

SCM GROUP SpA
STEFANI
via del Lavoro, 1/3 - PO BOX, 168
36016 Thiene, Vicenza - Italia
tel. +39 0445 359511
fax +39 0445 359599
stefani@scmgroup.com

BO.RD.I/ TECHNICAL DATA

N. 1

ROLL MATERIAL FOR STRAIGHT PROCESSING WITH BEVEL FINISHING:

MELAMINE THICKNESS MM 0.5

PAPER THICKNESS MM 0.5

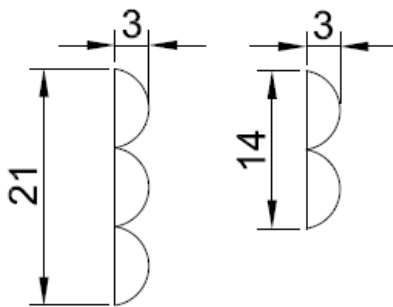
PVC THICKNESS MM 0.5

ROLL MATERIAL FOR STRAIGHT PROCESSING WITH RADIUS FINISHING:

PVC THICKNESS MM 1-2

ABS THICKNESS MM 1-2

SPECIAL PROFILE ABS 3MM WITH TWO OR THREE CURVED



PROFILING TO NAIL MDF PANEL INCLUDED ON THE CORNER WITH SPECIAL ROUND YA LIKE THE PICTURE



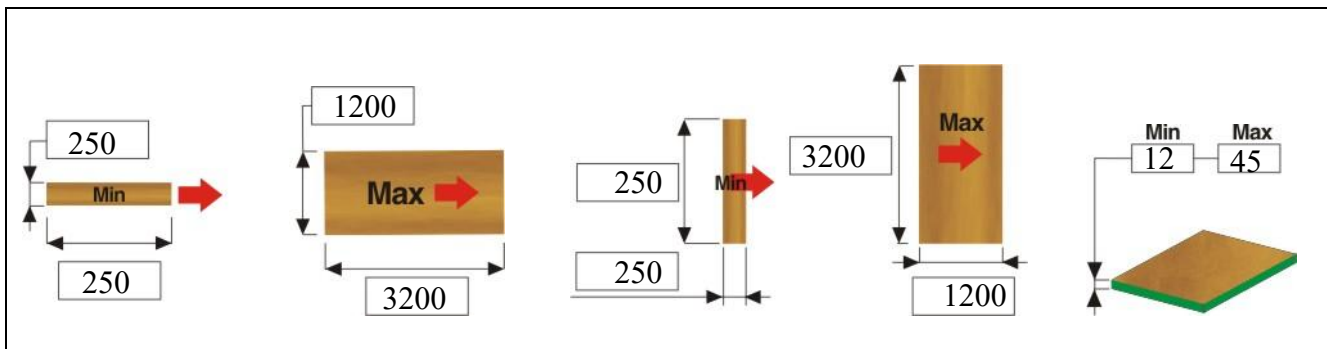
PROFILING ONLY ON LEFT SIDE WITH SPECIAL ROUND YA LIKE THE PICTURE



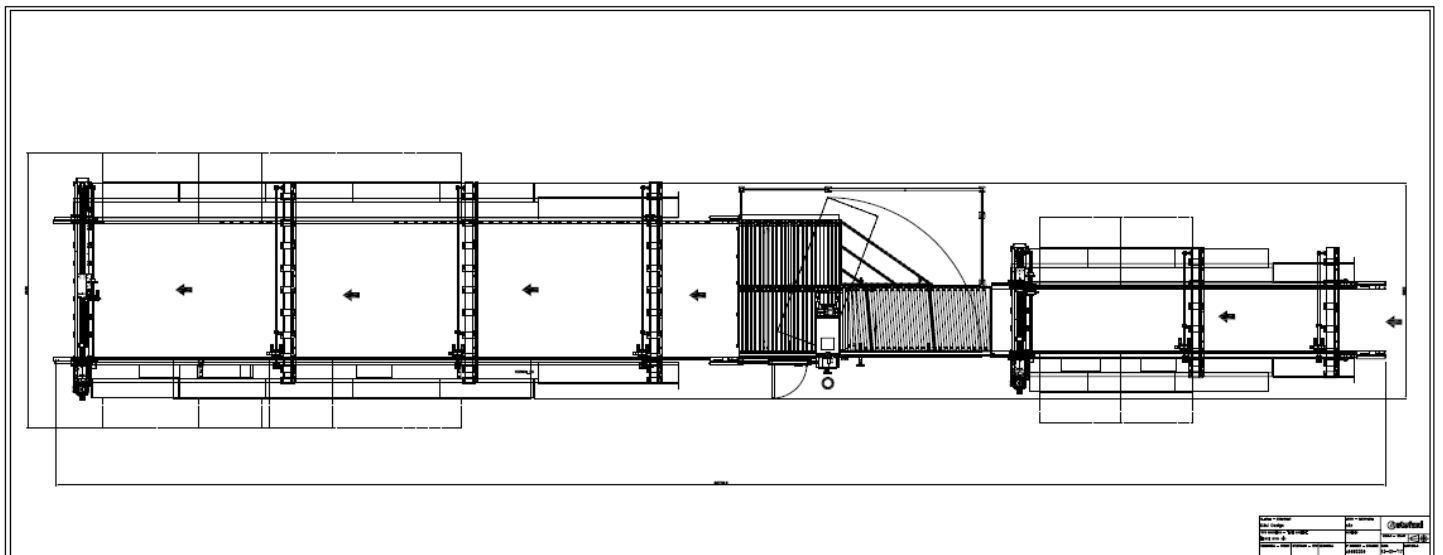
PANEL MATERIAL:
CHIPBOARD
MDF

PANEL COATING:
MELAMINE

PANEL SIZE (MM):

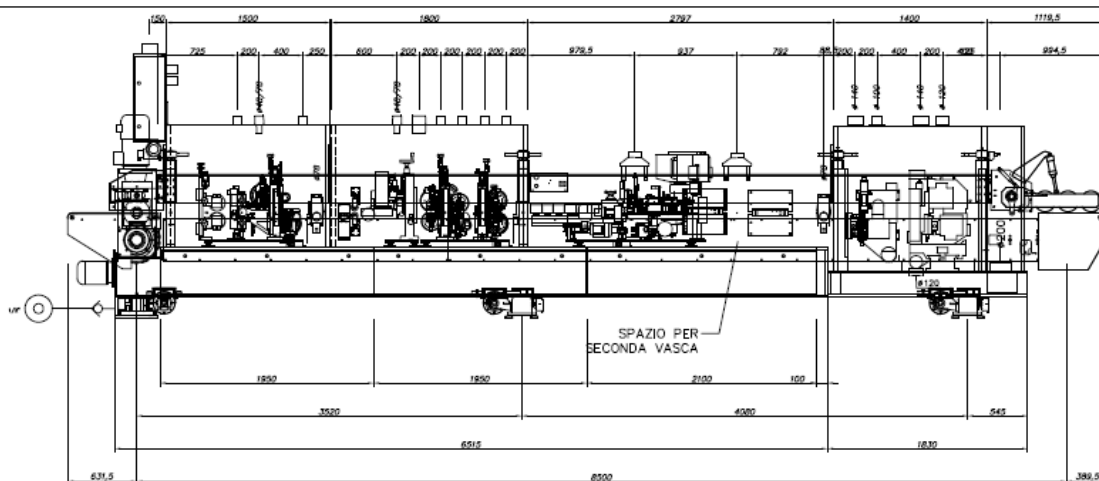


Panel thickness min/max: 8/60 mm with max 1 mm thick edge
 Panel thickness min/max: 10/60 mm with max 2 mm thick edge
 Panel thickness min/max: 12/60 mm with max 3 mm thick edge



PRELIMINARY LAY OUT

AUTOMATIC DOUBLE-SIDED SQUARING/EDGEBANDING MACHINE EVOLUTION SB 1^



Si specifica che l'eventuale installazione in linea della macchina comporta la decisione dell'efficacia della dichiarazione CE, emessa ai sensi dell'Art. 6A della Direttiva 2006/42/CE, di cui sarà corredata la macchina e richiede la ricertificazione a cura del Cliente dell'insieme risultante di cui egli diventerà il "fabbricante", il tutto ai sensi della Direttiva 2006/42/CE.

Please be advised that any use of line conforms with which the machine is pre-set, for facilitating on-line installation, will nullify the effect of the CE declaration issued according to Attachment A4 of Directive 2006/42/CE, which was provided with the machine; moreover, the use of said line conforms requires that the Client recertifies the resulting configuration, of which the client becomes "Manufacturer" for all rights and purposes of Directive 2006/42/CE.

LEADER - CUSTOMER	FINA - SIGNATURE	
D&J DESIGN	COLTRO	
PRO MACCHINA - TYPE MACHINE	MODELLO	SCALA - SCALE
EVOLUTION SB		
CONSEGNA - ORDER	OPZIONALE - OPTION	DATA
		17/02/17

A0.01.18	NR.1 USE AND MAINTENANCE HANDBOOK IN SLOVAK -SK-	N. 1
99.00.61	PC ENGLISH LANGUAGE	N. 1
A0.01.91	ELECTRICAL SCHEME IN ENGLISH	N. 1
A9.90.00	EUROPEAN SAFETY REGULATIONS (CE NORMS)	N. 1
93.07.31	Volt 400 EU	N. 1
93.12.01	Frequency 50 Hz	N. 1
A3.47.00	EVOLUTION SB 1ST MACHINE IN LINE	N. 1

Designed to square/edge-band straight and soft-formed panels with coil and strip materials depending on machine configuration.

The large steel basement with high degree stiffness represent an optimum support for the working units and ensure no vibrations.

The **feed track** consists of 70 mm wide, self-lubrication nylon sliders, coated with wearproof vulcanised rubber with a high coefficient of friction to ensure the maximum panel holding and precision of working.

The conveyor track consists of one flat guide and one round guide made of ground steel to ensure the straightness of movement and the holding on lateral loadings. **Lubrication is automatic.**

The industrial chain is made from sintered steel links and special reinforced bearings.

The track pinions have 13 teeth with a tempered and ground profile.

Top pressers are made of steel of big thickness with drafted belt and with a single v-shaped profile. **Automatic positioning** according to the panel thickness by NC.

Numeric control two-speed motorised mobile shoulder opening. Fast speed to reach the machining area and slow speed to recover final positioning play.

Mobile shoulder sliding on support guides: on linear ball recirculating guide at the back side, front and intermediate ground guides with centralised lubrication.

Automatic panel in-feed system, located on the in-feed track extension on in-line machines for lengthways panel machining. The unit contains the following:

- In-feed track transfer;

- Out-feed track transfer;
- Right hand in-feed guide;
- Pusher with 3 inflatable wheels connected to the upper pressure beam to enable panel in-feed.

The **sound proof cabins** are coated with noise-reducing material and they are **lighted inside with anti-dazzling neon lights**. The sound proof cabins, closed and connected to the suction plant in accordance with the required specifications.

Top suction system with suitable inlets for each unit.

