

# World of finger-joints

**Compact finger-jointing-lines**

**Finger-jointing cycle center**

**Packet finger-jointing lines**

**Crosscutting machines**

**Testing sets**

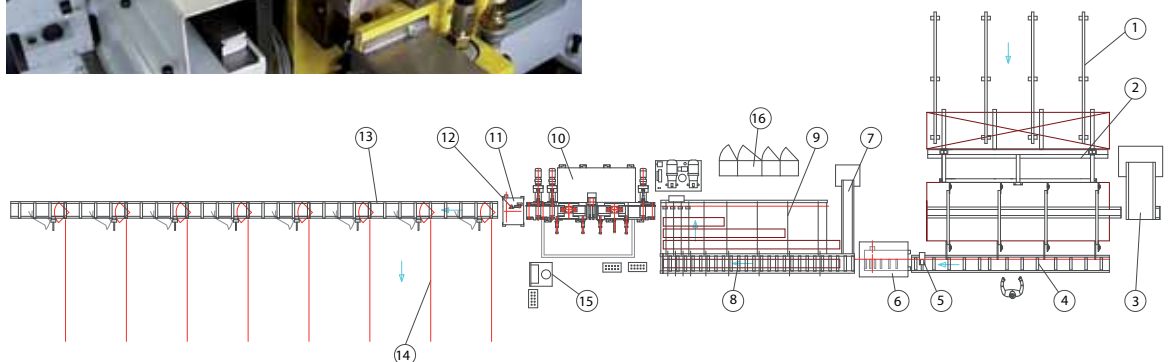
**Mechanisation systems**



# Compact finger-jointing line type FLP 6 – 50 tons of press capacity



For more than 20 years the compact finger-jointing automated line type FLP is the most successful machine SMB offers for production of construction timber and laminated wood. Ranges from 6 to 50 tons of press capacity enable to choose the line in accordance with the own personal need.



- |                            |                                |                                   |                    |
|----------------------------|--------------------------------|-----------------------------------|--------------------|
| 1 Cross conveyor           | 5 Moisture measuring station   | 9 Feeding magazine                | 13 Lamella stacker |
| 2 Tilt destacker           | 6 Cut-off saw                  | 10 Compact fingerjointing machine | 14 Cross conveyor  |
| 3 Belt conveyor for sticks | 7 Waste belt                   | 11 Crosscut saw                   | 15 Glue supply     |
| 4 Fault assessment center  | 8 Roller conveyor with ejector | 12 Length measurement             | 16 Switchcabinet   |

# Compact finger-jointing line type FLP 2 With vertical and horizontal milling cutter 6 – 50 tons of press capacity



Both vertical and horizontal finger jointing process is permitted on the same line.

Gluelam, solid construction timber as well as log house planks can be efficiently produced. The line is fitted with two cutterheads and two press slides. Machines operator may choose by simple switch on the control board the way of finger-jointing.

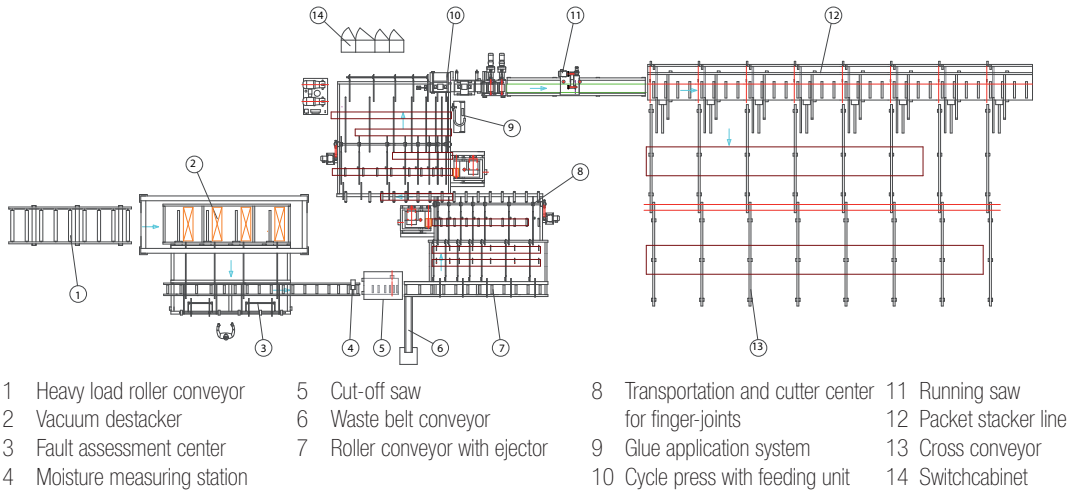


Several sizes from 20 to 30 tons of pressure capacity are at your disposal. Glue application system for all types of glue can be mounted on the machine.





