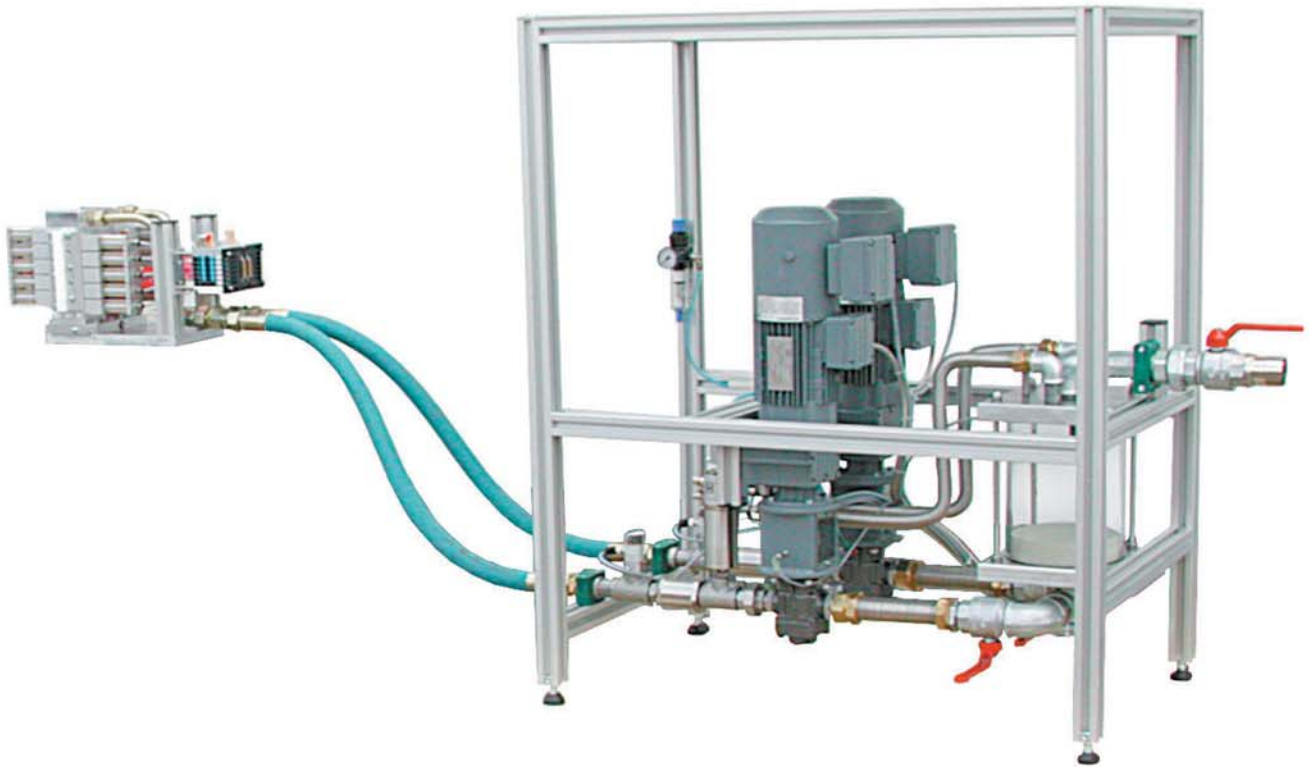


1C-PUR Glue Application System ECOPUR KBK



Field of Use

The ECOPUR KBK Glue Application System applies glue, without contact and from both sides, to finger joints in a compact finger jointing system

The ECOPUR KBK system has the following advantages over conventional glue application systems with counter profile:

Visible coating of glue

Simple change of dimension through almost conversion-free changeover (production to list, "large to small")

Minimised maintenance and cleaning requirement

Savings on glue and cleaning costs through glue application, which can be dosed and controlled precisely

Technical Features

Frequency controlled dosing pumps for precise glue dosing

The applicator head, with separately controlled valves, is guided, on a linear sled unit, past the finger profile

Precision dosing through parameter settings (wood thickness, application rate, finger profile)

Low maintenance material valves on the applicator head

Intermediate buffer for batch monitoring and change, with level monitoring

Automatic adjustment of the feed pressure for differing heights of wood

Switch cabinet with Siemens S7 PLC system

Operating panel OP 7 in a separate terminal box, with all operating controls, to install in a suitable location

