



Holzbearbeitungsmaschinen - Woodworking machinery - Machine à bois

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Order Nr. 09-C1-20153 BECK Gluing Press with 11 stores

Order No	09-C1-20153
Produce / Type	BECK / Gluing press with 11 stores, 4500 x 450 mm
Year / produced. no	2001 / 21670
electric	400 Volt / 50 Hz.
power	4,5 kW

- 11 stores
- for the production of solid wood panels for e.g. staircase steps and stringers
- press store with 11 compartments
- transport and gluing equipment
- the lamellas are glued blunt
- Glue store press length up to 4400 mm
- clamping depth 450 mm
- per store 15 pieces
- membrane type cylinder
- press lift per cylinder 70 mm
- press force per cylinder 6800 N
- the cycle time is approx. 2,5 minutes

Machine:	Gluing press
Manufacturer :	for staircase steps and stringers
Year of construction:	BECK
	2000/2001
- Mechanisation with buffer zones	Maschine no. 88619/1
- Solid wood gluing	Maschine no. 88619/2
- Collating conveyor before the press	Maschine no. 88619/3
- Store rotor 4500 x 450	Maschine no. 21670

Installation components:

Pos. 1.a1	Presort surface
Pos. 1.a2	Intermediate area
Pos. 1.a3	Working area
Pos. 1.b	Feed unit with separation
Pos. 1.c	Edge gluing
Pos. 1.c1	Length control
Pos. 2.a	Conveyor belt
Pos. 2.b	Cross pusher
Pos. 2.c	Feed belt
Pos. 3.a	Loading- and unloading table
Pos. 3.b	Store elevator
Pos. 3.c	Store rack with 11 gluing stores
Pos. 4	Transfer roller conveyor
Pos. 5	Control

Operating cycle:

The gluing unit can be operated automatically, as well as manually. In automatic mode, as soon as the gluing store is loaded, a starting signal is given, and the store elevator conveys the gluing store to its assigned free place in the store rack. In this store rack the pressing operation is activated. After this the store elevator takes out the store, that has been for the longest time in the rack and transports this on the loading- and unloading table. Here the driven roller conveyor raises and the glued panels are being transported out of the unit. Afterwards the already prepared block of laths can be conveyed from the feeding belt into the gluing store. The roller conveyor lowers and a new starting cycle begins.



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Operating cycle manually for stringers:

The timber lamellas are put in manually. The pressing operation is being activated manually at the loading table. By activating the start button the store elevator transports the gluing store to the free places in the store rack.

Technical data solid wood gluing:

Working piece dimensions:

Lath length	min. 800 mm	max. 3.600 mm
Lath width	min. 60 mm	max. 160 mm
Lath thickness	min. 30 mm	max. 60 mm
Panel width	min. 300 mm	max. 450 mm

Working height:	900 up to	950 mm
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Pos. 1.a1 Presort surface

5 Transport tracks:	Pitch 500-350-500-860mm
Application width:	approx. 2300 mm divided in presort surface with acceptance button, intermediate area
	Pos. 1.a2 and working area Pos. 1.a3
Transport speed:	V= approx. 10 m/min.
Drive:	geared motor, reversible

Pos. 1.b Feed unit with separation

Length:	approx. 3300 mm
Application width:	approx. 40 mm
Transport speed:	V=approx.. 40 m/min.
Drive:	geared motor
Bottom feed roller:	pneum. cycle
Passage height:	30-60 mm, manually adjustable

Pos. 1c Edge gluing: for all sided, straight planed edges

Gluing profile type:	blunt
Glue application:	one sided
Glue type:	white glue
Lath thickness:	30 - 60 mm
Glue quantity:	dosing
Glue application roller:	driven with geared motor
Glue container:	volumetric capacity 8 liter
Bottom feed roller:	driven
Top feed roller:	not driven
Transport speed:	V=approx. 40 m/min.

The first lath of each block of laths is not glued.



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Pos. 1.c1. Length control integrated in feed unit

For the control of the free length on the transfer belt and the next lath, which is ready to be glued. The control takes place by software always in interrelation with the adjustment of the gluing station, that is to say at each first piece of timber of the lath block.

