

# **Brandt Automatic Edgebander KDF 770 2C Servo with Quickmelt**

## **PC-20 Program Control**

- PC: Industrial PC, 600 Mhz, Front side USB port.
- Memory: 256 Mb ram, 1 Gb Flash Card.
- Screen: 12.1" Color, 800 x 600 pixel, Active TFT Screen.
- Internal modem for remote diagnostic link

**Motorized top pressure beam** via program control. Smooth pressure rollers.

**Feed speed variable 39-65 FPM.**

**Joint trimming unit** for pre-trimming the work piece edge prior to processing.

**Quick-melt granulate glue application system** with approximately 12 minute heat up time.

Quick-change glue tank for easy maintenance and quick change color changes if necessary.

Infrared heating unit positioned between glue roller and pressure zone contributes to improved edge quality.

**Four roller pressure zone** with motorized program control indexing.

**End trimming unit** with straight and chamfer trim capability. Chamfer up to 15°. Pneumatic indexing from straight to bevel end trimming.

**Flush trimming unit** with two position vertical indexing via program . Includes straight ( 15mm ) insert cutters.

**Fine trimming unit** with DFC cutter head technology, servo motor control for side copy positioning and to edge thickness for the unit. Auto tilt. Radius / straight DFC cutters included. This unit provides superior dust flow control of the trimmed chips and provides precise trimming due to location of the vertical copy rollers.

**Contour trimming unit** for profile corner trimming at 16 m/min = 52 FPM.

**Scraping unit** with top, bottom and side tracing device for machining or rounding of pre-trimmed PVC edges. Program controlled pneumatic indexing.

**Surface scraping unit.**

**Oscillating Jump Buffing unit** with two motors. Inclinable and adjustable vertically and horizontally. Cloth wheels included.

Electrical components according to UL/CSA Listings. Meets CE safety regulations.

**Technical Specifications**

Edge band thickness	0.4 - 15 mm (0.016" - 5/8")
Coil cutoff max.	0.8 x 60 mm 3.0 x 45 mm (PVC)
Edgeband height	12 - 65 mm (1/2" - 2 9/16")
Panel length min.	160 mm (6 3/8")
Panel width min.	65 mm (2 1/2")
Panel thickness - min. - max.	8 mm (5/16") 60 mm (2 3/8")
Feed speed – variable 8-20 m/min.	20 m/min (65 FPM) for edge thickness up to 3mm. 16 m/min (52 FPM) for edge thickness over 3mm.
Joint trimming unit Cutter speed	2.2 kw ( 3 HP ea ) two motors 12,000 RPM
Pressure section	First roller driven, three rollers idle
End trim unit - two motors Cutting speed	0.35 kw (1/2 HP) 12,000 RPM
Flush trimming unit Cutter speed	0.55 kw (3/4 HP ea) 12,000 RPM
Fine trimming unit Cutter speed	0.55 kw (3/4 HP ea) 12,000 RPM
Contour trimming unit Cutter speed	0.4 kw (1/2 HP ea) two motors 12,000 RPM
Machine length	6860 mm (22' 6)
Machine width	1650 mm (65")
Working height	850 mm (33 1/2")
Total height	2000 mm (78 3/4")
Machine net weight	3000 kg ( 6600 lbs. )

Amperage: 60 amps @ 230 volts, 30 amps @ 460 volts.

Total power required: 18 kw.

Electrical connection: 208/230 or 440/480 volt, 3-phase, 60 Hz.

Dust extraction: 2x 120 mm ( 4 3/4" ) 1200 CFM, 1x 100 mm ( 4" ) 500 CFM.

Compressed air connection: 0.18 CFM per panel, 7 bar (100 PSI).

**Motorized Height Adjustment for the Top Pressure Beam**

**Controls Mounted at Infeed of Machine for Operator Convenience**

### **PC-20 Controller with Integrated Line Control System**

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### **Joint Trimming Unit**

- pre-trimming of the workpiece edge prior to gluing
- two motors, 3 HP each, 12,000 RPM
- one motor clockwise rotation, one counter-clockwise
- vertical spindle adjustment via digital settings
- horizontal positioning via electro-pneumatic control
- dust extraction hood included with 120 mm diameter outlet ( 4 ¾ “)
- diamond cutter heads.

### **Automatic Magazine for Strip and Coil Feeding**

- large coil table (800 mm diameter) with built-in rollers to allow for 3 mm PVC coils
- edge-strip capacity from 0.4 mm to 13 mm (0.016” – 1/2”)
- direction of glue roller reversible
- glue roller section is also retractable from fence line
- **motorized pressure zone** via program control
- one large driven pressure roller with pneumatic pressure control
- three secondary rollers, all with controlled side pressure
- strengthened pre cutter for cutting thick PVC edges from the coil; maximum 3 x 45 mm; precutting system equipped with air volume reservoir for on-demand activation required for short workpieces

### **Quickmelt Gluing System**

- large granulate hopper with automatic glue feed system
- pneumatic positioning and locking system
- heat-up time is twelve minutes
- pre-melting unit between hopper and glue roller (required for glue demand of thick, long workpieces)
- quick-change glue tank for easy maintenance and glue color change, if necessary
- infrared radiant glue heat zone control for optimum gluing strength

### **Sound Cover**

- equipped with three independent openings
- safety interlock system - when sound enclosure door is opened, corresponding work station shuts off
- end trimming, flush and fine trimming motors are each equipped with electronic motor brakes to stop cutter rotation when hood is opened or when station is shut off at operator control panel

