

DATA SHEET

BL100

BLOCKHAUSFRÄSE



Loghouse milling machine Blockhausfräse BL100 for economic production of components used in modern log cabin construction.



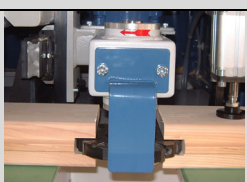

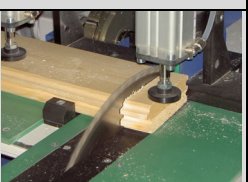
The available workings are cutting the exact length, milling of the joints and the drilling of the holes.

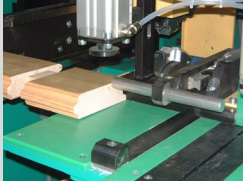
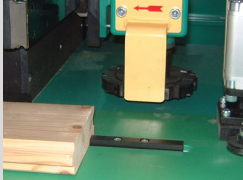


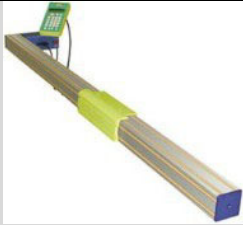
The hydro pneumatic feeding system with an express traverse, allows the creation of a four- fold corner joint only in a few seconds!

High performance spindle drives and climb milling ensures a clean cut milling contour without being frayed.

process flow: The machine should be adjusted to the required workpiece dimension. The operator puts the Log onto the machine table. To find the right workpiece position in relation to the working unit are workpiece stop faces (manually, pneumatic or electric) optionally available. Through pressing the button the workpiece will be pre fixed. With the two hand button at closed cabin the operation will be started. The cycle workpiece fixing – milling, cutting or drilling – unfixing the workpiece occurs automated by PLC. The operator moves the Log to the next position and starts the next operation. This process will be repeated until the Log is finished.

TECHNICAL DATA:

	Working dimensions:			
	Wall thickness x log height min.:	28 x 100mm		
	max.:	140 x 200mm		
	Workpiece length min.:	300mm		
	Workpiece length max.:	Depends on mechanisation		
Workingunits:				
				
Drives	<i>4-Fold unit</i> Hor.: 2 x 3kW Vert.: 2 x 4kW	<i>Groove unit</i> 3,0kW	<i>Drilling device</i> 1,5kW	<i>Circular saw</i> 4,0kW
Spindle speed	4200 U/min	4200 U/min	1500 U/min	86 m/s

Milling shaft Ø	4-Fold unit 30mm	Groove unit 30mm	Drilling device Drill chuck with Gear ring	Circular saw 30mm
Milling shaft length	120mm	90mm	-	-
Tool Ø max.	220mm	180mm	30mm	550mm
Tool width max.	140mm	40mm	-	-
Feed	Hydro pneumatic infinitely variable with express traverse		Pneumatic infinitely variable	
Adjustment milling support	Trapezoid spindle with digital counter		-	
Workpiece- holder	max. 5pcs. pneumatic pressing cylinder upside max. 2pcs. pneumatic pressing cylinder frontside (optional)			
Suction	under floor suction (hole) central D=160mm, 30m/min			D=120mm, 30m/min
Pneumatic supply	Euro coupler, compressed air - dried and cleaned, 8 bar, ca. 300l/min			
Current supply	Eurocurrency 400V+N+PE, 25kW			
Weight	+/-1600kg (without table)			
Accessories:				
Chalethead Stop face	To find the workpiece position in reference to the 4-Fold unit: Installed beside 4-Fold unit at right side. Operation by button (electric), pneumatic moving, length adjusting manually.			
Stop face Grooving unit	To find the workpiece position in reference to the Groove unit: Installed as fix stop face at Groove unit below the machine table. Operation by button (electric), pneumatic moving, length adjusting manually.			
Roller table, usable as In- or Outfeed table	Roller table element 3,0m with feet (2pcs. / Element), height variable, flat construction with ball bearing steel rollers D=60mm, Width=300mm, splitting +/- 600mm.			
Stop face pneumatic	To find the position of workpiece on the roller table: Base bar with measure scale, mounted on roller table. Operation of stop faces by pneumatic valve, central based beside the machine. Adjustment of length position manually.			
Stop face manual	To find position of workpiece on the roller table: mounted adjustable on base bar, manual operated			
TigerStop Servo Stop face system	Electronic Stop face system TigerStop for workpiece length 6,0m. The positions of the operations are entered to the display by the numeric keyboard. After pressing "GO" the TigerStop moves automatically to the first position. The operator moves the workpiece to the stop face and starts the operation at the machine. The information about the required job is shown by signal lamp. Through pressing the "GO" button the TigerStop moves to the next position and the operator starts the next process...		 Power = 0,6kW; speed = 60m/min, repeat accuracy = 0,1mm	
<i>Subject to changes - all rights reserved!</i>				