



BEVEL EDGEBANDER KE 396JS





KDT 396JB *Bevel* EDGEBANDER A unique design advantage



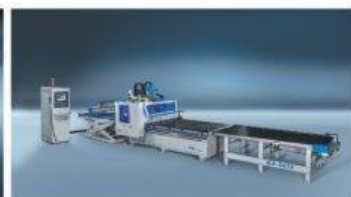
KDT – an introduction

KDT are a major manufacturer of panel-based machinery with over 20 years of technical knowledge and experience. They export successfully to all major world markets a comprehensive range of Edgebanders, Beamsaws, Panelsaws, Flow through production lines, CNC routing and Drilling machines. Annual production exceeds 19,000 machines

Click here and take a look...

<https://www.youtube.com/watch?v=xoqp9XiLNds&t=10s>

KDT machines are built to work hard and designed to last.



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KDT396JS Bevel Finish Edgebander

WORKING GROUPS

WORKING UNITS

- Pre-milling of angled or inclined edge up to 45°.
- Pre-milling of square edge.
- Hot melt glue application of square edge.
- Grooving back surface of edge strip with pneumatic pressure pad.
- Hot melt glue application of inclined edge.
- Edge strip application with pneumatic guillotine.
- Hot air blower on edge strip to assist bending.
- Pressing rollers for square edge and inclined edge.
- End trimming saws for flush trim.
- First top and bottom trimming unit – straight cutting tips.
- Second top and bottom trimming unit – radius cutting tips.
- Radius top and bottom scraper unit for fine finish.
- All stations fitted counters for exact adjustments.
- Flat top and bottom surface scrapers.
- Oscillating top and bottom buffing units.
- 3 Spray units
- 2nd Hot air blower before Buffing station



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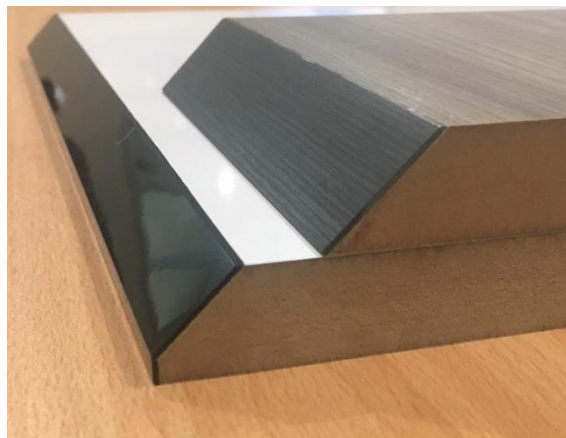


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KEY FEATURES

- Full safety covers over motorized cutting and trimming units.
- Convenient electrical control touch screen at infeed position.
- Fluorescent lights inside safety hoods.
- High feed rates – 12, 16 or 20 metres/min.
- Precision flat belt above feed chain
- Feed jogging button to assist setting up.
- Pneumatic shut-off gate on glue roller.
- Front and rear tape overlap adjustment from electrical control touch screen.
- Large 75mm dust exhaust hoses on trimming units for efficient extraction.
- Large windows in safety hoods for better visibility.
- Diamond tipped cutter heads on twin spindle pre-milling stations.
- High precision electronic angle setting of milling and gluing bevel
- Pneumatic gate prevents panels being fed in too close to one another.
- Motorized height setting of top beam for different panel thicknesses.
- High precision slide ways on cut-off saws.
- Efficient high frequency belt free motors on saws and trimmers.
- Pneumatic blowers on scraper tracer wheels to keep swarf from affecting accuracy.
- Buff unit , pneumatic oscillation and mounted on 50mm round bars
- 1440rpm motors on buffs to prevent scorching.
- Manual lube system for feed chain. Quick and easy
- Length of machine – 7400 mm.



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DESIGN IN DETAIL

Built in strength

Everything on an Edgebander relies on the design, strength and rigidity of the machine frame and work unit mountings and this is an area where KDT refuse to compromise. Wherever you look you see this

- Just a few examples:

- Saws on cast iron mount
- 10mm thick plate steel base running through the machine
- Table support rails 50mm diameter
- 18mm thick hard chrome infeed fence
- Buffers mounted on 50mm diameter columns

The list goes on...



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You're in control

The functionality and user friendly format of KDT's touch screen control sets new standards in Operator friendly operation of an Edgebander.

