

MARCH 2023 furniture

JOURNAL

ON THE COVER:

ABI's Jezz Dent talks about his IMA-Schelling saws and edgebanders and the service that keeps him coming back for more

The latest from Saviola and Kronospan go on show

Hranipex: now offering kitchen storage systems

Biesse's AR70 single-motor corner-rounding unit débuts

Browns 2000 opts for Mawera again after 23 years of tireless service

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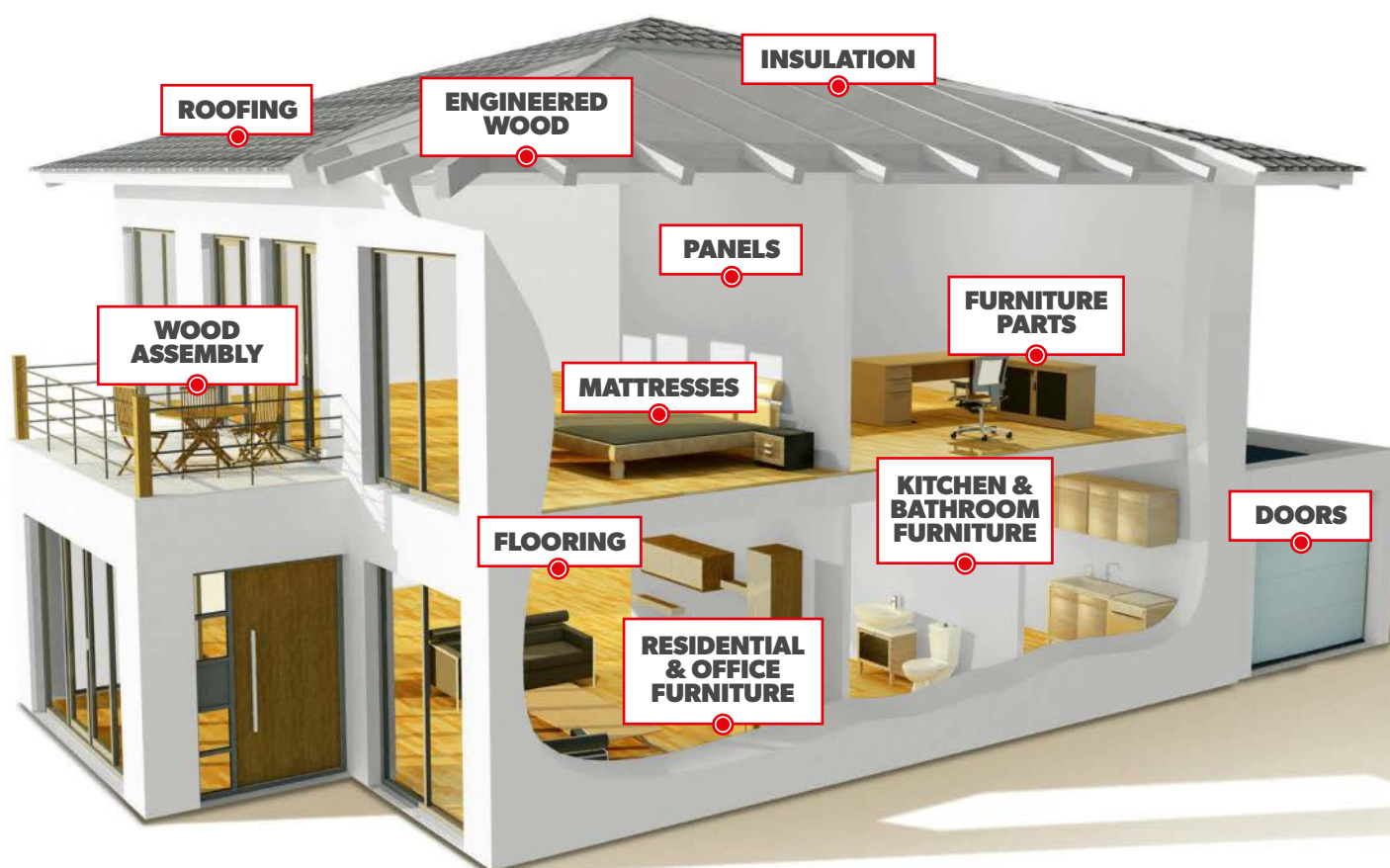
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Story: pages 46-51

