

項次/Term	機械編號/Machine number	數量/Quantity
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A1	HSTC-62A	1
A2	HSTC-62A	1

B	DFSR-62I	1	<u>技術資料(Technical Data)</u>	
C	HSTC-62A	1	工作高度(working height)	820/800mm
D	DFSL-62I	1	地面負載(load on floor:)	25 N/cm
E	HSTC-62B	1	集塵孔徑(exhaustion)	1 * 4" ; 6 * 8"
N	HSTC-62A	1	集塵速度(exhaust speed)	30 m/s at a depre.of 12 mbar
I	HSCB-62	1	空氣供應(compressed-air supply)	R1.5"
H	UFJ-600	1	空氣接頭(compressed-air connection)	4 * R1/2;8 bar constant consumer unit
			空氣消耗(compressed-air consumption)	2700 NL/min
			電力負載(connected load)	HP/KW

繪圖/Name		日期/Date	2019/3/26
比例/Rate	1:86	圖號/ Drawing number	HIAT-620-U(3000L)
視角/Vision	第三角 Third Angle	圖名/ Drawing name	auto finger joint system

## TECHNICAL SPECIFICATIONS

### Technical data of tour line

Timber working length(min-max) **L = 250MM ~ 3100MM**

Timber length to be processed must be at least 50% longer than the timber width to be processed.

Timber working thickness T = **25MM ~ 100MM**

Timber working width W = **35MM ~ 205MM**

Timber out-feed length L = ∞ (No Limit)

Glue type to be used **PVAC**

Timber species **SOFTWOOD / HARDWOOD**

Timber moisture **8 ~ 12 %**

Timber must be processed via four sides moulder machine (tolerance:±0.2mm) and wood needs 90 degrees right angle, four planning clear, straight.

## TO BE PROVIDED by CUSTOMER

Electric power supply to switch cabinet

Constant voltage (voltage deviations max.: 5%)

Temperature range for computer control not exceeding 35°C

65% Maximum relative air humidity for computer control system 65%

Dust exhaust system: (V=30M/S at a low pressure of12M BAR)

Compressed air connection to plant units: 6~8 KG/CM<sub>2</sub> – 8BAR

Cable, collecting duct

Hydraulic oil

Dust Collecting Port : 8” \* 6PCS, 4 \* 1PCS

Total electricity demand: **117 KW, 156 HP**

Compressor request : 30 HP + 100 LITER AIR TANK (Pressure 7~8 KG/CM<sub>2</sub> – 8BAR)

## CAPACITY

Working time **480 MIN/SHIFT**

Finger length **MADE BY ORDER**

Average in-feed length at the finger jointing line **2000 MM**

Average timber cross section **(200\*50MM)**

Shaper max speed **4 Cycle /Min**

**\*\*The speed will change by the working height of wood\*\***

Number of timber pieces per shaper table (vertical finger jointing 50\*200) **12 PIECES**

Number of timber pieces per shaper table(horizontal finger jointing 200\*50) **3 PIECES**

**Assembly Pressing length No Limit ∞Meters**

Rate of utilization **80%**

## CAPACITIES OF THE COMPONENT

### **CAPACITY OF THE SHAPER (VERTICAL FINGER JOINTING/50\*200)**

**0.5** TABLE Cycle /MIN x **12** PIECES/TABLE x **2,000** MM AVERAGE INFEED LENGTH x **480** MIN /SHIFT x **0.8** RATE OF UTILIZATION = **4608 M /SHIFT**

### **CAPACITY OF THE SHAPER (HORIZONTAL FINGER JOINTING/200\*50)**

**2** TABLE /MIN x **3** PIECES/TABLE x **2000** MM AVERAGE INFEED LENGTH x **480** MIN/SHIFT x **0.8** RATE OF UTILIZATION =**4,608 M /SHIFT**