The standard supply voltage is **400 V EU (+/- 10%) 50 Hz (+/- 1%) (with neutral)**. In the case of different voltages, the adaptation to the voltage of the destination country must be provided by means of an optional transformer or a transformer supplied by the customer

Conditions for the correct operation of the machine:

- Humidity: max 90%
- Temperature when the machine is in operation: min 10 ° C / 35 ° C max

The machine is in conformity with the following machines directives:

- Directive **2006/42/CE** ("Machine")
- Directive **2014/30/UE** ("electromagnetic compatibility")

A machine complete with set-up for I/O line consents in order to ensure interfacing with any upstream and/or downstream machines. The use of the aforementioned consents in the context of line installation annuls the effectiveness of the EC declaration, issued under Attachment IIA of Directive 2006/42/CE, provided with the machine, and requires recertification at the Client's expense and responsibility of the resulting set of equipment of which he will become "manufacturer" under the provisions of Directive 2006/42/CE.

When inserted in a line, the machine must not be commissioned until the line it is inserted into is declared conformant with Directive 2006/42/CE.

The standard equipment includes:

PC control system for the fast, easy and precise handling of the main functions of the machine.

It includes:

Unlimited working programs.

Widened video pages especially for diagnostics and report.

Creation, rescue and editor of working programs.

Working units ON/OFF control.

Easy and guided diagnostics for the fast solution of possible mistakes.

Working statistical data: number of worked pieces and meters, of the employed hours etc.

Productive efficiency measurement (indicator of the actual production compared with the maximum feasible production).

Selection of the first or second pass without changing program.

Unit of measurement in mm.

Operator "WinEdge" interface in the following languages: Italian, French, English, Spanish, German.

Functioning temperature: from 0 to + 45°C.

Main characteristics:

PC Office.

Operating system: Windows 7 Professional

Screen: 17" TFT LCD.

2 ETHERNET network cards.

6 USB ports - 2 ps/2 ports and possibility of connection of Bar Code reader

DVD reader.

Remote diagnostics web / based allows connection via Internet of the machine supervisor PC to SCM Group Service.

Software equipment:

TEAMVIEWER®

Software for remote diagnostic control of the machine via internet.

It allows:

- view of operator interface
- signal diagnostic
- on-line checking and editing of the configuration, parameter and program status of the machine
- data backup and file transfer
- upgrade of the machine logic and operator interface

The Buyer shall prepare Internet access on the PC machine.

KASPERSKY® Internet Security

The PCs are equipped with antivirus protection software and Kaspersky Internet Security firewall.

The license has a term of one year, starting from the shipment date of the machine.

The licence renewal at maturity is at customer's charge. If not renewed, the product is not deactivated, but it becomes impossible to update it with new virus definitions.

Each unit has its own inverter.

Instruction booklet attached.

Standard paint finish: Grey RAL 9002.

TECHNICAL DATA

Variable track feed speed	m/min 10-40
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The working speed depends on the combination of the settled units.

For softforming processing the feed speed can vary according to the type of profile and to the applied edge.

Panel overhang from the track:	fixed
- Standard straight processing	mm 35
- with YA	mm 75
- Softforming processing	mm 55

Panel dimensions:

Thickness (depending on the applied edge)mm 8-60
 - with 2M 100 mm 10-60

Minimum width:

- Standard straight processing	mm 225
- with YA	mm 305
- Softforming processing	mm 265

Maximum width mm 1600

Minimum panel dimensions:**Lengthwise and crosswise:**

width x length mm 225x3200

Data refer to the panel before the edge application.

Attention! for the processing line consisting of machines and transport machines, the data of the minimum and maximum dimensions of the panel to work in the line have to be considered greater than the data of each stand alone machine/automation the processing line.

Variable working height mm (+/-10 mm)

The performance in the quotation may vary depending on the types of processing, especially it can change according to the speed, to the processed materials and removed material.

The floor has to comply with the enclosed foundation plan.

A3.47.05	EVOLUTION SB 1-85	N. 1
	Machine total length: mm 9550	
P3.05.48	MODULE TYPE B FOR 13 TEETH 1830	N. 1
P3.06.56	MODULE TYPE A FOR 13 TEETH 6515	N. 1
B0.91.00	400V/50HZ POWER SUPPLY WITH NEUTRAL	N. 1
A3.32.33	CLEAN PACK L FOR PROTECTED EDGES - ONE SHOULDER	N. 2
	Suitable to protect delicate edges or without protective film with the risk of detachment, in contact with feelers and/or tools of the same film.	
	Complete with a spraying gun, and tank for the anti-adhesive liquid	

RIEPE NFLY.

P2.01.44 PANEL OVERHANG VARIABLE BY CONTROL ON SQUARING/EDGEBANDING MACHINE 1ST IN LINE N. 1

A1.80.00 SQUARING AREA FREE COMPOSITION N. 1

A5.01.64 "AAR" SPRAY ANTI-ADHESION UNIT N. 2
To avoid deposits of glue on the top and bottom surface of the panel. It is completed with 2 spray-guns fed by two anti-adhesive liquid containers.



A4.03.28 "DTR" DOUBLE HOGGING UNIT KW 5,8 N. 2
For the lengthwise panel processing:

- two horizontal motors, misaligned between themselves, mounted on the same carriage
- numerical indicator for shifting of the lower motor and alignment to the upper motor
- numerical indicators for the vertical and horizontal shifting of motors

Horizontal shifting used for manual adjustment of panel overhang from track.

Technical data

Speed: rpm 6000

Motors power: kW 5,8+5,8

Tools not installed Ø min.-max.: mm 200-250



P3.21.02 "DTR" MOTORS WITH POWER OF 10 KW INSTEAD OF 5,8 KW N. 2

P2.01.20 VARIABLE PANEL OVERHANG BY CONTROL (ELECTRONIC HORIZONTAL POSITIONING) N. 2

A4.04.87 AUTOMATIC MILLING UNIT FP KW 4 N. 2
Possible applications:
Panels profiling;
Processing through or timed milling:

- manual motor tiltable to 90°;
- double direction of rotation of the tool with selection from control;
- numerical indicators for the vertical and horizontal shifting of motors.



Horizontal shifting used for manual adjustment of panel overhang from track.

Technical data

Speed	rpm 6000
Motor power	kW 4
Tool <u>not installed</u> Ø min.-max.	mm 180-220

P4.21.02 MILLING UNITS MOTOR WITH 8 KW INSTEAD OF 4 KW N. 2

A4.30.08 ENLARGED MOTOR SHAFT 40X118 MM N. 2

P4.11.02 VERTICAL ELECTRONIC POSITIONING FOR MILLING UNIT N. 2
Including actioning and screw with rolling balls.

P2.01.20 VARIABLE PANEL OVERHANG BY CONTROL (ELECTRONIC HORIZONTAL POSITIONING) N. 2



A1.80.03 PRICE ADJUSTMENT FOR SQUARING AREA CLOSED COMPOSITION N. 1

A7.22.27 GLUING UNIT FOR STRAIGHT PROCESSING "HM 3002 LMS" N. 2

For the gluing on straight profiles of edges in coils and in strips with hot melted glue spreaded on the panel:

- provided with quick melt system for a fast glue melting
- small dimensions glue pot with Teflon antiadherent treatment to avoid incrustation
- copying of the glue pot on linear ball recirculating guides
- fast interchangeability of glue pot
- device to measure out the glue
- control of the glue temperature on glue pot and on the quick melt system
- safety edge presence
- smokes exhaust hood
- handling of the glue spreading roller, of the first pressure roller and of the feed roller by motors synchronized with the speed of the track by inverter
- guillotine shear for edges in coil
- automatic system of edges loading for material in coils and strips which allows to change the types of applied edges in a short time
- pressure area with pneumatic independent adjustment of the pressure and decimal mechanical indicator of position composed

by first motorized big diameter roller, made of Teflon and with three idle rolls with opposed iconicity.

- shifting of the pressure zone on linear ball recirculating guides
- automatic cut-off of the glue pot

Technical data:

Edge thickness	mm 0,3-12
Edge height	mm 12-65
Min. coil length	mm 230
Min. strips length	mm 230
Min. length of solid wood	mm 230
Cutting section max.	
- plastic edge	mm2 135 (mm 3x45)
- wood edge	mm2 96 (mm 3x32)
Strip storage capacity with single or double coil magazine	mm 200
Strip storage capacity with 6 coils magazine	mm 175
Glue pot capacity	kg 1,2
Glue melting capacity with pre-melting system	kg/h 22

P2.01.20 VARIABLE PANEL OVERHANG BY CONTROL (ELECTRONIC HORIZONTAL POSITIONING) N. 2

A7.22.86 PRECISION EDGE FEEDING AND REAR CUT HM N. 2

Main components:

- dragging roller motorized **by means of BRUSHLESS motor** to give the roller the necessary acceleration to bring the edge to the working position
- special software support for the shear.

Technical data:

Edge feeding and rear cut precision	
With speed up to 30 m/min	mm +/- 2
With speed up to 40 m/min	mm +/- 3

A7.23.23 ELECTRONIC POSITIONING OF EDGE GUIDE N. 2

A7.23.22 ELECTRONIC POSITIONING OF THE PRESSURE ROLLERS N. 2

A7.23.21 TIMED INTERVENTION OF THE PRESSURE ROLLERS N. 2

A7.23.42 MANUAL TABLE LIFTING FOR "HM 3002" N. 2

Manual height adjustment the in-feed table from +2 up to -7 mm.
The standard table position is -2mm in comparison to the track.

A7.23.39 MOTORIZATION OF THE VERTICAL ROLLER MAGAZINE N. 2

A7.23.15 KIT FOR GLUE POT CLAMPING HM 3002 N. 2

A5.03.63 INCREASED GLUE MELTING CAPACITY N. 2

It increases glue melting capacity of LMS melting system from 22 kg/hour to **40 kg/hour**. Hot melt granulate feeding system is required.

A5.03.62 HOT MELT GRANULATE FEEDING SYSTEM LMS N. 2

A7.23.82 DRIVEN RUBBER ROLLERS FOR DELICATE EDGES N. 2

Advised for delicate thin edge (paper, PVC) or edges with posterior lacquering face.

A8.16.17 ANTI-ADHESIVE DEVICE FOR FIRST PRESSURE ROLLER N. 2

It prevents the glue sticking to the first roller of the pressure zone of the gluing unit for straight. It's complete with a spraying gun, and tank for the anti-adhesive liquid.



A8.16.37 "SGP" GLUE POT WITH AUTOMATIC DOSING BY NC IN SUBSTITUTION OF THE STANDARD ONE N. 2

It allows a **quick changeover of the used glue type/colour**. The glue pot is fed by the standard pre-melting system for EVA glue.

