

SOLUTION

NC single-sided edgebanders

SOLUTION

TOP LEVEL EDGEBANDING TECHNOLOGY



Solution is your ideal partner for all edge banding requirements, at all times guaranteeing maximum machining precision and lasting reliability, always with fast returns on investments. Solution can be set up to apply all edging

strips, whether traditional or the latest fashions. It can perform processes for straight and softforming panels with maximum ergonomics. It can be set up either in stand mode or in complex machining cells.



Solution: Champion for price - performance ratio



Perfect for the medium-sized enterprise, ready for the sector



Your ideal partner for high quality, profitable production



SOLUTION

EDGE BANDING WITHOUT COMPROMISES

A UNIVERSAL EDGE BANDING MACHINE FOR WORKING DIFFERENT MATERIALS

Solution can apply thin melamine edging, plastic PVC, ABS, PP, PMMA, HIGH GLOSS,

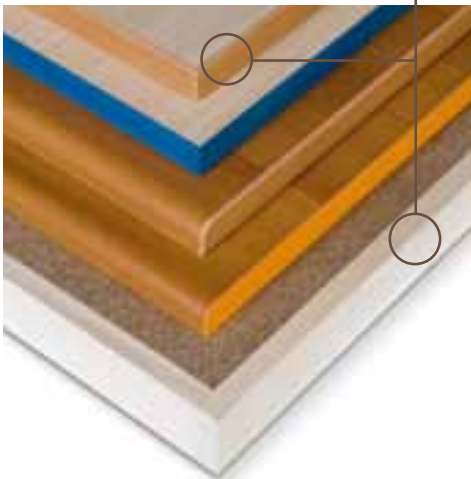
3D edging, aluminium edging, ready-cut strips veneer and plastic strips, and solid wood strips.



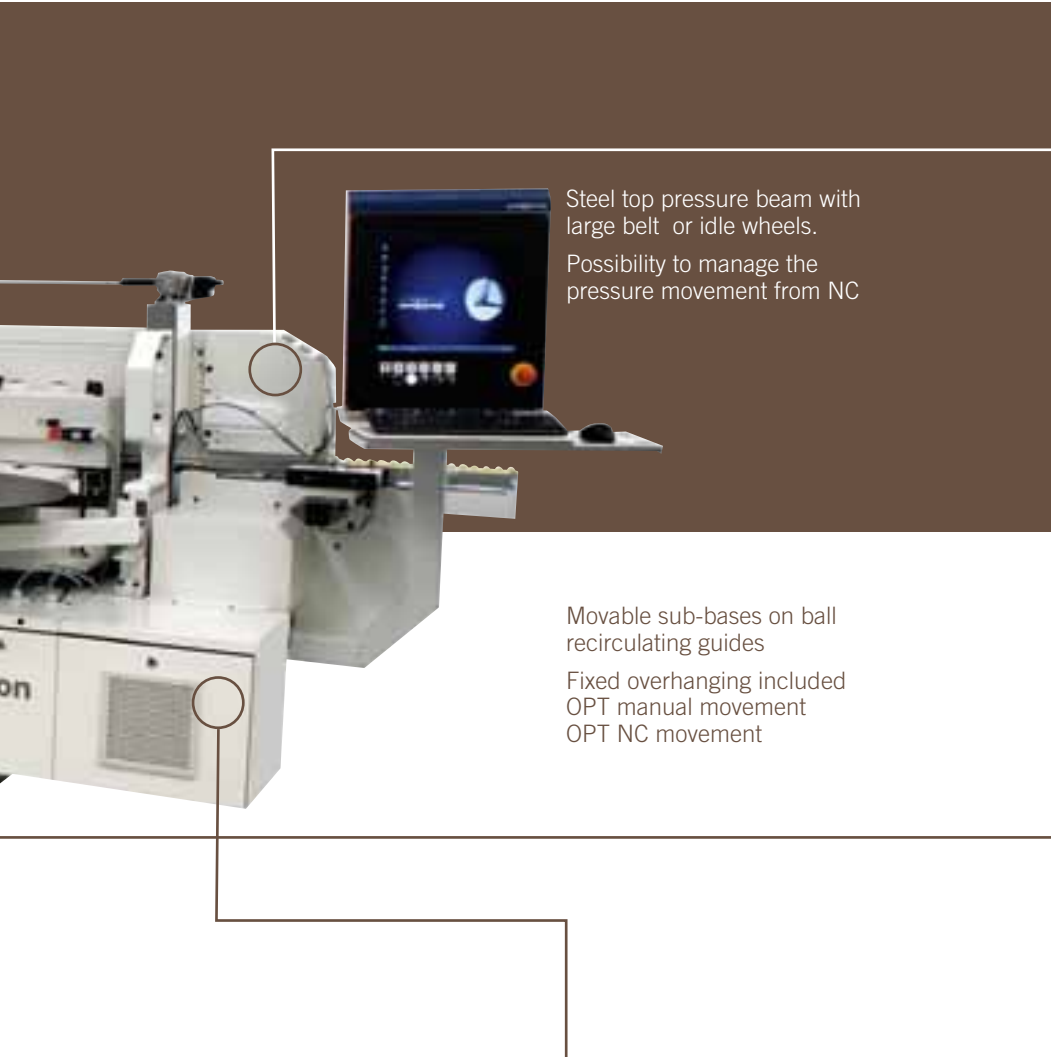
Thin, ABS and solid wood edges processing

Aluminium edges processing

Softforming processing



SOLUTION



Steel top pressure beam with large belt or idle wheels.

