HELEX

PRECISION BY DESIGN

EDGE BANDING MACHINES

Automatic Edge Banding Machine

Straight and L-type edges · T-type and hidden doors · Wall panels

Edge bander with 15 functions for straight and L-type edges on panels 10 to 60 mm thick, with pre-milling, servo tape feed, adaptive trimming and scraping.

MODEL HE 60 EL

10–60 mm	0.6–0.8 mm	6–13 m/min	15
PANEL THICKNESS	EDGE THICKNESS	FEED SPEED	FUNCTIONS



/ Application & Use

The HELEX HE 60 EL is an automatic edge banding machine for straight edges and for the L-type edges used on T-type doors, double-leaf doors with unequal leaves, hidden doors and on wall panels. It processes panels 10 to 60 mm thick, from a minimum size of 450 x 120 mm, with PVC, ABS, melamine or veneer edge 0.6 to 0.8 mm thick, at a feed speed of 6 to 13 m/min.

In one pass the panel goes through 15 functions: pre-milling with two counter-rotating 5.5 kW motors, release agent spraying, EVA gluing from a heated glue pot, servo-controlled edge feed synchronised with the panel, four servo-controlled pressure wheels and three floating forming presses, fine trimming, end cutting, scraping, cleaning agent spraying and buffing. Trimming and scraping adapt to straight and L-type edges, and the pressing, trimming and scraping modules have mechanical anti-impact protection.

The working groups have frequency-inverter or servo drives, and the top pressure beam has motorised height adjustment from the touch screen when the panel thickness changes. On request, the glue pot can be converted for pre-glued edge. The machine has no corner rounding unit. Total installed power is 26.4 kW at 380 V / 50 Hz, the compressed air requirement 0.6 MPa, and the overall dimensions 6500 x 900 x 1600 mm.

