

Edge chamfer lacquering for flooring production

Existing systems for lacquering the chamfers of flooring planks have so far not been capable of meeting market demand for feed rates of up to 200 m/min. Development work needs to address the issues of improved availability, acceptable lacquer application quality without over lacquering, prevention of lacquer drying when not in use and high-speed colour changes, while seeking to provide a lower-cost, higher-precision application unit compared to systems currently available in the marketplace (vacuum, transfer wheel, spray jets etc.). HOMAG AG has risen to this challenge and developed a new no-contact technique for processing special water-based lacquers. The particularly tricky aim of the development was to allow the system to be mounted in the transport chain section of a double-end tenoner without soiling the transport system: An essential condition, given the need for extreme precision in the lateral guidance of planks, particularly those with small chamfers.

The system is mounted on a stand with adjustment facility in the X and Y direction, which moves the application head pneumatically out of the working area on a feed stop. The application head is Homag's own development. It operates with a maximum of 4 nozzles, each working separately depending on the feed rate, material absorption capacity, colour coverage rate and printable surface. When the lacquer application unit is not required, the application head is swivelled automatically into a water bath, guaranteeing that lacquer is not able to dry up over long periods out of use. Lacquer feed takes place from the lacquer tank to the nozzle in a closed circuit.

The unit is due to be industrially tested from the end of March 2009 as a pilot application on the premises of a laminate flooring manufacturer, and the manufacturer aims to have it ready for market by the Ligna. The system will be showcased at the Ligna 2009 in Hanover on a flooring machine for longitudinal processing.

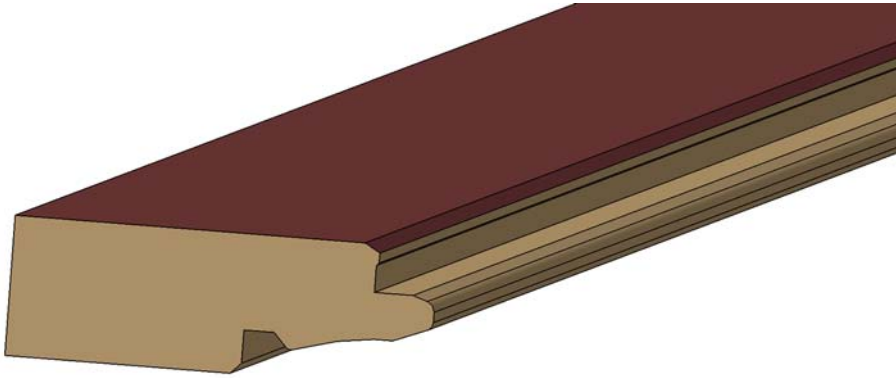


Fig. 1:
Laminate profile with mini chamfer



Fig. 2:
Laminate plant with mini chamfer

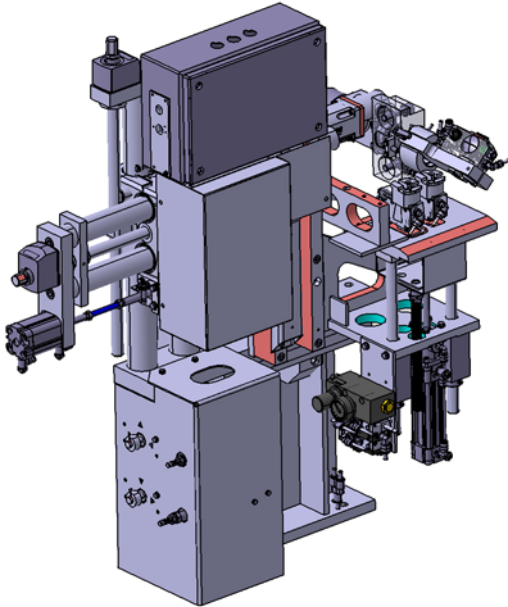


Fig. 3:
Printing unit for colouring the mini chamfer

For more information, contact

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