



## Single Line 1

- Formed by the efficient combination of a horizontal four-head welding machine with CNC corner cleaning machine and automatic turning station in one production unit
- All phases of the operation, from the loading of the profiles to the welding and corner cleaning process, up to the unloading of the frames or sashes, are controlled by the computer
- All CNC systems and other electronic equipment is controlled by Beckhoff programming
- All rails are coated to prevent oxidation

## KD 658

### Welding

- Welds four corners of PVC profiles simultaneously at 90° with high accuracy
- Allows fast data input via 10.4" touch screen
- Ability to compose a database of at least 200 profiles with 9 parameters for each profile (melting, welding and cooling times, height, width, profile number, color, welding fixture number, manufacturer code)
- Easy adjustment to weld color profiles as well as white ones - 2mm and 0.2mm setting
- The temperature is digitally controlled to provide the correct burn off
- Summer/winter working mode is automatically selected
- Heated welding knives provide better welding results in cold weather conditions
- Welding fixtures can be changed easily and fast
- Central lubrication system eases maintenance
- Automatic Teflon wrapping device shortens the time needed to change Teflon
- Network connection for data transfer

## CK 187

### Buffer

- Cooling station which transfers the welded frames or sashes from four head welding machine to turning station for corner cleaning
- Waiting time for cooling controlled by the computer of the welding machine



## **CK 172**

### **Turning Station**

- Automatically transfers the frame or sash and positions the corners one by one into the corner cleaning machine
- Transports the processed frame or sash to the off loading area

## **CN 772**

### **Corner Cleaning**

See CN 772 on page 40 of the catalogue

### **Optional**

AK-002 Barcode reader

AK-032 Gasket pressing system

AK-000 Hinge hole marking

### **KD658 - Technical Features**

- Power supply 415V, 3ph, 50-60Hz
- Power output: 12kW, 32A
- Standard welding length: 3,000mm x 2,580mm
- Min standard welding length: 420mm x 420mm
- Welding length with gasket pressing: 500mm x 500mm
- Max profile height: 180mm
- Min profile height: 30mm
- Max profile width: 120mm
- Air pressure: 6-8bar
- Machine height: 1,600mm
- Machine length: 4,600mm
- Machine width: 4,300mm
- Machine weight: 1,665kg

### **CN 772 & CK 172 - Technical Features**

- Power supply: 415V, 3ph, 50-60Hz
- Power output: 8kW, 22A
- Saw blade dimensions: Ø250 x Ø30 x 3.2mm, Z=80
- Saw blade rotation: 5200rpm
- Max outer frame dimension
- Automatic mode: 2300 x 2300mm/Manual mode: No Limit
- Min outer frame dimension: 420 x 420mm
- Max profile height: 200mm
- Min profile height: 30mm
- Max profile width: 120mm
- Air pressure: 6-8bar
- Machine height: 1900mm
- Machine length: 1910mm
- Machine width: 900mm
- Machine weight: 740kg