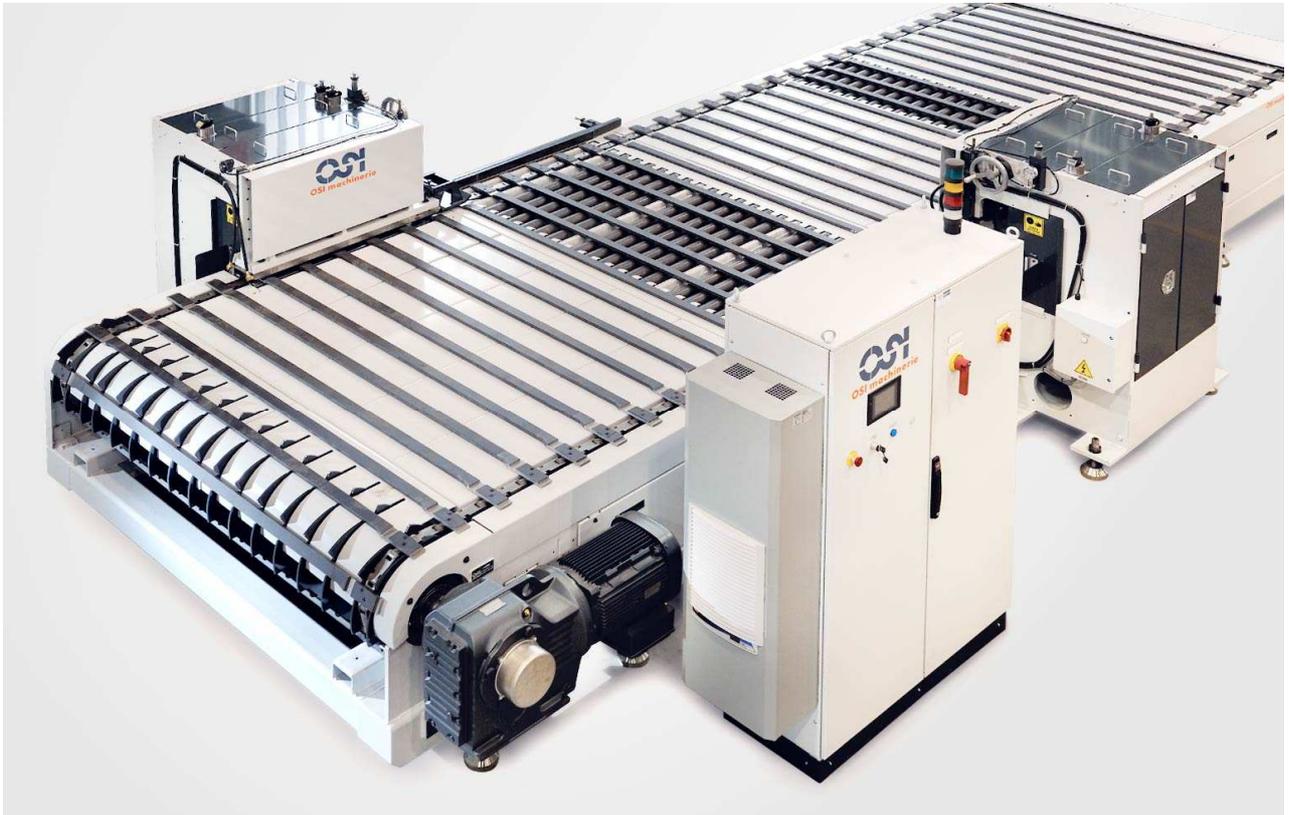


END MATCHER FEATURES, SPECIFICATIONS AND OPTIONS



STANDARD MACHINE FEATURES

Sprocket squaring accuracy of 0.001" per inch of material width

- Made of steel and machined from the mass
- 2 1/4" thick
- Easy to adjust for squareness enhancement
- Reversible and replaceable sprocket teeth



Precision ductile iron chain machined from a solid bar

- Will hold the tolerance and guarantee the accuracy



5/8" thick machined spring steel bar

- Will remain aligned
- Prevents pieces from going under
- Held in place with shoulder bolt for accuracy
- Machined from a solid T1-100 bar



Heads and saw motor modifications

- Modular and integrated to End-Matcher frame
- Very sturdy with 1 1/4" thick wall, made of stress-released steel plates, machined to accommodate the motor base
- Equipped with an adjustable chrome presser plate
- Saw motor flange machined by OSI to reduce blade floating (0.010" to 0.025" on std. bearing to 0.002" after machined)
- Saw motor bearing have better tolerance with built-in seals
- Additional seals on the saw motor
- 2 axes base, machined in house for more accuracy with 0.001" increments for adjustment
- Completely enclosed for better waste and dust cleaning
- Safety door locks



