



Performance SB

NC squaring-edgebanders

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STEFANI

Performance SB

NC
squaring-edgebanders

**A
successful
solution**

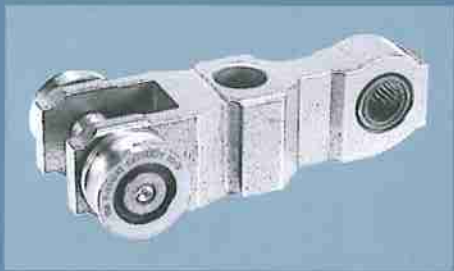
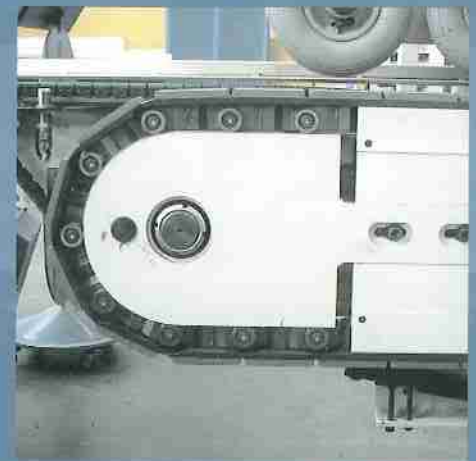
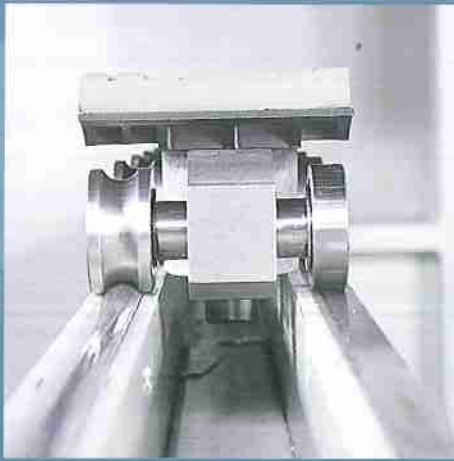
PERFORMANCE is a squaring-edgebanding machine with a range of more than 200 working units which allows high customisation, guaranteed maximum reliability thanks to more than 50 years' experience. The main technical characteristics are management by an Office PC, lengths up to 12 metres, speeds up to 40 metres per minute and sub-bases.

PERFORMANCE gives unlimited modularity with outstanding features and quality.

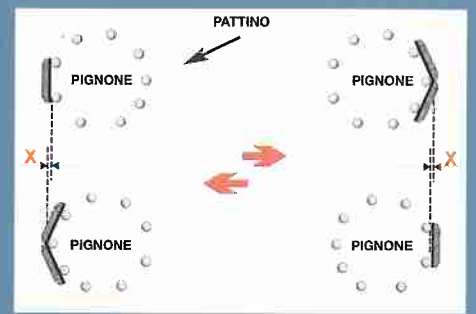


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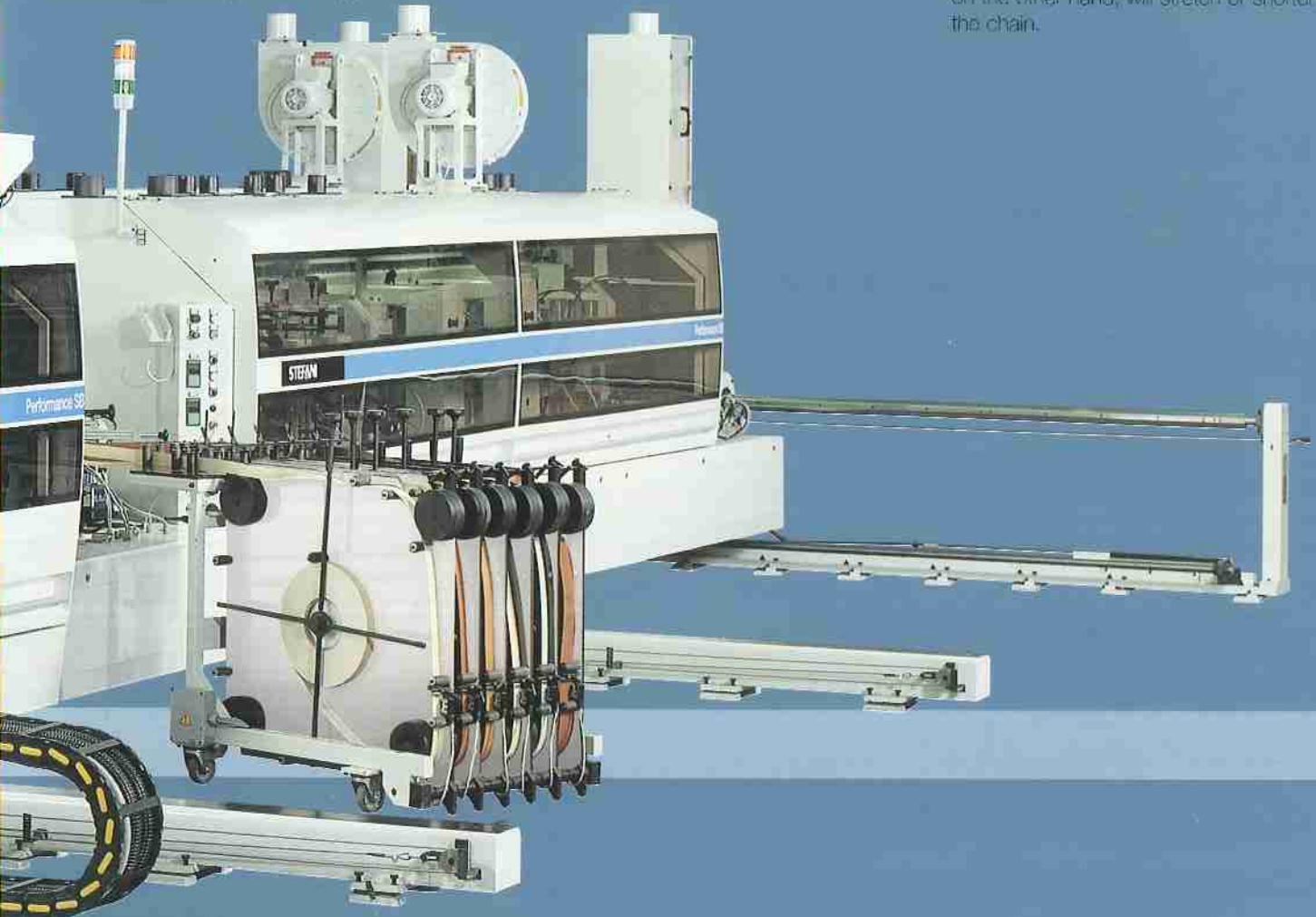
The **track sprocket** has 9 teeth for perfect constancy of the feed movement, avoiding the possibility of stretching the belt. The bearing housing sectors are tempered and ground to reduce wear and ensure long duration and operating accuracy.



