

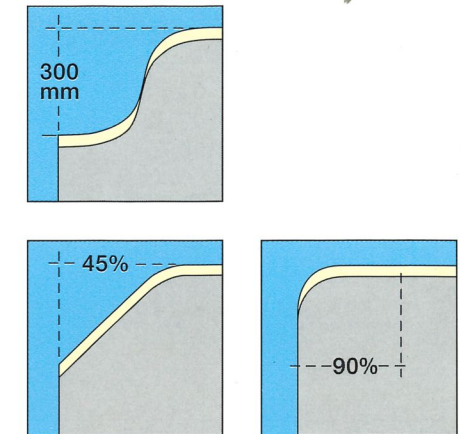
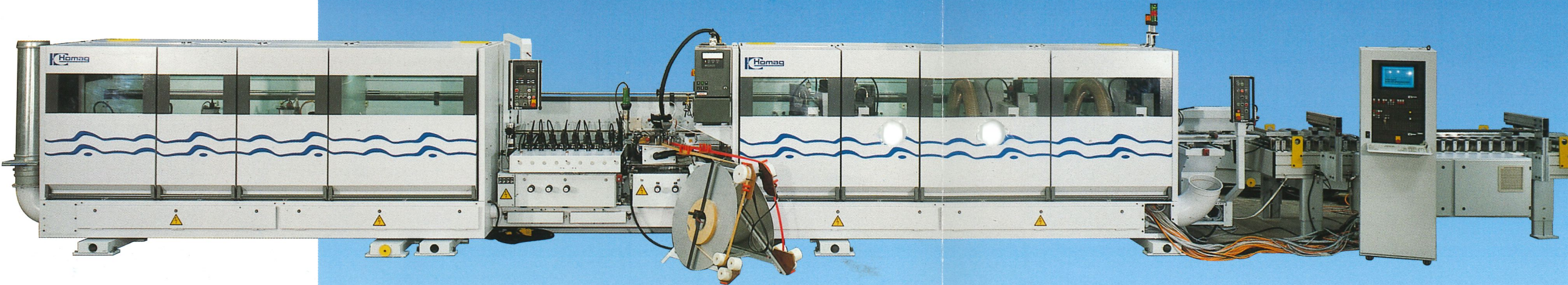
KFL 10/.../CF Continuous Shaped Part Machines

Shaped parts completely processed in one throughfeed

Beautifully shaped workpieces, perfectly processed edges - all in series production



Consumers are asking again and again for attractive, elegantly formed living room and bedroom furniture. For a long time the furniture industry could only manufacture shaped parts for such ranges at great expense – 2-3 operating sequences – or by using a stationary processing centre.



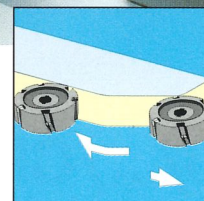
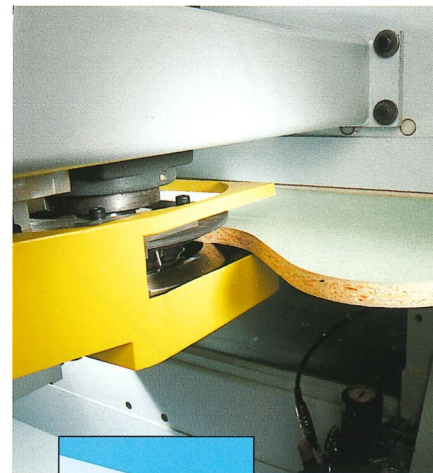
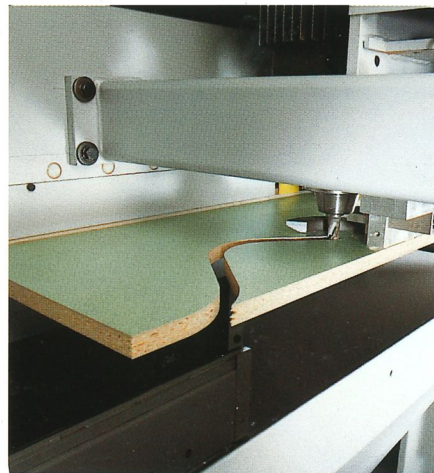
Multi-sided profiles
 ... up to 300 mm deep. Either with trimming unit CF 11, with one axis, approach angle of up to 60°, or with trimming unit CF 12, with 2 axes, approach angle of up to 90°, for workpieces with an edge of a maximum 45°. The machine processes the most varied edges: plastic or veneer, in strips or off the coil, for edge thicknesses of 0.4 to 3 mm. Edges can be changed via a two-slot magazine. The sectional pressure setting of the post-pressure rollers with servo-valves guarantees optimal pressing of the edge material – even for simple softforming profiles such as top or drum profiles.

