

WEINIG WORKS WOOD

Machines and systems for solid
wood processing in WEINIG quality

Order Confirmation

Cutting Line

SWEDBANK LIISING AS
LIIVALAIA 8
15039 TALLINN
ESTLAND



Order Confirmation

RAIMANN Holzoptimierung GmbH & Co.KG, Weisserlenstrasse 11, 79108 Freiburg

Your RAIMANN Expert:

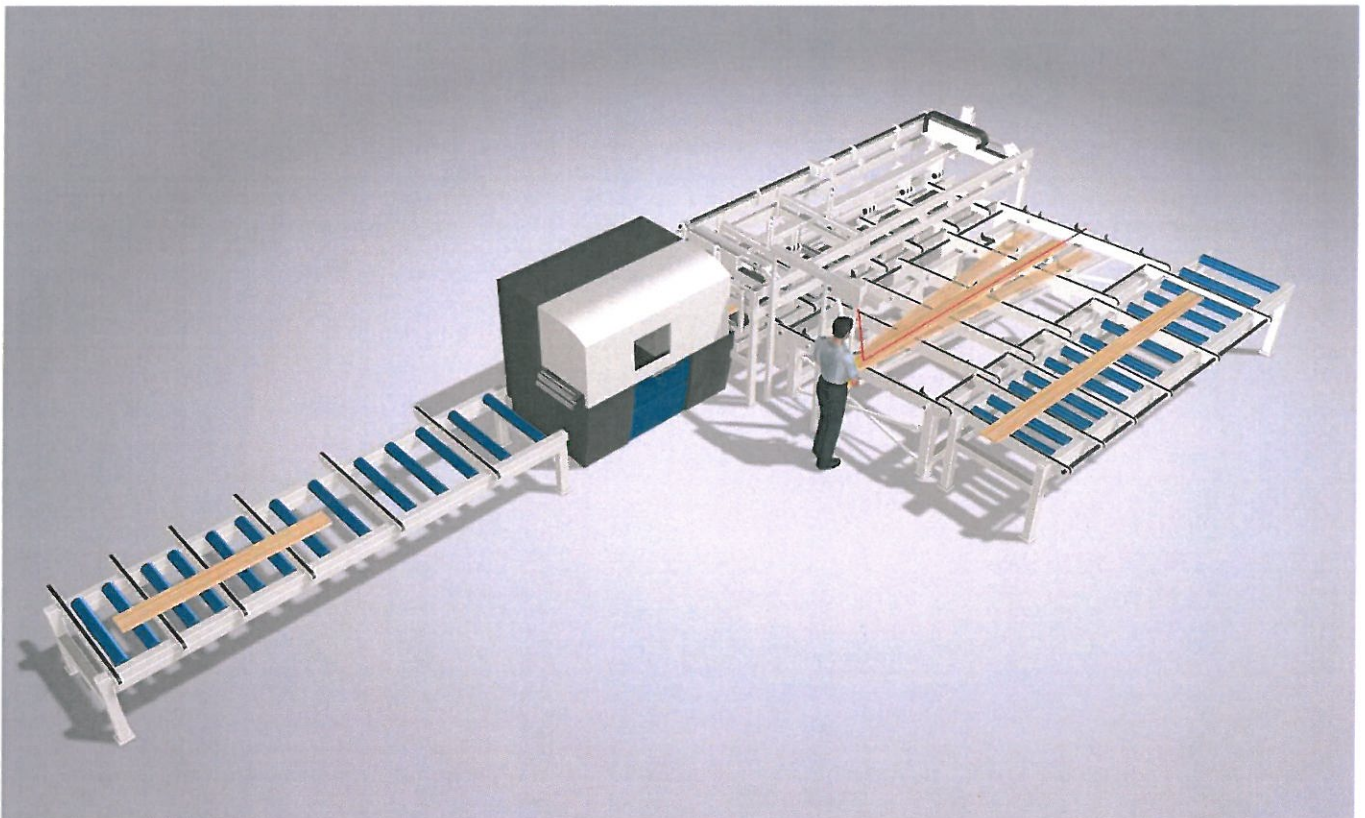
SWEDBANK LIISING AS
LIIVALAIA 8
15039 TALLINN
ESTLAND

Esttech Grupp OÜ
Peterburi tee 46-305
11415 Tallinn
ESTLAND
Tel: +372 6 139718
Fax: +372 6 139719
Email: info@weinig.ee

File: 05823/3
Your phone no.:
Your e-mail:

Order 14966
Your fax no.:

Customer: 0549647/05/06
Date: 22.07.2014
Our ref.: RAI/ AG



(Picture may differ in details depending on the order)

The layout of the individual components is based on the following data:

Technical data

Final product Components for pallets and sauna interior

Raw material: Mainly Aspen, undried,
Edged and unedged

Dimensions of the incoming materials:

Length: min. 1200 mm
2400 – 3600 mm
Main production
max. 6000 mm

Raw material shorter than 2400 mm may require manual support at destacking and board separation.

Width, Quality A&B: min. 200 mm
max. 300 mm
unedged from the
outer parts of the log

Thickness, Quality A&B: 22, 36 mm

No varying plank thicknesses for Quality A&B

Width, Quality P (pallets): min. 160 mm
max. 400 mm
partially edged from the log middle

Thickness, Quality P (pallets): min. 44 mm
max. 90 mm

Varying plank thicknesses for Quality P (pallets) 44 – 90 mm

The raw material is broad in bundles onto the cutting line, bundles consist of boards of equal length. Boards within a bundle are laying parallel onto each other. There will be no boards stacks on the line.

