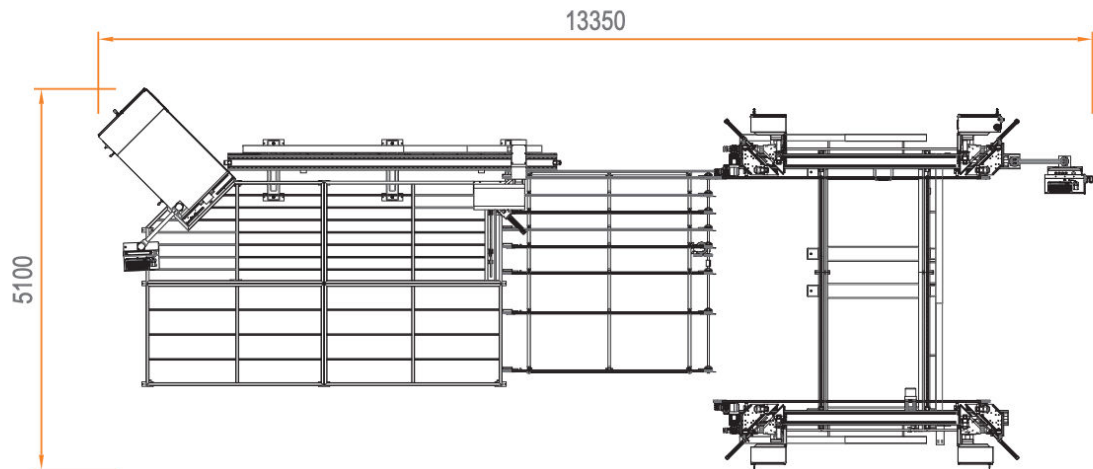




Single Line 2

- Formed by the efficient combination of a **KD 658/20** Four Head Welding Machine, **CK 187** Buffer Station, **CK 180** Faster Turning Station and **CN 772** CNC Corner Cleaning Machine in one production unit
- Welded frame or sash is automatically transferred to corner cleaning machine with all the data about the profile
- All phases of the operation, from 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
- CN 772 Corner Cleaning Machine can start cleaning while the Four Head Welding Machine starts the welding process
- Servo controlled CK 180 Faster Turning Station turns the frame or sash at an appropriate speed depending on its size and provides four corners to be cleaned
- The corner cleaning machine automatically adjusts the rotation speed after receiving data from the welding machine about geometric shapes, measurements and calculation of reinforcement steel weight
- High mechanical stability, servo controlled CK 180 Faster Turning Station enables fast and stable turning with high accuracy. Small frames take 1 second, large frames take 1.5 to 4 seconds. The positioning can be done by turning the corner
- Profile identification information is automatically transferred from the welding machine
- Durable and precision movement of the axis due to hardened rack and zero backlash gear boxes used in the gear system
- By online connection to the entire system, remote detection of malfunctions and maintenance is available
- The rails are specifically coated to prevent corrosion
- Central lubrication system eases maintenance
- Data transfer is available via network & connection or USB storage



KD 658/20 – Four Head Welding Machine

- Welds four corners of PVC profiles simultaneously at 90° with high accuracy
- At automatic production mode, works according to the data obtained from window and door production software
- PC controlled (PID) heat control system to sustain strong welding results in compliance with international standards
- Heating temperature, melting and welding times can be adjusted individually for every profile type
- Specially designed long lasting heating plates distributes heat homogenously without being affected by weather conditions
- Pre heated welding knives provide better welding results in cold weather conditions
- Welding fixtures can be changed easily and quickly
- High performance industrial PC operated by Windows 10 operating system, which works between 0°C and 55°C without the need for a fan
- 19" LED Monitor
- Data transfer is available via network connection or USB interface
- A database of welding parameters for every individual profile defined by the user (up to 6,000 parameters)
- All heads are moved by hardened steel ball-screw which provides accuracy and durability
- Measurement control system ensures high accuracy welding
- Settings available for white and coloured profiles
- Summer and winter working mode is automatically selected
- Central lubrication system eases maintenance
- Long lasting Teflon usage and easy change by special Teflon system
- All error messages can be monitored from the screen by the software
- By online connection to the entire system, remote detection of malfunctions and maintenance is available



CK 187 – Buffer Station

- 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 180 – Faster Turning Station

- CN 770/20 and CN 772 CNC Corner Cleaning machine works integrated
- 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 – CNC Corner Cleaning Machine

- 4 Axis high-speed servo controls allow fast working with high accuracy
- Shorter work cycle by simultaneously processing on both the lower and upper surfaces of the frame
- High quality surface cleaning by the use of different grooving knives
- 11 different specially designed tools gives ultimate results in corner cleaning
- White & coloured frames, as well as gasket retracted and plain profiles, can be chosen from the screen and cleaned automatically
- Ergonomic operator terminal
- High performance industrial PC with Windows 10 operating system, which works between 0°C – 55°C without the need for a fan
- User friendly unique interface allows new programmes to be created and existing ones to be edited easily, by using the .dxg drawing of profiles on the screen
- All error messages can be monitored from the screen
- Online connection to the entire system, allows remote detection of malfunctions and maintenance
- The software cleans unnecessary processes and sustains maximum security against virus attacks and user faults, during every system start up and shut down
- Data transfer is available via network connection or USB interface
- There is no limit to the number of profile dimensions and properties stored
- Ability to automatically back-up data on a daily basis onto an internal storage device
- Using a shift monitoring system, all operations can be controlled daily, weekly, monthly and annually
- Central lubrication system eases maintenance
- The rails are coated to prevent corrosion
- Ability to connect to a single line machine



Technical Features

KD 658/20

- Power supply: 415V, 3ph, 50-60Hz
- Power output: 11.75kw, 30.9A
- Standard welding length: 3,000mm x 2,585mm
- Min standard welding length: 420mm x 420mm
- Welding length with gasket pressing: 520mm x 570mm
- 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

- Power supply: 415V, 3 ph, 50-60Hz
- Power output: 14kW, 38A
- Saw blade dimensions: Ø250 x Ø30 x 3.2mm, Z=80
- Saw blade spindle speed: 5,200rpm
- Max profile height: 170mm
- Min profile height: 30mm
- Max profile width: 120mm
- Min outer frame dimension: 420 x 420mm
- Air pressure: 6-8bar
- Machine height: 1,900mm
- Machine length: 1,910mm (2,970mm with frame support table)
- Machine width: 900mm (2,390mm with frame support table)
- Machine weight: 740kg