Shaped parts in continuous throughput!

With the revolutionary development of a continuous shaped part machine Homag has succeeded in making available a technique by which shaped parts are manufactured from rectangular workpieces in one throughput. Including edge banding, of course. As a result, the efficient output of such units in mass production is possible for the first time. And still more: because of the extremely short change-over times, Homag KLF 10/.../CF continuous shaped part machines also operate profitably in small-lot production.

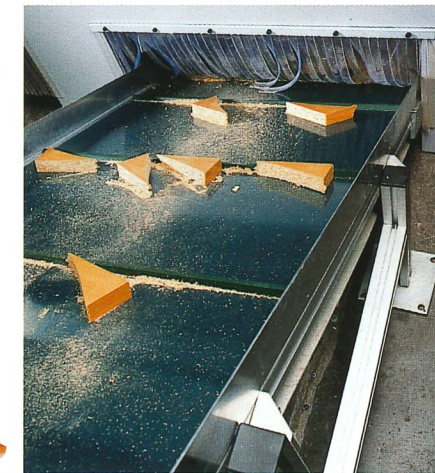
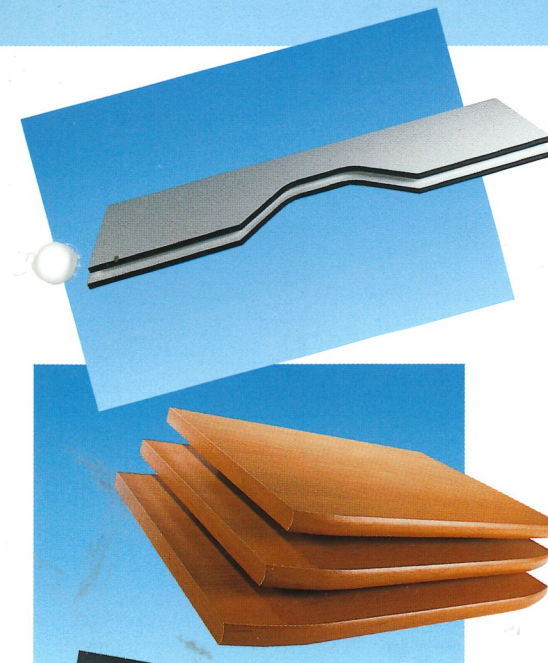
Program-controlled contour trimming – completely without a template

The workpiece contours are trimmed by CNC control – the user quite simply enters their geometry into the Homatic control. The reliable operator guidance provided by the WoodWOP processing software offers the user active programming support.



