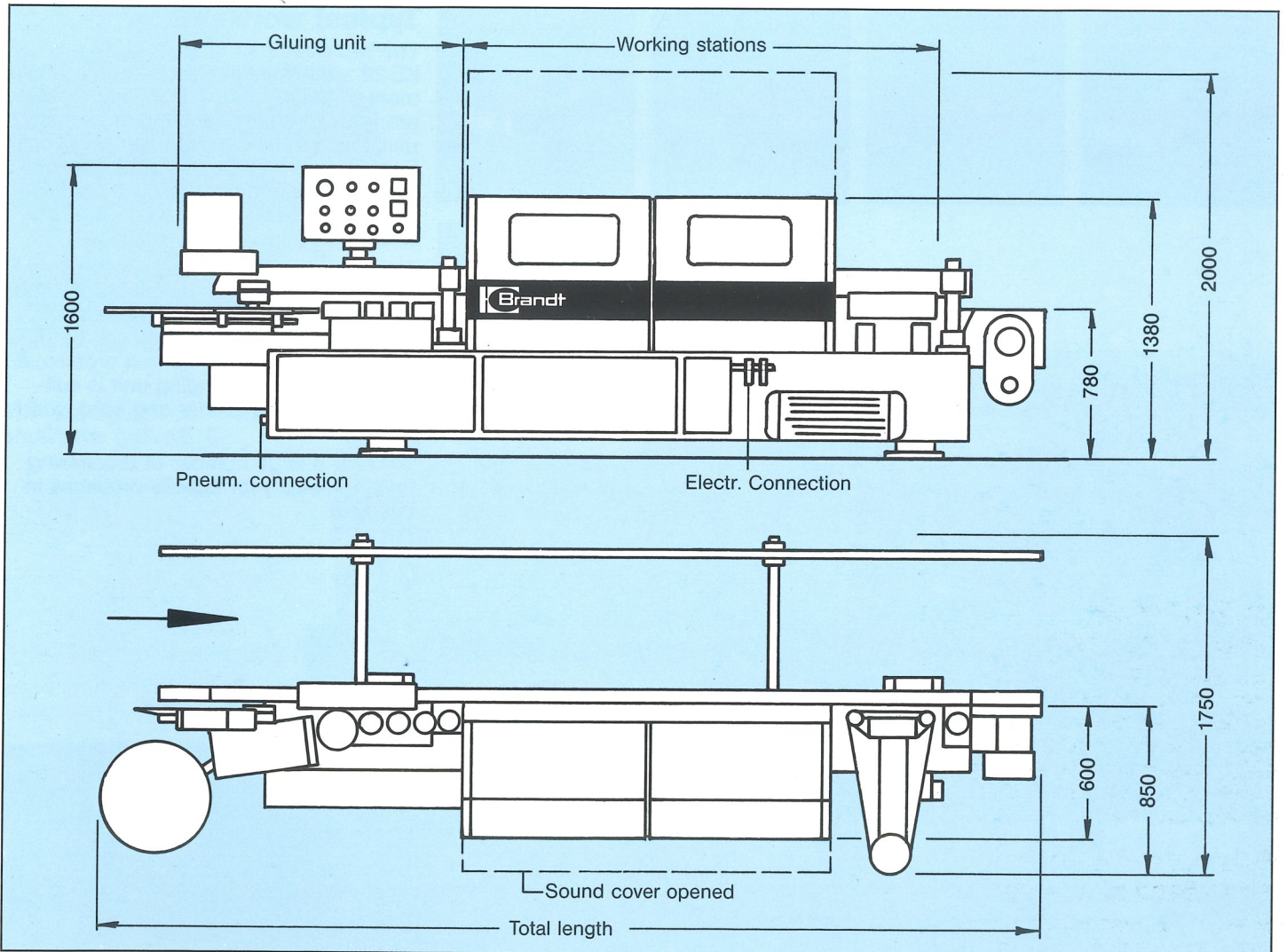
The illustrated KE 22 is equipped with an electronic line control. For this you need a separately installed control desk with data input unit (with standard units

