

## Edge Banding Machine with Double Gluing Units for Narrow Edge NB671EMN (NB7CJMN)



### Description

Compact press rollers cooperate with additional assistance rollers on front and in between make it possible to do edge banding work for min 30\*200mm, and 45mm end edge.

Two sets of gluing, fine trimming, scraping and buffing units make it easy and fast to switch between dark and light color glue which meet flexible edge banding requirements. Cutters of one set of fine trimming, scraping are able to move backwards automatically if changing to the other color glue, set-up time tends to zero. Low investment, big benefits.

封边方向 EDGE BANDING DIRECTION →

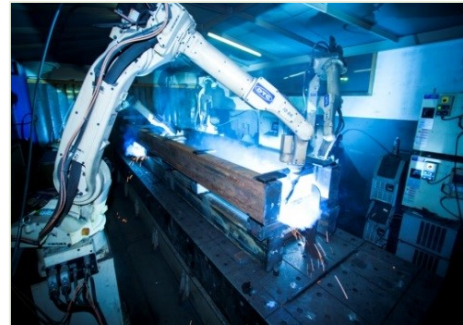


## Details

---

### 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; Machine net weight up to **3670kg- 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.



---

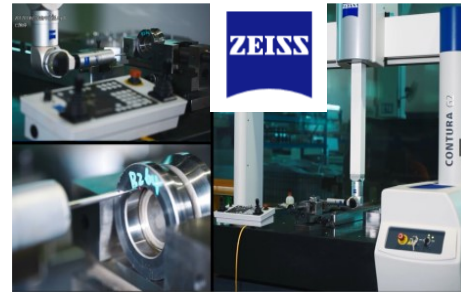
### 2. Professional assembly line

- 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.



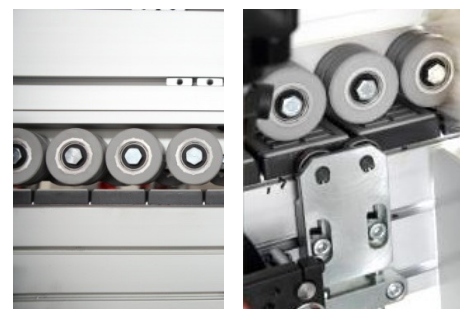
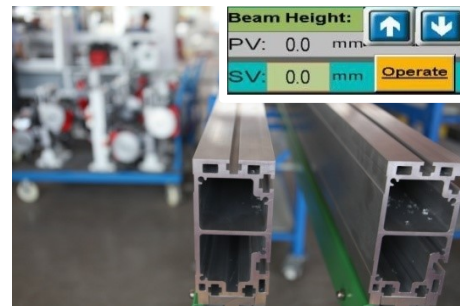
### 3. Quality control

- 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.
- Smaller rubber rollers connected compactly in rows press work pieces tightly plus side roller assistance to ensure smooth conveying of narrow workpieces.



## 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 conveyer motor makes variable frequency starting possible, very stable and equipped with braking system. Easy to install or uninstall.



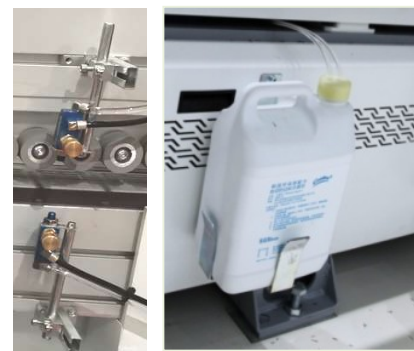
## 6. Assistance for narrow edge

- Narrow edge like min 45mm short end or 40min-width long edge is accessible thanks to the feeding assistance at front and additional assistance roller specially designed for narrow edge.



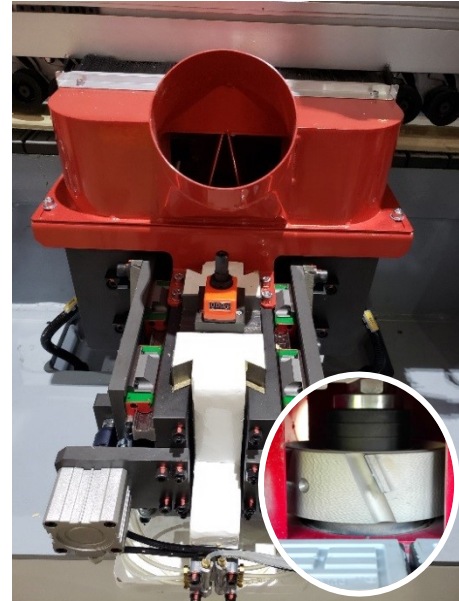
## 7. Sprayer unit-Cleaning agent

- Release Agent before pre-milling;



## 8. Pre-milling

- Pre-milling with 2 **diamond cutters**  $\varnothing 125 \times H35 \times \varnothing 30$  Z3+3 simply mill the work piece edge a little bit to ensure smooth edge;
- Two motors controlled pneumatically, milling panel edge intermittent.  $2 \times 3.7\text{kW}$  motors; 200Hz  
Rotating speed: 12,000 rpm.



