

HOMAG Edge-banding Machine EDGETEQ S-500

EDGETEQ S-500 Profi KAL375115N25

HOMAG SINGLE-SIDED EDGE BANDING MACHINE

Single-sided edge banding machine for processing straight workpiece edges and for gluing and post-processing different edging materials in longitudinal and cross through-feed.

BASIC MACHINE:

continuous machine frame for mounting the processing units noise protection for jointing part and unit part with individual suction

working height	950 mm
pneumatic connection	6 bar
machine length	8865 mm
total length	8865 mm
total connected load	27.19 kW
nominal current machine	36.07 A
nominal current backup fuse	50 A
consumption of compressed air	1010 NL/min
suction output	6490 m'

Floor conditions must correspond to the layout and suction plan

WORKPIECE PARAMETERS:

min. workpiece dimensions standard parts: (first measure in feed direction)

in case of workpiece thickness

8 - 60 mm:

longitudinal processing	240 x 120 mm
cross wise processing	120 x 240 mm

min. workpiece dimensions narrow parts: in case of workpiece thickness

8 - 22 mm:

- longitudinal : 300 x 60 mm

processing :

in case of workpiece thickness

23 - 60 mm:

longitudinal : 240 x 100 mm processing :

all minimum dimensions apply to workpiece

Overhang 30 mm plus edge thickness

Workpiece overhang : 30 mm

Workpiece thickness: 8 - 60 mm

For workpiece dimensions smaller 240x240 mm a feed aid is required due to safety reasons

The machine operator is responsible for the use of suitable materials (boards, glues, edging materials, cleaning means, lacquers etc.)

When processing workpieces or edge materials without protective lacquer or

- matt surfaces or
- high-gloss surfaces

bright streaks might occur.

By tests/reference samples at the manufacturer such materials are to be checked and confirmed in advance

Manual feeding of workpieces with

hinge hole drillings

through-drillings crosswise grooving

cut-outs in the workpiece

on the top side with at least 8 mm diameter or groove width and which lay in the clamping zone of the top pressure must not be fed to the machine due to safety reasons, this requirement is only possible by the separate option "safety package for construction elements"

ELECTRIC EQUIPMENT:

- Operating voltage 480 volt, 60 Hz
- switch cabinet installed at the machine installation accord. to European Norm EN 60204
- control of a suction of the customer by 2
- relay contacts:
 - contact 1 to switch on the suction as soon as the feed runs
 - contact 2 to open the suction flaps as soon as the machine is occupied
- Two further terminals for feedback of the suction to release production
- The machines are not suitable for connection to a RCD due to operational leakage currents. Instead the recommendation is to route the supply in such a way as to prevent ground faults or short circuits (e.g. in accordance with DIN VDE 0100-520/521.11)
- prescribed environmental temperature: + 10 degrees up to + 40° C
(For ambient temperature >40°C only with the option "increase of the cooling power")

SAFETY AND PROTECTION FACILITIES:

- EC conformity (CE) according to the currently valid Machinery Directive for individual machines in operation according to the Machinery Directive an additional EC conformity certificate for linked machine operation (cells/plants) is required in the defined countries.
- Wood dust protection max, 2 mg/m³) subject to the required extraction capacity being provided by the customer according to the suction plan.

- Condition for our warranty/product liability is the unrestricted observance of the original production instructions delivered along with the machine including the safety instructions.
- Surface sound pressure level:
The surface sound pressure level LA is equal or less than 90 dB(A), taking as a base the condition defined in DIN EN ISO 18217:2015
- part 12: edge banding machines
- The noise level of 85 dB(A) which is max. allowed at the working place, can only be achieved in most cases by means of a complete protection

HOMAG QUALITY KIT:

- TOV certificate accord. to DIN EN ISO 9001: 2015
- energy-efficient drives accord. to the EU no. 640/2009
- energy saving functions:
ECO Plus button for start of the stand-by mode, which can be activated during the production. After running empty or when the machine is empty it provokes the following:
the drives stop running public supply infrastructure is switched off
- When the machine is not producing, the control voltage is disconnected by means of preset time the function can be switched on and off modern, decentralized control system for the illumination of the machine compartment, modern energy-saving LED luminaries are used.
- In order to save energy the pneumatic cylinders and the blowing nozzles use 2 different pneumatic supplies

