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## **SPECIFICATIONS**

### **VOORWOOD MODEL L217N DOUBLE SIDED EDGE FOILER**

The Voorwood Series L217 Shaper Foiler profiles, sands, and applies transfer-finishing foil to both edges of your MDF parts in one pass. The L217 is capable of producing over 27,000 lineal feet (8200M) of finished product per shift. Production rates may vary with part size and operational conditions. Stock is transported through the machine by a bottom feed chain with special pads that grip the stock securely while it passes the workstations. With digital readouts and MicroPoint tilt at the workstations and digital readout on the eversquare infeed guide, this machine is designed for easy set-up and repeatable tool change between profiles. Easy operating doors cover the machining stations and provide safety, sound deadening and contemporary styling.

#### **MAIN FRAME:**

The welded box frame construction provides a rigid structure insuring accurate and repeatable tool positioning. Base weldment is pre-drilled for permanent machine installation.

#### **TRANSPORTER ASSEMBLY:**

When facing the infeed end of the machine, the right side is fixed and the left side is adjustable for width from the control panel. The transporter assembly incorporates an infeed support area that is equipped with an ever square infeed guide with digital readout, adjustable feed speed drive motor and bottom feed chain. When requested, the bottom feed chain with pop-up lugs on 4", 8", or 12" centers may be used. Substrate is positioned on infeed plate against the edge guide; when drive motors are activated, bottom feed chains transport the substrate past the scoring, grooving, shaping, sanding and foiling stations. Bottom feed chains are topped with non-marking polymer pads. An electronically controlled oil pump automatically lubricates transporter chain race assembly and drive motor rpm is electronically synchronized.

#### **ROLLER HOLDDOWN ASSEMBLY:**

The steel plate holddown beam is equipped with a safety switch at the infeed area, anti-intrusion hood and non-marking polymer rollers. Polymer rollers hold the substrate against the bottom pads while the workpiece is transported past the shaping, sanding and foiling stations. Infeed limit switch deactivates drive motor if substrate is misfed. Digital readout on vertical adjustment handwheel adjusts for substrate thickness.

#### **SCORING STATION(G):**

Top and bottom score saw on each side with high speed arbors and climb cut rotation to cleanly cut through papers, veneers, etc. Accurate digital readouts on in/out and up/down adjustments facilitate easy tool change and repeatable settings.

**GROOVING STATION (D) (TOP AND BOTTOM):**

Grooving stations are equipped with precision balanced drive motors and spindles. The grooving operation is performed on the top and bottom surface of the substrate on the fixed side of the machine. The spindles rotate with the direction of feed. The spindles are equipped with double washers and have horizontal and vertical positioning adjustments. Each station is equipped with dust hood/safety guard.

**SHAPING STATION (S):**

The shaping station rotates against the feed direction on each side of the machine. The spindle is equipped with double collets and has angular, horizontal and vertical adjustments with accurate and repeatable digital readouts as well as spindle locks to facilitate fast and repeatable tool changes. Each station is equipped with dust hood/safety guard.

**SANDING STATION (2 EA. A6):**

Two counter rotating sanding stations are equipped with precision-balanced motor and spindle. The spindle is equipped with double collets and has angular, horizontal and vertical adjustments with accurate and repeatable digital readouts and is equipped with dust hood/safety guard.

**FOILING STATION (F):**

Two foiling stations on each side are equipped with 8 inch diameter foil wheel, non-contact sensor and oven for automatic temperature control. Wheel adjustment positions are by digital readouts and MicroPoint tilt for easy tool changes. The foil unwinds have a large capacity with accurate tracking and constant tension adjustments. The adjustable torque rewind is conveniently located for removal of used foil.

**DUAL POST CLEANER (P):**

Top and bottom post cleaners on each side of the machine contain a rotary brush which rotates against the workflow, cleanly removing foil feathering and lightly smoothing the top/bottom foil trim line. Unit adjusts in/out and up/down and has a vacuum pick-up.

**CONTROL AND COMPONENT PANELS:**

Two lighted touch screen controls, one on each side are located on swing arms for operator convenience. Emergency stop push-button controls are located at the infeed, midwall, and outfeed areas left and right side. The function and logic of the machine is controlled by a “PLC”. Control and component panels conform to ANSI/NFPA 70, NFPA 79 electrical standards, and European Community standards. Machine is pre-wired for installation in customer’s factory.

**DUST COLLECTION:**

Each shaping and sanding station is equipped with a dust hood and hose. Ports located at the top of the machine are provided for connection to customer’s dust collection system.

The L217 is a production-oriented machine designed for reliability and operator convenience. It is furnished ready for hookup with safety enclosure.