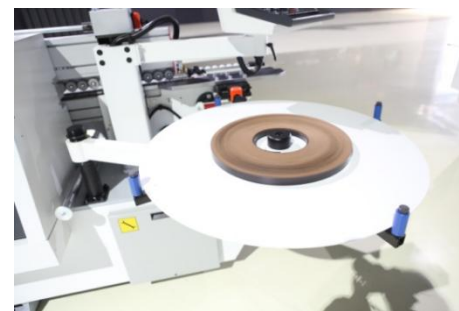
## 9. 2 sets of pre-heating

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



## 10. Coil tape bracket\*2

- Big edge tape bracket is in proper height for smooth edge tape feeding and longer service life. Machine screen will appear alarm when edge tape is used up. Save waiting time.



## 11. Tape Snipping\*2

- Snipping air cylinder with electric controlled switch to cut the edge tape properly.





### 12. 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, 50mm diameter gluing roller, more glue supplying suitable for mass production, long parts and least glue line.
- Sliding seat, easy to switch between pre-melter and PUR device. (PUR device is option)

Pneumatic Adjust Gate (Controlled By Cylinder)



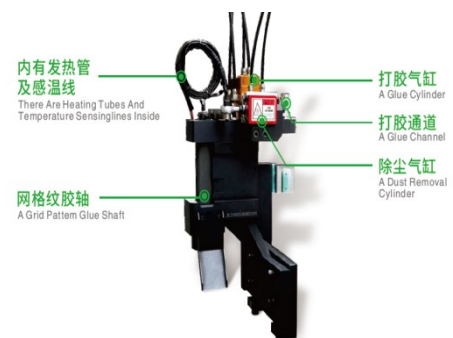
### 13. Auto glue pumping + 25kg glue basin

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



### 14. PUR gluing applicator

- The unique glue gate structure utilizes a diverting scraper principle, preventing wood chips from clogging the glue shaft and eliminating stroke limitations, resulting in even and stable adhesive application. The upper cover is made from a single piece of ductile iron, ensuring high precision with a multi-seal design to prevent glue leakage during high-temperature use.



## 15. 2-color PUR heater

- It allows for quick switching between two types of PUR adhesives, enhancing processing efficiency.
- The intelligent control touchscreen makes operation simple and convenient.
- The integrated aluminum alloy pressure plate ensures uniform heating, high-temperature durability, and resistance to deformation.
- It uses imported Teflon heating glue tubes, which are durable, flexible, and have better non-stick properties.



## 16. 2 sets servo edge tape feeders

- Compared with traditional edge tape feeder, higher trimming precision controlled by servo motor, cost saving up to RMB 20-50K per each machine due to shorter hanging out of tape at two ends.



## 17. 2 sets of pressure rollers

- Each set of rollers for one set of gluing unit. One pre-pressure roller of 100mm diameter coordinates well with four post rollers make edge tape pressed on edge surface firmly.



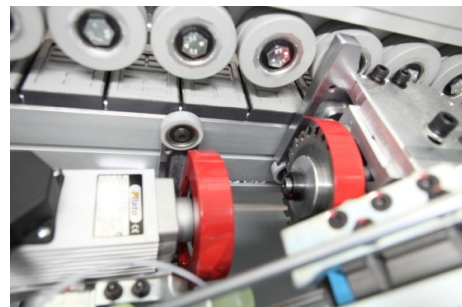
## 18. Lubrication system

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



## 19. 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 guide for very high repeatability
- 2pcs of saw blades (105\*3\*22\*24Z) with independent cover.



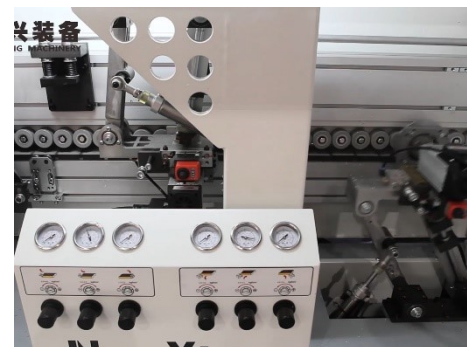
## 20. 2 sets of fine trimming units with 2 position pneumatic

- Each set with 2 motors (power: 0.55kw; frequency: 200 Hz, rotating speed: 12000rpm/min). (Oneset with R1.5, the other with R1); 2 fine trimming milling cutters move backwards automatically if changing to the other color glue, and tool position can be adjusted based on edge tape thickness by cylinder, set-up time tends to zero.



