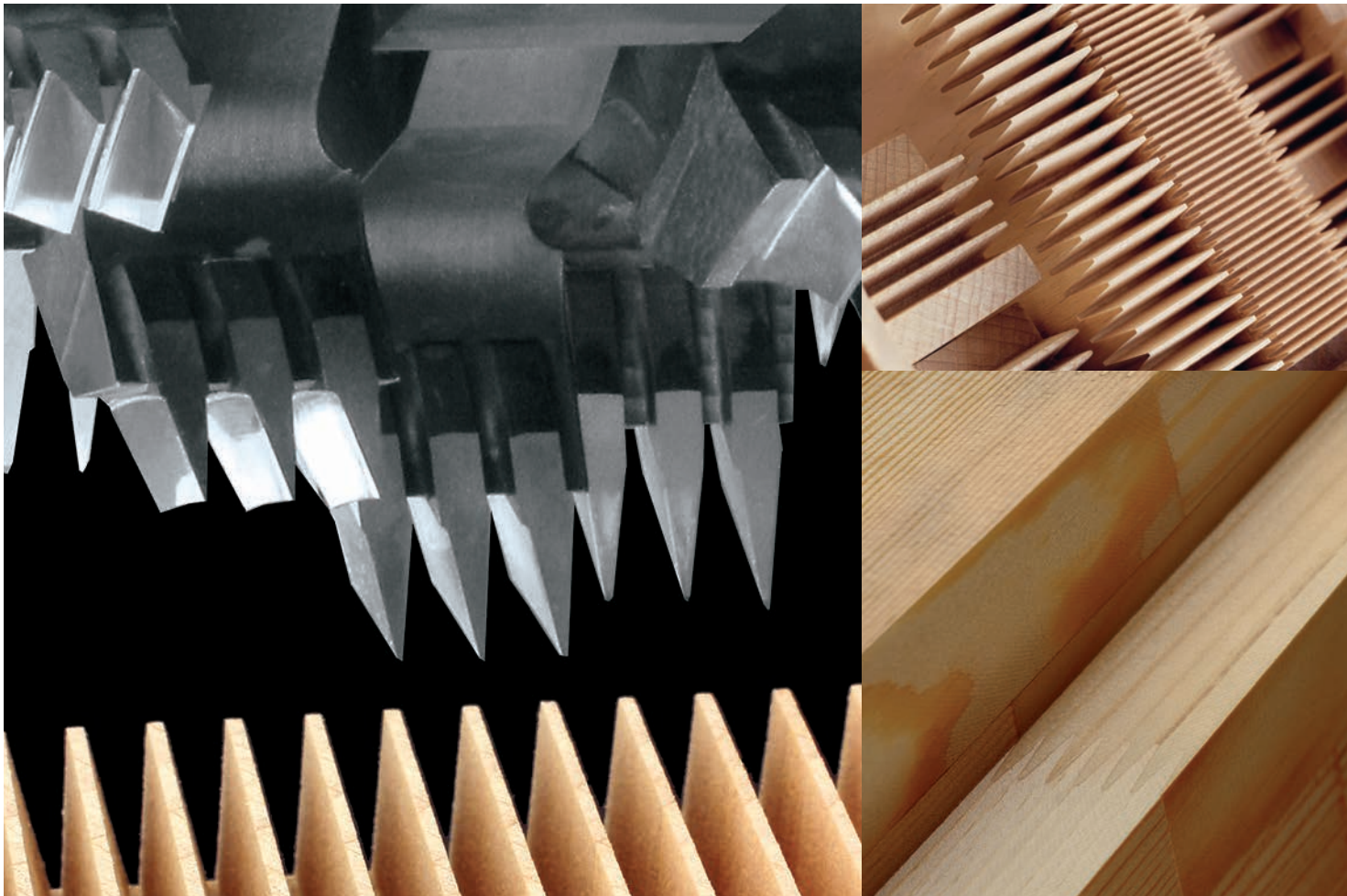


# Finger jointing lines CombiPact

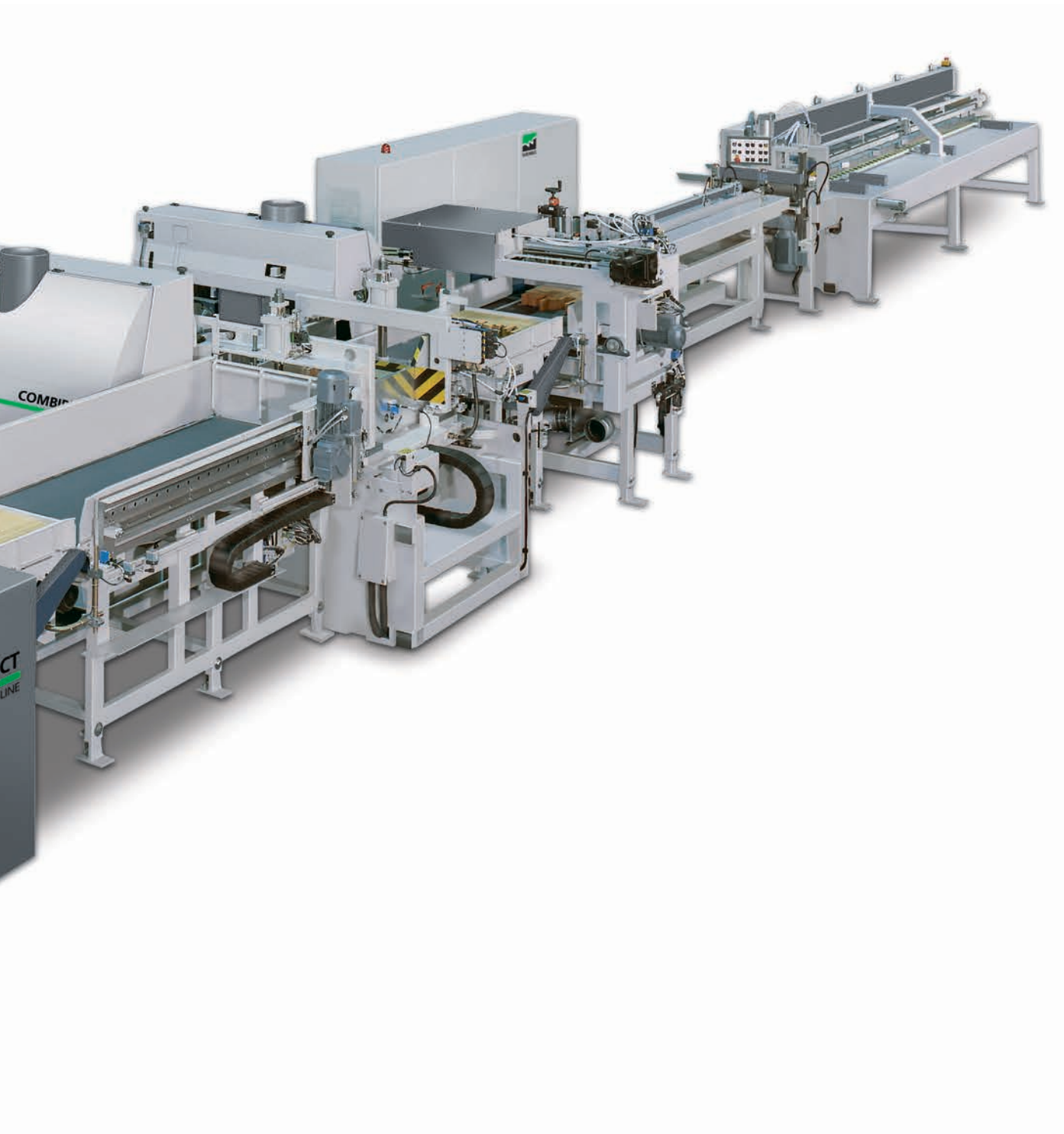
High performance for horizontal and vertical joints



## **WEINIG GRECON Finger jointing line CombiPact – State-of-the-art technology for tomorrow's demand**

WEINIG GRECON is the leading manufacturer of innovative finger





