CONFINDUSTRIA VENEZIA
AREA METROPOLITANA DI VENEZIA E ROVIGO

LanfRedini

AUTOMATIC LINE FOR PRODUCTION OF WOODEN WINDOW FRAMES

Complete CNC line for performing tenoning, drilling and profiling on window and door elements as per the attached layout.

TS. DESCRIPTION

01 MOULDER LOADING TABLE

02 4 SHAFT MOULDER

03 LOAD BELT l=6500 mm

04 RIGHT UNILATERAL TENONING MACHINE

05 ROLLER CONVEYOR

06 CONNECTION TAPE

07 LEFT UNILATERAL TENONING MACHINE

08 ROLLER CONVEYOR

09 CONNECTION TAPE L=4400 mm

10 3+3 HEADS LINEAR DRILLING MACHINE

11 CONNECTION TAPE l=6400 mm

12 LEFT ONE-SIDED PROFILING MACHINE PMS

13 "Z" TRANSFER WITH BUFFER

14 RIGHT SINGLE-SIDED PROFILER PMD

15 UNLOADING TABLE LINE

16 COMPLETE LINE CONTROL AND SUPERVISION SYSTEM

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Associated

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TECHNICAL DATA OF THE LINE:

Minimum working length: 280 mm (at shaving) + tenons

Maximum working length: 3000 mm (including tenons)

Minimum working width: 40 mm

Maximum working width: 100 mm

Minimum working thickness: 40 mm

Maximum working thickness: 100 mm

Power supply:

Main voltage: 400 V three-phase

Frequency: 50 Hz

Pneumatic supply: Compressed

air pressure: 6 Bar

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SUPPLY DESCRIPTION

TS. 01

MOULDER LOADING TABLE

Composition:

- No. 1 motorized stainless steel flat-chain table for lateral movement of workpieces,

workpiece storage table and No. 9 workpiece stop stations

- No. 1 pneumatic side pusher device for 90° translation of workpieces mechanically adjustable according to the width of the workpiece

- No. 1 pneumatic workpiece introducer in the machine of any length in sequence,

with 600 mm stroke, and hooks reset system

Technical characteristics:

- Total width of chain table: 2500 mm (approx.)
- Total length of chain table: 2200 mm (approx.)

TS. 02

4 SHAFT MOULDER

Technical characteristics:

- Input table length: 2500 mm
- Maximum table height adjustment: 10 mm
- Towing motor power: 5 HP
- Continuously adjustable feed speed: 6÷24 m/min
- Pneumatic pressure rollers: max 6 bar
- Feed rollers Ø: 140 mm
- Feed roller width: 50 mm

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- Axial adjustment vertical shafts: 40 mm
- Axial adjustment horizontal shafts: 20 mm
- Motorized height adjustment of the towing system.
- Side pressure roller opposite to the RIGHT vertical shaft.
- Suction hood on each engine.
- Soundproofing cabin.

Equipment:

Base made of a single cast iron that maximizes vibration absorption.

Full gimbal towing, without drive chains.

Wear-resistant work surface and guide made of hardened chrome.

Continuously adjustable feed rate.

Pneumatic pressure rollers to compensate for wide variations in part thickness.

Automatic lubrication for the sliding surface.

Motorized upper pressure rollers and No. 2 motorized lower roller units on the surface.

Dual controls for adjusting the shaft on the upper thickness and forward/backward displacement.

Lighting in the hood.

EC Standards

Electronic adjustment of working height.

Electronic adjustment of working width.

Special extractor device for short piece output.

Composition:

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Pos. 1 Bottom planer motor 7.5 kW 6000 rpm - Tool Ø: 125÷160 mm Shaft size:

Ø40x240 mm

Item 2 DX planer motor 5.5 kW 6000 rpm - tool Ø: 112÷200 mm shaft size:

Ø40x160 mm

Pos. 3 SX planer motor 5.5 kW 6000 rpm - tool Ø: 112÷200 mm shaft size:

Ø40x160 mm

Item 4 Upper planer motor 7.5 kW 6000 rpm - tool Ø: 100÷200 mm shaft size:

Ø40x240 mm

TS. 03

LOAD BELT l=6500 mm

Composition:

- No. 1 motorized belt conveyor, adjustable speed and with manually adjustable piece reference guide

Technical characteristics:

- Useful belt working width: 250 mm
- Total tape length: 6500 mm (approx.)

