

DESCRIPTION AND CHARACTERISTICS OF COMMODITY

**Edge banding machine EDGETEQ S-500 (PROFI KAL375/18/V25/O3)
Manufacturer HOMAG GmbH (Germany)**

Article no.	Description																
	<p><u>TECHNICAL DATA:</u></p> <table border="0"> <tr> <td>Workpiece thickness</td> <td>8... 60 mm</td> </tr> <tr> <td>Edge thickness</td> <td>0,3... 3 mm</td> </tr> <tr> <td>Feed stepless adjustable</td> <td>16... 25 m/min</td> </tr> <tr> <td>Working height</td> <td>950 mm</td> </tr> <tr> <td>Total connected</td> <td>52,41 kW</td> </tr> <tr> <td>Operating voltage</td> <td>400 V – 50 Hz</td> </tr> <tr> <td>Consumption of compressed air</td> <td>1.208 NL/min</td> </tr> <tr> <td>Suction output</td> <td>6.490 m3</td> </tr> </table>	Workpiece thickness	8... 60 mm	Edge thickness	0,3... 3 mm	Feed stepless adjustable	16... 25 m/min	Working height	950 mm	Total connected	52,41 kW	Operating voltage	400 V – 50 Hz	Consumption of compressed air	1.208 NL/min	Suction output	6.490 m3
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	<p><u>WORKPIECE PARAMETERS:</u></p> <p>Min. workpiece dimensions standard parts:(first measure in feed direction) in case of workpiece thickness 8 - 60 mm:</p> <ul style="list-style-type: none"> - longitudinal processing 240 x 120 mm - crosswise processing 120 x 240 mm <p>Min. workpiece dimensions narrow parts in case of workpiece thickness 8 - 22 mm:</p> <ul style="list-style-type: none"> - longitudinal processing 300 x 60 mm <p>in case of workpiece thickness 23 - 60 mm:</p> <ul style="list-style-type: none"> - longitudinal processing 300 x 100 mm <p>All minimum dimensions apply to the smallest defined workpiece overhang plus edge thickness.</p> <ul style="list-style-type: none"> - workpiece overhang 30 mm - workpiece thickness 8 - 60 mm - Top edge overhang max. 2 mm (for post-processing) - in combination with BF10 or BF20, for the top max. 16 mm however not in conjunction with LaserTec - Bottom edge overhang max. 2 mm (for post-processing) <p>For workpiece dimensions smaller than 240x240 mm an infeed aid is required due to safety reasons, The machine operator is responsible for the use of suitable materials (boards, glues, edging materials, cleaning means, lacquers etc.)</p> <p>When processing workpieces or edge materials</p> <ul style="list-style-type: none"> - without protective lacquer or, - matt surfaces or, - high-gloss surfaces <p>bright streaks might occur.</p> <p>Manual feeding of workpieces with</p> <ul style="list-style-type: none"> - hinge hole drillings, - through-drillings, - crosswise grooving, - cut-outs in the workpiece <p>on the top side with at least 8 mm diameter or groove width and which lay in the clamping zone of the top pressure must not be fed to the machine due to safety reasons.</p> <p>This requirement is only possible by the separate option "safety package for construction elements"</p> <p><u>ELECTRIC EQUIPMENT:</u></p> <ul style="list-style-type: none"> - operating voltage 400 volt, 50 Hz - switch cabinet installed at the machine - installation accord. to European Norm EN 60204 - control of a suction of the customer by 2 relay contacts: - contact 1 to switch on the suction as soon as the feed runs - contact 2 to open the suction flaps as soon as the machine is occupied - Two further terminals for feedback of the suction to release production - The machines are not suitable for connection to a RCD due to operational leakage currents. - Instead the recommendation is to route the supply in such a way as to prevent ground faults or short circuits (e.g. in accordance with DIN VDE 0100-520/521.11). - prescribed environmental temperature: + 10 degrees up to + 40° C (For ambient temperature >40°C only with the option "increase of the cooling power"). - The electrical connection at the main switch is designed for 1-core copper cables. The connection cross-section depends on the main switch size. For other designs or questions about the maximum electrical connection cross-section, please consult the manufacturer. <p><u>SAFETY AND PROTECTION FACILITIES:</u></p> <ul style="list-style-type: none"> - EC conformity (CE) according to the currently valid Machinery Directive for individual machines in operation 																