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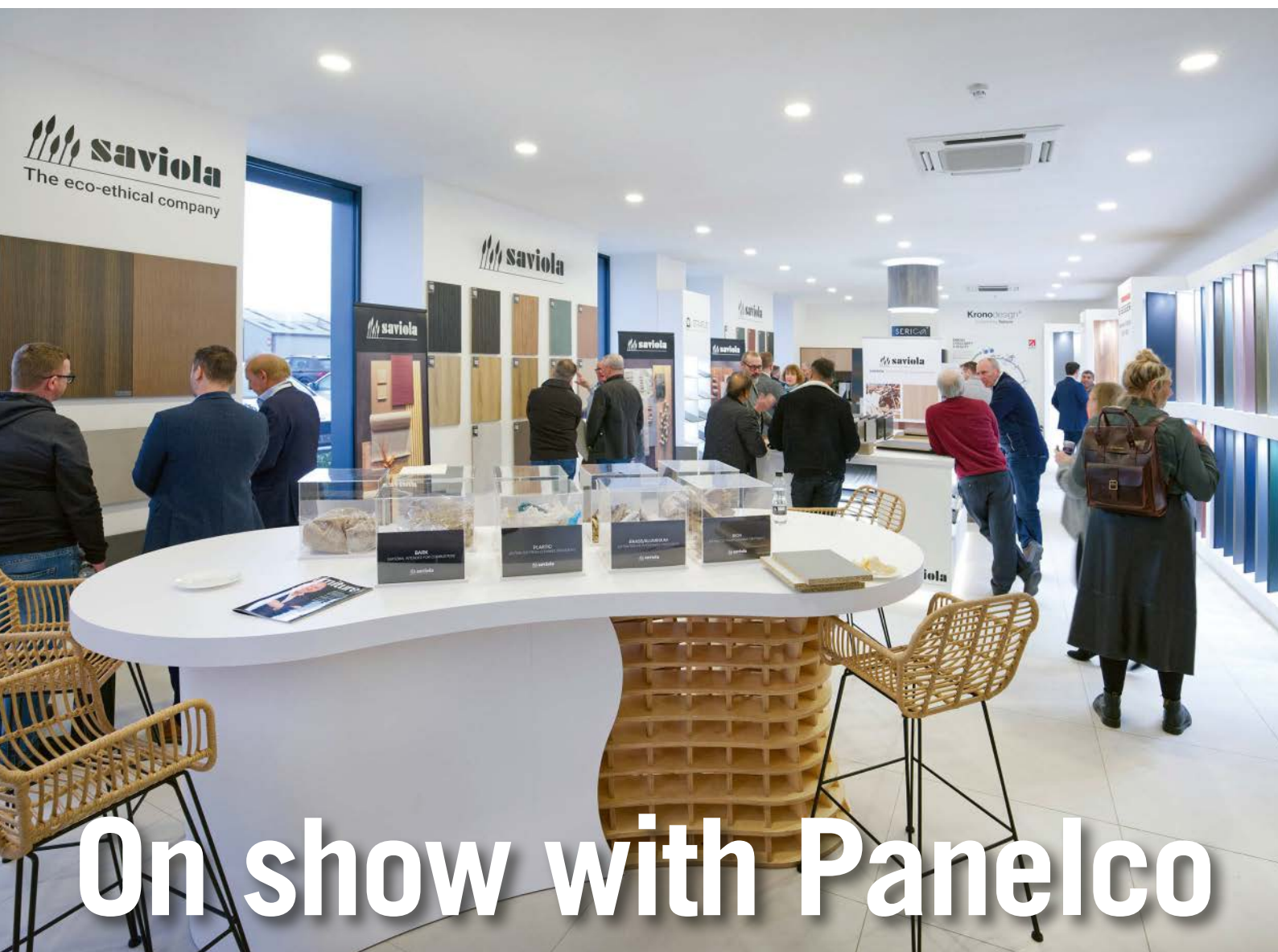
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On show with Panelco

Julie Dean talks about the company's Innovation Insight days as Panelco showcases the latest décors from Saviola and Kronospan.

New launches from Saviola and Kronospan prompted Panelco to stage a special event in January and invite customers to see the latest designs from these two very different décor and board producers.

"What we try to do when any of our suppliers are launching new ranges or new finishes is stage a special event in our showroom and invite our customers to visit over the course of two days," explained Julie Dean, Group Marketing Manager for the Hadleigh Group. "Our Innovation Insight event is an opportunity for customers to share their experience with us and tell us which of the new products they like so we can potentially incorporate the décors into our stock collection. This time we're launching Saviola's latest designs and Kronospan's new Global Collection.

"Kronospan went live with its Kronodesign Global Collection 3.0 on 1st January, so our Innovation Insight days are a perfect way to continue that process. The Kronospan range update is a real overhaul with a lot of talk in the industry about the new range. Kronospan supports our event and the whole team presented and helped across both days, so for us the event has been a tremendous success.

"Kronospan is a full launch of 43 colours, which are all new 18mm MFC décors to Panelco. We have added the full collection and everything is ex-stock now. Everything you can see on the Kronospan display wall is what we are adding.

"Saviola is a company we've only been working with for a few years. We have an ex-stock range of 29 colours. Currently everything you see on display at this event



Julie Dean



is brand new product. With Saviola, you really need to tell the story behind the designs and make sure people understand it's a 100% recycled product. It's a very exciting collection.

The event is a bit of an experiment to find out which Saviola designs our customers feel they could benefit from. It would be good if we could offer everything Saviola produces but the range is huge and Panelco's ethos is if it's in stock you can get it on next day delivery, so we need to be sure we are offering the most relevant products to our customers. We will review the collection after the show, add more colours and mix the range up a bit as soon as we have the feedback. So far, all feedback is positive, I think because it is so different. We're really pleased with how it's been received."

The format of Panelco's Innovation Insight days in January 2023, which took

place in a specially-designed showroom and attached discussion forum next to the Panelco factory and warehouse near Stoke on Trent, was based on the company's KBB stand from four years ago but it's only one of several events staged by Panelco and its sister companies in the Hadleigh Group. Oxfordshire-based Timbmet also had a Design Forum and staged its event directly after Panelco's.

"What they are doing is showing some of the other products we offer – Egger, Greenlam and Losan – as well as Kronospan and Saviola. Timbmet is presenting a few more suppliers because they didn't have an event in October, so we're pushing it across both sites over four days. Where we are situated, it means customers can go to the Timbmet event if they aren't able to get to the Panelco one.