## TOTAL CAPACITIES OF THE LINE

### **VERTICAL FINGER JOINTING/50\*200**

**4608 M /SHIFT**

**9.60 M/MIN**

**46.08 M<sup>3</sup>**

### **HORIZONTAL FINGER JOINTING/200\*50**

**4608 M /SHIFT**

**9.6 M/MIN**

**46.08 M<sup>3</sup>**

## MECHANICAL SPECIFICATIONS: HSTC-62A



### **A1 : HSTC-62A HEAVY SINGLE TABLE CONVEYOR DEVICE**

Working dimension W=620mm. L=3100mm

Speed 35M/min

Power 3HP \* 1pcs

Invertor 3 HP \* 1 pcs

### **A2 : HSTC-62A SINGLE TABLE CONVEYOR DEVICE**

Working dimension W=620mm . L=3100mm

Speed 35M/min

**Power 3HP \* 1pcs**

**Invertor 3 HP \* 1 pcs**

## MECHANICAL SPECIFICATIONS: DFSR-62I (single spindle)



### B:DFSR-62I HEAVY DUTY FINGER SHAPER (INVERTER)

Working dimension W=620mm. L=250mm~3100mm. H=25mm~205mm

Motor of finger spindle 30HP \* 2pcs

Spindle size 50mm

OD of finger cutter OD210mm (without finger cutter)

Finger spindle RPM 3800rpm / min

Power of Cut-off saw 15HP \* 1pcs

Size, cut-off saw 305mm x 80T x 5mm \* 1pcs

RPM, cut-off saw 2850rpm/min

Power of scoring saw 2HP \* 1pcs

Size, scoring saw 180mm x 50T x 5mm \* 1pcs

RPM, scoring saw 2850rpm/min

Conveyor power 3HP \* 1pcs

Inverter 3 HP x 1 pcs

Table movement inverter system power, HP 2HP+3HP Inverter\* 1pcs

Cycle speed packing/min 1-2 times/min(Top speed)

## MECHANICAL SPECIFICATIONS: HSTC-62A



### **C : HSTC-62A HEAVY SINGLE TABLE CONVEYOR DEVICE**

Working dimension W=620mm . L=3100mm

Speed 35M/min

Power 3HP \* 1pcs

Invertor 3 HP x 1 pcs

### **A2 : HSTC-62A SINGLE TABLE CONVEYOR DEVICE**

Working dimension W=620mm . L=3100mm

Speed 35M/min

Power 3HP \* 1pcs

Invertor 3 HP x 1 pcs

## MECHANICAL SPECIFICATIONS: DFSL-62I



### **D:DFSL-62I HEAVY DUTY FINGER SHAPER(INVERTER)**

Working dimension W=620mm. L=250mm~3100mm. H=25mm~205mm

Motor of finger spindle 30HP \* 2 pcs

Spindle size 50mm

OD of finger cutter OD210mm (without finger cutter)

Finger spindle RPM 3800rpm / min

Power of Cut-off saw 15HP \* 1pcs

Size, cut-off saw 305mm x 80T x 5mm \* 1pcs

RPM, cut-off saw 2850rpm/min

Power of scoring saw 2HP \* 2pcs

Size, scoring saw 180mm x 50T x 5mm \* 1pcs

RPM, scoring saw 2850rpm/min

Conveyor power 3HP \* 1pcs

Conveyor 3 HP x 1

Table movement inverter system power, 2HP+ 3HP Inverter\* 1pcs

Cycle speed packing/min 1-4 times/min

Glue Applier injection glue spreader

Standard glue height H=205mm Pitch 4.0mm L=10-12mm (special size made by optional)