Smooth, neat contours

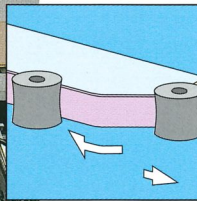
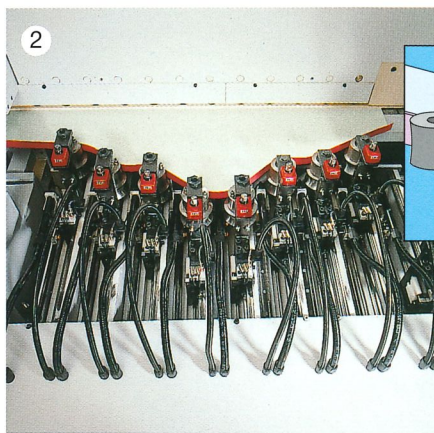
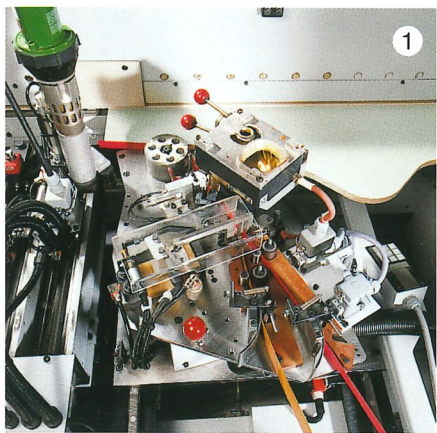
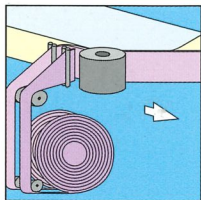
For large profile depths the rough contour is formed by two finger cutters with continuous path control. Two units then neatly trim the final contour synchronously and in counter rotation. The path motion of the cutters is generated via servo-drives (CNC axis). Because of the transport chain's smooth, accurate linear drive ... feed: up to 30 m/min! – an extremely neat cutting pattern is achieved.



Offcuts conveniently removed

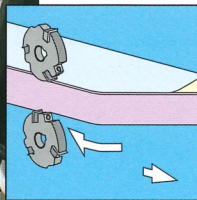
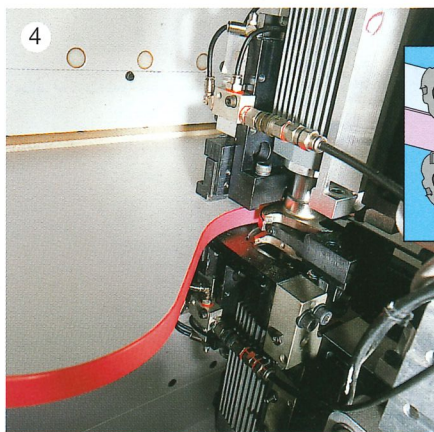
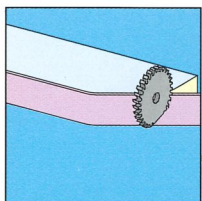
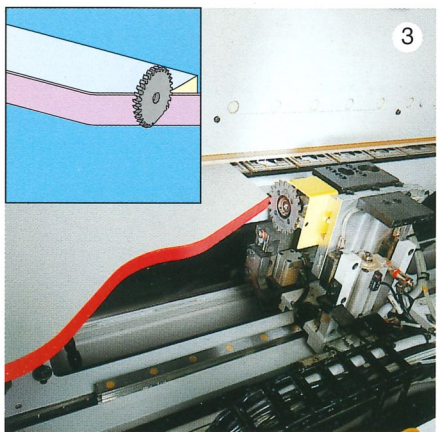
After the profile shape has been cut the offcut drops onto a conveyor belt via a chute in the machine frame and is removed at once.





1) Gluing unit

The gluing unit, controlled via a digital servo-axis, operates with direct glue application (EVA). The user can adjust the height of the entire **pressure zone (2)** for softforming profiles (drum or roof profiles).