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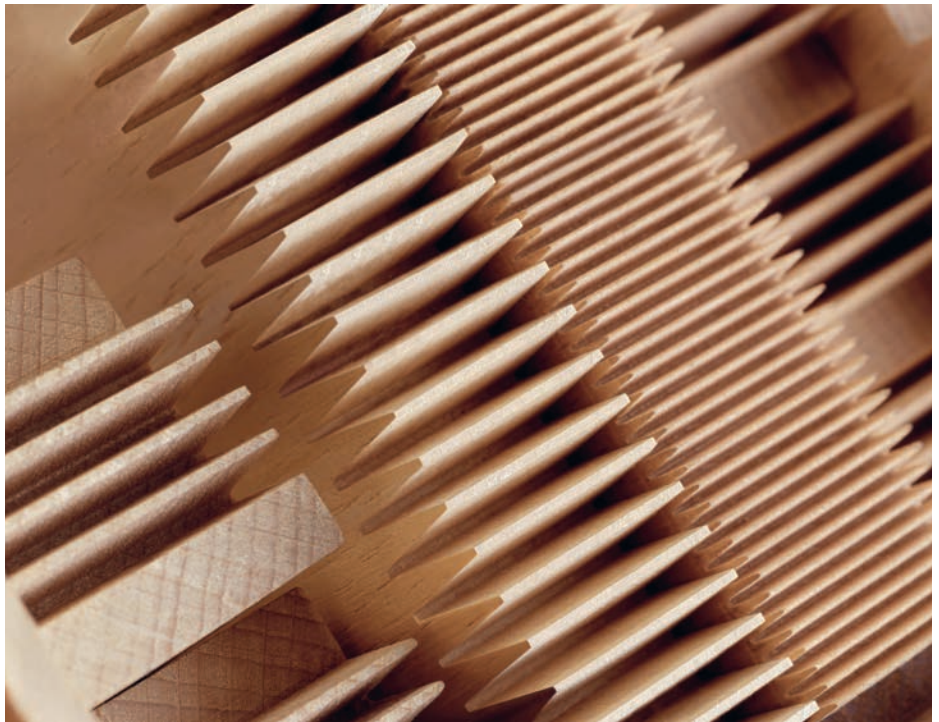




13:13:56	Order	24.04.2015	
Timber width/ thickness	65.00 /	23.00 mm	
Target 1 : Quantity / Length	1 /	6340.00 mm	
Target 2 : Quantity / Length	0 /	0.00 mm	
Target 3 : Quantity / Length	0 /	0.00 mm	
Quantity Pressing Cycles Target / Actual	0 /	0	
←	Shaper	Press	Parameter