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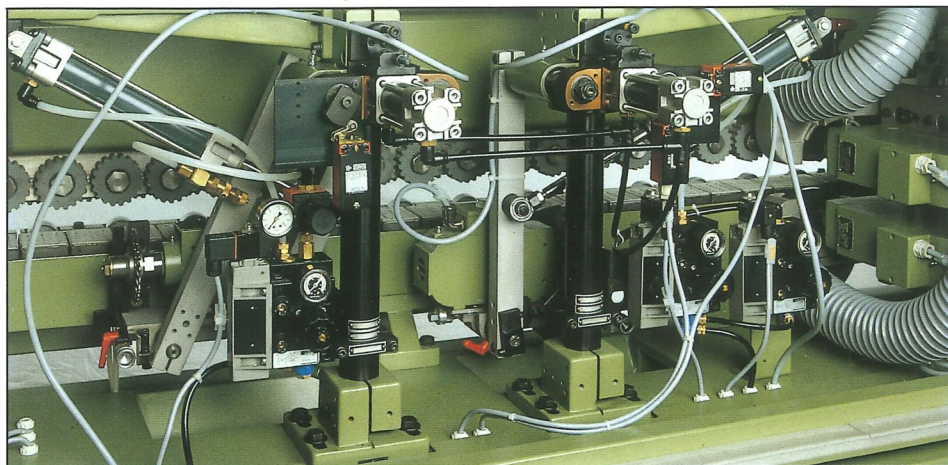


Technical specifications



Technical data	KE 13	KE 14	KE 15	KE 16	KE 17	KE 18	KE 19	KE 20	KE 21	KE 22
Mounting length mm	1940	2440	2940	3440	3940	4440	4790	5290	5790	6290
Total length mm	4500	5000	5500	6000	6500	7000	7500	8000	8500	9000
Net weight kg	1700	1950	2200	2400	2700	3000	3400	3800	4200	4600
Connected load kW	depends on working stations									
Workpiece thickness	8 - 55 mm									
Edge width	12 - 60 mm *									
Workpiece width	min. 70 mm									
Edge thickness	0,4 - 20 mm, coil cut-off max. 0,8 mm									
Feed	infinitely adjustable 7 - 25 m/min.									
Electrics	380 volts, 3 Ph., 50 Hz; special voltage possible									
Frequency changer	200 Hz									
Pneumatic connection	6 bar									
Subject to technical change	* with a max. edge thickness of 20 mm, edge width (strip height) is reduced to 45 mm									

Processing Units



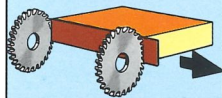
End trimming 3150/3200

Special end trimming units process the through-fed workpiece, vertical cut at front and rear edge. High precision adjustment. 2 motors 0.75 kW each, 200 Hz, 12000 r.p.m.

No. 3150: For straight workpiece corners. 2 HM saw blades diameter 110 mm, Z=20.
No. 3200: For straight and chamfered workpiece corners. Resetting from chamfer to straight

cut by quadruple revolver, manually or electropneumatically. 2 HM saw blades diameter 100 mm, 2 HM chamfer saws, diameter 92 mm, T=20, 45 degrees. Required space 1220 mm.

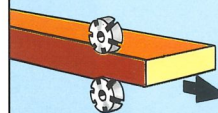
End trimming



Flush trimming unit 4100

For top and bottom flush trimming, with vertical/horizontal tracing. Tilt range from 0-25 degrees. 2 motors 1.5 kW each, 200 Hz, 12000 r.p.m. Tool diameter 70 x 16 x 25 mm, T=4. Space 475 mm.

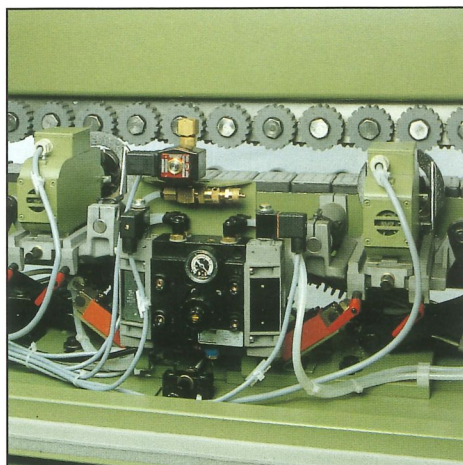
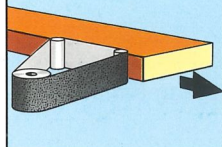
Flush trimming



Belt sanding unit 5060

Oscillating unit for the sanding of veneer and solid wood edges. Pneumatically pressurized controlled contact shoe. Rated motor power 1.75 kW. Required space 400 mm.