You're in total control- selecting functions, setting the 3 feed track speeds, Up/down of the feed beam, glue temperature setting the machine to 'standby' while you have lunch etc. You can even pre-program start up and shut down times – so your edgebander is heated up and ready for you when you arrive at work!

There's a comprehensive parameter setting function allowing you to adjust settings –e.g. front edge overhang

Technicians love this controller- as it has comprehensive diagnostics and fault finding functions and reports with reset methods and 'fix it steps that often mean no Technician is required.



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Handle the heaviest tapes

The tape coil holder is a great example of KDT's uncompromising focus on strength. At 800mm diameter and supported by a massive 60mm diameter column this will keep even the heaviest tape coils perfectly aligned with the infeed guides and rotating smoothly



Perfect tape feed and application



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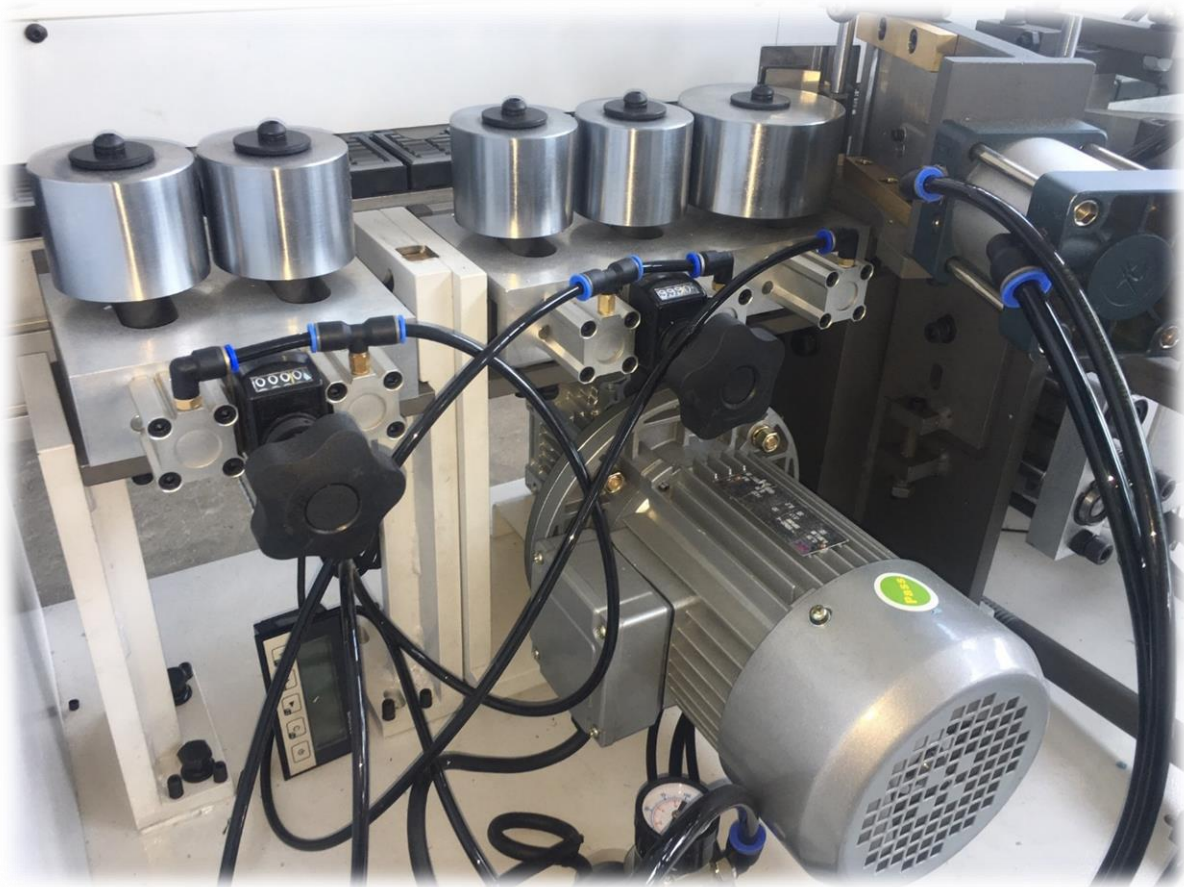
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Perfect alignment and uninterrupted feed of your tapes is an essential first step in achieving a great edge. This needs to be complimented by uncompromised application pressure.