Possibility to manage the pressure movement from NC

Movable sub-bases on ball recirculating guides
Fixed overhanging included
OPT manual movement
OPT NC movement



Steel solid and duty beam



STEFANI SOLUTIONS TO IMPROVE THE QUALITY OF YOUR PRODUCTION

ECO POWER PACK: A REAL SAVING POTENTIAL

SOLUTION is equipped with **EPP – ECO POWER PACK**, which allows a notable saving of power and material.

► **ED-SYSTEM suction system:**

effective chip and dust evacuation is ensured, with lower power consumption and improved cleaning of working units and machine.

► **OPTI-CUT device:** precision edge feeding and rear cut to reduce waste generation to a minimum for significant advantages of edge saving.

- If the machine is not in use, the track feeding automatically goes on stand-by and the glue pot temperature drops.
- Possibility of separated management of suction hoods to reduce consumptions up to 65%.

QUALITY ON DETAILS

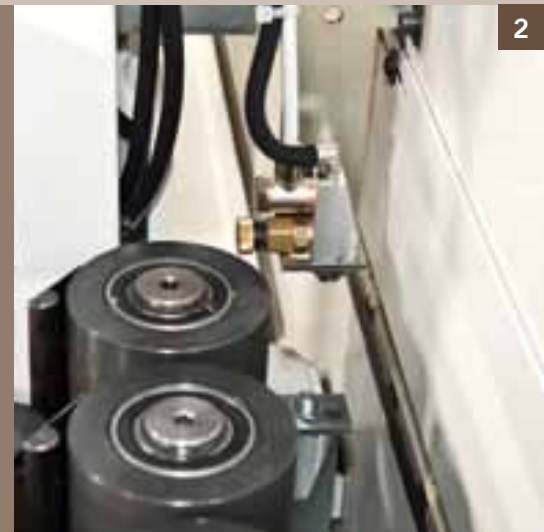
In addition to the anti-adhesive unit, SOLUTION can be equipped with devices that spray specific liquids to improve the working unit efficiency.

1. ACR UNIT

Cleaning device for glue scraping and edge brightening units.

2. ASR UNIT

Placed before the trimming unit, prevents the plastic edge scrap sticking to mechanical machine components. It helps to cool the temperature of the glue previously applied by gluing unit.



MULTIEDGE: DYNAMIC WORKING PROCESS CHANGE

To automatically change between 2 radiuses and infinite thin edges, without tool change. Available on fine trimming, corner rounding and edgescraping units.

Not available for the German market.



SOLUTION



X GRINDER PERFECT QUALITY BAR MACHINING

A system for grinding waste built into the extractor hoods of the edge scraper unit reduces the size of the waste when machining medium - long panels or bars (optional device, STEFANI patent pending).

NESTING EASILY WORKING WITH INTEGRATED CELLS

Availability of special feelers in trimming and fine trimming units for the edgebanding of nested panels.



EFFICIENT CHIP CUTTING AND SUCTION

The optimized ED-SYSTEM improves the chip suction's quality and performance by means of tools and suction hoods precisely designed for this purpose. By means of this technology chip is always evacuated from the panel and is always controlled. ED-SYSTEM is available on pre-milling, trimming, fine trimming and rounding units.



SOLUTION

STEFANI SOLUTIONS TO IMPROVE THE QUALITY OF YOUR PRODUCTION



INFEEED SYSTEMS - Simply extending the potential of SOLUTION

Infeed system for narrow workpieces

This device can be set up, facilitating the insertion of smaller panels.

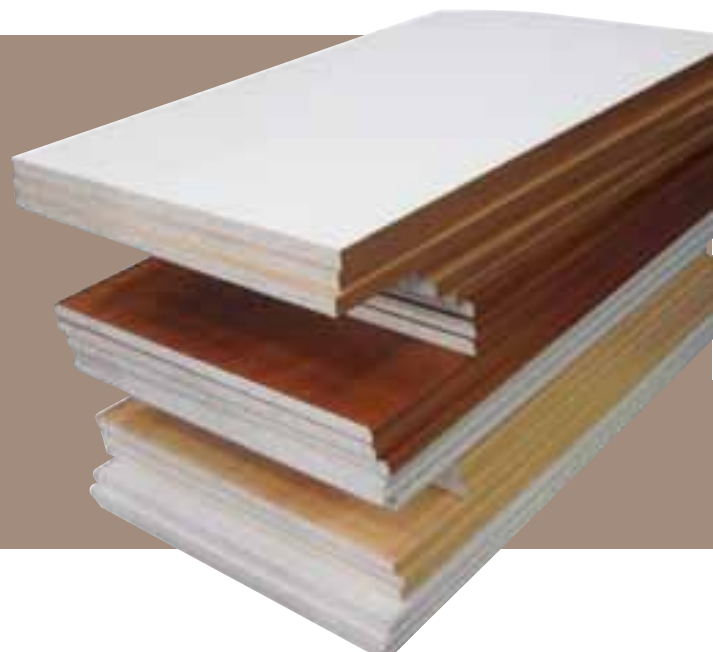
Manual infeed system for large workpieces

Optional device which facilitates transversal insertion of medium/large panels. The reference guide can be tilted to allow the insertion of panels with angled sides.