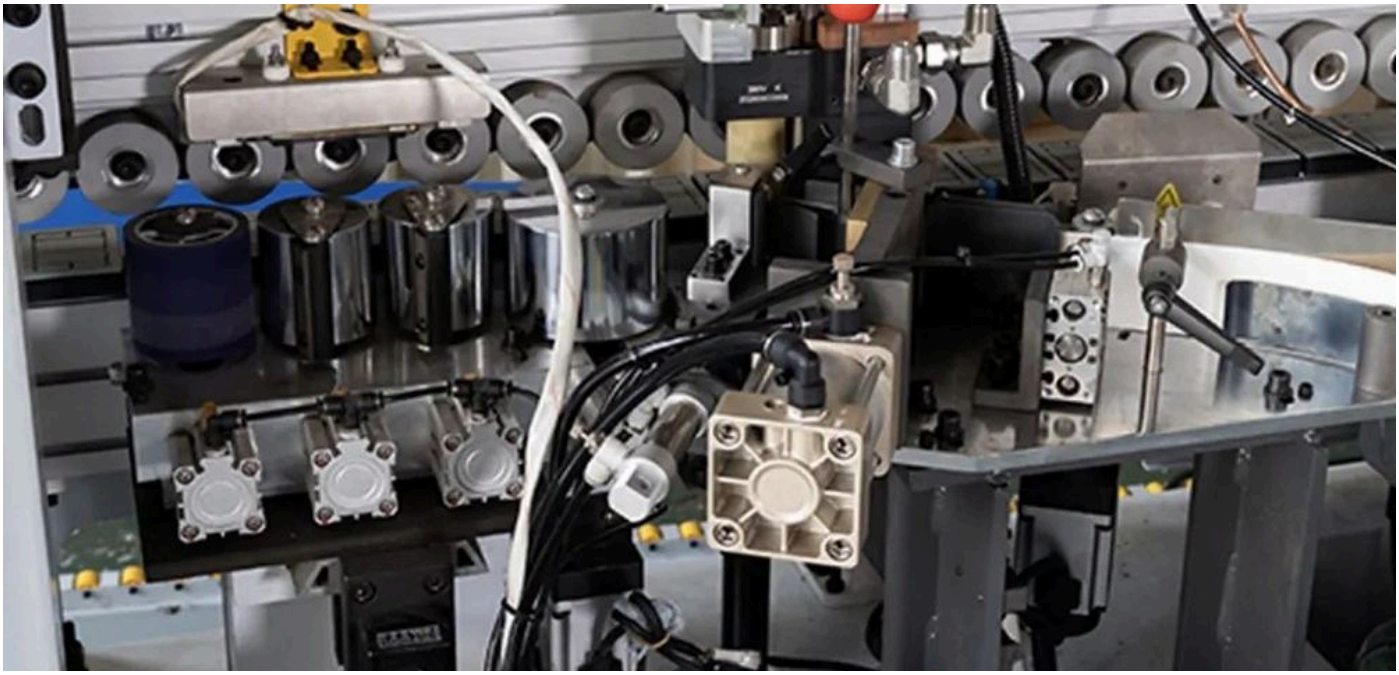
/ Applications & Edge Materials

APPLICATIONS

- Straight edges on furniture panels
- L-type edges on T-type doors
- Double-leaf doors with unequal leaves
- Hidden doors
- Wall panels

EDGE MATERIALS

- PVC and ABS edge
- Melamine edge
- Veneer edge
- Edge thickness 0.6–0.8 mm
- Panels 10–60 mm thick, min. 450 x 120 mm

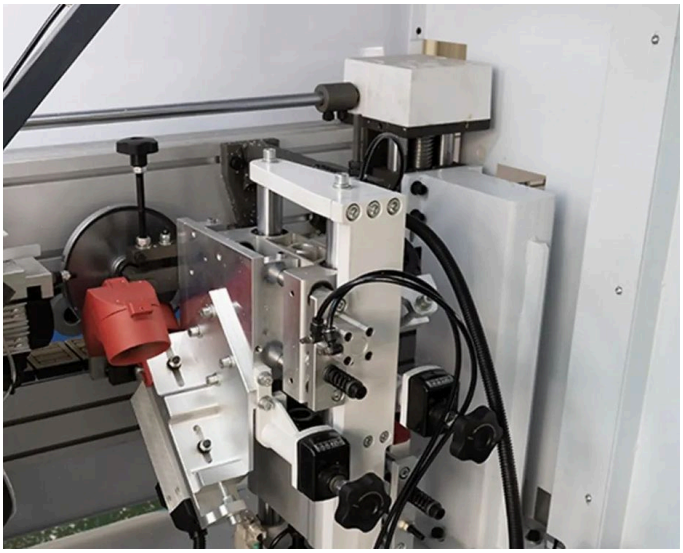


Four-wheel servo pressing and forming presses of the HELEX HE 60 EL edge bander

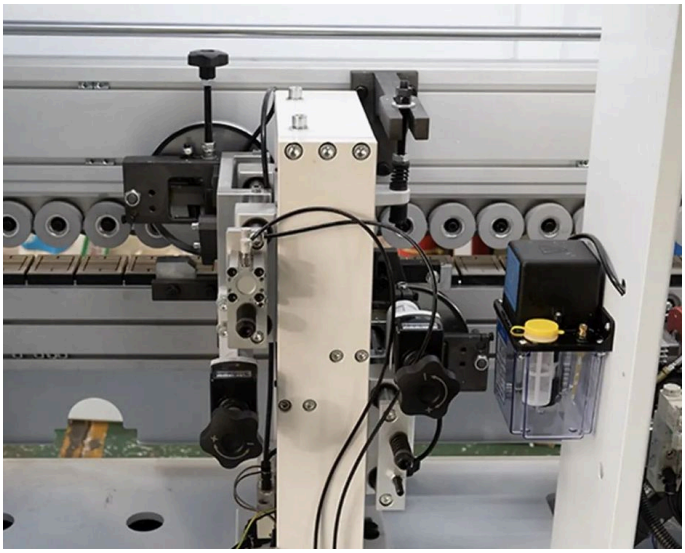
/ Structure and Configuration

15 functions in one pass. The working groups, in the order in which the panel meets them:

