



**KE706 – The VERSATILE
EDGE BANDER**

EDGE TECH





KE706 EDGEBANDER - The Versatile one

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

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

Click here and take a look...

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



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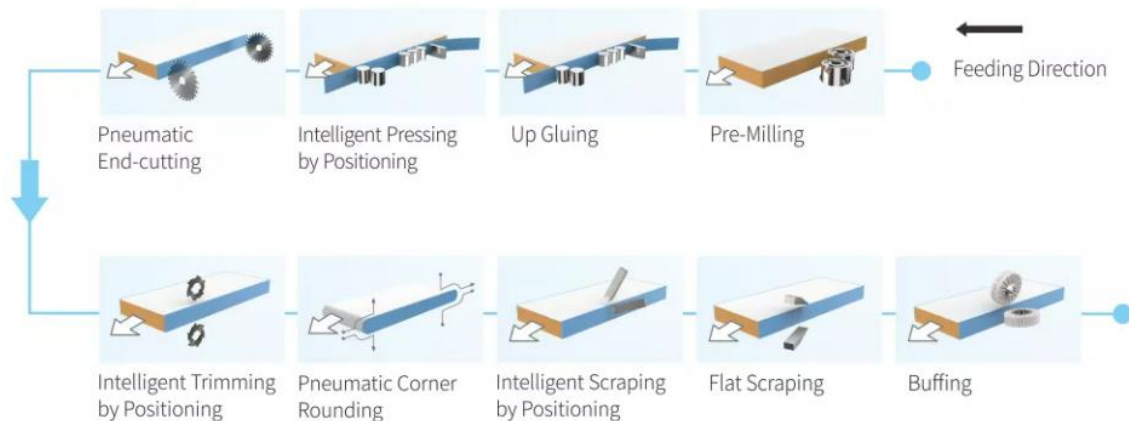


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KDT 706 – the VERSATILE Edgebander

Pre-mill, Corner rounding and programmable servo setting



WORKING GROUPS

- Diamond pre-milling – with Servo setting of infeed fence
- Hot melt overhead glue tank with large Hopper and auto hopper refill
- 2 Pneumatic timed Sprays – before Premill and buffing
- Heavy duty edge strip application station with pneumatic guillotine.
- Four-roller pneumatic pressure station with auto positioning
- End trimming – high precision cut-off saws with 15-degree auto angle adjustment.
- Top & bottom trimming with auto positioning
- Programmed twin motor Corner rounding with auto tape thickness resetting
- Top and bottom radius scrapers to fine finish PVC edging with auto radius change
- Pneumatic top and bottom Flat Glue Scrapers
- Top and bottom buffers – with polishing spray

WATCH THE VIDEO:

<https://www.youtube.com/watch?v=90hQNaMdlQ0>



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KEY FEATURES

- Compact – only 6138mm length. Full safety covers
- Convenient large touch screen, modern crisp graphics PC based – able to store 12 programs
- Servo set: infeed fence, trimmers, scrapers & pressure rollers from touchscreen or program
- Lights and sound damping inside safety hoods. Large windows for better visibility.
- High feed rates: 13-18 metres/min.
- Electric / pneumatic auto lubrication of feed track. Easy!
- Feed jogging to assist setting up with mobile control pad
- Pneumatic shut-off gate on glue roller.
- Front and rear tape overhang adjustment from touch screen
- Electronic 'line control' monitoring of workpiece position (eliminate microswitches)
- Large 100mm dust connections for efficient extraction.
- 4 pressure rollers – Individual pneumatic pressure to each roller – servo auto positioning
- Pneumatic gate 'pin' controls panel gap
- Touch screen motorized height setting on top beam with height pre-sets and piece counting
- High precision slide ways on cut-off saws with auto lube. 15 deg. pneumatic tilt of saws
- Efficient Direct drive and inverter-controlled motors on saws and trimmers.
- Pneumatic blowers on scraper tracer wheels keep swarf from affecting accuracy.
- Digital pneumatic positioning of trimmer stations from touchscreen
- Buffers on Solid round bars – no flex under load.
- 1440rpm buffs prevent scorching.
- Heavy weight delivers precision
- Extra solid panel support rail



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DESIGN IN DETAIL

Built in strength

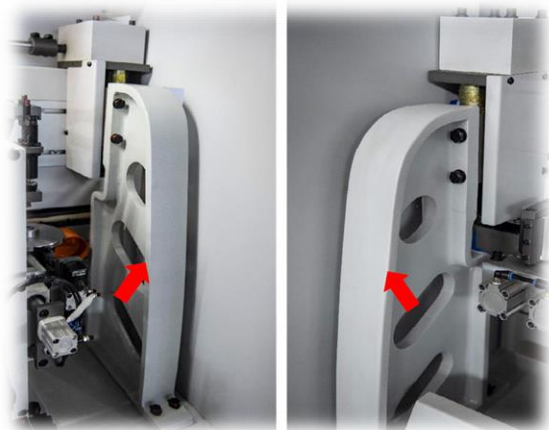
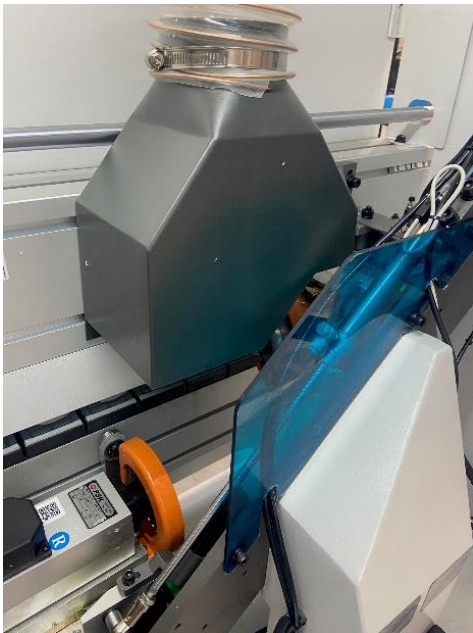
Edgebanding relies on the rigidity of the machine frame and work unit mountings

- A few examples:

- Saws on cast iron mount
- 10mm plate steel base
- 800 x 90 x 16mm thick hard chrome infeed fence
- CNC machining of one-piece frame
- Oversize Beam supports



The list goes on...





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You're in control

KDT's large 400 x 260mm touch screen Industrial PC sets new standards.

