

## **Tarkett successfully commissions two HOMAG flooring lines for an annual 20 million sq.m. laminate output**

When the laminate flooring factory “Tarkett Sommer” was officially opened in April of 2010 in the greater district of Moscow, 296.000 square metres of flooring planks had already been produced and further processed there on two laminate flooring plants supplied by HOMAG. This ambitious investment project was planned and implemented single handedly by a specialist flooring team from HOMAG Engineering. The HOMAG Group achieved this flexible production sequence working in cooperation with system partners of many years’ standing.

Tarkett Sommer’s General Director Slavoljub Martinovic summed up the project: “We were able to rely on the services of a single competent contact partner right from the project planning to the implementation phase. The quality of this complex plant speaks for itself. What have impressed us particularly are the high output levels coupled with this degree of flexibility. It goes without saying that the complete package has to be right, all the way through to the aftersales servicing.”

After being pressed on one of the two short-cycle presses, the stacks of panels are conditioned in an intermediate storage facility and then transported for further processing to the common stack infeed area for the two profiling lines.

The panel stacks are deposited on stack roller conveyors, automatically fetched by a cross carriage and fed to the relevant processing line. Once the panel stack has been automatically transported by the cross carriage into the feeder, the top panel in each case is lifted by a suction beam and deposited upstream from the longitudinal alignment station on a roller conveyor.

The panel is then aligned against a fixed fence or against a central line in the decor paper and ripped into up to 20 planks. All the sawing units and one of the two edge hogs are fitted with stepless axes for fully automatic and precise unit positioning.

The planks are then transported via an angular transfer to the cross-cutting saw, where they are cross cut optionally into halves or thirds. After being flipped, the finish divided raw planks are accelerated on a vacuum conveyor to **more than 200 m/min** and fed for longitudinal profiling.

After trimming the longitudinal profile using a HOMAG double-end tenoner equipped with **patented magnetic chain technology**, if there is a chamfer this can be coated with lacquer before the profile is sealed with a wax layer to protect against moisture penetration. Subsequent transverse processing also entails a chamfer lacquering and profile sealing station.

Following on from profile processing, the planks travel through an automatic monitoring station where faulty parts are automatically detected and can be ejected and stacked prior to packaging.

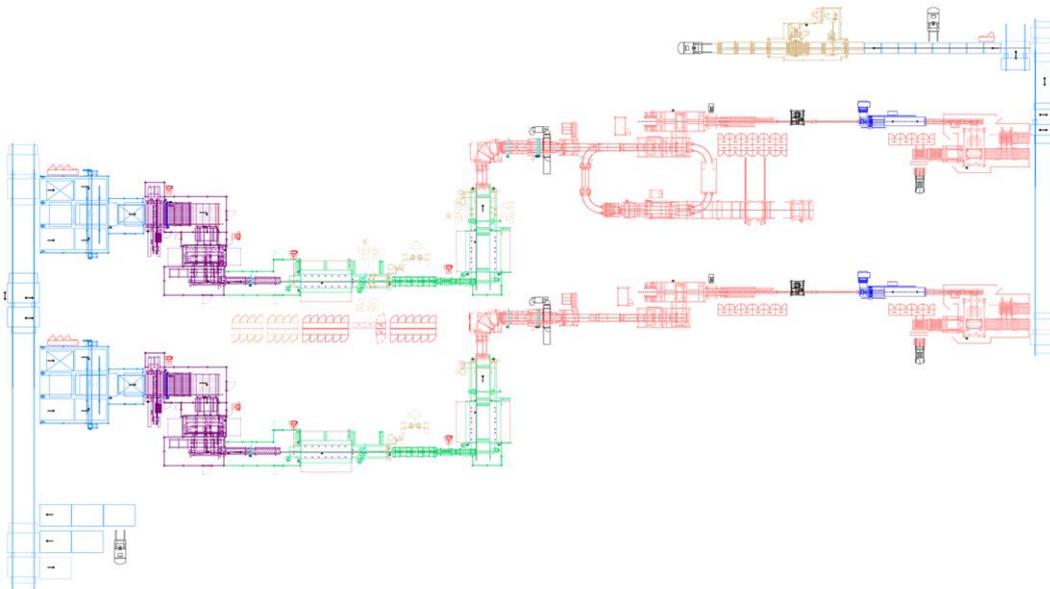
Class 1 planks can either be transported via a bypass to the footfall sound insulation plant and laminated on the back with a wide range of different materials or packaged directly into 5-sided pasteboard cartons. Both the footfall sound insulation plant and the fully automated cardboard box packaging plant are produced by the company Wächter Packautomatik GmbH, a system partner to HOMAG Holzbearbeitungssysteme GmbH in the field of flooring technology. Prior to stacking the finished books of planks on pallets in a palletizing gantry, they are welded into film in a shrink wrapping plant.

With the aid of another cross carriage, the finished pallets from both profiling plants are transported into a common pallet packaging area, where the books

of planks are fixed on the pallet against slippage using 2 vertical plastic tapes. The complete pallets are then wrapped with elastic film before being sent direct for delivery or into the finished product warehouse.

Following successful acceptance and handover of both the two profiling lines to Tarkett Sommer, the HOMAG Group was able to successfully conclude an important project in one of the world's fastest growing markets. This has provided Tarkett Sommer with two highly flexible profiling lines for standard and narrow parts, one of them with chamfer lacquering and sound insulation application unit, with a total capacity of appr. 20 million sq.m. a year at its Mytischki location.

Picture material courtesy of: HOMAG Group AG



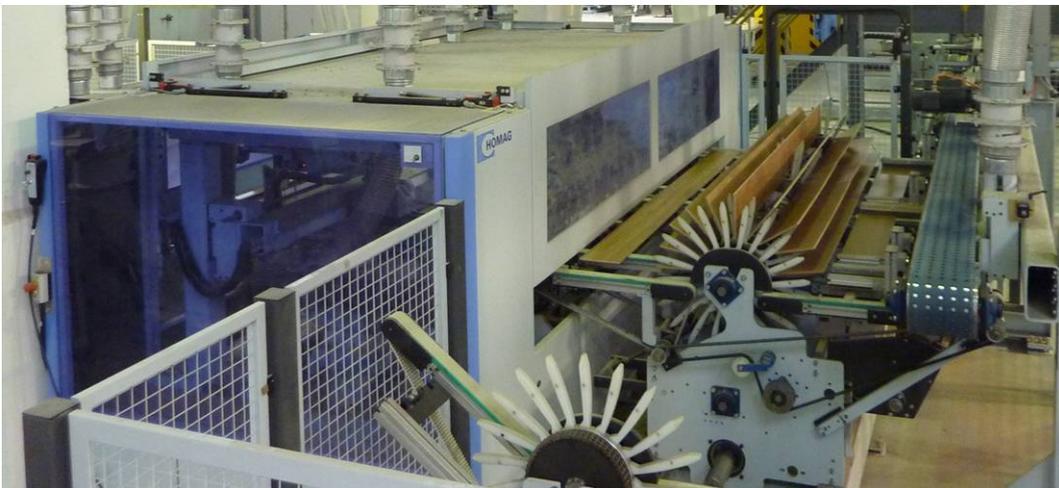
**Fig. 1:**  
Overall layout of both flooring lines



**Fig. 2:**  
Infeed station



**Fig. 3:**  
HOMAG rip saw



**Fig. 4:**  
HOMAG cross-cutting saw with flipping and acceleration station



**Fig. 5:**  
HOMAG double-end tenoner for transverse processing



**Fig. 6:**  
Packaging plant for laminate planks



**Fig. 7:**  
Pallet packaging plant

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