Can be networked with other control systems and host computers via bus systems

4-line text display for all operating situations and error messages and for entering all digital parameters

Help text for operator guidance

Suitable container or barrel connection with silica gel filter

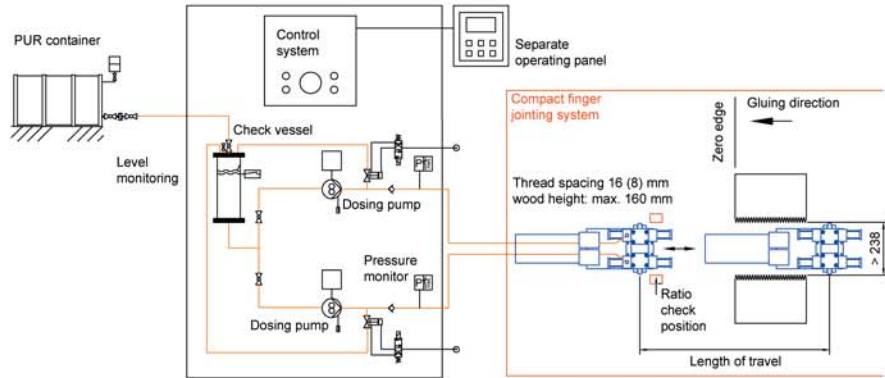
Functional Description

A split travelling applicator head, fitted with a dosing system, travels past the opposing finger profiles and applies glue to the peaks of these, at right angles to the profile. The distance between threads is 16 mm on both sides

Because the left and right-hand applicator heads are offset in height, the resultant thread spacing is 8 mm, when the finger joints are united

When the wood is in the gluing position, the applicator head travels at a fixed speed, past both pieces of wood and applies glue to them glue, at right angles to the finger profiles

Two frequency controlled dosing pumps meter the glue to the two applicator heads, when the linear sled is in motion. The rate of glue applied is determined according to the dimensions of the wood, speed of travel of the applicator head, rate to be applied in g/m² and finger profile



Function scheme

The number of threads is automatically calculated from the height of the wood and is set accordingly. Manual corrections can be made

A counter on the pumps checks, whether the pumps have performed the required number of rotations

Pressure monitoring systems on each pump offer safety if faults occur, e.g. sticking valves or blockages. At the same time, a pressure controller ensures that the inlet pressure in the glue feed

lines remains constant. A separate glue valve is provided for each thread

The linear sled for the applicator head is usually supplied by the finger jointing system manufacturer

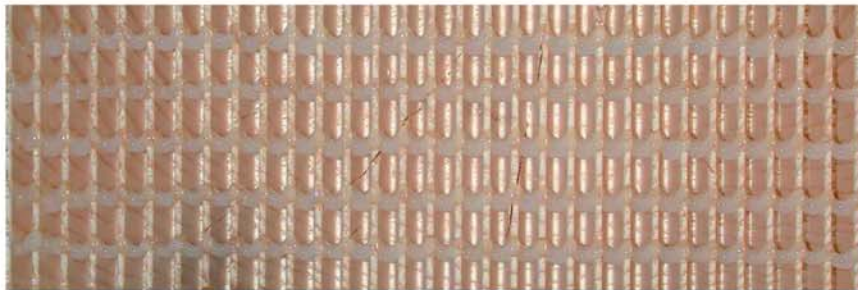
Recognition by the FMPA in connection with approval of a glue is pending

Accessories

Material supply system for flexible positioning of the raw glue container

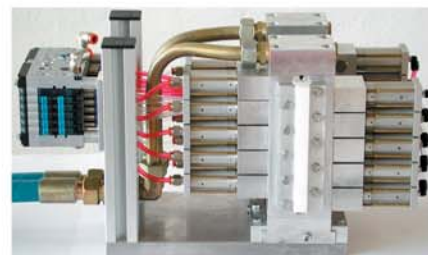
Integrated modem for remote maintenance of the control system

Customised solutions



Technical Data

Glue	1C-PUR glue without abrasive filler max. viscosity 10,000 mPa s
Distance between glue threads	16 (8) mm
Glue application	150 - 220 g/m ² per joint
Throughput rate	up to 12 kg/min depending upon the layout
Power supply voltage	400 V AC / 50 Hz; 3 kW



Applicator head



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