



Model FAST F65023 PLUS



For illustration purposes only

FAST F65023 PLUS SINGLE SIDE EDGE BANDER WITH PREMILLING UNIT

MAIN FEATURES:

- Machine structure in ribbed electrically welded steel, to grant high rigidity. • The machine has a compact design, it is versatile and user friendly. • Extensible panel support when machining large panels. • Built-in electrical cabinet with main switch.
- Rise of the top groups linked to the top pressure bar. Reading slip is through digital position indicator.
- All working units protected by cabin, wide opening allowing excellent view of inner parts complete with safety switch. • Dust extraction has individual outlets positioned on top of the cabin. Number and location of the outlets according to the machine configuration.
- All motors turn at 12,000 RPM and are controlled by an inverter of suitable power according to machine configuration.
- Emergency mushroom buttons placed at the entrance and exit of the machine. • Equipped with a signaling light to control the distance when loading of the panel.

PANEL CONVEYING SYSTEM:

- Track movement is made by a robust chain, by means of a specifically sized, orthogonal geared motor, feed rate 1216 m/min.
- Coefficient high friction rubber coated pads are fitted on the chain in order to grant maximum panel adherence. • Top pressure beam made of steel with a double row of wheels.
- A track guide with flat and round profile is fitted under the upper beam to obtain maximum precision and straightness even with loadings from the side.

CONTROL PANEL:

- The machine management is ensured by an operator panel with a 12" colour touch screen fitted in a handy position of simple intuition, to access all the features like; change machining program, variations of glue temperatures and enabling working units.
- The management of the machine and its working units is performed by an electronic control PLC. • On the screen the following data are displayed:
 - feed rate
 - glue tank temperature
 - program type selected by the operator
 - progressive statistical data
 - integrated simple and controlled diagnostic

MAIN FUNCTIONS:

- Panel reading is made by means of a highprecision micro switch.
- Loading of roll edging up to 3 mm thick with revolving coil holder plate Ø 800 mm. • PVC/ABS shear up to 3 mm.
- The glue tank is placed under the edge loading device and is tefloncoated to allow easy cleaning and replacing of the glue; it is equipped with heating elements of suitable power.
- In order to obtain perfect glue spreading on the panel, the glue tank moves on a 25 mm prismatic guide and a ball bearing pad.
- Automatic loading of the roll edging material up to 3 mm thick with motorized positioning device; complete with revolving coil holder dia. 800 mm.

TECHNICAL FEATURES:

Panel thickness	10 60 mm
Panel width	min. 60 mm
Edge width	12 63 mm
Edge thickness	0.4 8 mm
Feed speed	12 16 m/min
Capacity of glue pot	1 Kg
Voltage	460V / 3 Ph+N / 60Hz
Motor Kw and Amps	8.2 Kw
Minimum length of panel	120 mm (PVC)
Pneumatic power	6 bar
Weight	1200 Kg
Dimensions of machine	4.310 m
Working temperature (room)	Min. 15° C / max 45° C (Min. 59° F/ max 113° F)

Included

48 PC with 16" Color Touch Screen LED Technology

The simple and userfriendly PLC software manages the following:

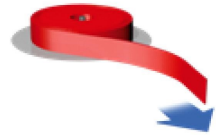
- The ability to store up to 800 different program . Display and regulation of glue pot temperature
- Workpieces and machining hours count



- Alarm diagnostics with video support for troubleshooting
- Start, Stop, Positioning and Exclusion of all units fitted on the machine
- Display and regulation of Pressure Beam (with option # 32) and Pressure Rollers (with option # 33)
- Selection of program via bar code reader with optional scanner

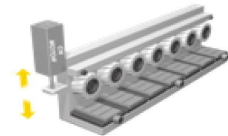
01 Revolving Longitudinal Coil Holder Ø 800

For coil up to Ø 800 mm, veneered, melamine paper, PVC and ABS edging up to 3 mm



32 - NC Positioning of top Pressure Beam

Pressure beam motorization with electrical motor and PLC control.



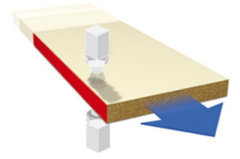
42 Numerically Controlled Infeed Guide

Allows panel material removal adjustment from 0 to 3 mm to balance edge thickness.