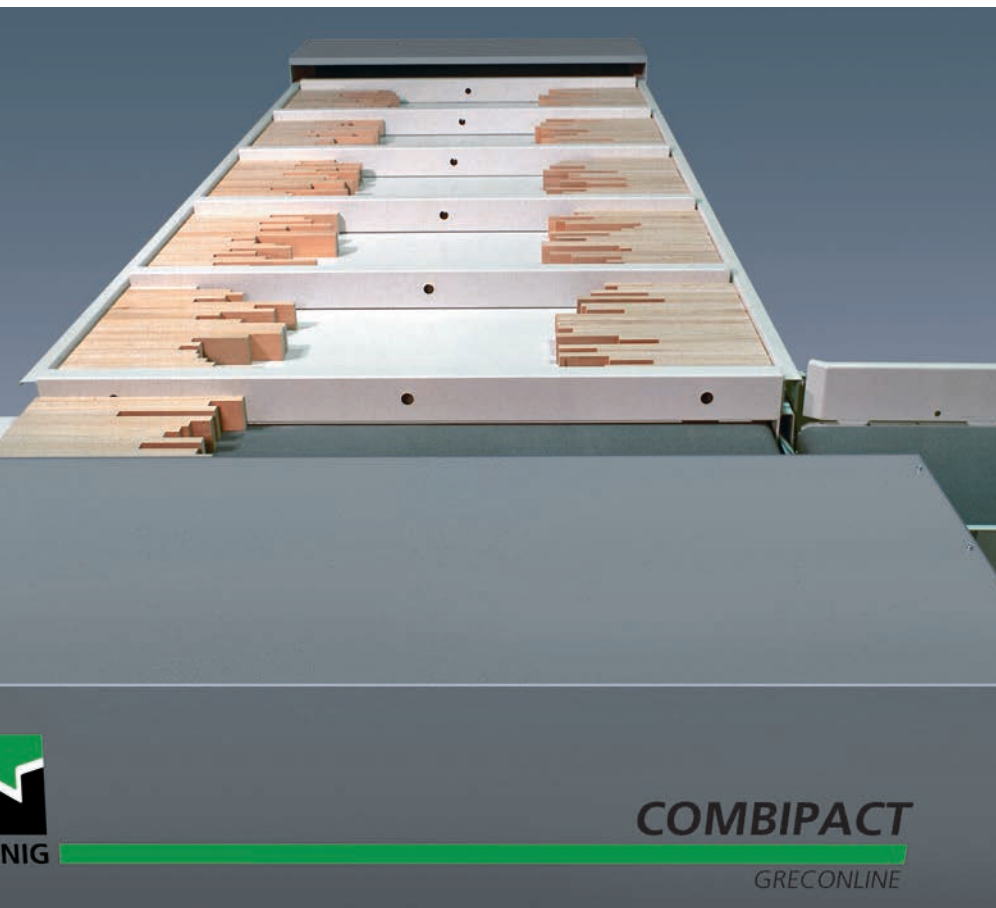
## **Finger jointing with WEINIG GRECON: Highest quality standard in all capacity ranges**

Perfected technology and innovative overall concepts characterize the package shapers. No matter what the field of application is – furniture and interior fitting, stairs, window scantlings, doors, profiles, etc. The WEINIG GRECON finger jointing lines are taken as an industry standard with regard to precision and quality. In addition, you can make a profit from the increasing popularity of finger jointed solid wood products sold in a variety of markets.