## 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 R1.5 3Z
- Rotating angle is adjusted automatic with an electric sensor.



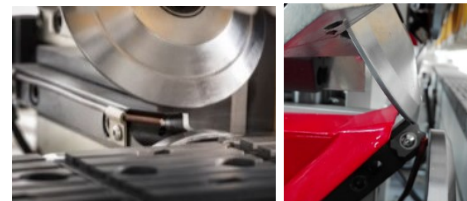
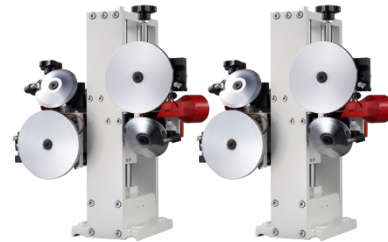
## 22. Dust collection

- Independent suction hood ( $\phi 125\text{mm}$ ) on processing units are fully covered, totally 8pcs dust collectors



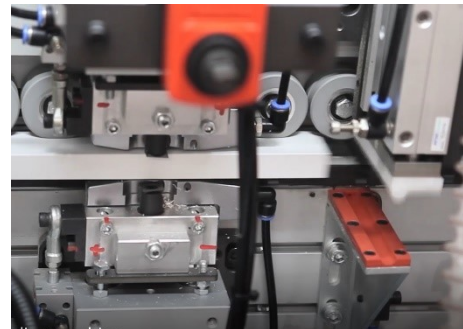
## 23. 2 sets of scraping units with 2 position pneumatic

- Two sets scraping units with scraping cutter in different circular arc radius. (One set with R1.5, the other with R1), making edge banding more beautiful. Cutters move backwards automatically if changing to the other color glue, set-up time tends to zero.
- Air blowing device blowing toward the scraping cutters on upside and underside for cleaning the scraps on cutter surface and cooling.



## 24. Off cut device and flat scraping

- Off cut device cleaning tape threads from scrapping, as to prevent any problem later during flat scraping and buffing, then flat scraping to remove possible extra glue of top and bottom.



## 25. Clean agent sprayer

- Clean Agent to clean edge before buffing.



## 26. 2 sets of buffing units

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



## 27. 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.



## 28. Remote switch and indicator light

- A remote 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.



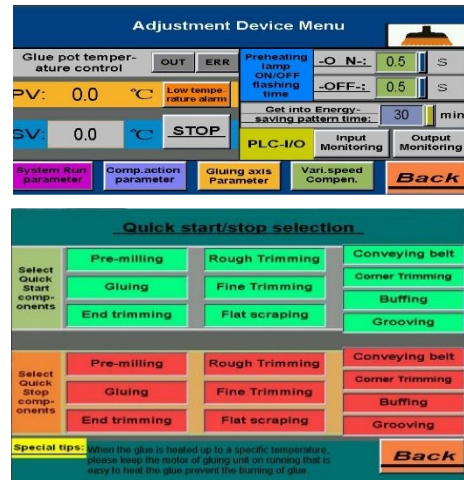
## 29. Control system

- 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.



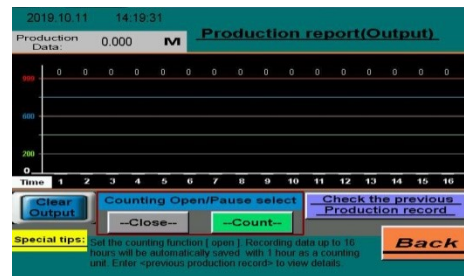
### 30. Energy saving

- 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. Production report

- Daily production included workpieces number and length is available at a glance



### 32. Electric equipment

- PLC control, input voltage 415v, 50Hz.
- 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.



### 33. Narrow workpiece solution

- Short edge: 45\*200mm end  
Long edge: 30\*200mm





## Technical Data

---

<b>Model</b>	NB7CJMN
<b>Narrow long edge</b>	40×200×9mm
<b>Narrow short edge</b>	45×200×9mm
<b>Panel thickness (narrow edge Corner trim on)</b>	≤25mm
<b>Panel thickness</b>	9-60mm
<b>Edge tape thickness</b>	0.4-3mm
<b>Feed speed</b>	16/18/20m/min
<b>Feed speed(narrow edge Corner trim on)</b>	16m/min
<b>Dust extraction</b>	φ125mm×5
<b>Total power</b>	30.1kw
<b>Overall dimension</b>	9800×1450×1650mm
<b>Net weight</b>	3670kg

*\*Thanks for the attention!*

*The company continuous to improve the product specifications and design details, the specifications are subject to change without notice. 200410*