KDT infeed guides and feed roller are mounted on twin 10mm steel plates. A pneumatic pressure roller (not shown in these photos) assures the tape is firmly pressed against the feed roller. This is followed by an oversized pneumatic guillotine that cleanly shears even the heaviest tapes from the roll smoothly and easily.

The tape is then pressed onto your panels on the straight and bevel by twin independent pressure roller groups with their own pneumatic cylinders.



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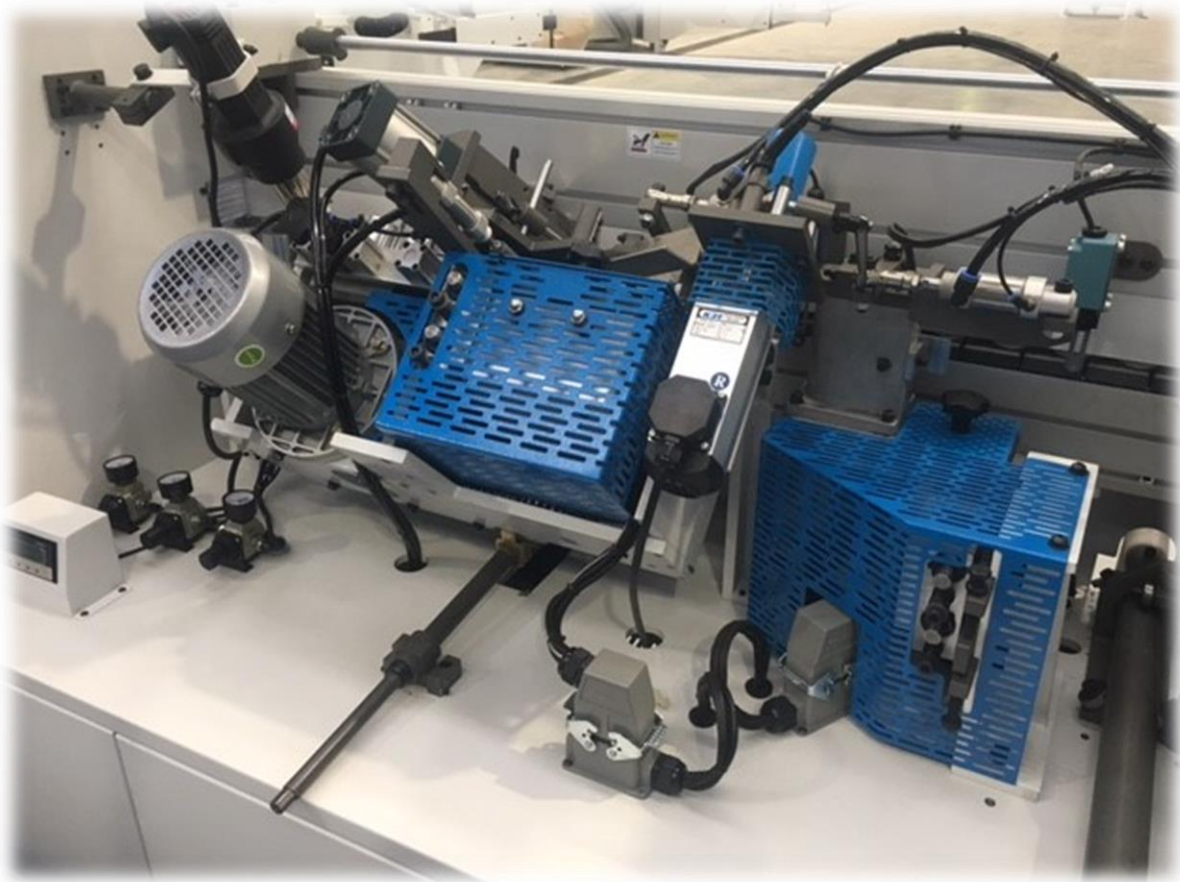
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Twin glue tank.

Multiple elements ensure quick and even heating of the glue and a convenient automatic 'standby' is activated if panels have not been processed for a set period. This lowers the glue temperature to maintain colour and strength.

Independent twin glue tanks apply the glue to the straight and bevel panel edges – not to the tape. This is a really important feature as it avoids sticky tape trimmings accumulating throughout the feed path.



