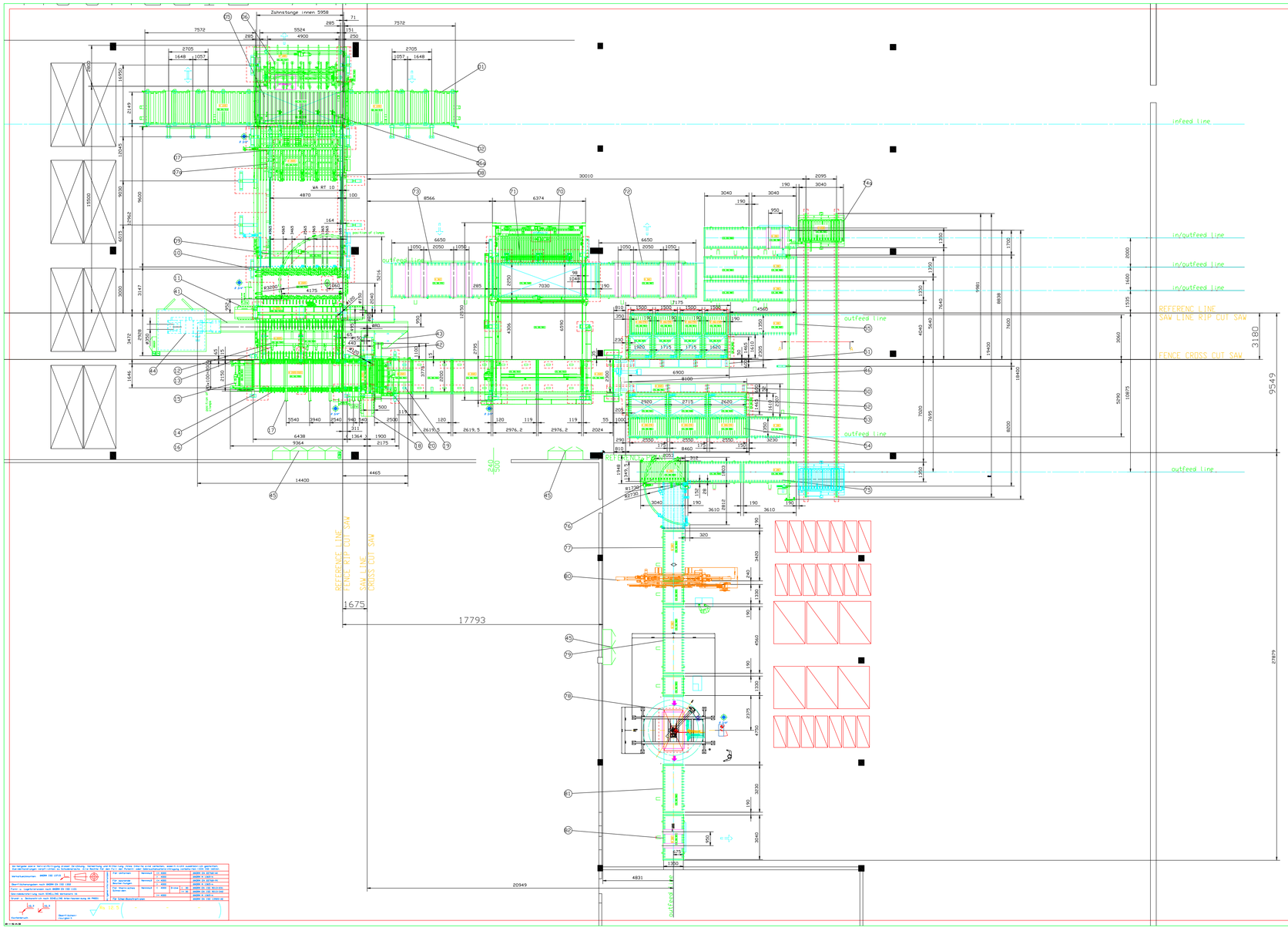
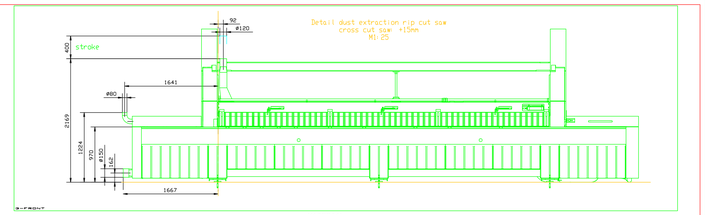
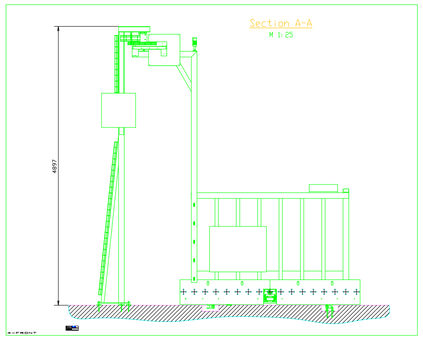






01 infeed roller track
02 positioning dogs
03 -
04 -
05 lift table with roller track
06 vakuum infeed
06a push off carriage
07 aligning table
07a roller table, moveable
08 book aligners
09 feeder with clamps
10 turn table
11 saw machine fh 6 580
12 pull out device
13 transfer table
14 feeder travel guides
15 feeder for cross cut saw
16 angular transfer table
17 strip aligners
18 cross cut saw fh 6 230
19 roller table with waste flap
20 outfeed pusher