Board displacement within a bundle max. 300 mm – for bundles 2400 - 3600 mm; bundles shorter than 2400 mm have to be without board displacement

Bundle cross section max. 1000 mm

Cutting widths Quality A&B:

70 mm
82 mm
90 mm
105 mm
130 mm
150 mm
170 mm
180 mm

Cutting widths Quality P (pallets):

44 mm
70 mm
90 mm

Cutting height 44, 70 und 90 mm

General information:

To ensure a faultless, automatic throughput through the cutting line, the cross section of the boards or strips should always be wider than they are high (with a 3:2 ratio of width to thickness).
Not all conceivable combinations of dimensions are feasible. When processing parts the cross section of which is higher than it is wide (upended parts), the process stability of the cutting line may be impaired.

The cutting line will operate with a maximum material length of 3600 mm according to technical description. For easier resale the cutting line and its components, except the outfeed cross conveyor Pos. 7, is designed for maximum material length of 6000 mm.

Capacity of the cutting line:

max. 12 boards/minute
at 2400 mm board length, 80 m/min. feed
speed and automatic shape measuring
with RaiScan

At manual board marking by operator the maximum capacity is reduced according to the operator.

Example calculation for board length 2400 mm:

Feed speed 80 m/min (1,33m/sec.) + 6 seconds marking time $\approx$ 7 boards per minute

A pressure system adjustment due to varying thicknesses the maximum capacity is reduced.

Example calculation for board length 2400 mm:

Feed speed 60 m/min (1 m/sec.) + 46 mm height adjustment (varying thickness 44-90 mm) $\approx$ 6 boards per minute

Optimizing mode at automatic shape measuring with RaiScan

Width optimisation according to price, quantity and yield

Optimizing mode at manual board measuring with adjustable laser

Width and quality optimizing according to price, quantity and yield.

Summary

- 1 **Destacking**
- 2 **RaiScan - Automatic geometry measurement**
- 3 **Marking station**
- 4 **PZE - Automatic positioning and centering unit**
- 5 **Automatic High Performance Gang Rip Saw with
Movable Saw Blade Raimann ProfiRip KR 610 M**
- 6 **SPT - Automatic splinter separation**
- 7 **RBAQR – Outfeed cross conveyor on right**

Installation, commissioning and training

Total price for you

880.660 €

Equipment according to the following technical specification.

Commercial terms and conditions

End customer

Sadala
Pajusi mnt 3a
48106 Poltsamaa
ESTLAND

Prices

Our prices are FCA Freiburg
[Free Carrier in compliance with Incoterms 2010],
installation, commissioning and training included.
An erection insurance policy can be taken out by Raimann at the request
and at the expense of the customer.

Payment:

30 % down payment with order.

30 % 6 weeks before delivery

30 % after announcement of readiness for shipping and before delivery

10 % final payment after installation and putting into operation plus transfer
with functional demonstration of the installation (record).

If delivery, installation and commissioning or transfer cannot be effected for
reasons beyond the responsibility of the supplier, final payment will become
due at the latest 60 days after announcement of readiness for shipping.

Installation, commissioning and transfer take place directly after delivery.

The Purchaser is under obligation to insure the goods against damage of
any kind from the time it arrives at the point of reception.

After complete payment of order value, the installation will enter into
possession of the customer.

Warranty:

The warranty period for this machine/cutting line is 12 months for one-shift
operation. The warranty period for two-shift operation is reduced to 6
months - in more than 2 shifts - to 3 months. Except for wear parts.

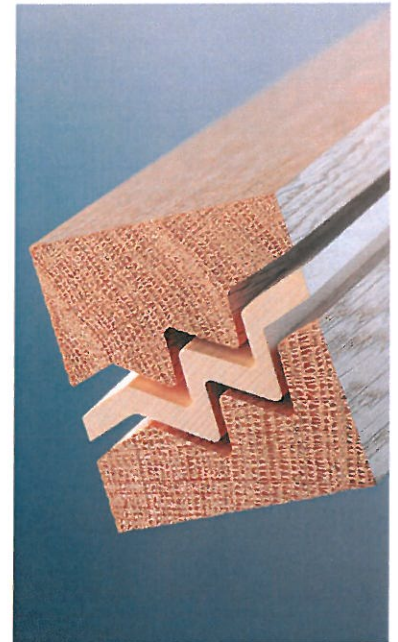
The total amount resulting from claims for damages and diminution is
limited to 5 % (five percent) of the net purchase price.

This limitation shall not apply if Raimann is responsible for the intent.

Raimann shall not be liable in any case for the compensation of indirect
damages, in particular not for loss of profits or losses of the customer.

This exclusion for Raimann shall not apply

- in case of intent,
- in case of gross negligence of the owner / the organs or managerial
employees
- in case of culpable injuries of life, body, health



- in case of defects it maliciously concealed
- within the scope of an indemnity commitment
- in case of defects of the delivery item to the extent warranty is provided according to the Product Liability Law for personal or physical damages at privately used objects

In case of culpable infringement of essential contractual obligations the supplier shall also be liable in case of gross negligence of non-managerial employees and in case of slight negligence, in the latter case limited to the contract-typical, reasonably foreseeable damages.

Additional claims shall be excluded.

