

One (1)

Secondhand BUERKLE Membrane / Flat Press, ODWMP 1734/12

Downstroke type, suitable for the coating of flat and moulded parts made of chipboards and MDF boards.

Technical Data of the Materials:

1. Substrates:

Dimensions: Length: 250 - 3,100 mm (10" - 122")
 Width: 150 - 1,550 mm (6" - 61")

a) Chipboards and MDF boards, with a smooth or profiled surface
 Thickness: 6 - 40 mm (1/4" - 1 1/2")

Technical Data concerning Energy Consumption:

1. Heating Medium

a) Thermal Oil approx. 150,000 kcal/h (600,000 BTU)

 Time for heating the hot platens
 from 25°C to 140°C (285°F): approx. 1 hour

b) Infrared Radiator Heating
 at the top: approx. 75 kw

c) Maximum energy consumption:
 when flat pressing: 150,000 kcal/h
 for membrane pressing: 100 kw (100 kw + 75,000 kcal/h)

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| 2. <u>Hydraulic Unit</u>
(Approx. 220 liters) | 18 kw |
| 3. <u>Vacuum Pump</u>
(Only in conjunction with
membrane pressing) | 1.5 kw |
| 4. <u>Compressed Air Connection</u>
up to maximum
Consumption when pressing
with the membrane press | 6 bar
600 liters/cycle |

Sequence of Operations:

- 1) Manual loading of the parts on the loading belt
- 2) Automatic loading of the press
- 3) Closing and sealing of the press
- 4) Short heating phase
- 5) Pressure build-up in the pressure chamber up to approximately 6 bar maximum in the space between the membrane and the top heating platen
- 6) Automatically controlled infrared radiators ensure the required temperature level and the reactivation of the glue at a high temperature.
- 7) Bonding (pressing) of the surface material
- 8) Air pressure decrease
- 9) Automatic opening of the press
- 10) Automatic unloading of the boards and simultaneous loading

Item 1:**Loading Belt**

White plastic fabric belt with polyurethane coating. Drive by a reversible geared motor. Covering over the gap between the belt and the infeed of the press. In addition the belt runs on supporting rollers. One-piece support of the belt.

Length of transport approx.: 4,000 mm
Width of transport approx.: 1,600 mm
Working height approx.: 950 mm

Feed coupled with the press loading equipment.

Markings on the conveyor belt for the cylinder rows and the maximum useful width.

Total transport track liftable and lowerable with a guided introduction of the sealing frame and the vacuum plate.

Mobile switch for acknowledgement and stop fitted to the top of the Infeed.

Item 2:**Membrane / Flat Press, Model ODWMP 1734/12****Technical Data:**

Size of heating platens: 1,700 x 3,400 mm (67" x 134")
Useful area: 1,550 x 3,100 mm (61" x 122")
Loading side: 1,700 mm (67")
Total pressure: 5,800 kN (638 tons)

Flat Press (without membrane):

Max. specific hydraulic pressure: 121 N/cm² (172 psi)
Daylight between platens/stroke: 150 mm (6")

Membrane Press:

Max. specific hydraulic pressure: 100 N/cm² (142 psi)
Max. specific pneumatic pressure: 6.0 bar (85 psi)
Daylight between platens/stroke: 400 mm (15 3/4")
Number of pistons: 10 x 160 mm (6 1/4") diameter
Hydraulic operating pressure: 288 bar (4095 psi)

2 steel heating platens
(heated by thermal oil): 2 x 115 mm (5 ½") thickness

Max. operating temperature on the
surface of the heating platens: 150°C (302°F)
Working height approx.: 950 mm (35 ¾")
Weight of the press approx.: 47,000 kg (103,400 lbs)

Special Features:

Frame made of solid steel platens. The frames are mounted on supporting girders.

Heating Platens made of solid steel platens with a polished surface and drilled heating channels. Insulation between frame and heating platen.

Parallel Guiding of the top heating platen by compensating rods and a roller guiding which is independent of temperature.

Hydraulic Cylinder made of steel with guide rings, lip seal packings and dust scraper lip.

Pistons with a chromium-plated surface

Heating Medium thermal oil fed by hoses with stainless steel armouring provided for at the left-hand side

Safety device to avoid the overriding of boards by means of a linear potentiometer, for the adjustment of the thickness of the boards.

Post-Suction Hydraulics with an oil container on the press and filling valves on the cylinders. The pressure is generated by a high pressure piston pump. Manometer to indicate the hydraulic operating pressure, provided for on the face of the press. Automatic opening of the press. Pump and control unit mounted together in between the frames. The hydraulic pressure is controlled according to the pneumatic pressure.

2 Transverse rows of cylinders to be isolated by a push-button in the control desk.

Protective grates at the longitudinal sides which can be pushed upwards.

Coiling station for the protective belt at the top heating platen with fast changing system.

Loading Station with circulation, temperature-resistant synthetic conveyor belts. Smooth starting and smooth slowing down. Covering over the returning belt. Drive by means of a reversible geared motor coupled with the loading belt. Guide rollers galvanized.

Shaking Device for the protective belt at the top heating platen to detach boards which might adhere to the same.

Cleaning Device for the circulating conveyor belts by means of suction nozzles at the infeed of the press.

Item 3:

Sealing Frame

Consisting of:

Infrared Radiator Heating Field

For heating the surface material, heating power approximately 75 kw.
4 steplessly adjustable heating zones.

1 Membrane Clamping Device

with a fast changing system for the membrane

1 Membrane Cloth

Item 4:

Vacuum Unit

Consisting of:

Vacuum Plate

with vacuum connection above the bottom heating platen.

Vacuum Pump

with container and connecting lines

Item 5:

Outfeed Roller Track

To take-over the finished boards. Dwell time on the rollers serves as cooling time.

Item 6:

Thermal Oil Heater and Secondary Control Circuits

Provided by user

Item 7:

Switch Cabinet

with microprocessor based programmable control (PLC make Schleicher, Promodul U). Cables placed on the floor (approx. 5 meter long).

Item 8:

Control Desk

Self-contained, at the left-hand side next to the sliding table, with ABT control panel to input the length, width and number of boards, the specific pressure and calculation and adjustment of the hydraulic pressure with the possible isolation of the cylinders. Pneumatic SET/ACTUAL pressure, input and 2-circuit time control. 4 Position selector switch for preselection of the programs.

Electric Equipment and Regulations:

Operating voltage: 460 volts, 60 cycles
Control voltage: 110 volts, 60 cycles, 24 volt DC
Total connected load: approx. 110 kw

Electric equipment as per VDE using UL components.
Electric switches UL approved, make Klockner-Moeller,
Motors as per NEMA regulations.