TS. 04

RIGHT UNILATERAL TENONING MACHINE

Single-sided tenoning machine with double transport chain, with motors on the right side only, for tenoning workpieces.

Technical characteristics:

- Heavy carpentry structure.

• Seasoned cast-iron motor and carriage-crossing columns with ground dovetail guides. System for single-point manual lubrication of all carriage-crossing contact surfaces.

• Chain composed of cast iron sliding links, with joint pins, on bearings lubricated for life.

• Positioning of chains at a fixed distance of 1000 mm.

• Series of intermediate supports to drag tracks for workpieces less than 1000 mm in length.

• Series of supports for parts longer than 1000 mm.

• Motor-side introduction guide, with manual horizontal adjustment and position display by decimal display.

• Motorized roller conveyor in and out of the machine, adjustable roller conveyor feed speed (N.B. Roller conveyors are positioned between the transport tracks). The conveyor is sized to support workpieces up to 3000 mm in length.

• Pneumatic hook mounted at machine inlet, for holding workpiece against drag

bar.

• Feed rate with gear motor.

• High-strength ground steel drive shaft.

• Complete chain coating with white oil-resistant and stain-resistant rubber plates (80 sh).

• Drive rods (roller shutter type) with standard 800 mm spacing.

• Press shoulders (twin track) with electrical vertical adjustment and position display (working thickness) by decimal display. Pressing by means of V-belts made of stain-resistant rubber, motorized by inverter synchronized with the advancement of the chains.

• Stand-alone electrical cabinet supplied with 3 m of cables for connection to the machine.

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MACHINE TECHNICAL DATA

Minimum working length: 280 mm (to the shaving)

Maximum working length: 3000 mm (including tenons)

Worktable height: 960 mm

Composition:

Pos. 5 BLADE

Rotational speed: 3000 rpm

Tool diameter: 350 mm max.

Complete with:

- Cross trolley with:
  - Manual horizontal displacement with screw and decimal indicator
  - Manual vertical displacement with screw and decimal indicator
- No. 1 fume hood
- electronic braking device

Pos. 6 1st VERTICAL TOUPIE

Rotation speed: 3750 rpm controlled by inverter Shaft:

Ø50x600 mm

Tool diameter: 180 mm min - 320 mm max Complete

with:

- Cross trolley with:
  - NC-controlled electronic horizontal displacement with AC motor
  - NC-controlled electronic vertical displacement with inverter-driven AC motor

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- automatic splinter guard device with pneumatic intervention

- No. 1 fume hood

- electronic braking device

Pos. 7 2nd VERTICAL TOUPIE

Rotation speed: 3750 rpm controlled by inverter Shaft:

Ø50x600 mm

Tool diameter: 180 mm min - 320 mm max Complete

with:

- Cross trolley with:

  - NC-controlled horizontal displacement with AC motor
  - NC-controlled vertical displacement with inverter-driven AC motor

- automatic splinter guard device with pneumatic intervention

- No. 1 fume hood

- electronic braking device

Item 8 HORIZONTAL DRILLING GROUP

- Cross trolley with:

  - NC-controlled electronic horizontal displacement with brushless motor
  - NC-controlled electronic vertical displacement with brushless motor
  - pneumatic longitudinal displacement
  - Longitudinal displacement electronic reference hook on NC-controlled workpiece with brushless motor

- No. 1 fume hood

- electronic braking device

PROTECTIVE CABIN AND SOUNDPROOFING TO CE STANDARD ON BOARD MACHINE

Complete with:

Access doors with sliding opening. Opening is managed by a timed control that allows it only when the motors come to a complete stop. Walls made of high-density sound-absorbing material, fire-resistant class 0, coated internally with a sheet of glass tissue and perforated sheet metal.
Internal lighting provided by watertight lamps. Inspection windows made of breakthrough and noise-proof glass.