The parties agree that the statements and warranties contained in the contractual documents of this purchase contract are not quality warranties, but they are quality descriptions relevant under warranty law for the machine sold hereby

Delivery Time:

Delivery date 52/2014: receipt of down payment and signed order confirmation at the latest by calendar week 32/2014

Installation and commissioning by plant fitters including all costs incurred:

This includes installation, commissioning, instruction during commissioning and transfer of all machinery and devices as well as travel, hotel and subsistence costs. The costs are calculated under the assumption that commissioning can be carried out efficiently, i.e. without interruption and obstruction of our technicians and with the assistance of 2-3 non-skilled workers provided free of charge by the customer. In the case of delays for which we are not responsible, all costs incurred will be charged in addition.

Safety Devices: included

CE safety:

The machines and plant components supplied are manufactured within limits defined by us, and when used as intended they conform to CE in compliance with the EC Machinery Directive and they receive a CE declaration of conformity.

If the machine or the plant components are linked to other machinery / plants provided by the customer, instead of the CE declaration of conformity they receive a "declaration of incorporation" in compliance with Annex II/B of the EC Machinery Directive.

We wish to point out that if the machine is linked to other machinery / plants belonging to the customer / operator, the latter becomes the manufacturer and is cognizant and responsible for the safety concept. In this case, if there is no safety concept for the entire plant, on no account can the machine be commissioned. Safety fences, maintenance doors and limit switch fuses and light barriers also supplied are part of the safety concept and have to be installed prior to commissioning. The plant must not be operated without this safety equipment.

Installation location:

The layout of the components of the cutting line is shown on the attached sketch.

The cutting line has to be installed in a closed room, within a temperature range of approx. 5-35°C. As a foundation a concrete slab of C 20/25 quality is necessary. This concrete slab has to rest completely on a solid foundation and must be plain. There must be no visible bows or sinkings.

Transfer with functional demonstration:

Raimann and the Customer take down a record of acceptance. The Contractor must be granted an appropriate period of grace to eliminate any defects. For this purpose the cutting line must be accessible to the Contractor during normal working hours.

The delivery item is accepted if:

- The delivery item has no or only minor defects, or
 - The customer was to blame that it was impossible to carry out acceptance test
1. Raimann gives written notification when commissioning has been completed.
 2. Acceptance of performance takes place at the customer's premises in compliance with the performance specifications described in the order confirmation.
 3. A record of the acceptance of performance to be signed by both parties is prepared. Insignificant defects which do not affect the machine/plant substantially do not entitle the customer to refuse acceptance.
 4. If acceptance of performance cannot be carried out for reasons for which Raimann is not responsible, acceptance is considered effected 10 days after it was offered by Raimann. The same applies when production of the contractual object for the intended use begins.

Material for commissioning and final acceptance

The timber for commissioning and final acceptance conforms to the contractually-appointed sorts of wood, dimensions and qualities (min. – max.) will be provided by the customer. This also applies to commissioning at the Contractor's factory around 1 to 2 weeks before delivery.

Performance to be rendered on site before the beginning of and during assembly and commissioning:

- Foundation, construction and lift works
- Adequate lighting at the installation location must be guaranteed
- Dry and lockable rooms must be provided for storing assembly tools
- Suitable (heating and light) theft-proof recreation rooms and sanitary facilities must be provided
- Unloading of cutting line components (8 t stacker with 1.8 m-long forks or a crane length)
- The plant parts must be brought to the final installation location
- If the plant is mounted on steel substructures a crane should be used if necessary for positioning the devices on the steel substructure.
- All ladders and assembly platforms must be provided.
- Prepare power supply up to the switching cabinet and complete one day after assembly begins
- An uninterrupted and constant voltage supply must be supplied (voltage fluctuations of maximally 5 %)
- Preparation for laying main compressed air line up to the machine components and completion immediately after the components are set up; the compressed air must conform to quality class 3.3(4).3 in compliance with DIN ISO 8573-1
- Prepare extraction and completion one day after the components are set up. It is advisable to install a block separator.
- 2 set-up assistants for installation
- 1 Ethernet network connection with TCP/IP and connection to the Internet CAT5 in double socket for Teleservice: preparation and completion two days after assembly begins
- Mechanical and electric connection or interconnection with components already present on site or provided by the Customer (unless otherwise noted in the order).
- Platforms, stairs, crossings, waste disposal etc. (adjustments to match the working height if not explicitly noted otherwise in the order)
- Safe access to the installation locations for commissioning

If there are any hindrances or delays with assembly and commissioning due to performance not rendered at the factory, the Contractor can stop or interrupt assembly and complete it later. The costs thus incurred (for example travel expenses), will be charged separately. Resumption of assembly will be rescheduled, taking available capacities into account.

Tools:

1 set of saw blades for the quoted machines are included in our quotation.

Documentation:

The following documents are included with the delivery and will be handed over, in one copy each in German and Estonian.

- Detailed installation drawing
- Operating manual

The illustrations in this order confirmation can include special equipment, which do not belong to the range of your order.

By this order confirmation all prior arrangements, made verbally and/or by writing become invalid.

Unless other arrangements have been met by this contract supplementary our general terms and conditions of sale and delivery are valid.

Of course, we assure you a careful processing and execution of your order and would ask you to return to us one countersigned copy of this order confirmation which you receive in duplicate until 31.07.2014, the latest. If we do not receive a signed copy until this date we suppose that you fully agree to our order confirmation.

For any further questions please contact Mr. Andreas Gafus,
phone: +49 761 13033-24.

By signing this order confirmation we confirm, that the general terms and conditions of Raimann Holzoptimierung GmbH & Co. KG have been handed over to us and that we have taken note of.