The **track** consists of **links** made in sintered steel and capable of withstanding the highest possible stresses. The track runs on round and flat guides by means of sealed bearings to reduce friction to an absolute minimum under high speed working condition. The pads fitted to the links are made of special low friction coefficient rubber and their support guarantees the complete protection from the dust created by the working process.

Infeed sprocket

The **infeed sprocket** has odd teeth and is mounted directly on the machine structure. This design solution guarantees high-precision, straight-line chain feed. A design with odd teeth only requires one movement of the chain forwards and backwards. A design with even teeth, on the other hand, will stretch or shorten the chain.



Machine frame



Steel top pressure beam

The top pressure beam consists of a full-size steel beam equipped with controlled-axis lifting.



Movable beam

The movable beam opening is rigid with a transmission that acts on a high precision worm screw, thus permitting perfect constant parallelism to be maintained over time. The beam has 2 speed motorised movement:

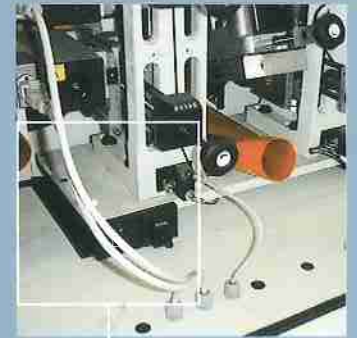
- the first speed, for reaching the work area
- for positioning the final millimetres with extreme accuracy.

Recirculating ball opening is available for greater speed. THK movable beam.



Central panel support

The central support allows the support of the panels wider than 1200 mm. A pulley system enables a perfect centring of the support according to the opening of moveable beam.



THK movable sub-bases

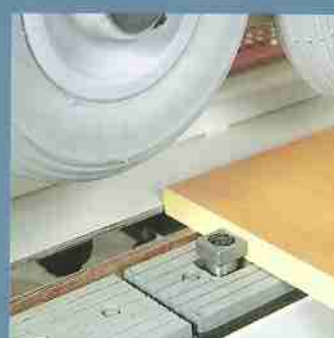
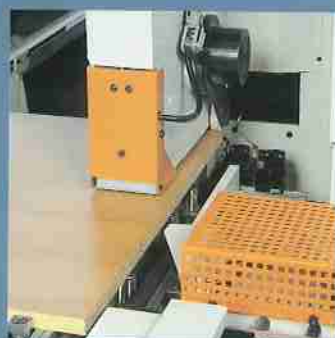
Panel infeed system



Performance SB has a safe panel infeed system, a fundamental condition for obtaining perfect squaring of the piece. The technical solutions used can be customised according to the specific machining needs, in function of the productivity, of the type of finish, and the feed speeds required.



During automatic lengthways machining, correct panel feeding is ensured by a wheeled pushing device; by pushing the panel against the left lateral guide it ensures perfect panel parallelism. A belt-driven mechanism and a right pneumatic fence guarantee the feeding and centring of the piece.



During automatic crossways machining, a sophisticated centring system always guarantees piece alignment against the machining line. A belt-driven mechanism, together with an rail-type centered device and a pusher mechanism with rungs guarantee the feeding and centring of the piece. Perfect synchronisation of the centring mechanisms guarantees a precise squaring of the piece, ensuring that the surfaces begin machined are perfectly perpendicular to each other.

The panel is pulled into the machine by a pair of dogs which operate automatically and are adjustable in height so as to optimise the pulling phase in function of the panel thickness.

In optional there is an infeed system for machining narrow pieces up to 90 mm in width. It is made of a bar of fixed disks on the mobile shoulder which guarantees the correct introduction of narrow panels.

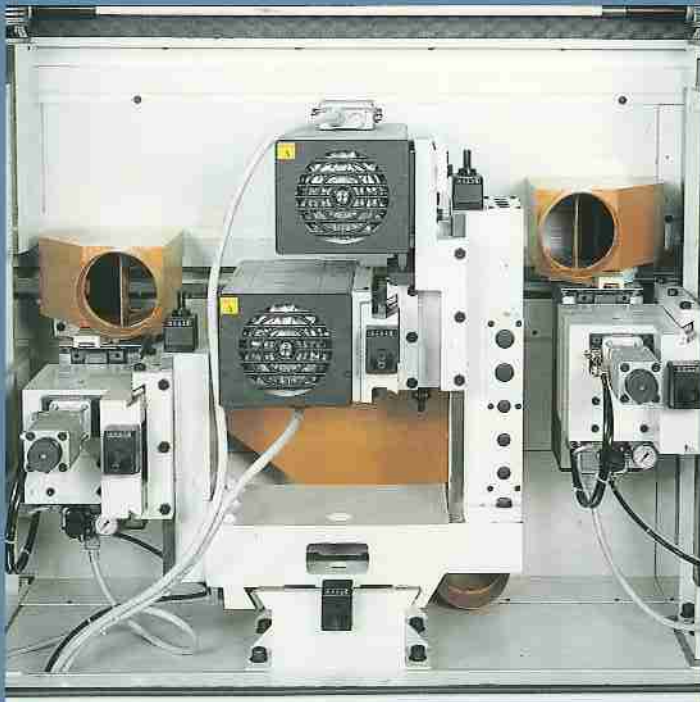
Panel squaring: modular and customised



In the section dedicated to panel squaring, Performance SB makes a modular solution available to satisfy every machining need.

There are several operating units to choose from, each of which integrates structural rationality with the need for customising the machine.

The result is the possibility of numerous compositions which are always rational and effective.



The combination pre-milling unit-double hogging unit provides maximum squaring quality on panels covered in melamine and plastic materials.

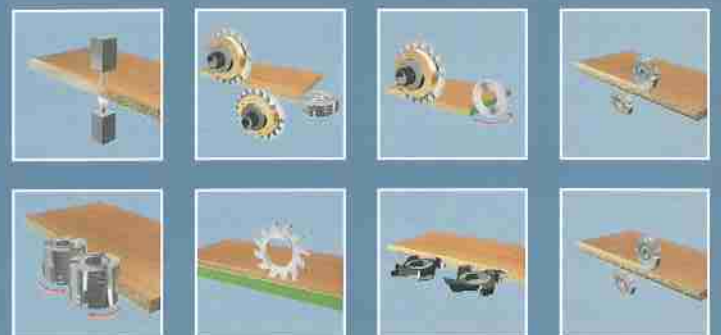


The combination scoring saw-hogging units, guarantees excellent quality machining of honeycomb panels or veneer coating panels.