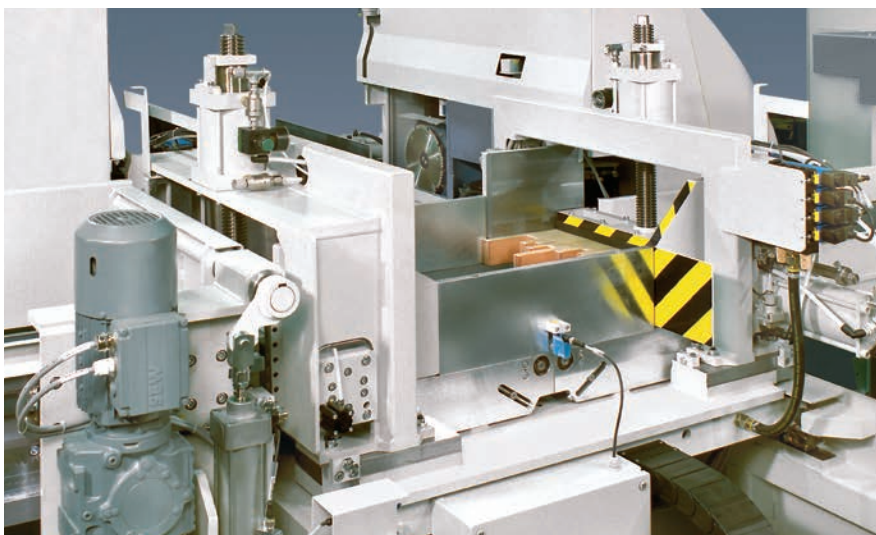


## WEINIG GRECON CombiPact – Simple and optimized feeding



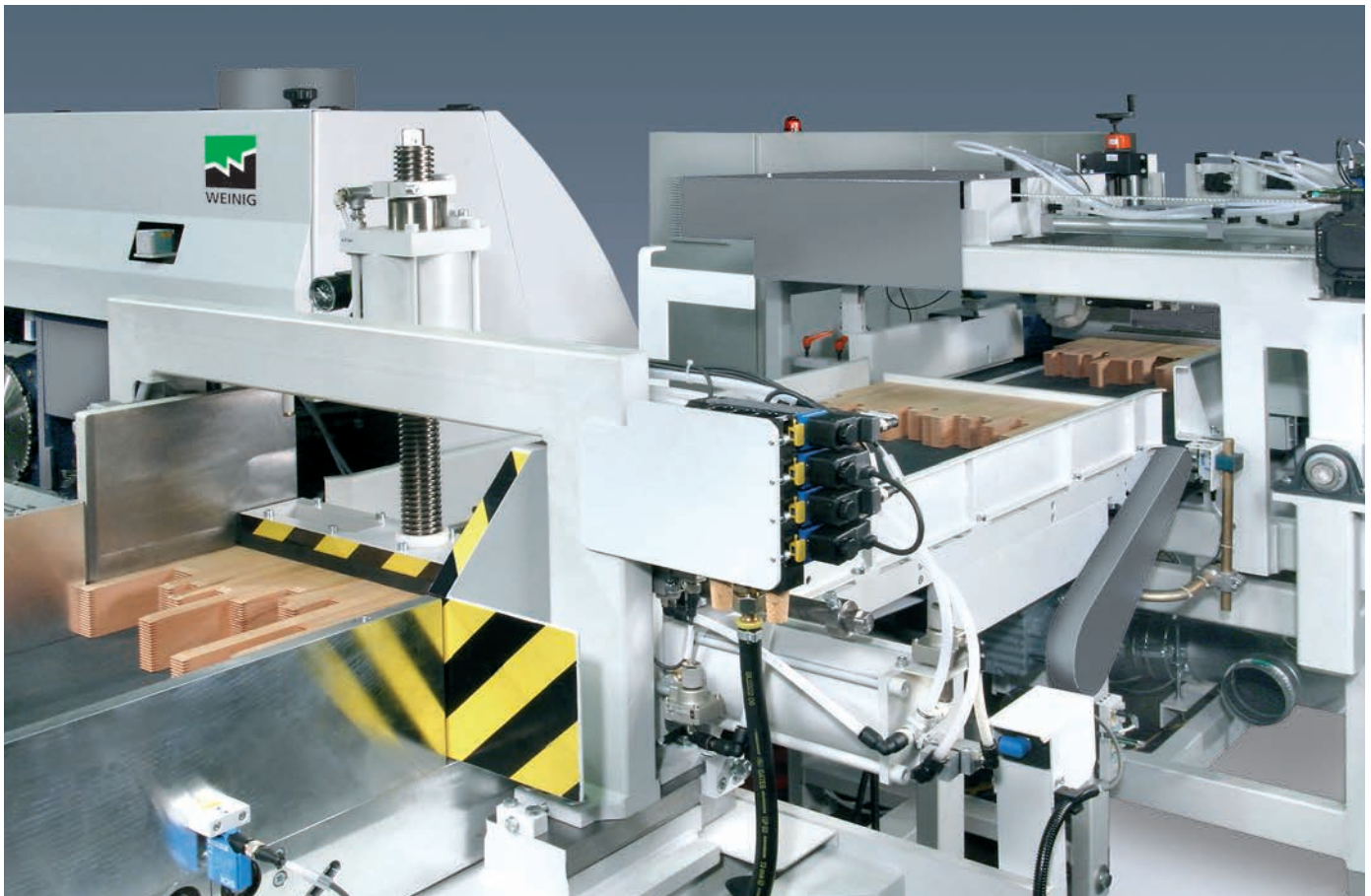
### Feeding by compartment-type conveyor

The feeding by a compartment-type conveyor is a comfortable alternative to the high speed feeding system of the CombiPact lines. A higher capacity of the line is guaranteed by a feeding from two sides (optionally). The liftable and lowerable function of the first compartment makes an easy filling of the buffer (optionally) possible.



### Feeding station

Due to the maintenance-free feeding motor, the timber pieces are automatically aligned at their front end and fed into the shaping unit. The reverse motion of the transport belt ensures the alignment at the frequency-controlled pusher. At the same time when a completely processed timber package leaves the processing unit, the next package is precisely positioned in the clamping station.

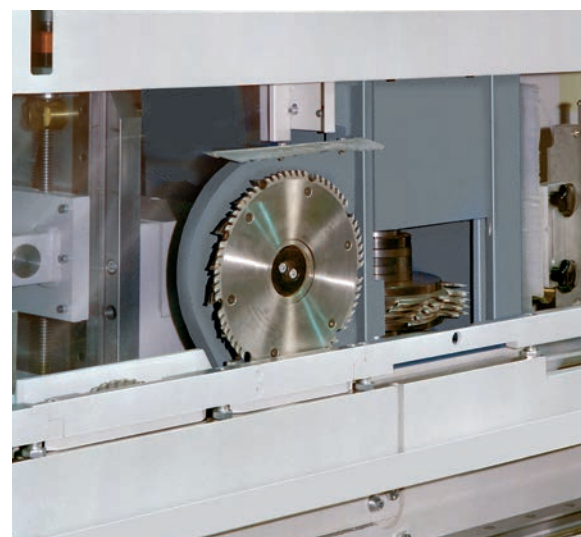


### **Complete automation through and through**

Once the timber package has been fed into the feeding unit, the following processes are carried out fully automatically: Alignment, cutting, glueing, discharge, separation, joining and pressing. All line components match each other perfectly and ensure an efficient and troublefree operation at the highest rate of utilization possible. Thanks to the exact dosage of the glue application "FlankenJet" developed by WEINIG GRECON, a glue saving of up to 30 % is achieved.