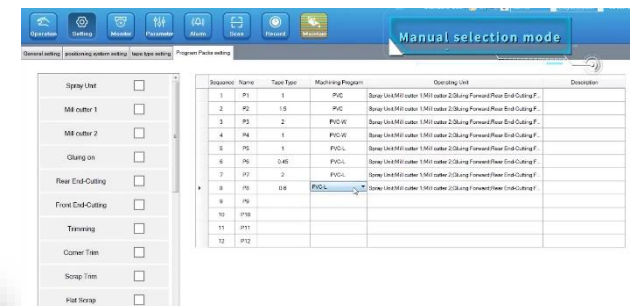
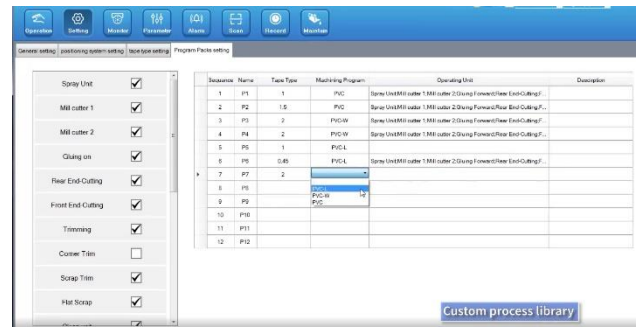
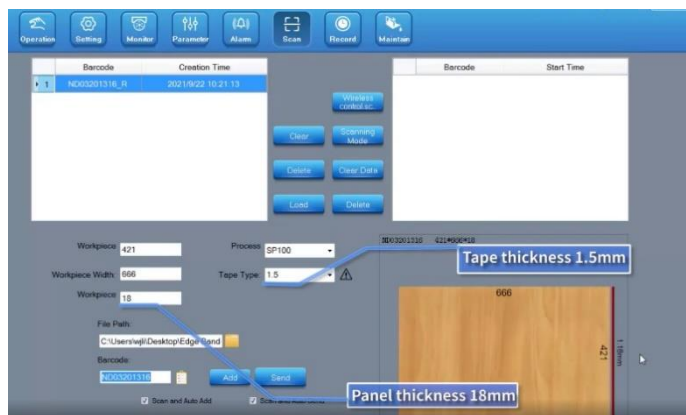
You're in total control - selecting functions, setting feed track speeds, controlling the corner rounding functions, height of the feed beam, machine 'standby' etc.

Or simply recall one of your programs!

Pre-program start up and shut down times

Tape used and Board count: another great feature

Comprehensive diagnostics and fault-finding with reset methods and 'fix it' steps - often no Technician required.

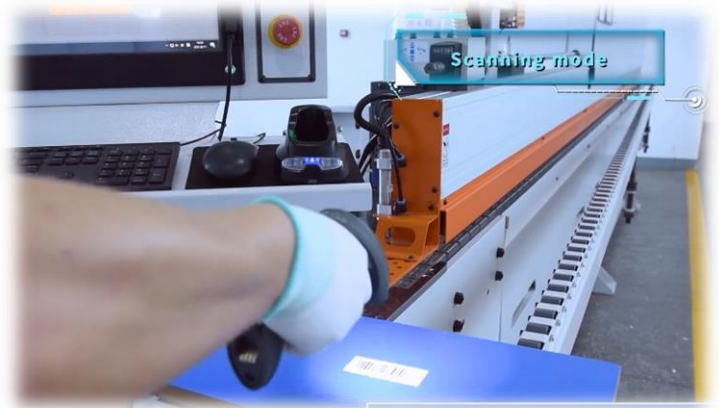


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—
or



Handy mobile control panel
convenient and practical

Servo repositioning of trimmers, scrapers and pressure rollers > programmed from the PC. Recall program on screen by Barcode.

Individual Inverter control of Motors

10 individual inverters- Saves power and maintains cutter speeds under varying loads

Top quality SIEMENS Electrics

CE compliance



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Panel feed: precise, reliable, foolproof

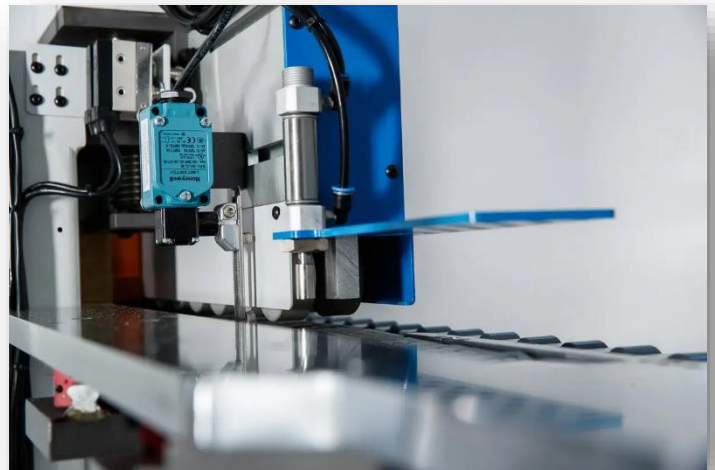
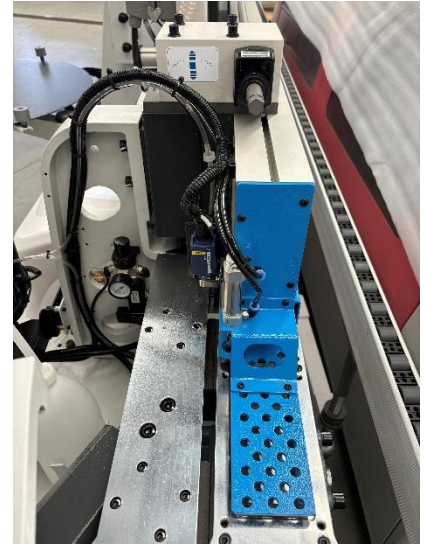
Simple reliable support and feeding ensures panels travel through the workstations perfectly aligned.

Starting with an oversize infeed plate and Pre-mill fence. Adjustment of the pre-milling allowance is by Servo from touchscreen or a program

A pneumatic pin prevents a second panel entering too soon. Timing is varied automatically. Foolproof and better than a 'red - green light' which relies on the operator

The electronic 'line control' knows exactly the position of panels on the track – eliminates troublesome micro switch's and allows precise activation setting from the control panel.

This is a huge plus.



A pneumatic outfeed roller device ensures even small panels are cleanly fed out from the track



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Premilling = perfect edge

Perfect edges – without scorer lines, tapers, swelling or chipping.