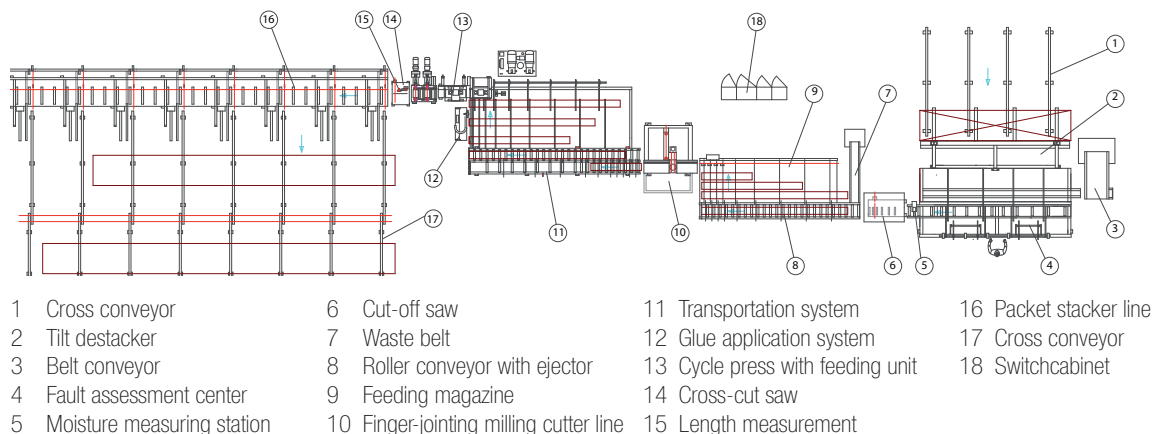
The finger-jointing cycle center type MKZ is equipped with two milling cutters erected separately. The workpiece is moved from one milling cutter to the other by passing a changing unit. A feeding with wood pieces of very different length requires this special setup. Personal needed requirements and space available make you choose between the types TKZ or MKZ.



## Milling-cutter press combination type GFP

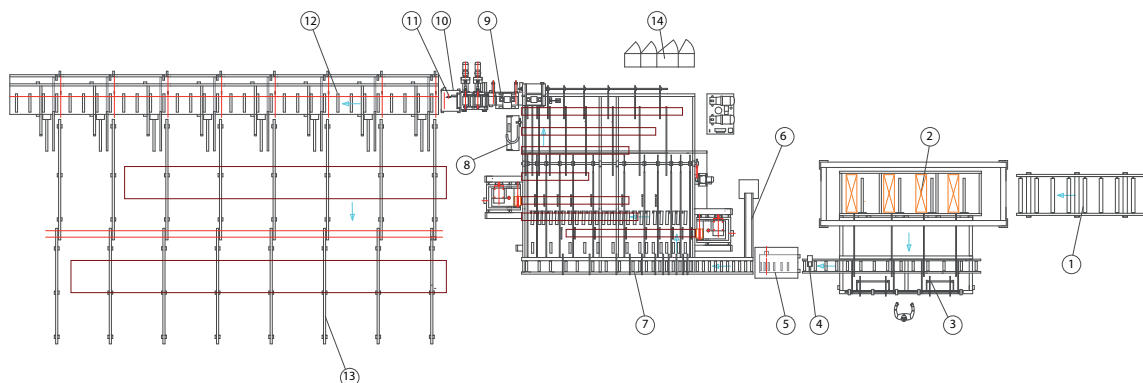


The type GFP offers a milling-press combination with contact-free glue application which finally increases considerably the output of a standard compact finger-jointing line. The line can be fitted with a glue comb. Press capacity can be chosen between 6 up to 50 tons.



