



Edge Banding Machine for Inclined Edge

NB370(NB7X)

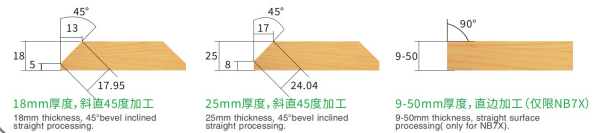
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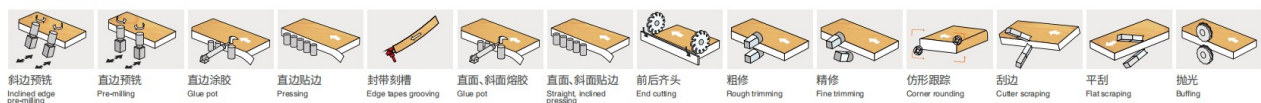
Bevel and straight Edges



Description

NB7X is an excellent solution for handle-free cabinet door. Easy to alternate between half bevel and full straight edges, .Featuring twin diamond cutters, twin glue station, plus a twin tape coil magazine,

封边方向 →
Edge banding direction



Details

1. Machine body

- Heavy duty machine body is welded with thick laser-cut steel plates, then through processing of advanced CNC machine for metal work, hence enhance the stability and strength, reduce the vibration in the process;**very heavy duty**;
- Frame body pass the **heat treatment** and **vibration aging treatment** to guarantees the whole service life without deforming.
- After **sandblasting** and **painting**, the top-grade CNC metal processing machines are used to process the body and components to make sure perfect quality and detail.



2. Professional assembly line

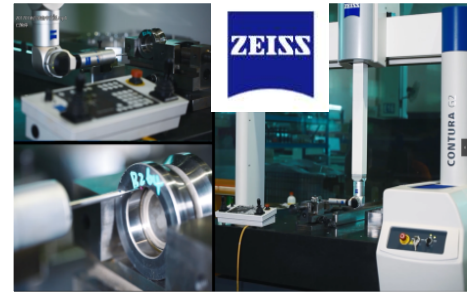
- Nanxing follow the SOP and set up the professional assembly lines. All the assembling is worked out by the experienced technicians that guarantee machine standardization and performance.





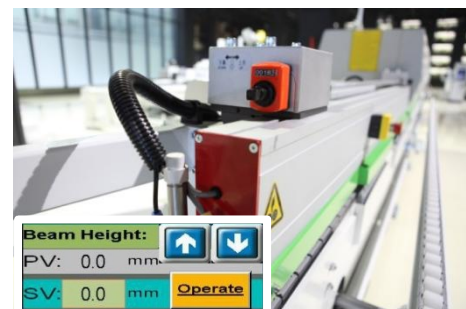
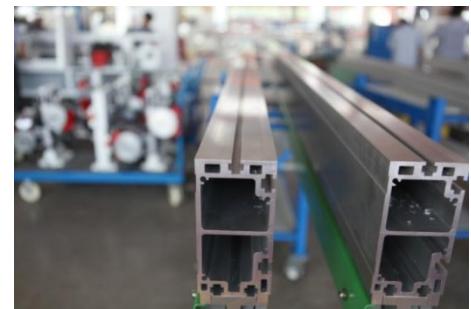
3. Quality control

- Advanced measuring equipment and strict QC system help to make sure the machines and parts are checked and certificated by very high standard.
- All the machines are delivered with Quality Certificate signed by QC specialist.



4. Top presser

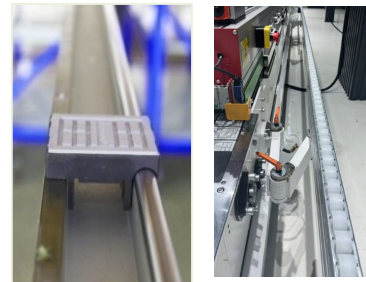
- Aluminum pressure beam provides excellent stiffness and long service life.
- The height of presser beam adjusted automatically based on work piece's thickness just by inputting the work piece information on touch screen which saves a lot of time.
- Rubber rollers connected compactly in rows press work pieces tightly to make sure the work pieces could convey without displacement, wearproof.