**TRANSPORTER:**

Motor:	2 hp per side, 4 hp total	
Feed Speed:	10 - 50 fpm	3 - 15.2 mpm
Feed Height:	41 inches	1040mm

**SUBSTRATE SIZE:**

Minimum Size:		
(Double Sided)	3 inches x 3 inches plus pattern face width*	76mm x 76mm plus pattern face width
Maximum Size:	84 inches x 84 inches	2134mm x 2134mm (7' machine)

\*Some exceptions may apply

**SCORING STATIONS:**

Saw Diameter:	4-1/2 inch (114mm) saw blade required
Vertical Adjustment:	
Top Score:	2 1/4 inches (57mm)
Horizontal Adjustment:	
Top Score:	3 inch (76.2mm)
Motor:	1.75 hp motor (1.3 kW)
Spindle Speed:	3200 rpm

**GROOVING STATIONS:**

Spindle Diameter:	1" (25.4mm)
Spindle Adjustments:	
Horizontal:	3" (76.2mm)
Vertical:	3" (76mm)
Motor:	1.75hp at 3600 rpm (1.3 kW)
Blade Diameter:	5.5" (140mm)
Blade Kerf:	.157" (4mm) wide x 3/8" (9.5mm) max depth

**SHAPING STATIONS:**

Spindle Diameter:	1-1/4 inches	31.75mm
Spindle Length:	2-7/8 inches	73mm
Spindle Adjustments:		
Tilt:	0-30 degrees	
Horizontal:	6 inches	152mm
Vertical:	3 inches	76mm
Motor:	7 1/2 hp at 6000 rpm	
Cutting Head Capacity:		
Maximum Diameter:	6 inches	152mm

**SANDING STATIONS:**

Spindle Diameter:	.984 inches	25mm
Spindle Length:	3 inches	76mm
Spindle Adjustments -		
Tilt:	0-30 degrees	
Horizontal:	6 inches	152mm
Vertical:	3 inches	76mm
Motor:	.75 hp at 1725 rpm	.56 kW

**FOILING FOR EACH SIDE:**

- (1) **Supply Roll:**
  - (a) Maximum diameter: 12-3/4 inches (324mm) (approximately)
  - (b) Maximum width: 2 inch (50.8mm)
  - (c) Core diameter: 1 and 3 inches ID (25.4mm and 76mm)
- (2) **Applicator Stations:**
  - (a) Furnished with two foiling stations for domestic or metric foil wheel.
  - (b) Up to 50 fpm (15.2 mpm)- some exceptions may apply
  - (c) One shaped applicator wheel per spindle required, not included.
  - (d) Station adjustments: 5-1/2 inches (140mm) in and out  
2-1/4 inches (57mm) laterally across face  
-10 to +52 degree angle from horizontal.
- (3) **Film Takeup:**  
Carrier film rewinds with automatic tension control. Stripper rollers for precision  
Trimming on mitres and edges follow the edge of the part for precision foil trimming.

**TOP AND BOTTOM POST CLEANER:**

Brush Diameter: 2.5" (64mm)  
 Brush Rotation: 1750 rpm  
 Motor .12 hp (.18kW)  
 In/out Adjustment: 2" (76mm)  
 Up/down Adjustment 2" (25.4mm)

**SERVICES REQUIRED:**

ELECTRICAL: 220/240 volts, 3 phase, 50/60 hz, 240 amps  
 or  
 440/480 volts, 3 phase, 50/60 hz, 120 amps  
 All voltages +10% -6%, all hertz +1% -1%

The customer is responsible for installing proper equipment grounding, in accordance with Part 6 and Part 7 of Article 250 in NFPA 70 Electrical Code before applying power to the machine. If a grounding electrode is necessary, it must be sized in accordance with Article 250.122 and conductor sized in accordance with Article 250.66, or in accordance with UL508A, Chapter 8.2.2.3.

**DUST COLLECTION:**

Ports (Ø5", Ø4", Ø5" with Ø2") outlets require exhaust air:  
 Velocity: 4000 fpm 1220 mpm  
 Total Air Volume: 3200 cfm 1500 lps

COMPRESSED AIR: 80 PSIG @ 3 CFM (5.4 BAR @ .085 CMM)

**SPACE REQUIREMENTS:**

158 inches long, 82 inches high, 164 inches wide  
 4.0m x 2.1m x 4.2m

**SHIPPING DIMENSIONS:**

175 inches long, 89 inches high, 60 inches wide  
 4.4m x 2.26m x 1.52m

**APPROXIMATE NET WEIGHT:**

7205 lbs. 3274 kg

**APPROXIMATE SHIPPING WEIGHT:**

8205 lbs. 3725 kg