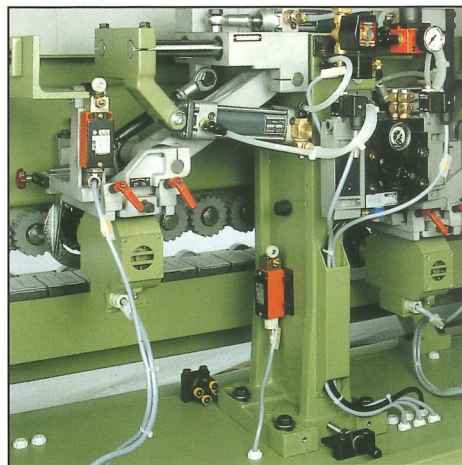
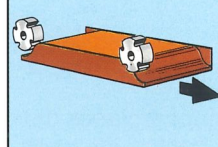
Belt sanding



Profile trimming 4805

For finishing profiled transverse front and rear edges from beneath. 2 motors 0.3 kW each, 200 Hz, 12000 r.p.m. Required space 800 mm.

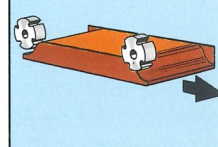
Profile trimming

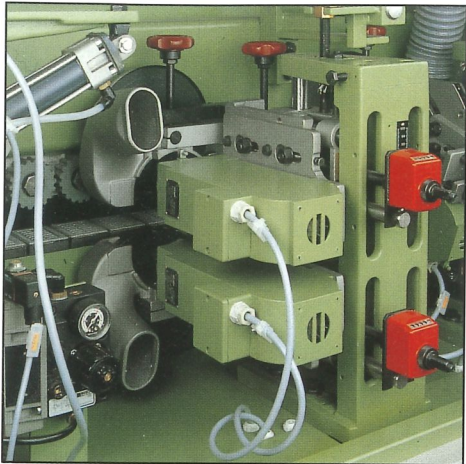


Profile trimming 4810

For finishing profiled transverse front and rear edges from the top. 2 motors 0.3 kW each, 200 Hz, 12000 r.p.m. Required space 930 mm.

Profile trimming

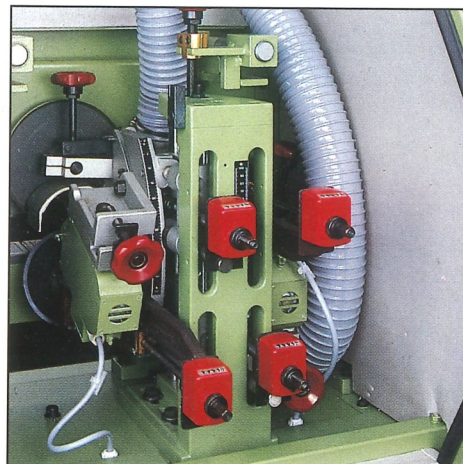
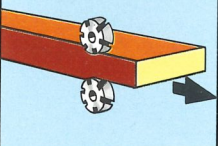




Rough trimming unit 4050

For top and bottom flush trimming, with horizontal tracing. Not tiltable, 2 motors 1.5kW each, 200 Hz, 12000 r.p.m. 2 trimmers diameter 70 x 16 x 25 mm, T=4. Required space 350 mm.