STANDARD MACHINE LABEL

FEED STEPLESSLY ADJUSTABLE 16-25 M/MIN

feed frequency-controlled

- adjustment of speed at the input unit

FIXED STOP SIDE ON THE LEFT

WORKPIECE THICKNESS 8 - 60 MM

- Preparation of the basic machine for workpiece thickness 8 - 60 mm
- Snipping front edge/rear edge: PK25/SK25/PK30/SK30

<u>Edge thick.</u>	<u>I chamfer</u>	<u>Workpiece thick.</u>
0J3-1 mm	chamfer straight:	8-60 mm
1-2 mm	straight/overhang	8-60 mm
Edge overhang top/bottom		max. 2 mm

Fine trimming on top and bottom: PF20/21, MF20/21

Edge thickn.) Profile workpiece thickn.

1 mm	"	R1	8-60 mm
2 mm	'	R2	8-60 mm
0,3-0,6 mm		chamfer 15°]	8-60 mm
0-2 mm		chamfer 45°:	8-60 mm

PF20/21: only in connection with double roller tracing
double roller tracing for MF20/21 included as standard

Fine trimming on top and bottom: BF40/MS40

- Continuous trimming workpiece thickness
8 - 60 mm

Edge thickn.:	Profile	workpiece thickn.
1 mm	R1	12 mm
2 mm	R2	12 mm
0,3-0,6 mm	chamfer 15°	8 mm
0-2 mm	chamfer 45°	12 mm

Profile trimming unit MF60

- Continuous trimming workpiece thickness
8 - 60 mm
- Profile trimming workpiece thickness > 12 mm depending on the material the tracing forces may have to be adjusted otherwise the quality might be reduced.

Edge thick.:	Profile	Workpiece thick.
2 mm	R2	12 mm
1 mm	R1	12 mm

0,3-0,6 mm : chamfer 15° 8 mm
0,3-2 mm : chamfer 45° 12 mm

Profile trimming unit FK11

- Continuous trimming workpiece thickness
8 - 60 mm
- Profile trimming workpiece thickness > 12 mm depending on the material quality might be reduced.

Edge thick.	Profile	Workpiece thick.
2 mm	R2	8-60mm
1 mm	R1	8-60mm
0,3-0,6 mm	chamfer 15°	8-60mm
0,3-2 mm	chamfer 45°	8-60mm

Scraper: PN10

Edge thick.	Profile	Workpiece thick.
2 mm	R2	10-60mm
1 mm	R1	8-60mm

Scraper: PN20

KD	Profile	WD
2mm	R2	12-60mm
1mm	R1	8-60 mm
0,3-0,6 mm :	chamfer 15°	8-60mm

Scraper: MN21

edge thickn.:	Profile	Workpiece thickn.
2 mm	R2	10-60 mm
1 mm	R1	8-60 mm

Only in connection with horizontal double roller tracing or tracing pad and lubricant depending on the material characteristics a loss of quality might occur.

PANEL OVERHANG FIX

- set to 30 mm at the factory

WORKING HEIGHT

- 950 mm

PAINTING

Lacquering of the machine and safety fence posts in RAL 9003 signal white design strips, safety fence fields, safety doors and stela in RAL 7021 dark grey

FEED INTERLOCKING

- with interlocking plan and connecting cable

INSERTION/FEEDING SYSTEM FOR SMALL PARTS

For the feeding of small parts in longitudinal and crosswise direction into the machine minimum workpiece thickness 16 mm

ALIGNMENT OF THE WORKPIECE AT THE INFEED

Infeed fence

infeed fence manually adjustable length before infeed interlocking: 600 mm

PANEL SUPPORT WITH ROLLER GUIDE

Movable by 1200 mm on permanently mounted floor supports working width 1500 mm

Panel support with roller guide

- 2 x panel support

INFEED INTERLOCKING

- Infeed interlocking pneumatically controlled

WORKPIECE TRANSPORT DEVICE

Workpiece transport device:

- transport chain with rubber coating, 80 mm wide
- hardened precision running and guiding surfaces
- magnetically braked transport chain

Automatic chain track lubrication store tank for oil

- oil level control
- lube pressure monitoring

TOP PRESSURE

- compound V-belt
- electronic height adjustment
- height adjustment of the post-processing units with the top pressure
- mechanical digital position read-out

