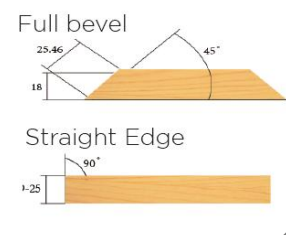
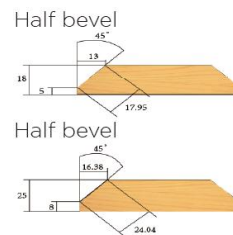


Edge Banding Machine for Inclined Edge NB370(NB7X)

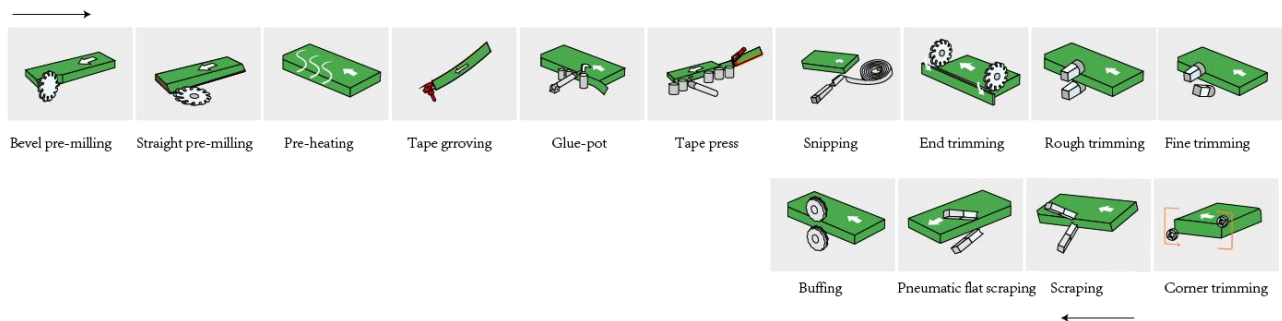


Half and full bevel, plus straight edges



Description

A switch of a button can alternate between bevel and straight edges, with no additional setup time or disruption to your operation. Featuring twin diamond cutters, twin glue station, plus a twin tape coil magazine, the NB7X is brimming with features.



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; Machine net weight up to **3900kg- 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.



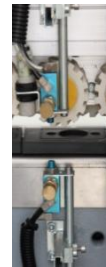
5. Conveyor

- Long straight semicircle guide rail is through hard treatment before installation, conveyor piece can perfectly contact with the guide rail, almost no gap.
- “stretched support conveyor” is strong and easy to adjust Max stretching width is 600mm.
- Long steel guiding plate of high thickness and rigidity for longer service life and extra stability during the banding work. Position is easy to adjust.
- The conveyer motor makes variable frequency starting possible, very stable and equipped with braking system. Easy to install or uninstall.



6. Release agent sprayer

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



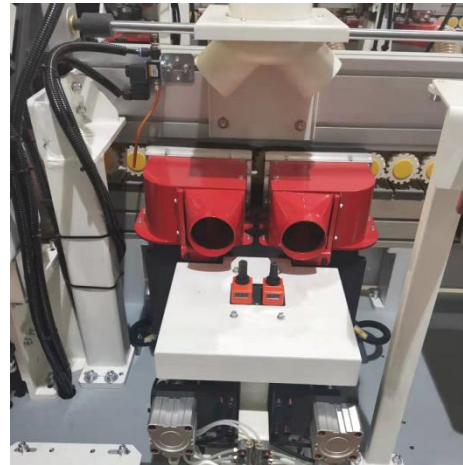
7. Bevel edge milling

- 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 edge pre-milling

- Pre-milling with diamond cutter(LEUCO) motivated by high-frequency motor 2× 3.7kW motors; 200Hz
- Rotating speed: 9,000 rpm.
- Fully covered dust cover.



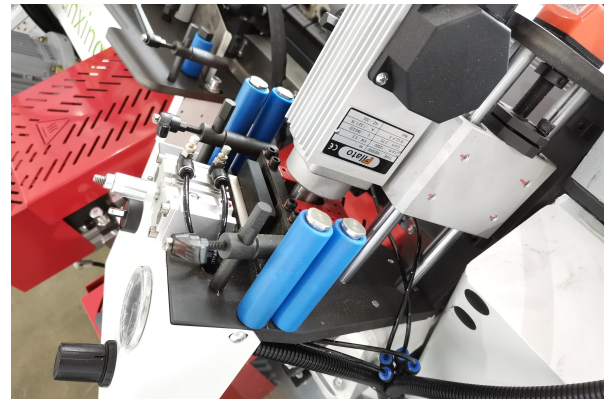
9. Pre-heating

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



10. Edge tape grooving device

- The depth and position of the groove can be adjusted by the digital display band calibration knob, easy operation. Motor power 0.37kw.
- Edge tape feeding by servo, save edge tape effectively.