EASY ORDER S Automatic in-feed device for panels with big dimensions



Optional device which facilitates the transversal insertion of medium/large panels and allows tailored machining of workpieces which are not perfectly square on their 4 sides (optional). Easy Order S is activated by the operator with each cycle.



TOURER. PANEL RETURN DEVICE.



Solution can be set up with the TOURER panel return device. A single operator can perform complete panel machining directly

from the edge banding machine loading zone.



UX routing unit for external mortises

During edge banding, allows up to two timed or through-mortises to be made simultaneously on the side opposite the one being edge banded.

Panel side support

Supports the side of the panel. Telescopically adjustable position.



Fixed panel side support

Used in place of the standard telescopic version for large and/or heavy panels.



Automatic infeed system

Possibility of managing panel insertion in an easier, automatic way.



Standard additional External pressure zone

Allows high quality finishing even when machining small/narrow workpieces.

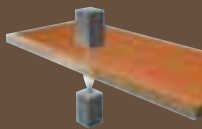


Solution:
Champion for price -
performance ratio

PANEL PREPARATION



Anti-adhesive unit



◀ To avoid glue deposits on the top and bottom surfaces of the panel.

▶ It mills the panel side to be edged ensuring an excellent gluing surface. Possibility of NC managed positioning of the first feeler. Possibility to equip the tools with HYDROLOCK technology to reduce coupling play and vibration. Optimized chip suction flow with ED-SYSTEM. Possibility to equip the EASY SIZE device, to manage from NC material removing depending on the applying edge.



Pre-milling unit



◀ Infeed guide by controlled axis (option)



▶ **Heating panels lamps**

To pre-heat the panel side to be edged for a better glue adhesion.



▶ **Entry Guide**

Aids correct panel positioning before in-feeding under the pressure beam. Possibility of double automatic position. Possibility of EASY SIZE NC movement. Possibility of manual movement.

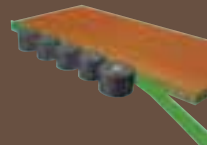
STEFANI COMMAND OF GLUE USING EDGE GLUING APPLICATION

SOLUTION



QMS pre-melting unit and unit for polyurethane block glue weighing 2 kg MC4 with melting capacity of 4 kg/h, with quick manual change-over device. Possibility of external pre-melting unit with melting capacity max. 6 kg/h. PUR glue.

Gluing unit



ROLL MAGAZINES

When one type of edging is not enough.

2 to 12 coils holders



EASY GLUE BASIC pre-melting unit, allows manual change-overs and in just a few minutes up to 5 colours of hot-melt glue, polyurethane glue and cleaner or combination of the three types.

Power-assisted
Edging feed



▲ **Power - assisted edging feed**
Edging can be fed with a precision of +/- 2 mm on the front and rear parts of the panel. This reduces the production costs for each panel.

▶ **QMS (LMS) melting system for thermofusible glue capacity till 8.5 kg/h (20 kg/h).**



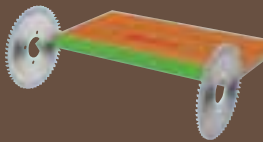


Perfect for the medium-sized enterprise, ready for the sector

FINISHING UNITS

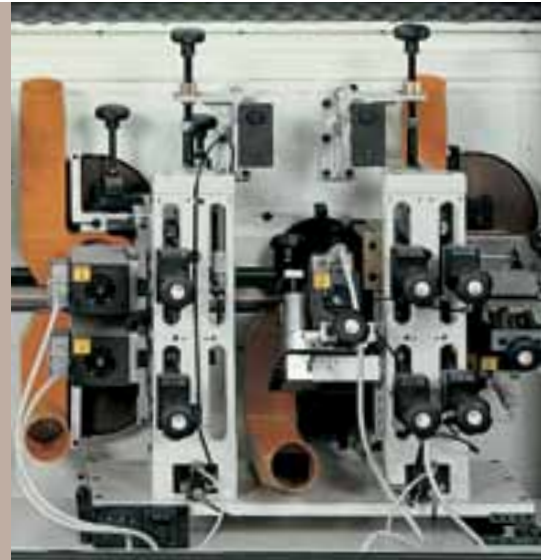


End-trimming unit

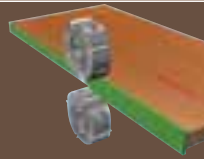


▶ For removing excess edging at the head and tail of the panels. Possibility of NC management of blades tilting and side feelers movement (by means of Brushless motors) for a perfect automatic management of the edge thickness. Possibility of using the NC to separately tilt the blades for working the head and tail of the panel independently.

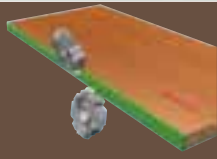
▶ For the top and bottom trimming of the edge excess. Possibility of NC double automatic positioning. Availability of special feelers in trimming and fine trimming units for the edgebanding of nested panels. Possibility to work separately top or bottom motors Optimized chip suction flow with ED-SYSTEM.