### **An excellent tool configuration**

including scoring saws from the top and bottom, hoggers and cutters (adjustable within a 1/100 mm range) is the basis of the production of precise finger joint profiles. The scoring saws are synchronized to prevent tear out. The indirect drive of the maintenance-free WEINIG built tool spindles ensures high capacity reserves and vibration-free processing of short timber pieces. This ensures precise joint quality without any chip-out from the finger base to finger joint point and an absolutely tight finger joint.







### **The tool technology**

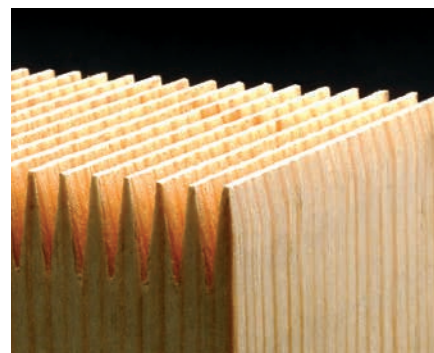
is state of the art. Finger lengths from 4 up to 15 / 16.5 mm can be processed. Cutters having a diameter of 250 and 260 mm (at a finger length of 15 / 16.5 mm) and produced by various tool manufacturers process the requested finger profile up to 205 (225 \*) mm (cutting height) at a very high speed, with highest precision and quality.



## **WEINIG GRECON CombiPact – Highest degree of safety, perfect finger joints**

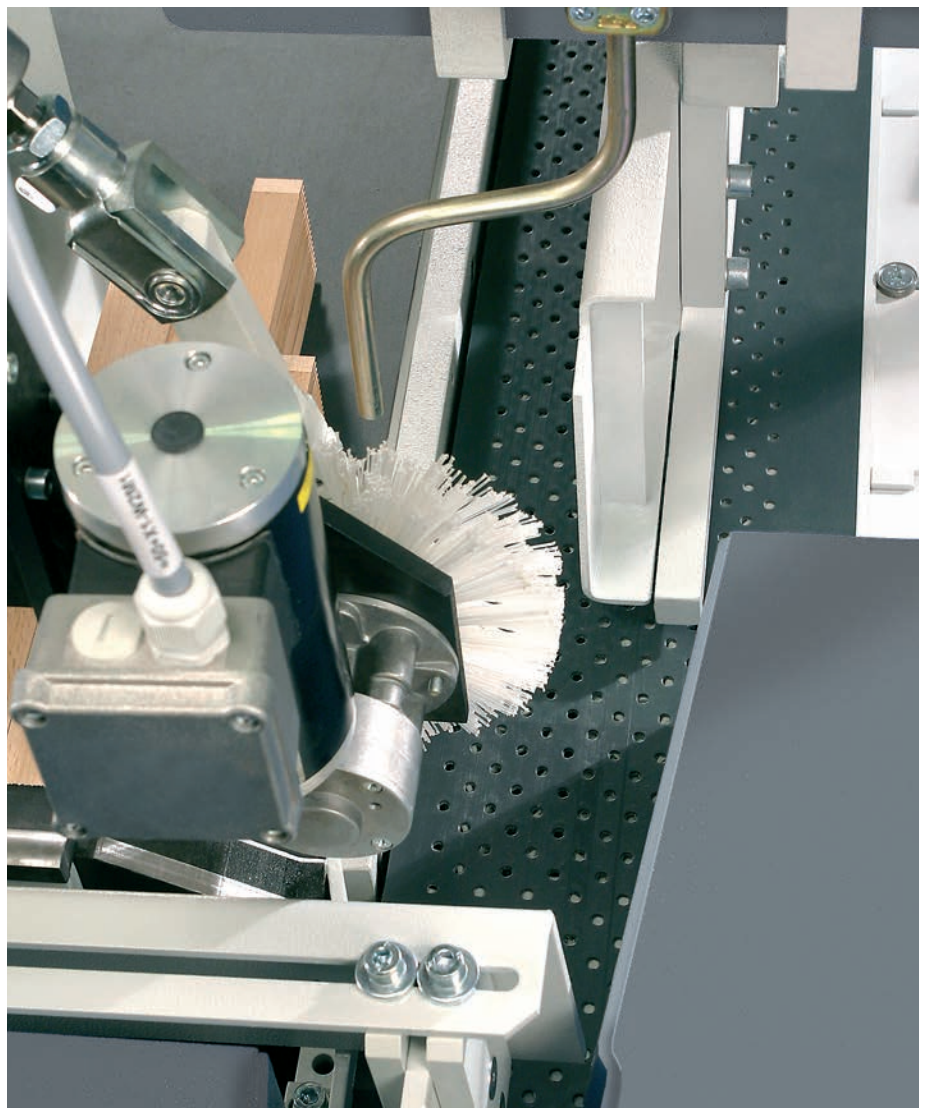
The top pressure beams of the clamping stations can be adjusted to the cutting height. Thus the reduction of the lift of stroke minimizes the clamping time and increases the productivity. The pressure control of the clamping stations ensures absolute production safety.