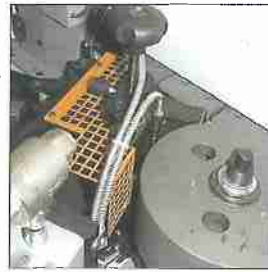


The squaring panel can be integrated with various operator units making it adaptable to different production needs:

- **Anti-adhesive unit**, for the application of adhesive-proof liquid to the upper and lower parts of the panel to facilitate the elimination of glue residue
- **Grooving unit**, for making blind through slots on the upper and lower parts of the panel;
- **COMBI Pre-milling unit**, for grinding a panel which has been previously squared to guarantee optimal finishing of the machined surface.
- **SOFTFORMING shaping unit**, to prepare the profile for the softforming process.



Edge gluing with precision edge feeding



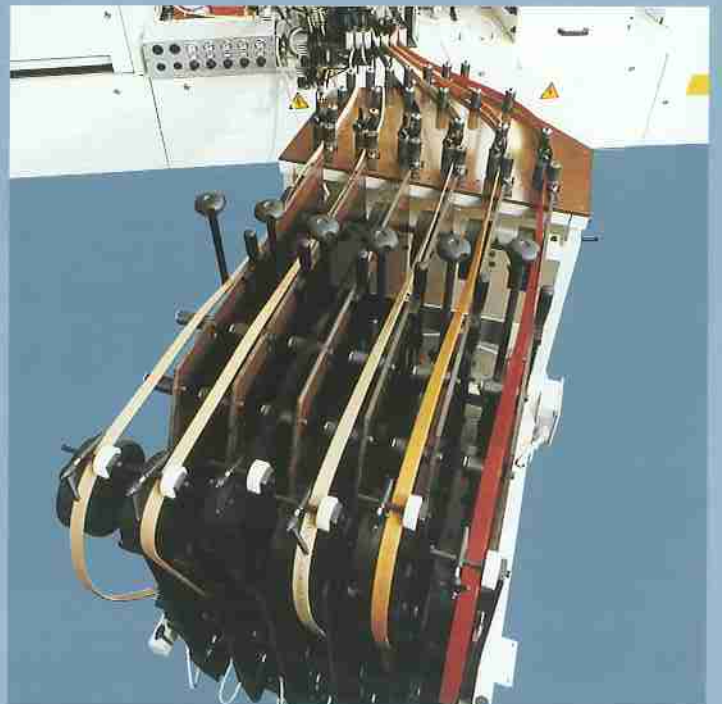
Gluing unit for straight process

Using a series of optional accessories, the gluing unit can be dedicated to specific machining operations like the application of veneer wood strips, solid wood up to 25 mm and the insertion of a dust-proof edge. In addition, there is also a gluing system that uses polyurethane glue, which is highly resistant to water and heat.



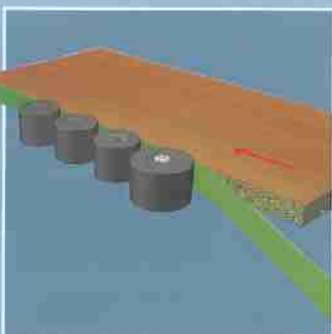
The automatic rollers change

with clamp makes it possible to change edges during machining, reducing change times to a minimum and guaranteeing excellent precision in edge placement.



Side pressure rollers

The side pressure rollers are equipped with independent pneumatic adjustment making it possible to regulate the pressure exerted by each roller individually. A full range of standard equipment, optional controlled axes on the side pressure rollers, edge height and sub-bases ensure the greatest flexibility when changing over from one type of operation to another.



The **multi roller** magazine is mainly used on machines that require a high degree of flexibility and automation with frequent changes of material and/or colour. The edge change can be carried out in pairs or cascade, and is managed by the control in function of the pre-set programs.

Softforming gluing unit with high depth of inlay



Gluing unit for softforming

The VC34/34 M softforming gluing unit is fitted with two glue rollers: the external glue roller for sticking the glue onto the edge (softforming processing), the internal glue roller for sticking the glue on the panel (straight processing).

The interchangeable presser sections enable great flexibility when changing over from one profile type to another.



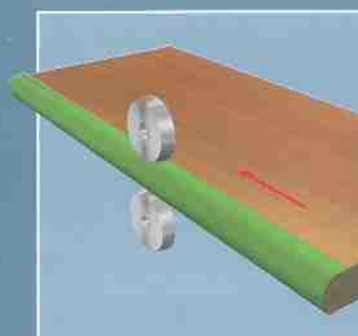
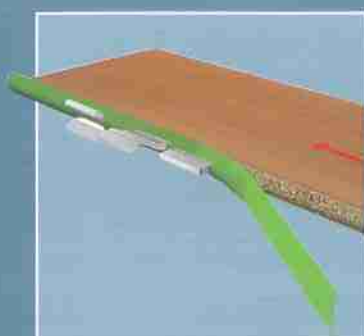
Longitudinal shear

To cut the excedance of the edge inlay profile, fitted on a dedicated column.



Pressure sector for softforming

Pressure sector of 1000 mm length allows high performance on softforming profile.



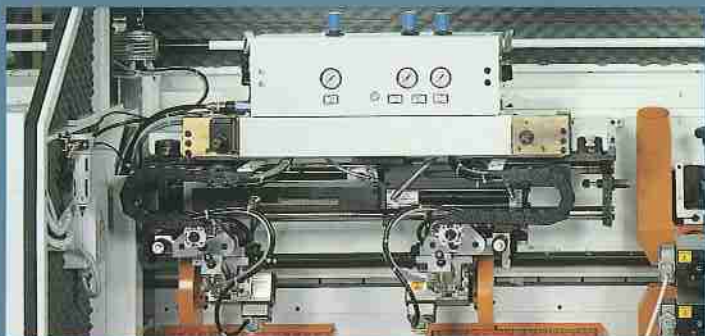
Accurate and reliable working units...

Performance SB offers a wide selection of operator units dedicated to edge finishing that ensure elevated quality of the finished products.



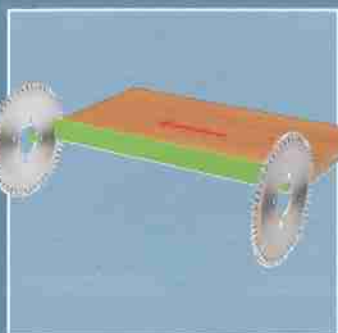
Upper end trimming unit

The upper horizontal and trimming unit enables high speed machining and high precision front and rear cut, two features guaranteed by the special cutting geometry and the THK guides.