Trimming unit



Fine trimming unit



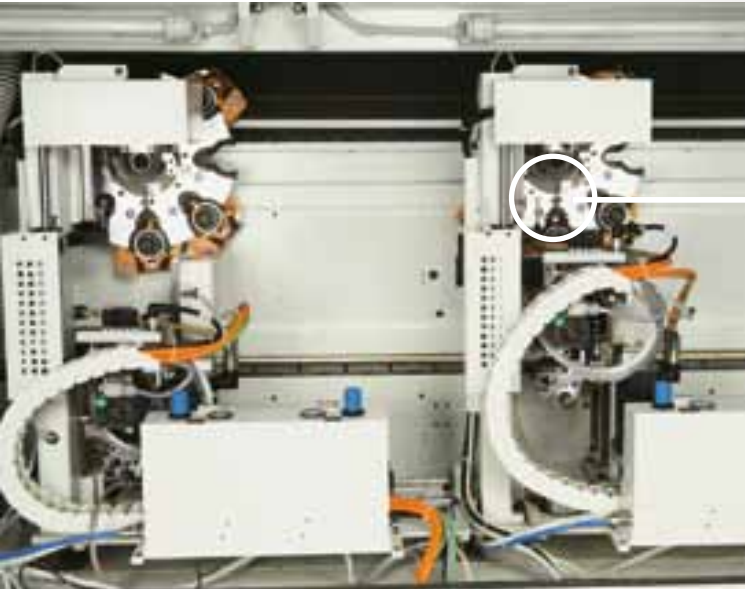
Multifunctional fine trimming unit



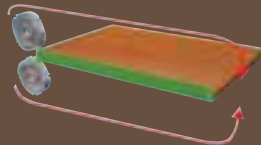
For upper and lower finishing of the excess thin edging and for fine trimming of PVC/ABS/PP/PMMA/3D/HIGH GLOSS edging. Quick release device for tool holder block and tool. Possibility of a NC lateral tracer for working different thicknesses or compensating for tolerances. Availability of special feelers in trimming and fine trimming units for the edgebanding of nested panels.

Possibility of setting up the 2P kit for automatically working a thin edging and a radiused edging using NC. Possibility of setting up the MULTIPLA kit for NC working of a thin melamine edging and three radiused edging strips with perfect quality. Optimised extractor flow with the ED-SYSTEM.

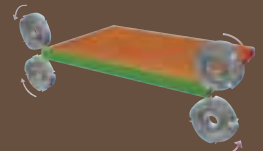
SOLUTION



NC corner rounding trimming unit with automatic tools change over.



4 motors corner rounding unit



For upper and bottom finishing with corner rounding of the panel edge banded with melamine, PVC/ABS/PP/PMMA/3D/HIGH GLOSS etc. Quick release device for tool holder block and tool. Possibility of a NC lateral feeler for working different thicknesses or compensating for tolerances. Possibility of setting up the 2P kit for automatically working a thin edging and a radiused. Possibility of setting up the Multiedge* kit for automatically working a thin melamine edging and two radiused edging strips with perfect quality. Optimized chip suction flow with ED-SYSTEM.

* Not available for the German market.



Multifunctional 4 motors corner rounding unit



Your ideal partner for high quality, profitable production

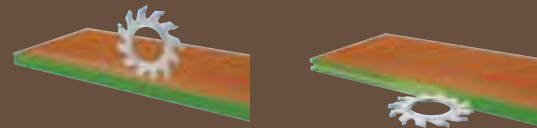
For making through- or timed grooves in the upper, lower and side surfaces of the panel. Quick release device for extractor hoods. Operating precision up to +/- 2 mm. Power ratings from 4 to 8.5 kW. Possibility of HSK release.

FINISHING UNITS



▼ For the finishing of PVC/ABS/PP/PMMA/3D/HIGH GLOSS rounded edges. Quick release device for tool holder block and tool. Availability of special feelers for edge banding panels previously machined with the nesting process. Possibility of setting up the 2P kit for working two radiused edging strips. Possibility of setting up the MULTIPLA kit for automatically working a thin melamine edging and three radiused edging strips with perfect quality. X-GRINDER waste grinding system built into the extractor hoods to reduce the size of the waste when machining medium - long panels or bars (optional device, STEFANI patent pending).

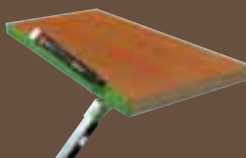
Grooving unit



NC controlled grooving unit with automatic tool change over

Edgescraping unit

Multifunctional edgescraping unit



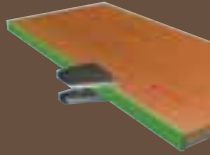
▼ To eliminate possible residual glue on the top and bottom side of the panel. Double bearing feelers for perfect process precision. A cooling and cleaning kit is available.

▼ For panel cleaning and brightening of plastic edges.

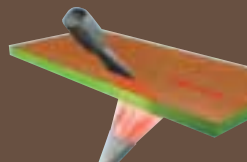
▼ For brightening of plastic edges.



