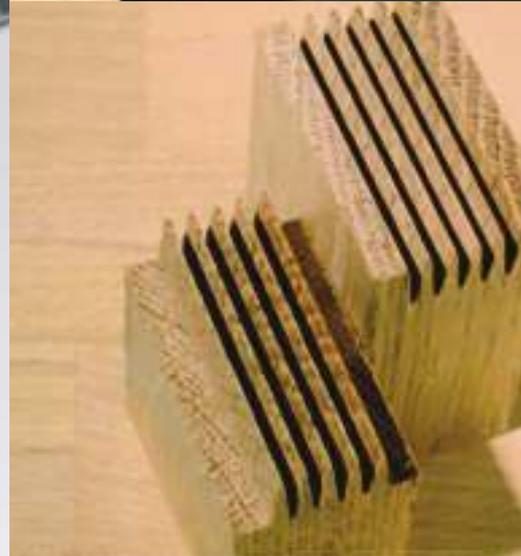
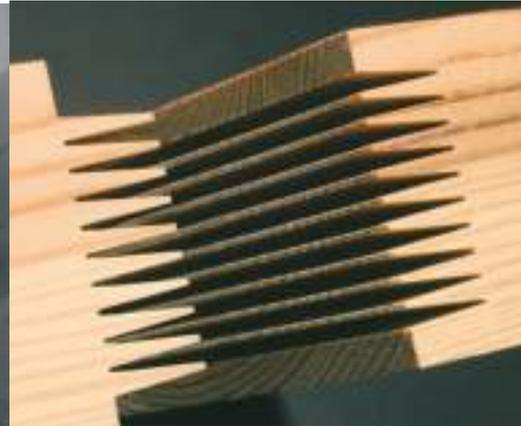
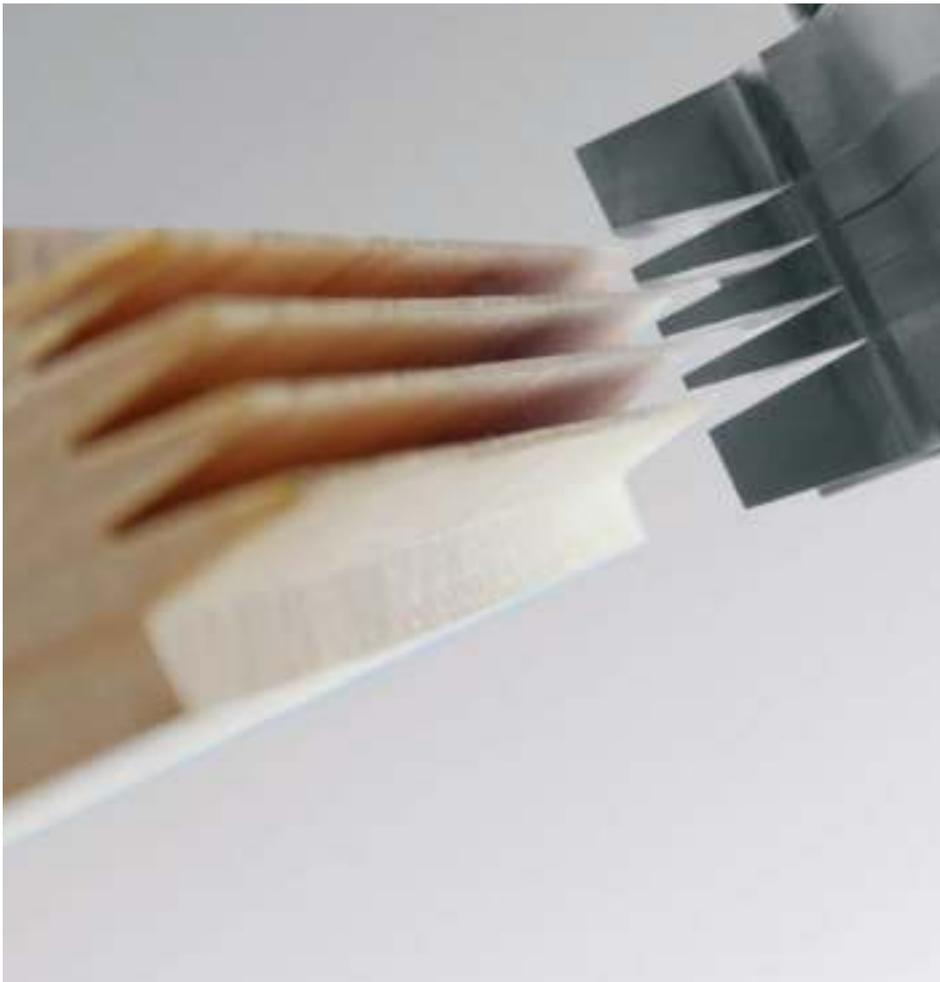