# Finger-jointing cycle center type TKZ

The finger-jointing cycle center type TKZ is fitted with two milling cutters, a contact-free glue applying system and a high capacity cycle press. This plant is to be considered as the most efficient on the market. A speed infeed-system with servo motors and an effective sequence control system assure a higher-than-average output



- |                              |  |                                 |                        |
|------------------------------|--|---------------------------------|------------------------|
| 1 Heavy load roller conveyor | 5 Cut-off saw  | 8 Glue application system       | 12 Packet Stacker line |
| 2 Vacuum destacker           | 6 Waste belt   | 9 Cycle press with feeding unit | 13 Cross conveyor      |
| 3 Fault assessment center    | 7 Transportation and cutter center for finger-joints | 10 Crosscut saw                 | 14 Switchcabinet       |
| 4 Moisture measuring station |  | 11 Length measurement           |                        |



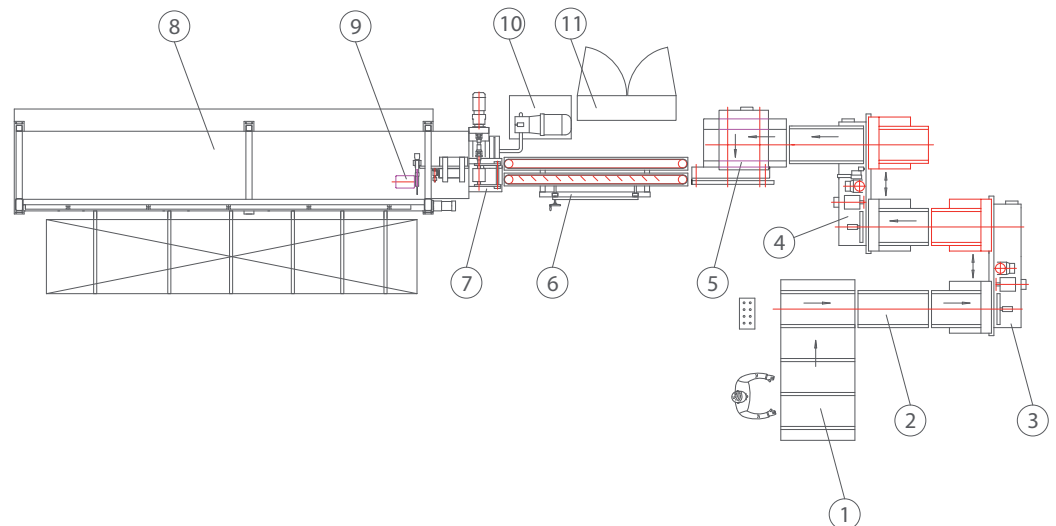
# Fully automatic packet finger-jointing line type VPK



The line is designed for milling work pieces of different length within one packet. Work piece clamping is done by pressure controlled clamping elements, horizontally and vertically placed. Movement of milling table is frequency controlled and infinitely adjustable. The way of handling timber is optionally both horizontally or vertically. Glue application is done by glue comb and membrane pump.



Work pieces are moved by tilting activity or direct transfer. The infeed-line is designed by a solid chain conveyor and a spring mounted chain conveyor, in vertical direction. High efficiency of the line is given by a simultaneous feeding and pressing effectuated on the level of the hydraulic front side press. Electronical measuring is an option how to cut final length. Feeding of the line can be realized by several different systems. An automatic stacking device can be mounted as an option.

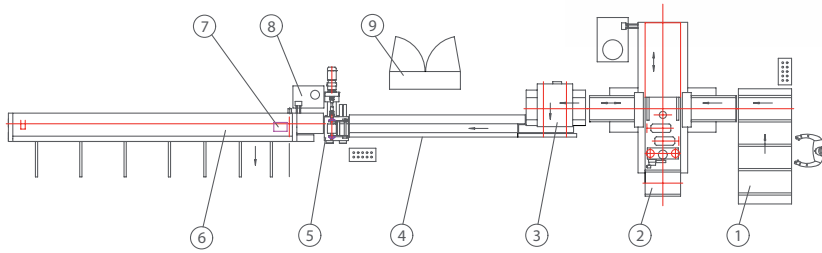


- |                                |   |                         |                   |
|--------------------------------|---|-------------------------|-------------------|
| 1 Preparing and feeding device | 4 Packet cutter machine 2 with glue application | 6 Pre-assembling device | 9 Cross-cut saw   |
| 2 Conveyor belt                | 5 Transfer and turning station                  | 7 Double roller infeed  | 10 Hydraulic unit |
| 3 Packet cutter machine 1      | 8 Front side press                              | 11 Switchcabinet        |                   |



# Fully automated packet finger-jointing line type SPK

Compartment packeting station in front of the finger-jointing central milling cutter line with two fix transporting plates  
An operable processing unit  
Two milling spindles with two chipping machines; a one or double-sided glue application.  
A transfer and turning station with tilting equipment into the feeding gate  
Solid double feed roller and a robust front side press fitted with a fixed cross-cut saw.