TS. 05

ROLLER CONVEYOR

Composition:

- No. 1 motorized roller conveyor, of which the first part is inclined, adjustable speed and with manually adjustable workpiece reference guide

Technical characteristics:

- Useful working width roller conveyor 1st part: 650 mm
- Useful working width roller conveyor 2nd part: 250 mm
- Total roller length: 4800 mm (approx.)

TS. 06

CONNECTION TAPE

Composition:

- No. 1 motorized belt conveyor, r egular speed and with reference guide

manually adjustable pieces

Specifications:

- Useful belt working width: 250 mm
- Total tape length: 4500 mm (approx.)

ST. 07

LEFT UNILATERAL TENONING MACHINE

Single-sided tenoning machine with double transport chain, with motors on the left side only, for tenoning workpieces.

Technical characteristics:

- Heavy carpentry structure.
- Bridge structure to support the slider for part sizing. The slider is positioned by a rack and pinion mechanism
- Seasoned cast-iron motor and carriage-crossing columns with ground dovetail guides. System for single-point manual lubrication of all carriage-crossing contact surfaces.
- Chain composed of cast iron sliding links, with joint pins, on bearings lubricated for life.
- Positioning of chains at a fixed distance of 1000 mm.
- Series of intermediate supports to drag tracks for workpieces less than 1000 mm in length.
- Series of supports for parts longer than 1000 mm.
- Motor-side introduction guide, with manual horizontal adjustment and position display by decimal display.
- Motorized roller conveyor in and out of the machine, adjustable roller conveyor feed speed (N.B. Roller conveyors are positioned between the transport tracks). The conveyor is sized to support workpieces up to 3000 mm in length.

- Pneumatic hook mounted at machine inlet, for holding workpiece against drag bar.
- Feed rate with gear motor.
- High-strength ground steel drive shaft.
- Complete chain coating with white oil-resistant and stain-resistant rubber plates (80 sh).
- Drive rods (roller shutter type) with standard 800 mm spacing.
- Press shoulders (twin track) with electrical vertical adjustment and position display (working thickness) by decimal display. Pressing by means of V-belts made of stain-resistant rubber, motorized by inverter synchronized with the advancement of the chains.
- Stand-alone electrical cabinet supplied with 3 m of cables for connection to the machine.

MACHINE TECHNICAL DATA

Minimum working length: 280 mm (to the shaving)

Maximum working length: 3000 mm (including tenons)

Worktable height: 960 mm

Composition:

Pos. 9 BLADE

Rotational speed: 3000 rpm

Tool diameter: 350 mm max.

Complete with:

- Cross trolley with:
  - Manual horizontal displacement with screw and decimal indicator
  - Manual vertical displacement with screw and decimal indicator

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- No. 1 fume hood

- electronic braking device

Pos. 10 1st VERTICAL TOUPIE

Rotation speed: 3750 rpm controlled by inverter Shaft:

Ø50x600 mm

Tool diameter: 180 mm min - 320 mm max Complete

with:

- Cross trolley with:

    - NC-controlled electronic horizontal displacement with AC motor
    - NC-controlled electronic vertical displacement with inverter-driven AC motor

- automatic splinter guard device with pneumatic intervention

- No. 1 fume hood

- electronic braking device

Pos. 11 2nd VERTICAL TOUPIE

Rotation speed: 3750 rpm controlled by inverter Shaft:

Ø50x600 mm

Tool diameter: 180 mm min - 320 mm max Complete

with:

- Cross trolley with:

- NC-controlled horizontal displacement with AC motor
- NC-controlled vertical displacement with inverter-driven AC motor

- automatic splinter guard device with pneumatic intervention

- No. 1 fume hood

- electronic braking device

Item 12 HORIZONTAL DRILLING GROUP

- Cross trolley with:

  - NC-controlled electronic horizontal displacement with brushless motor
  - NC-controlled electronic vertical displacement with brushless motor
  - pneumatic longitudinal displacement
  - Longitudinal displacement electronic reference hook on NC-controlled workpiece with brushless motor

- No. 1 fume hood

- electronic braking device

PROTECTIVE CABIN AND SOUNDPROOFING TO CE STANDARD ON BOARD MACHINE

Complete with:

Access doors with sliding opening. Opening is managed by a timed control that allows it only when the motors come to a complete stop. Walls made of high-density sound-absorbing material, fire-resistant class 0, coated internally with a sheet of glass tissue and perforated sheet metal.
Internal lighting provided by watertight lamps. Inspection windows made of breakthrough and noise-proof glass.