These general terms and conditions of sales and delivery form an integral part of the order and are also valid for all repeat orders.

Raimann Holzoptimierung GmbH & Co. KG
Weissenhofstr. 11
79108 Freiburg

RAIMANN HOLZOPTIMIERUNG GMBH & CO. KG

I herewith agree with the contents of the acknowledgement of the order in all respects.

Date / Place

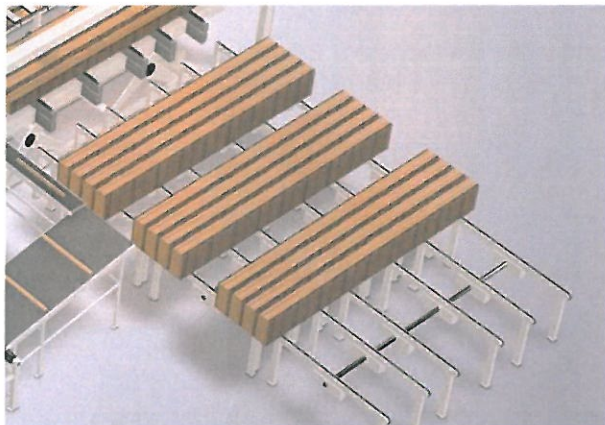
Buyer's signature / Company stamp

Technische Beschreibung

Pos. 1

Destacking, consisting of

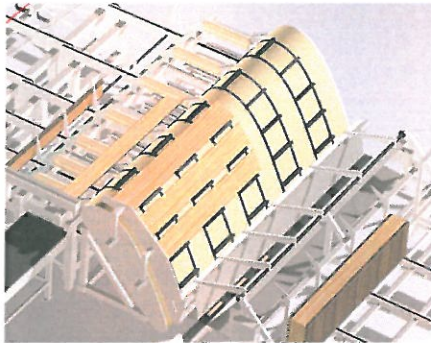
2 Stack crosswise conveyor



(Details of representation may differ from order)

Conveyance length, Stack crosswise conveyor 1	approx. 6000 mm For details see final layout
Conveyance length, Stack crosswise conveyor 2	approx. 2000 mm For details see final layout
Number of cross chains per stack crosswise conveyor	7
Dimensions der Brettbündel ca.	Ø approx. 1000 mm x bundle length 1200 - 6000 mm
Board displacement within a bundle	max. 300 mm – for bundles 2400 - 3600 mm; bundles shorter than 2400 mm have to be without board displacement
Working height	approx. 1000 mm For details see final layout

Unscrambler for board separation



Conveyance length:	approx. 3000 mm For details see final layout
Electro driven adjustment according to material thickness	22 – 36 – 44/70/90 mm
Funnel with back pressure prevention	
Inclined roller conveyor for board alignment	
Working height	approx. 800 - 2000 mm For details see final layout

KQF cross chain conveyor



**Platform for
operator provided
by customer**

Conveyance length:	2000 mm For details see final layout
Number of cross chains	7
Sensors for wane detection	2
Retainer row	1
Board turning device	
Working height	approx. 1800 mm For details see final layout

Pos. 2**RaiScan, consisting of****KQFN – chain cross conveyor with cams**

Conveyance length:	approx. 2000 mm For details see final layout
Number of cross chains	7
Working height	approx. 1600 mm For details see final layout

RaiScan - Automatic geometry measurement
2D Optimizing


(Details of representation may differ from order)

Function:

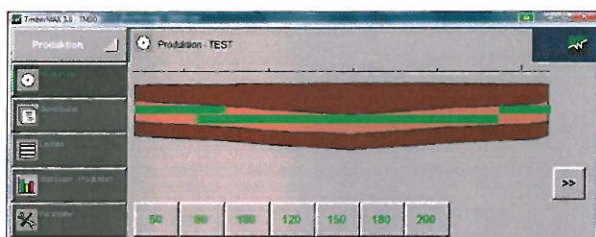
The separated boards are conveyed continuously throughout while being measured; the cross section of the board is captured from above at multiple measuring points.

Both edged and unedged material can be processed.

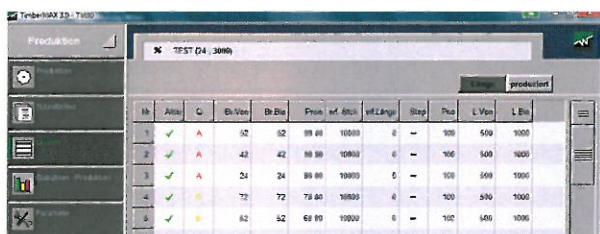
The resolution of the board length depends on the number of sensors used and the maximum board length.

The respective board geometry and the resultant useful area are calculated from the addition of the individual measuring points.

Automatic optimisation in the longitudinal and lateral direction then provides the ideal board segmentation.



(Example of TimberMax 2D optimisation, details of representation may differ from offer)



It	Stat	C	Q	Q. Ver	Q. Be	Pos. of. Stk	ef. Länge	Stap	Pro	L. Ver	L. Be
1	✓	A	52	52	88.88	10800	0	-	100	570	1000
2	✓	A	42	42	88.88	10800	0	-	100	500	1000
3	✓	A	24	24	88.88	10800	0	-	100	500	1000
4	✓	A	72	72	73.00	10800	0	-	100	590	1000
5	✓	A	62	62	69.89	10800	0	-	100	600	1000
6	✓	A	10	10	24.86	10800	0	-	100	430	1000

(Example of TimberMax cutting list, details of representation may differ from offer)

The system consists of:

A stable, torsionally rigid supporting beam to accommodate the sensors.

