

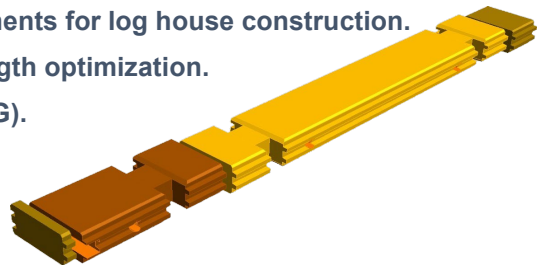
## DATASHEET

# BL100A

## BLOCKHAUSFRÄSE



- Blockhausfräse BL100A for the rational production of components for log house construction.
- MULTILOG production with Multiple length with automatic length optimization.
- Maximum performance through constant workflow (MULTILOG).
- Precise processing of the various log house connections.
- High performance up to 150 meter / hour.
- Absolute precision and accuracy.



- Compact processing zone.
- Optimal arrangement of the processing units.
- High Tech milling tools with HM inserts.
- Optional axes with servo technology.
- Various processing options.
- Minimum set-up times.
- IITO Software for component management and the control of all machining processes.
- BTL Data Import.
- Optimization.
- Label printer for component marking.

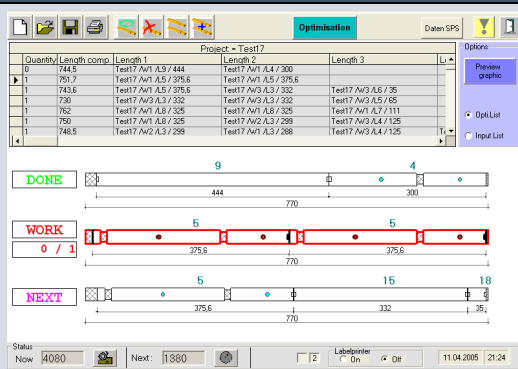


## Working dimensions:



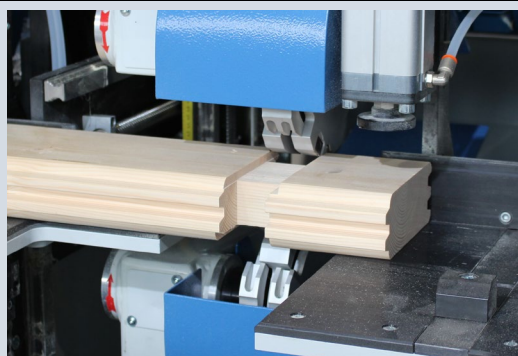
Wall thickness:	28 – 140mm
Log height:	100 – 200mm
Raw material length min.:	800mm for autom. process
Workpiece length min.:	+/-300mm / je nach Bearbeitung
Workpiece length max.:	Je nach Mechanisierung
Requirement raw material:	Flat surface for table. Right angle face surface (1-side)

## IPC control & IITO Software:



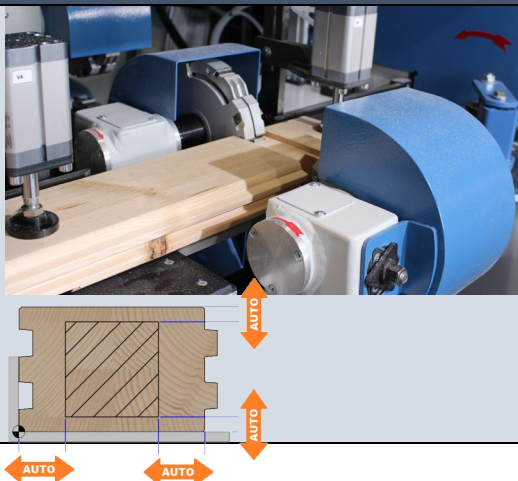
control:	Siemens RTX TIA 2023
HMI:	Ergonomic console, with storage for Printer & Labelprinter
Software:	IITO Control, Input- Import- & Optimization
IPC:	SIMATIC IPC427E
Input Interface:	Keyboard + Mouse
Monitor:	22" Monitor 1920 x 1080; installed on operator console
Data Interface:	BTL

## 4-Fold unit [4F.SERVO]



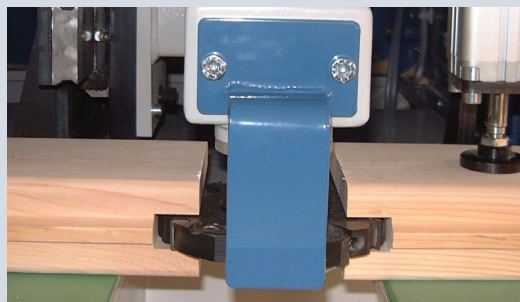
Milling depth horizontal up / down:	60 / 35mm
Milling depth vertical:	90mm
Drives:	4 x 4,0kW
Spindle speed:	4200min <sup>-1</sup>
Milling shaft Ø:	30mm
Tool Ø hor. / vert.:	220 / 280mm
Feed:	SERVODRIVE / express traverse
Adjustment milling depth:	Manual with digital counter

## OPTION [4F.POSI]



Milling depth horizontal up / down:	60 / 35mm
Milling depth vertical:	90mm
Drives:	4 x 4,0kW
Spindle speed:	4200min <sup>-1</sup>
Milling shaft Ø:	30mm
Tool Ø hor. / vert.:	220 / 280mm
Feed:	SERVODRIVE / express traverse
Adjustment milling depth:	<b>Automatic by Software control; SERVODRIVE</b>
Tolerance:	+/- 0,2mm