27 System with special release agent "RT/S"

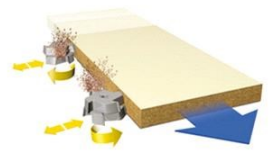
- Electropneumatic system, used in conjunction with the premilling unit.
- Before the entry of the piece on the premilling unit, is applied a thin layer of special release agent on the top and bottom of the panel being processed, before the glue application.
- The layer of release agent applied, prevents any residues of adhesive to adhere on the surface of the panels edges.



23 PreMilling Unit for F600/F650 "RT/F"

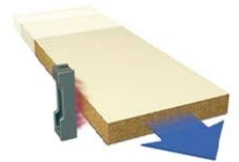
Infeed premilling unit with adjustable infeed guide

- 1 x 1.1 kW (HP 1,50) fix motor. • 1 x 0.75 kW (HP 1,00) motor with programmed infeed and outfeed intervention.
- The unit is equipped with Whispercut by Leitz Ø 60 x 64H tools (tools with interchangeable diamond tips)
- Also Includes the following features:
 - frame lengthening
 - pressure beam
 - workpiece feed system
 - chip suction
 - protection cabin



24 IR Lamp:

Allows rapid heating of the panel side to be edgebanded, improves gluing resistance even in unfavourable room temperature and humidity conditions.



05 Automatic Loading Device for F650 Only

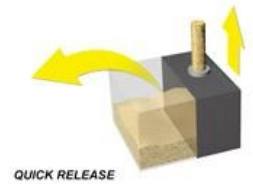
Automatic loading device for precut edges, solid wood strips and Formica, up to 8 mm thick.

They are dragged by a needle roller for the automatic loading.



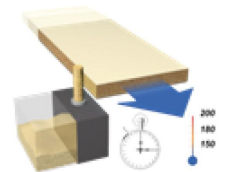
30 Quick release for glue tank 1 KG for F625 & F650 only

Ideal for quick change of glue tank when a color change or a change of glue type is required.



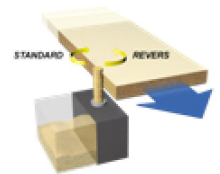
17 Eco Mode System

Temperature reduction of glue tank by means of a timer to optimize the energy consumption during machine standby phases. Programmable timer direct from control panel.



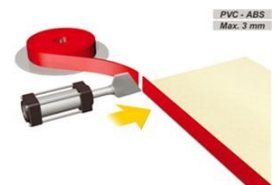
14 Reverse Unit

Reverse unit fitted on the glue tank, to spread glue by turning the roller in reverse direction with respect to panel feed direction, thus improving glue resistance on wood, formica and laminate edges.



07 3mm Shear

Shear for cutting PVC and ABS up to 3 mm thick, maximum shear section 195 mm².



04 1KG Glue Tank:

Glue tank for hot melt granular adhesive placed under the loading device, with gluing roller synchronized with panel feeding, Teflon coated for easy replacing and cleaning. The temperature is set and controlled by the PLC.

Note: Thanks to the Teflon® treatment of the special glue spreading roller it is now possible to use EVA, PUR and PO type glue granules.



33 NC Positioning of the Pressure Roller Unit

Pressure roller motorization with electrical motor and PLC control. Allows automatic variation of the pressure roller position according to the size of the edge to be applied.



Controlled by PLC by means of a Numerical Control, it saves the last preset dimension automatically for any program type.

06 Pressure Roller:

In order to achieve perfect edge bonding, the pressure roller is composed of the following:

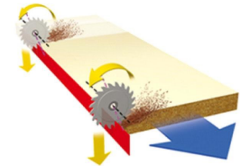
- 1 motorized roller • 1 rubber roller
- pressure rollers are driven by means of spring • roller position adjustment by means of an exclusive edge sizing system called presetting (quick change) for a quick and precise positioning of the unit



08 End Trimming Unit "INT 1/F"

The end trimming unit has one 0.22 kW (HP 0.30) high frequency 12 000 RPM independent motor.