The swivelling splinter protection sits close to the timber package during the shaping process avoiding tear-outs at the finger joints of the very last timber piece. All this results in finger-jointed timber lengths which require the minimum of further processing.



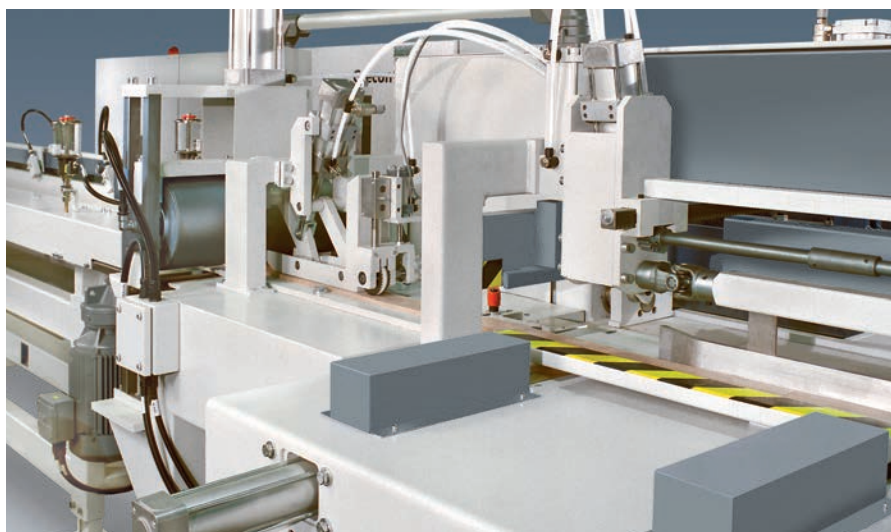
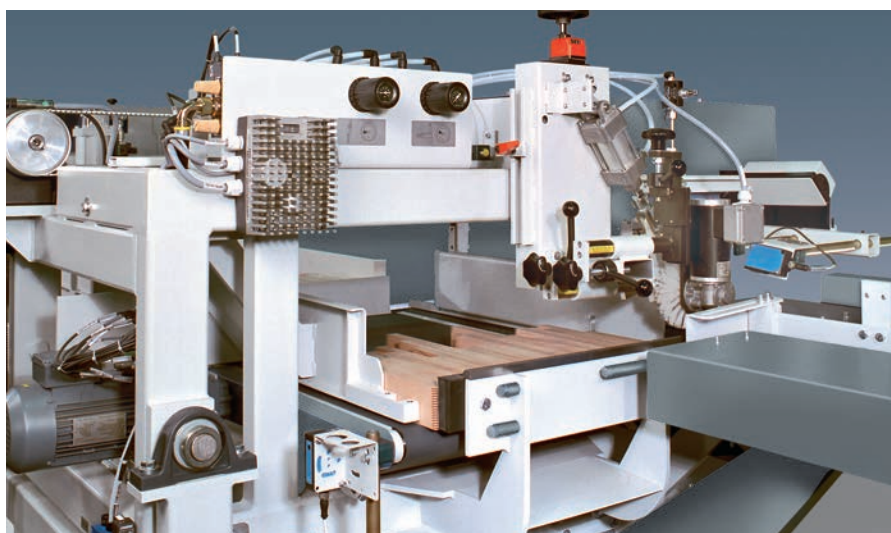
## WEINIG GRECON CombiPact – Perfection in detail

- Frequency-controlled transport belts at optimum speed and positioning at the limit stops (optional).
- Fully automatic transfer station incl. patented suction air belt to transfer the pieces to the feed-in track with slip reduction.
- Maintenance-free servo cross transport device for the separation of the finger-jointed timber packages.
- The liftable and lowerable function of the transfer station ensures precise adjustment of the table in order to reliably separate the vertically finger-jointed timber packages. In case of horizontally finger-jointed packages, the transfer station is on the same level as the suction air belt.
- The speed of the frequency-controlled brush-type motor can be adjusted as required to carry out the separation of the finger-jointed timber pieces. Each timber piece is quickly positioned on the suction air belt.
- Feed-in track including non-contact, electronic filling control.
- Lateral chains and pressure rollers (optional) ensure the precise alignment of the timber bar on one side.
- Automatic lubricating device (oil)