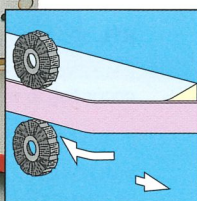
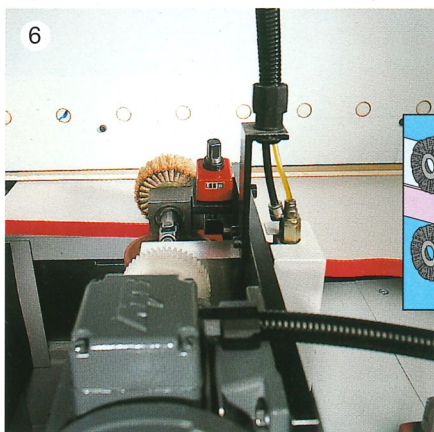
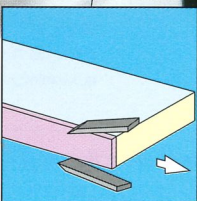
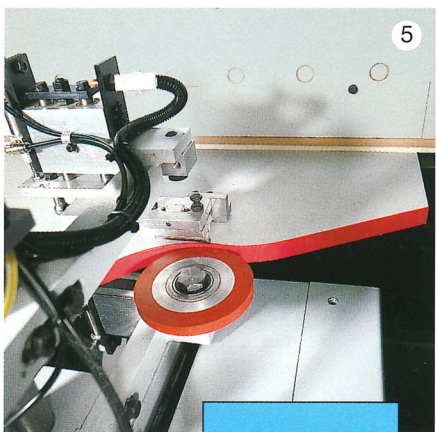


3) End trimming unit

As the initial process in the finishing section the overhanging edges are cut off flush.

4) Flush trimming unit with digital servo-axis

With vertical and horizontal tracing. The unit can also be used for radius or bevel trimming.