1. **Pre-milling**
   Two 5.5 kW motors rotating in opposite directions.
2. **Release agent spraying**
   Before gluing.
3. **Gluing**
   EVA adhesive from a heated glue pot; on request convertible for pre-glued edge.
4. **Edge feed**
   Servo-controlled, synchronised with the panel feed.
5. **Pressing**
   Four servo-controlled pressure wheels and three floating forming presses.
6. **Fine trimming**
   0.75 kW, adaptive for straight and L-type edges.
7. **End trimming**
   2 x 0.75 kW.
8. **Scraping**
   Profile scraping, adaptive for straight and L-type edges.
9. **Cleaning agent spraying**
   Before buffing.
10. **Buffing**
    2 x 0.37 kW.
11. **Top pressure beam**
    60 rubber wheels; motorised height adjustment, 0.37 kW, from the touch screen.
12. **Control and protection**
    Programmable controller with colour touch screen; frequency-inverter or servo drives; mechanical anti-impact protection on the pressing, trimming and scraping modules.



Fine trimming unit with adaptive stopper and extraction hood



Scraping unit of the HELEX HE 60 EL with central lubrication reservoir

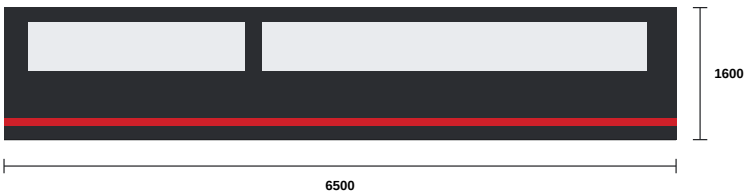
/ Technical Data

Specification	HE 60 EL
Model	**HE 60 EL**
Panel thickness	**10–60 mm**
Edgebanding thickness	**0.6–0.8 mm**
Minimum panel dimensions	**450 x 120 mm**
Workpiece edge profile	**straight and L-type**
Compatible edgebanding materials	**PVC, ABS, melamine, veneer**
Feed speed	**6–13 m/min**
Declared number of stations	**15**
Pre-milling	**2 x 5.5 kW, counter-rotating**
Gluing system	**EVA hot melt, heated glue pot; on request convertible for pre-glued edge**
Edgebanding feed	**servo-controlled, synchronised with the panel feed**
Edgebanding pressure zone	**4 servo-controlled pressure wheels + 3 forming presses**
End trimming	**2 x 0.75 kW**
Longitudinal trimming (rough / fine)	**fine: 0.75 kW, adaptive (straight and L-type)**
Corner rounding	**none**
Scraping (profile / glue)	**profile: adaptive (straight and L-type)**
Spraying units	**release agent before gluing, cleaning agent before buffing**
Buffing	**2 x 0.37 kW**
Top pressure system	**pressure beam with 60 rubber wheels; motorised height adjustment 0.37 kW from the touch screen**
Control system	**programmable controller with colour touch screen**
Total installed power	**26.4 kW**
Electrical supply	**380 V / 50 Hz**
Compressed air requirements	**0.6 MPa (6 bar)**
Dust extraction: connections and requirements	**4 x Ø 100 mm; air velocity 32 m/s**
Overall dimensions (L × W × H)	**6500 x 900 x 1600 mm**

Data according to the technical documentation of the machine. The supplied configuration and the installation requirements are specified in the quotation. Technical changes reserved.

/ Overall Dimensions

FRONT VIEW



PLAN VIEW



Dimensions in mm. Schematic drawing, not to scale.

SUPPLIER

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