"We have a great space to present products and we use it well. We have

large samples in the showroom where you can see and feel the designs. Alongside, we have a more intimate space for matching, exploring, trying things out. We have a full library with all the decorative samples we stock – around 500 edged pieces. The room is always in use with customers. Having everything in one area speeds up the design process for them because we don't need to send swatches, then samples. They can see everything here and they can meet the team, see the warehouse and the factory. We are lucky to have such a good space.

"We haven't got design showrooms in all our branches but it is something we are looking to roll out across the group. We're already in talks with the designer of our Panelco showroom to do just that."

If you'd like to use the Panelco showroom, call 01782 392100 or visit Panelco's website at [panelco.com](https://www.panelco.com)

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Kronodesign at the

Lawcris has pushed new boundaries with an immersive product event to launch the new Kronodesign Global Collection, held in their resourceful DesignHUB.



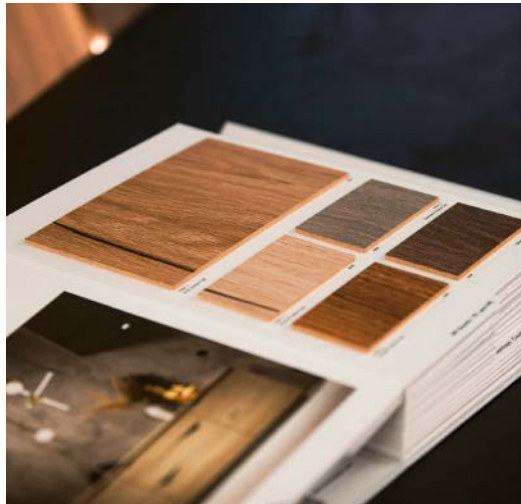
Originally launched in Malta last November, Lawcris decided to bring the Kronospan experience back to sunny Leeds. Customers were invited to smaller, more personal sessions over two weeks, where they could see all the large-size samples of the 40 new décors (including four authentic new textures) whilst absorbing key information about the 2023 trends. There was a chance to explore and play with the exciting new developments in the Kronospan App and most importantly, they were able to take their experience with them, including digital imagery and three different swatches.

Lauren Barker, Marketing Manager, explains, "Kronospan is constantly engineering new surface possibilities for the next era of high-performance projects and the size of the session really meant we could give a more personal experience and understand what our customers objectives were."

"We started at the very beginning with trend identification. Material sourcing can take Kronospan's research and development team to some very unusual places. But once they have found what they are looking for, be it timber, stone, commercial artwork and other objects of interest, the creative process begins. Customers were fascinated as they were shown a brief insight into the procedures the team goes through before these products are even brought to market."

"We then jumped straight into the trends of 2023, which introduced this year's bright, statement-making individualism. The way interior designers decorate has definitely shifted. Yes, there are some new key colours, textures and materials but most importantly, there are new moods, which are the source of inspiration for the new Kronodesign Global Collection."

"Inspired by the natural world and underlining the importance of having a visual



Lawcris DesignHUB

and sensual bond with colours, textures, and forms, Kronospan has introduced four stories revealing a new personality type with distinctive taste and experience:

The Nomad, The Optimist, The Passionate and The Adaptable. We explored how these personalities and décor combinations resonated with the environment and how those people lived, thought and felt.

"A general debate followed about which customer fell into which storyline. It was great to have such a fantastic source of enthusiasm in the room. There was such a buzz as we were talking about these personalities and scattering all the new décors on the table. Customers were taking pictures, making notes of key designs they thought would work for them and this led on nicely to the new Kronodesign App development. It was great to show off such an innovative design tool that can really aid customers who don't have access to this

sort of technology. The ability to upload photos and design on top of them in a perspective way really blew our customers away and they could see how beneficial this could be.

"The most important thing was that they got to take their experience away with them in a gift set, with immediate access to all the digital imagery and full board scans to start designing with. They also received Kronospan's impressive marketing tools, including a fan swatch set, a wall chart and the sought after swatch brochure."

Over 100 customers attended the two-week **launch event** held in the DesignHUB. This design facility now hosts all the brand-new décors and can be booked by anyone who wants to use the space to create or bring their own clients down to choose décors for themselves.