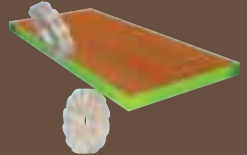
Gluescraping unit



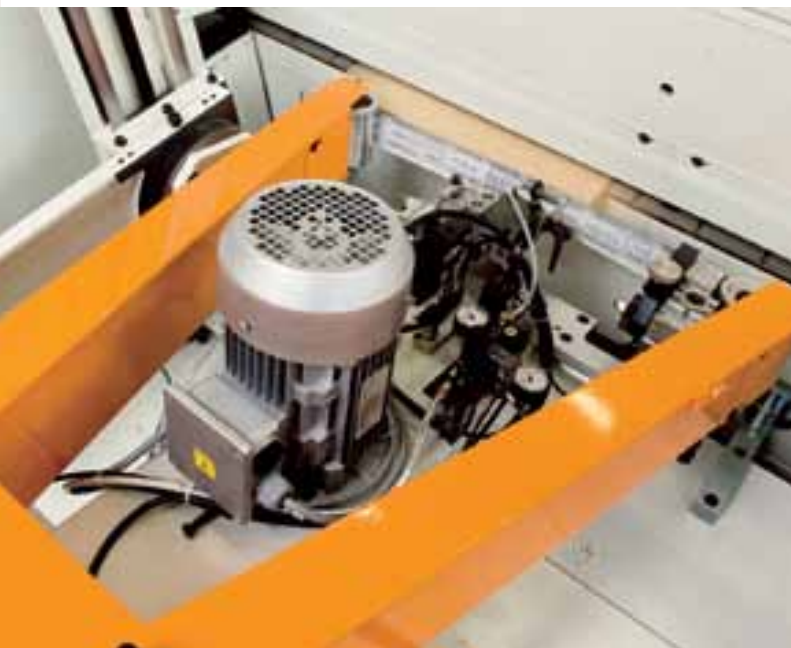
Edge brightening unit



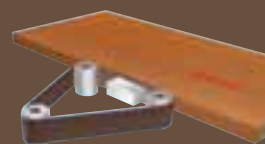
Buffing unit



Available for straight, shaped panels or for corners. It prepares the veneer panel for the coating processing.



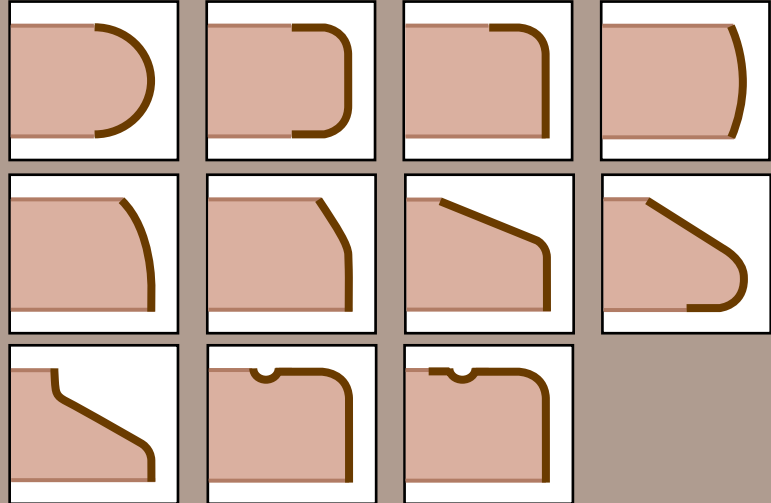
Sanding unit





Perfect for the medium-sized enterprise, ready for the sector

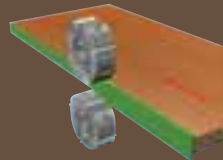
SOFTFORMING PROCESSING



Shaping unit



Inlay shaping unit

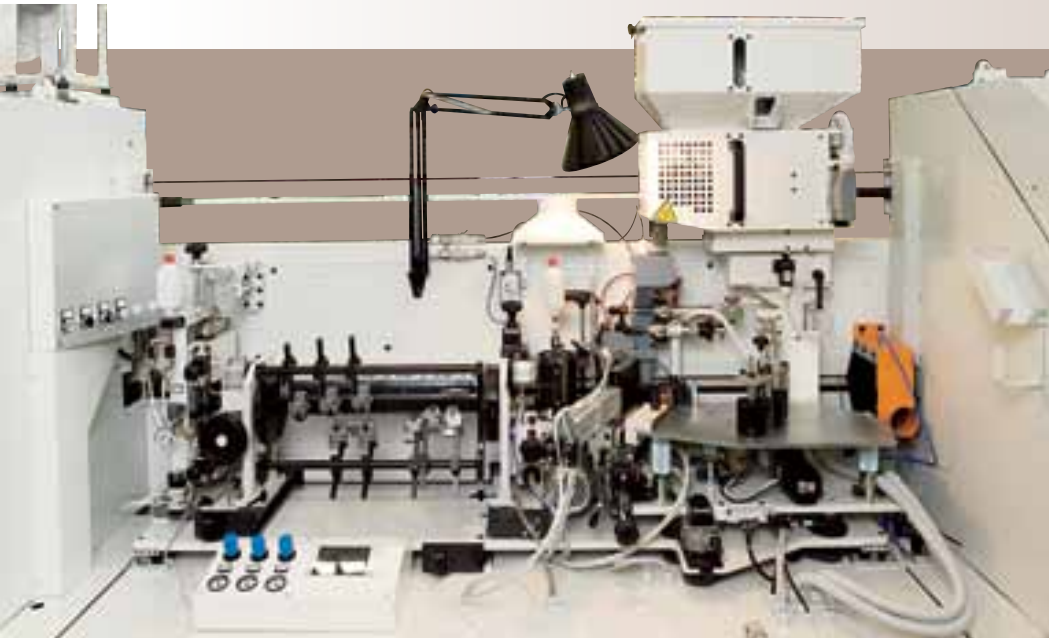


In one or more units it allows material removal in order to obtain the correct panel shape. Possibility of HSK release. Power ratings from 4 to 8.5 kW.