41 vibrating conveyor
42 waste conveyor belt
43 waste chute
44 hogger
45 control cabinet
46 control desk
47 -

50 air floatation table
51 air floatation table
52 lift table
53 manual stacking device
54 angular transfer
55 outfeed roller track

70 fork stacking device
71 scissor lift with roller track
72 outfeed roller track for stacks
73 roller track for protection boards
74 -
74a discharge carriage

75 roller track for stacks
76 roller track for stacks, rotating
77 roller track for stacks
supplied by customer--> 78 wrapping device
79 roller track for stacks
supplied by customer--> 80 lateral strapping system
81 roller track for stacks
82 outfeed roller track for stacks

MATERIAL

Laminated HDF, laminated particle board, laminated plywood

Length:	1860 mm - 5650 mm	Width:	1200 mm - 2200 mm
Thickness:	2 mm - 60 mm	Thickness tolerance:	-0.2 mm - +0.2 mm
Board edges:	trimmed	Specials:	x
Stack height:	2 mm - 700 mm	vertical deviation:	-30 mm - + 30 mm
Infeed height:	1200 mm	Output height:	280 mm
format size min.:	300 mm x 100 mm	stacking height max.:	x mm - 1000 mm
format size out.:	300 mm x 200 mm	stacking height out.:	x mm - 1500 mm

MACHINE SUPPORTING AREA

The thickness of the concrete has to be at all defined areas (including cut outs for tracks and pits for scissor lift, etc.) at least 200 mm.
Quality of concrete: C20/25 reinforced (according to DIN EN 206-1) (suitable for straddling dowels)

GROUT

Quality cathegory: A SKVB 1 (according DafStb-guide line)
Expansion: swelling >0,5% shrinkage: <0,5 mm/m at 20°C/65% relative humidity

FOUNDATIONS

Saw area: 1035 mm
Stacking area: 1035 mm
Tolerances of new foundations: height +/- 5 mm; position +/- 10 mm.

REFERENCE POINT

EL. MAIN ENTRY SAW
ap. x kVA / x V / x Hz / 3 Ph

EL. MAIN ENTRY x
ap. x kVA / x V / x Hz / 3 Ph

COMPRESSED AIR REQUIREMENT
ap. 3200 l/min at 1 bar pressure (without strapping and wrapping machine)
Working pressure : 6 bar excess pressure

SERVICE UNIT
R 3/4" (supply R 1 1/2")
Height of service unit appr. 1600 mm

SBV CHANGE OF SAW BLADE

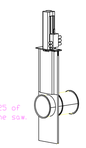
DUST EXTRACTION

Pressure beam/Hold down beam	2x ø120 = 2600 m3/h
Chip conduit	2x ø150 = 4070 m3/h
Fence	2x ø 80 = 1160 m3/h
Hogger	1x ø350 = 11000 m3/h
Dust extraction total at 32 m/s air speed Under pressure 2000 Pascal at the saw	18830 m3/h

PERFORMANCE OF CUSTOMER

Providance of pits for scissor lifts and cable conduits, connections for electric power, compressed air and dust extraction and required pedestals, stairways and handrailing at the machine.
In the suction pipe for the suction connection piece a 120/125 of the pressure beam a pneumatic flap must be installed above the saw.

This flap has to be reversible in two positions:
first position - suction is open
second position - suction is open between 0 and 50%
The controlling is made by Schelling.
Dust extraction diameter 120/125 and 80/100
Connection with flexible pipe or cleaning-flap in the bend.
All suction connections have to be removed easily.
In the loading and unloading area of the fork lift truck close to the plant a colliding protection has to be provided by the customer!



The positioning of the accesses (gangways, platforms, staircases and doors to protected zones), the separating protection devices and control stands (schematically represented in the drawing) was effected by the manufacturer without consideration of the local conditions such as walls, columns, pits, ducts, supply lines etc. Location and position of the accesses result from reasons of the running operation, service and maintenance and not from the necessity of escape and emergency routes. These routes have to be specified and / or checked by local organisations. Any variation must be clarified with regard to conformity. If accesses (gangways, platforms, staircases, doors to protected zones), the separating protection devices and control stands are neither supplied nor installed by the machine manufacturer, then the performing company is responsible for keeping the national regulations, harmonized standards, safety distances and dimensioning etc.

For further informations please look at the acknowledgement of order!

All dimensions in mm !

Standard heights of safe guards

protection grid	180 - 2000 mm
safety light barrier (dual beam)	400 / 900 mm
safety light barrier (grid) over floor and/or working height	300 - 1750 mm

IMPORTANT!

We kindly ask you to check this drawing carefully. If we do not receive any written comment within 3 weeks from the date of drawing dispatch, we will consider this drawing as accepted.

Schelling Anlagenbau GmbH
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z.H. Verkauf
Gebhard-Schwärzlerstrasse 34
6858 SCHWARZACH
AUSTRIA

151.320	SUS	Cleaf
361.063	ah6	Cleaf

Disegnatore: FerWood s.p.a.
Titolo:
Descrizione: Machine Assembly Drawing
Data:
Sistema:
1:75

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