	<ul style="list-style-type: none"> - according to the Machinery Directive an additional EC conformity certificate for linked machine operation (cells/plants) is required in the defined countries. - wood dust protection max. 2 mg/m³, subject to the required extraction capacity being provided by the customer according to the suction plan - surface sound pressure level: The surface sound pressure level LA is equal or less than 90 dB(A), taking as a base the condition defined in DIN EN ISO 18217:2015 - part 12: edge banding machines The noise level of 85 dB(A) which is max. allowed at the working place, can only be achieved in most cases by means of a complete protection. <p><u>HOMAG QUALITY KIT:</u></p> <ul style="list-style-type: none"> - TÜV certificate accord. to DIN EN ISO 9001:2015 - energy-efficient drives accord. to the EU no. 640/2009
0865	<u>FEED STEPLESSLY ADJUSTABLE 16-25 M/MIN</u>
0467	<u>FIXED STOP SIDE ON THE LEFT</u>
0474	<u>WORKPIECE THICKNESS 8 - 60 MM</u>
0702	<p><u>CONSTRUCTION ELEMENTS</u></p> <p>Workpieces with longitudinal groove. Standard sizes for longitudinal grooves in cover layers (indicated for WÜ30):</p> <ul style="list-style-type: none"> - width of longitudinal groove 1 - 10 mm - depth of longitudinal groove 1 - 20 mm - distance to glue joint min. 4 mm, max. 27 mm (depending on groove width) - the use of the post-processing units is depending on groove position and groove width <p>Workpieces with hinge holes. Standard sizes for hinge hole drilling:</p> <ul style="list-style-type: none"> - distance glue joint min. 5 mm (with servo in longitudinal pass ↓ snipping unit) - distance glue joint min. 4,5 mm in cross pass - diameter 8 - 35 mm
1006	<u>PANEL OVERHANG FIX</u> set to 30 mm at the factory
0216	WORKING HEIGHT 950 mm
0472	<u>FEED INTERLOCKING</u> with other machines in the line
9119	<u>FOIL/HIGH GLOSS PACKAGE ON TOP AND BELOW</u>
0442	<p><u>AIR CUSHION TABLE FREE-STANDING</u> at the machine front</p> <ul style="list-style-type: none"> - dimensions: 2020 x 420 mm - Incl. fan - for easy handling of returned workpieces
0171	<p><u>SLIDING CARRIAGE</u></p> <ul style="list-style-type: none"> - for rectangular panel infeed in case of single-sided processing - rigid linear guidance for precise working - panel dimensions max. 350 x 1600 mm
0395	<p><u>ALIGNMENT OF THE WORKPIECE AT THE INFEED</u></p> <p>infeed fence automatic</p> <ul style="list-style-type: none"> - for machines with a preceding jointing part - length before infeed interlocking: 600 mm
0261	<p><u>PANEL SUPPORT WITH ROLLER GUIDE</u></p> <ul style="list-style-type: none"> - movable by 700 mm on permanently mounted floor supports - working width 1000 mm
0466	<p><u>INFEED INTERLOCKING</u></p> <ul style="list-style-type: none"> - infeed interlocking pneumatically controlled
0473	<p><u>WORKPIECE TRANSPORT DEVICE</u></p> <p>workpiece transport device:</p> <ul style="list-style-type: none"> - transport chain with rubber coating, 80 mm wide - hardened precision running and guiding surfaces - magnetically braked transport chain <p>Automatic chain track lubrication</p> <ul style="list-style-type: none"> - store tank for oil - oil level control