Proper for micro-removal on the top and/or bottom side of the panel



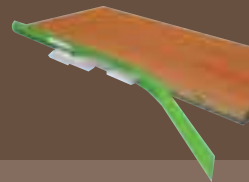
SOLUTION



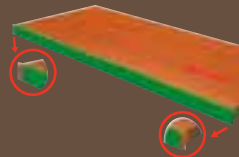
Possibility of applying edging both on softforming panels and on straight panels, with edging rolls up to 100 mm high.
Possibility of Kit for feeding glue in pellet form. Possibility of NC positioning for the pressure roller. Possibility of PU glue management.

Edging can be fed with a precision of ± 2 mm on the front and rear parts of the panel. This reduces the production costs for each panel.

Softforming gluing unit



Power-assisted Edging feed



Possibility of installing till 4 sectors for edge pressing with automatic selection from NC (opt).

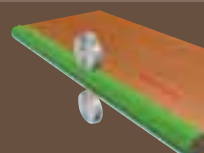
Specific finishing units for softforming processing useful for trimming and removing overhanging edge.



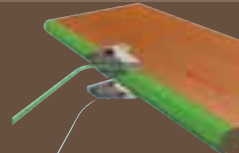
Pressure sectors exchange by revolver



Longitudinal shear unit



Scraping unit





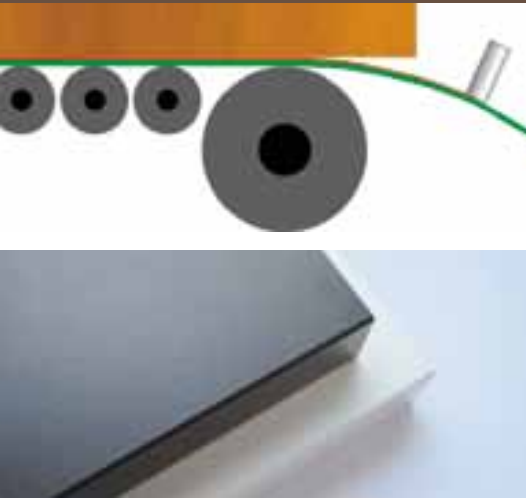
Perfect for the medium-sized enterprise, ready for the sector

MAIN OPTIONALS



Counter shoulder

Aids panel stability in softforming or solid wood edging application processes.



SLIM LINE. Perfect quality edge banding

SOLUTION can be set up with SLIM LINE gluing technology, the new STEFANI patented technology which allows glue to be applied directly to the edging instead of to the panel, in a geometrically perfect way by means of slots. This technique allows glue distribution that is controlled and above all on a completely flat surface.

FEATURES:

- strip of glue less than a tenth of a millimetre thick
- use of PU glues with production costs comparable to those with hot-melt glues, with all of the consequent advantages
- NC controlled dosing in terms of amount and size
- excellent, above standard finishing quality.
- The panel looks perfect.

Panel spacing device



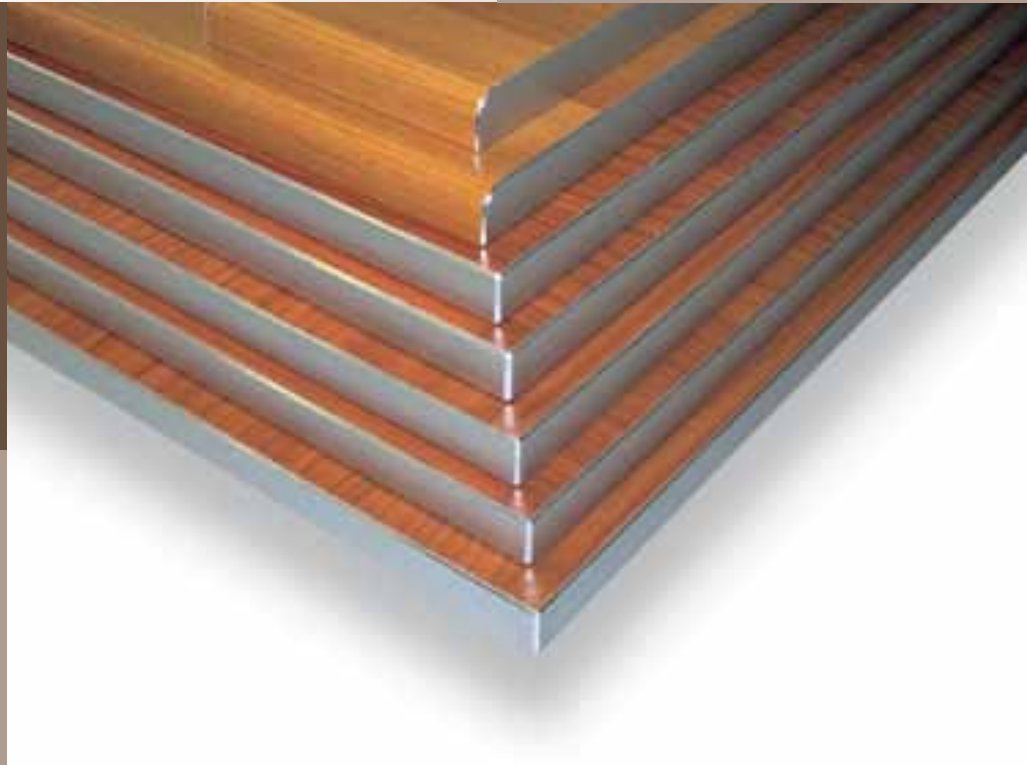
Disk-type counter pressure bar for processing narrow pieces