Electronic end trimming unit

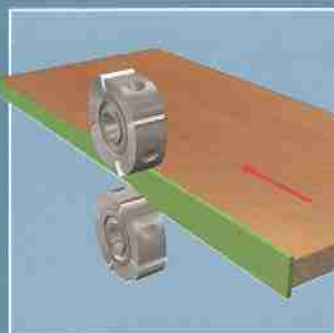
The electronic end trimming unit is designed for customers looking for high productivity.



Rough trimming unit

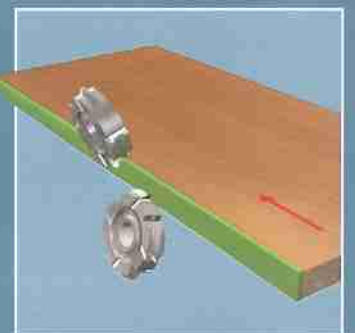
Unit designed for the rough trimming of thin and thick edges and for the finishing of solid wood edges.

The structure of the unit and the wide range of adjustments ensure a high-quality finish.



Fine trimming unit

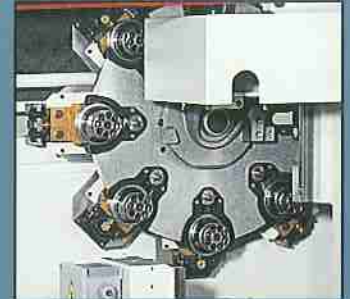
Unit designed for rough trimming/finishing thin edges, thick edges and solid wood, or for rough trimming the radius on the ABS/PVC edges. The structure of the unit and the precision feelers guarantee a high quality finish under all working conditions. High flexibility of the change over with units equipped with the quick-release device or two pneumatic positions or multifunction versions.



...with possibility to chose units from traditional up to multifunction...

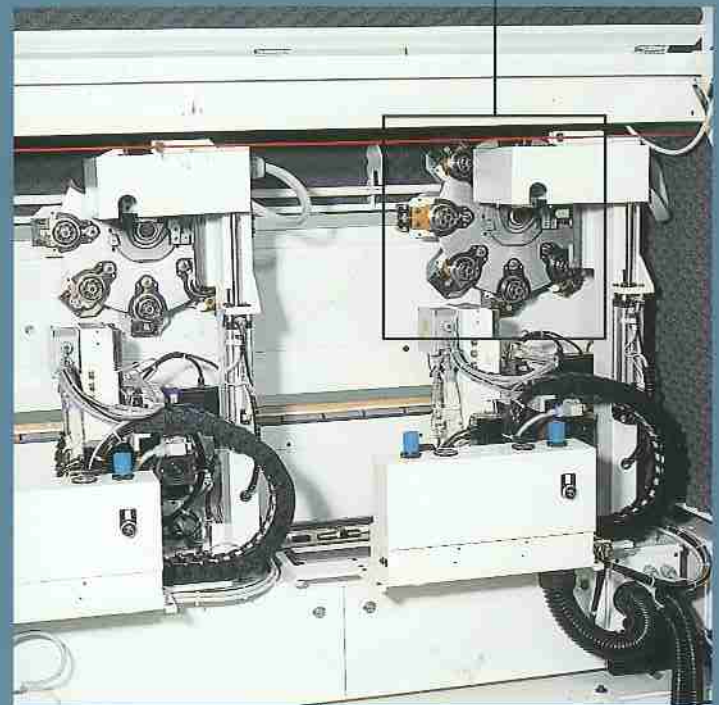
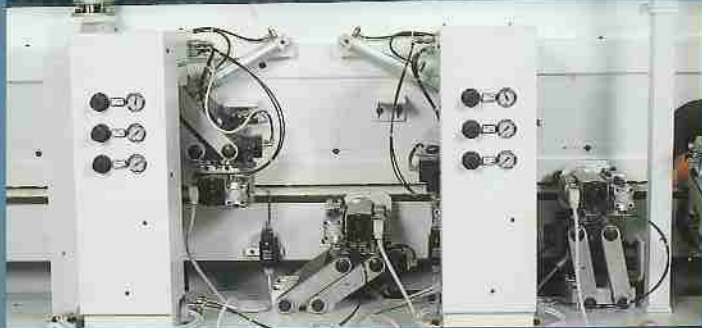


Multifunctional 4-motors corner rounding unit



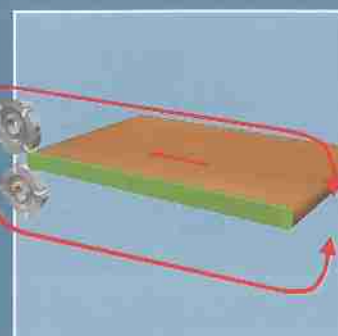
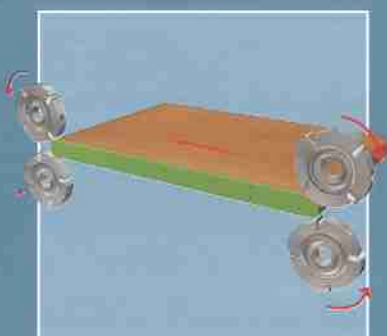
4-motors corner rounding unit

For finishing the edges of panel heads and tails.
Necessary for rounding wooden edges.
Available with quick-release motors or two pneumatic positions or multifunction unit with 18-motor magazine.