	- lubrication pressure monitoring
0470	<p><u>TOP PRESSURE</u></p> <ul style="list-style-type: none"> - compound V-belt - electronic height adjustment - height adjustment of the post-processing units simultaneously with the top pressure - mechanical digital position read-out <p>Top pressure motor-driven Small parts kit</p> <ul style="list-style-type: none"> - continuously close roller lever distance 50 mm instead of 80 mm on the top pressure - minimum panel length in feed direction from 120 mm
9403	<p><u>TFU140/25/10</u></p> <p>Return system for panel-shaped workpieces</p> <ul style="list-style-type: none"> - Air table L= 2500 mm, W = 1400 mm (diagonally positioned with height difference of approx. 100 mm) - Top roll pressure with roller strips and air wheel - Switch cabinet with process control and sensors - Conveyor belt: see layout - With fixed roller strip on the inside, distance to edge approx. 1400 mm - Non-powered roller conveyor designed as jam line or air table with lift - Safety equipment for CE conformity consisting of: <ul style="list-style-type: none"> - Pull cord lengthwise to the return belt - Crosswise multi-beam safety light barrier in the aisle between the return and the edge banding machine - Additional Emergency stop button in the aisle between the return and edge banding machine - Creep zone protection
2531	<p><u>Workpiece detection sensor</u></p> <p>Return path processes are controlled via the vertical workpiece recognition.</p>
9417	<p><u>Return path</u></p> <p>Transport unit for returning the workpieces to the machine operator. Belt cleaning with a rigid brush mounted from below.</p>
2532	<p><u>Inner workpiece support</u></p> <p>Support for supporting wide workpieces.</p>
2542	<p><u>Air cushion table with lifting function</u></p> <p>Air table with lift at the end of the return path to compensate for the difference in processing height between edge processing machine and return section, while at the same time allowing for simplified part handling.</p> <p>Technical data:</p> <ul style="list-style-type: none"> - table length 2500 mm - table width 1250 mm - processing height, upper (+/- 30 mm) 950 mm - Lift (from processing height = 850/870 mm) stroke approx. 80/100 mm
9532	<u>FORMAT PACKAGE</u>
0255	<u>SEPARATING AGENT SPRAYING UNIT</u>
0485	<u>JOINTING TRIMMING UNIT S2 – BASIC</u>
0640	<u>SET OF DIAM. JOINTING CUTTERS WD40</u>
2326	<u>PANEL PRE-HEATING UP TO 60 MM PANEL THICKNESS</u>
0557	<p><u>GLUE APPLICATION SYSTEM</u></p> <p>Glue type: EVA or PUR is suitable.</p> <p>1st station EVA melting unit with granular container Basic. In case of PUR melting a Manual filling of PUR glue is needed.</p>
0519	<p><u>Application unit</u></p> <p>QA65-P application unit</p>
9958	<u>SWAP CONTAINER EVA 2,5-4KG/H</u>
0557	<p><u>GLUE APPLICATION SYSTEM</u></p> <p>Glue type: PUR or EVA is suitable.</p> <p>2nd station PUR melting with filling from PUR cylindrical container.</p>