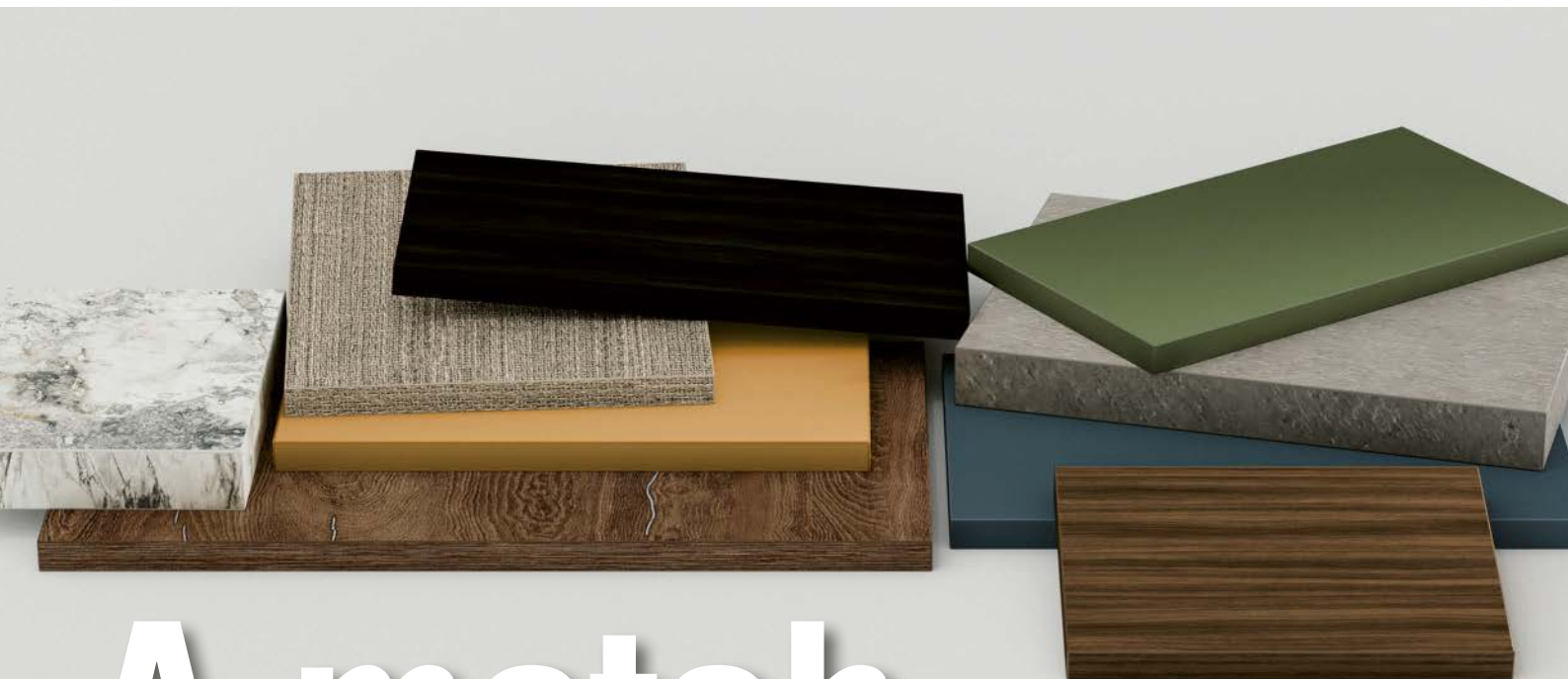
"We broke new ground with how we presented this range," concludes Lauren.

"It is exactly what the collection deserved. We wanted to make sure everyone could explore the products in their own time with a real understanding of why the décors have been introduced. There was plenty of time to ask questions and talk more about the Kronospan brand, which has come a long way since the installation of a new cleaning line for producing a high-quality chipboard core. It was very informal, with food and drink to enjoy whilst our discussions took place.

"We know time is valuable and we always want to go that extra mile to make sure customers get what they need out of these events. The feedback we have received makes us believe we delivered on this."

The 40 brand new décors with matching 0.8mm and 2mm edging are in stock and ready for next day delivery.

To book the **DesignHUB**, contact marketing@lawcris.co.uk



A match for Kronospan

Ostermann has ABS edgings in stock to match the New Kronospan Global Collection 3.0

Timed to coincide with the launch of the Kronospan Global Collection 3.0, Ostermann prepared a collection of matching edgings in close cooperation with Kronospan – and all are in stock for immediate delivery.

The new Kronospan collection comprises 154 melamine-coated particle boards, 68 worktops and 24 design-oriented avant-garde surfaces that include wood, stone and textile décors with a matt look and plain décors in soft trend colours. Ostermann has developed a perfectly-matched edging collection with 200 colours and décors, which is now available directly from the UK warehouse. All items can be ordered in any width up to 100 mm.

A key focus point in the development of matches to the Kronospan Global Collection was to replicate elements in each décor and optimise them for use on edging. Among the new surfaces are wood, stone, metal and textile reproductions. The embossing of the new wood décors provides a natural look with a tactile dimension that enhances the

realistic appearance. Many of them have a matt surface finish. Among the oak décors, two surfaces with delicate tin-look strands stand out. In addition, there are walnut and pine reproductions as well as textile reproductions in neutral basic colours and easily combinable stone reproductions with a marble or granite look.

New, soft unicolours such as Toffee (warm maize yellow) and Marshmallow (tender pink) provide something new in interior design, while Smoke Green and Azure Blue are more classic variations. Neither are loud but, instead, err towards warm, pastel shades. Most of the new products feature a pleasant soft matt surface.

The typical Ostermann service means all orders are available in small quantities from one metre and, if you place your order before 4pm, it will be dispatched on the same day. All information on the new edgings for Kronospan décors can be found by typing in the search item #KronospanGlobal on the Ostermann website www.ostermann.eu



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New Family Member

Decormax Limited are proud to announce Prem Line as their newest partner for the UK market.

Decormax Limited, a family run, national distributor of wood-based panel products from the market pioneers such as Egger, FunderMax, Decospan and Unilin. Being a forward-thinking company and fully committed to giving their customers something different, they have developed a range of PET faced panels for use within the furniture industry.

National Sales Manager, Luke Johnson explains

'We have seen a growing trend for our customers to create their own door frontals and components and we wanted to take this trend one step further.

Whilst the market has access to Acrylic Faced Panels and also various ranges of lacquered panels, PET foiled panels are something new to the market. Not only are we giving the market something new, but we also looked at the current ranges and noted the cons of each range, took that to the factory and tried to turn the cons into pros. I truly believe we have succeeded.'



He continues to say 'Prem Line are the forefront of innovation when it comes to surface designs and textures for the furniture industry also being a family run business, this encouraged us even more. After visiting the factory, we knew we had made the right choice and seeing their continued investments in purpose-built machinery, new textures and commitment to quality, just cemented our desire to distribute for them here in the UK'

The UK based range will consist of 17 decors which are a mixture of plain decors, synchronised woodgrains and metallic designs which complement each other effortlessly. Available with matching 1mm ABS Edging, the range will give endless possibilities to any designer. And working with a sheet format of 3050 x 1220 x 18mm, using a hybrid core of MDF and Chipboard, makes choosing this range extremely cost effective.