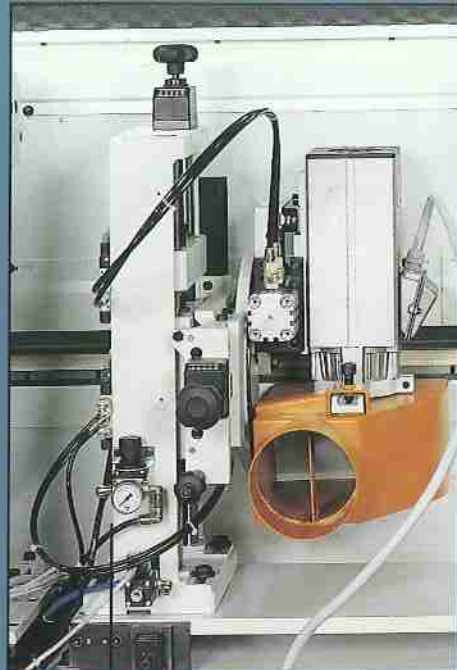


2-motors corner rounding-trimming unit

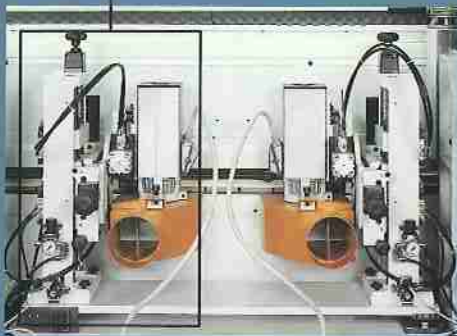
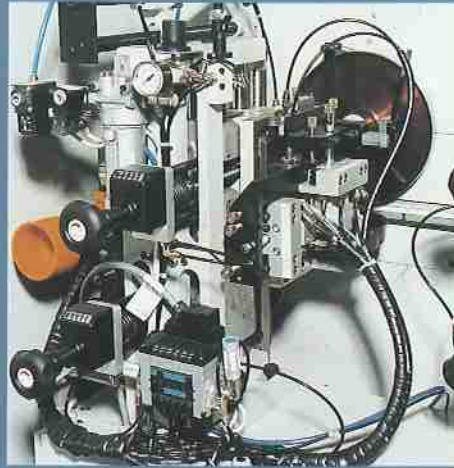
Designed for finishing the head and tail edges and the upper and lower parts of the panel.
Fitted with an 8-positions automatic tools change-over.
Movements by brushless motors to ensure high working speeds.
PATENTED SYSTEM



...to guarantee
high quality finishing ...



Multifunctional edge scraper

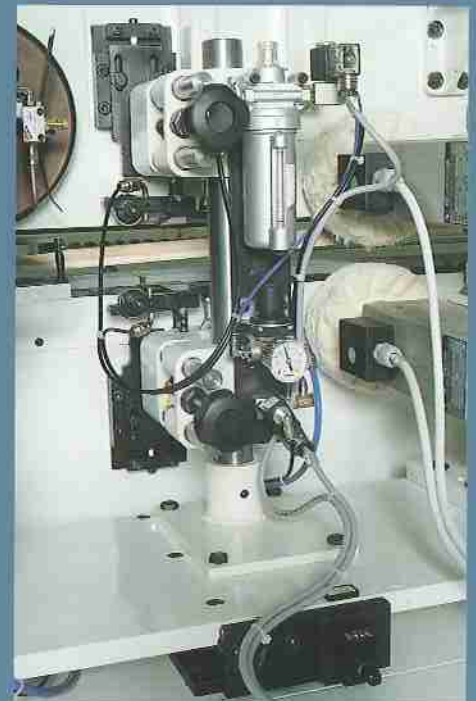


Grooving unit

Executes through and dead groove on the panel.
Top and side feeders to guarantee high precision.

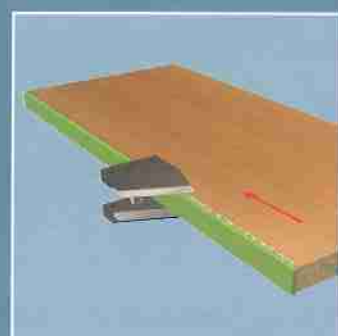
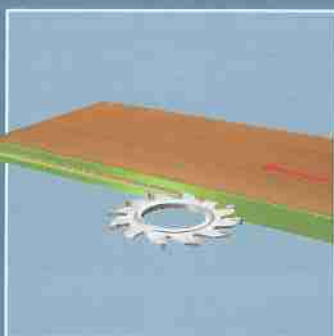
Edgescraper

For finishing ABS and PVC edges rounded or chamfered.
The structure of the unit and the large diameter of the feelers provide the maximum stability and ensure a top quality finish.
Available in quick release or multi-function versions.

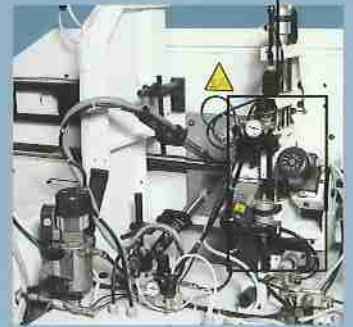
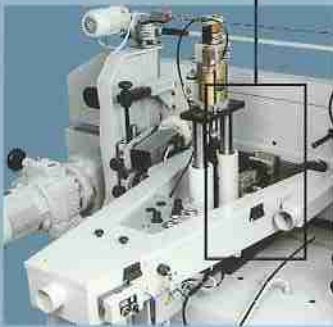
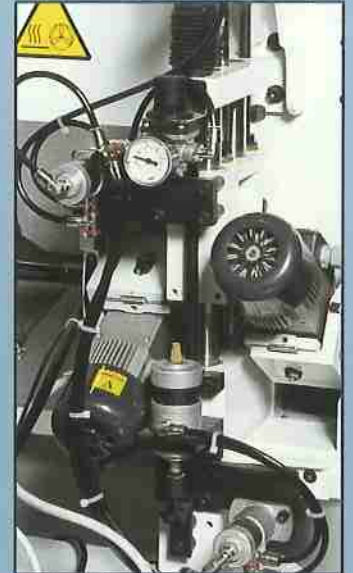


Gluescraper

Removes eventual glue residues, guaranteeing a perfectly clean panel.
The tools are pneumatically operated upon panel entry and are kept efficient by a humidifying liquid spray to avoid glue deposit.



With maximum flexibility of use



Sanding unit

Sands the veneer or solid wood edges using an abrasive belt. Performance SB offers a wide range of sanding units that, in addition to sanding the straight part of the edge using units with or without oscillation, also sand the upper and lower corners with tilted units dedicated to this machining operation.

Edge brightening unit

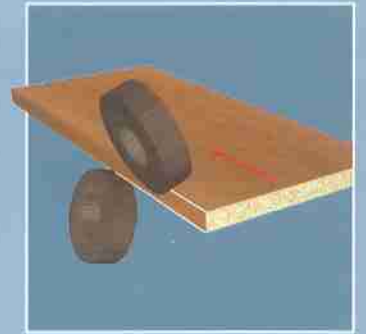
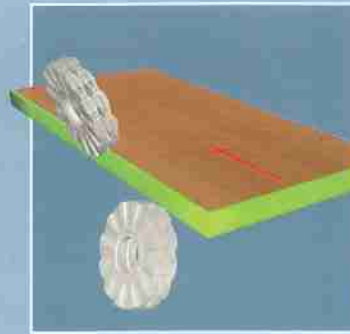
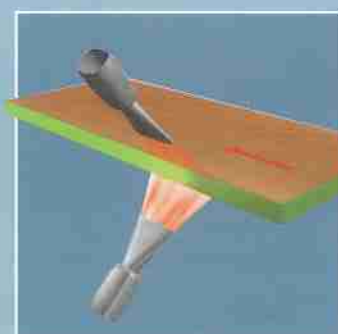
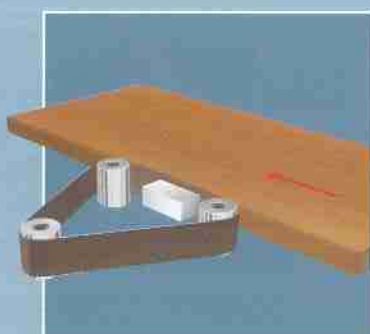
In finishing ABS edges, the unit revives the colour of the plastic material, altered by the previous machining processes.