Pos. 2a Conveyor belt of the edge gluing to the transfer

Usable width:	120 mm
Length:	approx. 4500 mm
Execution:	PU-belt with wedge-type guiding
Feed speed:	V= approx. 30 m/min. adjustable

Pos. 2.b Cross pusher from the conveyor belt to the feed belt

Pusher length:	approx. 2000 mm
Pneum. lift:	400 mm

designed for a clamping depth in the press of 300 - 450 mm.

Pos. 2.c Feed belt

Usable width:	450 mm
Length:	4500 mm
Execution:	PU-belt with wedge-type guiding
Drive:	Geared motor
Speed:	V= 20 m/min. adjustable

Pos. 3a Loading- and unloading table with driven roller conveyor

Roller conveyor:	driven V= approx. 20 m/min. with lifting- and lowering device
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Pos. 3b Store elevator

Store elevator driven with geared motor with driven cross infeed for the gluing stores. Vertical moving speed approx. 8 m/min. Cross infeed speed approx. 5 m/min.



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Pos. 3c Store rack with 11 gluing stores

Store rack consisting of a robust profile tube construction.

Outside completely covered

Gluings store:

Press length up to 4400 mm
max. clamping depth 450 mm

per store:

15 pieces pneumatic
diaphragm cylinder with
280 mm axis center and
200 mm longer pressure plate

Press lift per cylinder 70 mm

Press capacity per cylinder at 6 bar 6800 N

Down hold device:

per store 1 down hold frame
manually folding upwards
with 16 pneumatic down holders.
axis center 280 mm

Counter bearing::

per store 15 spherical counter
bearings, stepless adjustable
in a grid of 5 mm adjustable,
thus on all stores it is possible
to glue stringers

Pos. 4 Transfer roller conveyor with driven carrying rollers

Track width:

450 mm

Track length:

4500 mm

Drive:

Geared motor

Speed:

V= 20 m/min.

Pos. 5 Switch cabinet with PLC control Siemens S 7

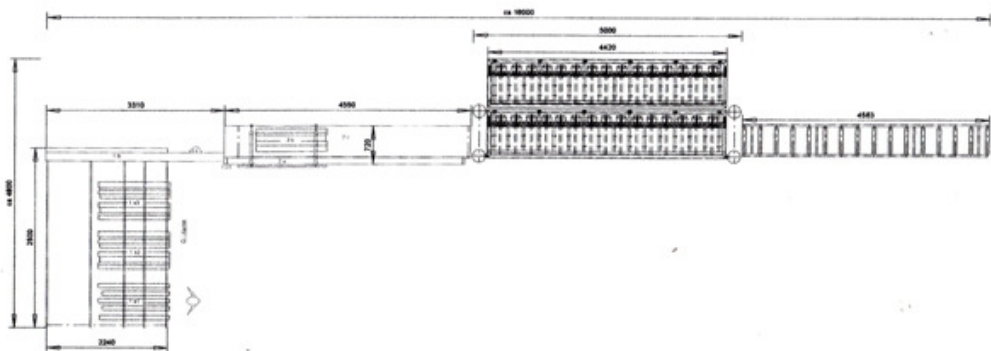
Contactless sensor system optical, inductive all switching devices in main switch cabinet wired according to VDE.

Pos. 6 Painting

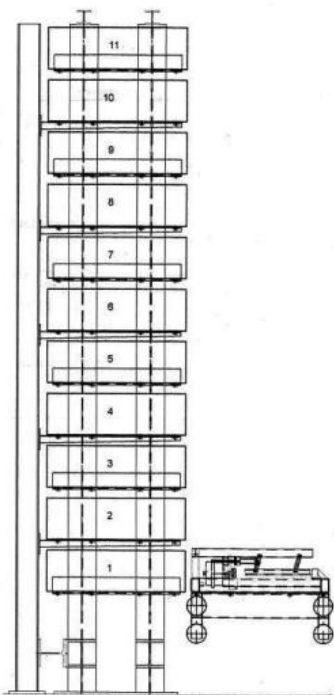
Base colour telegray RAL 7047, moving parts gentian blue RAL 50010



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ETAGENROTOR





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