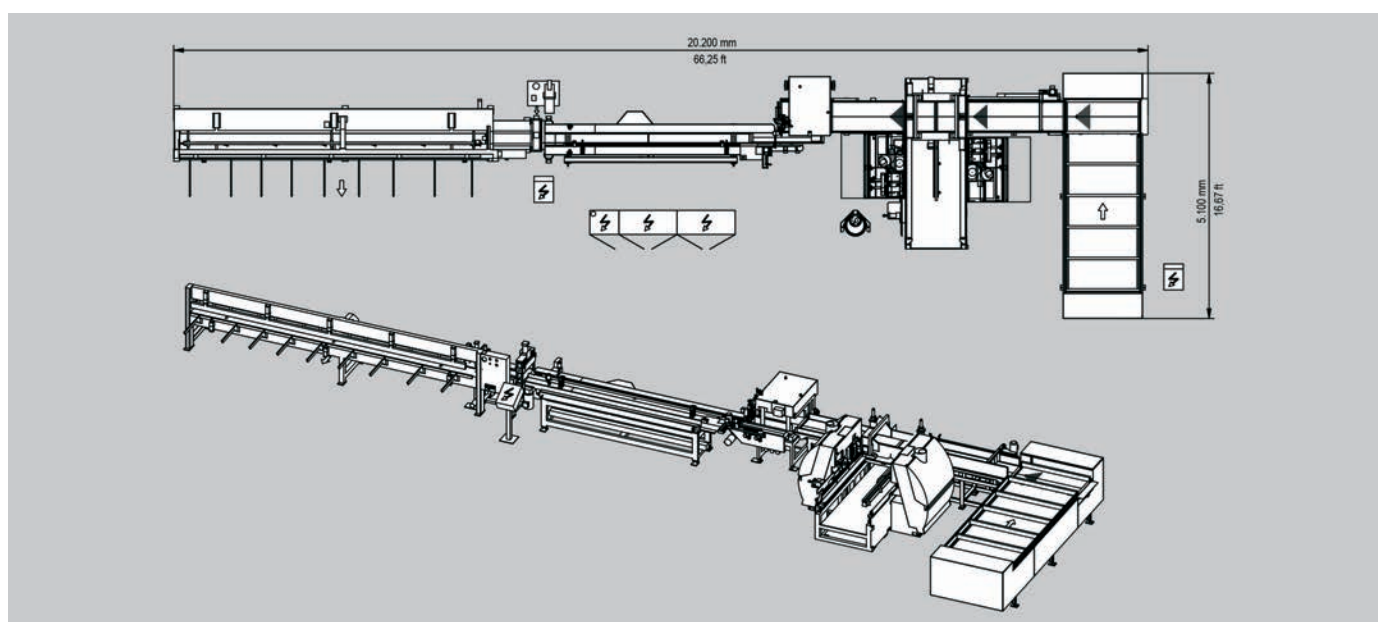
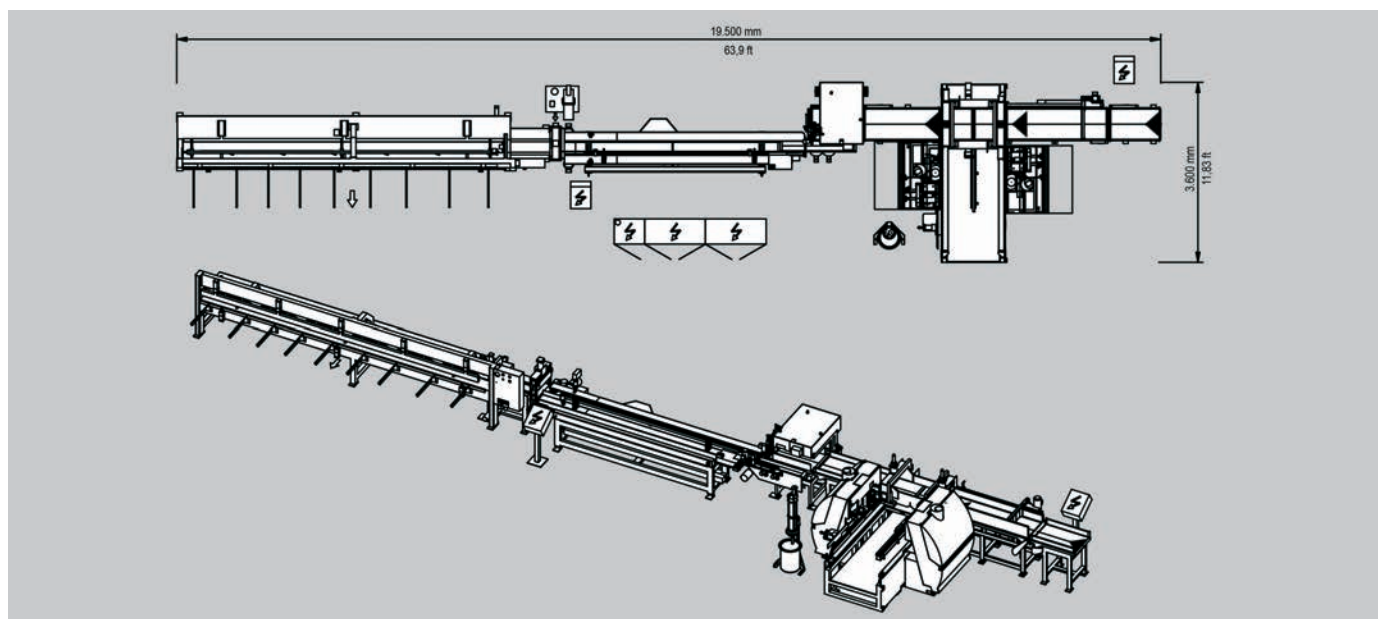


- used for the chains.
- Frequency-controlled feed motors ensure fast feeding of the press.
- A brake unit required for prepressing and the subsequent length measurement ensure the exact feeding of the press.
- Two-channel press; feeding and pressing are carried out at the same time; Optional capacity up to 12 cycles per min./73 m per min., (240 ft / min.).
- Intermediate cuts are possible by entering the dimensions at the central operating panel.
- Even the shortest timber pieces are perfectly positioned in the press area by means of an additional cross pusher installed in the infeed area of the press.
- Automatic adjustment of the final length at the press (optional).