The range is launching this month, March 2023 and will be available exclusively through Decormax Limited. If you need anymore more information, please call or email us using the below information. Or check out Prem Line's website - www.premline.it



Natural charm

Reduced... but lively – and therefore extremely expressive. That's how Continental describes its new skai Casella Oak.

Designed as an all-over structure, the focus of this design is the authenticity of the wood grain. It gives classic oak an exclusive and modern twist. Small inclusions and cathedrals provide movement while supporting the reserved impression and clear veneer character of the design.

In keeping with interior design trends, Continental decided on a matt finish for skai Casella Oak, making the surface particularly elegant. Available in a colour spectrum that ranges from light bleached to dark brown, the oak pattern is stylish and enriches interiors with natural charm.

The style of the pattern fits the *wood feeling* trend perfectly. Continental devotes a chapter to this in its latest trend book, *Global Fusion*, which focuses on the diversity of wood looks. The different grains and structures create exciting new designs, suitable for many applications – anything from kitchens and bathrooms to living areas.

Egger uses Casella Oak on its classically-laminated Euro design plywood and MDF and Continental's woodgrain was developed in close cooperation with Egger. "With Casella Oak, we have developed a very natural reproduction of oak that omits rustic elements like cracks and knots and has a realistic veneer character due solely to its balanced pores and cathedrals, allowing it to match any environment smoothly and create value in the interior," said Klaus Monhoff, Director of Pattern and Design Management at Egger. Patrick Holz, Senior Product Manager Interior Living at Continental, added: "The creation of skai Casella Oak shows that our trend analysis was correct and we are on the same wavelength with other manufacturers. The partnership with Egger makes us both successful. Together, we approach topics in a targeted and customer-oriented manner, market these and fill the palette of designs with life."

For more information visit www.skai.com/en/interior/furniture-foil-oak/

With skai Casella Oak, Continental offers a reinterpretation of a classic that's far from its rustic roots.



Images: Continental



Yin and yang

Nicholas Yazigi creates a stunning contemporary kitchen that fits perfectly with the bare stone walls inside a French vineyard.

It's common knowledge that opposites attract and that's especially true of materials: dark with light, rough with smooth, old with new – they work together so easily. In fact, there is something quite magical to characterful old stonework, or time-worn timber that makes it the perfect backdrop for the simple, clean lines of ultra-modern fitted furniture designs that employ sleek, clean, smooth surfaces and harmonious colours.

When Nicholas Yazigi was given the job of creating a kitchen filled with modern functionality that worked perfectly with

beautifully-pointed bare stone walls and natural, warm earth tones – the dramatic and stunning setting inside a vineyard in the south of France – it's hard to imagine more alluring combinations than the materials he chose.

Originally a woodworker, Nicholas enjoys the visual and tactile experiences that result from combining different types of wood with other materials, so for the vineyard he employed oak, natural stone and HiMacs. "The specifications were simple at first glance," he says. "Design a harmonious, ergonomic, elegant kitchen in a vaulted space, integrating it perfectly into the irregular, stone



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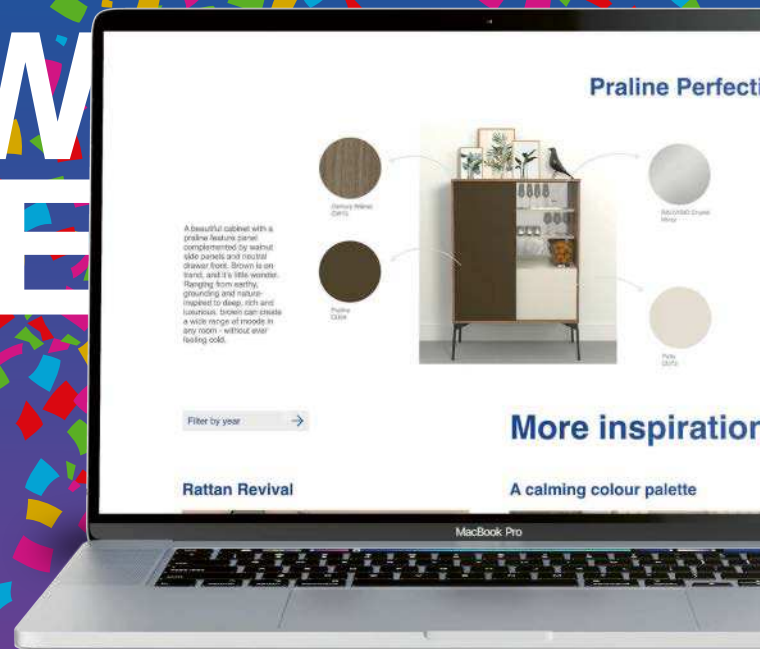
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The hob and sink are both embedded in the worktop and two dish drainers are carved into its surface.



A chopping board slides along the worktop.



interior. What made this even trickier was that there needed to be a space for a passage into an adjoining room. The choice of materials was a key component.”

The kitchen comprises two runs of units made from oak. Each unit measures an impressive 4.3 metres long (one of 80 cm wide and the other 70 cm) and its worktop, splashback and side façades in immaculate HiMacs create a striking contrast.