Tilt angle of the second gluing station is electronically/ digitally set for total accuracy



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Panel feed is precise, reliable and foolproof

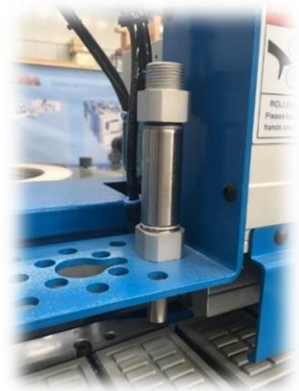
Simple reliable alignment, support and feeding of your panels keeps your operator happy while ensuring panels arrive and travel through the workstations evenly and perfectly aligned. KDT start with an oversized chromed infeed plate and an 18mm thick fence with accurate digital setting of the premilling allowance. A safety barrier/ switch prevents panels too thick for the track setting to be fed in.



To eliminate any chance of the gap between panels being too short there is a pneumatic pin that prevents a second panel entering too soon. The timing is varied automatically dependent on what working stations you have activated.

This is better than a 'red light/ green light' system which relies on the operator obeying the light!

Once the panel enters the feed track the electronic 'line control' knows exactly the front and back position of the panel on the track – this eliminates the need for troublesome micro switch control of the working units and allows precise activation setting from the control panel. This is a huge plus for set-up and precise operation of the work units.



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Onto the feed track....

The infeed ensures your panels enter the feed track perfectly aligned, spaced and with the line control knowing where they start and stop. Now the feed track must ensure they stay that way as they pass through the machining groups.

The first step is setting the feed track height and KDT have made this effortless and accurate with powered feed track height adjustment coupled to a digital readout. A clever tensioning system guarantees the feed track positioning

Above the feed chain is a continuous belt feed- your assurance of precision feeding of even small and slippery panels.

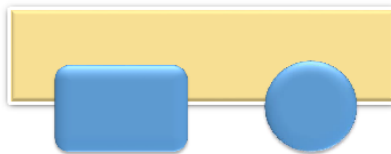


Oversize columns at each end support the overhead roller track and ensure alignment without flexing under load



The driven track

The bottom driven track run on combined square and round guide rails. This is the best guide system as it ensures the track cannot move sideways or tilt under load. Cast bearing housings and heavy chain feed ensure long life, low maintenance and accurate trouble free feed of even your largest and smallest panels.



A centralised manual lubrication pump for the feed track is included – simple and effective.



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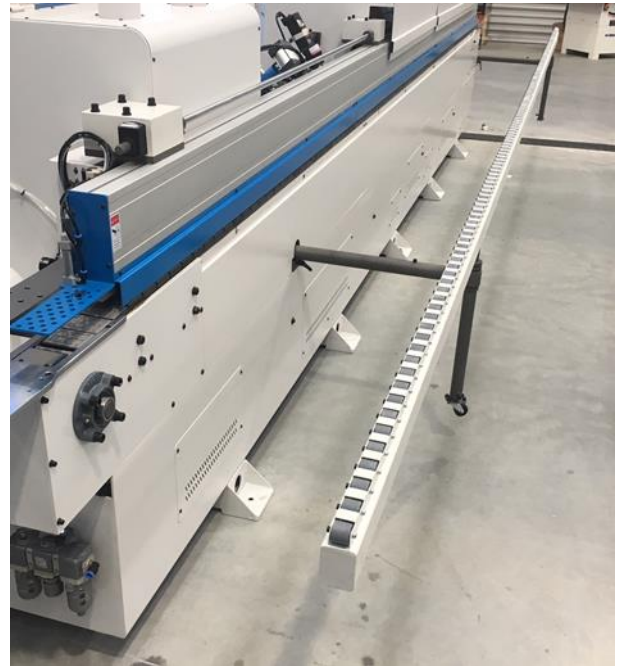
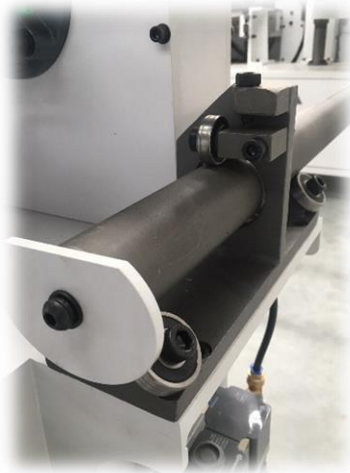
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Well supported

The panel support easily extends out 620mm to support wider panels.