Accurate chain lubrication system

- Oil mist and compressed air
- Perfect injection timing to keep the chain clean

STANDARD MACHINE

1.1 End Matcher general specification

- Cross Bar/Cross transfer type
- Material minimum length of 8"
- Material maximum length of 84"
- Machining thickness of 7/16" to 1 1/2"
- Machining maximum width: 5"
- Chain pitch of 8" center to center
- Squareness accuracy of +/- 0.001" per inch of width
- Feed speed variable from 80 to 170 lugs per minute
- Orientation: face-up, tongue right, groove Left
- Length of 306"
- Width of 159" including heads
- Height of 64"
- Weight of 27 000 lb
- Working height of 36"
- Security features
 - Double board detector
 - Safety lock on head door
 - Over board length detector
 - Anti-return detector

1.2 End Matcher frame

- Transversal rollers run before each machining head to ensure lateral movement of the boards
- Rolls are 3" OD mounted on ball bearings driven by a V-belt and a 1.5 hp motor with gearbox reducer; the 2 first rollers are chrome-knurl to speed up lateral movement. Rolls are machined to get an accurate rotation, which prevent material oscillation
- Exit in line
- Modular frame for future extension before and after the machining stations. (Please refer yourself to the drawing)

1.3 End Matcher feed

- Forward movement is driven by a 20 hp SEW Eurodrive motor with a gearbox reducer
- 4" diameter drive shaft
- 2 1/4" thick drive sprocket with reversible and replaceable teeth
- Cast iron chain links developed by OSI Machinerie, machined for high accuracy and stability against stretching, equipped with replaceable hardened steel bushings
- The chain has been designed to avoid the need of an extra device to kick the piece out of the chain when exiting the machining heads, this is very important when processing short material
- Equipped with a chain lubrication system (oil mist and compressed air) to reduce wear out on the chain
- Lugs are made of 5/8" thick steel and machined for high accuracy

1.4 End Matcher machining station

- Groove and Tongue Station are modular units with walls made from 1¼" thick, machined, stress-released steel plates to ensure precision and stability
- Both machining heads come equipped with an adjustable chrome pressure plate and position locks
- Hydraulic locks on the top presser and on each head
- Mechanical readout on all axes
- Cooling system on each heads
- Perske saw arbor motors
- 5 hp saw arbor to drive 12" trim saw and 10" V-joint shaper on the groove station
- Jumping head including 2 units of 6" blades and 7.5 hp motor on the groove station
- 5 hp saw arbor to drive 12" trim saw and 10" V-joint shaper on the tongue station
- 2 units of 5 hp saw arbor to drive 10" tongue shapers (top and bottom) on the tongue station
- Each of the above motors is mounted on a 2 axis adjustable precision base
- Enclosed heads for efficient vacuum cleaning
- Waste outlet (vacuum) 2x 8" diameter, one per head
- SCFM requirement: 1745 SCFM minimum for each of the 2 ports
- 120 PSI static air pressure from 3/4" pipe

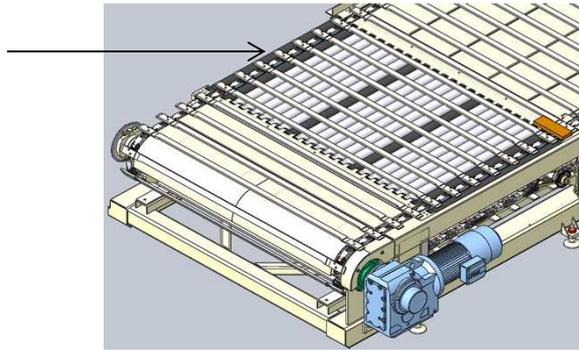
1.5 End Matcher electrical panel

- 460 Volts, 60 Cycles, 3 phases
- CSA and UL approved
- PLC (to automate all sequences for motor start-up)
- Communication ready for remote technical support
- Limit switch for excessive length positioned on the first roller run
- Limit switch for excessive thickness before tongue station
- Limit switch for excessive thickness before groove station
- Proximity switch under the chain before each head to sense if the chain is not too high, to prevent pressure shoe damages in the head
- Safety trap above the chain return
- Emergency stop (CAT 3)

AVAILABLE OPTIONS

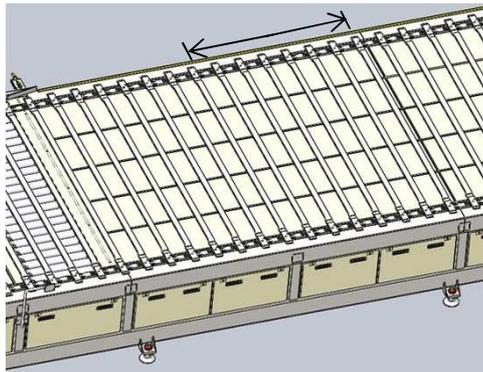
2.1 Cross outfeed roller section

- Automatically moves the boards from the output of the machine to your next production step



2.2 Additional 5ft frame section

- 5ft long frame section allows the addition of a chop saw
- The desired number of sections can be added to your application



2.3 Movable blade device

- Movable blade device for groove station specially designed to eliminate split out
- Working with 2 un. 6" diameter blades (one clockwise and another counterclockwise)