### **End Trimming Station**

- straight/chamfer end trim unit equipped with two 0.35 kw (1/2 HP) 12,000 RPM motors; electronic motor brakes
- end trim unit utilizes drawing cut system for reduced blade projection when working on thick panels
- tooling also included
- program controlled pneumatic indexing from straight to bevel end trimming

### **Flush Trimming Unit**

- equipped with two .55 kw (3/4 HP) 12,000 RPM trimming motors
- electronic motor brakes
- **vertical tracing wheels** with 2 position vertical indexing
- each trimming motor is equipped with one dust hood and dust extraction hose
- equipped with two straight cutter-heads, including four knife carbide inserts flush trimming possible up to 15 mm edge thickness

### **Fine Trimming with DFC Cutter Head and Servo motor control**

- equipped with two .55 kw (3/4 HP) 12,000 RPM trimming motors
- electronic motor brakes
- **horizontal and vertical tracing wheels**
- auto tilt feature
- each trimming motor is equipped with one dust hood and dust extraction hose
- equipped with two radius cutter heads, including four knife carbide inserts.
- **servo motor controlled positioning of the work units and side copy to edge thickness**

### **Contour Trimming Unit**

- for rounding front and trailing corners of workpieces with 3 mm PVC edgings
- operates at **16 m/min. ( 52 FPM )**
- includes two trimming motors 0.4 kw (1/2 HP) 12,000 RPM; electronic motor brakes
- equipped with 3 mm radius insert cutter heads

### **Scraping Unit with Knives**

- for scraping of roughly trimmed thick PVC edges in order to remove the cutter marks
- 3 mm radius reversible profile knives standard
- program controlled pneumatic indexing

### **Surface Scraping Unit**

#### **Top and Bottom Oscillating Jump Buffing Unit**

- top and bottom buffing motors for finishing of longitudinal edges
- two 2800 RPM polishing motors
- inclinable vertically and horizontally
- two buffing wheels included

**Price** **\$ 138,980**  
F.O.B. Shipping Point

**Leasing Option**

Stiles Machinery offers a variety of flexible financing options to meet your needs. Contact your sales representative for a detailed leasing quote at current rates.

**Installation** **\$ 3,550**

All inclusive. Any required change of voltage will be performed at time of installation, not prior to shipment.

**IN CASE OF INCOMING MAIN VOLTAGE FLUCTUATIONS OF MORE THAN +5%/-5% OF MACHINE CONNECTED VOLTAGE, A VOLTAGE STABILIZER MUST BE INSTALLED BY THE CUSTOMER ON THE INCOMING POWER CONNECTION.**

**STILES SHOP SOLUTIONS STANDARD TERMS AND CONDITIONS OF SALE ARE APPLICABLE.**

**Delivery**

Available for shipment from Place of Inventory, after receipt of official order with down payment and clarification of all technical details; subject to prior sale.

**Terms of Payment** **(Subject to Credit Approval)**

- 30% down payment with order
- 30% due prior to shipment from Inventory
- 30% due upon arrival of machine to customer's plant
- 10% due upon installation or thirty (30) days after delivery of machine to customer's plant, whichever occurs first

**Installation**

Stiles Machinery Inc. cannot be held responsible for any delays caused by customs authorities.

Stiles Machinery defines installation as the assembly and preparation of the machine to the 'ready-to-run' state; it does not include any preparation of the site, floor, anchoring of machine to floor, masonry work, running of electrical, pneumatic or dust extraction services to the site, or building alterations.

Your Company is responsible for the off-loading and positioning by crane, forklift or other means, as well as supplying the necessary equipment to perform this task. At your Company's request and expense, a Stiles field service representative can be made available during the off-loading and positioning in order to act in an advisory capacity, but this is to be understood as fully at your own risk. Moving and modifying existing machinery in your facility is not included in the installation.

Once the machine is in the "ready-to-run" state and the necessary services have been provided, the field service representative will test run, adjust as necessary, demonstrate, and instruct your personnel who are selected to operate and maintain this machine. The field service representative will also review the manuals supplied for this equipment.

Programming of customer patterns/samples is not included. Our field service representative will demonstrate to your personnel how to enter your patterns/programming into the control as part of the installation. If additional instruction is requested, our field service representative will be available at the current published service rates.

### **Terms & Conditions**

All equipment listed is offered subject to our General Conditions of Sale. Machine to be wired according to U.L. standards. If specific or unusual local regulations require inspection(s) and/or permit(s), the cost of such is the responsibility of the buyer. Terms of payment offered herewith, or any terms agreed upon, are subject to proper credit approval. Due to fluctuations in currency exchange rates and freight costs, all prices are subject to confirmation or revision at time of order.

The price quoted is to be understood for delivery, F.O.B. Port of Entry/Place of Inventory, U.S. Customs duty paid. Price of additional equipment, if any, valid only when installed at the factory during construction of the machine, and/or shipped with original machine. Technical description and data subject to change or modifications without notice. Our offers are contingent upon strikes, accidents to machinery by carriers, or any other cause beyond our control.

Unless specifically stated otherwise within the terms of this proposal, Stiles has no responsibility for staging, alignment or any other preparation of parts, panels or other materials fed into or otherwise introduced into the equipment covered by this proposal or for any unloading, stacking, routing, storing or any other disposition of parts, panels or other materials exiting such equipment.

This offer is valid for thirty (30) days.