HELEX

PRECISION BY DESIGN

EDGE BANDING MACHINES

Automatic Edge Banding Machine

Straight edges · Panel furniture production · Up to 23 m/min

Edge bander for panel thickness 10–60 mm and edge thickness 0.4–3 mm, with pre-milling, rough and fine trimming, corner rounding, scraping and buffing, up to 23 m/min.

MODEL HE 65 M

10–60 mm	0.4–3 mm	23 m/min	15
PANEL THICKNESS	EDGE THICKNESS	MAX. FEED SPEED	FUNCTIONS



/ Application & Use

The HELEX HE 65 M is an automatic edge banding machine for straight panel edges in furniture production. It processes panels 10 to 60 mm thick and at least 60 mm wide, with PVC, ABS, PMMA, melamine or veneer edgebanding material 0.4 to 3 mm thick and 12 to 65 mm wide, supplied in rolls or pre-cut strips. The feed speed reaches up to 23 m/min and is selected electrically in three preset steps.

Ten working groups cover fifteen functions in one pass: edge magazine with automatic feed, release agent spray, pre-milling with two counter-rotating motors, panel pre-heating lamp, EVA gluing from a temperature-controlled glue pot, multi-roller pressing with one driven and several pneumatically loaded rollers, front and rear end trimming with two saw units on a tracking carriage, rough and fine trimming for flat or radius profiles, a corner rounding unit, profile scraping and removal of excess adhesive using flat scrapers, cleaning agent spray and two buffing wheels. Each group is switched on or off from the touch screen.

The upper pressure beam has height adjustment with a digital position display, and six pneumatic regulators with gauges set the working pressure of the pre-milling, gluing, end trimming, fine trimming, corner rounding and tracking units. The machine has five dust extraction connections, Ø 100 mm; a 5.5 kW double-bag dust collector is included in the delivery. Total installed power is 20 kW at 380 V, the minimum compressed air pressure 7 bar (0.7 MPa) with dry, filtered air, the overall dimensions 7300 x 1050 x 1750 mm and the net weight 2800 kg.

/ Panels & Edge Materials

PANELS

- Panel thickness 10–60 mm
- Panel width from 60 mm
- Straight edges

EDGE MATERIALS

- PVC, ABS and PMMA
- Melamine and veneer
- Edge thickness 0.4–3 mm
- Edge width 12–65 mm
- In rolls or pre-cut strips

