

# Stegherr

*Innovative  
Solutions*

## Creative machine concepts for the efficient production of windows and doors

Our woodworking machines have proven their worth in thousands of small to large window and door plants worldwide and have become synonymous with high quality cost effective solutions for this kind of production.

If your workpiece requires profiling, milling, gluing, bending, cutting to length, drilling or doweling Stegherr has the most efficient, customized and practical solution for the job.

### Decades of experience

We maintain our most fundamental and important commitment of creating the highest quality practical production solutions for window and doors.

### Our experience and expertise is your resource

With over 1,000 installations worldwide as evidence, no one makes more or better cross joint milling machines than Stegherr, your production requirements are easy on our machines.

### Custom Solutions

Our experience in the design and manufacture of specialized machinery for window and door production combined with our uncompromising quality standards makes us the logical choice to supply the correct machine to meet your production needs.

Whether you are a small shop looking for a single machine or a large shop looking for automated production, the custom solution is waiting for you at Stegherr.

### Durability

With increased pressure to meet exacting production schedules, down time related to machine problems is unacceptable. Stegherr's industry tested reliability, parts availability and service is your best insurance against unscheduled down time.

**STEGHERR**  
Synonymous with  
Economic Solutions

### Custom Solutions

Stegherr Engineering Works is a second-generation family owned and operated Manufacturer of specialty machinery. From humble beginnings, the company has grown into one of the largest suppliers of specialty machinery for window and door production in the world. Located in Regenstauf, 10km north of the town of Regensburg in southern Germany, the current production facility is housed in a 2,500sq/m state of the art facility.

A large operational showroom is manned and ready to demonstrate our complete range of equipment in real production scenarios and to explore challenges to production solutions brought by our valued customers.

Find out more about us: [www.stegherr.net](http://www.stegherr.net)

# Stegherr

Stegherr Maschinenbau GmbH & Co. KG • Fabrikstraße 2-4 • D-93128 Regenstauf  
Tel: 0049 (0) 9402/501-0 • Fax: 0049 (0) 9402/501-49 • e-mail: [info@stegherr.net](mailto:info@stegherr.net)





## Innovation, Quality and Reliability:

Stegherr's decades long reputation for producing the highest quality most reliable and best valued machinery is proven daily in thousands of shops worldwide.

All our machines have been developed from the necessities prompted by practice and are being continuously adapted to the latest requirements of the state-of-the-art technology. The main concerns are precision, service life and the price-performance ratio.



### CNC Machining Center for drilling, doweling and milling

**1 2 5 6 7 BBF**

This modern machining center is the result of our long standing experience in the development and manufacture of fully automated drilling, milling and doweling machines in the wood working industry.

All necessary cutting, drilling and doweling operations are applied to the stationary workpiece by a horizontally actuated carriage equipped with different work units mounted to the customer's requirements, vertically or horizontally. Pinpoint accuracy, low maintenance costs and optimal user-friendliness are the outstanding features of this machining center. The high-quality PC- and PLC components ensure maximum functional safety and flexibility.



### Copping Center

**1 KF-mini**

Distinctive feature of the Copping Station KF-mini are its two high-speed milling spindles, rotating in opposite directions. They ensure a perfect, tear free profiling.

An optional cross cut saw and a fence for cut-to-length production ensure that profiled stock can be copped quickly, accurately and tear free.

Due to a quickly adjustable fence (range +/- 45°) the machine can also cope angular joints.



### Copping Center

**1 5 KF-1**

The Sash Copping Center KF-1 features two vertical milling spindles that rotate in opposite directions for tear-free coping of profiled ends. The process is fully automatic, with safe pneumatic workpiece clamping.

The machine cuts lengthwise, but is also available with options such as a cross-cut saw mounted on the fence or an additional drilling unit to drill holes or mill for connection elements such as dowels, clips, etc.



### Copping Center

**1 5 7 KF**

The Copping Center type KF is a machining center for cutting to length, coping and drilling of casement and frame profiles for copped corner joints with dowels or screws.

The excellent quality of the corner joints is guaranteed by two counter rotating milling spindles. At the same time it is possible to make all drilling operations for screws or dowels.

The flexible concept of the STEGHERR Copping Center KF allows manufacturing of a variety of customized machine versions: With milling spindles from 4.0 to 7.5 kW with different shaft lengths and tool holders, with height adjustable spindles, either pneumatic or over servo drive, with cross cut saw or with a NC automatic saw, to name just a few possible executions.