- The unit provides high precision and speed of operation by gliding on steel cylindrical guides that are hardened and rectified, with ball runner bearings.
- Pneumatic exclusion of the unit from the operator panel.
- Ability to exclude head / tail trim on workpiece from the operator panel.
- Automatic blade inclination without any manual intervention. • Complete with two circular saw blades \varnothing 100x20x3, 2Z24 Tool material: WIDIA



46/9 Nesting setup for Trimming / Bevelling Chamfering Unit

This device allows machining of nesting configured panels by means of rough trimming /bevel trimming unit set up on copy pads with bearings.

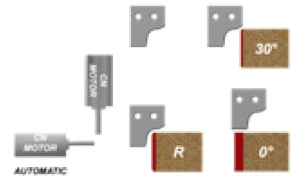
Allows rough trimming of nestingcut panels with hinge drilling or fittings even on the side to be edgebanded.



40/9 4axis numerical control Rough Trimming / Bevel Trimming Unit "RFS/S"

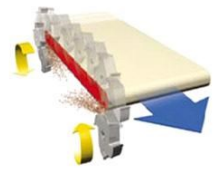
Combined to the "RFS/S" rough trimming / bevel trimming unit (opt. #9) for rapid tool profile changeover from thin edge 30° to radius R=1÷3 mm and solid wood up to 12 mm.

It allows fine adjustments from control panel without opening the cabins.



21 Corner Rounding Unit "FAST 1"

This unit is used to finish the panel edge on the corner, the main features are:

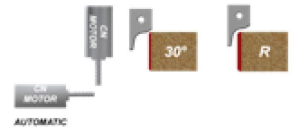


- compact
- excellent finish on joints
 - adapts easily to the various panel profiles without adjustments or particular settings
 - always operates on all 4 panel sides during panel feed phase
 - equipped with 0.22 kW, 12 000 RPM motor
- equipped with a special profile cutter bevel 30° + R1 ÷ R3mm (FRAVOL Patent) • working capacity, panel thickness min. 10 mm max. 60 mm

The machine can operate with or without corner rounding unit without reducing its working capacity.

40/21 2 Axis Numerical controlled Corner Rounding Unit

Control from the control panel (PLC) with possibility of independent corner rounding unit adjustment directly on the touch screen, with rapid tool profile changeover from thin 30° edge to R=1÷3 mm and fine tuning from the control panel without opening the cabins.

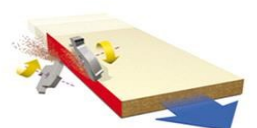


Universal Profile tool "Patent pending"
Allows carrying out edgebanding with profile:

- Rough trimming at 30°
- R = 1-3 mm
- Tool material: PCD

09 Rough Trimming / Bevel Trimming Unit "RF/F":

Multifunction unit equipped with 2 tilting motors of 0,37 kW (HP 0.5) 12 000 RPM



- The rough/fine trimming function is perfect thanks to the use of vertical copy wheels with large diameter
- Side copying device with high precision double bearing, to avoid any possible scratch, especially on high gloss edges
- Equipped with a Special Profile cutter bevel 30°/ R1 ÷ R3 mm/ flat FRAVOL Patent . Tool material: WIDIA Tool ANGLE 30°+R1÷R3+P20

The adjustment is facilitated by a table showing all the positions of the units 09 21 10 for quick changeover from one process to another.

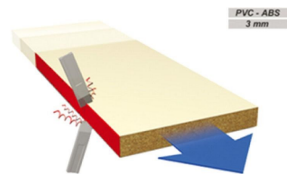
UNIT EQUIPPED WITH POSITIONS INDICATORS Analog position indicators for easy precision adjustment and format changes.

10. Edge Scraping Unit "RB/F":

Multifunction finishing unit for PVCABS edge scraper. It removes ripples generated by previous machining thus improving surface finishing.

- Built with highstrength steel structure to grant absence of vibrations.
- Equipped with rotating vertical and side copying devices allowing perfect positioning of the tools with respect to the edge to be processed
- Equipped with Special Profile tools bevel 30°/ R1 ÷ R3 mm / flat (FRAVOL Patent)
- Tool material: Tool WIDIA ANGLE 30° + R1-R3+P20

The adjustment is facilitated by a table showing all the positions of the units #09 21 10, for quick changeover from one process to another. UNIT EQUIPPED WITH POSITIONS INDICATORS Analog position indicators for easy precision adjustment and format changes.