Sensor mount and flashing

Measuring sensors with evaluation unit

Number of sensors (max.24)

16

Sensor distance (board-length resolution)

ca. 390 mm board length max. 6000 mm
ca. 230 mm board length max. 3600 mm

Industrial PC with colour touch panel to display and input cutting lists, optimisation and machine parameters and for error diagnostics.

Optimisation software, TimberMax 3.0 to control infeed mechanisms as well as the movable saw axes.
Two-dimensional optimisation (longitudinal and lateral direction) provides the optimal board division with regard to timber yield, value creation and productivity.
Though the different widths, lengths, prices and quantities from the cutting list in use are taken into account according to a freely chosen priority.

Width optimisation:

Pure width optimisation with the raw material divided up according to cutting list. The best combination of measurements provides the maximum yield.

Price optimisation:

The prices are stored with the measurements in the cutting list. The distribution is optimised so that the highest price per board is achieved.

Quantity optimisation:

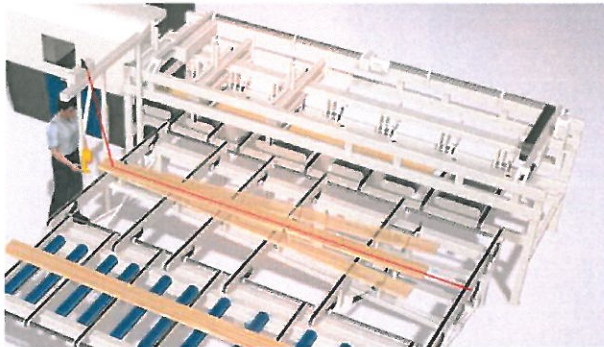
Quantities are also stored in the cutting list. The distribution is optimised according to the quantity required and thus facilitates fast processing of all jobs.

Network connection

Product data capture, output in the form of csv files for individual analysis.

Pos. 3

Marking station



Function:

Adjustable laser show the operator the individual optimizing solution. It can be confirmed or overwritten by the operator.

KQF Cross chain conveyor

Conveyance length	approx. 3000 mm For details see final layout
-------------------	---

Number of cross chains	7
------------------------	---

Alignment beam to position the raw boards in front of the operator

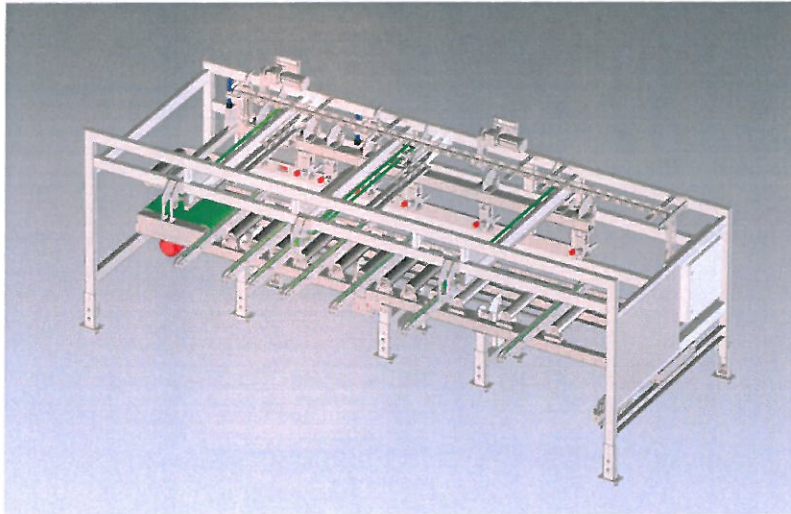
Cutting layout visualisation via automatic adjustable laser axes	each 30mW, red
Number of adjustable laser axes	5

Adjustable laser for board measuring	30 mW, green
---	--------------

Operator chair



Platform for operator provided by customer

Pos. 4**PZE - Automatic positioning and centering unit**

(Details of representation may differ from offer)

Function:

The measured boards are placed down individually after crosswise conveyance on the preliminary positioning of the PZE.

Thereafter the raw material is always slid by two positioning cams exactly in front of the infeed if the ProfiRip, depending on the result of optimisation and the measured alignment angle.

Pneumatically-controlled top pressure rollers fix the board onto the infeed conveyor which then feeds it, exactly positioned, to the multi blade circular saw.

The device consists of positioning cams lying on top, a high-strength, low-wear conveyor belt, driven infeed rollers and top pressure rollers set up on a sturdy frame.

Number of positioning cams	7
Adjustment track	900 mm
Belt width	600 mm
Feed electromotive, frequency-controlled	Synchronous with ProfiRip
Number of conveyance and support rollers	4
Working height	1600 mm For details see final layout

Pos. 5

188693*

Automatic High Performance Gang Rip Saw with Movable Saw Blade Raimann ProfiRip KR 610 M



493056*

ProfiRip KR 610 M4 with 4 movable saw blades

492853*

Positioning system incl. Gear motor for infinite adjustment, by ball-threaded adjustment spindle, of 4 movable saw blades.



487119*

Positioning tolerance:
2 positioning speeds (slow/fast motion)

+/- 0,1 mm

Saw assembly

46965*

Cutting width max.