# Horizontal finger jointing lines HS

The innovative solution  
for horizontal finger jointing

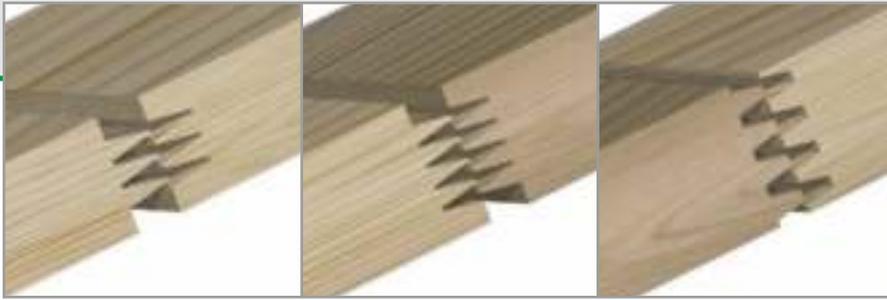


## **WEINIG-GRECON high-capacity horizontal finger jointing lines – technology and speed for economical and efficient production**

WEINIG GRECON is the leading manufacturer of innovative finger jointing lines. The models HS 120 and HS 200 (+) (horizontal single board shapers) are a logically consistent and future-oriented development of this machine type, thus rounding off the top range of the versatile WEINIG GRECON product range of finger jointing lines.

Advantages that will make your business better – selecting the HS is a proven investment with a fast return.





### The HS model

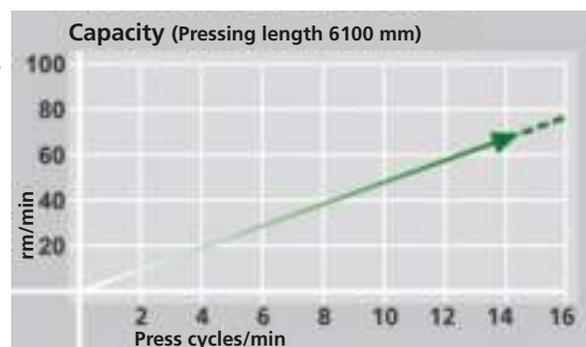
- Up to 240 timber pieces per minute can be processed on the two single board shapers – for both soft and hard wood.
- These finger jointing lines are equipped with state-of-the-art tooling thus ensuring maximum precision and stability of the finger joints.
- Proven high-performance standards were fully integrated in the design of this model.
- Simple, efficient and cost-effective production sequence, ease of operation and short set-up times.
- The modular design of the horizontal finger jointing lines ensures that the customer's technical requirements are met all the way up to a fully automatic feeding of the finger jointing lines by means of a Lugloader and Spinfeeder.
- Optional equipment, such as trimming saws, planer heads (one-sided, two-sided), Trimsaver, timber moisture meter, control of the glue application, cut-to-length saws installed at the outfeed area of the press, stackers, etc., can be supplied.
- High production capacities can be reached (up to 40 km / shift).



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

Perfected technology and innovative overall concepts characterize the single board shapers. No matter what the field of application is – gluelam panels used for furniture and interior decoration, stairs, solid wood floors, parquet, molding blanks, 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.



## Finger joints with automatic control: The easiest operation of complex lines

The machine controls for all finger jointing lines define a new state of the art. The simplicity and clear arrangement of the operating unit make a handling with few efforts possible.