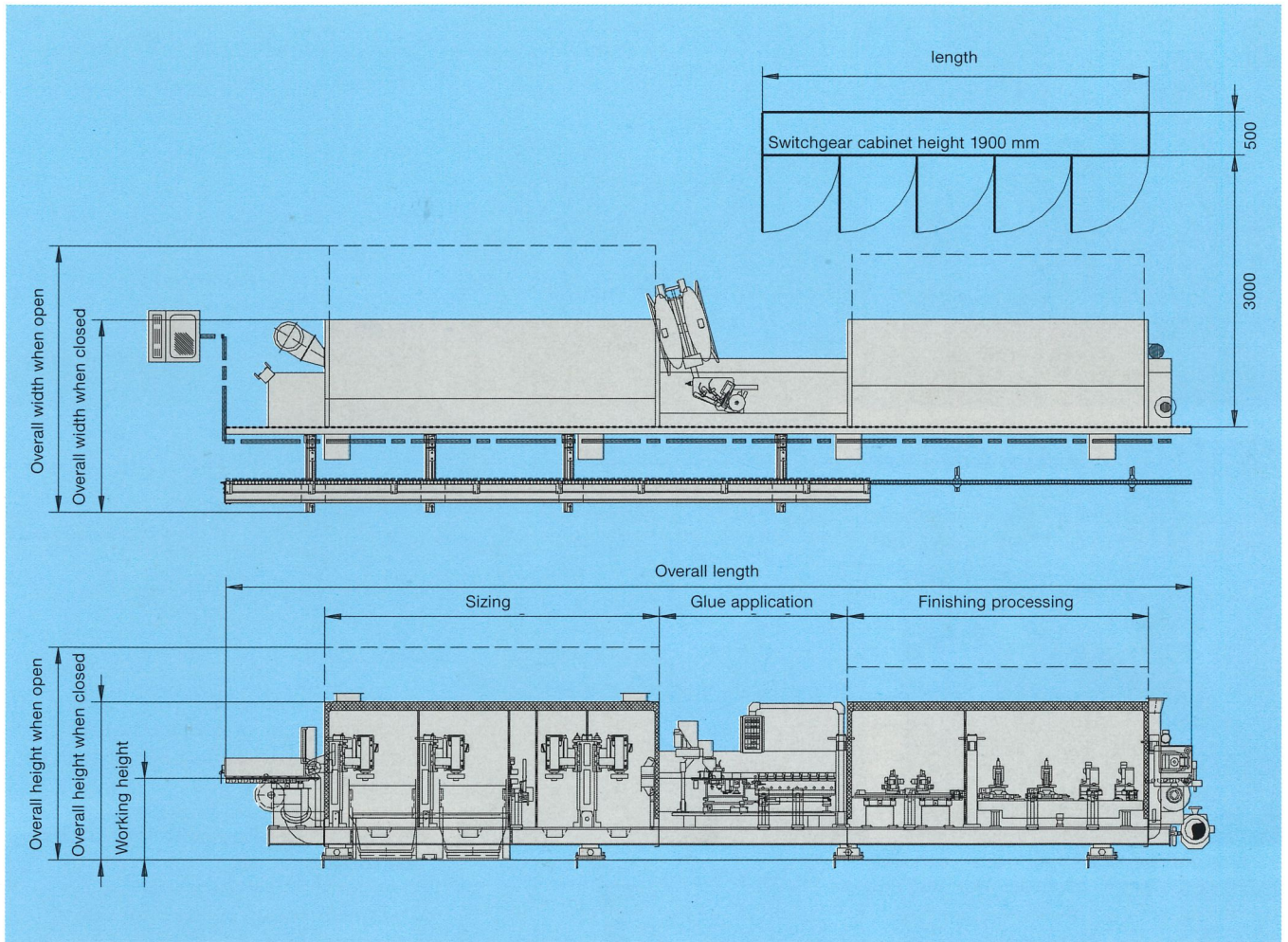
5) Scraping unit

The edge is scraped clean by means of the scraping unit. Glue residius is removed.

6) Buffing unit

For finish processing, with top, bottom and side tracing, again using servo-valve technology.

Technical Data



Machine models

KFL 10/.../CF

KFL 10/.../CF

Machine dimensions

- overall length mm	according to machine model
- sound enclosure closed/open	
overall width mm	2330/3110
overall height mm	1840/2475
- working height mm	950

Connected loads

- overall extraction system m ³ /h	according to fitting
- air speed m/sec.	35
- compressed air consumption nl/min.	according to fitting
- compressed air connection	2 x 1/2" inside thread supply pipe R 1"
- pressure loss mm/WP	250
- voltage/frequency V/Hz	400/50
- total connected electrical load kW	according to fitting

Other

- feed m/min.	6/30
- machine weight approx. in kg	according to machine model

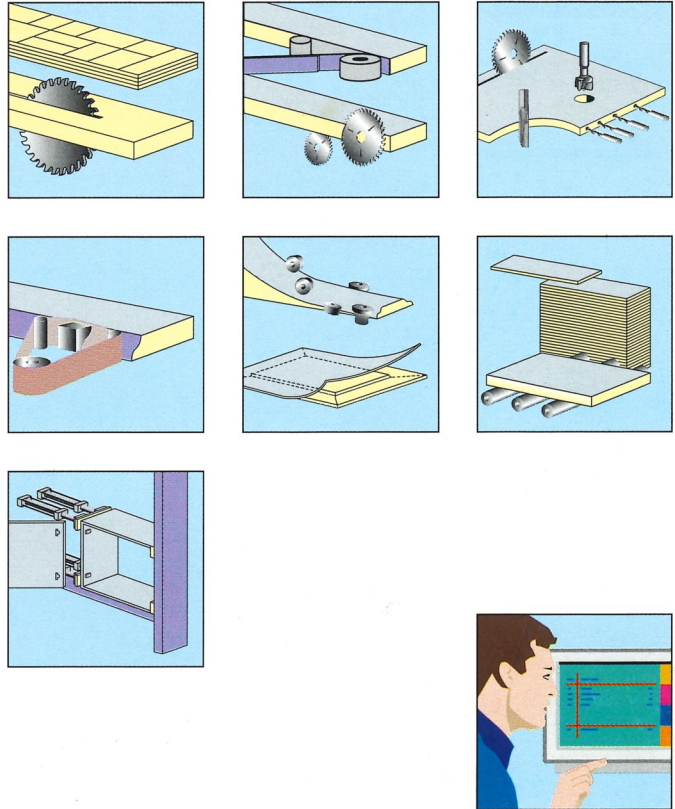
Working dimensions

- workpiece thickness mm	12-30
- workpiece width mm without back pressure	min. 120 + contour depth
- workpiece length mm	min. 250
- contour depth mm	max. 300
- contour inclination angle	max. 45°
- contour inside radius	min. 80 mm, but depends on workpiece

The minimum contour radius depends on the edge profile and the contour.



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