EDGE BANDING MACHINES

Automatic Edge Banding Machine

Casadei Industria Kronos 60.0

Automatic edge banding machine with upper hybrid EVA/PUR glue pot, chain feed, pre-milling and multifunctional TRIA unit for end trimming, flush trimming and corner rounding, for panels 8–60 mm thick and edges 0.4–3 mm thick.

MODEL KRONOS 60.0

12 m/min	8–60 mm	0.4–3 mm	7.44 kW
FEED SPEED	PANEL THICKNESS	EDGE THICKNESS	INSTALLED POWER



/ Application & Use

The Casadei Industria Kronos 60.0 is an automatic edge banding machine for straight panels of particleboard, MDF, plywood and solid wood, 8–60 mm thick, for kitchen, bedroom and office furniture, in small and medium batch production in furniture factories and workshops. It applies coil or strip edges of ABS, PVC, melamine and veneer, 0.4–3 mm thick, at a feed speed of 12 m/min. The panels are fed on a double steel chain with rubber pads, and an automatic cadencer sets the spacing between panels at the infeed.

The infeed guide runs on linear guides and has micrometric adjustment of 0–3 mm for the pre-milling removal. Pre-milling uses two independently moving 1.1 kW high-frequency motors with diamond cutters Ø 80 x 65 mm at 12000 rpm, with its own extraction and a blower that cleans the panel before gluing. The upper hybrid glue pot, Teflon-coated and holding about 1.4 kg, works with EVA or PUR and has 6 heating elements (5 in the pot, 1 in the roller) totalling 1.63 kW; temperatures are set automatically and the roller is cleaned automatically. Changing the glue takes about 15 minutes, and with PUR the machine can stand for up to 4 days without cleaning; PUR joints are water- and heat-resistant.

The edge is fed in sync with the panel and cut from the coil by a pneumatic shear with horizontal oscillating movement. Two floating pressure rollers, the first in aluminium (Ø 80 mm) and the second rubber-coated, press the edge onto the panel, and the steel top pressure beam with two rows of rubber rollers on bearings is positioned electronically. The multifunctional TRIA unit, with two high-frequency motors and diamond cutters, combines end trimming, flush trimming and corner rounding and changes from one edge thickness to another without manual intervention; the tools have a radius of R = 2 mm.

/ Key Features

- Panels 8–60 mm; edges 0.4–3 mm from coil or strips
- Feed speed 12 m/min on a double steel chain with rubber pads
- Pre-milling 2 x 1.1 kW, diamond cutters Ø 80 x 65 mm
- Upper hybrid EVA/PUR glue pot, approx. 1.4 kg, 1.63 kW
- TRIA unit: end trimming, flush trimming, corner rounding
- Edge coil up to Ø 800 mm
- Installed power 7.44 kW, 400 V / 50 Hz / 3 phases + N

/ Standard Equipment

- 10-inch touch panel, PLC with encoder, diagnostics and statistics
- Automatic panel cadencing at the infeed
- Steel pressure beam with two rows of rubber rollers, electronic positioning
- Infeed guide on linear guides, micrometric adjustment 0–3 mm
- Synchronised edge feed; pneumatic coil shear with oscillating movement
- Two floating pressure rollers: aluminium (Ø 80 mm) and rubber-coated
- Automatic roller cleaning, quick drainage, glue change in approx. 15 min
- Extensible front support for large panels
- Tools with radius R = 2 mm; CE conformity