11. Pre-melter gluing system

- 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)



➤ Pneumatic Adjust Gate (Controlled By Cylinder)

12. 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.



13. 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.
- Easy to move out for maintenance.



14. Hot air blowing gun (2pcs)

- Need to add hot air gun to warm edge tape if you use ABS this kind of fragile edge tape, but PVC is most suitable edge tape



15. Edge tape pressing



- Straight edge of fully straight edge banding is done by front straight rollers.(point 10).
- Bevel or half bevel edge by second set of rollers, and bevel rollers will get back while processing straight edge.



16. Lubrication system

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



17. 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.
- With dust cover



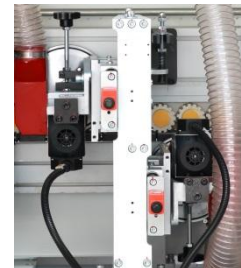
- **Fast move back structure**, move a little backward while doing bevel edge, move forward while doing straight edge so as to achieve fast switch between bevel edge and straight edge banding work, different cutting position for two kinds of edge ensures higher edge banding quality and avoids possible collision or damage on edge tape.



18. Rough Trimming unit

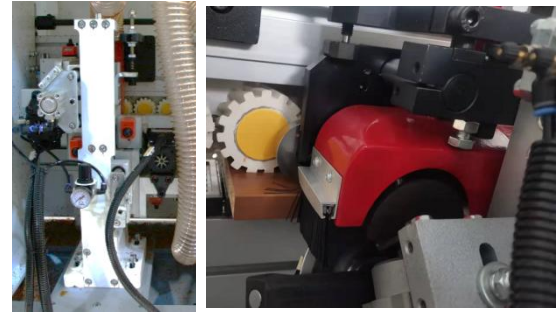
- Rough trimming unit with 2 powerful motors of world famous brand (power 0.75kw; frequency 200hz; rotating speed 1,200rpm/min), 2 milling cutters with two stiff steel positioning guides;

Independent cover keeps scraps from flying, and guiding to machine bottom.



19. Fine trimming unit

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



20. 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 R2 3Z



21. Profile scraping unit

- Scraping the edge by R2 cutters (Standard), making edge banding more beautiful;
- Pro-nesting copy tracing structure prevent damage on hinge hole.



22. Lat scraping

Remove possible extra glue of top and bottom for better edge banding effect



23. Clean agent spray

- Spray clean agent mist on edge surface to clean possible excessive glue sticking on edge, thus least glue line, without need of cleaning by hand.



24. Buffing

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



25. Dust collection

- Independent suction hood ($\phi 125\text{mm}$) on processing units are fully covered totally 6 dust collectors.



26. 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.



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.



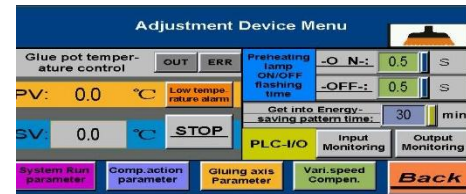
28. Control system

- 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.



29. Energy saving

- 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.



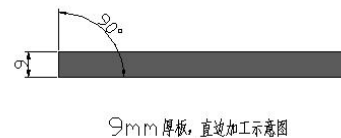
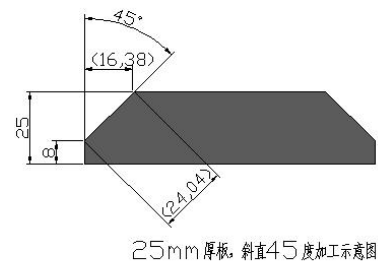
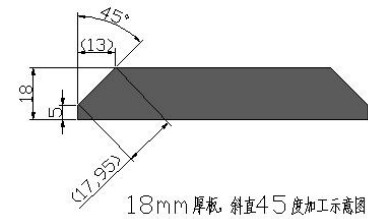
30. Electric equipment

- 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.



31. Processing diagram

- The thickness of panel is 18mm, and the Angle is 45 ° inclined.
- The thickness of panel is 25mm, and the Angle is 45 ° inclined.
- The thickness of panel is 9mm, and it is Straight side.





Technical Data

Panel length:	≥150mm
Panel width:	≥120mm (inclined) ≥150mm (straight)
Panel thickness:	9-50mm(straight) 15-25mm(half bevel) 15-25mm(fully bevel)
Edge tape thickness:	0.4-2mm
Feeding speed:	14/18m/min
Min. panel size:	≥150×120mm
Dust collector	φ125mm×6
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. 220310