Jump Milling Head with opposite rotation eliminates break out on trailing edge of panels

KDT's premill is built right with independent motors and pneumatics

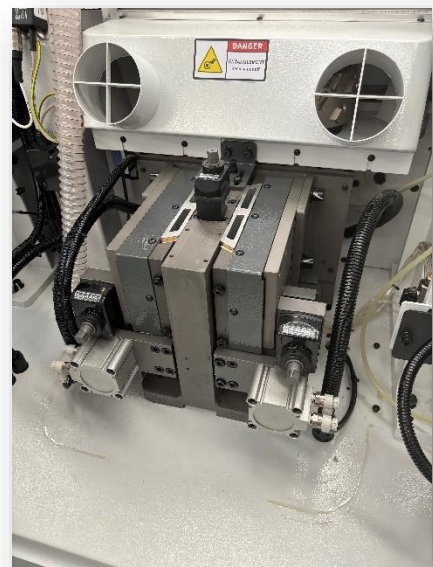
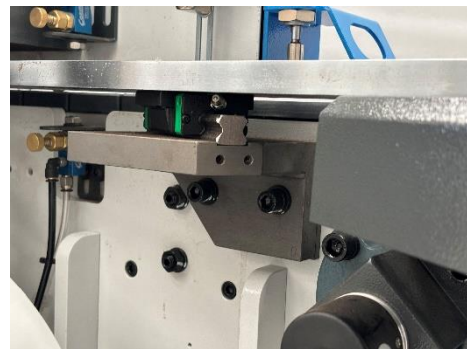
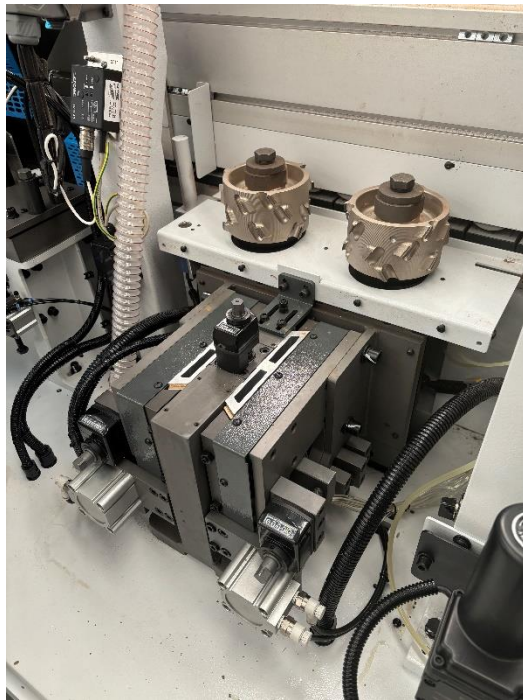
Large 125mm x 70mm Shear Angle Diamond Cutting Heads
Precise digital Premill removal setting.



Two Powerful
3.7KW high
frequency milling
motors

Efficient twin
100mm Dust
extraction
outlets
Blowers clean
Panel prior to
Gluing.

Adjustment
of Premill to
match
different
edge
thickness is
simple > from
the
Touchscreen



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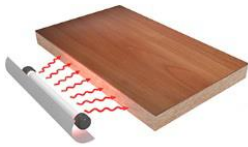
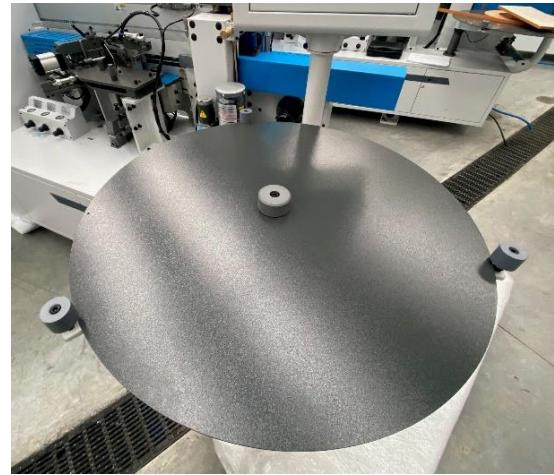


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Handle the heaviest tapes



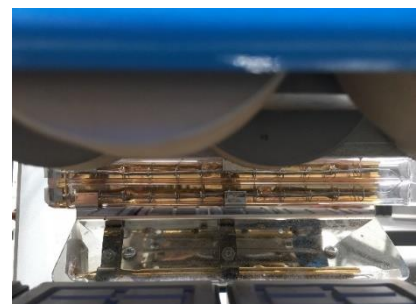
A great example of KDT's strength.
800mm plate supported by a massive 60mm column so the heaviest tape coils stay perfectly aligned with infeed guides and rotating smoothly



Infra-Red Edge Heating

Pumps heat into your Panel Edges on cold days

Improves Glue open time and bonding
Electronic timed activation



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The pressures on...



Precise Servo positioning from Touchscreen or Program

Perfect alignment and feed of tapes and strong application pressure is essential

KDT infeed guides and feed roller are mounted on twin 10mm steel plates followed by an oversized pneumatic guillotine that cleanly shears the heaviest tapes to 3mm



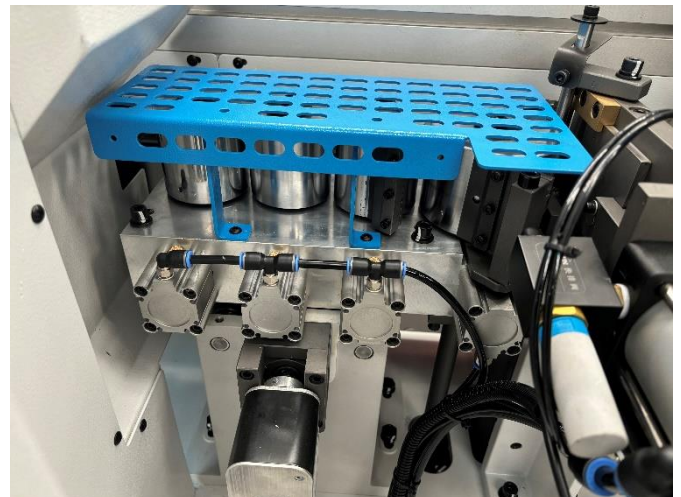
4 Pressure rollers with individual pneumatic pressure:

The hard chromed driven roller does the initial application. Two Rollers are tapered – applying extra pressure top and bottom to close-up the glue line for a magic result. Roller 4 guarantees the perfect tight edge.

Scrapers on the first roller keeps it clean

Programmed re-positioning of pressure roller group to suit different tape thicknesses.