**\*\*the Glue system is only for PVAC\*\*\***



## MECHANICAL SPECIFICATIONS: HSTC-62B & HSCB-62



### **E : HSTC-62B HEAVY REAR OUT-FEEDING CONVEYOR DEVICE WITH GLUE CLEANER**

Working dimension W=620mm. L=3100mm

Speed 35M/min

Power 3HP \* 1pcs

Conveyor Invertor 3 HP x 1 pcs

Clean conveyor device power 1/2HP \* 1pcs

### **I : HSCB-62 TURNING CONVEYOR + NARROW CONVEYOR DEVICE**



Working dimension W=620mm. L=3100mm & W=250mm. L=3100mm

Speed 35M/min

Power 3HP \* 1pcs



## Mechanical Specifications: UFJ-600



### **H : UFJ-600 Infinite finger assembler device**

Working dimension W=35mm~205mm . H=25mm~100mm. L=∞mm

In-feed speed 30M~50M / min

Cut-off saw, pow 7.5HP \* *1pcs*

Cut-off dimensions 455 x 120T x 25.4MM ( with saw blade) \* *1pcs*

Cut-off saw, RPM 2850rpm/min

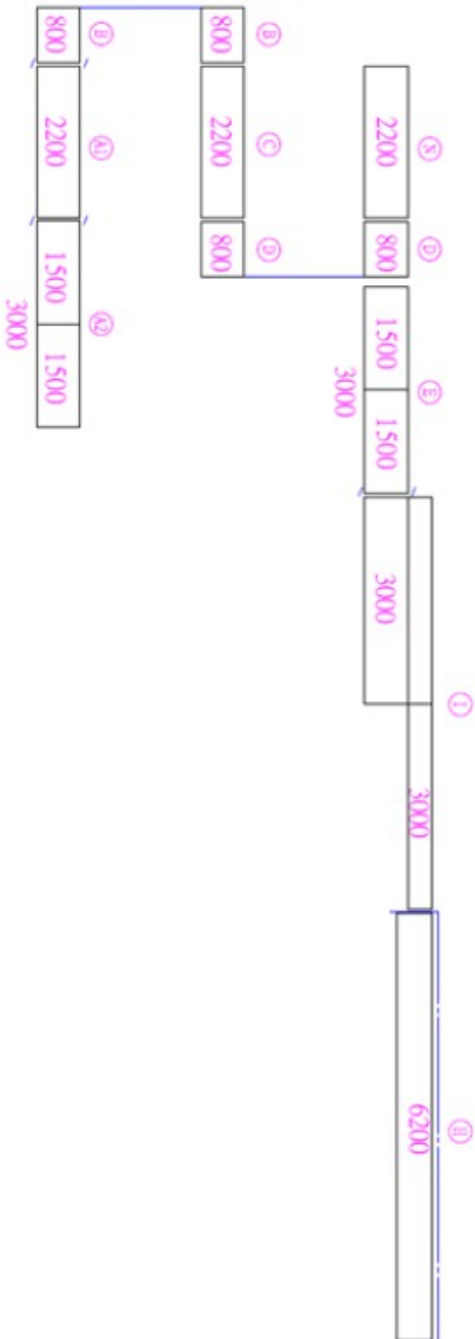
Hydraulic power 10HP \* *1pcs* , 15HP \* *1pcs*

Out-feed table size 2M \* 3

Oil tank **200L**

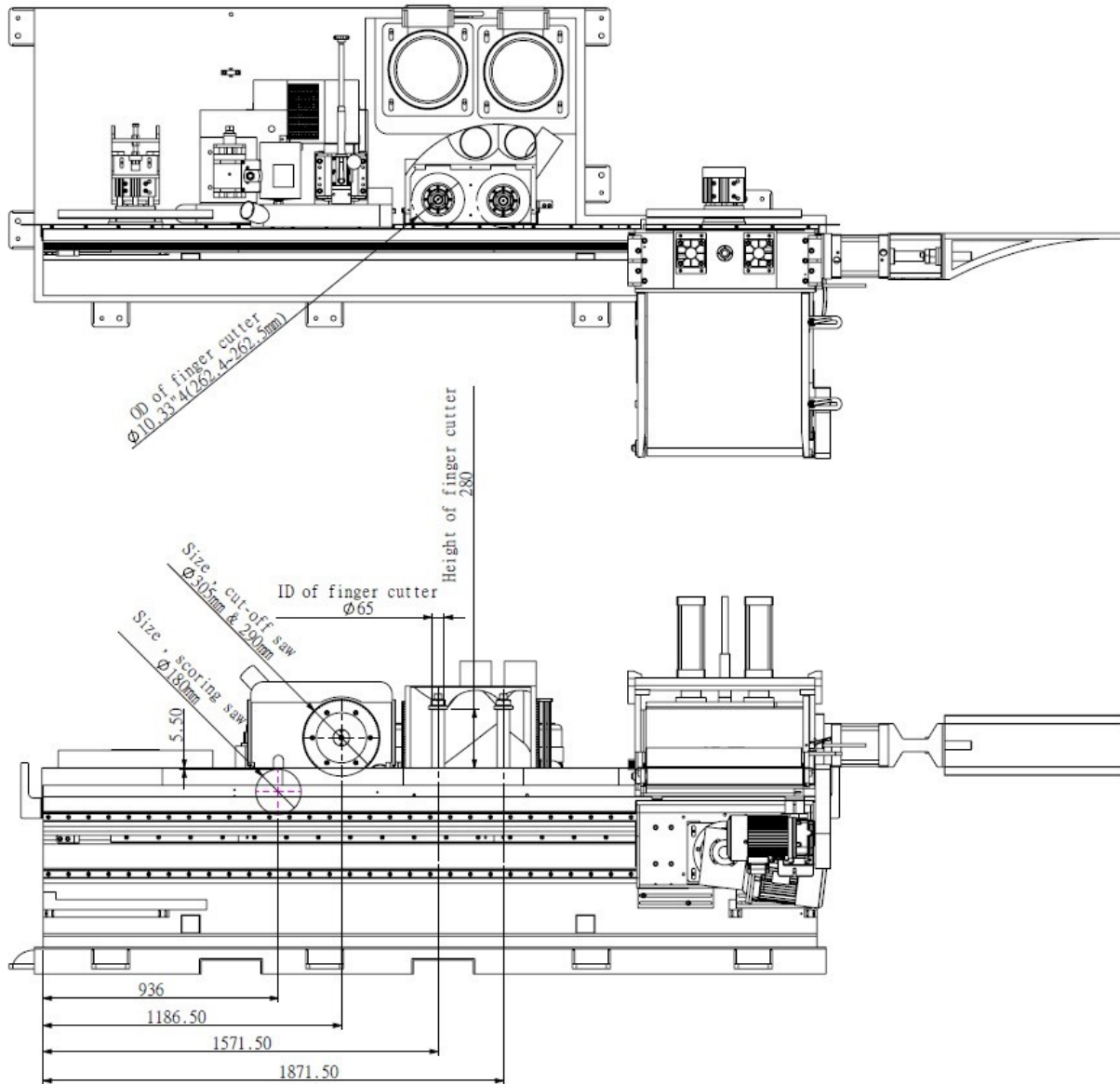
- A1 : HSTC-62A
- A2 : HSTC-62A
- B:DFSR-62I
- C : HSTC-62A
- N : HSTC-62A
- D:DFSL-62I
- E : HSTC-62B
- I : HSCB-62
- H : UFJ-600