### Your advantages:

- All production statistics as production performance and conditions of the plant are displayed.
- Minimisation of trouble shooting times by most exact monitoring and display of protective motor switches, frequency converters, bus modules, limit switches, etc.
- Process failures and operating errors are indicated with component description and location.
- The operating unit is integrated in the main panel. Failures are identified immediately and changes of the plant are implemented quickly and easily.
- Teleservice and a modem in the line facilitate the update of the latest programs as well as a trouble shooting directly from WEINIG GRECON.



## WEINIG GRECON horizontal finger jointing lines – high capacity potential in combination with the Spinfeeder.



**The HS 200 Spinfeed** is the automatic alternative to any other highspeed feeding unit of a horizontal finger jointing line. The short timber pieces are automatically fed into the finger jointer, no matter whether they are initially coming from an optimizing cut-off saw or from a container.

The unsorted timber pieces are aligned by the centrifugal force in a centrifuge and are then transferred to a feeding channel. Any misaligned timber pieces (length and width ratio) are automatically ejected. The buffer zone ensures continuous feeding. The servo-controlled 3-roller infeed unit installed downstream transports more than 4 pieces per second (independent of the length) to the cross conveying unit. The timber pieces are aligned at the limit stop and transported to the Lugloader installed downstream.



## Tools for any type of application: Optimized tooling for exact finger jointing



### **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 any tear-outs at the tool exit area. The indirect drive of the maintenance-free WEINIG tool spindles ensures high capacity reserves and vibration-free processing of short timber pieces. This is the only way to produce a precise joint quality without any splinters from the finger base to finger point as well as an absolutely tight finger joint.

### **FlankenJet glue application system**

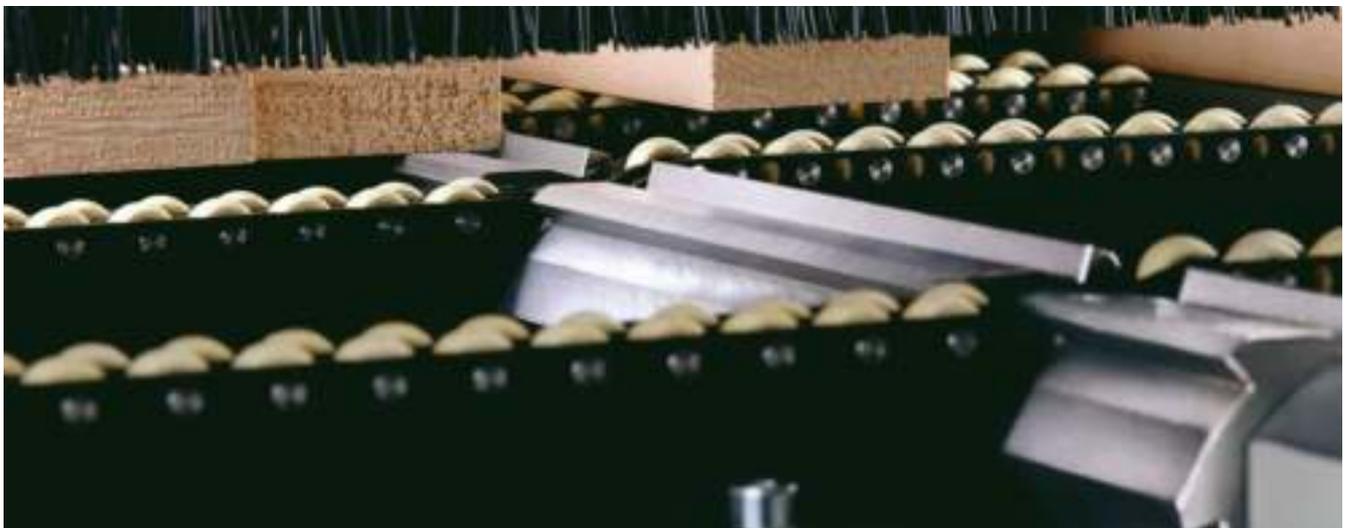
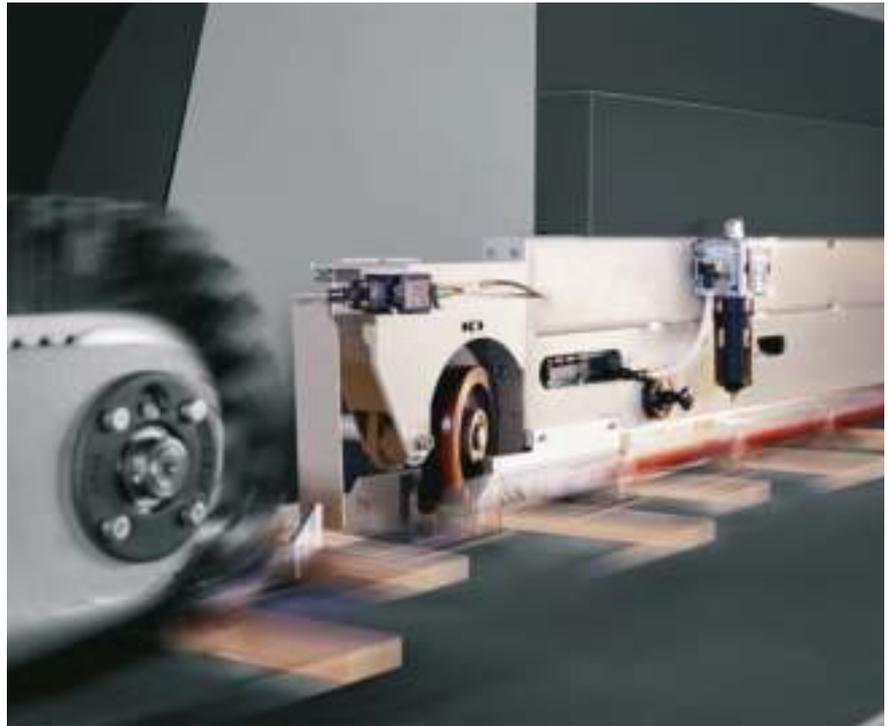
The glue application system developed by WEINIG GRECON provides for an exactly proportioned and specific glue application all the way down to the finger base, even with critical profiles. The glue film is distributed on the entire surface of the joints; dripping is reduced.