Buffing unit

The buffing unit guarantees perfect cleaning of the machined part and restore the gloss to edges in plastic material. Based on the need, overlapping brushes may be chosen which take up limited space, or oscillating brushes for homogeneous wear along the entire width of the brush.

Staining unit

Applies a layer of paint on the upper and lower edges in paper, melamine, veneer to guarantee perfect colour uniformity of the applied edge. The unit includes a paint feed pump.



Managing by PC Office

Tele-assistance:

a direct link to the company
STEFANI offers its clients an effective tele-assistance service via modem for eventual interventions or program updates, considerably reducing service costs and times.

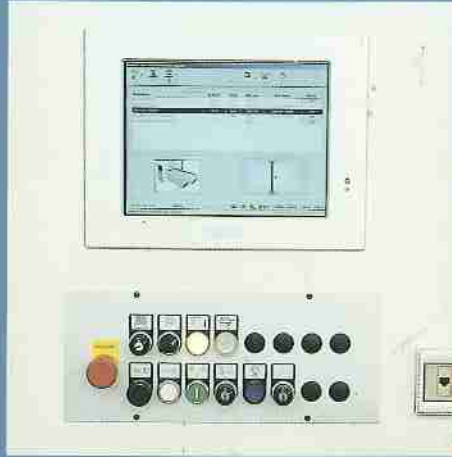


High functionality and ease of use

The use of Office PC allows easy management of the data exchange between the control and the "outside" with the possibility of saving, printing, filing, analysing, and sending all of the machine work data.

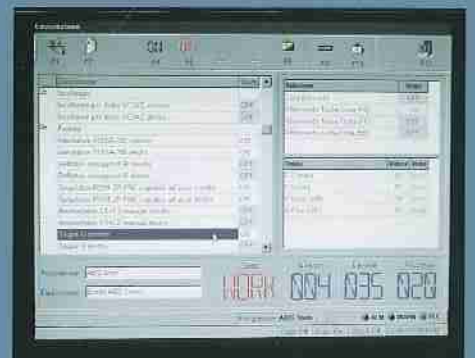
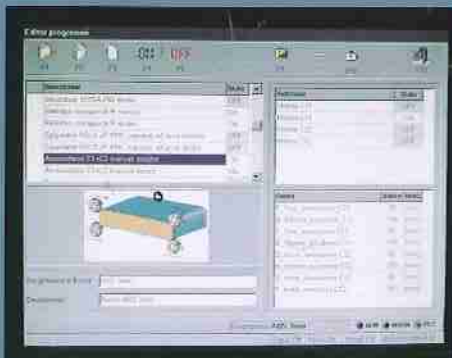
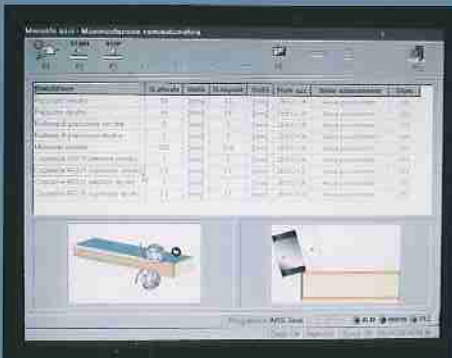
The layout of the screen, the horizontal position of the keyboard and the use of the mouse, together create an ergonomic, efficient control station.

The use of a PC interface offers flexibility and the possibility of expansion, even in the case of more complex configurations.



The management software

The software that manages the entire machine has been developed internally within the company using a programming logic suitable to the specific needs of the machine. The software allows management of an unlimited number of machining programs with the possibility of associating a name and a description to each program. Using the software is facilitated by the extremely rational layout that characterises the entire program structure. Moreover, the use of graphic buttons with an indication of their logical functions makes all of the functions easy to use. A simple software configuration utility permits the addition, at any time, of optional accessories not provided for at the outset.



Writing programs is extremely easy

The software is structured in independent tables and is easily comprehensible thanks to the graphic auxiliary. Writing new programs is easy and immediate by utilising the codes inherent to the existing tables already in use. The machine data table is common to all of the programs: in case of changes, the data is automatically updated with a considerable reduction in programming times and highly rationalised employment. Entering the machining data is guided and controlled with logical functions so that even the most inexperienced operator is able to correctly set-up the programs. Other control functions filter eventual operator programming errors.

A complete diagnosis

The screen displays messages regarding machine operation (ex.: machine empty cycle in progress), warning situations (ex.: insufficient glue temperature) or alarm situations (ex.: no compressed air or cabins open), facilitating machining and reducing intervention times. In addition to this, there is information relative to alarm intervention timing.

Technical and operational characteristics

Office PC with Windows operating system

Colour liquid crystal display

Alphanumeric keyboard and mouse

Graphic display of operator units

Unlimited program memorisation capacity

Control of operator unit interventions

Operator unit selection

Automatic motor start-up

Graphic diagnostics for resolving errors

Display of work data: pieces being machined, pieces produced, pieces per minute, etc.

Report of the executing machining operations, metres machined and hours the machine is in use on a daily basis and on a total basis

Program update by floppy diskette, tele-assistance or PLC memory replacement

Back-up and restore function for machine data and machining programs

Possibility of managing programs from the office

Possibility of selecting the desired language

The modular solution

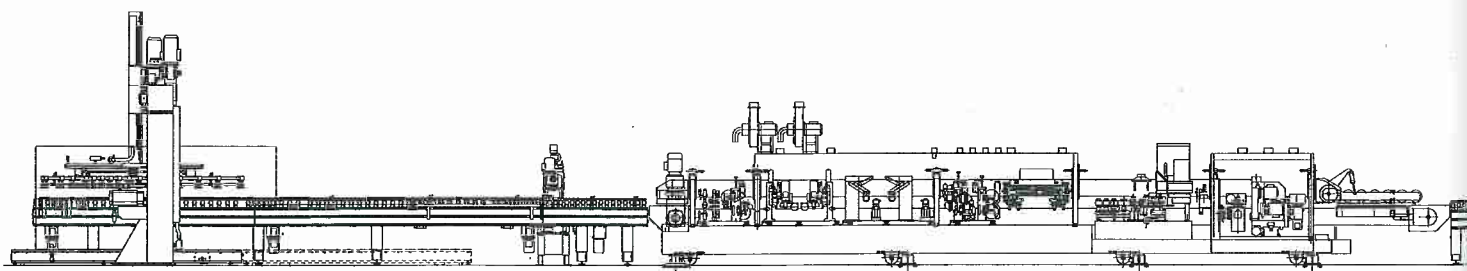
Performance SB synthesises and unites squaring technology with edge banding technology for high performance and high machining quality.

