Data sheet for sanding line COSTA KKH-CCT+CCT 1350 – Norway -year 2008

One bottom and one top sanding machine.

No.1 BOTTOM + No. 2 TOP CALIBRATING MACHINE MOD. KKH - CCT + CCT 1350

SERVICE SIDE: LEFT Conf. n° 1779/GLS/A73

Equipped with the following working units: C250 + C250 + T1 - C250 + C250 + T1

General technical data:

General characteristics:

Useful working width mm. 1350

Width of longitudinal sanding belts to obtain maximum working width W. + mm 30

(one for each w. unit)

Sanding belt oscillation system with electronic photocell - complete with safety micro-switches to stop the machine in case of abrasive belt breakage/mistracing; a timed activated air jet blower for photocell automatic cleaning is included.

Constant pass-line height of feed table from floor mm. 1000

Over-thickness safety in machine entry; a rubber covered roller is connected to micro-

switches; thicker work-pieces activate the emergency and open up the machine.

Bottom machine:

Longitudinal sanding belt length mm. 2620

Standard working thickness mm. 3÷160

Lifting/lowering of the feed table with motor variator, power kW 0,55

Top machine:

Longitudinal sanding belt length mm. 2620

Standard working thickness mm. 3÷160

Lifting/lowering of the frame with the working units with motor variator, power kW 0,55

Machine frame:

General characteristics:

Combined Bottom + Top machine, composed by two sections mechanically linked by a centralized feed system. The feed belts Bottom and Top are linked by cardan joints to a common shaft, driven by one main motor variator controlled by inverter.

Transmission from main motors to working units with V-belts and pulleys, disk brakes on each working unit for emergency stop

Machine manufactured per CE regulations according to European general machine directive CE 98/37

Bottom machine:

Standard paint in light grey and sky-blue RAL 7035-5012

Top machine:

Standard paint in light grey and sky-blue RAL 7035-5012

Pressure units:

Pressure units with "lips" and rubber rollers to hold work pieces on the feed belt; positioned in front and rear of working unit; rigid or floating to compensate panel thickness differences are equipped with variable pressure control.

Feed system - General characteristics:

Drive unit with motor variator controlled by inverter for feed speed variation.

Feed speed variable in continuous from - to m./min. 4÷24

Bottom machine:

Feed table for high performances H.R - rigid. The top plate is built in anti-wear steel type T1, with surface fine-grinded for low friction and long lasting of feed belt; planarity within centesimal accuracy.

Feed belt with surface in rubber at appropriate hardness; construction in a close loop without joints with various layers of cloth; top profile according to operation requirement.

Top machine:

Feed table for high performances H.R - rigid. The top plate is built in anti-wear steel type T1, with surface fine-grinded for low friction and long lasting of feed belt; planarity within centesimal accuracy.

Feed belt with surface in rubber at appropriate hardness; construction in a close loop without joints with various layers of cloth; top profile according to operation requirement.

1st Bottom Working unit:

C250 - Working unit with cylinder ø mm. 250 - Complete with: sanding belt tensioning unit; electronic oscillation; dust hoods; safety systems. Is included an eccentric mechanism to compensate the variation of thickness of the abrasive belt.

Cylinder with steel surface and helicoidal grooves for cooling C-steel

Pneumatic Grit-set - for setting the working height in relation to sanding belt thickness, with support on a revolving turret at 4 pre-set positions. Stand-by position with quick exclusion of cylinder in case of stop in emergency.

Motor with one speed of rotation, with power kW 37

Cutting speed of sanding belt m./sec. 30

B1 - Standard oscillating air jet blowers for sanding belt cleaning, complete with dust hood

2nd Bottom Working unit:

C250 - Working unit with cylinder ø mm. 250 - Complete with: sanding belt tensioning unit;

Electronic oscillation; dust hoods; safety systems. Is included an eccentric mechanism to compensate the variation of thickness of the abrasive belt.