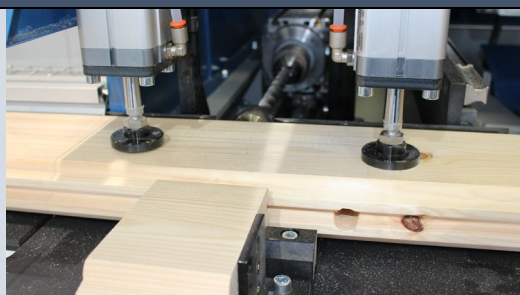


**Groove unit [STN.SERVO] for grooves / head slots**


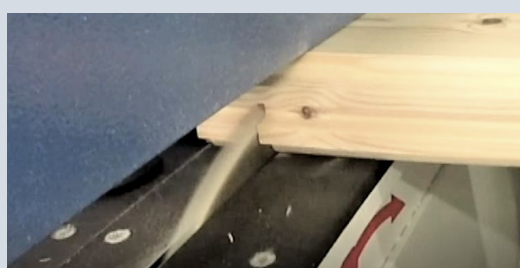
Milling depth:	40mm
Drive:	4,0kW
Spindle speed:	4200min <sup>-1</sup>
Milling shaft Ø:	30mm
Tool Ø:	180mm
Feed (Y-Axis):	SERVODRIVE / express traverse
Height adjustment (Z-Axis):	Manual with digital counter; optional with SERVODRIVE

**Dovetail 3-AXIS UNIT for Grooves, Slots, Tenon, Dovetail connections**


positioning:	in place of groove unit [STN]
Milling depth grooves:	50mm
Milling depth dovetail connection.:	35mm
Drive:	5,5kW
Spindle speed:	FU controlled, 0 - 7500min <sup>-1</sup>
Milling shaft Ø:	30mm
Tool Ø Groove tool:	240mm
Tool Ø Dovetail profiler:	50mm
Y-Axis:	SERVODRIVE
Z-Axis:	SERVODRIVE
R-Axis:	SERVODRIVE / Planetengetriebe
Tolerance:	+/- 0,1mm

**Drilling unit horizontal with driller guide [BGD.SERVO]**


Driller Ø max.:	30mm
Drive:	1,5kW
Rotation speed:	1500min <sup>-1</sup>
Feed (Y-Axis):	SERVODRIVE
Height positioning (Z-Axis):	Manual with digital counter; optional with SERVODRIVE

**Circular saw [KS.500i]**


Cutting dimension (W x H):	200 x 140mm
Drive:	4,0kW
Cutting speed:	85m/s
Sawblade Ø:	500mm
Feed (Z-Axis):	SERVODRIVE / express traverse
Workpiece holder:	Pneumatic press bar from top with plastic counter profile

**DuoDrill unit [DD] for perfect bore holes from two sides**


Setup in a separate base:	Double drill opposite in the same axis with collision protection system
Number of units:	2x DuoDrill (A+B) possible
Driller Ø max.:	35mm
Drives:	2x 1,5kW
Rotation speed:	FU controlled; 0 - 3000min <sup>-1</sup>
Feed (Y-Axis):	SERVODRIVE
Height positioning (Z-Axis):	Manual with digital counter; optional with Stepper Drive / KGT

**Corner cutter 45° [EF] to cut the corner at the end to get a 45° chamfer**


Setup in a separate base:	4 units of corner cutters with 45° position, separately controlled
Working dimension (W x H) max:	50 x 160mm
Chamfer max.:	4 x 35mm x 45°
Tool Ø:	250mm
Drives:	4x 1,1kW
Spindle speed:	4500min <sup>-1</sup>
Feed:	Pneumatic infinitely variable & Servo Drive / KGT shaft

**Mechanization cross conveyer [QF] & infeed table**


Construction:	Steel arms with HTD Supergrip belt
Number of arms / workpiece length:	6 arms at 6m 8 arms at 9m 9 arms at 12m
Division:	650 / 650 / 850 / 1500 / 1500mm
Length:	+/- 1,8m
Drive:	Gearbox drive, 1,5kW
Takeover to infeed table:	Level reduction pneumatic
Infeed table:	plastic coated sliding surface for damage free manipulation
Table width:	200mm

**Component feed [X-Axis]**


Servopusher:	Pushing arm in a precise linear guide module
Drive:	Gearbox Servo drive, 3,0Nm
Measuring- system:	Resolver
Max. adjusting velocity:	110m/min
repeat accuracy:	0,2mm
Sliding table [X2-Achse], function:	For positioning the components before machining on the face.
Drive:	PN Multi-stage cylinder

**Mechanization outfeed table, cross-pushing device & deposit table**


Outfeed table:	plastic coated sliding surface for damage free manipulation
Table width:	250mm
Cross-pushing device:	pneumatic
Deposit table:	Full-surface storage table for finished goods
Table width:	0,8m (Standard) / 1,4m (Option)
Length (outfeed- & deposit table):	6m (Standard) / 9m / 12m (Option)

**Component labeling:**


Label printer:	Thermal Transfer Printer
Labels:	PE, 70 x 30mm
Function:	After production of the component, the respective label is automatically printed. It is stuck on by the operator.
Information printable	Producer, project, component ID, length, wall number, CAD- ID; more information on request

**General:**

Workpiece holder:	Clamping cylinder from top and from front + Tensioning & infeed rollers from the front
Dust- & chips aspiration:	Underfloor aspiration cone, pit required under the machine *
Pneumatic supply:	Cleaned & dried compressed air, 8 bar, ca. 300l/min *
Electric power supply:	400V, 3L+N+PE, 50Hz *
Weight:	+/- 2900kg without mechanization *
Dimensions (L x W):	+/- 17,0 x 3,5m (Standard) *
* further Information on the Installation layout	

Subject to changes - all rights reserved!