

on semi automatic two side molder ▶

Mechanically processing blanks on semi-automatic two-sided milling machine, it is possible to make simultaneously two similar or different profiles at two front sides of blank. This process consists of four stages:

1. Both sides of the panel are undercut from the top and bottom.
2. Oversize is crushed with spiral saw.
3. On the edges required profile is machined with profile cutter.
4. If necessary, chamfer can be made with special cutter.

HAPAKS
Size of board:

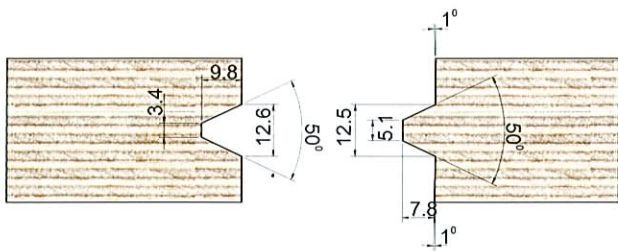
Length
min 100mm
max 3500mm

Width
Min 260mm
max 3500mm

Thickness
max 60mm

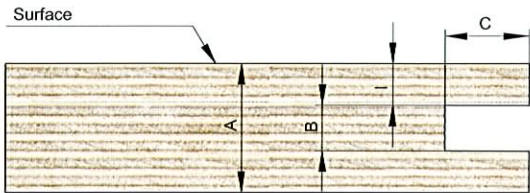
profile types

▶ H-TG 1



Could be used for panels with thickness of 18...38 mm.

▶ Groove H-G



Tolerance: for size C +0,3 /0 mm; for size B -0,1/+0,3 mm; for size l ±0,2 mm. Tolerance after assembling is analogous to profile H-TG.

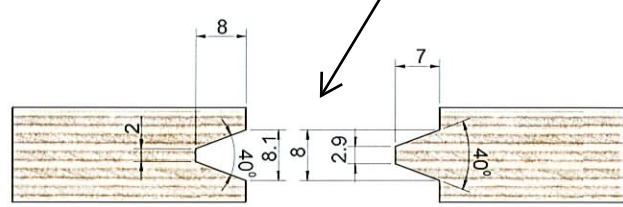
A	9	12	15	18	21	24	27	30
l	2	4	5	6	7	7	9	10

Profile	A	B	C
H-G1	9...15	4	11
H-G2	18...21	6.5	11
H-G3	24...30	9	11
H-G4	9	4	20

C_{max} 40mm

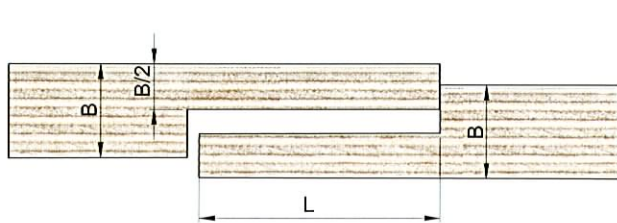
PROFILNAMN

▶ H-TG 2



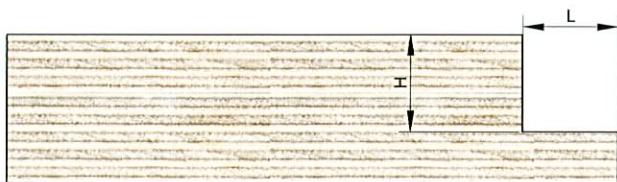
Could be used for panels with thickness of 12...27 mm. Is recommended for panels of 15 mm thickness.

▶ Half lap H-PS



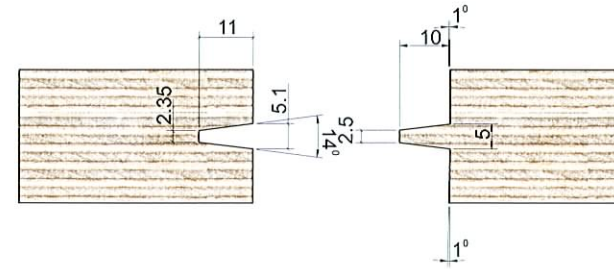
For thickness of 9-60mm. L_{standard} = 50 mm; L_{spec} = 1-50mm. Tolerance after assembling is analogous to profile H-TG.

▶ Partial groove H-DG



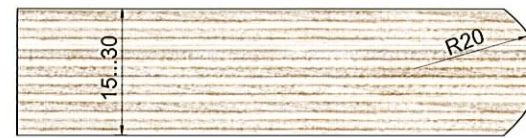
H = 1...50 mm, L = 1...50mm. These sizes of profile should be always agreed on. Production tolerance: for sizes L and H ± 0,3mm.

▶ H-TG 3



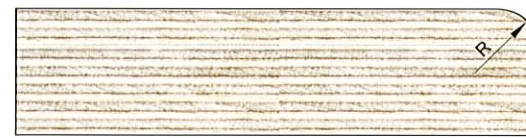
Could be used for panels with thickness of 12 ... 27 mm. Advisable thickness of panels is 15 mm.

▶ Profile for table top H-M 4



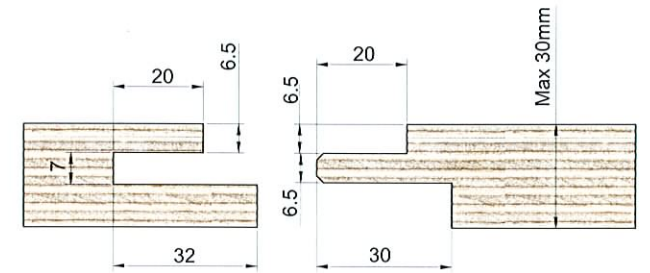
Could be used for panels with thickness of 15 ... 30 mm.

▶ Rounding H-R



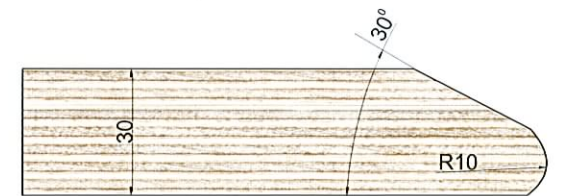
Possible radius R = 3, 5, 8 mm.

▶ H-TG 4



Could be used for panels with thickness of 18 ... 30 mm.

▶ Profile for table top H-M 11



Could be used for panels with thickness of 30 mm.

▶ Chamfer H-L



L = 0...90°; A_{max} = 30 mm. Production tolerance: for size L = 1°; for size A=±0.5mm.

Production tolerance: Width after processing ±0.3mm/lm (±0.2mm/m)*; difference of diagonals max 0.3mm/m (max 0.2mm/m)*; deviation of profile perpendicular to base plate ±0.2mm (±0.1mm)*.