Part of the challenge was to create such extremely long worktops but the incredible properties of the solid surface material made seamless assembly possible. Not only did Nicholas achieve the sleek lines he wanted, he also created a work surface that was easy to

clean for impeccable hygiene. The hob and sink are both embedded in the worktop and two dish drainers are carved into its surface. Attentive to detail, Nicolas even crafted a chopping board that slides along the worktop.

Though meticulous execution was required to fit the kitchen snugly against the stone wall of the interior, the end result is absolutely stunning. Because HiMacs can be worked like wood, for this project, Nicolas used the carpentry techniques he acquired during his work on mountain cabins. In so doing, an initial wood template was constructed and laid on top of a HiMacs sheet, which was then cut using a conventional woodworking router.

This project is a remarkable illustration of a flawless interface between past and present. HiMacs stands up marvellously to the challenge because its properties enable designers to adjust to each era, each structure and ultimately enhance the end results. The completely smooth, non-porous surface and seamless assembly of HiMacs make it not only incredibly hygienic but also resistant to wear, scratches and even to stains such as those from the wine produced in the vineyard.

For more information and to find out how HiMacs could enhance your next project, visit www.himacs.eu or call 01732 897820.

Photographs by Nicolas Yazigi.

Luke Rawlinson's UPM
Biophilic Storage Cabinet



Lathams: supporting

James Latham involves three of its premium supplier partners to provide materials for Rycotewood's competition.

James Latham, is a long-time supplier to Rycotewood College, Oxfordshire. When the college approached the timber and decorative surfaces supplier as a potential partner for its 2022 student competition, James Latham was delighted to donate the materials for it.

At the heart of the competition's aims were colour and curve, inspired by guest mentor Fred Baier. So, to provide an extra level of challenge, James Latham suggested the students should work with unfamiliar materials, using the resources available at Rycotewood, under strict timings.

Once the overarching theme of 'storage' was agreed, James Latham approached three of its premium supplier partners to get

involved: HiMacs, UPM and Valchromat – all globally popular options for furniture applications. All agreed to participate.

Following a 10-week entry period in which 12 Rycotewood degree students participated, judging took place during the end-of-year celebratory show and the winning and commended entries were announced at a special event last summer.

2022 was a particularly strong year, with highlights including the work of Yuchen Liu, one of the joint winners, who used his concept to showcase HiMacs. His cool and contemporary bar cabinet is a true celebration of the surface, using its bright orange tone with stained European oak to create a visually arresting piece of furniture.



Yuchen Liu's HIMACS
Contemporary Bar Cabinet



Catherine Warsi's
Valchromat Storage Sphere

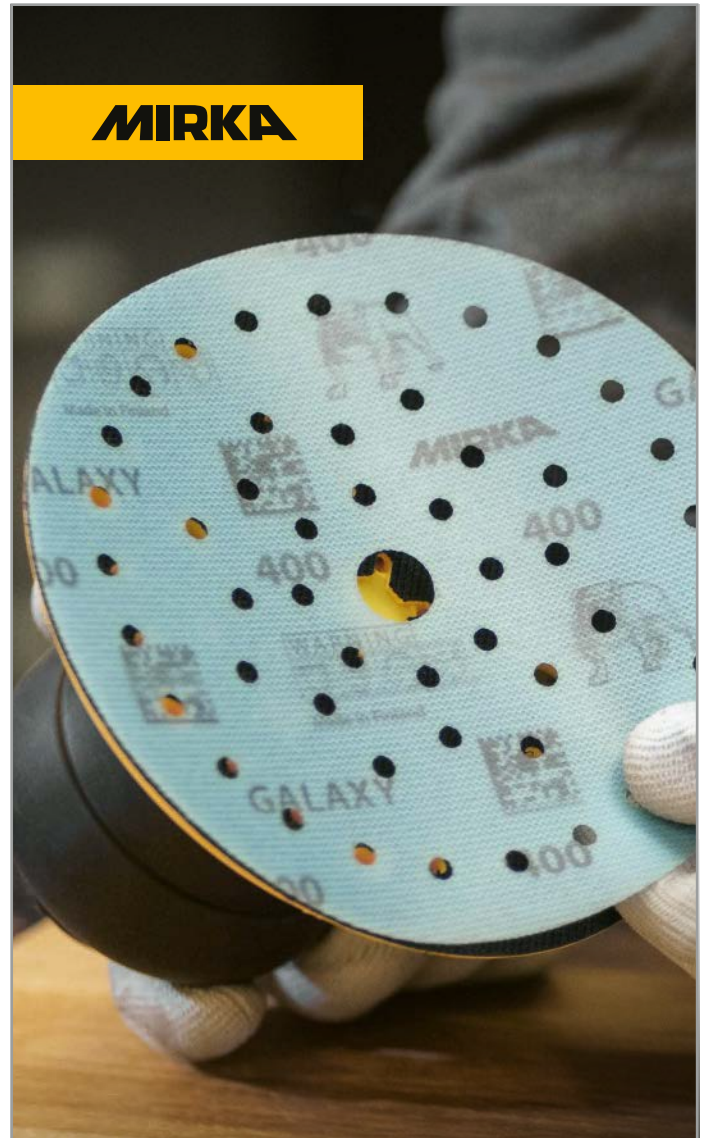
creativity

What made his piece stand out for the judges was the originality in its use of HiMacs and the way in which he had formed the surface to create a seamless s-shaped curve.