5. Conveyor

- Long straight semicircle guide rail is through hard treatment before installation, conveyor piece can perfectly contact with the guide rail, almost no gap.
- Two steel rods of high rigidity connect the “stretched support conveyor” to the machine body to ensure the stable conveying of the wide work pieces. Max stretching width is 600mm.
- Long steel guiding plate of high thickness and rigidity for longer service life and position is easy to adjust.
- The conveyor motor makes variable frequency starting possible, very stable and equipped with braking system. And motor is fully covered by cover.



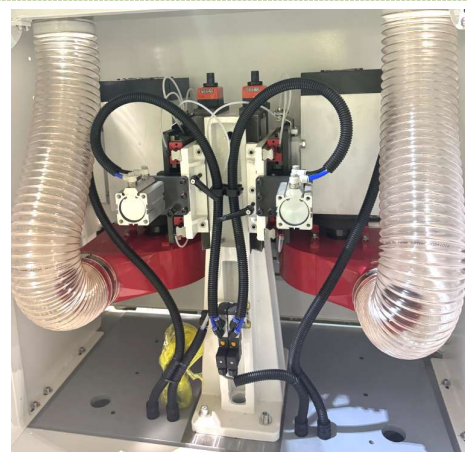
6. Release agent sprayer

- Spraying release agent on workpiece surface reduce the adhere of glue.



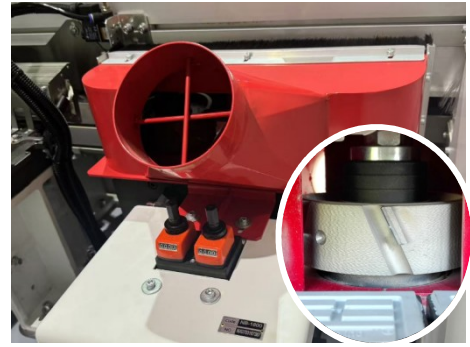
7. Bevel edge milling

- Two pieces of 4kw high-power motors, rotating speed 2800rpm, high rotating speed, low vibration and low noise;
- 45 degrees diamond forming bevel cutters offer higher rigidity, longer service life and stable performance to ensure perfect milling effect without cracks.
- Fully covered cover door, prevent possible influence caused by wood scraps.



8. Straight surface Pre-milling

- Pre-milling with 2 **diamond cutters** $\phi 125^*H43^* \phi 30$ Z3+3 simply mill the work piece edge a little bit to ensure smooth edge before gluing for better edge banding result;
- Two motors controlled pneumatically, milling panel edge intermittent. $2 \times 3.7kW$ motors; 200Hz
Rotating speed: 12,000 rpm.



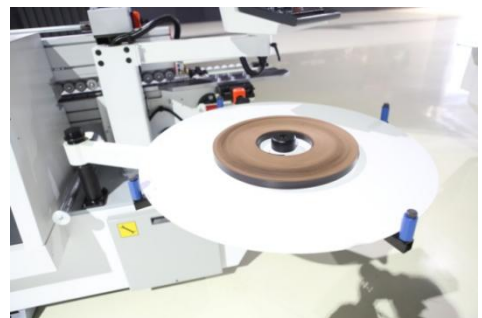
9. Pre-heating

- Warm the work piece edge, the glue could well melt during gluing, especially suitable for wet or cold zones.



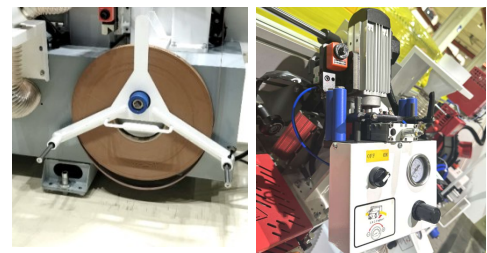
10. Full straight tape bracket

- Full straight and bevel-straight tape brackets and tape feeding are separate, which offers most convenience of switching;



11. Half bevel tape feed and edge tape grooving device

- Edge tape grooving to groove on thicker tape for better folding effect;
- The depth and position of the groove can be adjusted by the digital display band calibration knob, easy operation. Motor power 0.37kw.