Features:

- specific **compact design** that reduces to a minimum the melted glue before the application in order to maintain the best quality characteristics
- spreading roller with optimized graining and PLASMA anti-adherent treatment
- **automatic emptying cycle** with collection of the residual glue on a removable tank
- automatic locking of glue loss with stopped machine (SCM GROUP patent)
- **automatic dosing adjustment by NC** according to the used glue and/or to the panel type and finish quality
- glue roller reverse rotation
- **quick release** device for the removal and easy replacement of the glue pot
- **simple and quick access** for the internal cleaning with the possibility to disassemble all parts.
- **short time of heating** of the glue during the starting of the machine thanks to its small dimensions
- **double thermo-regulation system** for an easy use of two types of glue with different melting temperature



Technical data:

Heating time from environment T°: <10 min

Heating time from pre-heating T°: <5min

Glue capacity: 0,5 Kg

Installed power: 2,05 kW

A7.23.16 3 ADDED PRESSURE ROLLERS HM N. 2

A5.01.52 HEATING DEVICE RPS FOR MAX. 60 MM THICKNESS PANELS N. 1

Complete with no. 2 shotwave lamps 1500W set before the gluing unit to pre-heat the side of the panel.



A7.22.19 VERTICAL 2 ROLLER PLIER MAGAZINE WITH AUTOMATIC EDGE TURNOVER (MAX. H=65) N. 1

Feeding edges system with 2 stations automatic infeed for material in coil with the chance to insert material in pile-form in thin strip or thin solid wood:

- 2 coil-holder magazines vertically placed;
- automatic infeed system of the belt with automatic change-over at the end of the roll;
- warning indicating the end of the roll.

Technical data:

Maximum roll Ø	mm 800
Max. edge thickness	mm 3
Max. edge height:	
For thin edges up to 1 mm	mm 65
For edges up to 3 mm	mm 45
Distance between panels:	
18 / 25 / 35 / 40 m/min	mm 300 / 320 / 350 / 380

SPEC02 Mantis 15873:Second modul glue, included support and motorization pot for accept pre melting VERSA PUR and unit lamp RPS thikcness max 60 mm N. 2

A8.16.39 ADDITIONAL "SGP" GLUE POT WITH NC DOSING DEVICE - FEEDING BY PREMELTER N. 2

Interchangeable with the "SGP" glue pot installed on the machine.

A0.05.90 "VERSAPUR SLUG" PREMELTER FOR PU GLUE FOR GLUE POT FILLING **INSTALLED ON LEFT SIDE N. 1**

Free-standing pre-melting device for Polyurethane glue with **Melt On Demand** technology placed outside the machine and on a mobile carriage for an easy positioning.

The glue cartridge (which can be inserted in the melting tank with the protective film) is pushed through a pneumatic pusher on a heated grill that melts only the first glue layer.

An operator interface is on board of the premelter. The device can be interfaced with the main control of the edgebander.

The cartridge can be removed without damage after a partial use, as it is not fully melted.

Electronic temperature control. Under-/over-temperature

monitoring.

Pump with variable rotating speed to adjust the glue capacity supplied directly from the control interface.

0.5 Kg melted glue stock under the melting tank area. It allows sufficient duration to substitute the ended cartridge without stopping the machine time

Heated hose which allows the melted glue supply up to EB 60 V slot applicator. Reinforced Inox steel, thermo-isolated hose, with disconnect fittings for the connection. FE/KO thermo-couples.

Technical data

Melt capacity: **16 kg/h**

Operating temperature: °C 50-150

Cartridges: cylindrical type, **18/20 Kg** with external protective material in aluminum, 280 mm diameter

It does not require inert gas for the functioning.

A0.05.92 GLUE POT FEEDING ON THE 2ND BEAM WITH SINGLE PREMELTER "VERSAPUR SLUG" **FOR RIGHT SIDE** N. 1

It allows the use of a single pre-melting unit for supplying the PUR glue in the glue pot in both sides of a double side edgebander/squaring edgebander.

It includes, in addition to VERSAPUR SLUG premelter (compulsory and not included):

- 2nd pump con heated hose on premelter
- heated Hose for Hot Melt, with temperature control, insulated, reinforced with stainless steel mesh, electrical connectors with quick-release. Length 9,000 mm. Internal diameter: 16 mm
- maximum machine opening: 3,200 mm

A5.07.00 "R-E" TRIMMING UNIT, 1 KW N. 2

For the rough trimming of thin and thick edges or for the finishing of solid wood:

It consists of:

- closed and highly stiff monolithic supporting structure;
- two overlapped motors with **quick release** of the motor bloc + tool for a fast and precise change
- vertical movement on linear ball recirculating guides with manual lubrication
- top motor connected to the pressure beam for the automatic adjustment of the working position according to the panel thickness
- "ED-SYSTEM" high efficiency exhaust hoods
- copying system by vertical disc-shape feelers of large diameter
- motor+tool position manually adjustable with numerical indicators
- device for the **automatic vertical positioning by HMI** on 2 positions with manual adjustment of stops by numerical indicators



Technical data:

Panel thickness min/max: 8-60 mm
 Edge thickness min/max: 0,3-12 mm
 Motor power: 2 x kW 1
 Motor rotation speed: rpm 12000
 Separate vertical automatic exclusion
 Tools installed: head with HM cutters to throw Ø 80x20

A5.05.03 EXHAUST HOODS WITH TEFLON COATING INSTEAD OF STANDARD ONE FOR TRIMMING UNIT "R-E" N. 2
A5.09.21 "RSU-E" FINE TRIMMING UNIT, 1 KW N. 2

For the finishing of thin edges and wood or for the rough trimming of the radius on plastic edges PVC/ABS/PP:

It consists of:

- high stiff and closed monolithic supporting structure
- motors moving on linear ball recirculating guides with manual lubrication
- two motors tilted at 20°
- manual device for the **quick-release** of the motor bloc + tool for a fast and precise change of processing or tool
- top motor connected to the pressure beam for the **automatic adjustment** according to the edge thickness
- **vertical copying system** by disc-shape feelers of large diameter
- **horizontal copying system** by disc-shape feelers of large diameter with independent adjustment
- numerical indicators for the horizontal and vertical shifting/adjustment of motors and for the shifting/adjustment of lateral feelers
- **separate** vertical and horizontal automatic exclusion of motors
- automatic exclusion of lateral feeler for the passage of max 25 mm thick solid wood.

**Technical data:**

Panel thickness min/max: 8/60 mm with max 1 mm thick edge
 Panel thickness min/max: 10/60 mm with max 2 mm thick edge
 Panel thickness min/max: 12/60 mm with max 3 mm thick edge
 Edge thickness min/max: 0,3/12 mm
 Motor power: 2 x 1 kW
 Motor speed: 12000 rpm
 Tools: not installed

A5.09.28 NC MULTIEDGE KIT FOR THE STRAIGHT/R/R/R PROCESSING FOR "RSU-E" N. 2

For the finishing of thin edges or solid wood, or for the rough trimming of the radius on plastic edges PVC/ABS/PP.

It replaces the "RSU-E" manual unit with the "**RSU-E NC MULTIEDGE**" unit with the same power.

It allows the processing up to 3 rounded edges + infinite thin edges or wood edge (specific tool to be chosen), with setting directly from NC without manual adjustments.

It consists of:

- highly stiff and closed monolithic structure
- 2 motors tilted at 20°
- manual device for the quick release of the tool-holder block/tool for a fast and precise change of processing or tool
- upper motor connected to the pressure device for the automatic adjustment depending on the thickness of the panel
- motors moving on linear ball recirculating guides with manual lubrication
- vertical copying system by disc-shape feelers of large diameter
- horizontal copying system by disc-shape feelers of large diameter with independent adjustment
- power assisted positioners for the vertical and horizontal automatic movement of the tool-holder carriage + tool
- power assisted positioners for the horizontal automatic movement of the lateral feeler on infinite working positions.
- separate vertical and horizontal automatic exclusion of motors
- automatic exclusion of the lateral feeler for the passage of max 25 mm solid wood

Technical data:

Panel thickness min/max: 8/60 mm with max 1 mm thick edge

Panel thickness min/max: 10/60 mm with max 2 mm thick edge

Panel thickness min/max: 12/60 mm with max 3 mm thick edge

Motor speed: 12000 rpm

Tools straight/R/R/R: not installed



A5.09.88 EXHAUST HOODS WITH TEFLON COATING INSTEAD OF STANDARD FOR "RSU-E" N. 2



A7.73.34 NO. 2 "ED-SYSTEM" HM TOOLS 3/2/1/STRAIGHT N. 2

A7.38.36 MILLING UNIT U WITH THE SAME ROTATION AS THE FEED DIRECTION KW 5,5 N. 2

For through or timed grooves on the top, bottom and sides of the panel:

- motor manually tiltable up to 90°;
- double direction of tool rotation for vertical or horizontal motor positioning
- selected from the controller;
- **time-entry device on linear ball recirculating guides with high degree precision of intervention assured by the special software support;**



- numerical indicators for the vertical and horizontal positioning of the motor;
- tool-holder flange for cup-shaped cutter;
- manual adjustment of time-entry;
- 2 quick change exhaust hoods for top, bottom and lateral machining;
- blowers for the panel cleaning;
- automatic cut-off.

Technical data:

Intervention precision at 20 m/min: mm +/- 2

Intervention precision at 30 m/min: mm +/- 3

Speed: rpm 12000

Motor power: kW 5,5

Tool not installed: Ø mm 125 max. height mm 63

A9.10.20 ELECTRONIC VERTICAL POSITIONING N. 2

Including driver and ball screw.

A9.10.21 ELECTRONIC HORIZONTAL POSITIONING N. 2

Including driver and ball screw.

A5.08.99 TIME-ENTRY AUTOMATIC SELECTION N. 2

For the automatic selection of the direction of the time-entry depending on the milling unit position (horizontal and vertical).

A5.08.29 90 MM LONG SHAFT FOR MULTIPLE CUTTER TOOLS N. 2

Instead of the standard 55 mm.

A7.80.38 KIT ANTI-EJECTION SOLID WOOD LIPPINGS N. 2

Kit for machining of solid wood safely, when it is processed (profiling or realization of grooves) with tools having the same rotation as the panel feed direction.

It consists of a contrast and pressure system on the top, bottom and side of the panel.

Note: Compulsory device when the machine is equipped with "VC600" or "HM3002" gluing unit together with the MILLING UNIT "U" WITH THE SAME ROTATION AS THE FEED DIRECTION (code A73834 or A73836)

A5.12.13 "RCS-E" EDGE SCRAPING UNIT N. 2

For the finishing/smoothing of rounded plastic edges PVC/ABS/PP: It consists of:

- closed and highly stiff **monolithic** supporting structure
- manual device for the **quick-release** of the tool holder bloc + tool for a fast and precise change of the tool
- upper tool holder carriage connected to the pressure beam for the **automatic adjustment** according to the edge thickness
- tool holder carriages moving on **linear** ball recirculating **guides** with manual lubrication
- **vertical copying system** by disc-shape feelers of large diameter



- **horizontal copying system** by lateral disc-shape feelers of large diameter with independent adjustment
- numerical indicators for the horizontal and vertical shifting/adjustment of tool holder carriages and for the shifting/adjustment of lateral feelers
- suitable cleaning and nebulising blowers for each tool
- suction of the edging cuts-off with suitable external container for plastic chips

Technical data:

panel thickness min/max 8/60 mm with max 1 mm thick edge
 panel thickness min/max 10/60 mm with max 2 mm thick edge
 panel thickness min/max 12/60 mm with max 3 mm thick edge
 edge thickness min/max 0,3/3 mm

separate vertical and horizontal automatic exclusion of tool-holder carriages and for the passage of max 25 mm thick solid wood
 Tools not included

A5.12.58 NC MULTIEDGE KIT FOR PROCESSING STRAIGHT/R/R/R N. 2

For the finishing/smoothing of PVC/ABS/PP rounded edges.