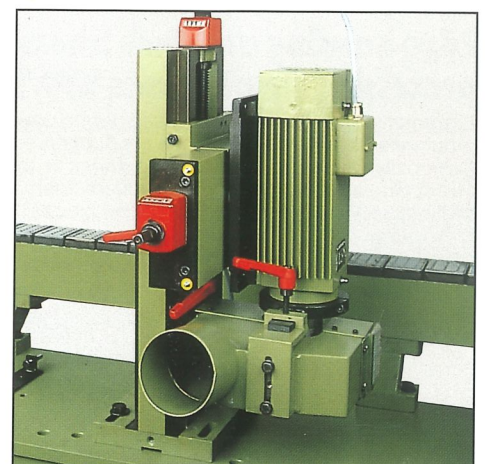
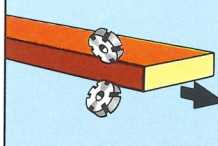
Rough trimming



Fine trimming unit 4150 (4125)

Top and bottom trimming with vertical/horizontal tracing. Tilt range 0-25 degrees. 2 motors 0.33 (0.55) kW each, 200 Hz, 12000 r.p.m. Tool diameter 70 x 16 x 12 mm, T=4. Space 475 mm.

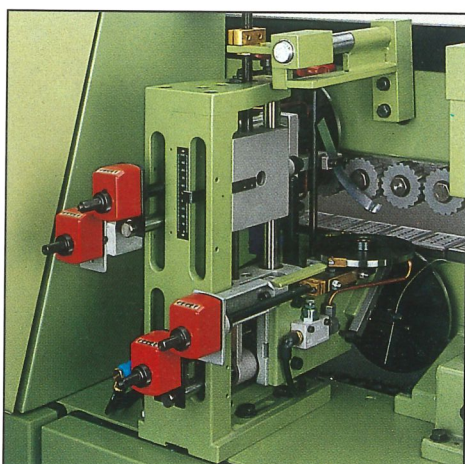
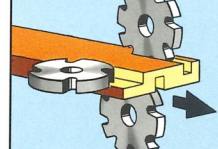
Fine trimming



Universal trimming unit 4500

For the trimming of grooves, rebates, profiles. Trimming column with cross support including spindle adjustment. Motor 2.2 kW, 200Hz, 12000 r.p.m. horizontally and vertically tiltable. Space 470 mm.

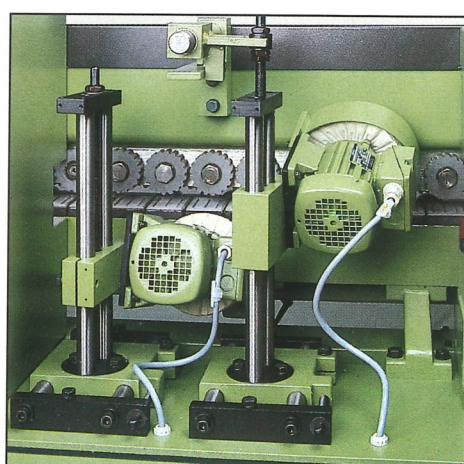
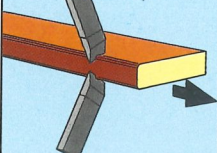
Universal cutting



Scraping unit 5700

For chamfer or round shaping of roughly trimmed PVC-edges in order to remove the cutting dents. Chamfer or profile knives. Suitable for radii from 2-6 mm. Required space 470 mm.

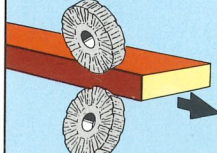
Scraping



Chamfering unit (buffing) 5350

For the finishing (polishing) of longitudinal edges. Standard unit equipped with molton disks. 2 motors 0.18 kW each, 50 Hz, 1400 r.p.m. Required space 520 mm.

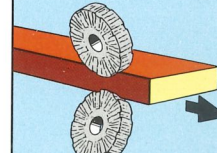
Buffing



Oscillating chamfering unit 5375

For the finishing of trimmed longitudinal edges. Oscillating unit ensures full use of the complete disk width. 2 motors 0.18 kW each, 50 Hz, 1400 r.p.m. Required space 620 mm.

Buffing



Heinrich Brandt Maschinenbau-GmbH
 P.O. Box 6108, Weststraße 2,
 D-4920 Lemgo 1
 Tel. 0 52 61 / 60 09-0
 Telex 9 31 596 mabra
 Telefax 0 52 61 / 64 86

The models depicted below are intended to provide a survey of the most important Brandt machines and appliances for processing straight workpieces and shaped parts. We will be pleased to furnish you with information on hot melt glue applicators, automatic rotary and shaped part processing machines, and rebate banding machines.