Operators:3



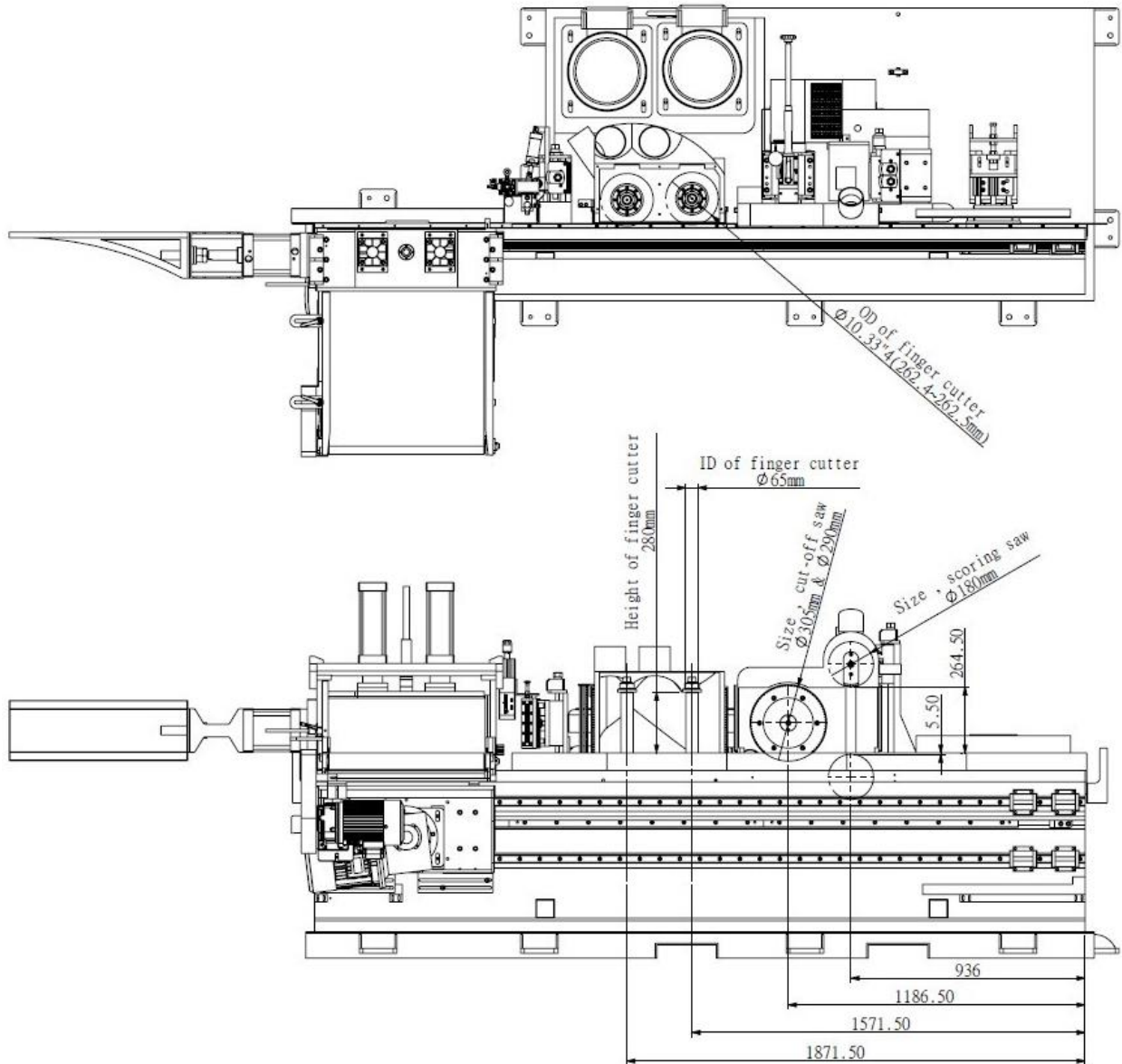
# Left Hand Side First Shaper

## Lay Out

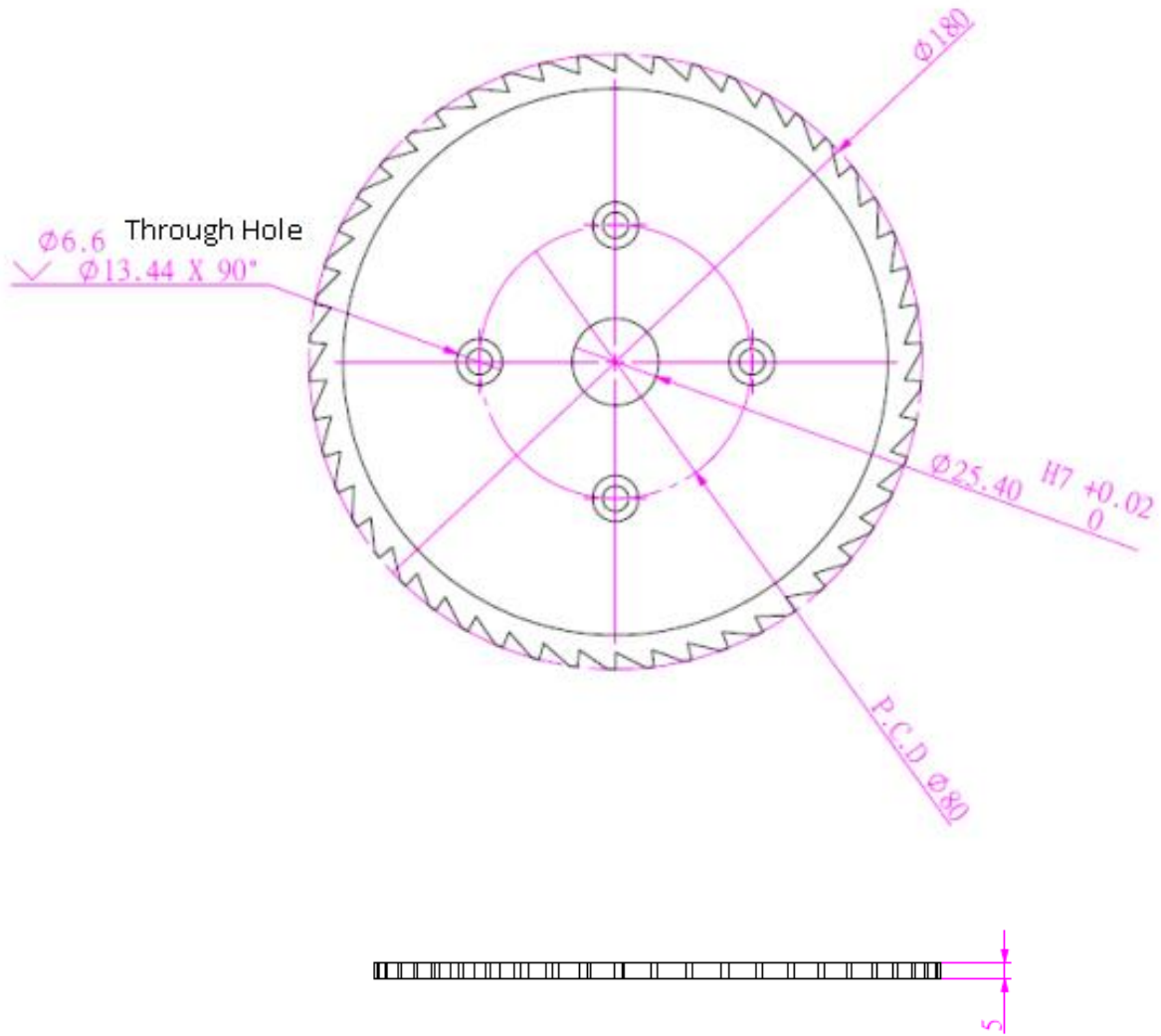


# Right Hand Side Second Shaper