TS. 08

ROLLER CONVEYOR

Composition:

- No. 1 motorized roller conveyor, of which the first part is inclined, adjustable speed and with manually adjustable workpiece reference guide

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Technical characteristics:

- Useful working width roller conveyor 1st part: 650 mm
- Useful working width roller conveyor 2nd part: 250 mm
- Total roller length: 3100 mm (approx.)

ST. 09

CONNECTION TAPE

Composition:

- No. 1 motorized belt conveyor, adjustable speed and with manually adjustable piece reference guide

Technical characteristics:

- Useful belt working width: 250 mm
- Total tape length: 4400 mm (approx.)

TS. 10

3+3 HEADS LINEAR DRILLING MACHINE

Technical characteristics:

- Monolithic base made of stabilized steel on which the carriages that support the operating units run. The carriages move on recirculating ball bearing slides and guides, and are moved by centesimal-resolution ball screws driven by brushless axes
- Conveyor belt with inverter-adjustable speed.
- Excludable pneumatic front workpiece stop device for determining the longitudinal position of the workpiece during the first pass
- Workpiece clamping devices during machining
- CE-compliant mesh perimeter guards with sliding access doors. Opening is managed by a timed control that allows it only when the motors come to a complete stop

Item 13 HORIZONTAL DRILLING GROUP

Power: 1.7 kW

Rotational speed: 4500 rpm one direction of rotation

Complete with:

- Heavy motor carriage fixed on the left side of the basement

relative to the direction of workpiece feed with:

- NC-controlled electronic horizontal displacement with brushless motor
- NC-controlled electronic vertical displacement with brushless motor
- NC-controlled electronic longitudinal displacement with brushless motor

- fume hood

- electronic braking device

Item 14 HORIZONTAL DRILLING GROUP

Power: 1.7 kW

Rotational speed: 4500 rpm one direction of rotation

Complete with:

- Heavy motor carriage fixed on the left side of the basement

relative to the direction of workpiece feed with:

- NC-controlled electronic horizontal displacement with brushless motor
- NC-controlled electronic vertical displacement with brushless motor
- NC-controlled electronic longitudinal displacement with brushless motor

- fume hood

- electronic braking device

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Item 15 HORIZONTAL DRILLING GROUP

Power: 1.7 kW

Rotational speed: 4500 rpm one direction of rotation

Complete with:

- Heavy motor carriage fixed on the left side of the basement

relative to the direction of workpiece feed with:

- NC-controlled electronic horizontal displacement with brushless motor
- NC-controlled electronic vertical displacement with brushless motor
- NC-controlled electronic longitudinal displacement with brushless motor

- fume hood

- electronic braking device

Item 16 VERTICAL DRILLING GROUP FOR ANUBE

Power: 1.7 kW

Rotational speed: 4500 rpm one direction of rotation

Complete with:

- Heavy motor carriage fixed on the left side of the basement relative to the direction of workpiece feed with:

- NC-controlled electronic horizontal displacement with brushless motor
- NC-controlled electronic vertical displacement with brushless motor
- NC-controlled electronic longitudinal displacement with brushless motor

- fume hood

- electronic braking device

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Item 17 VERTICAL DRILLING UNIT FOR HANDLE HOLE

Power: 1.7 kW

Rotational speed: 4500 rpm one direction of rotation

Complete with:

- Heavy motor carriage fixed on the left side of the basement relative to the direction of workpiece feed with:

  - NC-controlled electronic horizontal displacement with brushless motor
  - NC-controlled electronic vertical displacement with brushless motor
  - NC-controlled electronic longitudinal displacement with brushless motor

- fume hood

- electronic braking device

Item 18 VERTICAL DRILLING GROUP FOR ANUBE

Power: 1.7 kW

Rotational speed: 4500 rpm one direction of rotation

Complete with:

- Heavy motor carriage fixed on the left side of the basement relative to the direction of workpiece feed with:

  - NC-controlled electronic horizontal displacement with brushless motor
  - NC-controlled electronic vertical displacement with brushless motor
  - NC-controlled electronic longitudinal displacement with brushless motor

- fume hood

- electronic braking device

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TS. 11

CONNECTION TAPE l=6400 mm

Composition:

- No. 1 motorized belt conveyor, r egular speed and with manually adjustable piece

reference guide

Technical characteristics:

- Useful belt working width: 250 mm
- Total tape length: 6400 mm (approx.)