It replaces the "RCS-E" manual unit with the "**RCS-E NC MULTIEDGE**" unit.

It allows the processing up to 4 edges: 3 rounded edges + 1 straight edge or 4 rounded edges, with setup directly from NC without manual adjustments.

It consists of:

- high stiffness closed monolithic structure
- manual device for the quick release of the tool-holder block/tool for a fast and precise change of processing or tool
- upper tool holder carriage connected to the pressure device for the automatic adjustment depending on the thickness of the panel
- tool-holder carriages moving on linear ball recirculating guides with manual lubrication
- vertical copying system by large diameter disc-shape feelers
- horizontal copying system by large diameter disc-shape feelers with independent adjustment
- power assisted positioners for the vertical and horizontal automatic movement of the tool-holder carriage + tool
- power assisted positioners for the horizontal automatic movement on infinite working positions of the lateral feeler

Technical data:

panel thickness min / max: 8/60 mm with max 1 mm thick edge
 panel thickness min / max: 10/60 mm with max 2 mm thick edge
 panel thickness min / max: 12/60 mm with max 3 mm thick edge
 edge thickness min / max: 0.3 / 3 mm

separate vertical and horizontal automatic exclusion of motors
 automatic exclusion of the lateral feeler for the passage of max 25 mm solid wood
 tools straight/R/R/R not installed



A5.12.36 WASTE PRODUCT DETACHMENT SYSTEM N. 2

Helps the waste product suction.

A7.73.80 NO. 2 PLATES 3/2/1/STRAIGHT N. 2
A5.12.11 "RCA/2C" GLUE SCRAPING UNIT N. 2

It eliminates possible excess of glue on the top and bottom side of the panel:

- completed with two cutter-tools of Widia;
- vertical feelers;
- two blowers which allows the cutters to be always clean;
- pneumatic intervention to assure the best processing of the starting and the ending side of the panel;
- automatic cut-off.


A5.16.10 ANTI-ADHESIVE DEVICE FOR CUTTER CLEANING N. 2
"RCA/2C" GLUE SCRAPER

To avoid deposits of glue on the cutter tools of the scraping unit in order to improve panel quality and cleaning from glue residue.

It includes:

- 2 spraying guns, feed by 2 RIEPE LP 163/93 liquid boxes

Note: if used together with code A51451, the brightness of some particular types of edges (poor pigmentation) can be of lower quality than that obtainable with blowing brightening units (Phon type).

A8.15.76 "SP/F" OVERLAPPED BRUSHING UNIT N. 2

For the cleaning and finishing (shining) of plastic edges:

- two overlapped motors with manual inclination completed with two cloth brushes
- top motor connected to the pressure beam for the automatic adjustment according to the thickness panel
- manual cut-off

Technical data:

Speed: rpm 1500

Max. horizontal inclination: 5°

Max. vertical inclination:

- with 8 mm panel: 4°

- with 60 mm panel: 8°

Motor power: kW 0,29+0,29

Brush dimensions: mm 150x50x33



A8.15.77 PNEUMATIC CUT-OFF AND OSCILLATION FOR "SP/S", N. 2
"SP/F"

B8.10.52 GUN-SHAPED BAR CODE READER N. 1
 The bar code reader reads the program to be run and the panel thickness value.

A0.04.56 WATCH B02: SOFTWARE FOR LINE MANAGEMENT (2 N. 1
MACHINES + MAHROS/SAG ROTATOR SYSTEM)
 Control and supervision software "WATCH" that integrates into a single point of command / control all areas of the edgebanding / squaring-edgebanding cell for quick and easy management of various functions and sends the processing programs to all machines according to the production list.
 It optimizes production changes and reduces times of set up and machine programming.
 It allows to receive support and remote assistance.
 "WATCH" is developed and implemented by SCM GROUP.

Features:

- **User-friendly operator interface**, with intuitive and immediate use, with real-time visualization of the production flow of the line production, the work zones and process / machine available data (ID panels, quantity of workpieces ..). The plant interface corresponds to the plant layout and allows to define and check its conditions of each zone.

- **The entire production cycle management** ensures the analysis to get maximum flexibility for both large batches that for small orders (custom analysis in function of the architecture of the cell and the equipment of each machine).

- **Programming management with Program Editor/ processing cycles** to be performed on the plant. The programs can be imported (manually or with optional Bar Code), created, edited, saved, deleted, renamed and moved. The data for the programs can be imported from SQL or XML database, even by the company management system; the Editor can also manage lists or mix of processing that is the sequences of programs to be generated in order to reuse and launch them running. The lists or mix can be queued or launched running entirely or partially, with a selection of the necessary processing. The lists or mix can be called up / queued / run running even through Bar Code option. The validation function is also available for the check of the feasibility of the configured program/list/mix in function of the plant parameters. There is no limit to the number of programs/list/mix the system can handle.

- **Diagnostics management** which allows the display of all messages / alarms / warning system of the plant with assignment of the priority / severity. For each alarm, an additional management window is configurable where information (images and text) can

manually be added and saved as history for the operator.

- **Report management** that allows the viewing, exporting, printing of statistical data referring to messages, states, productivity, and performed production (for each product with date-time start-end and relative amounts). The information are filterable per time set by the operator. The reports are available for each machine or the whole plant.

- **Shift management** for setting of the shifts of plant utilization, breaks, time slots in the 24 hours and weekly. The shift change operation can be done automatically or by user request.

SPEC03 Mantis 15879: Gestione con supervisore Watch di una foratrice Morbidelli (prossimo acquisto) posta in uscita seconda SQB con scarico manuale N. 1

A0.04.58 WATCH 001: SOFTWARE FOR BAR CODE READER N. 1

A0.04.60 MOBILE CONTROL WORKSTATION FOR THE LINE SUPERVISOR N. 1

It allows to use the line supervisor from a comfortable position that can be chosen according to the length of cable provided, instead of the standard position of the machine.

Equipped with the PC with the line management software installed (optional), complete with screen, keyboard, mouse and main control switches.

It includes:

- support for the keyboard and the mouse
- easy access to the PC, placed in a side space with door
- 8 m long connection cable between workstation and the machine (longer lengths of cable must be managed separately)
- swiveling wheels equipped with manual brake for the positioning and the fixing of the station

Main features:

PC Office.

Operating system: Windows 7 Professional

Screen: 17" TFT LCD.

2 network card ETHERNET.

6 USB ports - 2 PS/2 ports.

Bar code reader management.

DVD reader.

Remote diagnostics web / based allows connection via Internet of the machine supervisor PC to SCM Group Service.

Hardware equipment: card/network interface.

Software equipment: linking program **TEAMVIEWER®** that allows:

- View of operator interface
- Signal diagnostic
- On-line checking and editing of the configuration, parameter and

program status of the machine

- Data backup and file transfer
- Upgrade of the machine logic and operator interface

The Buyer shall prepare Internet access on the PC machine.

KASPERSKY® Internet Security

The PCs are equipped with antivirus protection software and Kaspersky Internet Security firewall.

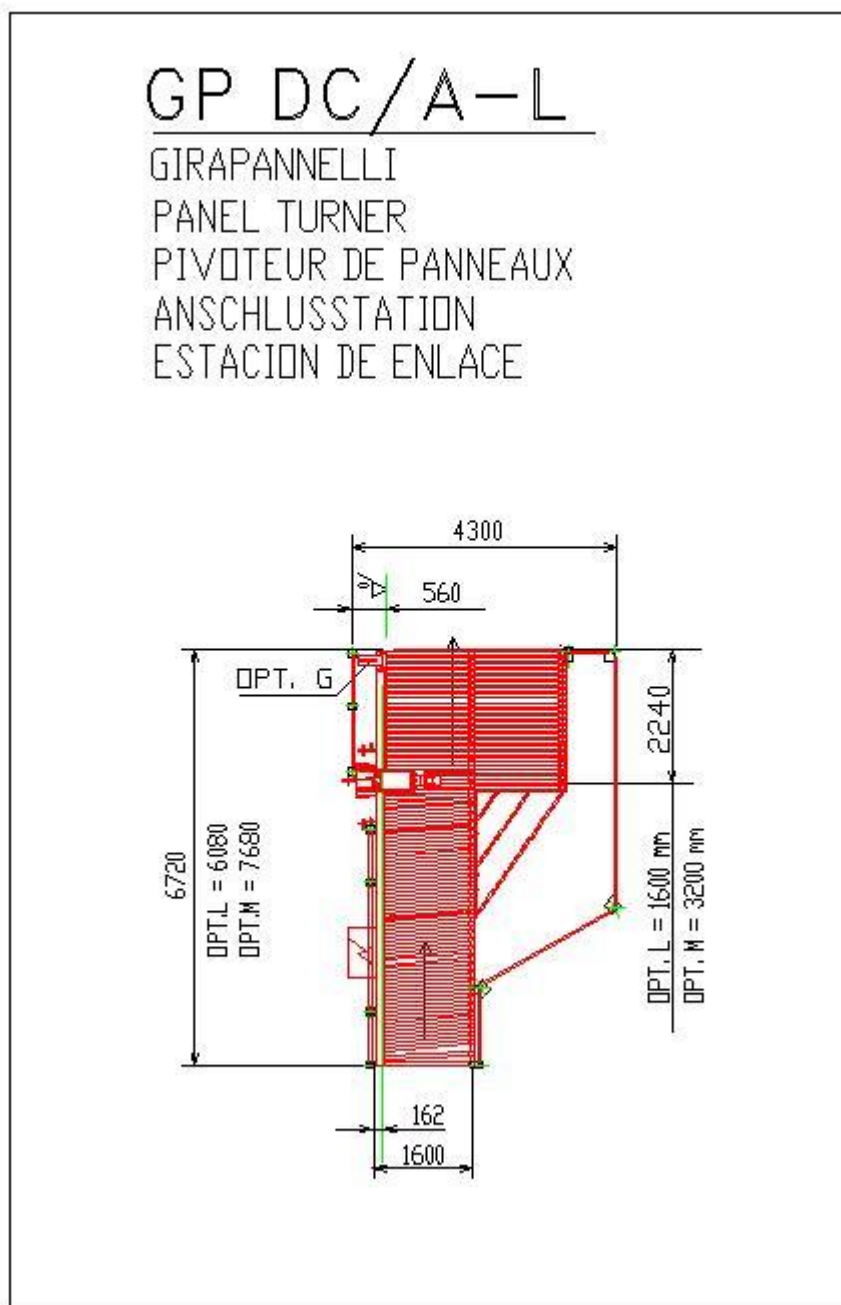
The license has a term of one year, starting from the shipment date of the machine.

The licence renewal at maturity is at customer's charge. If not renewed, the product is not deactivated, but it becomes impossible to update it with new virus definitions.