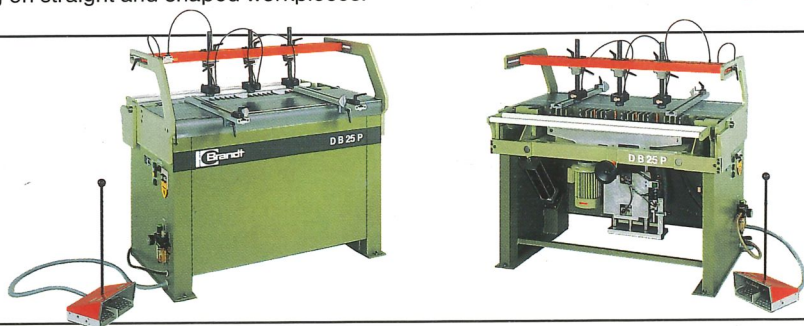
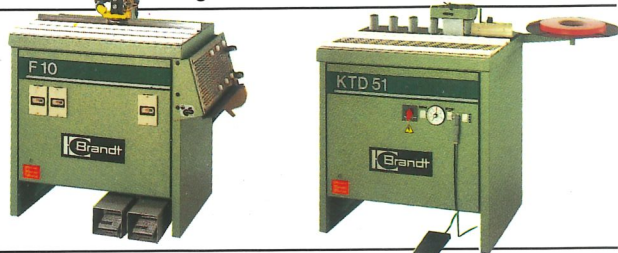


Compact edge banding machines KTV/KTD 62-65

Optionally for processing edging material precoated with hot-melt glue, or for direct glue application. Automatic workpiece transport – end trimming – flush trimming – profile edge gluing – extraction unit built in – these are the main features of these extremely economical machines designed for use in craftsmen's enterprises.

Edge banding and flush trimming machines for processing shaped parts KTD/KTV 51 and F 10/EK 11

Extremely versatile multi-purpose shaped part machines for one-off and series production. Optionally for use with pre-coated edges or for direct glue application. Top and bottom flush trimming on straight and shaped workpieces.

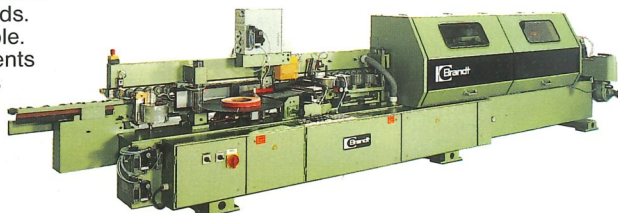


Universal dowel hole boring machines DB 11 H, DB 19 H, DB 25 P, RB 25

Face and surface boring by means of a swivellable boring unit. For all construction and row hole boring work as well as holes for knock-down fittings in craftsmen's enterprises or for producing special models. Row hole boring machine with 2 boring units.

Universal edge banding machines KE, KA and KA/E 13 – 22

For hot melt and PVAC glues, also in a combined version for both methods. 10 basic machine lengths available. Processing units for all requirements arising in craftsmen's enterprises and interior fitting workshops. QUICK MELT gluing section with extremely low heating-up time.

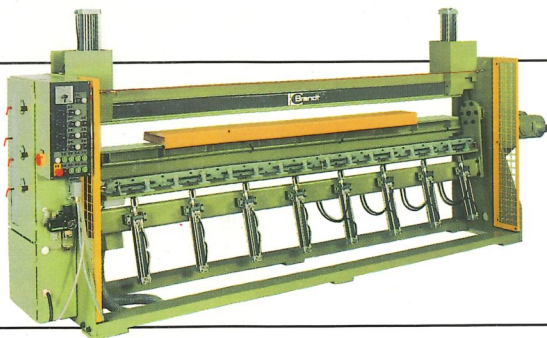


Standard edge banding machines KS 20 – 25

An efficient, reasonably priced machine series. Available in 6 length measurements. For solid edges up to 20 mm. Offering excellent operator convenience. Most widely sold solid edging machine of the Brandt range.

Cyclical postforming machines PF 10 and PF 20

Particularly economical, universal postforming technique. Forming and gluing by means of a patented, electrically heated bar. Automatic profile adjustment. Veneer postforming possible. Extremely short re-equipping times.



Your specialist dealer: