

# CAM-WOOD

## HORIZONTAL FULLY AUTO FINGER JOINT SYSTEM- SINGLE CHAIN TYPE F1      6" x 20 ft Model: FAH



This drawing is a schematic content  
(Machine's lay-out / footprint can to  
change according to customer demand)



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## TECHNICAL SPECIFICATIONS

### Technical data of tour line

Timber working length(min-max)	<b>L = 150MM ~ 1000MM</b>
Timber length to be processed must be at least 50% longer than the timber width to be processed. (Example; if the material width is 6" then the length must be 50% more as 9" or longer)	
Timber working thickness	<b>T = 17MM ~ 60MM</b>
Timber working width	<b>W = 25MM ~ 160MM</b>
Timber out-feed length	<b>L = 3000MM ~ 6200MM</b>
Glue type to be used	<b>PVAC</b>
Timber species	<b>SOFTWOOD / HARDWOOD</b>
Timber moisture	<b>8 ~ 12 %</b>
Infeed qualities	

Timber must be processed via four sides moulder machine (tolerance:  $\pm 0.2\text{mm}$ ) and wood needs 90 degrees right angle, four planning clear, straight.

Maintenance and cleaning please refer the operating manual.

## TO BE PROVIDED LOCALLY

Electric power supply to switch cabinet

Constant voltage (voltage deviations max.: 5%)

Temperature range for computer control not exceeding 35°C

Maximum relative air humidity for control system computer 65%

Dust exhaust system: **6,800 cfm at low pressure of 0.18 psi**

(V=30M/S at a low pressure of 12M BAR)

Compressed air connection to plant units: **80 to 95 psi**

(6~8 KG/CM<sup>2</sup> – 8BAR)

Cable, collecting duct

Hydraulic oil

Skilled operating and maintenance personnel

Noise control

Lighted working environment

Computer cable if machine be with monitoring

☆ Dust Collecting : 4" \* 3PCS, 8 \* 4PCS

☆ Total electricity demand: 65 KW, 86 HP

☆ Compressor request: 30 HP + 100 LITER AIR TANK

## CAPACITY

Working time	480 MIN/SHIFT
Finger length	MADE BY ORDER
Average infeed length at the finger jointing line	500 MM
Average timber cross section	50*100 MM
Number of timber pieces per shaper table (horizontal finger)	(MAX) 150 PCS/MIN
Capacity of the press	8 WORKING PIECES/MIN

\*\* The data is the max capacity for one-section cutting, the capacity will be reduced while multi-section cutting. \*\* Example; 17 ft will be the maximum assembly production capacity, but if we do two of the 8.5 ft length pcs, it will lower down the capacity due to the extra cutting processing

Pressing length	6.2 Meters
Rate of utilization	80%

## CAPACITIES OF THE COMPONENT

### CAPACITY OF THE SHAPER

#### (HORIZONTAL FINGER JOINTING/50\*100)

120 PCS/MIN  
X 500 MM AVERAGE INFEEED LENGTH\*\*/1000MM  
X 480 MIN /SHIFT  
X 0.8 RATE OF UTILIZATION =23,040 M /SHIFT

### CAPACITY OF THE PRESS(6M)

8 PIECES/MIN  
X 6.2 M /MIN  
X 480 MIN /SHIFT  
X 0.8 RATE OF UTILIZATION=19,046 M /SHIFT

## TOTAL CAPACITIES OF THE LINE

### CAPACITY OF THE SHAPER

#### HORIZONTAL FINGER JOINTING/50\*100

23040 M /SHIFT  
48.00 M/MIN  
115.2 M<sup>3</sup>

### CAPACITY OF THE PRESS(6M)

19046 M /SHIFT  
39.67 M/MIN  
95.23 M<sup>3</sup>

## A MECHANICAL SPECIFICATIONS: FEEDING SYSTEM

Working size	L=150 ~ <b>1000</b> T=17-60 W=25- <b>160</b>
intermittence feeding motor	2HP + 1:25 Gear Box

## C1 MECHANICAL SPECIFICATIONS: FEEDING SYSTEM

Working size	L=150 ~ <b>1000</b> T=17-60 W=25- <b>160</b>
main feeding chain servo drive motor	20KW + 1: 40 Gear Box
working feeding speed	120-150 pcs/min
feeding motor	1HP + 1: 40 Gear Box

## C2 MECHANICAL SPECIFICATIONS: SHAPING DEVICE(R)

Working size	L=150 ~ <b>1000</b> T=17-60 W=25- <b>160</b>
Motor of finger spindle	25HP *1 PCS
Spindle size	ID50(70)mm
OD of finger cutter	<b>OD250mm</b> (without finger cutter)
Finger spindle RPM	4600RPM at 50Hz/5500 RPM at 60Hz
Power of Cut-off saw	15HP *1 PCS
Cut-off saw blade size	305mm x 80T x 5mm (with saw blade) 290mm x 40T x 5mm (with saw blade)
Cut-off saw Speed	4300rpm/min
Power of scoring saw	3HP *1 PCS
Scoring saw	180mm x 50T x 5mm (with saw blade)
Scoring saw spindle	4200 rpm/min
Press device up/down drive motor *1PCS	0.5HP + 1: 10 Gear Box

## C3 MECHANICAL SPECIFICATIONS: SHAPING DEVICE(L)

Working size	L=150 ~ <b>1000</b> T=17-60 W=25- <b>160</b>
Motor of finger spindle	25HP *1 PCS
Spindle size	<b>Diameter 50 or70 mm</b>
OD of finger cutter	<b>OD250mm</b> (without finger cutter)
Finger spindle RPM	4600RPM at 50Hz/5500 RPM at 60Hz
Power of Cut-off saw	15HP *1 PCS
Size, cut-off saw	305mm x 80T x 5mm (with saw blade) 290mm x 40T x 5mm (with saw blade)
RPM, cut-off saw	4300rpm/min
Power of scoring saw	3HP *2 PCS
Size, scoring saw	180mm x 50T x 5mm (with saw blade)

RPM, scoring saw spindle	4200rpm/min
press device up/down drive motor	0.5HP + 1: 10 Gear Box *1PCS
Glue Applier	<b>GLUE COMB</b>
Standard glue height	H=150mm. Pitch 3.8mm. L=10mm-12(Special size made by order)

### K MECHANICAL SPECIFICATIONS: OUT-FEED

Working size	L=150-900 T=17-60 W=25-150
Speed	70M/min
Power	3HP * 1pcs
Vacuum device – blower	5HP (3" Vacuum port)

### G MECHANICAL SPECIFICATIONS: PRE-JOINT

Working size	L=150-900 T=17-60 W=25-150
Feeding chain drive power	3HP*2pcs
In-feed Inverter	7.5HP * 1pcs
Chain type	Double chain - flat type
Feeding speed	10M~90M / min

### H MECHANICAL SPECIFICATIONS:6METER ASSEMBLER

Working dimension	W=20mm~ <b>160mm</b> . H=15mm~75mm L=6000mm
Power of upper & lower roller	2HP * 2pcs
In-feed Inverter	7.5HP * 1pcs
In-feed speed	10M~70M / min
Cut-off saw, power	5HP * 1pcs
Cut-off dimensions	355MM x 120T x 25.4MM * 1pcs
Cut-off saw, RPM	2850 rpm/min
Hydraulic power	5HP * 1pcs (High speed oil tank)
Capacity /min	1-8 PCS/min (TOP SPEED)

## Optional 1 SAT-FD-60/4S 4 Out-hanging saw with 4 Saws



Working dimension L=6200mm

Power of Cut-off saw 3HP \* 4 Pcs

Size, cut-off saw 405MM x 120T x 3.2mm\*25.4mm

RPM, cut-off saw 2850rpm

Quantity of out-hanging saw 4 Saws