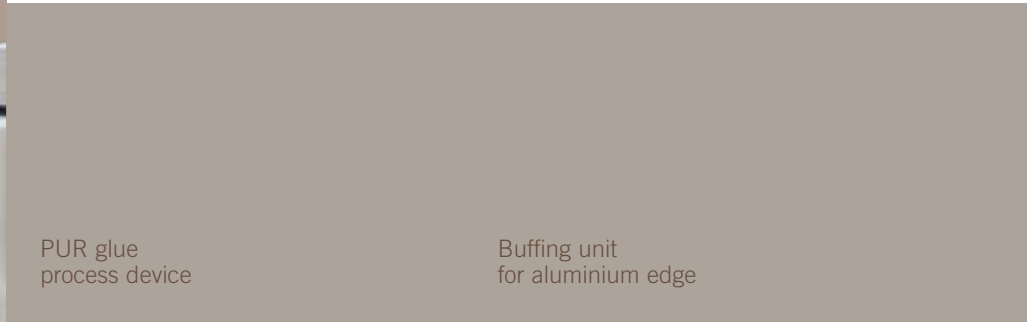
PANELS WITH ALUMINIUM EDGING. EXCLUSIVE DESIGN WITH THE STEFANI TECHNIQUE.

SOLUTION

The technology developed by Stefani for aluminium edge processing doesn't require sanding units and allows you to obtain both shining and opaque finishing.



PUR glue
process device



Buffing unit
for aluminium edge



Finishing unit
for aluminium edge





Perfect for the medium-sized enterprise, ready for the sector

SOFTWARE FOR MACHINE MANAGEMENT. A WORLD OF POSSIBILITIES.



Solution currently manages all its operating units with flexibility. This means that it's possible to introduce into the machine panels with different processing without waiting for machine emptying. SOLUTION is equipped with PC Office that works in Windows XP. WIN EDGE software allows easy, quick and precise machine management. Double Hard disk for a continual auto back-up. Display 15" LCD. Touch screen management is possible. UPS unit is available.



Unlimited number of processing programmes. Selection of the first or second pass without changing the program. Possibility of touch screen control.

Diagnostic management

In case of machine in warning, the PC visualizes the alarm, identifies the reasons of alarm and finds out where the alarm is on the machine. Therefore the PC leads the customer to the solution of the troubleshooting.

Production reports

Processing data, worked panels, used edge, daily, monthly and yearly. Reports allow production monitoring by statistic graphics and Excel files.

OFFICE-MACHINE INTERFACE

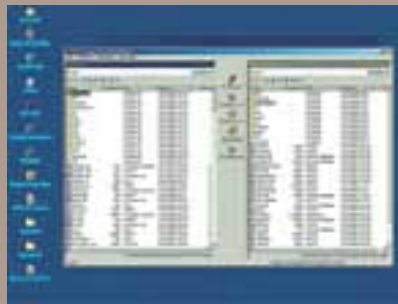
Through the PC Office it's possible to program the machine directly from the office and to receive production reports directly from the machine.

SOLUTION

WORKSHOP



CUSTOMER PREMISES

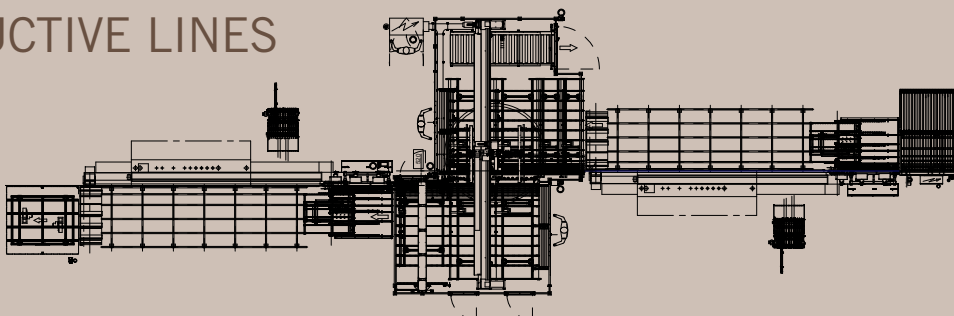


TELESERVICE

Through teleservice (optional) an immediate intervention from STEFANI technicians in situation of warnings during the machine process is assured to the customer. Further to the request of intervention about the customer, STEFANI technicians will connect by modem to the PC situated on the customer machine and, in real

time, they will resolve the software problems and re-set the machine to the best conditions. Besides, thought teleservice it's possible to modify or update the programs according to customer requests.