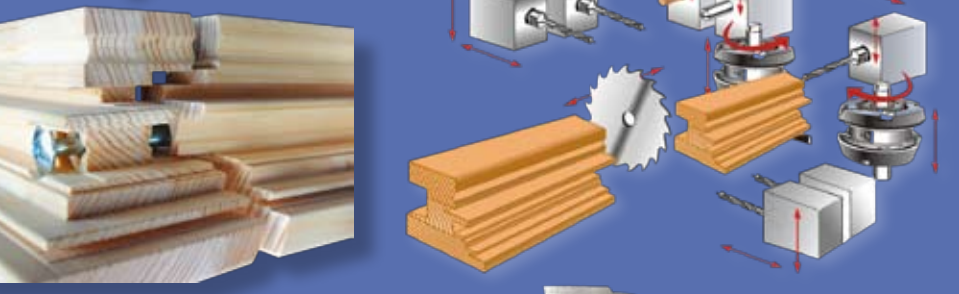
### Copping Center type KF with tool changer (KF-W)

This Copping Center ensures absolutely tear free end scribing by means of two HSK63 counterrotating milling spindles which can hold up to three tooling sets.

With the KF-W it is possible to accomplish all drilling operations for screws, dowels including for spacer blocks. Automatic glue injection and dowel insertion are available as optionals as well. The long side profiled stock is cut to length by a cross cut saw.

For a fully automatic processing of window casements and frames without change over times, the machine can be provided with a tool changer which can hold two or more tooling sets.

Output: Up to 60 casements and frames per shift.



### Drilling and Doweling Station

**5 7 DS**

The Drilling and Doweling Station Stegherr type DS is employed for both end and long side drilling and dowel insertion in the workpiece ends. Due to its three servo controlled axes the DS can drill in any position on the workpiece.

The DS has a NC pusher and a color six inch touch screen monitor, for a simple operating both in the manual and in the online mode and for the alternate processing of the workpiece ends without any waste of time.



# Stegherr

The industry leader in cross joint machining

Our application engineers are ready to assist you in analyzing any specialized applications.



[www.stegherr.net](http://www.stegherr.net)





Blairs of Scotland

**FD-E2 2 5 6 7 NC Machining Center for Drilling, Milling and Doweling in the Manufacturing of Windows and Doors**

With its three standard servo controlled axes the FD-E2 can accommodate any drilling and milling pattern. The flexible machine concept can be adapted to optimal customized solutions. The work stations can be mounted to the customer's requirements, vertically or horizontally. The operations are applied to the stationary workpiece. For longside operations the machine can be provided with a NC pusher, which positions the workpieces accurately in the work stations.

- With the FD-E2 or FD-E3 you can:
- drill dowel holes, inject glue and insert dowels
  - drill any hardware locations ( for armatures and hinges, olive holes, window hinges)
  - mill for lock sockets and strike plates
  - effect any special milling and drilling jobs

**FD-E3**

On the FD-E3 the profiled components are processed on all six parts in one passage, on condition that the machine is working in the online mode. A fully automated processing is possible as well on components that are profiled lengthwise after processing on the FD-E3 machine.

**KSF-mini 4 Cross Bar Milling Machine**

The KSF-mini is the ideal small cross bar milling machine for all usual cross joints. Even already profiled bars can be milled quickly and accurately with the KSF-mini, due to its unique design by which all three cuts are accomplished in one single clamping. The KSF-mini is owing to its good value for money the ideal machine for companies that are not currently processing cross joints.

**KSF-2 4 Cross Bar Milling Machine**

For the production of precision half lap joints. Unequalled accuracy, flexibility and reliability at an affordable price. This semi automatic machine is an industry favorite where computerization is not a requirement. If provided with four milling units this machine can mill any profile tear free on the view side. Setup is easy with an electronic digital display.

**KSF-2E 1 4 5 8 Cross Bar Milling Machine**

Beside the classic cross joint the NC cross bar milling machine KSF-2E can perform the following operations:

- End scribing of SDL bars (tear free, by means of two counter rotating cutter heads)
- Cutting to length of sash bars at various angles
- Cutting to length of glazing bars at various angles
- Cutting to length of frames
- Drilling of fastening holes for fixing glazing bars onto frames.

Both for the automatic and the semiautomatic operation the machine can be supplied with customized in/outfeed tables.