610 mm

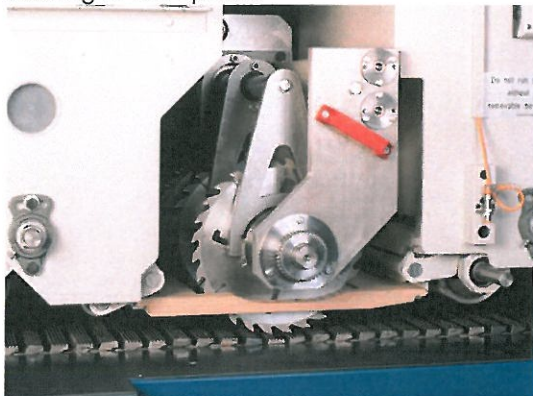
189020

Motor

75 kW (100 HP)

256310*

Saw arbor spindle with 3 high precision ball bearings, incl. outboard bearing of the spindle



285294*

Motorized height adjustment of saw arbor, by push button

247508*

V-belt driven saw arbor, with safety guard

Diameter of saw arbor

65 mm

254340*

Revolutions of saw arbor

3700 r/min

KPT 1517829

10 carbide tipped saw blades - basic equipment

Ø 400 mm

256313*

Saw blade diameter

min./max.

250 / 400 mm

247510*

Saw blade bore

80 mm

Saw blade adjustment

491739

Electronic Control and Optimizing Unit TimberMax 3.0

486391+

controls and optimizes the movable saw axles,
consisting of:

- Industrial PC with coloured touch panel for indication and input of cut-lists, optimizing and machine data as well as for error classification.
- Optimizing software TimberMax 3.0.
- Multifunction joystick on stand-alone rack, on wheels, for width measuring and quality marking;
- Laser axle for width measuring of boards;
- Each 1 joystick per movable saw axle, for stepless adjustment;
- Connection to network.

486131+

Caution: temperature range between

0 and +40°C

486392+

TimberMax 3.0 optimizes ripping with regard to timber yield, value adding and productivity.

It takes care of different widths, qualities, prices and number of pieces, according to arbitrary priority.

486132+

Operating functions:

486396+

Width optimizing:

Pure width optimizing, ripping the raw material according to a cut-list. The best combination of sizes results in the maximum yield.

Quality optimizing:

Width optimizing ripping the raw material according to a cut-list. Different quality levels are considered. The best combination of sizes results in the maximum yield of different qualities. There can be defined 4 different qualities.

Price optimizing:

Besides the sizes, the prices are also memorized in the cut-list. The ripping process will be optimized in a way to achieve the highest price for each board.

Quantity optimizing:

In the cut-list, the numbers of pieces are also memorized. The ripping process will be optimized according to required numbers of pieces and thus makes it possible to quickly work off all orders.

486393+

Selection of the memorized strip sizes via touch screen.

486397+

All production data are entered, memorized and analyzed. Thus all rippings can be precisely controlled at any time. TimberMax supports you effectively with product and operation data entry.

KPT 1518406
Operator panel with swivel arm mounted on the PZE
with well arranged control elements

944878
Spray mist device
Spraying lubricant for the saw arbor,
in order to prevent dirt and resin from seizing.

1159251+
In the electrical cabinet there is a signal output available
to trigger an automatic suction flap.
The suction flap has to be provided by the customer.

188615*
1 FIX bushing "Standard" for mounting 1 saw blade

490069
Additional enlarged FIX saw bushing
for installation of a chipper or for cutting 6x44 mm.
Spacers included.

Length of the saw bushing customized approx. 300 mm
For details see separate layout

486678*
Each 1 MOVABLE bushing "Standard"
for 1 saw blade per movable saw axle
Cutting width min. 40 mm

Feed and chain

247506*
Infinitely variable feed speed via AC inverter

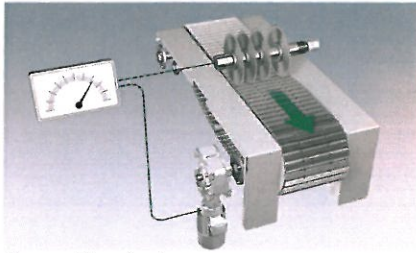
946428*
Feed speed 8 - 48 m/min

946741*
Feed system 3,0 kW (4,1HP)

KPT 1518986
Feed system with splitted chain



487446



SpeedControl

When reaching the maximum current consumption the feed speed is reduced to a pre-set value.

47766*

Chain width

630 mm

247817*



Presice cut by accurate board feed and extremely quiet running of prism guided transport chain, made of high-quality cast

257220*

High performance chain
transport chain in special design with hardened sliding bolts within chain prisms. Prism guidings also hardened

474592*

Automatic adjustable chain lubrication
incl. collecting pan for proper disposal of oil residues

253455*

Closed chain links
Wear resisting chain deflection below saw blades

256395*

Easy operation and advantages when cutting short pieces by
automatic board infeed via elongated transport chain

KT 1518987

Transport chain with spikes, every 3rd chain link
Inserts with spikes, screwed on to chain links.

Length of spikes, standard:

7 mm

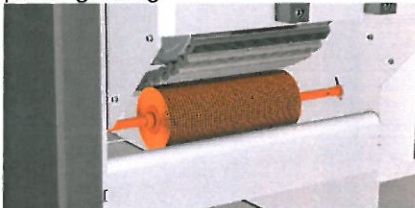
Penetration depth, standard:

1,8 mm

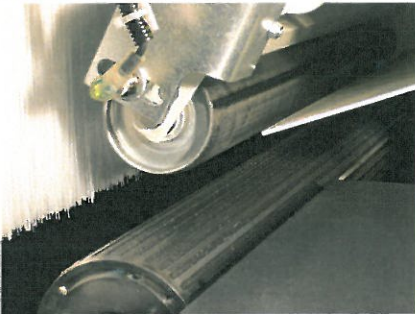
Spikes guarantee an absolutely parallel board feed and an accurate cut. They are advantageous when cutting contorted, twisted or short boards and if a direct glue joint cut is required.