Small parts kit

Continuously close roller lever distance 50 mm instead of 80 mm on the top pressure
minimum panel length 120 mm

APPLY FLUID AND PROCESS FORMAT

FORMAT PACKAGE

SEPARATING AGENT SPRAYING UNIT

- for reducing the surface contamination by glue residue stuck
- application of separating agent before the panel sizing part
- Separating agent must be provided by the customer

Start-up equipment:

- Top/bottom: empty container Riepe LPZ/II more detailed information about suitable separating agents has to be taken from the operating instructions "separating agent spraying"

Nozzle position on top, below

- fluid application by 2 spraying nozzles from top and below overhang fix

JOINTING TRIMMING UNIT 52 - BASIC

For jointing trimming the workpiece narrow surface before gluing.

Maximum feed speed

- For minimal panel length 120 mm 30 m/min
 - For minimal panel length 240 mm 40 m/min
 - max, resharpening zone 4 mm
- (regarding tool radius in case of workpiece overhang 30-60 mm)
panel blow-off device

Motor performance 3 kW, 150 mm²

Height jointing processing 60 mm

designed for workpiece thickness max. 60 mm, depends on the workpiece

Tool interface, key way

- motor shaft diameter 30 x 68 mm, key way

Electropneumatic intermittent control

Electropneumatic control of both motors for intermittent trimming

Horizontal adjustment device manually for 52 for manual adjustment in case of modification of the tool diameter for manual adjustment of the panel overhang in the range of 30-80 mm

Note:

for tool diameter 150 mm the workpiece over- hang adjustment is only possible in the range from 30 - 60 mm!

Adjustment device manual vertical for 52 manual vertical adjustment for better utilization of the tool's blade and to align the jointing cutters to the centre of the work- piece,

Tool diameter 125 mm

SET OF DIAM. JOINTING CUTTERS WD40

- 2 "I" diamond jointing cutters 125x43x30 mm
- double key way, d=3x3
- asymmetric execution
- cutter with reversible carbide tip technology high processing quality due to low soiling of the workpieces
- for the processing of already applied edges which are damaged special tools are recommended
- the capturing of chips is reduced for the processing of already applied edges which are damaged

EDGE-BANDING

PANEL PRE-HEATING UP TO 60 MM PANEL THICKNESS

- For heating of workpiece edge before glue application
- For improvement of the gluing quality

GLUING UNIT

Glue type unit EVA EVA pre-melting unit

- incl. suction hood
- melting unit with granular container Basic granular container ca. 6 liter
- level control of the application quantity
- temperature control electronically automatic decrease in glue temperature when interrupting the work (time is freely selectable)
- melting capacity 6 - 12 kg/h, depending on the glue(see technical data sheet)

Position surveillance melting unit

GLUE APPLICATION SYSTEM

- Mounting fixture for application unit QA/PU quick clamping system for quick change of the application unit
e.g. when using several application units for different glue colours
- drive application roller in case of feed stop glue container lift-off in case of feed stop glue container clamping workpiece-actuated
- Manual glue amount dosing

- reproducible dosing of the application quantity via vernier

APPLICATION UNIT

- Execution QA65P
- 2 glue levels
- low glue level selectable for shorter heating time
- glue roller diameter 34 mm heated application roller
- application unit is filled automatically or manually
- application unit for Hot melt: EVA, polyolefin, PUR
- pre-heating station XES 200 is recommended

Application roller with groove for the removal of chips

- for improved cleaning, especially for particularly porous chipboards or chipboards with a loose middle layer
- Dosing bar pneumatic for application roller for cleaning the application roller in case of particle adhesion by briefly opening and closing of the dosing bar
- interval setting via program or manually automatic closing of the dosing bars in case of power failure in order to prevent running out of the glue

APPLICATION UNIT

Execution QA65P

- 2 glue levels
- low glue level selectable for shorter heating time
- glue roller diameter 34 mm
- heated application roller
- application unit is filled automatically or manually
- application unit for Hot melt: EVA, polyolefin, PUR
- pre-heating station XES 200 is recommended

