

Ligmatech Automationssysteme GmbH • Ligmatech Str. 1 • D-09638 Lichtenberg

Order Confirmation

Projecta Oy
Lukkosepänkatu 14
20321 TURKU
FINNLAND

Order number	:	098064
Customer	:	
Machine number	:	0-305-09-8064
<hr/>		
Customer number	:	32870
Your order number	:	22895
Your order date	:	24.11.2014
Competent person	:	B. Sass
Tax-ID	:	FI23694906

ORDER CONFIRMATION

Dear sirs

We thank you for ordering and confirm the following order:

G.00 **ZHR05/L/085**
BOOMERANG (R) Return conveyor ZHR05 - Optimat



Telefon: +49 37323 16-0
Telefax: +49 37323 16-170
E-Mail: info@ligmatech.de

Gesellschaft mit beschränkter Haftung mit Sitz in D-09638 Lichtenberg
Registergericht Chemnitz HRB 519
Geschäftsführer: Holger Blötscher, Jochen Fischer

Internet: <http://www.ligmatech.de>
Ust-IDNr: DE 141134129
Steuernr. des
Organträgers: 42070/06960

Banken
Deutsche Bank AG, Dresden
Commerzbank AG Villingen
HypoVereinsbank AG, Freiburg
KBC Bank Bremen

Blz	Kto
870 700 00	220067300
694 400 07	158175000
680 201 86	7602820
290 201 00	700542

BIC
DEUT DE 8C
COBA DE FF 694
HYVE DE MM 357
BANV DE HB

IBAN
DE28 8707 0000 0220 0673 00
DE21 6944 0007 0158 1750 00
DE57 6802 0186 0007 6028 20
DE24 2902 0100 0000 7005 42

Date : 28.11.2014 Customer : RAUMA
Machine number : 0-305-09-8064 Type : ZHR05/L/085
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Layout: 5-013-70-5010

Technical data of the basic machine

brand :Homag
type :Ambition 2274 Airtec
machine no. :
machine length :8635 mm
working high :950 mm
feed speed :18-25 m/min
stopping side : left

NOTES:

The basic machine has to be prepared electrically and mechanically for the retrofitting of the return conveyor.

Application

The BOOMERANG return conveyor ZHR05 allows a one-man operation at one-sided edge banding machines.

Function

Workpieces leaving the machine are taken over by driven chain gripper deliveries supported by a driven roller and are supplied to an pneumatic air-cushion table.

By means of a pusher and the inclination of the pneumatic air-cushion table, the workpiece slides onto a driven return conveyor belt on which the same is conveyed further.

At the end of the return track the workpiece is transported to the operator onto a non-driven roller track (VKNR 0199) or an air-cushion table (VKNR 0209).

For a flexible usage the machine is by default equipped with four operation modes:

- air consumption table always lowered, pusher offline
- air consumption table always lowered, pusher online
- air consumption table in lifting mode (upper position at takeover, afterwards lowered), pusher online
- air consumption table always in upper position for manual pickup (no return of parts)

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Design

- air-cushion table: l= 2.500 mm, w= 1.000 mm
(inclined by approx. 65 mm)
- conveyor belt: w= 900 mm
(see VKNR 0052)
- non-driven roller track (VKNR 0199) or
liftable air-cushion table (VKNR 0209)
- belt cleaning (simple)

Workpiece parameters

Longitudinal throughfeed:

- length: 300 ... 2.500 mm
- width: 60 ... 800 mm

cross throughfeed:

- length: 300 ... 800 mm
- width: 300 ... 2.000 mm

- thickness: 8 ... 60 mm

- 4-side-processing:
 - min. parts size: 300 x 300 mm
 - max. parts size: 2.000 x 800 mm

- Larger parts can be returned or even fed out
at 4-sided processing with manual support
during crosswise offset and turning.

- Weight: max. 50 kgs

Strongly overhanging workpieces may collide
with workpieces on the return system.

Therefore, we recommend a supporting roller
rail. (VKNR 0054, 0058)

In case of extremely overhanging workpieces
they may have to be driven separately.

Condition for a proper function of the return
system are even, continuous, rectangular and
sliding workpieces.

Technical parameters

- working height: 820 to 980 +/-30 mm
- feeding speed: 8 to 30 m/min
- automatic feeding speed adaption integrated:
premises:

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preliminary machine provides an analog signal in the range of 0-10 V (If the signal can not be provided, an adaption is effected by a pot at the control of the return conveyor.)

Pneumatic system

Operating pressure: 6 bar
Air consumption: 50 Nl/min

Electrical system

Control system: Eaton EASY
Remote control from the infeed of the machine.

Operating voltage: 400 V, 50 Hz
(Please always indicate differing voltage!)
Total connected load: approx. 2.2 kW
Required room temperature:
+5 ... +35 Celsius degrees

Varnishing

Robustic structure varnish, grey RDS 240 80 05
(see VKNR 4500, 4502)

Requirements concerning the floor

- Tension-loadable/pressure-loadable
- standard concrete C16/20 XC1
- minimum thickness 150 mm

Conformity

Prior to market the machine, it must be equipped with suitable safety devices against entering the danger zones of the machine according to the valid legal regulations of the country of destination.

Within the EC the machine must be certified according to the EC directive 2006/42/EC.

For this purpose sales no. 5056 is required!

Fabrikat : Homag
Type : Ambition2274 Airtec
Maschinenr. : 8635 mm
Arbeitshöhe : 950 mm
Vorschub : 18-25 m/min

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G.0001 Number : 0052 12 x left
WIDENING OF REFEEDING TRACK TO 1,100 MM

G.0004 Number : 0199 1 x left
BASIC OUTFEED RETURN BELT



Undriven roller track at the outfeed of the
return belt

Length: 2.500 mm
Width: analog return belt

G.0007 Number : 5056 1 x left
CE PACKAGE ZHR05, ZHR340
Safety related equipment of ZHR05
to achieve the CE-conformity, consisting of:
- rip cord back to the return belt
- multi-ray safety light barrier crosswise
between ZHR and KAL
- additional E-stop button between ZHR and KAL
- creep-zone protection

D.01 Service: 8331 1 time
DOCU.- AND CONTROL TEXTS: FINNISH

The following will be translated:
1. production instruction,
consisting of operating and maintenance
instructions on DIN A4 paper and CD-ROM

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2. on-screen operator control texts
for machine operators, NC21, PC22, PC52,
PC83 and PC85
3. spare parts designations in ENGLISH or
GERMAN on CD-ROM

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B.23 DELIVERY FCA
- FCA Lichtenberg according to INCOTERMS 2010
without installation

transport by Projecta OY

B.2601

B.2901