Independent control of the tape feed engage/disengage – allows the tape overhang to be precisely set



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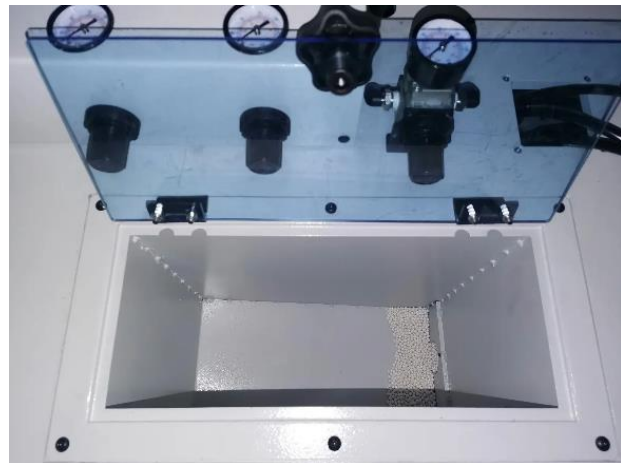
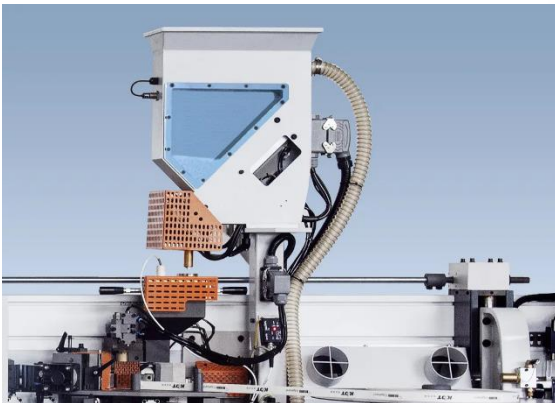


Easy to use glue application.

The overhead glue tank is convenient and efficient – and automatically replenished from the 5kg capacity Hopper which monitors and auto replenishes the glue tank. No more unexpected glue runouts. The hopper is kept full automatically from a 12.5kg glue granule reservoir in the machine bed via compressed air

Only a small amount of glue is pre-melted -maintains excellent glue integrity

Multiple elements ensure quick and even heating of the glue and a 'standby' function lowers the glue temperature to maintain colour and strength.



PUR Glue Compatibility



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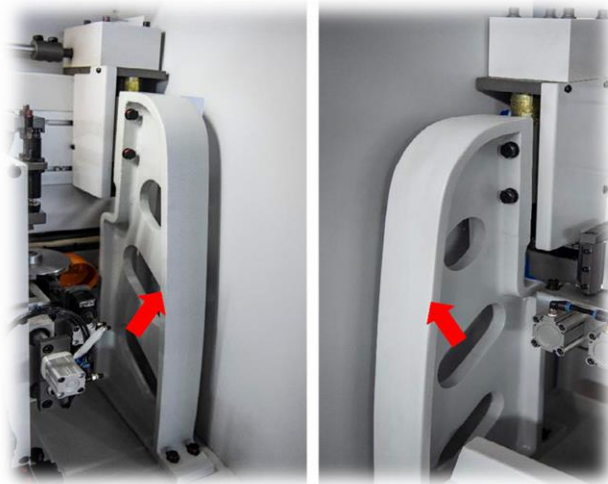
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Onto the feed track....

The feed track must ensure panels stay perfectly aligned through the machining groups.



Overhead feed rollers are mounted in a heavily ribbed aluminium top beam. Oversize Beam supports ensure alignment without flexing under load. A clever tensioning system guarantees parallel alignment.

Two rows of offset idle rollers keep even small panels under firm even roller pressure

Powered feed track height setting is effortless and accurate with five user specified pre-set heights selected on the touchscreen or included in programs

The feed track runs on square and round guides guarantee no sideways movement or tilt under load. Cast bearing housings and heavy chain feed ensure long service life



Automatic electric/pneumatic lubrication of the feed track from a clean cartridge system ensures this important maintenance requirement is never forgotten.



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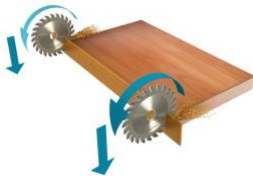
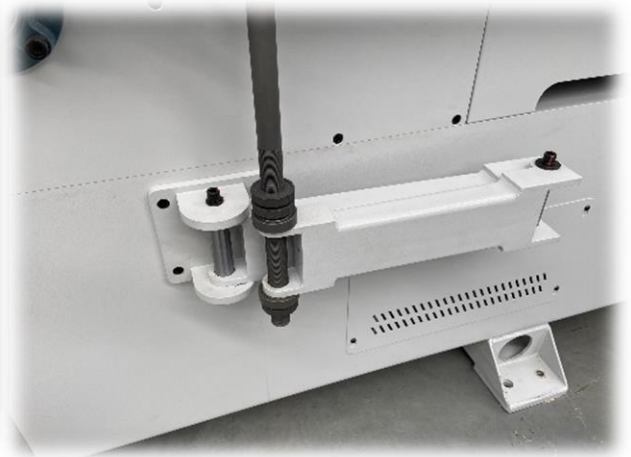
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Well supported

The panel support extends 950mm: easy to reposition and won't sag supporting heavy panels.



End saw precision guaranteed.

The saws are mounted on a cast iron base and single high precision THK guide for perfect alignment

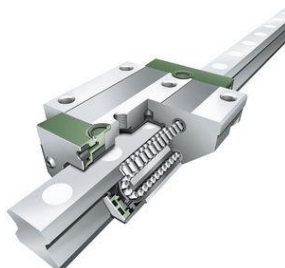
Inverter controlled 12,000 rpm saw motors deliver clean trimming

Line control ensures the saws are in position to avoid ruining your panel or damaging the saw unit

Edging post formed panels: from the Touch screen increase the overhang to avoid damage