	In case of EVA melting a Manual filling is needed.
2038	<u>SWAP CONTAINER PRE-MELTING UNIT PUR 2,5-4 KG/H</u>
0519	<u>Application unit</u> QA65-P application unit
0519	<u>Application unit</u> QA65-P application unit (extra glue-pot can be used for another glue colour. Quick change of application unit on the machine)
0490	<u>AIRTEC ACTIVATION UNIT</u>
0475	<u>EDGE MAGAZINE</u> Roll material and single strip edges (as fixed length edges pack). For the processing of roll material up to max. 3 mm and single strip edges/solid wood strips up to max. 12 mm thickness. EDGE HOLDING-DOWN DEVICE STEPLESS - for automatic adjustment in case of different edge heights Magazine height adjustment manually - magazine height adjustment via spindle 0 to -5 mm.
0571	<u>6 COIL SEATS</u> Magazine is able to contain 6 Rolls of different edges
0477	<u>PRESSURE ZONE</u> pressure zone C 7 rollers - 1 driven prepressure roller, diameter 150 mm - 6 postpressure rollers, diam. 70 mm - pneumatic pressure adjustment Automatic adjustment pressure zone S-500 For automatic adjustment of the pressure zone in case of varying edge thicknesses. <u>WETTING DEVICE PRESSURE ZONE</u> - Coating of the first press roller to avoid glue deposits - Stripping device for all press rollers
0254	<u>COOLING/LUBRICANT SPRAYING UNIT</u>
0516	<u>SNIPPING UNIT PK25</u> For snipping the edge overhangs at the front and rear edge. Manual adjustment chamfer snipping stop - adjustment of the chamfer snipping stop to different edge thicknesses manually
0636	<u>PARTITION WALL FOR DUST PROTECTION</u> (between aggregates)
0508	<u>ROUGH TRIMMING UNIT BF10</u> PNEUMATIC ADJUSTMENT OF ROUGH TRIMMING UNIT BF10+20
0514	<u>SET OF I-TCT CUTTERS STRAIGHT</u> - 2 I-TCT cutters 70x25 mm, t=4, HSK 25 R with integrated chip collecting system
0537	<u>MULTITRIMMING UNIT MF21</u>
9959	<u>I-DIA 45° CHAMFER SPECIAL TRIMMER PMMA FOR MF21</u> HSK 25 R, Z=6 with integrated chip collection
0349	<u>PROFILE TRIMMING UNIT FK30/V20</u>
0314	<u>TRIMMING UNIT FK30/31 FOR 3 TOOLS</u>
0984	<u>I-DIA TOOL FK30/31 3 RADII</u> I-DIA cutters basic diameter 80 mm, Z=4 for 3 radii and 1 chamfer - radius 1 = 2.0 mm - radius 2 = 1.5 mm - radius 3 = 1.0 mm - chamfer 1 = 15° on the outlet angle of the radius
0481	<u>MULTI SCRAPER MN21 AUTOMATIC</u>

9960	<u>45° CHAMFER SPECIAL SCRAPER PMMA FOR MN21</u> 2 carbide knives designed for seven profiles: - chamfer 45 degrees, especially for processing edge material in combination with PMMA cover layer material (e.g. Rauvisio Crystal, glass laminate), bevel size max. 3x45°. - chamfer 20 degrees, R=1.0 / R=1.3 / R=1.5 / R=2 / R=3
0256	<u>DETERGENT SPRAYING UNIT</u> - spraying unit for application of detergent onto the panel upper and lower side - without detergent liquid (filling on the user account and responsibility)
0381	<u>GLUE JOINT SCRAPER FA20 BASIC</u> Automatic adjustment tracing FA20 - for adjustment of the tracing relative to the workpiece on top and bottom - stepless adjustable, e.g. for parts with / without foil
0155	<u>EDGE BUFFING UNIT FP10 TOP + BOTTOM</u>
0379	<u>POWERCONTROL PC23 POWERTOUC</u>
6163	<u>EMERGENCY INTERLOCKING DISRUPTION</u>
6530	<u>NETWORK CONNECTION ETHERNET</u>
6340	<u>Wired manual operation for run-in mode</u>
9202	<u>woodCommander 5</u> basic package
0780	<u>MACHINE DATA RECORDING</u> MMR BASIC
6281	<u>FLEXIBLE EDGE SEQUENCE CONTROL SOFTWARE</u>
0780	<u>Record and evaluate machine data</u> – MMR
0779	<u>Diagnosis system</u> woodScout
6365	<u>RESETTING IN THE GAP FOR S-500</u> For higher productivity.
6230	<u>SPEED ADAPTATION FOR LINE CONTROL</u>
6629	<u>TOOLMANAGER</u>
0970	<u>BARCODE READING SYSTEM PACKAGE PROFESSIONAL</u>
0704	<u>MMR OFFICE LITE (SINGLE-SEAT LICENCE)</u>
8315	<u>Language selection: German, Lithuanian</u>
0001	<u>Optimat XES200</u> service station Preheating station for application unit QA Machine for emptying, cleaning and preheating of the hot melt glue application units of HOMAG edge banding machines.
2123	<u>ADAPTER + COLLECTING TRAY QA34/65/P/75I LEFT</u>