46/10 Nesting setup for Edge Scraping Unit

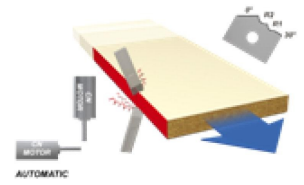
This device allows machining of nesting configured panels by means of edge scraping unit set up on copy pads with bearings.

Allows rough trimming of nestingcut panels with hinge drilling or fittings even on the side to be edgebanded.



40/10 4Axis Numerical Control of Edge Scraping Unit "RB/S"

Combined to the "RB/S" edge scraping unit (option # 10) for rapid tool profile changeover from thin edge 30° to radius R=1÷3 mm and solid wood up to 8 mm.



It allows fine adjustments from control panel without opening the cabins.

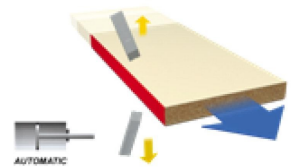
Universal profile tool

Allows carrying out edgebanding with profile:

- Rough trimming at 30°
- R = 1-3 mm

20/10 Edge Scraping Unit Pneumatic Exclusion

Pneumatic exclusion from control panel for edge scraping unit.



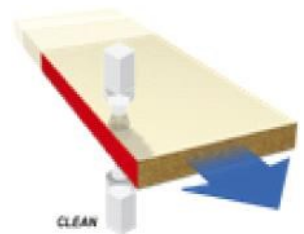
16 Spray Cleaner Unit

The application of the special liquid cleaner is made automatically upon the passage of the panel. The product is sprayed on the top and bottom sides of the panel.

The use of cleaner, combined with the glue scraping unit, allows the removal of the release agent previously applied and any residue of glue deposited on the panel.

A further benefit arising from the application of special liquid cleaner, is the cooling of the glue line and of the edge, avoiding the glue line reactivation and prevents the adhesive effect between one panel and the other in the stacking phase.

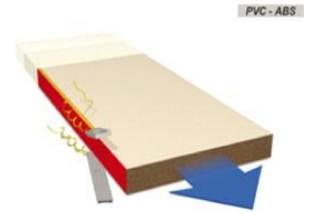
In addition, the liquid sprayed combined with the brushes action allows to obtain a perfect cleaning and polishing of the edge applied.



25 Glue Scraping Unit "RC/F":

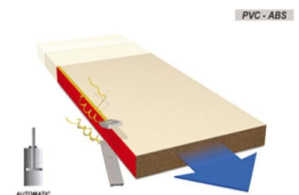
Finishing unit used to remove excess glue on melamine paper, PVC, ABS and veneered edges, with possibility of excluding the unit from the control panel.

- Built with a highstrength steel structure preventing any possible vibrations.
- Equipped with vertical rotating copy pads granting perfect positioning of the flat knives with respect to the upper and lower panel sides.
- Manual intervention.
- Complete with 2 flat knives Tool material: WIDIA



20/25 Pneumatic Exclusion for Top or Bottom Glue Scraping Unit

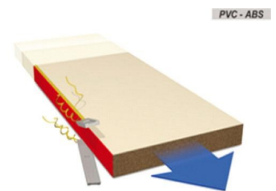
Pneumatic exclusion from control panel, for glue scraping units.



40/25 NC Positioning of Glue Scraper

Finishing unit used to remove excess glue on melamine paper, PVC, ABS and veneered edges.

- Built with a highstrength steel structure to grant absence of vibrations.
- Equipped with vertical rotating copy pads granting perfect positioning of the flat knives with respect to the upper and lower panel sides.
- Manual intervention. . Complete with 2 flat knives.



12 Box for Shavings

Complete with two suction openings to remove shavings of scraper.



50 Interior LED Lighting and Soundproof booth



DPC Electric predisposition for buffing unit and hot air units Fast Series Starter Pack

This Starter Pack includes the following items:

- 2 x JOWATPO221** Low speed Glue for Fast and Smart EVO, 15kg bag
- 2 x 590SM0200** 20 X 12 X 1.5 TOK Insert Knives for glue scraper
- 1 x FRVMOLYKOTE1** Molykote L1428 Oil (1 Liter)
- 1 x RIE00630ASSY** Cleaning Agent Riepe LP163/93 30L
- 1 x RIE00130ASSY** Release Agent Riepe LPZ/II 30L
- 1 x 4830A2** Teflon Spray for fraval (300g)