Saws tilt to 15 degrees pneumatically – from the touchscreen



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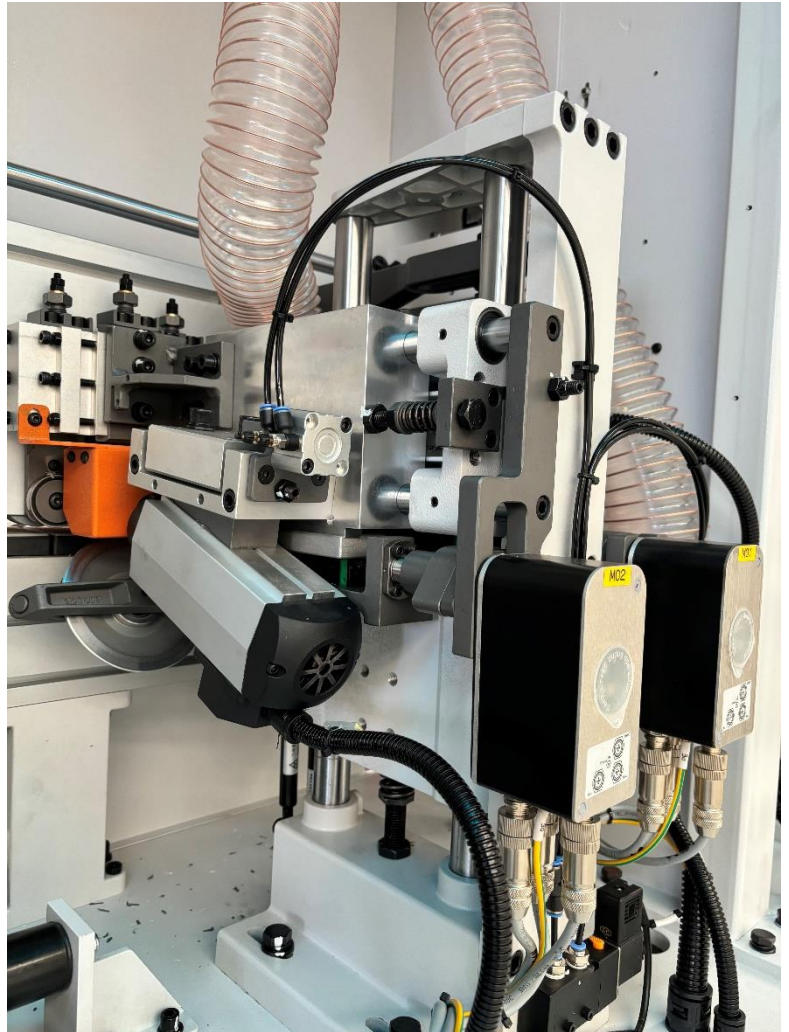
Auto lubrication of the saw slides: a great feature



Trimmed top and bottom 'spot on'

Heavy steel and cast construction guarantee ultra-fine precision trimming. Rotary 3 roller copy wheels with 12,000 rpm HF motors ensure perfect tracing and fine trim of edges.

Here in Australia Hinge hole bridging on, scrapers and glue scrapers is a standard inclusion as shown here.....



Servo precision reset to suit tape thickness from the touchscreen or program
- and 4 knife TCT combi cutters - the perfect trimming setup.

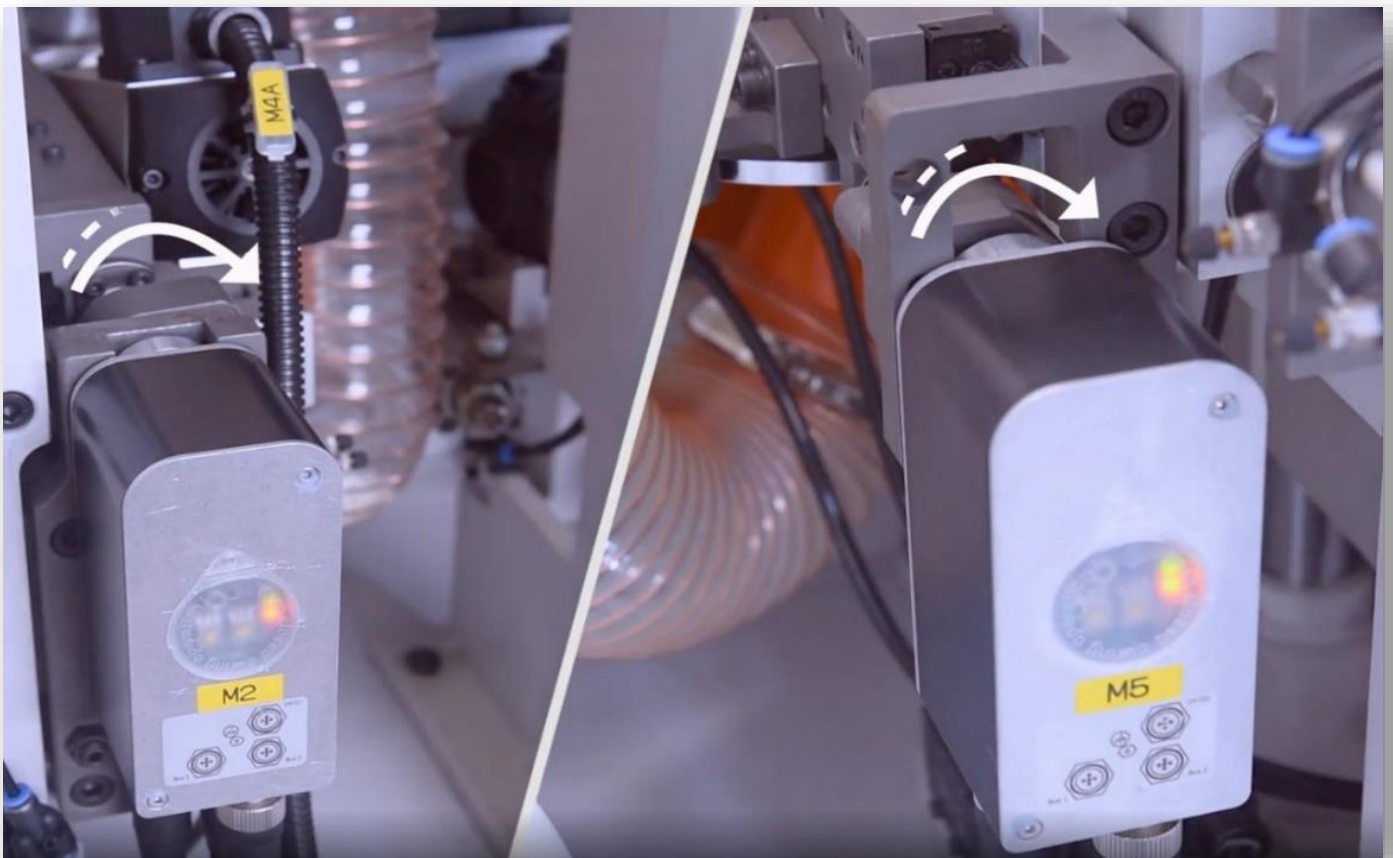
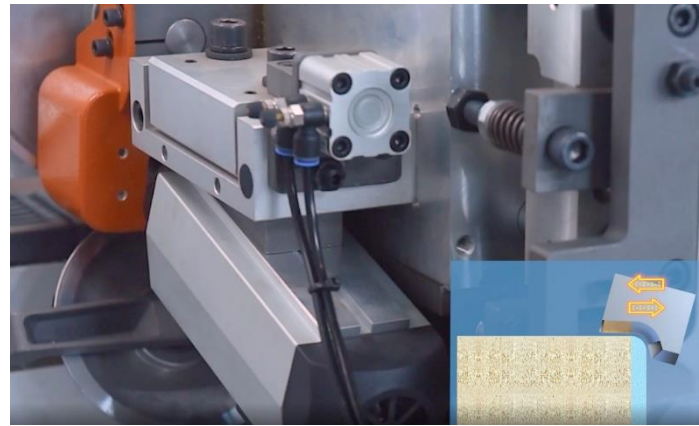
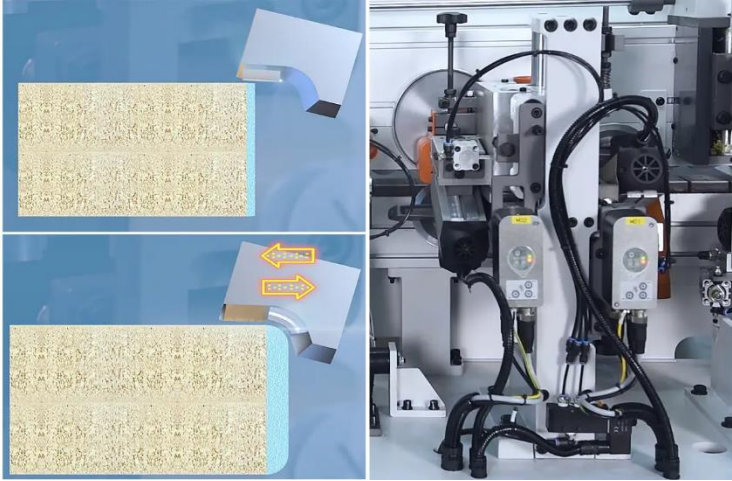