/ Machine Details



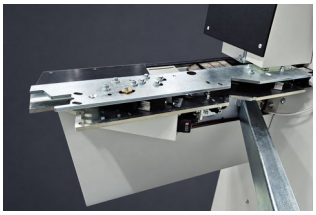
MULTIFUNCTIONAL TRIA UNIT



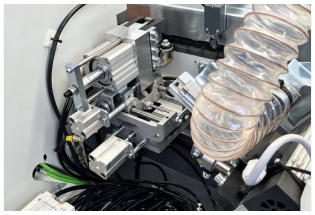
PRE-MILLING WITH DIAMOND CUTTERS AND TWO HIGH-FREQUENCY MOTORS



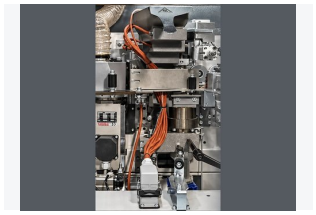
INFEED GUIDE WITH ROLLER CONVEYOR AND MICROMETRIC ADJUSTMENT



ADJUSTMENT OF THE PRE-MILLING REMOVAL, 0–3 MM



PNEUMATIC ACTUATORS ON LINEAR GUIDES



GLUING UNIT WITH HYBRID EVA/PUR GLUE POT



FINISHING UNIT WITH HIGH-FREQUENCY MOTOR, UNDER THE GUARD

/ Options on Request

- Special voltages: 230 V / 50 Hz / 3 phases, 230 V / 60 Hz / 3 phases, UL-CSA version, transformer for networks without neutral, 600 V transformer
- Remote diagnostics and monitoring via Ethernet
- Anti-adhesive spraying unit (required for PUR gluing)
- Infrared lamp for panel preheating
- Glue roller rotation reversal
- Additional interchangeable glue pots: lower EVA, upper EVA/PUR, upper EVA/PUR with reversed roller
- Antistatic and cooling device
- Sliding device for panels and edges with protective film
- Front / rear end trimming with shear (panels max. 45 mm)
- Top rough milling unit, 0.37 kW, 12000 rpm
- TRIA Nesting for nesting panels with hinge holes
- Edge scraper: manual, pneumatic or with two motorised radii
- Glue scraper: manual or pneumatic
- Cleaning agent spraying unit
- Buffing unit with 2 motors x 0.13 kW
- Numerical indicator for the infeed guide
- Internal LED lighting
- Additional roller conveyor: 2594 / 3080 / 3245 mm
- Motorised axes for TRIA, infeed guide and pressure rollers
- Extraction system kit
- Insert sets R = 1 or R = 3 mm
- Packing: case, case with VCI bags, seaworthy packing, wooden base with VCI bags

/ Technical Data

Model	Kronos 60.0
Panel thickness	8–60 mm
Edgebanding thickness	0.4–3 mm (coil or strips)
Minimum panel dimensions	length (edged side) min. 140 mm; width min. 70 mm
Compatible edgebanding materials	ABS, PVC, melamine, veneer
Feed speed	12 m/min
Pre-milling	2 x 1.1 kW HF motors with independent movement; diamond cutters Ø 80 x 65 mm, 12000 rpm; removal max. 3 mm, max. 130 mm² (depending on material); micrometric adjustment 0–3 mm
Gluing system	upper hybrid EVA/PUR glue pot, Teflon-coated, approx. 1.4 kg; 6 heating elements (5 in the pot, 1 in the roller), 1.63 kW; heat-up 14–16 min (4–6 min from stand-by); automatic roller cleaning, quick drainage, glue change approx. 15 min; lower EVA glue pot approx. 1 kg: optional
Edgebanding feed	coil diameter max. 800 mm; synchronised with the panel; pneumatic coil shear with horizontal oscillating movement
Edgebanding pressure zone	2 floating pressure rollers: first aluminium (Ø 80 mm), second rubber-coated
End trimming	in TRIA unit (2 HF motors, diamond cutters); front / rear end trimming with shear (panels max. 45 mm): optional
Longitudinal trimming (rough / fine)	flush trimming in TRIA unit, diamond cutters; top rough milling unit 0.37 kW, 12000 rpm: optional
Corner rounding	in TRIA unit; 2 edge thicknesses without manual intervention; tools R = 2 mm (R = 1 / R = 3 mm insert sets: optional)
Scraping (profile / glue)	optional: edge scraper (manual, pneumatic or with two motorised radii); glue scraper (manual or pneumatic)
Spraying units	optional: anti-adhesive agent (required for PUR gluing); cleaning agent
Buffing	optional: 2 motors x 0.13 kW
Top pressure system	steel beam with two rows of rubber rollers on bearings, electronic positioning
Control system	10-inch touch panel; PLC with encoder; automatic temperature control with stand-by, diagnostics, statistics
Total installed power	7.44 kW
Electrical supply	400 V / 50 Hz / 3 phases + N; rated / max. current 10.74 / 16.32 A; recommended fuse 20 A
Compressed air requirements	320 Nl/min at 7–8 bar (peak 1150 Nl/min)
Dust extraction: connections and requirements	connections Ø 60 mm; pre-milling: min. 550 m³/h, 20 m/s
Overall dimensions (L × W × H)	3614 x 1155 x 1538 mm; width 1999 mm with extended front support
Machine weight	942 kg (net)

Data refer to the standard Kronos 60.0 configuration. The supplied configuration and included options are defined in the quotation. Technical data may be updated without prior notice. Images are illustrative.

SUPPLIER

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