469534

- 2 ROTO Chain brush
at the outfeed side of the machine,
for the permanent cleaning of the closed transport chain from saw
dust or chips.
Guarantees constant efficiency of the chain and a precise work
piece guiding.



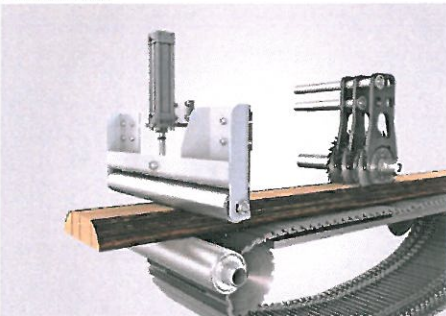
246637



Driven outfeed roller, below, in FLUTED design,
with smooth pressure roller from above, for better outfeed of work
pieces. Fixed at machine frame, behind transport chain.

933953

Pneumatic control of the upper outfeed roller
The control guarantees the outfeed of all rest pieces out of the
machine.



Pressure hood

188699*

Cutting height max.
with maximum saw blade diameter
with movable blades
- without pressure board
- with pressure board
with saw bushing and standard spacers
- without pressure board
- with pressure board

125 mm
110 mm
140 mm
125 mm

256469*

Motorized height adjustment of pressure hood using wear resistant guides, incl. push buttons and electronic positioning display

945553*

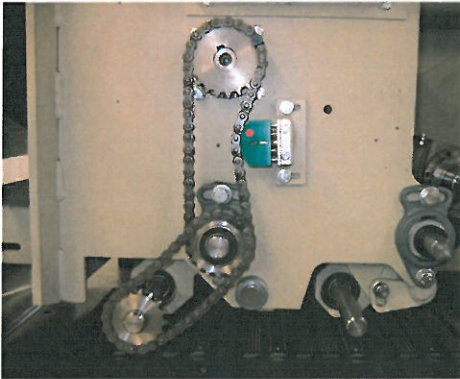
Heavy top pressure system with 4 adjustable upper pressure rollers, supported at both sides.

945554*

Pneumatic suspension of pressure rollers
incl. separate regulation of pressure for each roller as well as for the pressure board, for an optimal guiding of the work piece, especially in case of high feed speed, extremely twisted material and important thickness tolerances in raw material.

491749

2 driven top pressure rollers
(within pressure hood, infeed and outfeed side)
Chain driven synchronously with transport chain by frequency converter.
Fluted execution of the 2 pressure rollers,
for a safe and secure board feed when cutting very rough and wet timber.



188627*

Recessed pressure board made of phenolic wood

464245*

Shortest piece possible
- standard execution with pressure board: 540 mm
(Valid for manual infeed and outfeed)

188684*

Outlet width in total, max. 960 mm

247502*

Outlet width right from saw blade, max. 150 mm

Electrics

256559*

Stand-alone electrical cabinet, beside the machine

247823*

Operation voltage 400 V / 50 Hz
(Range of voltage 400 - 460 Volt)

KPT 1518988
ADS Firewall
For Online-Service for up to 4 WEINIG machines



Working and operational safety

247493*
1 set of operating manual and service notes, each in German and one EU language on choice (additional copies and languages available upon request at a surcharge)
Operator tools

517197*
European safety norms (CE), German BG regulations for dust protection
Multiple anti-kick-back devices

517199*



RAIMANN SafetyPlus
An additional kevlar curtain, improves operators safety from kick-backs including small splinter kick-backs

(patent)

517200*
Swivelling safety cover, incl. locking and standstill control.
Safety switch at the infeed side for automatic machine STOP in case of oversized boards
EMERGENCY STOP switch at the infeed and outfeed side as well as at the operator panel
Safety cover with noise absorbent lining, incl. observation window

Connections

1160420*
Temperature range between 0 and +40°C

188686*
Suction hood Ø 350 mm

248262*
Air velocity for dust exhaust 30 m/sec

188687*
Air volume for dust exhaust, in total 10400 m³/h

1560444*
Noise emission
Emission value at the workstation
- in idle motion: LpA = 78 dB(A)
- in operation: LpA = 82 dB(A)
Sound volume
- in idle motion: LwA = 96 dB(A)
- in operation: LwA = 100 dB(A)
according to EN 1870-4 and ISO 7960 annex Q
uncertainty constant value K = 4 dB(A)