TS. 12

LEFT ONE-SIDED PROFILING MACHINE PMS

Technical characteristics:

- Base with welded and normalized steel columns.
- Lateral workpiece inlet unit, with motorized belt and pneumatic inlet function with NC-controlled electronic horizontal displacement.
- Dimensional counterguides with NC-controlled electronic horizontal displacement.
- Adjustable feed speed from 3 to 16 m/min with inverter.
- Chain composed of cast iron sliding links, with joint pins, on bearings lubricated for life.
- Complete chain coating with oil and stain-resistant white rubber plates (80 sh), grooved.
- Upper pressers with anti-stain belt and NC-controlled electronic alt. adjustment.

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Item 19 MULTIPROFILE PROFILER GROUP

Rotation speed: 6000 rpm with belt drive, one direction of rotation Shaft: Ø50x620 mm with counter support

Tool diameter: 240 mm max.

Complete with:

- Cross trolley with:
    - NC-controlled horizontal displacement with AC motor
    - NC-controlled vertical displacement with inverter-driven AC motor
- fume hood
- electronic braking device

Item 20 MULTIPROFILE PROFILER GROUP

Rotation speed: 6000 rpm with belt drive, one direction of rotation Shaft: Ø50x620 mm with counter support

Tool diameter: 240 mm max.

Complete with:

- Cross trolley with:
    - NC-controlled horizontal displacement with AC motor
    - NC-controlled vertical displacement with inverter-driven AC motor
- fume hood
- electronic braking device

Item 21 HORIZONTAL MILLING UNIT

Rotational speed: 6000 rpm rotation

Tool diameter: 240 mm max.

Complete with:

- Cross trolley with:

  - NC-controlled horizontal displacement with AC motor
  - NC-controlled vertical displacement with AC motor

- fume hood

- electronic braking device

PROTECTIVE CABIN AND SOUNDPROOFING TO CE STANDARD ON

BOARD MACHINE

Complete with:

Access doors with sliding opening. Opening is managed by a timed control that allows it only when the motors come to a complete stop. Walls made of high-density sound-absorbing material, fire-resistant class 0, coated internally with a sheet of glass tissue and perforated sheet metal.
Internal lighting provided by watertight lamps. Inspection windows made of breakthrough and noise-proof glass.

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TS. 13

"Z" TRANSFER WITH BUFFER

Composition:

- No. 1 PVC-covered motorized roller conveyor with manually adjustable workpiece reference guide and 90° motorized INOX steel flat chains with pneumatic override

- No. 1 motorized stainless steel flat-chain table for lateral movement of workpieces, workpiece storage table and No. 5 workpiece stop stations

- No. 1 PVC-covered motorized roller conveyor with manually adjustable workpiece reference guide and 90° motorized INOX steel flat chains with pneumatic override

Technical characteristics:

- Useful roller working width: 200 mm
- Total input roller length: 3500 mm (approx.)
- Total length of exit roller conveyor: 3500 mm (approx.)

TS. 14

RIGHT SINGLE-SIDED PROFILER PMD

Technical characteristics:

- Base with welded and normalized steel columns.
- Lateral workpiece inlet unit, with motorized belt and pneumatic inlet function with NC-controlled electronic horizontal displacement.
- Dimensional counterguides with NC-controlled electronic horizontal displacement.
- Adjustable feed speed from 3 to 16 m/min with inverter.
- Chain composed of cast iron sliding links, with splice pins, on bearings lubricated for life.
- Complete chain coating with oil and stain-resistant white rubber plates (80 sh), grooved.
- Upper pressers with stain-resistant belt and NC-controlled electronic height adjustment.