12. Full straight edge-Pre-melter gluing system

- Independent straight gluing unit especially for fully straight edge banding work, Pre-melt gluing system has a glue tank on top to offer proper glue volume according to processing, save heating-up time, and a small glue pot on bottom, thus reducing the carbonization and vulcanization from burning up of glue resins, keep glue always fresh.
- Liquid level sensor detection device controls the glue amount accurately so as to prevent overflow.
- Just one screw to release and install glue pot, 60mm high gluing roller, more glue supplying suitable for mass production, long parts.
- Sliding seat, easy to switch between pre-melter and PUR device. (PUR device is option)



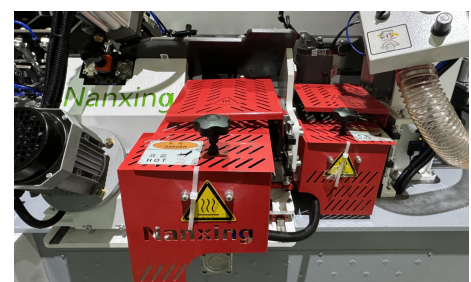
13. Auto glue pumping + 25kg glue basin

- Max 25kg capacity basin, glue would be pumped to pre-melt system's upper pot automatically as soon as lower than level sensor.



14. Bevel and straight gluing

- One straight edge gluing device for straight edge of half bevel edge banding work, and the other for 45 bevel edge.
- Glue is coated on the surface of workpiece edge, so glue line is smaller.



15. Hot air blowing gun (2pcs)

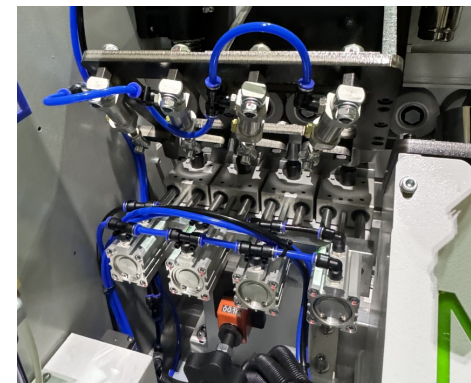
- Hot air gun to warm edge tape makes folded tape stuck perfectly on board, recommend PVC edge tape thickness $\leq 1.2\text{mm}$



16. Edge tape pressing



- Straight edge of fully straight edge banding is done by front straight rollers.
- Bevel or half bevel edge by second set of rollers, and bevel rollers will move back while processing straight edge.



17. Lubrication system

- Lubrication pump for daily maintenance, greasing work of guiding rail just by pulling the handle. Easy and save time.



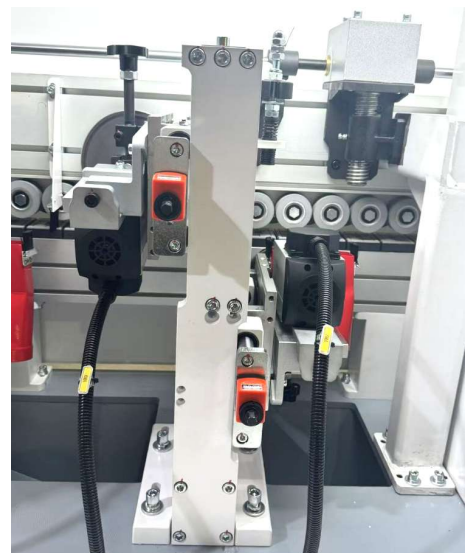
18. End trimming

- Linear guide way structure at an angle of 45 degrees with 2 motors 0.35kw 200hz 12000rpm/min to remove the extra edge tape on front and back. High precision linear guides – for very high repeatability.
- 2pcs of saw blades (105*3*22*24Z) with independent cover.



19. Rough Trimming unit

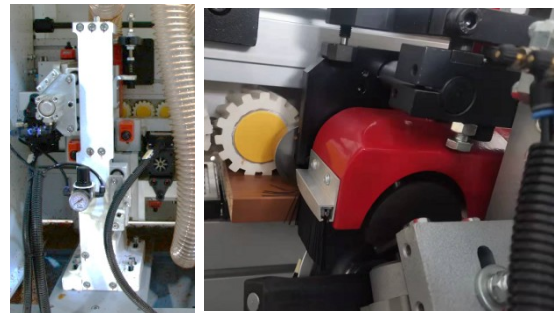
- Rough trimming unit with 2 powerful motors (power 0.75kw; frequency 200hz; rotating speed 1,200rpm/min)
- Pro-nesting copy tracing structure prevent damage on hinge hole





20. Fine trimming unit

- Rough trimming unit with 2 powerful motors of world famous brand (power 0.75kw; frequency 200hz; rotating speed 1,2000rpm/min), 2 milling cutters with two stiff steel positioning guides; R1
- Independent cover keeps scraps from flying, and guiding to machine bottom.