KT 1518989*
Working height 850 mm

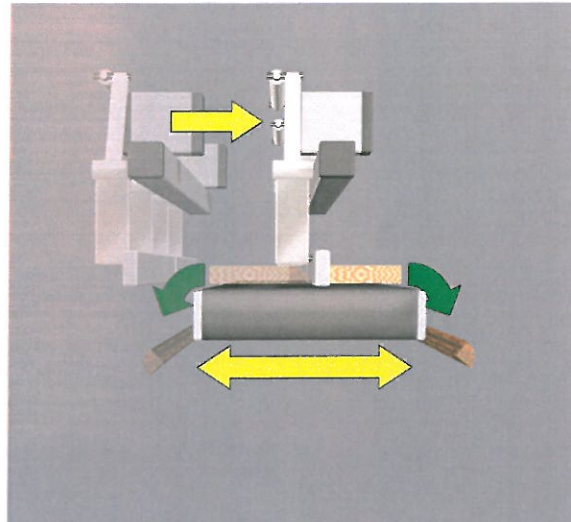
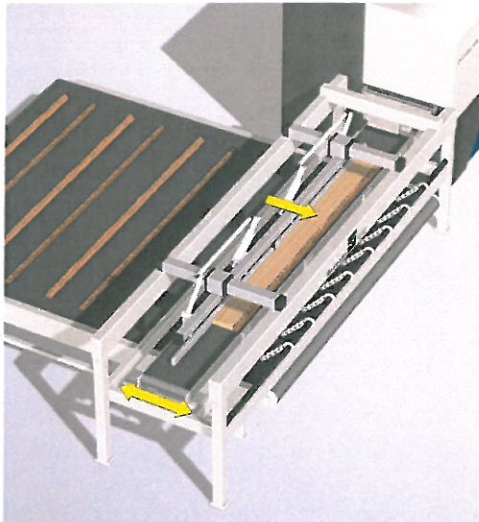
**Platform for cutting
line height 1600 mm
and platform for
operator provided
by the customer
after specifications
from Raimann**

188707*
Total length 2200 mm
Total width 2700 mm
Height 2000 mm

1323056*
Detailed technical information according to installation plan.

928848*
Net weight approx. 5700 kg
(The weight may vary according to equipment)

247822*
Paint:
- light grey RAL 7035
- anthracite RAL 7016

Pos. 6**SPT - Automatic splinter separation**

(Details of representation may differ from order)

Function:

Removes the waste/offcuts of the sawn boards on the right- and left-hand side. The sawn boards are passed onto a conveyor belt at the outfeed side of the gang rip saw.

The offcut on the right falls out of the gang rip saw immediately at the outlet onto the chip drop flap and is dropped under control when the board has moved out completely.

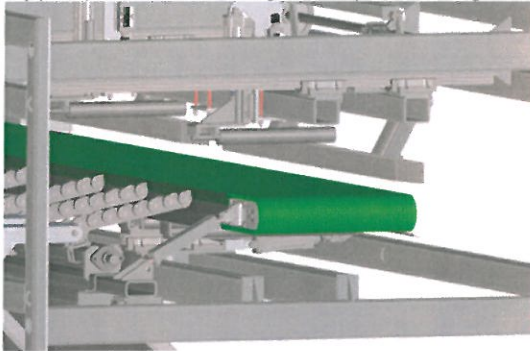
The sawn package of strips is transported crosswise until the offcut on the left falls down also.

The device consists of a high-strength, low-wear conveyor belt and a slider lying on top, set up on a sturdy frame.

Belt width	600 mm
Belt length	approx. 6000 mm
Feed electromotive, frequency-controlled	Synchronous with ProfiRip
Reinforced feed for belt and feeder	
Stiffening and strengthening of the frame construction	
Working height	1600 mm For details see final layout

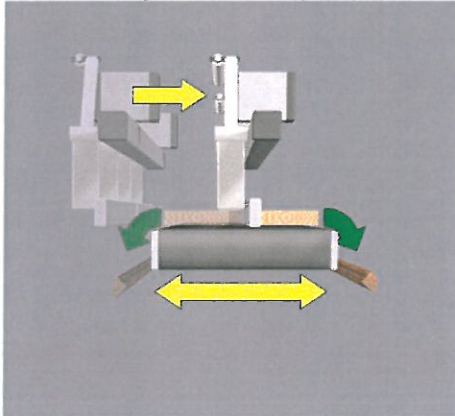
Waste disposal provided by the customer

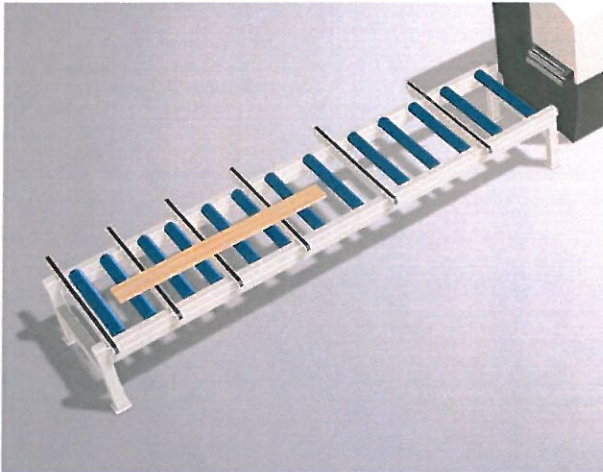
Upper pressure for edgewise processing



To prevent an overturn of the lamellas pneumatic upper pressure rollers lower onto the ripped boards.
These upper pressure rollers are linked with the overhead feeder and drive to the left band edge.

Conveyor belt can move sideways
when using extended bushing in the saw to position the belt edge
in conformity with the respective reference saw blade



Pos. 7**RBAQR – Outfeed cross conveyor on right**

(Details of representation may differ from order)

Function:

The sawn boards are passed on to a roller conveyor downstream of the multi-blade circular saw. Integrated cross chains with cams draw off the material crosswise to the left or right.

Technical Data:

The device consists of a roller conveyor and integrated cross chains with cams built onto a sturdy frame.

Roller width	800 mm
Roller conveyor length	4000 mm
Drive for roller conveyor Feed electromotive, frequency-controlled	Synchronous with ProfiRip
Feed, electromotive	30 m/min.
Working height	1600 mm For details see final layout