Application roller with groove for the removal of chips

- For improved cleaning, especially for particularly porous chipboards or chipboards with a loose middle layer
- Dosing bar pneumatic for application roller for cleaning the application roller in case of particle adhesion by briefly opening and closing of the dosing bar
- interval setting via program or manually automatic closing of the dosing bars in case of power failure in order to prevent running out of the glue

EDGE MAGAZINE

- material on coils
- for processing material on coils up to max. 3 mm
 - feed up to 40 m/min for edge thickness up to 0,8 mm
 - feed up to 30 m/min for edge thickness up to 3 mm
 - reduced feed for veneer (depending on material)
- processing max.

with PVC	"	135 mm ²
with veneer	I	100 mm ²

- for veneer max. edge thickness s 1,5 mm, pay attention to wood moisture being min. 8 - 12% optional processing of veneer edges with edge thickness >1,5 mm possible via edge channel 1 by means of roll plate horizontal separate (ref. no. 2448)
- clipping unit
- edging material control with feed stop
- Automatic edging material change
- 6 edging material feeding devices

SERVO-CONTROLLED EDGE FEEDING FOR AI - A20

- edge feeding of the material on rolls by means of servo drive
- max. edge overhang at front and rear edge when processing material on coils: +/-3 mm in case of feed up to 50 m/min and a maximal
- coil weight of 15 kg
- in case of surface overhang the accuracy cannot be guaranteed
- in case of feed > 40 m/min and high coil weights a driven roll carriage is recommended precision in terms of position cannot be granted when processing veneer roll material in connection with laserTec panel overhang front edge 10 mm/ rear edge 20 mm

EDGE HOLDING-DOWN DEVICE STEPLESS

- for automatic adjustment in case of different edge heights
- magazine height adjustment manually
- magazine height adjustment via spindle
- 0 to -5 mm

6 COIL SEATS

- remnant edge length control

PRESSURE ZONE

- pressure zone A 5 rollers
 - 1 driven pre-pressure roller, diameter 90 mm
 - 4 post-pressure rollers, diam. 70 mm pneumatic pressure adjustment
- Automatic adjustment pressure zone 5-500
- for automatic adjustment of the pressure zone in case of varying edge thicknesses.

POST-PROCESS WORKPIECE

FUTURE PACKAGE 6

COOLING/LUBRICANT SPRAYING UNIT

- application of coolant/lubricant by spraying nozzles before post-processing for cooling of the glue joint and for static discharge of the edging strip from top and bottom as well as for lubricating effect of units with tracing pad on the covering layer and narrow surface
- for panels with protection foil or edges sensitive to scratches

Without coolant/lubricant, the customer has to provide for it
basic equipment:

- top/bottom: empty container anti-static

Cooling agent Riepe LP289/99

- lateral: empty container separating agent

NFLY

- more detailed information about suitable separating agents has to be taken from the operating instructions "separating agent spraying"

HOMAG expressly points out that, according to the current legal position, on machines that use separating agents after the edge banding process and before further postprocessing) such as routing, where this separating agent is used to cool the edging strip and glue joint and/or has an antistatic effect on the edging strip, the routing chips created during postprocessing, and the glue joint, in the Republic of Germany, only separating agents provided by Riepe GmbH & Co. KG may be used on machines that use separating agents after the edge banding process and before further postprocessing) such as routing, where this separating agent is used to cool the edging strip and glue joint and/or has an antistatic effect on the edging strip, the routing chips created during postprocessing, and the glue joint, outside the Republic of Germany, separating agents provided by any manufacture may be used, if the workpieces manufactured on machines that use separating agents after the edge banding process and before further postprocessing, such as routing, where this separating agent is used to cool the edging strip and glue joint and/or has an antistatic effect on the edging strip, the routing chips created during postprocessing, and the glue joint, are offered in the Republic of Germany and delivered in the Republic of Germany, only separating agents provided by Riepe GmbH & Co. KG may be used

Nozzle position on top, below

- fluid application by 2 spraying nozzles from top and below

- Overhang fix

SNIPPING UNIT PK2S

- Overhang fix
- upright snipping stop
- manual adjustment chamfer snipping stop adjustment of the chamfer snipping stop to different edge thicknesses manually
- flush snipping/ overhang snipping
for adjustment of the snipping motors to 2 positions
position 1: flush snipping
position 2: snipping with overhang - for post-trimming with profile trimming unit