Performance SB modularity translates into a vast selection of squaring-edgebanding machines that offer a wide range of composition possibilities, for both squaring and edgebanding processes, in lengthways and crossways machining of the panel.

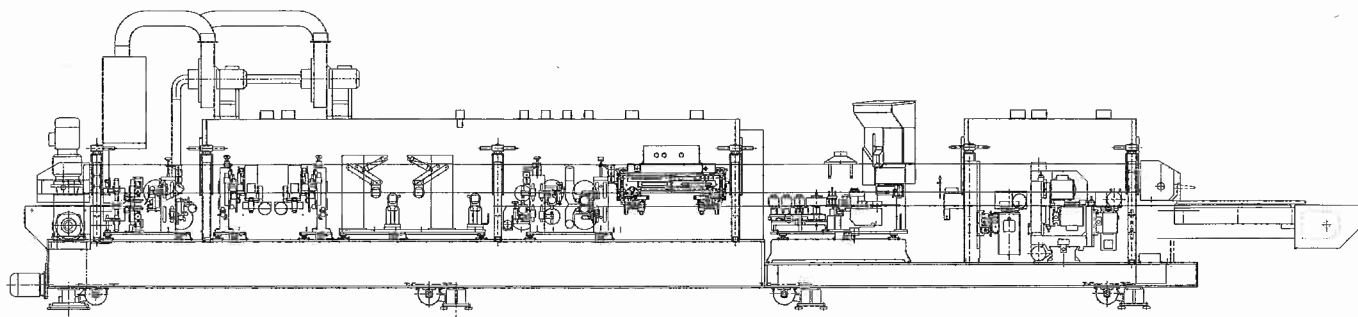
Here are represented the most request lines of ABS and thin edge.

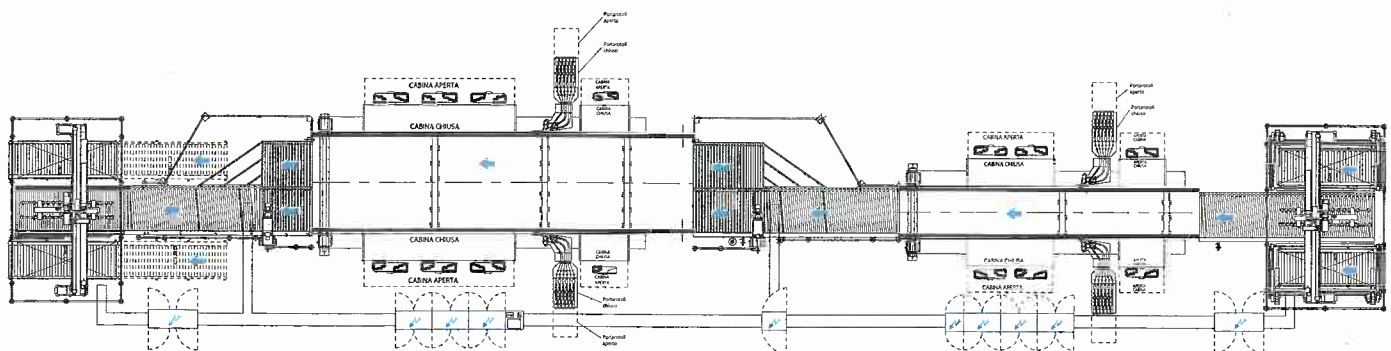
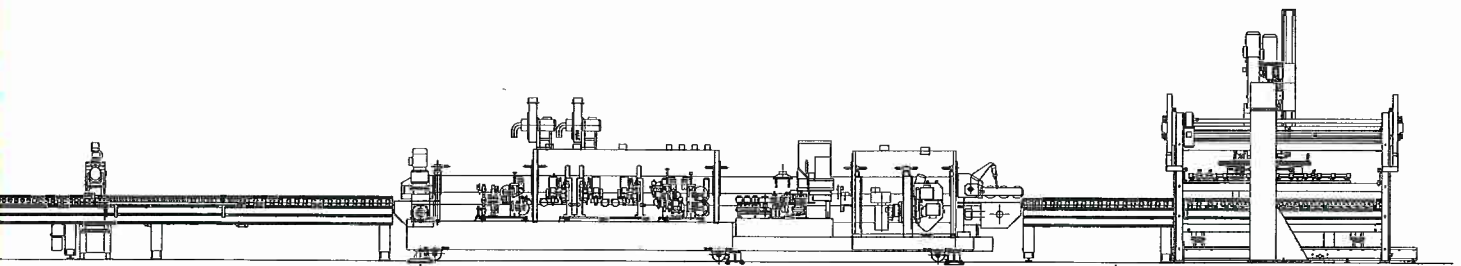
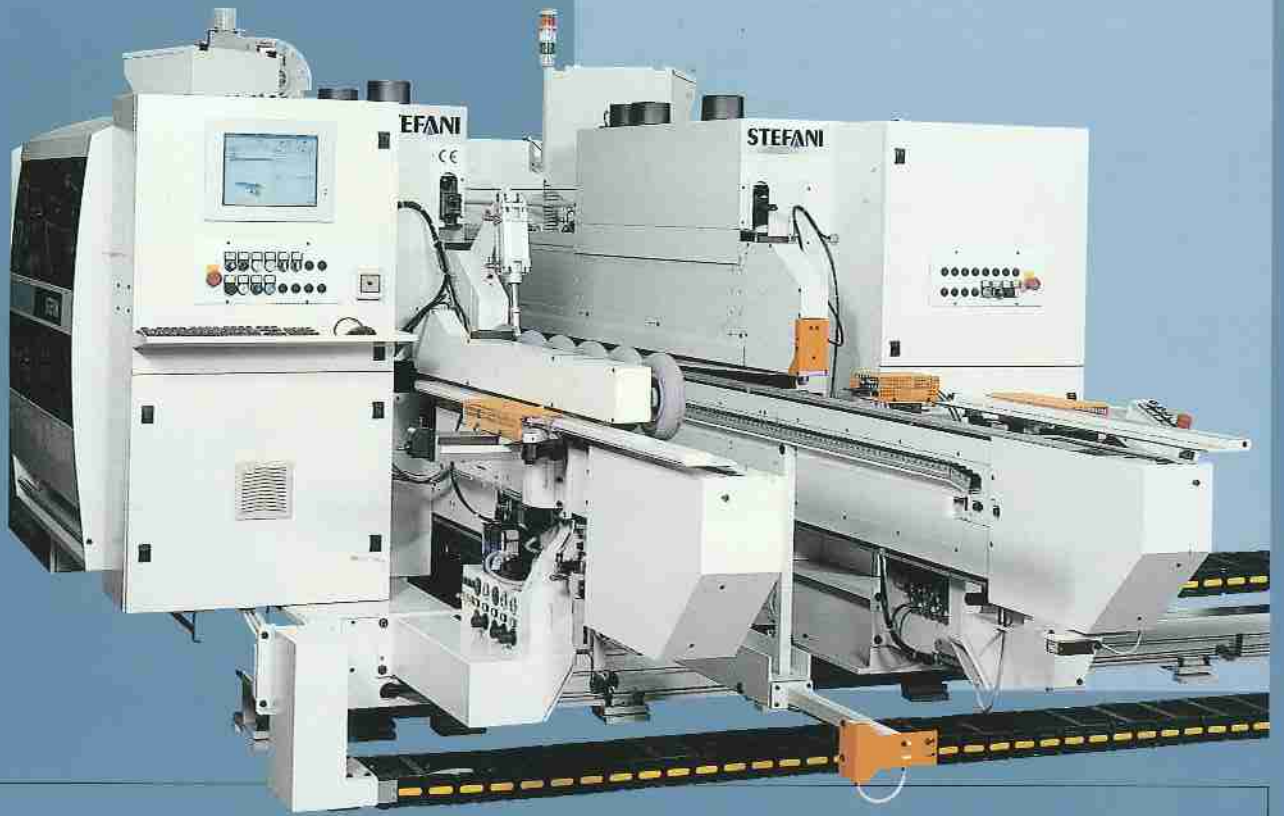
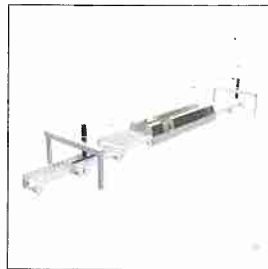
Performance SB can be integrated with the most modern movement systems, making it possible to create completely automatic squaring-edgebanding lines.