52.26.41	Operating cost for additional packing	N. 1
SPEC01	Mantis 0015665: Lingua software in Slovacco per Evolution SB	N. 1

AUTOMATIC DOUBLE-SIDED SQUARING/EDGEBANDING MACHINE GP-DC BOR

Y0.05.22 STAZIONE GIRAPANNELLI PER LINEA SQ.B. "GP DC/A-L" N. 1





It is composed of:

GP/DC/A DOUBLE TAPERED-ROLLER PANEL ROTATOR

with reference fences on the left: rubber coated rollers for infeed fences and sheet outfeed fences, both of them are manually adjustable by means of hand-wheel. Aluminium extruded profile structure. The machine allows lengthwise panel translation and rotation to crosswise direction. It is equipped with an infeed conveyor, 4480 mm length and 1600 mm width, with PVC-coated rollers, diameter 60 mm, pitch 128 mm, operated by motor with adjustable speed by inverter 20 to 60 m/min.



Panel rotation unit is made of 2 rubber-coated tapered rollers with interchangeable tip and tapered-roller rotation speed is controlled by inverter. Powered working thickness adjustment with encoder, controlled by operating machine (Squaring-edgebander). The lower tapered-roller has a pneumatic exclusion by means of an electronic control. A pneumatic exclusion idle pivot improves panel rotation. The outfeed conveyor, 2240 mm length and 3070 mm width, is equipped with PVC-coated rollers, pitch 96 mm, diameter 60 mm, operated by two independent motors with adjustable speed by inverter 12 to 37 m/min. Front stops, placed at the end of the conveyor, allow the panel frontal alignment.

ENVIRONMENTAL CONDITIONS

The functioning of the machines is guaranteed within the following environmental condition:

temperature min/max: +10 ÷ +35 °C

relative humidity: max 1000m_above sea level_ (over this quota contact the Manufacturer).

NOTE: for an optimal functioning it is suggested to use the machines in a room having temperature between 18 and 30 °C and relative humidity between 30 and 65%.

ENERGY SAVING MODE

The automatic adjustment of the loading system speed according to the panels request allows the energy saving mode. In case of absence of panels to be processed in the machine for a certain period, the motors are automatically disconnected, then they automatically turn on as soon as the panels arrive. Furthermore, the energy saving mode is assured by using high efficiency and quality components.

BASIC MACHINE TECHNICAL DATA

TYPE OF PANELS

Standard chipboard panels /MDF ennobled, without projecting coat. Surfaces and/or edges of opaque colour (no glossy surfaces and/or reflective), without protective films.

PANEL DIMENSION		
Thickness	mm	10 to 60 mm
Length	mm	260 to 3200
Width	mm	210 to 1200
Weight	kg	60
TECHNICAL DATA		
on board Electrical control cabinet		
Voltage (three phase with neutral and ground cable)	Hz	400 V/50
Installed power	kW	10
Pneumatic feeding		
Solid	µm	≤40
Dew point	°C	+3
Oil concentration	mg/m ³	5 ≤
Feeding pressure	bar	from 6 to 8
Minimum pressure	bar	6
Compressed air consumption (6 bar)	l/min	80

External metallic guards in accordance with the safety standards now in force.

First panel quality control device

SYSTEM PRODUCTIVITY

10 to 40 panels/min.

MANUAL ADJUSTMENTS TO DO:

- * conveyor speed adjustable with potentiometer on the electric board
- * crosswise movement of guides and tapered rollers according to the working line

NOTES:

The machine must be powered by a neutral cable.

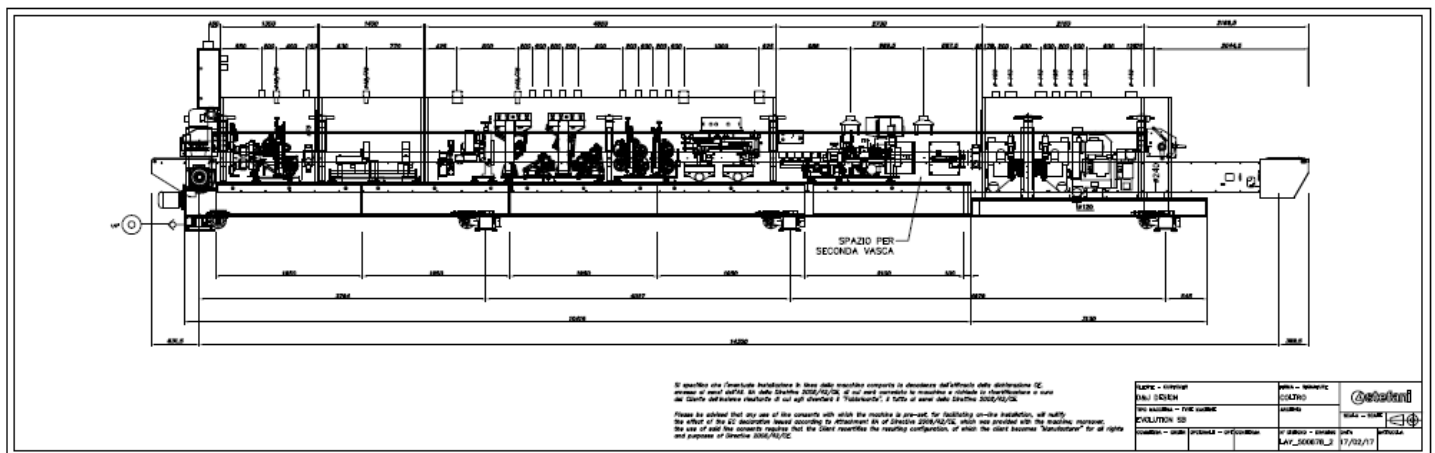
Notice:

The above technical data and dimensions refer to the basic machine only. The specifications of the product described could change by choosing optional devices.

93.12.01	Frequency 50 Hz	N. 1
93.07.31	Volt 400 EU	N. 1
Y8.11.28	PANELS HANDLING OF MINIMUM LENGTH 230 mm Instead of 260 mm, roller pitch 112 mm instead of 128 mm.	N. 1
Y8.11.22	PANELS WITH OVERHANGING EDGE (G) Outfeed conveyor equipped with pneumatic side aligner and lateral guide with exclusion.	N. 1
		
Y5.00.03	LARGE TAPERED ROLLERS can be produced from 15 to 40 panels/min.	N. 1
Y9.08.00	ANALOGICAL SIGNALS FOR SPEED CONTROL by operating machine.	N. 1
Y5.00.02	PRESETTING FOR NO.3 CONTROLLED AXIS Motorization with encoder for axis positioning of the two lateral guides and of the panel rotation unit. Axis control through the electronic control system of the machine toll (Squaring-edgebanding machine).	N. 1
Y9.08.51	User interface with languages different from the standard one For languages different from Italian, English, Spanish, French and German. User interface with Latin characters.	N. 1

Y9.08.52	Documentation with language different from the standard one	N. 1
	Operation and maintenance book, electric circuit arrangement and spare parts manual with language different from the Italian, English, Spanish, French and German. Documentation with Latin characters.	
52.26.41	Operating cost for additional packing	N. 1
10.98.06	Machine language: SLOVAK -SK-	N. 1

AUTOMATIC DOUBLE-SIDED SQUARING/EDGEBANDING MACHINE EVOLUTION SB 2^



A0.01.18	NR.1 USE AND MAINTENANCE HANDBOOK IN SLOVAK -SK-	N. 1
99.00.61	PC ENGLISH LANGUAGE	N. 1
A0.01.91	ELECTRICAL SCHEME IN ENGLISH	N. 1
A9.90.00	EUROPEAN SAFETY REGULATIONS (CE NORMS)	N. 1
93.07.31	Volt 400 EU	N. 1

93.12.01 Frequency 50 Hz N. 1

A3.47.50 EVOLUTION SB 2ND MACHINE IN LINE N. 1

Double-sided squaring/edgebanding machine with fixed working shoulder on the left for crosswise panel processing.

Designed to square/edge-band straight and soft-formed panels with coil and strip materials depending on machine configuration.

The large steel basement with high degree stiffness represents an optimum support for the working units and ensure no vibrations.

The **feed track** consists of 70 mm wide, self-lubrication nylon sliders, coated with wearproof vulcanised rubber with a high coefficient of friction to ensure the maximum panel holding and precision of working.

The conveyor track consists of one flat guide and one round guide made of ground steel to ensure the straightness of movement and the holding on lateral loadings. **Lubrication is automatic.**

The industrial chain is made from sintered steel links and special reinforced bearings.

The track pinions have 13 teeth with a tempered and ground profile.

Top pressers are made of steel of big thickness with drafted belt and with a single v-shaped profile. **Automatic positioning** according to the panel thickness by NC.

Numeric control two-speed motorised mobile shoulder opening. Fast speed to reach the machining area and slow speed to recover final positioning play.

Mobile shoulder sliding on support guides: on linear ball re-circulating guide at the back side, front and intermediate ground guides with centralised lubrication.

Automatic panel in-feed system complete with:

- In-feed track transfer;
- Out-feed track transfer;
- Right hand in-feed guide;
- Panel centring device with automatic pneumatic adjustment mounted on the mobile beam;
- Infeed chain extension for the automatic panel insert with max. 1000 mm length crosswise side ;
- Dogs with centre to centre of 500 mm, with automatic infeed controlled by panel presence. 3 height selections: 12, 18 and 25 mm.;
- Dogs waiting system with felt sector fit for **panel processing with soft surfaces** and logic management for space reduction between

- panels;
- Chain stake panel support consisting of two pneumatically controlled rods, secured to the upper pressers in the infeed area.

The **sound proof cabins** are coated with noise-reducing material and they are **lighted inside with anti-dazzling neon lights**. The sound proof cabins, closed and connected to the suction plant in accordance with the required specifications.

Top suction system with suitable inlets for each unit.

The standard supply voltage is **400 V EU (+/- 10%) 50 Hz (+/- 1%) (with neutral)**. In the case of different voltages, the adaptation to the voltage of the destination country must be provided by means of an optional transformer or a transformer supplied by the customer

Conditions for the correct operation of the machine:

- Humidity: max 90%
- Temperature when the machine is in operation: min 10 ° C / 35 ° C max

The machine is in conformity with the following machine directives:

- Directive **2006/42/CE** ("Machine")
- Directive **2014/30/UE** ("electromagnetic compatibility")

A machine complete with set-up for I/O line consents in order to ensure interfacing with any upstream and/or downstream machines. The use of the aforementioned consents in the context of line installation annuls the effectiveness of the EC declaration, issued under Attachment IIA of Directive 2006/42/CE, provided with the machine, and requires recertification at the Client's expense and responsibility of the resulting set of equipment of which he will become "manufacturer" under the provisions of Directive 2006/42/CE.

When inserted in a line, the machine must not be commissioned until the line it is inserted into is declared conformant with Directive 2006/42/CE.

The standard equipment includes:

PC control system for the fast, easy and precise handling of the main functions of the machine.

It includes:

Unlimited working programs.

Widened video pages especially for diagnostics and report.

Creation, rescue and editor of working programs.

Working units ON/OFF control.

Easy and guided diagnostics for the fast solution of possible mistakes.