It's mounted on 50mm diameter bars running on ball bearing roller guides so it's simple and easy to reposition and won't sag when supporting large heavy panels. Support legs on rollers are included if you are edging really heavy panels



Unique twin hogging system shapes your Panel edge

The heavy duty twin vertical and bevel trimmers cleanly hog the panel edge to the required bevel angle or bevel/ vertical combination profile.

These are mounted on very solid dovetailed tilt guides and in a separate cabinet from the downstream edging functions to keep dust away from these work areas.

High precision digital angular setting displays are included.



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Clever bevel cut into Tape ensures clean fold

This unit machines out the rebate in the rear of your tapes that is the key to a perfect 'fold' at the point of vertical to bevel. The cutter profile has been carefully designed/ developed to deliver a unique flat/curve groove shape for this requirement



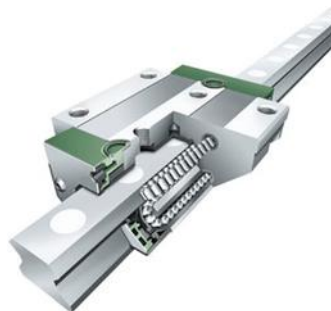
End saws precision is guaranteed

KDT have paid particular attention to their End saw design which like the premill is built the right way.

The saws are mounted on a super strong base and both run on the same high precision THK guide for perfect alignment

Independent 12,000 rpm saw motors ensure clean, effortless trimming Of your toughest tapes.

A proximity sensor works in conjunction with the line control to ensure the saws are in position before the next panel arrives – and will shut the feed down if this is not the case avoiding ruining your panel and potentially damaging the saw unit



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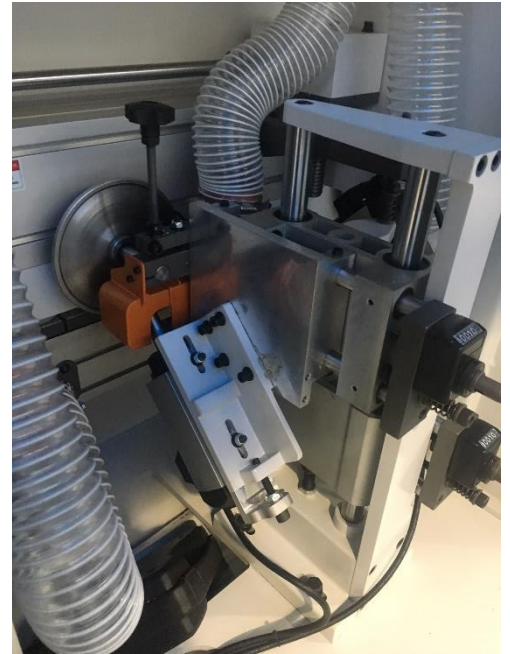
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Trimmed top and bottom 'spot on'

KDT use heavy steel construction for the 2 sets of Trimmers to guarantee the ultra-fine precision required. Large rotating '180mm copy wheels allied with 12,000 rpm HF motors ensure the cutters perfectly trim and radius your edges prior to scraping.

Digital precision resetting complete the perfect trimming setup.



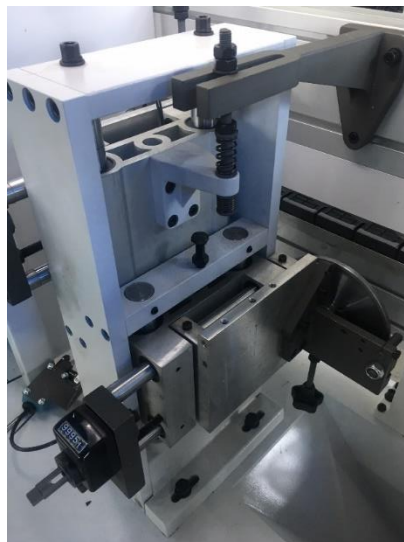
Highest precision scraping

KDT's scrapers use the same cast iron and steel mounts as the Top and bottom trimmers – it may look like overkill but scraping is critical to the final appearance of your Panels.

Large rotary copy wheels with air jet blower cleaning deliver the perfect smooth, cutter mark free finish your customers will love.