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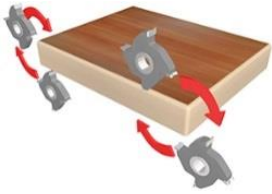


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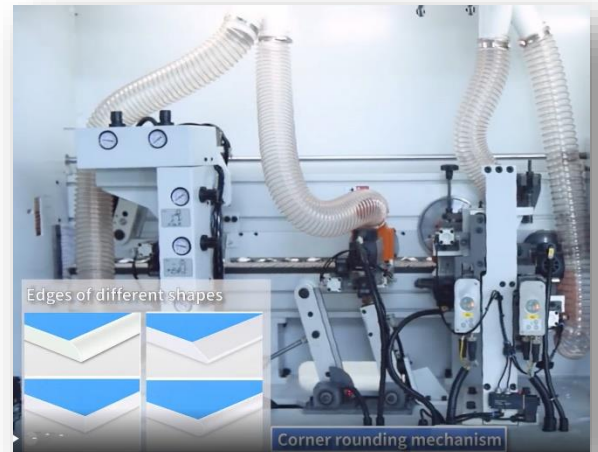
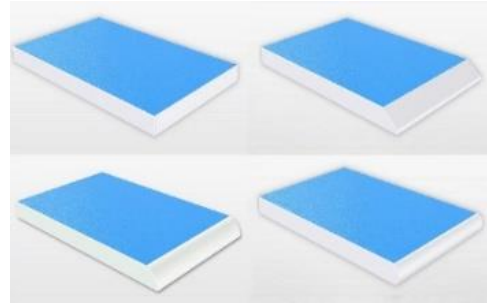


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Corner rounding made easy

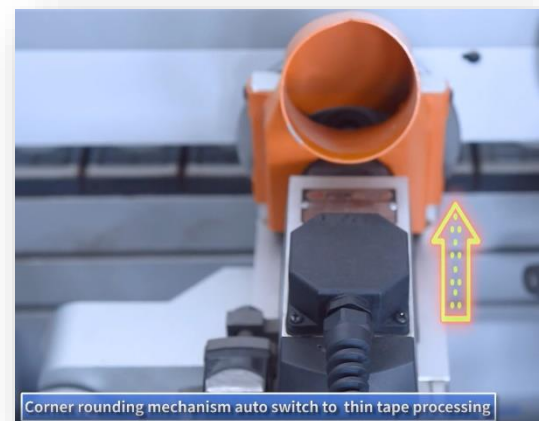
KDT corner rounding simply works and works simply!



Programmed from the touch screen the two-motor unit delivers precise finishes even on post formed and finger pull – and fantastic results on square edge panels

Select full corner round, front only, rear only, top only, bottom only or 360 degrees for great versatility at the touch of an icon.

Feed track speed to 18m/ min can be selected even when corner rounding



Diamond cutter tools – for long term precision

Reset from thin to thick tape – automatically from the touchscreen or within a Program



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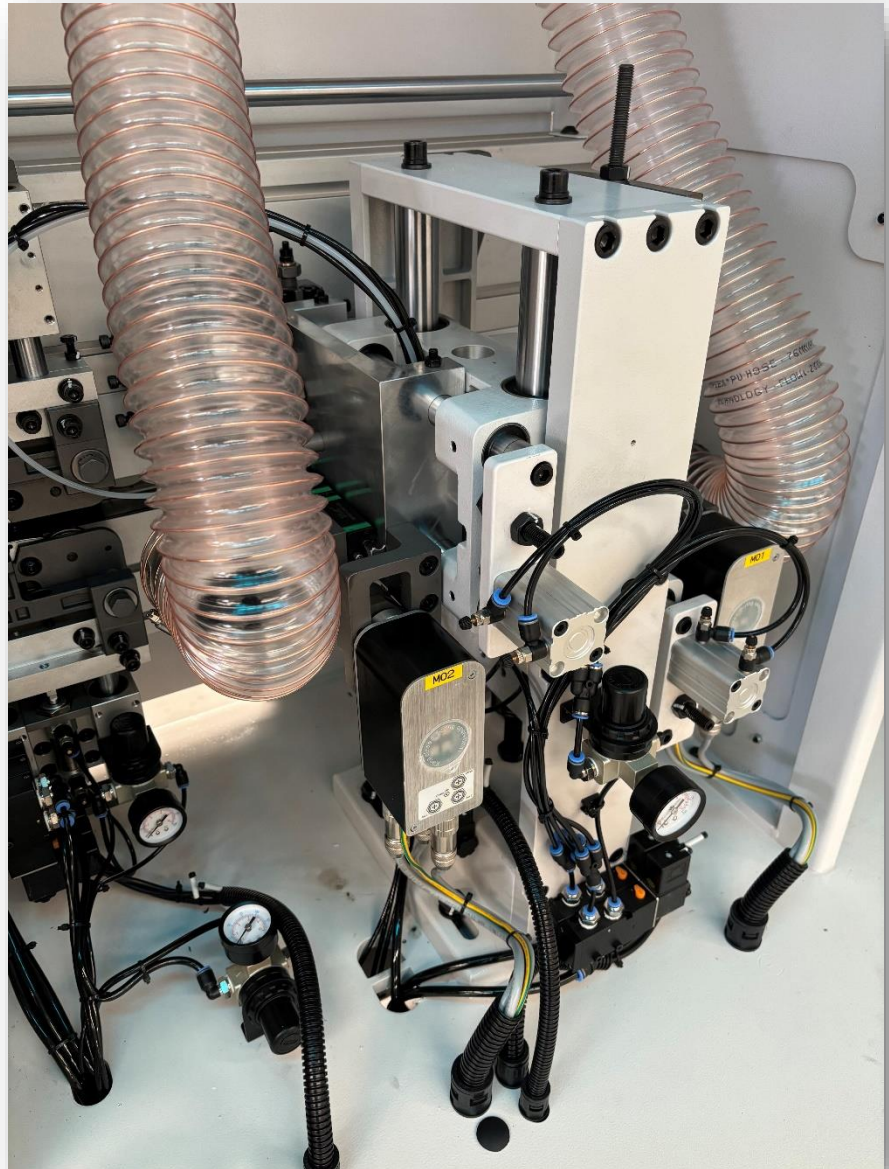
Highest precision Scraping