**KSF-R 3 4 5 Universal Closed Halving Joint Milling Machine**

For the milling of 90 degree, diagonal (35° - 90°), diamond and half round grills in wood, vinyl and aluminum. The KSF-R's uniquely designed milling head employing two profile cutters and a grooving saw makes single pass cutting of difficult half lap joints easy, accurate and with an unsurpassed finish.

**NF 4 Dentil Moulding Machine**

The Notching Machine Stegherr type NF is designed for notching in one working cycle several bars up to a total width of 400 mm. On the NF the bars are accurately cut to length and notched from top and bottom. The machine can be equipped with either one milling unit (bottom) or with two units (top and bottom). The powerful milling motors of 4.0 or 5.5 kW (spindle diameter 30 mm) contribute to the overall sturdy execution of this machine, suited for the manufacturing of various types of grilles and frames.



**Operations:**

- 1 Coping
- 2 Milling for hardware (lock sockets)
- 3 Sash jointing (curved or straight)
- 4 Sash jointing (straight)
- 5 End connecting
- 6 Milling for hardware
- 7 Drilling, gluing, doweling
- 8 Cutting Sash Bars



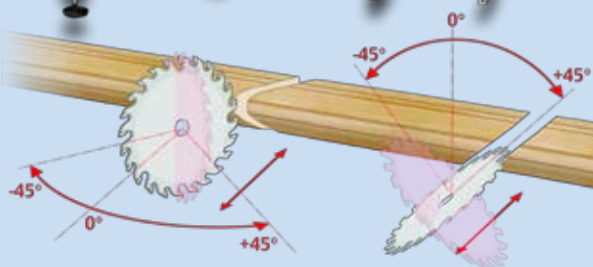
## NC Mitre Saw STEGHERR type GLS-2

with servo controlled sawing angle adjustment in two planes



The machine control can be used manually or in fully online mode, with programs created and sent from the front office.

The GLS and GLS-2 can mitre-cut glass strips, water drainage channels or similar profiles of wood, aluminum or PVC at any angle between +45° and -45°. Further angles on inquiry.



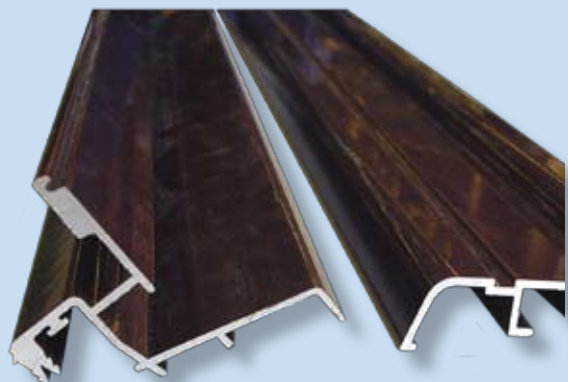
The cutter heads are positioned over servo axes at the angle stored in the machine program. Speed adjustment of the working stroke over servo axis. Accurate positioning of the workpieces by means of a NC pusher.

The machine can be provided with additional punching and/or drilling units, as well as with label or laser printers.

Both GLS and GLS-2 can be upgraded to fully automatic operation by mounting customized workpiece conveyors



Can handle various materials e.g. solid wood, mdf, aluminum or synthetic material.



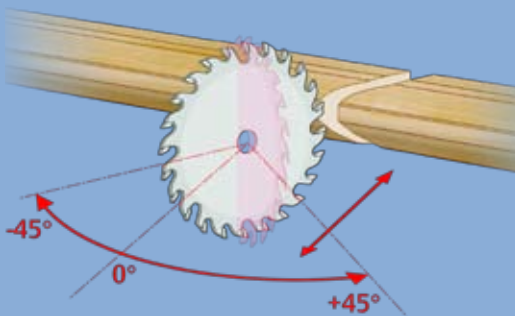
The Stegherr NC Mitre Saws process also special profiles.

## NC Mitre Saw STEGHERR type GLS

with servo controlled sawing angle adjustment in one plane

The cutter heads of the GLS are positioned pneumatically or over servo axes at the angle stored in the machine program. Speed adjustment of the working stroke is set pneumatically or over servo axis. Accurate positioning of the workpieces by means of a NC pusher.

The GLS can be upgraded to fully automatic operation as well.



Stegherr has the right machine tailored to your needs at the most effective price. Why not contact us today with all your requirements and put us to the test.

**Stegherr**  
*Innovative Solutions*

On our web site you will find further detailed information on our product range as well as brochures and videos of our machines for download.

[www.stegherr.net](http://www.stegherr.net)

Stegherr