

DATA SHEET

BL Twin

BLOCKHAUSFRÄSE



Double end Log cabin milling machine Blockhausfräse BL Twin for serial production of components for garden log Cabins.

The corner joint „CHALET“ will be done on both ends of the log at the same time.

Optionally can be cut in the same step the chamfer on both end of the log.

Also optionally is possible to calibrate the exact length of the Log by sectional trimmers

The new SERVODRIVE feed system with PLC controlled speed adjustment and express stroke, 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 left and the right machine should be adjusted to the required workpiece dimension (Both machines synchronic). The operator inputs the required length of the workpiece to the display by the numeric keyboard, and with “START” the right, movable unit goes to the proper position.

If length calibration is required, the raw material should be pre cutted 2 - 3 cm longer (For example with cross cutter machine). If length calibration is not required, the logs have to be cutted exactly.

The operator puts the Log from the front onto the machine table. To find the right workpiece position in relation to the working unit is installed one workpiece stop face at each unit.


With the foot switch the operator starts the cycle: The cabin close automatically - the working units horizontal and vertical are doing the milling process - the workpiece will be released and pushed out from working position - the cabin opens automatically. The operator applies the next log to the table, takes the finished away and starts the next working cycle...

Both machines can also be used independent for shorter single jointed pieces.

The working cycle for processing the workpiece on both sides with chamfering and length calibration takes 12 – 15 seconds!



TECHNICAL DATA:

	Working dimensions:		
	Wall thickness x log height	min.: 28 x 100mm max.: 70 x 160mm	without length calibration & without chamfering
		50 x 160mm	
	Workpiece length min. Single joint:	300mm	
Workpiece length min. Double joint:	1000mm		
	Workpiece length max.:	6000mm	
Workingunits:			
			
Drives	(4 + 4) x 4,0kW		
Spindle speed	4200 U/min		
Milling shaft Ø	30mm		
Milling shaft length	175mm		
Tool Ø max.	Hor.: 170mm milling tool / 250mm sectional trimmer Vert.: 220mm		
Tool width max.	60mm		
Feed	SERVODRIVE infinitely variable with express traverse (PLC controlled)		
Adjustment milling support	Trapezoid spindle with digital counter		
Workpiece- holder	Upside: 1 + 1 pneumatic pressing cylinder Frontside: 1 + 1 pneumatic pressing cylinder with pusher for finished workpiece		
Suction	under floor suction (hole) central 2x D=120mm, 30m/min		
Pneumatic supply	Euro coupler, compressed air - dried and cleaned 8 bar, ca. 300l/min		
Current supply	Eurocurrency 400V+N+PE, 21kW		
Weight	ca. 2600kg		
Accessories:			
Calibration of length	Sectional trimmers for length calibration. The raw material should be pre cutted 2-3cm longer. The sectional trimmer on upper spindle of horizontal unit cuts the exact length.		
Chamfer on end of log	Additional tools at front and back vertical spindle for chamfering the ends of the log on both sides. To get a clean cutting surface is mountable a additional small table as support and contra profile.		
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