KDT's use the same cast and steel mounts on the trimmers as scraping is critical to the final appearance of Panels.

Nesting copy wheels with air jet blower cleaning / cooling deliver perfect smooth, cutter mark free finishing. Scrapings extract to a separate collection box so they don't foul your dust extractor fan.

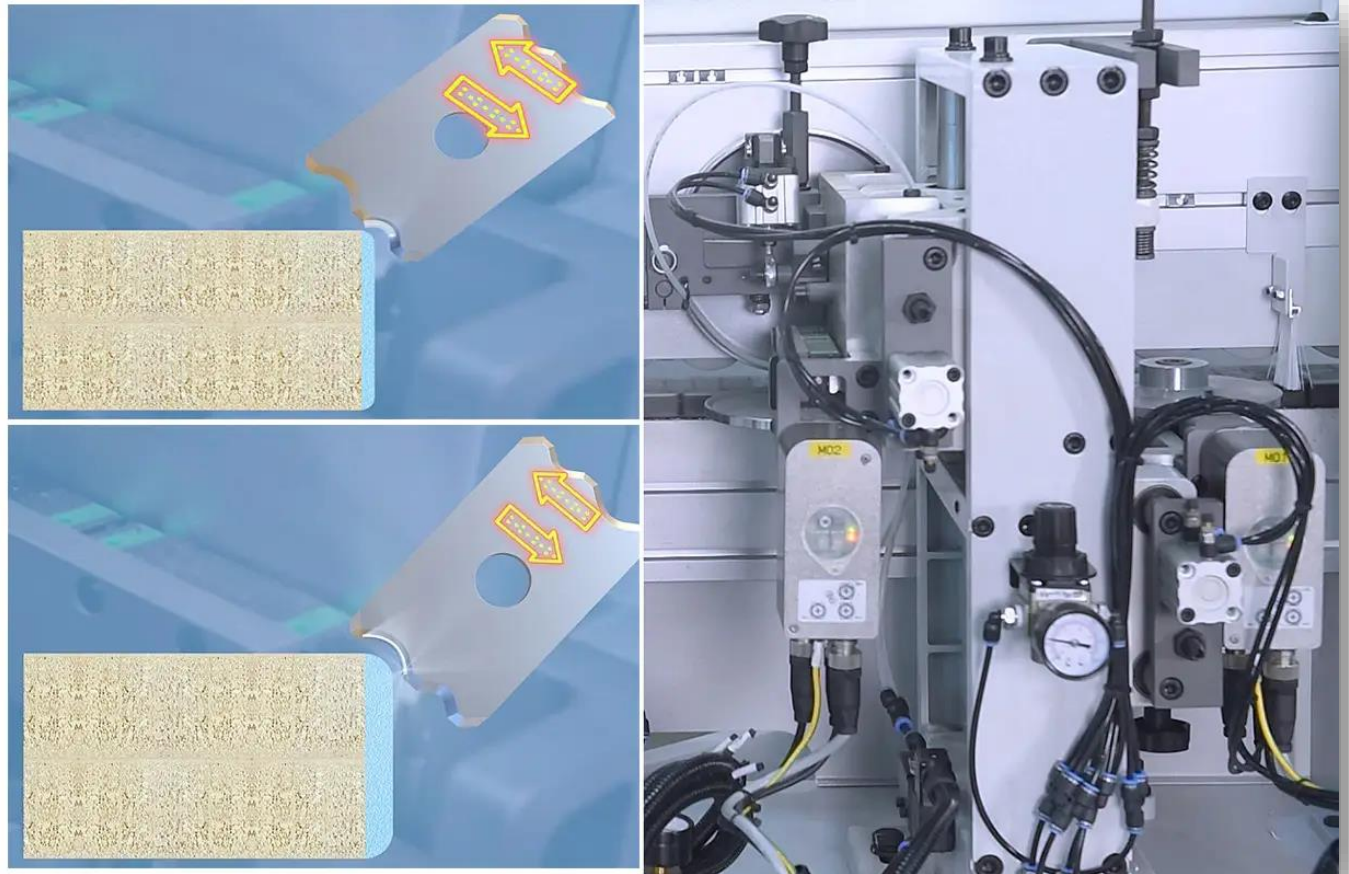
A pneumatic arm cleanly detaches the scraping from the trailing end of panels
Simple and accurate

**2 position auto
Servo drive re-
setting of scraper
knives from
touchscreen allow
perfect 1 and
2mm radius
scraping**





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Two Pneumatic Spray units

Individually Touchscreen activated or programmed – positioned before the Premill to avoid any glue stick and for final polish before Buffing.



