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.





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Workpiece length max.: Requirement raw material: Requirement raw material: Flat surface for table. Right angle face surface (1-sid Right angle face surface (1	Working dimensions:				
Raw material length min.: Workpiece length min.: Workpiece length max.: Je nach Mechanisierung Requirement raw material: Flat surface for table. Right angle face surface (1-sid Right ang		Wall thickness:	28 – 140mm		
Workpiece length min.:		Log height:	100 – 200mm		
Workpiece length max.: Requirement raw material: Requirement raw material: Flat surface for table. Right angle face surface (1-sid Right angle face surface (1		Raw material length min.:	800mm for autom. process		
Requirement raw material: Flat surface for table. Right angle face surface (1-sid Right angle for Printer & Labelprinter for Printer	A A B B B B B B B B B B B B B B B B B B	Workpiece length min.:	+/-300mm / je nach Bearbeitung		
Right angle face surface (1-sid process) PC control & IITO Software: Control: Siemens RTX TIA 2023	1	Workpiece length max.:	Je nach Mechanisierung		
control: Siemens RTX TIA 2023 HMI: Ergonomic console, with storat for Printer & Labelprinter Software: IITO Control, Input-Import- & Optimization IPC: IITO Labelprinter IPC: IITO Labelprinter I		Requirement raw material:	Flat surface for table. Right angle face surface (1-side)		
HMI: Ergonomic console, with storat for Printer & Labelprinter Software: IITO Control, Input. Import. & Optimization IPC: IIITO Control, Input. Import. Mouse IIITO Control, Input. Import. Input. Input. Import. Input. Import. Input. Input. Import. Input. Import. Input. Input. Input. Input. Input. Input. Input. Input. Input	IPC control & IITO Software:				
Software: IITO Control, Input-Import- & Optimization IPC: SIMATIC IPC427E Input Interface: Keyboard + Mouse Monitor: 22" Monitor 1920 x 1080; installed on operator console BTL	Designs - Total 7				
Software: In	1 /43,6 [est17 /vi7 /l.5/3/5,6 [est17 /vi3 /l.3/32] [est17 /vi3 /l.6/35] 1 230 Test7 /vi2 /l.3/3/32 Test7 /vi2 /l.3/3/32 Test7 /vi2 /l.5/55		for Printer & Labelprinter		
IPC: SIMATIC IPC427E Input Interface: Keyboard + Mouse Monitor: 22" Monitor 1920 x 1080; installed on operator console BTL	1 7485 Test17 Av2 A.3 / 259 Test17 Av1 A.3 / 258 Test17 Av2 A.4 / 125 Test17 Av2 A.4 / 125 Test17 Av2 A.4 / 125 Test2 Av2 Av2 Av2 Av2 Av2 Av2 Av2 Av2 Av2 Av	Software:	l ·		
Input Interface: Monitor:	770	IPC:	SIMATIC IPC427E		
Monitor:	0 / 1 275.6 375.6	Input Interface:			
### Adjustment milling depth horizontal up / down: Milling depth horizontal up / down: 60 / 35mm	NEXT O • • • • •	Monitor:			
Milling depth horizontal up / down: Milling depth vertical: Drives: 4 x 4,0kW Spindle speed: Milling shaft Ø: Tool Ø hor. / vert.: Eed: Adjustment milling depth: Milling depth horizontal up / down: Milling depth vertical: Drives: 4 x 4,0kW Spindle speed: 4 x 4,0kW Spindle speed: Milling shaft Ø: Tool Ø hor. / vert.: 220 / 280mm Feed: SERVODRIVE / express travel Adjustment milling depth: Milling depth horizontal up / down: Milling depth vertical: 90mm Drives: 4 x 4,0kW Spindle speed: 4200min ⁻¹ Milling shaft Ø: Tool Ø hor. / vert.: 220 / 280mm Feed: SERVODRIVE / express travel	Status Now #1080	Data Interface:	BTL		
Milling depth vertical: Drives: 4 x 4,0kW Spindle speed: Milling shaft Ø: Tool Ø hor. / vert.: Eed: Adjustment milling depth: Milling depth horizontal up / down: Milling depth vertical: Drives: 4 x 4,0kW Spindle speed: Manual with digital counter Milling depth horizontal up / down: Milling depth vertical: Drives: 4 x 4,0kW Spindle speed: Milling shaft Ø: Tool Ø hor. / vert.: 220 / 280mm Tool Ø hor. / vert.: 220 / 280mm Feed: SERVODRIVE / express travel	4-Fold unit [4F.SERVO]				
Drives: Spindle speed: 4200min ⁻¹		Milling depth horizontal up / down:	60 / 35mm		