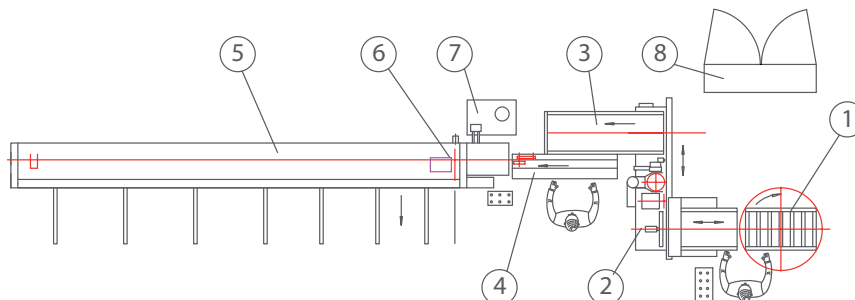


- |   |                                |                    |                 |
|---|--------------------------------|--------------------|-----------------|
| 1 Preparing and feeding device                        | 3 Transfer and turning station | 6 Front side press | 9 Switchcabinet |
| 2 Central packet-cutter-machine with glue application | 4 Chain conveyer               | 7 Cross-cut saw    |                 |
|   | 5 Double feed roller           | 8 Hydraulic unit   |                 |

# Semi-automatic packet finger-jointing line type HPK



Manual rotary table erected in front of the finger-jointing machine  
Automatic milling cutter tablefed with adjustable gear unit  
A fixed milling cutter unit with lifting spindle, chipping device, movable cutter table with glue application system included  
Transfer conveyor with feeding gate into a manual singularising of workpieces and automatic feeding in the front side press in connection with the cut-saw.



- |   |   |                    |                 |
|---|---|--------------------|-----------------|
| 1 Manual rotary table                         | 3 Transfer belt conveyor                | 5 Front side press | 8 Switchcabinet |
| 2 Packet cutter-machine with glue application | 4 Feeding station with transport device | 6 Cross-cut saw    |                 |
|   |   | 7 Hydraulic unit   |                 |

## Automatic feeding for cut-off-saws and finger-jointing lines



An economic operating procedure is given by our automatic feeding systems. Packet destacking introduced by tilting table or vacuum changer Workpieces were directed in layers or individually to the operator or to the operating line. An effective production process is supported by an automatic stick stacker system. Feeding stacker for construction timber can also be obtained.



## Longwood stacking facilities for planed and unplaned workpieces

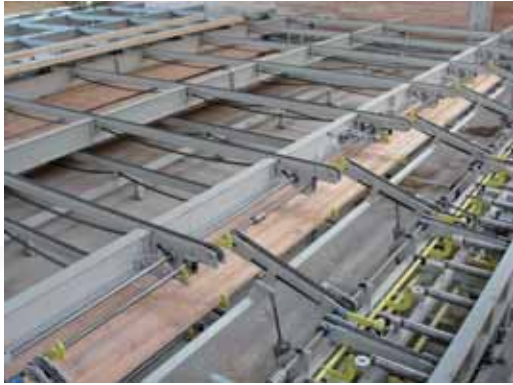


Stacking facilities with their corresponding cross storage systems for curing of gluelam timber are available in SMB normal product range. Those stacking facilities are used for longwood stacking purposes as well. We offer film wrapping machines and strapping plants which can be integrated at any time in the whole system.





We offer you years of experience in planning for production lines for all kind of laminated wood, solid construction timber, duo and trio beams.



## Electronic cut-off-saws, type KK 700/900 and type SKS 550

To act in the scope of comprehensive solution, we offer powerful defect-cut-off saws, in order to obtain the best possible timber output.

Destacker units from our product range carry out the feeding of the cut-off saws.



This machine type stands for years for fully automatic mark recognition system and easy handling. Fitted in the corresponding mechanization this type enables an upgrading to a fully automated line.



The electronic defect-cut-off saw type SKS 550 is used when smaller wood quantities are handled.



## Fractometer and shearing force tester



Consisting of:  
Torsion-resistant welded steel frame with adjustable workpiece support, 18-fold calculated on timber thickness. 2900 mm max. span between supports. One pivotable support plate  
Support positioning by using measurement scale. Applied force adjustable on 1/3 by using measurement scale. Frequency controlled motor drive with worm gear and trapezoidal thread spindle to make speed infinitely variable. Hottinger-Baldwin load cell with electronic amplifier  
Value of bending test and bending rigidity shown in the display

All SMB designed lines can be fitted to additional components. Stick stacker system and waste processing take part in the production process. Longwood stacking and de-stacking devices are available in different types.



Special cross cut saw, running saws or gluelam cross cut saw are designed in different types. Feeding is realized by means of separate facilities





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