ROUGH TRIMMING UNIT BF10

For rough trimming of the edge overhangs on the workpiece upper edge and on the workpiece lower edge

- incl. electronic frequency converter

Motor capacity 0,55 kW

- 2 motors one above the other, each 0,55 kW, 200 Hz, 12000 rpm working in opposite movement
- edge thickness max. 6 mm
- workpiece thickness 7 - 60 mm
- swivelling range +/- 1 degree
- Edge overhang top/bottom max. 18 mm
(The extraction hood may need to be recessed depending on the edge overhang - Two levels possible (8 mm or 18 mm). Prefabricated perforation available for breaking out the recess. Recessed extraction hoods can have an adverse effect on chip collection)

PNEUMATIC ADJUSTMENT OF ROUGH TRIMMING UNIT BF10+20

on 2 positions

- position 1 rough trimming with projecting edge (approx. 0,2 mm)
- position 2 flush trimming without projecting edge separately controlled

Adjustment workpiece thickness with top pressure

SET OF I-TCT CUTTERS STRAIGHT

- 2 I-TCT cutters 70x25 mm, t=4, HSK 25 R with integrated chip collecting system high collecting degree of chips up to 95 %
- reduction of the suction capacity by approx. 50%
- high processing quality due to low dirtying of the workpieces

PROFILE TRIMMING UNIT FF32 TOP/BOTTOM WD60

- For crosswise processing of postforming or soft-forming parts and for rounding plastic edges at panel front and rear edge on top and bottom.
- prepared for mounting the processing motors incl. electronic frequency converter with motor braking function and extension of noise protection
- electropneumatic movement out of the working area, e.g. solid wood edges incl. control for continuous trimming, automatic
- per profile and per edging material (wood or plastic edge PP)) a separate changing device is required (synchronous movement/opposite movement)
- when changing from wooden edge to PP plastic edge a separate changing device is only necessary for the front edge
- edge thickness max. 3 mm
- panel thickness 8- 60 mm
- panel length min. 120 mm
 - single-sided min. 120mm
 - double-sided min. 80mm
- the performance indications refer to a panel thickness, max. 38mm
- when thicker panels are processed the performance reduces:
 - feed soft-forming max. 25 m/min
 - feed f. max. 20 m/min

Panel gap min. 500 mm

AUTOM. CHANGING DEVICE FF32/FF42

- For radius and chamfer trimming with combination tool
- 4 motors, each 0,4 kW, 200 Hz, 12000 rpm autom. adjustment of the lateral tracing to different edge thicknesses (0,3 - 3 mm) chamfer and radius adjustment automatic max. edge thickness for chamfer with radius cutter:
 - in case of R 1,5 0,6 mm
 - in case of R 2,0 0,8 mm
 - in case of R 3,0 1 mm
- chamfering angle approx. 15 degrees tool chuck HSK25 without tools
- sliding lateral tracing

SET OF I-DIA RADIUS CUTTERS

- 4 I-diamond radius cutters, basic diameter 70 mm, HSK 25 R, t=4 with integrated chip collecting system
- radius 1.0 mm
- chamfer 15° at the outlet angle of the radius
- high collecting degree of chips up to 95 % high processing quality due to low dirtying of the workpieces

RESIDUAL SPACE

- 100 mm

PROFILE SCRAPER PN10

- tracing from top, bottom and lateral
- for chamfering or rounding-off pre-trimmed PVC-edges
- pneumatic adjustment for lateral moving away out of the working area
- blowing nozzles pneumatically controlled edge thickness max. 3 mm
- suction box for PVC chips
- feed max. 25 m/min

Note: Blunt-angled workpieces can be processed with a front-side edge overhang of 2 mm

- Adjustment workpiece thickness with top pressure

Chopping device top/bottom

- for PVC chip removal

SET OF QUICK CHANGE HEADS FOR PN10

- 2 quick change heads for simple radius change

SET OF PROFILE KNIVES FOR PN10/PN20

- 2 profile knives with reversible carbide tip
 - radius 1.0 mm

DETERGENT SPRAYING UNIT

- spraying unit for application of detergent onto the panel upper and lower side

- application of the detergent in front of the cleaning buffer
 - without detergent, customer has to supply for that
- basic equipment:
- top/bottom: empty container for Riepe detergent LP163/93
 - more detailed information about suitable separating agents has to be taken from the operating instructions "separating agent spraying"
 - Nozzle position on top) below fluid application by 2 spraying nozzles from top and below

