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Used WEMHÖNER VARIOPRESS®- Model BASIC Plus

Technical information

Press system	Hydraulic single daylight upstroke press With 2 tables, with automatic Vario pin system and turnover system
Year of construction	2012
Press body	Consists of steel frames which are bolted together to form a closed unit. Each frame is manufactured out of a single piece.
Heating platen dimensions	2.800 x 1.500 mm
Pressure chamber height	60 mm
Working height	Approx. 950 mm
Daylight opening	Max. 150 mm
Automatic membrane tensioning	Yes
Number of pressing cylinders	6
Diameter of press pistons	Ø 125 mm
Execution of press tables	2 Tables with Pin system, Solid steel platens - top and bottom side.
Max. charge respectively workpiece size	Approx. 2540mm x 1250mm Measurement of sealing cord in the lay-up frame/outside to outside 1.370 mm
Total press capacity	2.400 kN
Installed power supply	55 kW
Operating voltage	400 V
Control voltage	24 V
Brake voltage	205 V
Frequency	50 Hz
Electrical equipment	According to EN
cutting station	yes
Chamber pressure	Max. 6 bar
Operating pressure of the hydraulic system	Max. 320 bar
Necessary air pressure	Min. 8 bar / Approx. 80 Nl/press cycle x operating pressure

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Multi-Functioning Frame - Wemhöner Patent–
Height of the multi-functioning frame 20 mm

2-Daylight Lifting System including Lay-up Table
2 trays carriages with an aluminium plate. Aluminium plate consisting of aluminium sheet with grooves and channels for aeration and lay-up frame 20 mmTurn-Over System

Turn-Over Device - Sidewise
Once the tray has reached the position of the in the press outfeed, the turn-over head flips the whole carpet of workpieces by 180º. During the turn over cycle, a vacuum system is activated in order to fix the carpet of doors under the turn over head. As soon as the flipper head has reached the final parking position the vacuum will be switched off and the doors can be trimmed by an operator within one step by using a special knife.

- Heavy-duty welded steel-frame construction to receive the machinery elements
- Turn-over process hydraulically controlled
- Turn-over table with covered with plastics
- Vacuum system for the turn-over table
- Turn-over cycle approx. 18 seconds

Electric Control
Programmable Controllers (PLC) Model SIEMENS Step 7 for the whole delivery volume. Operator panel as Touch Panel for PLC control SIEMENS MP 277 with 10‘‘colour monitor in national language. Decentral switch and control panel including cabling. Analogue modem for supervising the program sequence of the PLC controls