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SPECIFICATIONS

VOORWOOD MODEL L115J EDGE FOILER

The Voorwood Series L115 Shaper Foiler profiles and sands, then applies transfer-finishing foil to a single edge of your MDF parts in one pass. The L115 is capable of producing over 8,000 lineal feet (2500M) of finished product per shift. Production rates may vary with part size and operational conditions. Stock is transported through the machine by a bottom feed chain with special pads that grip the stock securely while it passes the workstations. With digital readouts and MicroPoint tilt at the workstations and digital readout on the ever-square infeed guide, this machine is designed for easy set-up and repeatable tool change between profiles.

MAIN FRAME:

The welded box frame construction provides a rigid structure insuring accurate and repeatable tool positioning. Base weldment is pre-drilled for permanent machine installation.

TRANSPORTER ASSEMBLY:

The transporter assembly incorporates a large infeed support area and is equipped with an ever-square infeed guide with digital readout, adjustable feed drive motor and bottom feed chain. Substrate is positioned on infeed plate against the edge guide; when drive motor is activated, bottom feed chain transports the substrate past the shaping, sanding and foiling stations. Bottom feed chain is topped with non-marking polymer pads. An electronically controlled oil pump automatically lubricates transporter chain race assembly.

ROLLER HOLDDOWN ASSEMBLY:

The steel plate holddown beam is equipped with a safety switch at the infeed area, anti-intrusion hood and non-marking polymer rollers. Polymer rollers hold the substrate against the bottom pads while the workpiece is transported past the shaping, sanding and foiling stations. Infeed limit switch deactivates drive motor if substrate is misfed. Digital readout on vertical adjustment handwheel adjusts for substrate thickness.

OUTBOARD SUPPORT:

Non-marking outboard rollers support the weight of extra wide substrates as they are transported past the shaping and sanding stations.

SHAPING STATION:

Shaping station is equipped with precision-balanced drive motor and spindle. The spindle rotates against the direction of feed. Spindle is equipped with double collets and has angular, horizontal and vertical adjustments with accurate and repeatable digital readouts as well as a spindle lock to facilitate tool changes. Each station is equipped with dust hood/safety guard.

SANDING STATIONS:

Sanding station is equipped with precision-balanced drive motor and spindle. The spindle rotates against the direction of feed. The spindle is equipped with double collets and has angular, horizontal and vertical adjustments with accurate and repeatable digital readouts and is equipped with dust hood/safety guard.

FOILING STATION:

One foiling station equipped with 8-inch (203mm) diameter foil wheel, non-contacting sensor and oven for automatic temperature control. Position adjustments are viewed by digital readout. Each foil station is equipped with individual foil unwind and rewind wheels with constant tension adjustment. All foil stations will be positioned to apply foil on the top edge of the substrate and will be equipped to handle foil width of up to 150mm. Each foiling station will be equipped with pneumatic jump to automatically dis-engage foil wheel when substrate is not present.

GROOVING SAW:

Adjustable grooving saw module is an extension of the feed of the parent machine. The saw is adjustable for width and depth of cut and contains a dust hood and vacuum outlet.

CONTROL AND COMPONENT PANELS:

Lighted touch screen controls are located on a swing arm for operator convenience. Emergency stop push-button controls are located at the infeed and outfeed areas. The function and logic of the machine is controlled by a "PLC". Control and component panels conform to ANSI/NFPA 70 and NFPA 79 electrical standards and can meet European Community standards. Machine is pre-wired for installation in customer's factory.

DUST COLLECTION:

Each shaping and sanding station is equipped with a dust hood and hose. Manifold is provided for connection to customer's dust collection system.

The L115 is a production-oriented machine designed for reliability and operator convenience. It is furnished ready for hookup with safety enclosure.