## WEINIG GRECON horizontal finger jointing lines – automatic feeding by the Lugloader

Due to the Lugloader, it is possible to achieve a continuous feeding of 240 pieces per minute. It does not matter whether a short timber piece is followed by a long one; the timber pieces are cycled and transported at an optimum (complete length spectrum). The servo control of the Lugloader automatically adjusts to the feed speed of the single board shaper. By entering the board width at the central operating panel, the cycle roller is automatically adjusted.



## WEINIG GRECON horizontal finger jointing lines – an intelligent machine technology

- Motor-driven top pressure, to be opened up to 300 mm, for an easy tool change and access to the cutters.
- Quick change of top pressure units possible.
- Fully enclosed, easily removable extraction hood used as a protection device of the cutting tools.
- Automatic glue detection system. The "GlueEye Vision" is suitable for almost any type of glue incl. automatic removal of timber pieces which have not been properly glued.
- Ejector for faulty timber pieces (fingers too short, incorrect glue application). Faulty timber pieces are removed from the line before the transfer station.
- Fully automatic transfer station incl. patented suction air belt to transfer the pieces to the feed-in track without any slipping (easy access, no mechanically movable parts, thus no malfunction).
- Feed-in track including non-contact, electronic filling control and automatic adjustment of the feed speed of the shaper.
- Lateral chains and pressure rollers ensure the precise alignment of the timber ribbon on one side.
- Automatic tensioning of the chains by means of air cylinders.