Luke Rawlinson was the competition's other winner. He used UPM's Grada2000 Birch Plywood to breath-taking effect in an elegant, biophilic-themed storage cabinet. Taking advantage of the material's thermo-formability, he adopted an innovative approach to the design by accentuating Grada2000's signature ability to curve and stay curved.

Finally, Catherine Warsi was also commended for her clever and creative use of Valchromat. She unveils the versatility of this popular engineered panel in an ambitious spherical storage unit. Seeking a through-colour surface but realising the tools available on-site would limit her opportunity to work with HiMacs, Valchromat's blue-hued board provided the perfect solution to this challenge.

To find out more about the competition and for more information about HiMacs, UPM and Valchromat, as well as James Latham's wider material portfolio visit www.lathamtimber.co.uk



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Making life easy

What sets your joinery workshop apart? For bespoke joinery company, Golding Bespoke Woodwork, it's not only their ability to create truly show-stopping furniture but their investment in equipment that pushes the boundaries of design. A fully-fledged Lamello user for over three years, Joe Golding and his team of skilled joiners have modernised their production processes with help from Swiss joining expert, Lamello.

"We pride ourselves on being able to find solutions to the most complex designs," says Joe Golding, Owner of Golding Bespoke Woodwork. "Designers will come to us because they know we thrive on using innovative techniques that help us create truly unique pieces. Lamello has played a huge part in this."

Originally attracted by the ease and flexibility Lamello's Zeta P2 biscuit joiner and P-system connectors provided, Joe saw Lamello as a problem solver. "We didn't want to waste time figuring out the best places to insert pocket screws. We also didn't want to be restricted by size or space, or be

concerned by on-site damages. We needed something that could offer us clean, precise, strong joins that could be put together in a flash. We knew Lamello's unique range of fixings were the answer."

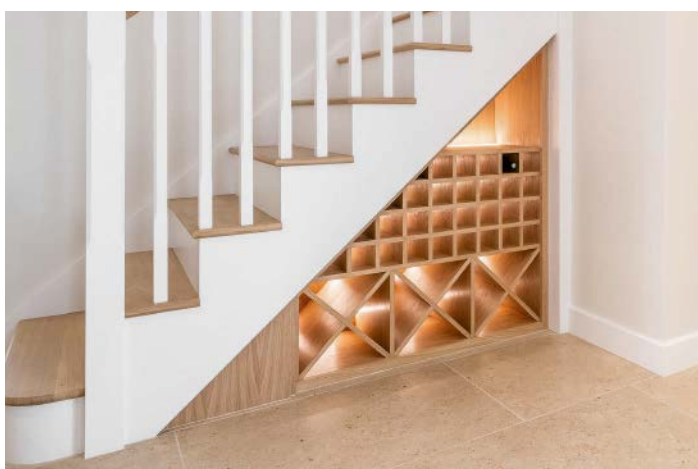
Fast forward three years and the Buckinghamshire-based company uses Lamello's connectors in every design they create. "I can think of so many designs that we've created that would have been almost impossible without Lamello's fixings," admits Joe. From hide-away entertainment units and curved bedroom furniture to home bars and kitchen dressers, Joe and his team are true advocates of the Swiss-fixing company and now use a wide range of P-System fixings, including the Clamex-P, Tenso-P and Divario-P.

"We knew it would make our lives easier but what we didn't anticipate was how much the P-system would change our approach to the work and the kind of projects we could undertake," he says. "It has opened up a world of possibilities for us as creative makers and given us so much design flexibility."

Acute and difficult angles, long pieces of furniture that are difficult to install – Lamello makes them easy.

The team at Golding Bespoke Woodwork





One of Joe's most challenging projects was the design and creation of a 3D basement bar. "No fabricator would touch it because of the obscure angles and thicknesses, so we set about creating the illusion of stone using MFC and plastic sheets.

"For us, the biggest challenge was finding a way of joining pieces of MDF cut at acute angles. We couldn't glue the panels because that would require clamping each panel in place. They would simply end up sliding upwards and creating gaps. We also couldn't screw the panels in place because it wouldn't have offered us the strength we needed and the holes wouldn't have been easy to hide. The solution was a combination of Lamello's Clamex-P and Tenso-P fixings."

Joe and his team created the framework with Clamex-P fixings. Effective across large surface areas and shallow depth while remaining strong, the detachable connector eliminates the need for glue and enables aesthetically pleasing joints at all angles. They are also ideal for use on permanently joined or detachable mitres, making the bar build simple. Additional Tenso-P's were used as a self-clamping gluing aid, offering a seriously high clamping force and quick assemble. And,

to stay in keeping with the bar's sleek design, once inserted, there wasn't any unsightly fixing holes on display.

"Because the angles were so tight, we used 14mm and 10mm Clamex-P fixings to join the panels together. It allowed us to bring this imaginative design to life. We were able to assemble parts of the bar in our workshop and the rest on site to save time. We also took one of our Zeta P2s with us in case we needed to add any additional fixings during the final build. The whole project took two weeks to complete. If we hadn't used Lamello and had only glues, dowels and clamps to rely on, we wouldn't have been able to complete the design to such a high standard and it would have taken five times as long."

Joe's material wastage has also been reduced. "A lot of our projects are pretty out-of-the-box. This means we don't always use MDF and ply. We regularly work with solid woods and finish furniture in-house with expensive stains and lacquers. This means we can't afford to make mistakes at any point during the manufacturing process or during the assembly. When using Lamello, the set-up is so easy. You can't go wrong."