Working statistical data: number of worked pieces and meters, of the employed hours etc.

Productive efficiency measurement (indicator of the actual production compared with the maximum feasible production).

Selection of the first or second pass without changing program.
Unit of measurement in mm.
Operator "WinEdge" interface in the following languages: Italian,
French, English, Spanish, German.
Functioning temperature: from 0 to + 45°C.

Main characteristics:

PC Office.

Operating system: Windows 7 Professional

Screen: 17" TFT LCD.

2 ETHERNET network cards.

6 USB ports - 2 ps/2 ports and possibility of connection of Bar Code reader

DVD reader.

Remote diagnostics web / based allows connection via Internet of the machine supervisor PC to SCM Group Service.

Software equipment:**TEAMVIEWER®**

Software for remote diagnostic control of the machine via internet.

It allows:

- view of operator interface
- signal diagnostic
- on-line checking and editing of the configuration, parameter and program status of the machine
- data backup and file transfer
- upgrade of the machine logic and operator interface

The Buyer shall prepare Internet access on the PC machine.

KASPERSKY® Internet Security

The PCs are equipped with antivirus protection software and

Kaspersky Internet Security firewall.

The license has a term of one year, starting from the shipment date of the machine.

The licence renewal at maturity is at customer's charge. If not renewed, the product is not deactivated, but it becomes impossible to update it with new virus definitions.

Each unit has its own inverter.**Instruction booklet** attached.

Standard paint finish: Grey RAL 9002.

TECHNICAL DATA

Variable track feed speed m/min 10-40

The working speed depends on the combination of the working units.

For softforming processing the feed speed can vary according to the type of profile and to the applied edge.

Panel overhang from the track: fixed
- standard straight processing mm 35

- with YA	mm 75
- softforming processing	mm 55

Panel dimensions:

Thickness	mm 8-60
-with 2M 100	mm 10-60

Minimum width:

- standard straight processing	mm 225
- with YA	mm 305
- softforming processing	mm 265

Maximum width	mm 3200(*)
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(*) This width requires the choice of the self-centering central panel support as optional.

Minimum length: depending on the installed working units.

Data refer to the panel before the edge application.

Attention! for the processing line consisting of machines and transport machines, the data of the minimum and maximum dimensions of the panel to work in the line have to be considered greater than the data of each stand alone machine/automation in the processing line.

Max. panel weight	Kg 80
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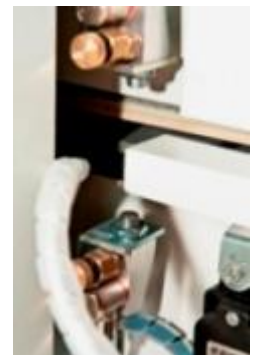
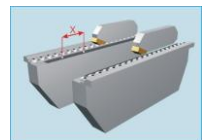
Variable working height	mm 960 (+/-10 mm)
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The performance in the quotation may vary depending on the types of processing, especially it can change according to the speed, to the processed materials and removed material.

The floor has to comply with the enclosed foundation plan.

A3.47.57	EVOLUTION SB 2-143	N. 1
	Machine total length: mm 15350	
P3.05.50	MODULE TYPE B FOR 13 TEETH 3130	N. 1
P3.06.62	MODULE TYPE A FOR 13 TEETH 10415	N. 1
B0.91.00	400V/50HZ POWER SUPPLY WITH NEUTRAL	N. 1
P3.11.10	CENTRAL SELF-CENTRING SUPPORT FOR 13 TEETH	N. 1
A3.46.63	ADDITIONAL CENTERING DEVICE ON THE FIXED SIDE FOR 2ND OR 1/2ND MACHINE IN LINE	N. 1
P1.04.04	EXTRA-WIDE RUBBERIZED FEED DOGS FOR VENEER / HIGH SPEEDS	N. 1

- A3.32.33 CLEAN PACK L FOR PROTECTED EDGES - ONE SHOULDER N. 2**
 Suitable to protect delicate edges or without protective film with the risk of detachment, in contact with feelers and/or tools of the same film.
 Complete with a spraying gun, and tank for the anti-adhesive liquid RIEPE NFLY.
- A3.31.81 MACHINE DIVIDED IN TWO FOR TRANSPORT (BY SHOULDER) N. 2**
- A9.01.61 CROSSWISE PANEL INFEED 1200 MM N. 1**
 Max. panel weight kg 120
- P2.01.47 PANEL OVERHANG VARIABLE BY CONTROL ON SQUARING/EDGEBANDING MACHINE 2ND IN LINE N. 1**
- P1.04.07 DOGS GAP OF 300 MM INSTEAD OF 500 MM N. 1**
- A1.80.00 SQUARING AREA FREE COMPOSITION N. 1**
- A5.01.64 "AAR" SPRAY ANTI-ADHESION UNIT N. 2**
 To avoid deposits of glue on the top and bottom surface of the panel. It is completed with 2 spray-guns fed by two anti-adhesive liquid containers.
- A4.03.50 "AS" ANTICHIPPER UNIT KW 4 + "DTR" DOUBLE HOGGING UNIT KW 5,8 N. 2**
 For the crosswise panel processing:
 - automatic timing operation for vertical motor with antichipping function;
 - two horizontal motors, misaligned between themselves with double hogging function



- all motors mounted on the same base.
- numerical indicators for shifting of the lower motor ad alignment to the upper motor
- numerical indicators for the vertical and horizontal shifting of motors. Horizontal shifting used for manual adjustment of panel overhang from track.

Technical data

Speed: rpm 6000

Antichipping unit

Motor power: kW 4

Tools not installed Ø min.-max. mm 160-190*Double hogging unit*

Motors power: kW 5,8+5,8

Tools not installed Ø min.-max. Mm 200-250

P2.01.20 VARIABLE PANEL OVERHANG BY CONTROL (ELECTRONIC HORIZONTAL POSITIONING) N. 2

P3.21.01 "DTR" MOTORS WITH POWER OF 8 KW INSTEAD OF 5,8 KW N. 2

A4.04.87 AUTOMATIC MILLING UNIT FP KW 4 N. 2

Possible applications:

Panels profiling;

Processing through or timed milling:

- manual motor tiltable to 90°;
- double direction of rotation of the tool with selection from control;
- numerical indicators for the vertical and horizontal shifting of motors.

Horizontal shifting used for manual adjustment of panel overhang from track.

Technical data

Speed

rpm 6000

Motor power

kW 4

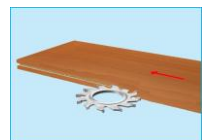
Tool not installed Ø min.-max.

mm 180-220

P4.21.02 MILLING UNITS MOTOR WITH 8 KW INSTEAD OF 4 KW N. 2

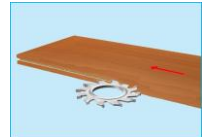
A4.30.08 ENLARGED MOTOR SHAFT 40X118 MM N. 2

P4.11.01 VERTICAL/ HORIZONTAL ELECTRONIC POSITIONING FOR N. 2



MILLING UNIT

Including driver and ball recirculating screws.



A4.04.87 AUTOMATIC MILLING UNIT FP KW 4 N. 2

Possible applications:

Panels profiling;

Processing through or timed milling:

- manual motor tiltable to 90°;
- double direction of rotation of the tool with selection from control;
- numerical indicators for the vertical and horizontal shifting of motors.

Horizontal shifting used for manual adjustment of panel overhang from track.

Technical data

Speed	rpm 6000
Motor power	kW 4
Tool <u>not installed</u> Ø min.-max.	mm 180-220

P4.21.02 MILLING UNITS MOTOR WITH 8 KW INSTEAD OF 4 KW N. 2

A4.30.08 ENLARGED MOTOR SHAFT 40X118 MM N. 2

P4.11.01 VERTICAL/ HORIZONTAL ELECTRONIC POSITIONING FOR MILLING UNIT N. 2

Including driver and ball recirculating screws.

A1.80.03 PRICE ADJUSTMENT FOR SQUARING AREA CLOSED COMPOSITION N. 1

A7.22.27 GLUING UNIT FOR STRAIGHT PROCESSING "HM 3002 LMS" N. 2

For the gluing on straight profiles of edges in coils and in strips with hot melted glue spreaded on the panel:

- provided with quick melt system for a fast glue melting
- small dimensions glue pot with Teflon antiadherent treatment to avoid incrustation
- copying of the glue pot on linear ball recirculating guides
- fast interchangeability of glue pot
- device to measure out the glue
- control of the glue temperature on glue pot and on the quick melt system
- safety edge presence
- smokes exhaust hood
- handling of the glue spreading roller, of the first pressure roller and of the feed roller by motors synchronized with the speed of

the track by inverter

- guillotine shear for edges in coil
- automatic system of edges loading for material in coils and strips which allows to change the types of applied edges in a short time
- pressure area with pneumatic independent adjustment of the pressure and decimal mechanical indicator of position composed by first motorized big diameter roller, made of Teflon and with three idle rolls with opposed iconicity.
- shifting of the pressure zone on linear ball recirculating guides
- automatic cut-off of the glue pot

Technical data:

Edge thickness	mm 0,3-12
Edge height	mm 12-65
Min. coil length	mm 230
Min. strips length	mm 230
Min. length of solid wood	mm 230
Cutting section max.	
- plastic edge	mm2 135 (mm 3x45)
- wood edge	mm2 96 (mm 3x32)
Strip storage capacity with single or double coil magazine	mm 200
Strip storage capacity with 6 coils magazine	mm 175
Glue pot capacity	kg 1,2
Glue melting capacity with pre-melting system	kg/h 22

P2.01.20 VARIABLE PANEL OVERHANG BY CONTROL (ELECTRONIC HORIZONTAL POSITIONING) N. 2

A7.22.86 PRECISION EDGE FEEDING AND REAR CUT HM N. 2

Main components:

- dragging roller motorized **by means of BRUSHLESS motor** to give the roller the necessary acceleration to bring the edge to the working position
- special software support for the shear.

Technical data:

Edge feeding and rear cut precision	
With speed up to 30 m/min	mm +/- 2
With speed up to 40 m/min	mm +/- 3

A7.23.23 ELECTRONIC POSITIONING OF EDGE GUIDE N. 2

A7.23.22 ELECTRONIC POSITIONING OF THE PRESSURE ROLLERS N. 2

A7.23.21 TIMED INTERVENTION OF THE PRESSURE ROLLERS N. 2

A7.23.42 MANUAL TABLE LIFTING FOR "HM 3002" N. 2

Manual height adjustment the in-feed table from +2 up to -7 mm.
The standard table position is -2mm in comparison to the track.

A7.23.39 MOTORIZATION OF THE VERTICAL ROLLER MAGAZINE N. 2

A7.23.15 KIT FOR GLUE POT CLAMPING HM 3002 N. 2

A5.03.63 INCREASED GLUE MELTING CAPACITY N. 2

It increases glue melting capacity of LMS melting system from 22 kg/hour to **40 kg/hour**. Hot melt granulate feeding system is required.