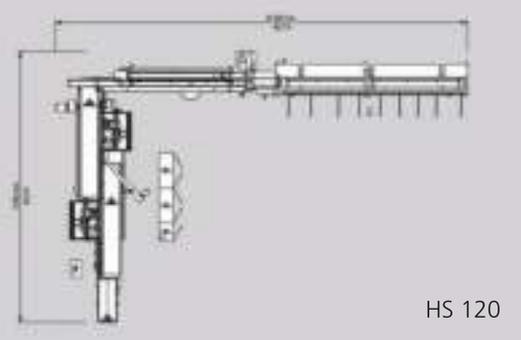


- Automatic lubricating device (oil) used for the chains.
- Frequency-controlled feed motors ensure fast feeding of the press.
- A brake unit required for prepressing and the subsequent length measurement ensure the exact feeding of the press.

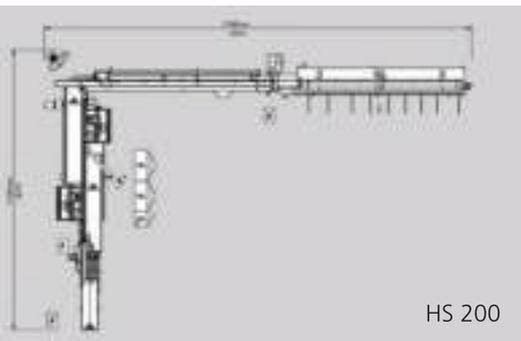
- Two-channel press; feeding and pressing are carried out at the same time; capacities up to 15 cycles per minute or 91 m/min (act. 73 m/min).
- Intermediate cuts are possible by entering the dimensions at the central operating panel.



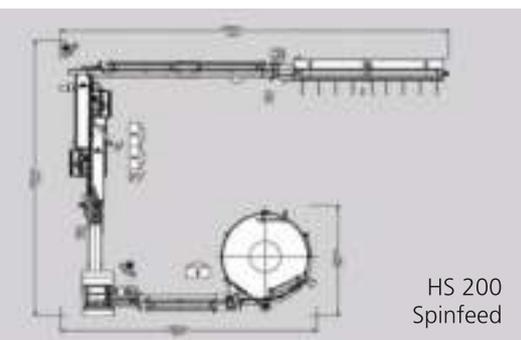
## Synoptic table for horizontal finger jointing lines HS – standards and options



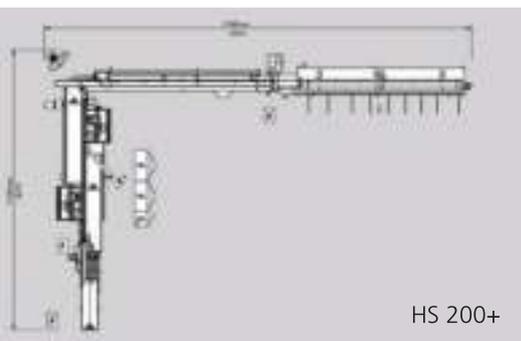
HS 120



HS 200



HS 200  
Spinfeed



HS 200+

The matrix shows the significant features of difference between the single models. Your WEINIG GRECON specialist will be happy to provide you with information about e. g. the HS 120, HS 120 Capacity, HS 200, HS 200+, HS 200 Spinfeed, taking your individual requirements into account.

### Facts

Infeed length

Timber width

Timber thickness

Outfeed length

Thrust force

Timber cross section at a finger length of 10/11 mm (softwood)

Timber cross section at a finger length of 10/11 mm (hardwood)

Vertical jointing

Horizontal jointing

Capacity (horizontal jointing) with 22 x 50 x 350 mm

Increase in capacity

Feeding system

Shaper types

Transfer station

Press

Production statistics

Diagnosis system

Multiple lengths

Intermediate cuts

Scoring units (top and bottom)

Timber width, min. 25 mm

Timber width, max. 203 mm

Timber thickness, max. 70 mm

Final length, max. 7200 / 7500 / 9300 mm

Timber monitoring

Quality inspection

Glue application FlankenJet

Control of glue application (GlueEye Vision)

Communication (Teleservice)

Servo-controlled feed

Drive of cutter spindle

Drive of hogger (+ scoring units)

Cutter spindle, diameter 50 mm

Cutter spindle, diameter 1 13/16"

Cutter diameter

Cutter diameter



## 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



Customers 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 on 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

# Horizontal finger jointing lines HS

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## **Product Unit Jointing Technology**

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