TRANSPORTER:

Motor:	3/4 hp	.56 kw
Feed Speed:	8 - 35 fpm	2.4 - 10.7 M per minute
Feed Height:	35 inches	89 cm

SUBSTRATE SIZE:

Minimum Size:	3 inches x 3 inches plus pattern face width*	76.2mm x 76.2mm plus pattern face width
Minimum Thickness:	1/8 inch	3mm
Maximum Thickness:	2 inches	51mm
Maximum Profile Face:	1-3/4 inches	45mm

*Some exceptions may apply

SHAPING STATION:

Spindle Diameter:	1-1/4 inches	31.75mm
Spindle Length:	2-7/8 inches	73mm
Spindle Adjustments:		
Tilt:	0-30 degrees	
Horizontal:	6 inches	152mm
Vertical:	3 inches	76mm
Motor:	5 hp at 6000 rpm	3.70 kw
Cutting Head Capacity:		
Maximum Diameter:	6 inches	152mm

SANDING STATION:

Spindle Diameter:	.984 inches	25mm
Spindle Length:	3 inches	76mm
Spindle Adjustments -		
Tilt:	0-30 degrees	
Horizontal:	6 inches	152mm
Vertical:	3 inches	76mm
Motor:	.75 hp at 1725 rpm	.56 kw

FOILING:

- (1) Supply Roll:
 - (a) Maximum diameter: 12-3/4 inches (324mm) (approximately)
 - (b) Maximum width: 2 inches (50.8mm)
 - (c) Core diameter: 1 and 3 inch ID (25.4mm and 76.2mm)
- (2) Applicator Stations:
 - (a) Furnished with one foiling station for domestic or metric foil wheel.
 - (b) One shaped applicator wheel per spindle required, not included.
 - (c) Station adjustments: 5-1/2 inches (140mm) in and out
2-1/4 inches (57mm) laterally across face
-10 to +30 degree angle from horizontal.
- (3) Film Takeup:

Carrier film rewinds with automatic tension control. Stripper rollers for precision trimming on mitres and edges follow the edge of the part for precision foil trimming.

GROOVING SAW:

Saw Diameter:	8 inches	203mm
Saw Width:	Up to 3/8 inch	9.5mm
Saw Depth:	Up to 3/8 inch	9.5mm
Width adjustment:	Up to 10 inches	254mm
Motor:	3hp @ 3450 RPM	4.3kw

(Width/Depth must be specified quoted separately, saw blade not included)

CONTROLS:

Infeed and Outfeed End:

- Emergency stop switches
- Main power on/off
- Switch/circuit breaker on infeed end

Control Panel: Touch Screen Display with the following functions:

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|-----------------------|---------------------------|
| (1) Shaper On/Off | (5) Rewind On/Off |
| (2) Sander On/Off | (a) Rewind tension adjust |
| (3) Feed On/Off | (6) Master On/Off |
| a) Feed speed adjust | (7) Power On/Off |
| (4) Foil On/Off | |
| a) Temperature adjust | |

SERVICES REQUIRED:

Electrical: 220 volt, 3 phase, 60 hz, 40 amps
380 volt, 3 phase, 50 hz, 20 amps
440-480 volts, 3 phase, 60 hz, 20 amps
All voltages +10% -6%, all hertz +1% -1%

The customer is responsible for installing proper equipment grounding, in accordance with Part 6 and Part 7 of Article 250 in NFPA 70 Electrical Code before applying power to the machine. If a grounding electrode is necessary, it must be sized in accordance with Article 250.122 and conductor sized in accordance with Article 250.66, or in accordance with UL508A, Chapter 8.2.2.3.

Dust Collection:

Three Ø5" (127mm) outlet requires exhaust air:
Velocity: 4000 fpm 1230 mpm
Static Pressure: 1" of water 2.54 gm/sq cm
Minimum Air Volume: 400 cfm 189 lps

SPACE REQUIREMENTS:

96 inches long, 54 inches high, 41 inches wide
2.44M x 1.37M x 1.04M

SHIPPING DIMENSIONS:

113 inches long, 78 inches high, 55 inches wide
2.87M x 1.98M x 1.40M

APPROXIMATE NET WEIGHT:

2720 lbs. 1234 kg

APPROXIMATE SHIPPING WEIGHT:

3650 lbs. 1650 kg

VOORWOOD COMPANY