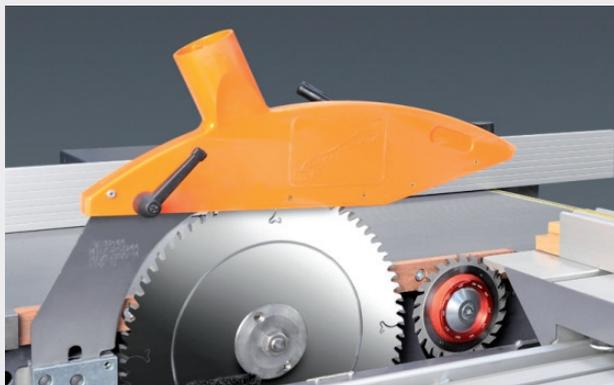


3B PANELS MANUAL CUT



TABLE SAW MACHINE EQUIPPED WITH SCORING BLADE

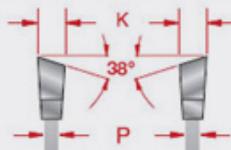
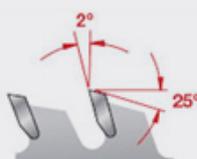
Avoiding tearout when cutting melamine and polimeric sheets.



TIPS FOR A CORRECT TYPE OF BLADE FOR PANELS

TOOTH'S FEATURES

High Alternate Top Bevel
(HiATB) Tooth Design
produces splinter-free cuts



BLADE'S FEATURES



D mm	250	300
Teeth	80	96
Arbor	30	30
Kerf (K)	3,2	3,2
Plate (P)	2,2	2,2

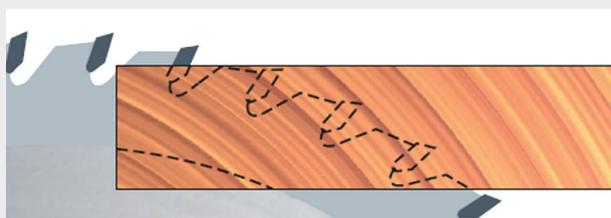
D: Cutting diameter

BLADE HEIGHT

TOOTH'S FEATURES

You should have a blade
height which is about
10 mm above the board.

Each tooth travels a greater distance
and there are more teeth engaged in
the cut at a time.

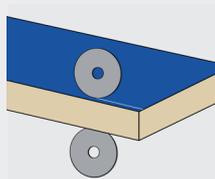
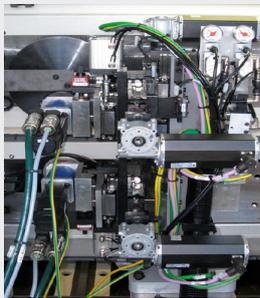


BASE ISTRUCTIONS FOR EDGE BANDING MACHINE



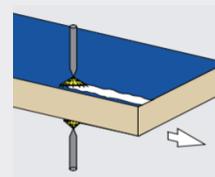
① PRE-CUTTING PROTECTIVE FILM DEVICE

It prevents the lifting of the protective film on the jointing trimming



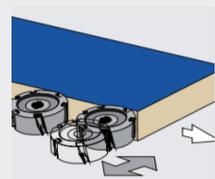
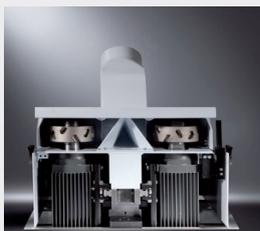
② SEPARATING AGENT SPRAY

It prevents the adhesion of hot melt glue residue on the top and bottom of components, so creating optimum component quality.



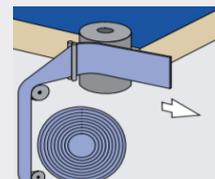
③ JOINTING TRIMMING

This unit permits a high level processing precision, preparing the component for high-quality gluing without chipping and foil lifting.



④ HOTMELT GLUING UNIT

For processing coil material from 0.3–3 mm.

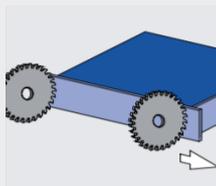


The separating agent spraying unit and the jointing trimming unit ensure an optimum preparation of components for gluing. The sprayed separating agent application simplifies the removal of glue residue. The jointing trimming unit provides a perfect basis for splintered-free glue joints with a consistently high standard product quality.

Gluing units for a fast, positive-locking glue bond. Eva pre-melting unit. Heated glue roller ensures an optimum gluing temperature. Magazine height adjustment for different edge heights to be processed with a consistent component thickness. The gluing unit can also be equipped with a pu pre-melting unit allowing rapid changeover between two different colours or pu glues.

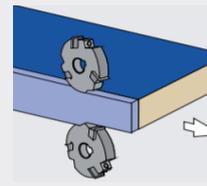
⑤ SNIPPING UNIT

Clean snipping cut of overhanging edges on leading and trailing component edges.



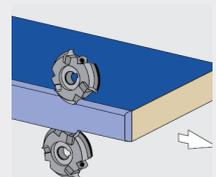
⑥ ROUGH TRIMMING UNIT

For rough trimming the upper and lower edge overhang.



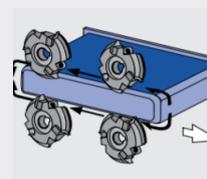
⑦ FINE TRIMMING UNIT

For trimming chamfers and radii with manual adjustment.



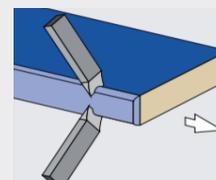
⑧ PROFILE TRIMMING

Profile trimming – for rounded edges. Universal profile trimming units to program any profile. Profile trimming units permit both corner rounding and trimming of upper and lower projecting edges.



⑨ PROFILE SCRAPER UNIT

For smoothing trimmed edges to achieve an optimum appearance.



⑩ FINISH PROCESSING

Glue joint scraper unit for disposal of glue residue at the top and bottom of plastic edges and a buffing unit.