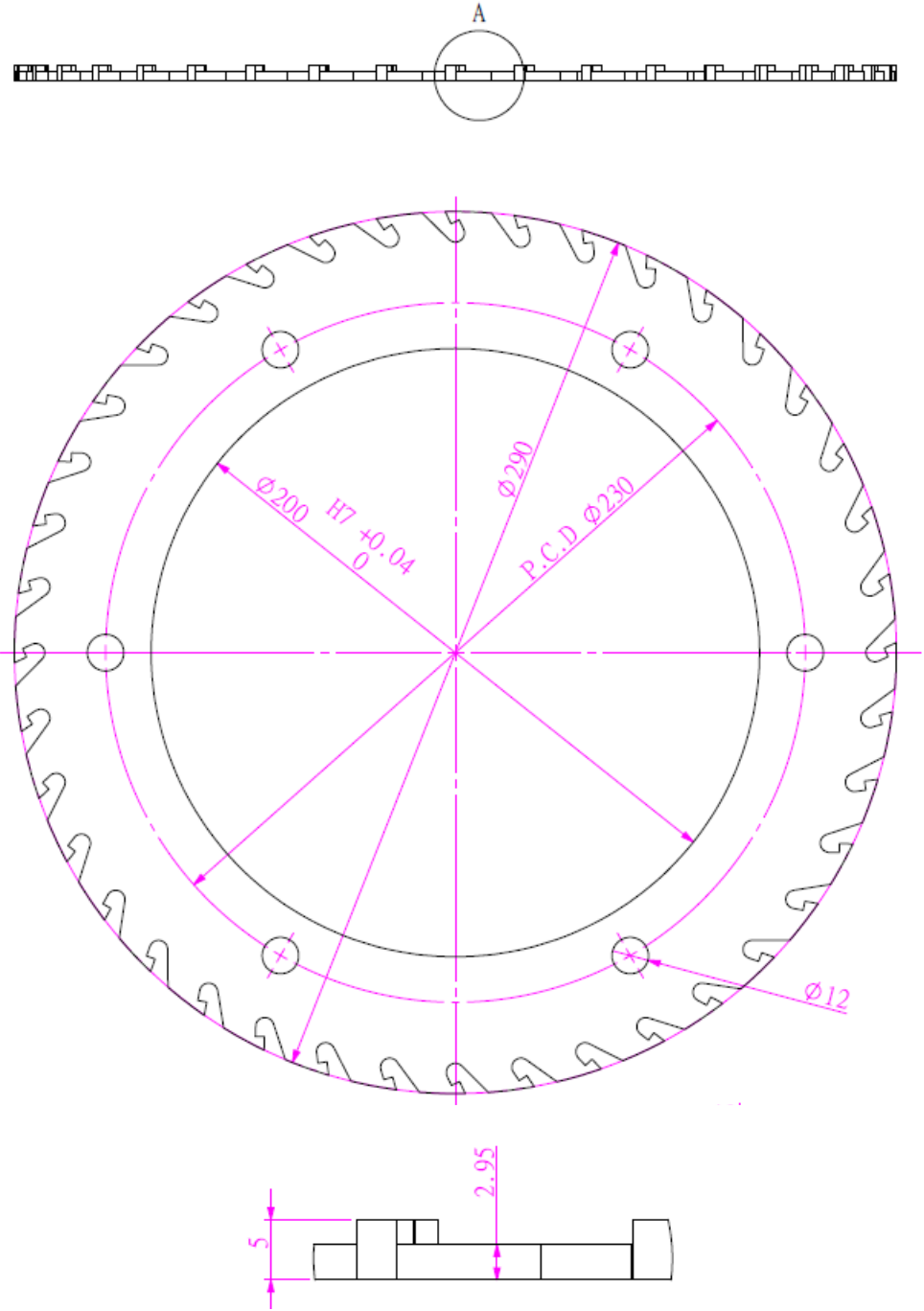
## Lay Out



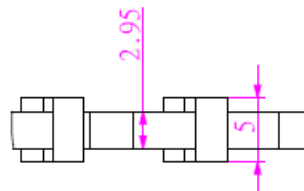
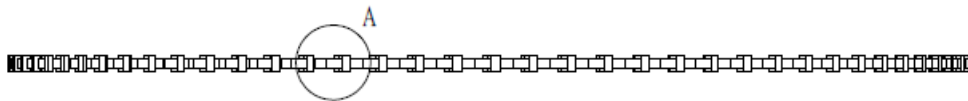
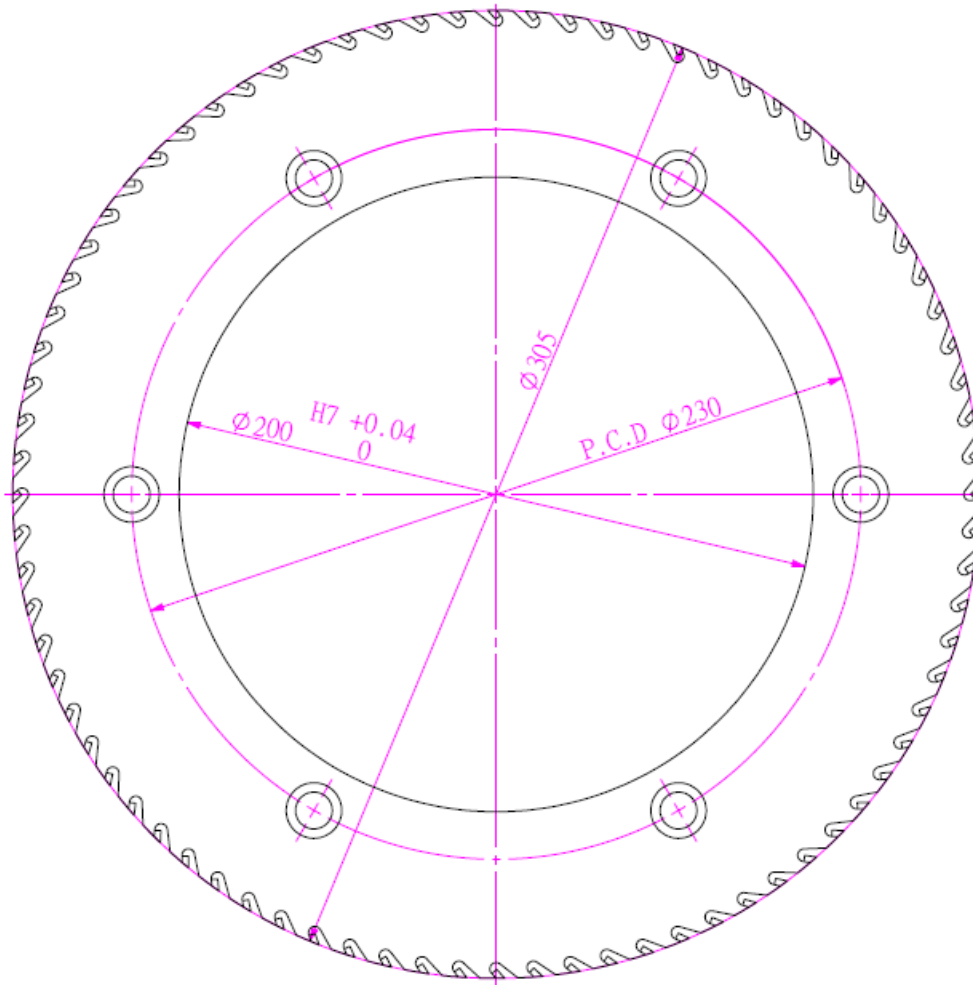
# 1, 3 Finger Shaper Scoring Saw Blade



# 2~1, 4~1 Finger Shaper Trim Saw Blade



# 2~2, 4~2 Finger Shaper Cut-Off Saw Blade





## 5. Assembly Press Cut-Off Saw Blade