Overhang fix

GLUE JOINT SCRAPER FA20 BASIC

- for removal of glue rests
- mounted on chain track and top pressure height adjustment with top pressure hard metal knife) 4-fold reversible carbide tip
- fine tracing with minimum tracing force
- for a constant quality for different surfaces
- pneumatic adjustment for vertical moving out of the working zone
- Adjustment workpiece thickness with top pressure
- Adjustment tracing/tool manually

EDGE BUFFING UNIT FP10 TOP+ BOTTOM

- for cleaning the edges
- 2 motors each 0,18 kW
- height adjustable
- height adjustment with the top pressure
- 2 molleto disks, diam. 150 x 20 mm

STANDARD TRIMMING UNIT SF21

- For grooving and rebating from top/bottom/ lateral (without edge) in synchronous movement.
- installed at the front side of the trimming column
- cross support with spindle adjustment possibility to change the direction of rotation
- tool diameter: 180 - 200 mm
- when grooving from bottom : 180 mm
- suction hood for processing from top/bottom/ lateral (without edge) in synchronous movement on back side of column
- light barrier for safety monitoring of the tool position
- application control electro-pneumatically controlled
- operating stroke max. 20 mm for max. 15 mm grooving depth
- hogging cross section max. 150 mm² for feeding speed 20 m/min
- electronic frequency transformer without tools

Motor capacity 5 kW

- 1 motor 5,0 kW, 100 Hz, 6000 1/min

motor shaft diam. 35x70 mm, key way

Position of groove

- minimum distance 5 mm to the chain track resp. to the top pressure

adjustment vertical manually

- via spindle and counter device

adjustment horizontal manually

- via spindle and counter device

swivelling range fixly adjustable

- from -3° up to 90° (or 3° up to -90°)

Tolerance indications intermittent control application depth+/- 0,5 mm with turning in application point+/- 5 mm with feed speed 20 m/min

ENERGY AND SUPPLY

UNINTERRUPTIBLE POWER SUPPLY (UPS)

- In the event of a power failure, the electronic control unit still supplies power from the built-in batteries for approx. 10 minutes
- All values and statuses are saved You have to restart the PC
- The UPS also acts as a voltage stabilizer for the electronics, because it also responds in the event of under- or over-voltage

RAISING THE COOLING CAPACITY

- increasing the cooling capacity at an environmental temperature between 40°(and 45 °C

ELECTRICAL INSTALLATION

- Transformer for voltage adaption EDGETEQ 5-500 line voltage 200 - 600 Volt
- installed in the switch cabinet
- in the machine the voltage is always transformed into 400 V

Neutral not chargeable

- creation of a neutral conductor for single- phase and unsymmetrical three-phase consumers
- e.g. machine lightening, heating, sockets, usv, computers etc.

INSTALLATION ACCORDING TO UL SPECIFICATIONS

- switch cabinet executed according to UL specifications

POWERCONTROL PC23 POWERTOUCH

Modern control system based on Windows-PC

Hardware:

- PLC control accord. to International Standard IEC 61131
- integrated line control for contactless control of the processing units
- modern industrial PC with operating system Windows 10
- USB connection
- digital field bus system for inputs/outputs and decentralized units
- antivirus software

Software:

- equal HOMAG user interface powerTouch ergonomic touch operation with gestures such as zooming, scrolling and swiping
- easy navigation for equal and intuitive operation of the machine
- intelligent display of readiness of production by light function
- operator guiding system (BDL) for indicating necessary manual adjustments at the machine in case of resets

The control of the machine is not suitable to process personal data within the meaning of EU-DSGVO.