A5.03.62 HOT MELT GRANULATE FEEDING SYSTEM LMS N. 2

A7.23.82 DRIVEN RUBBER ROLLERS FOR DELICATE EDGES N. 2

Advised for delicate thin edge (paper, PVC) or edges with posterior lacquering face.

A8.16.17 ANTI-ADHESIVE DEVICE FOR FIRST PRESSURE ROLLER N. 2

It prevents the glue sticking to the first roller of the pressure zone of the gluing unit for straight. It's complete with a spraying gun, and tank for the anti-adhesive liquid.

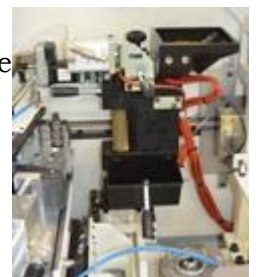


A8.16.37 "SGP" GLUE POT WITH AUTOMATIC DOSING BY NC IN SUBSTITUTION OF THE STANDARD ONE N. 2

It allows a **quick changeover of the used glue type/colour**. The glue pot is fed by the standard pre-melting system for EVA glue.

Features:

- specific **compact design** that reduces to a minimum the melted glue before the application in order to maintain the best quality characteristics
- spreading roller with optimized graining and PLASMA anti-adherent treatment
- **automatic emptying cycle** with collection of the residual glue on a removable tank
- automatic locking of glue loss with stopped machine (SCM GROUP patent)
- **automatic dosing adjustment by NC** according to the used glue and/or to the panel type and finish quality
- glue roller reverse rotation
- **quick release** device for the removal and easy replacement of the glue pot
- **simple and quick access** for the internal cleaning with the possibility to disassemble all parts.
- **short time of heating** of the glue during the starting of the machine thanks to its small dimensions
- **double thermo-regulation system** for an easy use of two types of glue with different melting temperature



Technical data:

Heating time from environment T°: <10 min

Heating time from pre-heating T°: <5min
 Glue capacity: 0,5 Kg
 Installed power: 2,05 kW

A7.23.16 3 ADDED PRESSURE ROLLERS HM N. 2

A5.01.52 HEATING DEVICE RPS FOR MAX. 60 MM THICKNESS PANELS N. 1

Complete with no. 2 shotwave lamps 1500W set before the gluing unit to pre-heat the side of the panel.



A7.22.19 VERTICAL 2 ROLLER PLIER MAGAZINE WITH AUTOMATIC EDGE TURNOVER (MAX. H=65) N. 1

Feeding edges system with 2 stations automatic infeed for material in coil with the chance to insert material in pile-form in thin strip or thin solid wood:

- 2 coil-holder magazines vertically placed;
- automatic infeed system of the belt with automatic change-over at the end of the roll;
- warning indicating the end of the roll.

Technical data:

Maximum roll Ø	mm 800
Max. edge thickness	mm 3
Max. edge height:	
For thin edges up to 1 mm	mm 65
For edges up to 3 mm	mm 45
Distance between panels:	
18 / 25 / 35 / 40 m/min	mm 300 / 320 / 350/ 380

SPEC02 Mantis 15873:Second modul glue, included support and motorization pot for accept pre melting VERSA PUR and unit lamp RPS thikcness max 60 mm N. 2

A8.16.39 ADDITIONAL "SGP" GLUE POT WITH NC DOSING DEVICE - FEEDING BY PREMELTER N. 2

Interchangeable with the "SGP" glue pot installed on the machine.

A0.05.90 "VERSAPUR SLUG" PREMELTER FOR PU GLUE FOR GLUE POT FILLING **INSTALLED ON LEFT SIDE N. 1**

Free-standing pre-melting device for Polyurethane glue with **Melt On Demand** technology placed outside the machine and on a mobile carriage for an easy positioning.

The glue cartridge (which can be inserted in the melting tank with the protective film) is pushed through a pneumatic pusher on a heated grill that melts only the first glue layer.

An operator interface is on board of the premelter. The device can be interfaced with the main control of the edgebander.

The cartridge can be removed without damage after a partial use, as it is not fully melted.

Electronic temperature control. Under-/over-temperature monitoring.

Pump with variable rotating speed to adjust the glue capacity supplied directly from the control interface.

0.5 Kg melted glue stock under the melting tank area. It allows sufficient duration to substitute the ended cartridge without stopping the machine time

Heated hose which allows the melted glue supply up to EB 60 V slot applicator. Reinforced Inox steel, thermo-isolated hose, with disconnect fittings for the connection. FE/KO thermo-couples.

Technical data

Melt capacity: **16 kg/h**

Operating temperature: °C 50-150

Cartridges: cylindrical type, **18/20 Kg** with external protective material in aluminum, 280 mm diameter

It does not require inert gas for the functioning.

A0.05.92 GLUE POT FEEDING ON THE 2ND BEAM WITH SINGLE PREMELTER "VERSAPUR SLUG" **FOR RIGHT SIDE** N. 1

It allows the use of a single pre-melting unit for supplying the PUR glue in the glue pot in both sides of a double side edgebander/squaring edgebander.

It includes, in addition to VERSAPUR SLUG premelter (compulsory and not included):

- 2nd pump con heated hose on premelter
- heated Hose for Hot Melt, with temperature control, insulated, reinforced with stainless steel mesh, electrical connectors with quick-release. Length 9,000 mm. Internal diameter: 16 mm
- maximum machine opening: 3,200 mm

A5.05.45 UPPER END TRIMMING UNIT "YU/SP-1000" KW 0,35 N. 2

For the removal of the exceeding edge from the top and bottom of the panel:

- unit installed on the pressure beam
- two motors with pneumatic stroke
- front, back feeler with automatic intervention
- lateral feelers on linear ball recirculating guides with pneumatic intervention
- motors with manual inclination up to 22°
- automatic cut-off.



Technical data:

Speed: rpm 12000

Max. track speed (depending on edge thickness): m/min 25

Motor power: kW 0,35+0,35
 Edge thickness: mm 0,4-25
 Max. edge section: mm² 1100
 Min. panel length:
 - on single-sided machine: mm 140
 - on double-sided machine (with manual introduction): mm 80
 Distance between panels: mm 120
 Min. distance between the beginning (end) of one panel and the beginning (end) of the following at /min 25: mm 600
 Blade stroke: mm 40
 Tools installed: nr. 2 blades Ø 150 mm

P2.01.20 VARIABLE PANEL OVERHANG BY CONTROL (ELECTRONIC HORIZONTAL POSITIONING) N. 2

A5.05.71 AUTOMATIC HORIZONTAL BLADE TILT "YU" N. 2

A5.07.00 "R-E" TRIMMING UNIT, 1 KW N. 2

For the rough trimming of thin and thick edges or for the finishing of solid wood:

It consists of:

- closed and highly stiff monolithic supporting structure;
- two overlapped motors with **quick release** of the motor bloc + tool for a fast and precise change
- vertical movement on linear ball recirculating guides with manual lubrication
- top motor connected to the pressure beam for the automatic adjustment of the working position according to the panel thickness
- "ED-SYSTEM" high efficiency exhaust hoods
- copying system by vertical disc-shape feelers of large diameter
- motor+tool position manually adjustable with numerical indicators
- device for the **automatic vertical positioning by HMI** on 2 positions with manual adjustment of stops by numerical indicators



Technical data:

Panel thickness min/max: 8-60 mm
 Edge thickness min/max: 0,3-12 mm
 Motor power: 2 x kW 1
 Motor rotation speed: rpm 12000
 Separate vertical automatic exclusion
 Tools installed: head with HM cutters to throw Ø 80x20

A5.05.03 EXHAUST HOODS WITH TEFLON COATING INSTEAD OF STANDARD ONE FOR TRIMMING UNIT "R-E" N. 2

A5.09.21 "RSU-E" FINE TRIMMING UNIT, 1 KW N. 2

For the finishing of thin edges and wood or for the rough trimming of the radius on plastic edges PVC/ABS/PP:

It consists of:

- high stiff and closed monolithic supporting structure
- motors moving on linear ball recirculating guides with manual lubrication
- two motors tilted at 20°
- manual device for the **quick-release** of the motor bloc + tool for a fast and precise change of processing or tool
- top motor connected to the pressure beam for the **automatic adjustment** according to the edge thickness
- **vertical copying system** by disc-shape feelers of large diameter
- **horizontal copying system** by disc-shape feelers of large diameter with independent adjustment
- numerical indicators for the horizontal and vertical shifting/adjustment of motors and for the shifting/adjustment of lateral feelers
- **separate** vertical and horizontal automatic exclusion of motors
- automatic exclusion of lateral feeler for the passage of max 25 mm thick solid wood.



Technical data:

Panel thickness min/max: 8/60 mm with max 1 mm thick edge

Panel thickness min/max: 10/60 mm with max 2 mm thick edge

Panel thickness min/max: 12/60 mm with max 3 mm thick edge

Edge thickness min/max: 0,3/12 mm

Motor power: 2 x 1 kW

Motor speed: 12000 rpm

Tools: not installed



A5.09.28 NC MULTIEDGE KIT FOR THE STRAIGHT/R/R/R PROCESSING FOR "RSU-E"

N. 2

For the finishing of thin edges or solid wood, or for the rough trimming of the radius on plastic edges PVC/ABS/PP.

It replaces the "RSU-E" manual unit with the "**RSU-E NC MULTIEDGE**" unit with the same power.

It allows the processing up to 3 rounded edges + infinite thin edges

or wood edge (specific tool to be chosen), with setting directly from NC without manual adjustments.

It consists of:

- highly stiff and closed monolithic structure
- 2 motors tilted at 20°
- manual device for the quick release of the tool-holder block/tool for a fast and precise change of processing or tool
- upper motor connected to the pressure device for the automatic adjustment depending on the thickness of the panel
- motors moving on linear ball recirculating guides with manual lubrication
- vertical copying system by disc-shape feelers of large diameter
- horizontal copying system by disc-shape feelers of large diameter with independent adjustment
- power assisted positioners for the vertical and horizontal automatic movement of the tool-holder carriage + tool
- power assisted positioners for the horizontal automatic movement of the lateral feeler on infinite working positions.
- separate vertical and horizontal automatic exclusion of motors
- automatic exclusion of the lateral feeler for the passage of max 25 mm solid wood

Technical data:

Panel thickness min/max: 8/60 mm with max 1 mm thick edge

Panel thickness min/max: 10/60 mm with max 2 mm thick edge

Panel thickness min/max: 12/60 mm with max 3 mm thick edge

Motor speed: 12000 rpm

Tools straight/R/R/R: not installed

A5.09.88 EXHAUST HOODS WITH TEFLON COATING INSTEAD OF STANDARD FOR "RSU-E" N. 2



A7.73.34 NO. 2 "ED-SYSTEM" HM TOOLS 3/2/1/STRAIGHT N. 2

A7.38.01 CORNER ROUNDING UNIT "ROUND 4" N. 2

To carry out the **front and rear rounding** of shaped panels or PVC/ABS edges and thin solid wood with high finishing quality. It consists of:

- 4 motors supported by a parallelogram kinematic motion which allows the unit to follow the head (end) of the panel in sequence, independently from the geometry of the profile
- manual device for the **quick release** of the motor block + tool for a fast and easy change of processing
- motor+tool position manually adjustable with decimal readout
- **"ED-SYSTEM"** high efficiency exhaust hoods
- separate processing sequences to avoid the simultaneous working



which could cause vibrations of the panel, provided with oscillating motion to follow the panel

- copying system by frontal **rolling** feelers and lateral **slide** feeler

Technical data

Panel thickness:

with max. 1 mm thick edges	mm 8-60
with max. 2 mm thick edges	mm 10-60
with max. 3 mm thick edges	mm 12-60
Edge thickness min/max	0,3/3 mm
Motor power	4 x 0,35 kW
Motor speed	rpm 12.000
Max track feed speed	25 m/min
Min. concave profile radium	36 mm
Working line	35 mm
Panel gap at 25 m/min	500 mm
Minimum panel length	120 mm (for single sided edge bander)
Minimum panel length	80 mm (for double sided edge bander)
Max automatic exclusion	25 mm
Tools not included	

A7.38.11 MULTIEDGE KIT FOR 3 AUTOMATIC POSITIONS STRAIGHT/R/R N. 2

Kit for the processing of **1 thin edge + 2 rounded edges** with NC automatic changeover.