PRODUCTIVE LINES

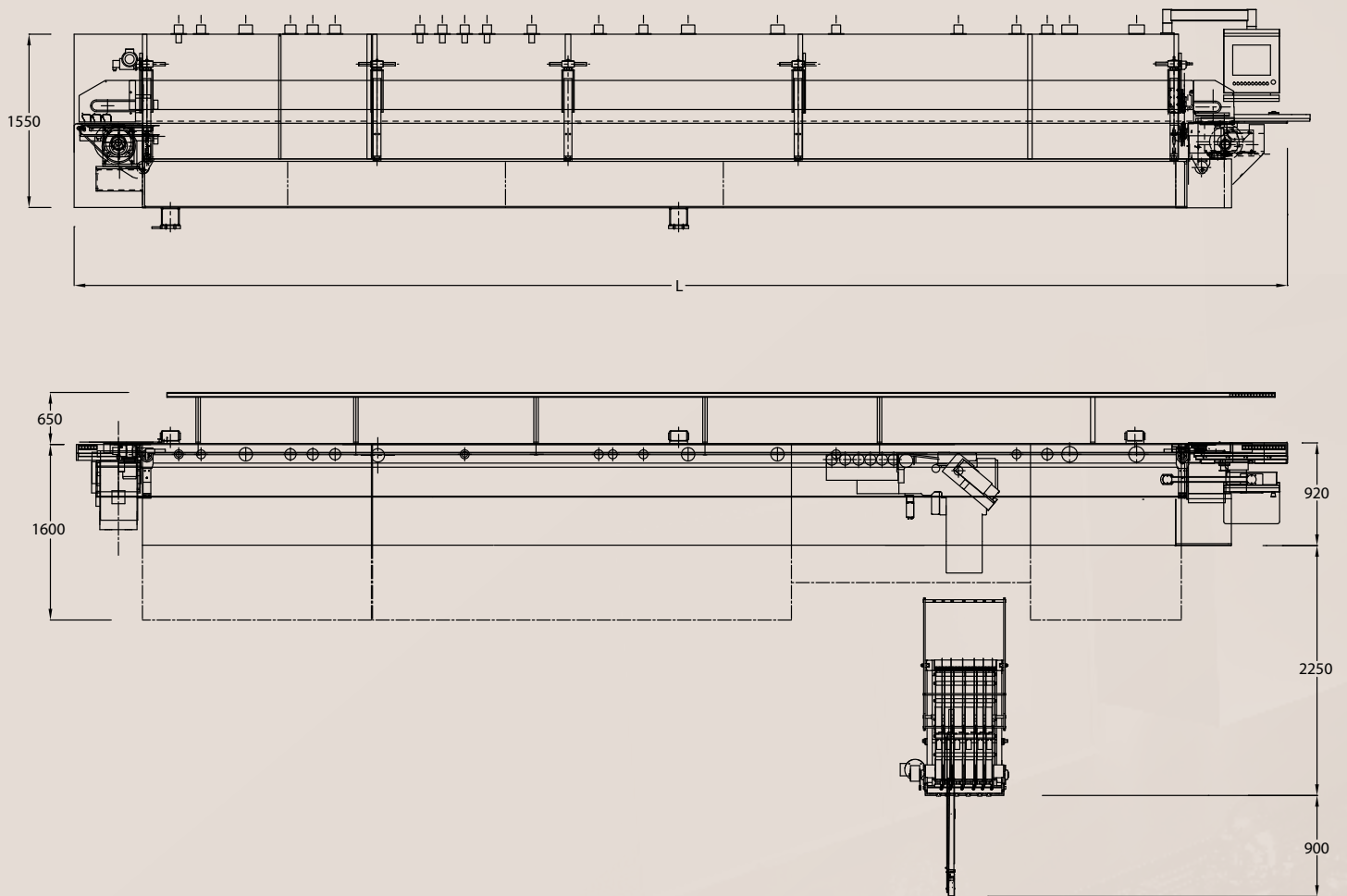


With SOLUTION complex production lines can be set up in several machines, even of different types, to fulfil process and flow requirements in the best possible way. Production cells can be managed using a supervision software which optimises their operation.

SOLUTION

TECHNICAL SPECIFICATIONS

OVERALL DIMENSIONS



SOLUTION

| | | | | | | | | |
|----------------------------|----------------------|----------------------|----------------------|----------------------|----------------------|--------------------|---------------------|---------------------|
| SOLUTION | Solution R-47 | Solution R-54 | Solution R-60 | Solution R-67 | Solution R-73 | Solution 47 | Solution 54 | Solution 60 |
| Total length (L) mm | 5650 | 6350 | 6950 | 7650 | 8250 | 5650 | 6350 | 6950 |
| SOLUTION | Solution 67 | Solution 73 | Solution 80 | Solution 86 | Solution 93 | Solution 99 | Solution 106 | Solution 112 |
| Total length (L) mm | 7650 | 8250 | 8950 | 9550 | 10250 | 10850 | 11550 | 12150 |

| | |
|---|--------------------------------|
| Minimum and maximum coil edge thickness | 0,4 - 3 mm |
| Minimum and maximum strip edge thickness | 0,4 - 25 mm |
| Minimum and maximum panel thickness | 10 - 60 mm (opt. 80 mm) |
| Adjustable feed speed | 10-25 m/min (opt. 12-30 m/min) |
| Glue types | EVA - EVA / PU |

| | Reference standard | VSA | LAV |
|---|--|------------|------------|
| Sound power level emitted dBw(A) [mW(A)] | EN ISO 3746 : 1995 ISO 7960-95 Annex G | 92,7 [1,9] | 94,5 [2,8] |
| Sound pressure level at operator position, infeed dB(A) | EN ISO 11202 : 1997 ISO 7960-95 Annex G | 77,9 | 79,4 |
| Sound pressure level at operator position, outfeed dB(A) | EN ISO 11202 : 1997 ISO 7960-95 Annex G | 72,1 | 74,5 |

NLWE: no load values without extraction OV: operating values

The tests were carried out with air extraction speed equal to 20 m/s.

Uncertainty associated with the measurement of the sound power ≤ 4.0 [dB(A)]

Uncertainty associated with the measurement of the sound pressure at the operator position ≤ 4.0 [dB(A)]

The maximum C-weighted instantaneous sound pressure values are less than 130 dB(C).