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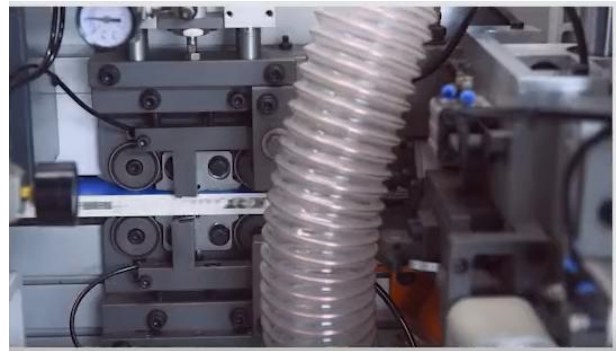
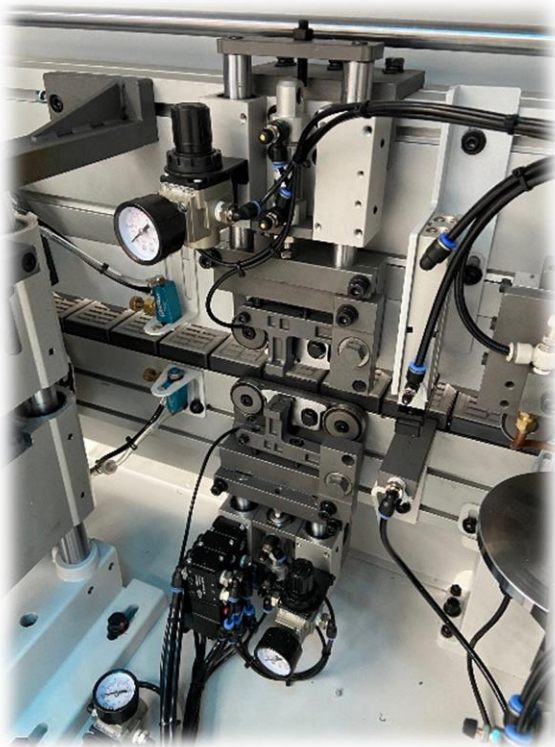
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Flat glue scrapers

With touchscreen or programmed exclusion / activation
Pneumatic timed intervention and 'nest friendly' hinge hole bridging



The final polish

Final cleaning /polishing and restoration of colour to darker tapes is via large 1440rpm buffs on extra heavy mounts that deliver a vibration free finish.

Angle adjustment increase buffer wheel life and results



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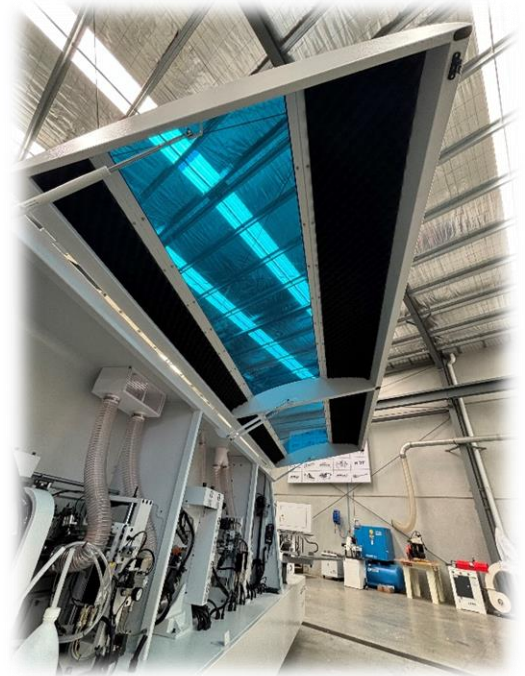


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Keeping things safe and quiet

Heavy construction and sound dampening hoods reduce noise levels significantly.

Electrically interlocked with large windows and internal lighting to easily keep on eye on things.



Extraction is important

Good dust extraction is vital.

All hoods and ducts are large and designed to function efficiently. 4 x 126 and 2 x 100mm connection points

A scraper separation box, scraper blowers and chute to catch and collect end saw offcuts are also included.



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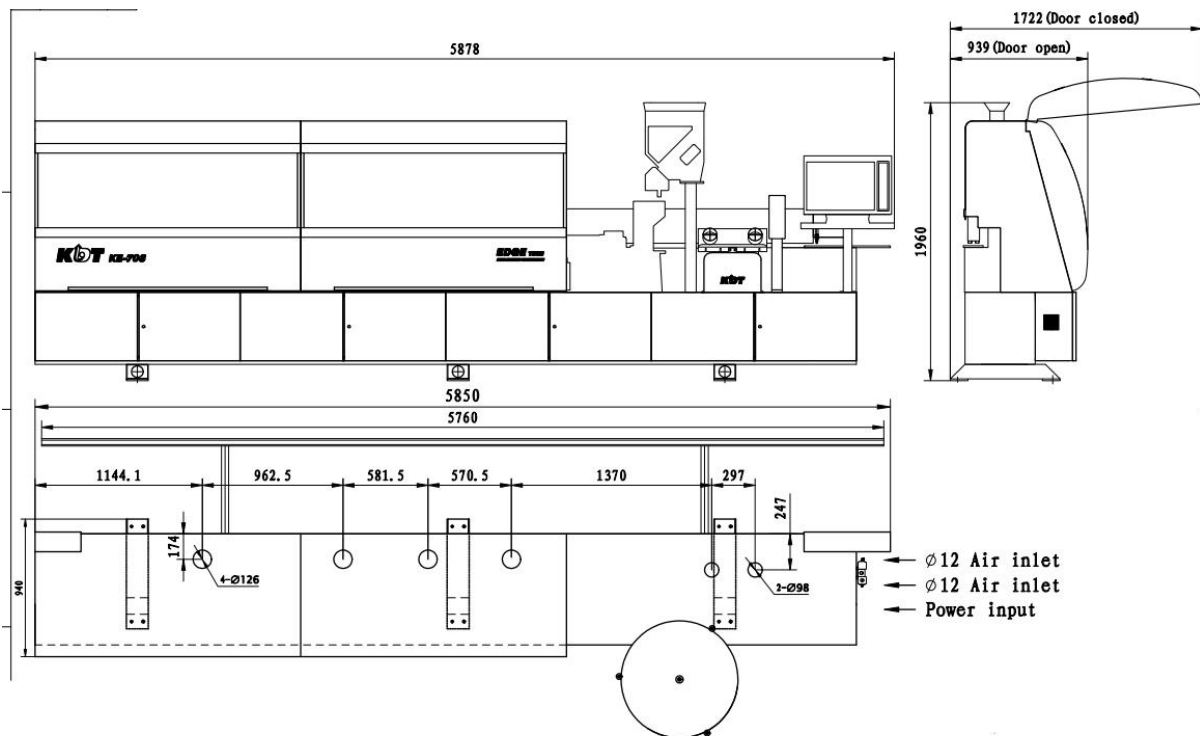
It all adds up....

Fast, easy settings
Attention to even the small details.
Perfect results, straight from the
Edgebander



You have the room...

Compact overall length.



A lot of machine in a small space!



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KDT Edgebanders look great in the workshop enhancing your company's presentation



PANEL DATA

2500kg – solid construction wherever you look!

Feed speed 13 > 18m/min

Tape thickness 0.4 > 3.0mm

Panel thickness 10 > 60mm

Panel length minimum 120mm

Panel width minimum 90mm

Total power 20.73 kw

Overall size 6138mm L X 830mm W X 1960mm H



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OPTIONS

KDT's new KHF530 auto return is perfectly matched to the 706 feed speeds and length.

Variable return speed
13>18m/min



Dust extraction manifolds

Galv steel construction – discharging left or right



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