Performance SB line

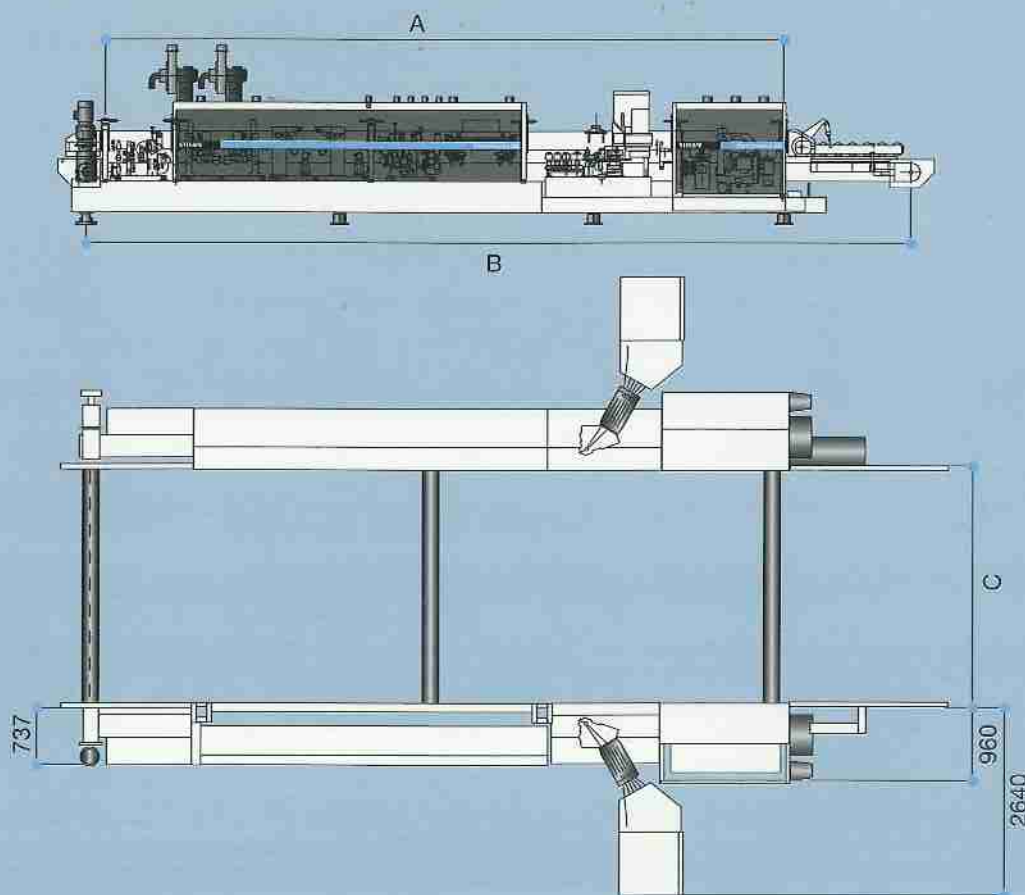


Performance SB - 1st e 2nd in line





Variable panel overhang	30 - 90 mm
Crosswise way	1200 mm (STD) 1400 mm
Minimum and maximum edge thickness	0,3 - 25 mm
Minimum and maximum panel thickness	10 - 60 mm
Minimum panel width on single belt	90 mm
Minimum panel width on double belt	220 / 230 mm in function of the operator units mounted on the machine
Minimum panel length	300 mm
Dogs distance	900 mm (STD) 500/400 mm
Dogs height	12 / 18 / 24 mm
Feed speed	12-40 m/min adjustable
Compressed air	6 bar
Work height	from 960 to 970 mm



Performance 1st in line		Performance 1st and 2nd in line	
Useful space A	Interaxis B	Useful space A	Interaxis B
5250	6300	4350	6300
6070	7200	5250	7200
6930	8100	6070	8100
7840	9000	6930	9000
8740	9900	7830	9900

Italy's leading squaring-edgebanding machine specialist

STEFANI



Over fifty years' experience in the woodworking machinery industry, thousands of edgebanding and squaring-edgebanding machines sold throughout the world, have made the STEFANI name one of the most well-known and esteemed at international level.

A brand synonymous with technical innovation, reliability and high quality standards, STEFANI is the ideal partner for largescale furniture makers who require machines and systems with high output capacities.