The radius scrapers are followed by a second set of flat scrapers.

Large diameter rod fine thread Digital setting complete these precise scraping units



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The final polish

Final cleaning /polishing and restoration of colour to darker tapes is via large 1440rpm buffs at the outfeed. These are mounted on extra heavy (50mm diameter!) mounts that deliver a heavy duty vibration free finish.

Buffing angle is easily adjusted 10-15 Degrees

Pneumatic oscillation setting is included.



Released polished and restored

We include 3 separate spray units to apply release and cleaning sprays through the process. There are also 2 heat guns –the first to soften the tape prior to folding and the second to assist with colour restoration prior to buffing.



Keeping things quiet

The heavy construction of the working units and frame do a great job of noise reduction which is enhanced with the sound dampening hoods.

These are electrically interlocked and operated by large self-supporting gas struts for safety while the large windows allow you to easily keep on eye on things while the machine is working.

Internal lighting can be switched on from the touchscreen control



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It's a small point but they enhance the overall look of the machine – this is a machine that will look great in your workshop and enhance your company's presentation

Extraction is important

Good dust extraction is vital to good edgebanding. KDT understand this and have paid particular attention to ensuring all hoods and ducts are well designed and function well.



Quality Electronics

9 Independent Inverters for the functions and International quality electrical and pneumatic components



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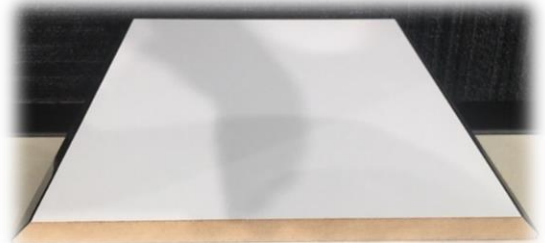
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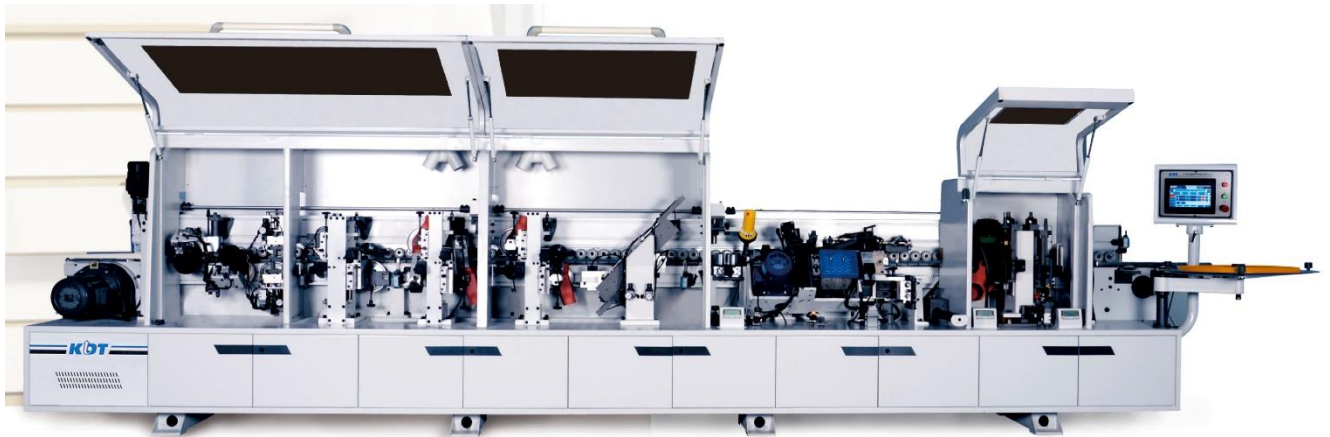


The 396JB is a cleverly engineered, purpose built Edgebander to give your products a unique design advantage



PANEL AND PRODUCTION DATA

- Feed Speed. 12 – 20 m/min
- Angle Adjustment Range. 0 – 45 degrees
- Edge Thickness. 0.45 -2mm for angular. 0.45 – 3mm
- Panel Thickness @ 45deg. 9 - 25mm @ 2mm edge. 9-35mm normal
- Minimum Panel Length. 150mm
- Minimum Panel Width. 135mm
- Machine Size. 7400 x 870 x 1610mm
- Overall Power. 19.88kw



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