Cylinder with rubber surface and helicoidal grooves for cooling, hardness Sh 90

Pneumatic Grit-set - for setting the working height in relation to sanding belt thickness, with support on a revolving turret at 4 pre-set positions. Stand-by position with quick exclusion of cylinder in case of stop in emergency.

Motor with one speed of rotation, with power kW 30

Cutting speed of sanding belt m./sec. 25

B1 - Standard oscillating air jet blowers for sanding belt cleaning, complete with dust hood

3rd Bottom Working unit:

T1 - Pneumatic pad unit with electronic control of timing of entry and adjustable pressure of contact element; contact insert made by a graphite cloth + felt + steel blade, assembly easily interchangeable;

depth of deployment mechanically adjustable

Motor with one speed of rotation, with power kW 18

Cutting speed of sanding belt m./sec. 16

B1 - Standard oscillating air jet blowers for sanding belt cleaning, complete with dust hood.

Bottom auxiliary units:

S140 - Nylon brush unit for cleaning processed work-pieces - motor kW. 1,1 ø mm.140

1st Top Working unit:

C250 - Working unit with cylinder ø mm. 250 - Complete with: sanding belt tensioning unit;

Electronic oscillation; dust hoods; safety systems. Is included an eccentric mechanism to compensate the variation of thickness of the abrasive belt.

Cylinder with steel surface and helicoidal grooves for cooling C-steel

Pneumatic Grit-set - for setting the working height in relation to sanding belt thickness, with support on a revolving turret at 4 pre-set positions. Stand-by position with quick exclusion of cylinder in case of stop in emergency.

Motor with one speed of rotation, with power kW 37

Cutting speed of sanding belt m./sec. 30

B1 - Standard oscillating air jet blowers for sanding belt cleaning, complete with dust hood

2nd Top Working unit:

C250 - Working unit with cylinder ø mm. 250 - Complete with: sanding belt tensioning unit;

Electronic oscillation; dust hoods; safety systems. Is included an eccentric mechanism to compensate the variation of thickness of the abrasive belt.

Cylinder with rubber surface and helicoidal grooves for cooling, hardness Sh 90

Pneumatic Grit-set - for setting the working height in relation to sanding belt thickness, with support on a revolving turret at 4 pre-set positions. Stand-by position with quick exclusion of cylinder in case of stop in emergency.

Motor with one speed of rotation, with power kW 30

Cutting speed of sanding belt m./sec. 25

B1 - Standard oscillating air jet blowers for sanding belt cleaning, complete with dust hood

3rd Top Working unit:

T1 - Pneumatic pad unit with electronic control of timing of entry and adjustable pressure of contact element; contact insert made by a graphite cloth + felt + steel blade, assembly easily

interchangeable; depth of deployment mechanically adjustable

Motor with one speed of rotation, with power kW 18

Cutting speed of sanding belt m./sec. 16

B1 - Standard oscillating air jet blowers for sanding belt cleaning, complete with dust hood

Top auxiliary units:

S180 - Nylon brush unit for cleaning processed work-pieces - motor kW. 1,1 ø mm.180

Top auxiliary units:

SR - Rotary blowers for blowing away the dust left by the sanding operations on the surface and on the sides of panels. Are complete with an auxiliary dust hood.

Electric plant:

IP54 - EN60204

Electric plant in a separated cabinet. It includes a main switch.Push button and control panel

with a series of leds for the automatic diagnostic of faults.

N°6 - E lectric plant built on standard CE rules Volt 400 - Hz. 50

Auxiliary circuits of electric plant Volt 115

Limited operational time of air jet blowers, only in presence of work-pieces.

Pneumatic plant:

Pneumatic plant complete with filters - oil/air nebulizer - normal pressure of operation at bar 6

Safety pressostat with machine stop when the air pressure drops below a minimum bar 4

Control unit:

VT-21 - Digital thickness read-out for 2 axes, with decimal accuracy.

The end of technical specification of the line.