It includes, in addition to the standard, the device for the automatic changeover of the working tool position.

Tools straight/R/R not installed.

A7.38.13 NC LATERAL FEELER/TOOL POSITIONING N. 2

It allows the NC processing of infinite thin edges or the micro-adjustment of the rounded edges according to the installed or selected tools.

It includes a NC positioner for each working head, for the positioning of the tool+motor carriage with respect to the lateral feeler. It ensures an optimal adjustment/setting of the finish precision.

A7.38.14 LATERAL COPYING KIT FOR DELICATE MATERIALS N. 2

It allows the optimal processing of panels with delicate material or protective film.

A7.38.51 NO. 4 DIAMOND TOOLS STRAIGHT 20° MAX 0,8 MM/R=1/R=2 N. 2

A5.11.01 "YA" ROUND CORNER MILLING UNIT N. 2

For rounding the corners on panels edged in solid wood:

- two motors equipped with two independent movements by pneumatic control: translation on the carriage and simultaneous rotation controlled by templates
- front, back and lateral feelers

- templates combined with the tools which determine the radius of the corner
- automatic cut-off.

Technical data:

Speed	rpm 12000
Max. feed speed track	m/min 14
Motors power	kw 1+1
Min. work-radius	mm 3
Max. work-radius	mm 18
Min. panel overhang	mm 75
Panel thickness	mm 40
Min. length panel	mm 350
Tools and templates <u>not installed</u>	tool Ø (plus radius) mm40

SPEC03 Mantis 15880 : Set di due dime YA raggio da definire

N. 1



A7.38.36 MILLING UNIT U WITH THE SAME ROTATION AS THE FEED N. 2 DIRECTION KW 5,5

For through or timed grooves on the top, bottom and sides of the panel:

- motor manually tiltable up to 90°;
- double direction of tool rotation for vertical or horizontal motor positioning
- selected from the controller;
- **time-entry device on linear ball recirculating guides with high degree precision of intervention assured by the special software support;**
- numerical indicators for the vertical and horizontal positioning of the motor;
- tool-holder flange for cup-shaped cutter;
- manual adjustment of time-entry;
- 2 quick change exhaust hoods for top, bottom and lateral machining;
- blowers for the panel cleaning;
- automatic cut-off.

Technical data:**Intervention precision at 20 m/min: mm +/- 2****Intervention precision at 30 m/min: mm +/- 3**

Speed: rpm 12000

Motor power: kW 5,5

Tool not installed: Ø mm 125 max. height mm 63**A9.10.20 ELECTRONIC VERTICAL POSITIONING N. 2**

Including driver and ball screw.

A9.10.21 ELECTRONIC HORIZONTAL POSITIONING N. 2

Including driver and ball screw.

A5.08.99 TIME-ENTRY AUTOMATIC SELECTION N. 2

For the automatic selection of the direction of the time-entry depending on the milling unit position (horizontal and vertical).

A5.08.29 90 MM LONG SHAFT FOR MULTIPLE CUTTER TOOLS N. 2

Instead of the standard 55 mm.

A9.01.14 ADDITIONAL EXHAUST HOOD FOR GROOVING MILLING UNIT N. 2

It improves the suction of the material removed by the grooving milling unit.

In addition to the hood, it includes a blower for the grooves cleaning.

A7.80.38 KIT ANTI-EJECTION SOLID WOOD LIPPINGS N. 2

Kit for machining of solid wood safely, when it is processed (profiling or realization of grooves) with tools having the same rotation as the panel feed direction.

It consists of a contrast and pressure system on the top, bottom and side of the panel.

Note: Compulsory device when the machine is equipped with "VC600" or "HM3002" gluing unit together with the MILLING UNIT "U" WITH THE SAME ROTATION AS THE FEED DIRECTION (code A73834 or A73836)

A5.12.13 "RCS-E" EDGE SCRAPING UNIT N. 2

For the finishing/smoothing of rounded plastic edges PVC/ABS/PP:
It consists of:

- closed and highly stiff **monolithic** supporting structure
- manual device for the **quick-release** of the tool holder bloc + tool for a fast and precise change of the tool
- upper tool holder carriage connected to the pressure beam for the **automatic adjustment** according to the edge thickness
- tool holder carriages moving on **linear** ball recirculating **guides** with manual lubrication
- **vertical copying system** by disc-shape feelers of large diameter
- **horizontal copying system** by lateral disc-shape feelers of large diameter with independent adjustment
- numerical indicators for the horizontal and vertical shifting/adjustment of tool holder carriages and for the shifting/adjustment of lateral feelers
- suitable cleaning and nebulising blowers for each tool
- suction of the edging cuts-off with suitable external container for plastic chips



Technical data:

panel thickness min/max 8/60 mm with max 1 mm thick edge

panel thickness min/max 10/60 mm with max 2 mm thick edge

panel thickness min/max 12/60 mm with max 3 mm thick edge

edge thickness min/max 0,3/3 mm

separate vertical and horizontal automatic exclusion of tool-holder carriages and for the passage of max 25 mm thick solid wood

Tools not included

A5.12.58 NC MULTIEDGE KIT FOR PROCESSING STRAIGHT/R/R/R N. 2

For the finishing/smoothing of PVC/ABS/PP rounded edges.

It replaces the "RCS-E" manual unit with the "**RCS-E NC MULTIEDGE**" unit.

It allows the processing up to 4 edges: 3 rounded edges + 1 straight edge or 4 rounded edges, with setup directly from NC without manual adjustments.

It consists of:

- high stiffness closed monolithic structure
- manual device for the quick release of the tool-holder block/tool for a fast and precise change of processing or tool
- upper tool holder carriage connected to the pressure device for the automatic adjustment depending on the thickness of the panel
- tool-holder carriages moving on linear ball recirculating guides with manual lubrication
- vertical copying system by large diameter disc-shape feelers
- horizontal copying system by large diameter disc-shape feelers with independent adjustment
- power assisted positioners for the vertical and horizontal automatic movement of the tool-holder carriage + tool
- power assisted positioners for the horizontal automatic movement on infinite working positions of the lateral feeler



Technical data:

panel thickness min / max: 8/60 mm with max 1 mm thick edge
 panel thickness min / max: 10/60 mm with max 2 mm thick edge
 panel thickness min / max: 12/60 mm with max 3 mm thick edge
 edge thickness min / max: 0.3 / 3 mm
 separate vertical and horizontal automatic exclusion of motors
 automatic exclusion of the lateral feeler for the passage of max 25 mm solid wood
 tools straight/R/R/R not installed

A5.12.36 WASTE PRODUCT DETACHMENT SYSTEM N. 2
Helps the waste product suction.

A7.73.80 NO. 2 PLATES 3/2/1/STRAIGHT N. 2

A5.12.11 "RCA/2C" GLUE SCRAPING UNIT N. 2
It eliminates possible excess of glue on the top and bottom side of the panel:

- completed with two cutter-tools of Widia;
- vertical feelers;
- two blowers which allows the cutters to be always clean;
- pneumatic intervention to assure the best processing of the starting and the ending side of the panel;
- automatic cut-off.



A5.16.10 ANTI-ADHESIVE DEVICE FOR CUTTER CLEANING N. 2
"RCA/2C" GLUE SCRAPER
To avoid deposits of glue on the cutter tools of the scraping unit in order to improve panel quality and cleaning from glue residue.
It includes:

- 2 spraying guns, feed by 2 RIEPE LP 163/93 liquid boxes

Note: if used together with code A51451, the brightness of some particular types of edges (poor pigmentation) can be of lower quality than that obtainable with blowing brightening units (Phon type).

A8.15.76 "SP/F" OVERLAPPED BRUSHING UNIT N. 2
For the cleaning and finishing (shining) of plastic edges:

- two overlapped motors with manual inclination completed with two cloth brushes
- top motor connected to the pressure beam for the automatic adjustment according to the thickness panel
- manual cut-off

Technical data:

Speed: rpm 1500
Max. horizontal inclination: 5°
Max. vertical inclination:
- with 8 mm panel: 4°
- with 60 mm panel: 8°
Motor power: kW 0,29+0,29
Brush dimensions: mm 150x50x33

A8.15.77	PNEUMATIC CUT-OFF AND OSCILLATION FOR "SP/S", "SP/F"	N. 2
52.26.41	Operating cost for additional packing	N. 1
SPEC01	Mantis 15666: Lingua software in Slovacco per Evolution SB	N. 1

GENERAL SALE CONDITIONS

Validity of offer:	30 days
Delivery time:	to be agreed/end September test Stefani, if customer pay end February.
Delivery terms:	ex our factory in Thiene; transport excluded <i>In case of transport at our charge by truck, the offloading of the machine and the costs sustained are at customer's charge</i>
Tools:	not included (except for what is indicated in description).
Payment:	20% down payment 75% before delivery 5% after test in D&J Design balance by irrevocable and confirmed letter of credit payable at sight on a main Italian Bank.
Installation and test-run:	all machines are accurately tested in house commissioning prior to despatch. First official test-run in customer's presence is included. This service also includes operator training. In case of test run at the customer's premises are included: <i>Offloading, machine positioning, electrical, pneumatic and suction connections have all to be carried out before our technician's arrival. If all connections have not been completed by the customer before our technician's arrival or if the necessary material for the test run (panels, edges, glue, etc) has not been prepared, the costs we sustain during the forced stop would be charged to the customer.</i>
Warranty:	the warranty covers the mechanical parts for a period of 12 months and the electrical and electronic parts for a period of 12 months starting from the date of test run at the customer's premises. For daily uses of more than eight hours, this term will be reduced proportionately. The warranty concerns the parts that in the producer's unquestionable opinion have manufacturing defects. Parts subject to normal wear and damages caused by tampering or improper use of the machine are excluded. Parts covered by warranty are supplied free of charge, while the transport costs, meals and hotels for STEFANI technicians will be charged to the consignee. Any other cost (e.g. labour cost of STEFANI technicians) will be covered by STEFANI. Any reimbursement or damage due to lost production caused by machine faults is excluded.

Packing: included