Item 22 MULTIPROFILE PROFILER GROUP

Rotation speed: 6000 rpm with belt drive, one direction of rotation Shaft: Ø50x620 mm with counter support

Tool diameter: 240 mm max.

Complete with:

- Cross trolley with:
    - NC-controlled horizontal displacement with AC motor
    - NC-controlled vertical displacement with inverter-driven AC motor
- fume hood
- electronic braking device

Pos. 23 MULTIPROFILE PROFILER GROUP

Rotation speed: 6000 rpm with belt drive, one direction of rotation Shaft: Ø50x620 mm with counter support

Tool diameter: 240 mm max.

Complete with:

- Cross trolley with:
    - NC-controlled horizontal displacement with AC motor
    - NC-controlled vertical displacement with inverter-driven AC motor
- fume hood
- electronic braking device

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Pos. 24 UPPER HORIZONTAL MILLING UNIT

Rotational speed: 6000 rpm rotation Tool

diameter: 240 mm max.

Complete with:

- Cross trolley with:
    - NC-controlled horizontal displacement with AC motor
    - NC-controlled vertical displacement with AC motor
- fume hood
- electronic braking device

Item 25 INK-JET MARKER DEVICE

Inkjet printer equipment complete with software for communication interface with CN.

- Special cross trolley with:
    - NC-controlled horizontal displacement with AC motor
    - NC-controlled vertical displacement with AC motor

PROTECTIVE CABIN AND SOUNDPROOFING TO CE STANDARD ON

BOARD MACHINE

Complete with:

Access doors with sliding opening. Opening is managed by a timed control that allows it only when the motors come to a complete stop. Walls made of high-density sound-absorbing material, fire-resistant class 0, coated internally with a sheet of glass tissue and perforated sheet metal.
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TS. 15

UNLOADING TABLE LINE

Composition:

- No. 1 motorized belt conveyor, speed adjustable by inverter and with manually adjustable piece reference guide

- No. 1 pneumatic side pusher device for 90° translation of workpieces mechanically adjustable according to the width of the workpiece

- No. 1 piece storage shelf

Specifications:

- Useful belt working width: 200mm
- Total tape length: 4400 mm (approx.)

TS. 16

COMPLETE LINE CONTROL AND SUPERVISION SYSTEM

Composition:

CNI numerical control "iLENIA System"

Modular and integrated production process automation system with distributed

intelligence.

The system enables complete line management with application versatility and production flexibility, while maintaining ease of use and human-machine communication.

The adopted HW configuration enables high performance. Customization

of interfaces using flexible SW packages. Technical features:

- HP server IPC
- 19" color graphic LCD monitor.

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- DVD RW burner.
- No. 2 hard drives RAID 1 80GB configuration.
- Operating system: Windows XP Pro.
- RS232 serial output.
- Parallel printer output.
- USB 2.0 output.
- Antivirus installed.

Main functions:

- Data entry from the keyboard, via CD or through the network.
- Memory for user programs hard disk 80 GB.
- Association with each work program of a note list and user drawing.
- Management of tools and axis correctors.
- BOM.
- Statistics-Diagnostics-Messaging.
- Descriptive page for errors and warnings.
- Positioning axis characteristics:

automatic reset.

decimal and centesimal resolution

Fully programmable special positioning data.

CAD-CAM Software CNI "Easy Win"

System for parametric design of windows (framed and frameless windows, patio doors), component parts (mullions, transoms, laths, etc.) and related machining to be performed on each part depending on the hardware used. Based on CAD/4 technology for parametric drawing with integrated machining technology and configurable CAM/3 postprocessor/optimizer, it provides a flexible and immediate tool for automatic program construction for CNC machines.

Main functions:

- Quick and immediate definition of various window components.
- Parametric relationships between the various component parts of the window.
- Parametrically definable processing macros.
- Graphic aids defining type and data of processing macros.
- Hierarchical representation of machining and parts.
- Customizable and user-expandable machining library.
- Customizable window project library.
- Automatic program construction for CNC with specific optimizations.
- Independence of the type of machine and CNC that will do the machining

Separate cabinet containing the electrical and electronic equipment approved according to current standards.

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