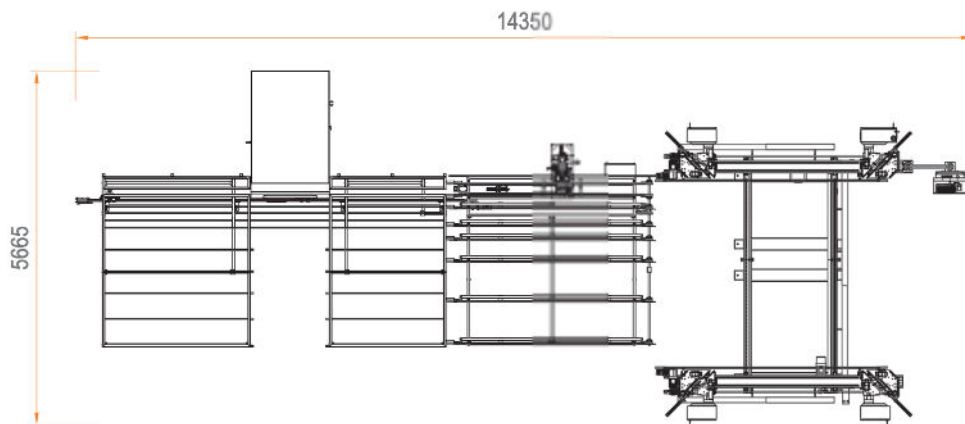




Single Line 3

- Formed by the efficient combination of a **KD 658/20** Four Head Welding Machine, **CK 188** Buffer Station, **CK 176** Automatic Turning Station and **CN 776** 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 776 Corner Cleaning Machine can start cleaning while the Four Head Welding Machine starts the welding process
- Computer controlled triple handle drilling and espagnolette canal milling is processed while the frame or sash is cooling at the buffer station
- The CK176 Automatic Turning Station turns the frame or sash at an appropriate speed related with the size and provides four corners to be cleaned
- 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 188 – Buffer Cooling 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
- Computer controlled triple handle drilling and espagnolette channel milling

CK 176 – Turning Station

- Works integrated to the CN 776 CNC Corner Cleaning Machine
- Automatically transfers the frame or sash and positions the corners one by one into the corner cleaning machine
- Two under table transporters and clamping system enables faster operation
- Transports the processed frame or sash to the off loading area

CN 776 – CNC Corner Cleaning Machine

- Four axis high-speed servo controls enable fast working with high accuracy
- Shorter work cycle by simultaneously processing on both the lower and upper surfaces of the frame
- Using different grooving knives enables high quality surface cleaning
- Ultimate results in corner cleaning by 11 specially designed tools
- White and coloured frames as well as gasket retracted and plain profiles can be chosen from the screen and cleaned automatically
- Kiosk type ergonomic terminal can be easily moved to every corner around the machine
- High performance industrial PC with Windows 10 operating system, which works between 0°C and 55°C without the need for a fan
- User friendly unique interface allows new programs to be created and existing ones to be edited by using the .dxf drawings of profiles on the screen
- All error messages can be monitored from the screen
- By online connection to the entire system, remote detection of malfunctions and maintenance is available
- The software cleans unnecessary processes and sustains maximum security against virus attacks and user faults at every system start-up and turn-off
- Data transfer is available via network connection or USB interface
- Infinite number of profile dimensions and properties can be stored
- Ability to automatically back-up daily data on internal storage unit
- With shift monitoring system, all operations can be controlled daily, weekly, monthly and yearly
- Central lubrication system eases maintenance
- The rails are specially coated to prevent corrosion
- Ability to connect to a single line machine

Optional

Barcode reader

Gasket pressing system

Automatic 0.2mm & 1.2mm welding seam restriction setting



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 776

- Power supply: 415V, 3ph, 50-60Hz
- Power output: 17kW
- Saw blade diameter: 250mm
- Min outer frame dimension: 370mm x 370mm
- Max outer frame dimension: 2,300mm x 2,300mm (auto mode)
- No limit: Manual mode
- Max profile height: 200mm
- Min profile height: 30mm
- Max profile width: 130mm
- Air pressure: 6-8bar
- Air consumption: 148 l/min
- Machine height: 2,200mm
- Machine length: 1,850mm
- Machine width: 1,250mm
- Machine weight: 990kg