- Keyboard support with keyboard and mouse stable support for keyboard and mouse
- incl. keyboard and mouse for data entry

Firmly installed control panel

- operating panel with 24" FULL-HD multitouch display in widescreen format

EMERGENCY INTERLOCKING DISRUPTION

TAPIO READY

- with the purchase of your HOMAG machine, the machine is already prepared to be connected with tapio (connecten)
- this functionality gives you the opportunity to use tapio's innovative digital products and of tapio partners to be ready for the future
- find out more from your HOMAG Sales team or at www.tapio.one
- the machine is delivered as "tapio ready" please consider that some offers and services of tapio only can be used, if you register for this, register the machine resp. connect it and if you activate Services for it.
- More information find under store.tapio.one or contact your HOMAG sales team,
- the "tapio ready" functionality additionally
- achieves that when starting the machine a connection to the tapio agency service is automatically made, in order to check by means of the machine number, whether this machine is activated and authorized for the use with tapio.

NETWORK CONNECTION ETHERNET

Enables the machine to be connected to a local Ethernet network.

Hardware for NCxx control:

- Ethernet card with AUi-connection (10 Base-5)
- without cable

- Hardware for PCxx control:
- Ethernet-card with RJ45-connection (10/100 Base-T) for twisted-pair cabling
- without cable

Data communication via FTP or Windows network, additional network software and/or components must not be installed on the machine

Technical hint for the network integration on part of the customer:

- within the machine or machine line Homag uses data networks with the identifications 192.2.x.x or 192.168.1.x

if one or both identification(s) are also used in the customer network, the customer has to provide a router in order to avoid network conflicts

MANUAL OPERATION TETHERED FOR RUN-IN MODE

- integrated magnet for flexible fixation
- specified according to IP65

The following functions can be selected

- run-in mode
- feed start/stop
- emergency switch with protection

SOFTWARE FOR MACHINE

SOFTWARE PACKAGE WOODCOMMANDER

- graphically supported creation and storage of machine programs
- administration of tool data via tool macros

EDGING MATERIAL SEQUENCE CONTROL

- for pre-selection of the edging material in arbitrary sequence,
- If an edging material channel is empty, the next selected channel is triggered

CAPTURE AND EVALUATE MACHINE DATA - MMR

MMR basic:

- integrated counters and predefined maintenance intervals always inform the machine operator about necessary maintenance works in due time
- through the need-based maintenance the avail-
- ability of the machine increases and the downtimes of the machines are significantly reduced
- besides the maintenance data the amount of produced workpieces and the total running time of the machine is gathered, therefore information about the productivity is constantly available

ERROR DIAGNOSIS

- display of the error description on the machine control
- error message in plain language
- Diagnosis system woodScout

- Software kit for graphical diagnosis of the machine condition, With the woodScout system it is possible to systematically eliminate troubles which in turn considerably increases the plant availability
 - graphical PLC diagnosis in different levels learning system due to the possibility of entering the reasons for disturbances and the measures to eliminate them
 - optimum support for the elimination of machine down-times

SPEED ADAPTATION FOR LINE CONTROL

- enables the automatic adaptation of line points to feed speed

TOOLMANAGER

- simple management of tools of a machine in a database
- graphic representation of the tool data unique tool description for all HOMAG machines
- unique identification of the tools
- simple export and import of tools enables the use of a tool on several machines
- simple tool search by filter
- table editor to change single parameters of several tools
- management of main and auxiliary tools management of sister tools
- management of tool changers

DOCUMENT

LANGUAGE SELECTION: ENGLISH

- operating manuals and on-screen operator control texts for machine operators in English

DOCUMENTATION ON DATA CARRIER

- (data format PDF)
- operating manuals consisting of operating and maintenance manuals
- spare parts denominations wiring diagram

DOCUMENTATION ON PAPER

- (folder, paper A4)
- operating manuals consisting of operating and maintenance manuals

SERVICE AND TRAINING

RUNNING IN STANDARD PROGRAM

- the machine is run-in and delivered with HOMAG standard program

SERVICEREMOTE

- serviceRemote - the TeleService solution of the future.
- Our HOMAG service experts will assist you as usual in all your matters concerning machine technology via the ServiceBoard app, by phone or e-mail. With

serviceRemote you will benefit from an even faster and future-proof technology for the remote diagnosis.

- Please provide an internet connection as well as the access to "Port 443 HTTPS",
- The setup of the serviceRemote connection is done via your tapio account at my.tapio.one by assigning the automatically provided serviceRemote license to your machine. Kindly note that the remote diagnosis can only be executed when the license has been assigned to your machine previously. You will get the full functional range when your machine is in the status "tapio-connected"