## Finger jointing lines CombiPact: Standards and options

Only the intertwining of all automation modules by control technique on highest level makes permanent and continuous performances without interruptions possible. WEINIG GRECON experts develop solutions for your specific requirements from proven, reliable elements.



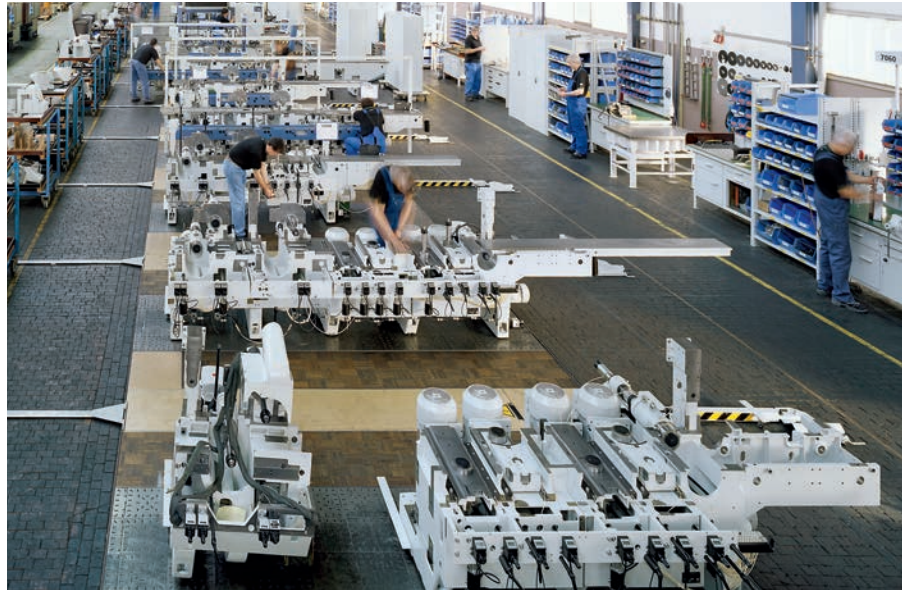




The matrix shows the significant features.  
Your WEINIG GRECON expert provides you any  
information taking into consideration your  
individual needs.

Facts	CombiPact
Infeed length	150 - 1000 mm
Timber width	40 - 205 mm
Timber thickness	20 - 80 mm
Outfeed length	3000 - 6100 mm
Thrust force	120 (145) kN
Timber cross section at a finger length of 10/11mm (softwood)	100 (120) cm <sup>2</sup>
Timber cross section at a finger length of 10/11 mm (hardwood)	80 (96) cm <sup>2</sup>
Capacity (vertical jointing) with 30 x 90 x 400 mm	41.8 m/min
Capacity (horizontal jointing) with 22 x 50 x 350 mm	19.25 m/min
Feeding system	Feeding conveyor/compartment type conveyor
Shaper types	Package shaper combination
Transfer	Automatic, servo-controlled
Press	Two-channel press
Production statistics	●
Diagnosis system	●
Multiple lengths	●
Intermediate cuts	∞
Compartment-type conveyor	○
Horizontal jointing	○
Timber tear-out prevention (scoring unit at the bottom)	○
Timber thickness min. 16 mm	○
Timber thickness max. 100 mm	○
Timber width min. 30 mm	○
Shuffling limit stop	●
Timber package control	●
Splinter protection	●
Glue application system FlankenJet	●
Different kind of glue	○
Communication (teleservice)	○
Capacity reserve cutter spindle drive (37 kW)	○
Frequency controlled shaper table	●
Power shaper	22 (37) kW
Power hogger (+ scoring unit)	11.5 (15) kW

## WEINIG quality: The sum of many properties



Not many companies succeed in becoming a brand. WEINIG has succeeded in doing so. Trust plays a central role here. And the ability to prove this trust on a daily basis with our customer. We do this with quality. From product development to our supply of spare parts, from materials used to our worldwide service network. Based on employees noted for their expertise and passion for the product. Utmost care in assembling machines is part of this, as is continuous training. In order to maintain WEINIG's high standards we focus on vertical integration and independent quality management. Based on the world famous kaizen method, our production undergoes a continuous optimization process.

But WEINIG quality also means aligning production for the future with open machine systems, energy efficiency and sustainability. All these characteristics blend to create a product praised by our customers around the globe as outstanding. We call it 100% WEINIG quality.



## WEINIG service: Very close to customers



Customer relations are good. But we have a better word for it: WEINIG service. Supported by people who want to share their enthusiasm for wood with others. And when experts start talking together, a solution is not far away. This is why WEINIG service focuses on dialog with you, on outstanding training and a local support presence. The global WEINIG service network is so densely spread like no other in the sector. For you this means easy communication in your own language and rapid help. Whether by telephone or by a technician on site. We are here for you when you need it. You can order any spare part you need via the hotline for rapid delivery - even old models.

You will be advised in detail by a professional WEINIG expert in your country. In our individually tailored training programs you can find out how to optimally exploit the capabilities of your machine. Our specialists are always open to your production tasks.

- Subsidiaries in all continents of the globe
- Local WEINIG expert who speaks your language
- Mobile team of over 300 service technicians
- Spare parts via the hotline
- Professional advice by specialists via the hotline
- 6 day service
- Individually tailored training program
- Service agreements on request
- International ExpoCenter
- Financing to suit your needs

# Finger jointing lines CombiPact

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## **Product Unit Jointing Technology**

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