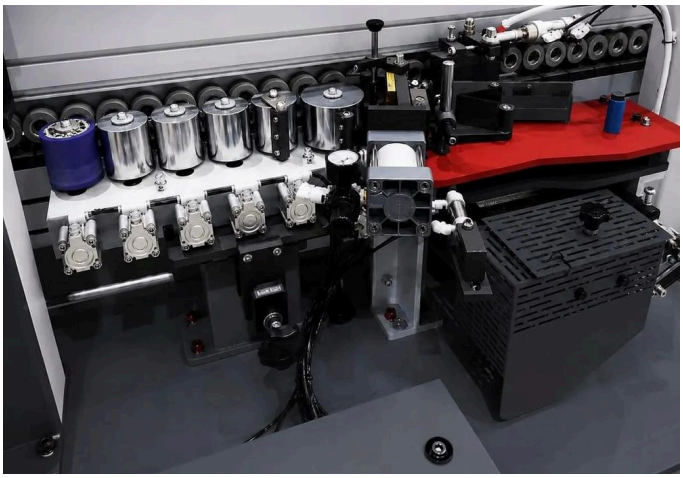


HELEX HE 65 M edge banding machine with the hoods open over the working groups

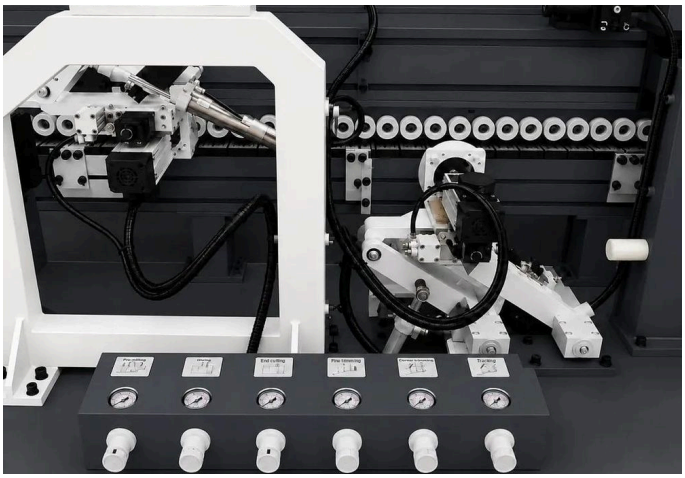
/ Structure and Configuration

Ten working groups cover fifteen functions in one pass:

1. **Edge magazine**
   Automatic edge feed.
2. **Release agent spraying**
   Before gluing.
3. **Pre-milling**
   Two counter-rotating motors.
4. **Pre-heating lamp**
   Panel pre-heating.
5. **Gluing**
   EVA adhesive, temperature-controlled glue pot.
6. **Pressing**
   One driven roller and several pneumatically loaded rollers.
7. **End trimming**
   Two saw units on a tracking carriage, front and rear.
8. **Rough and fine trimming**
   Flat or radius profile.
9. **Corner rounding**
   Corner rounding unit.
10. **Scraping**
    Profile scraping; flat scrapers for excess adhesive.
11. **Cleaning agent and buffing**
    Cleaning agent spraying and two buffing wheels.
12. **Top pressure beam and control**
    Height adjustment with digital position display; touch screen, each group switched individually, piece and linear metre counters; 6 pneumatic regulators with gauges.



Glue pot for EVA adhesive and multi-roller pressing section with pneumatic loading



Corner rounding unit and bank of six pneumatic regulators

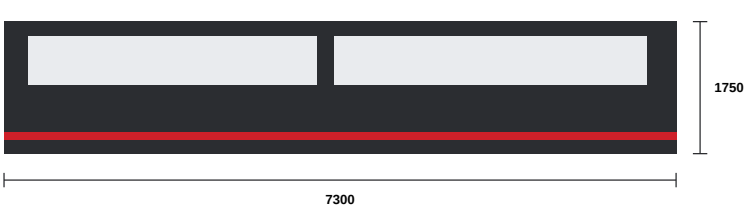
/ Technical Data

Specification	HE 65 M
Model	**HE 65 M**
Panel thickness	**10–60 mm**
Edgebanding thickness	**0.4–3 mm**
Minimum panel dimensions	**width from 60 mm**
Workpiece edge profile	**straight**
Compatible edgebanding materials	**PVC, ABS, PMMA, melamine, veneer; edgebanding width: 12–65 mm (min.–max.); rolls or pre-cut strips**
Feed speed	**up to 23 m/min, three preset steps**
Declared number of stations	**10 working groups (15 functions)**
Pre-milling	**2 counter-rotating motors**
Gluing system	**EVA hot melt, temperature-controlled glue pot; panel pre-heating lamp**
Edgebanding feed	**automatic, from edge magazine**
Edgebanding pressure zone	**1 driven roller + pneumatically loaded rollers**
End trimming	**2 saw units on tracking carriage**
Longitudinal trimming (rough / fine)	**rough: yes; fine: flat or radius profile**
Corner rounding	**corner rounding unit**
Scraping (profile / glue)	**profile scraping; flat scrapers for excess adhesive**
Spraying units	**release agent before gluing, cleaning agent before buffing**
Buffing	**2 buffing wheels**
Top pressure system	**upper pressure beam height adjustment with digital position display**
Control system	**touch screen, units switched individually, piece counter and linear metre counter; 6 pneumatic regulators with gauges**
Total installed power	**20 kW**
Electrical supply	**380 V**
Compressed air requirements	**min. 7 bar (0.7 MPa), dry and filtered**
Dust extraction: connections and requirements	**5 connections, Ø 100 mm; 5.5 kW double-bag dust collector included in delivery**
Overall dimensions (L × W × H)	**7300 x 1050 x 1750 mm**
Machine weight	**2800 kg**

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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