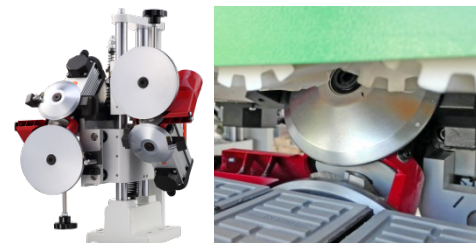
21. Corner trimming unit

- Designed to trim sharp corner on front, back and two straight edges so as to achieve R circular arc radius.
- Driven by 2 motors (power: 0.3kw; frequency: 200 Hz, rotating speed: 12000rpm/min).
- Planar linkage with 4 corner trimming tools R1 3Z
- Rotating angle is adjusted automatic with an electric sensor.
- Diamond cutters.



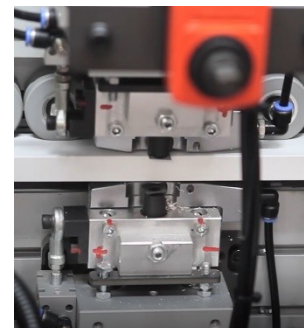
22. Fine trimming

- 2 motors (power: 0.55kw; frequency: 200hz, rotating speed: 12000rpm/min). 2 fine trimming milling cutters (Standard: R1.5);
- Copy wheel with high stiffness and independent cover on cutters for longer service life.



23. Flat scraping

- Flat scraping to remove possible extra glue of top and bottom.



24. Clean agent sprayer

- Spraying clean agent on workpiece surface to clean



25. Buffing

- Buffing by dual screen cloth structure is the last step to make perfect edge banding to make the edge shining, more stable.



26. Dust collection

- Independent suction hood ($\phi 125\text{mm}$) on processing units are fully covered ;



27. Remote Switch

- A switch enables the operator to stop or start the machine anytime during the process that provides the max. convenience to adjust or test the machine.
- Operation indicating light, the operation status of the machine is available at a glance.



28. Safety device

Feeding protector and thickness detection

- Protector prevents any possible accidents and ensures safety of operators, automatic monitoring abnormal operation.
- Work piece thickness detection, if work piece thickness over the limited position, conveyor will stop at once to reduce machine damage.

Interval feeding detection system

- Keep work pieces in proper distance for max edge banding performance.

E-STOP

- To stop running at once, guarantee operator life safety.



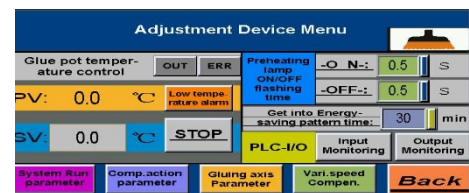
29. Control system

- 10" touch screen. Operation interface is intuitive and simple, available to control each component independently easy for testing and commission work.
- System languages: English, simplified Chinese, and traditional Chinese.



30. Energy saving mode

- Stand-by mode automatically turned on when machine stops working for a certain period (according to setting time) in order to save energy. Only one click to re-start production.
- One-click Selection, quick start/stop.



31. Electric equipment

- PLC control, input voltage 380v, 50Hz (Standard).
- The position can be calculated precisely by encoder
- Each processing unit is controlled and protected by independent frequency converter with motor braking function.
- Most of electric components of the machine adopted international brands for high quality and generality.
- Good documentation, each wire has a unique code label which offers max convenience for troubleshooting and online support.





Technical Data

Panel length:	≥150mm
Panel width:	≥120mm
Panel thickness:	9-50mm(straight) 15-25mm(bevel+straight)
Edge tape thickness:	0.6-2mm (need to leave more straight surface when use 2mm tape, recommend ≤1.2mm)
Feeding speed:	14m/min; Straight Edge:24m/min
Min. panel size:	≥150×120mm
Total power:	42kw
Overall dimension:	9,800×1,050×1,650mm
Net weight:	3900kg

**Thanks for the attention!*

The company continuous to improve the product specifications and design details, the specifications are subject to change without notice. 241116

All the photo in the specification is for reference only!!!