Spindle speed: Milling shaft Ø: Tool Ø hor. / vert.: Eed: Adjustment milling depth: Milling depth horizontal up / down: Milling depth vertical: Drives: Spindle speed: 4200min ⁻¹ Manual with digital counter Milling depth vertical: 90mm Drives: 4 x 4,0kW Spindle speed: Milling shaft Ø: 30mm Tool Ø hor. / vert.: Eed: SERVODRIVE / express travel Spindle speed: Milling shaft Ø: Spindle speed: Milling shaft Ø: Spindle speed: SERVODRIVE / express travel		Milling depth vertical:	90mm		
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Tool Ø hor. / vert.: Feed: SERVODRIVE / express traveled: Adjustment milling depth: Manual with digital counter		Spindle speed:	4200min ⁻¹		
Feed: Adjustment milling depth: Manual with digital counter OPTION [4F.POSI] Milling depth horizontal up / down: Milling depth vertical: Drives: 4 x 4,0kW Spindle speed: Milling shaft Ø: Tool Ø hor. / vert.: Eed: SERVODRIVE / express travel		Milling shaft Ø:	30mm		
Adjustment milling depth: Manual with digital counter OPTION [4F.POSI] Milling depth horizontal up / down: Milling depth vertical: Drives: Spindle speed: Milling shaft Ø: Tool Ø hor. / vert.: Feed: Manual with digital counter Manual with digital counter Milling depth horizontal up / down: 4 x 4,0kW Spindle speed: 4200min ⁻¹ Milling shaft Ø: 220 / 280mm Feed: SERVODRIVE / express travel		Tool Ø hor. / vert.:	220 / 280mm		
Milling depth horizontal up / down: 60 / 35mm Milling depth vertical: 90mm Drives: 4 x 4,0kW Spindle speed: 4200min ⁻¹ Milling shaft Ø: 30mm Tool Ø hor. / vert.: 220 / 280mm Feed: SERVODRIVE / express travel		Feed:	SERVODRIVE / express traverse		
Milling depth horizontal up / down: Milling depth vertical: 90mm Drives: 4 x 4,0kW Spindle speed: Milling shaft Ø: Tool Ø hor. / vert.: Feed: SERVODRIVE / express travel		Adjustment milling depth:	Manual with digital counter		
Milling depth vertical: 90mm Drives: 4 x 4,0kW Spindle speed: 4200min ⁻¹ Milling shaft Ø: 30mm Tool Ø hor. / vert.: 220 / 280mm Feed: SERVODRIVE / express travel	OPTION [4F.POSI]				
Drives: 4 x 4,0kW		Milling depth horizontal up / down:	60 / 35mm		
Spindle speed: Milling shaft Ø: Tool Ø hor. / vert.: Feed: SERVODRIVE / express travel		Milling depth vertical:	90mm		
Milling shaft Ø: Tool Ø hor. / vert.: Feed: SERVODRIVE / express travel		Drives:	4 x 4,0kW		
Tool Ø hor. / vert.: 220 / 280mm Feed: SERVODRIVE / express travel		Spindle speed:	4200min ⁻¹		
Feed: SERVODRIVE / express travel		Milling shaft Ø:	30mm		
		Tool Ø hor. / vert.:	220 / 280mm		
	P//XX		SERVODRIVE / express traverse		
Adjustment milling depth: Automatic by Software contr SERVODRIVE		Adjustment milling depth:	Automatic by Software control; SERVODRIVE		
Tolerance: +/- 0,2mm	E	Tolerance:	+/- 0,2mm		



Manual with digital counter; optional with SERVODRIVE

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

Height adjustment (Z-Axis):



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 ⁻¹
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 ⁻¹
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	



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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 FU controlled; 0 - 3000min⁻¹ Rotation speed: 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 50 x 160mm Working dimension (W x H) max: Chamfer max.: 4 x 35mm x 45° Tool Ø: 250mm Drives: 4x 1,1kW Spindle speed: 4500min⁻¹ Feed: Pneumatic infinitely variable & Servo Drive / KGT shaft [QF] & infeed table Mechanization cross conveyer 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 110m/min Max. adjusting velocity: 0,2mm repeat accuracy: Sliding table [X2-Achse], function: For positioning the components **AUER TECH** before machining on the face. Drive: PN Multi-stage cylinder



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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:		
7.0	Label printer:	Thermal Transfer Printer
97	Labels:	PE, 70 x 30mm
## 1	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	
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