On-site build constraints have also been reduced: "Before we used Lamello, one of the biggest challenges we faced was getting long pieces of furniture into houses. With Lamello, size doesn't matter. Regardless of the length, height or angles required, Lamello's fixings make assembly possible in the tightest of spaces and joins remain strong, even when moved and reworked several times."

Joe adds, "We now have three Zeta P2s. They've become as important as a drill to us, so it is easy to justify the price. As soon as you start using it, you make your money back through time, manufacturing efficiencies and quality of finish. How quickly things can be put together should not be underestimated. We call it the Lamello clip-and-go process. It has made a big impact on our bottom line and ultimately allowed us to work smarter on some beautiful projects. We're now considering purchasing the new Cordless Zeta for use on-site. That's next on my wish list. But for now, we can rest easy knowing the P-System does exactly what is designed to do and it does it to an exceptional standard."

For more information, visit www.lamello.co.uk

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Free — from Häfele

The Free family is a range of hingeless and hinged flap-type fittings from Häfele, which eliminate the need for large, space consuming cover caps. Available in a variety of options to suit kitchens of different sizes, heights and depths, the collection has already won several international awards and is becoming a must-have solution for kitchens where space is at a premium.

Designed using Häfele's extensive knowledge of the furniture manufacturing market, the Free family places user-friendly functionality at the heart of its design and has undergone extensive testing to ensure high quality and durability. It offers the option to either tilt, lift, fold or swivel cabinet doors into a fixed open position,

depending on the available space, ensuring users are able to reach deep into the cabinet from all angles.

The Free Space has been recognised by world leading award programmes, which have highlighted the product for its distinctive but functional properties. It achieved a special award with the globally-renowned Red Dot Award and was presented as a 'world first' when it achieved the Interzum award for 'High Product Quality' in 2019. It then went on to win the German Design Award and German Innovation Award in 2020.

The fittings are simply clip-mounted to cabinets using a single pre-mounted conventional screw connection on the side walls for quick assembly and each offers

A range of hinge-less and hinged flap-type solutions from Häfele.



different weight and angle capabilities. Their design is minimalist and available in standard colours – white, light grey and anthracite, and in black as a special-order product – to match most modern kitchen cabinets.

In addition to flap solutions, Häfele has successfully supplied a broad range of hinges to the furniture market for more than 40 years, helping you produce high quality designs with fittings that are built to last. For its own-brand Metalla range, Häfele applied its extensive knowledge into three years of research and development, resulting in products that boast an unbeatable level of quality and performance.

The Metalla 310 hinge is the first of the range to launch onto the UK market and it

has been specially designed to give you a high-quality choice, whatever the application. The range includes a large assortment of mid-range hinges suitable for wide angle openings, post hinge applications and 30 or 45-degree opening and it is available in soft-close or a non-soft close variant. It is ideal for standard installations such as common 110° angle openings.

In the development of Metalla, Häfele UK came together with its counterparts in all other global regions to explore the varying needs, differences and commonalities of customers when working in different territories. And while in the UK residential and commercial hinges need to meet BS 6222-2:2009+A1:2017 Level H, Häfele has

ensured its Metalla 310 hinge – regardless of application – has also been tested for at least 40,000 cycles and 48 hours against corrosion resistance in accordance with EN 15570 level 2 / LGA quality certification.

A lot of scrutiny goes into Häfele's production and testing processes to make sure what it sells meets, or exceeds, the standards customers expect. The Metalla 310 was tested on-site where they're made and again by the company's headquarters in Germany. It was then tested to FIRA standard. For extra peace of mind, it comes with a 25-year guarantee.

For more information on the Free family or the Metalla range, call Häfele on 01788 542020 or visit www.hafele.co.uk

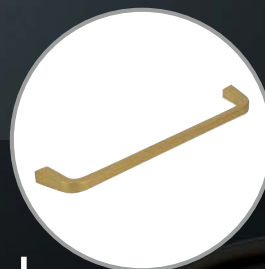


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Kesseböhmer Base Unit



Larder Convoy

Hranipex branches out

From edgelandings to hinges, slides, handles and now kitchen storage, the range of products available from Hranipex just keeps growing.



Adam Stevenitt

If you thought Hranipex was just a manufacturer of edgelandings and a provider of adhesives and cleaning fluids, the last few editions of Furniture Journal we've published must be starting to change your perception: in July, we brought news of a new edgelanding servicing offer; in November came the announcement of a new range of hinges; January saw the addition of handles; and this month, Hranipex UK has revealed an entire range of kitchen storage solutions as part of a growing fittings and components portfolio.

A key constituent of any kitchen, the kitchen storage solutions Hranipex UK offers include full height larder units, corner cabinets, base units and organisers. A major part of the offer comes from the range of Kesseböhmer kitchen storage solutions.

Adam Stevenitt, Technical product manager at Hranipex UK, explains: "We

have the Convoy, Tandem, and Dispensa larder units and they provide full height storage solutions with accessories such as e-touch opening and closing, as well as additional baskets. We are also offering the Riex brand alternatives – a more cost-effective solution that still has the functionality you would expect. Riex products include the GX58 (F001860) larder unit, available in dark grey or white, with chrome wire, or with matching full bottom baskets.

"The combination of Kesseböhmer storage solutions alongside the Riex range gives both a premium design option as well as an economic choice, so you can find the perfect balance for you and your customer."

Under-counter corner storage options from Hranipex include the Lemans, Magic Corner, Revo and carousel options and these are available in a range of cabinet



Clockwise from top left:
 Riex GP58 Baskets, Riex GP28, Kesseböhmer Accessories,
 Youboxx storage accessories and Riex GP58.

heights and finishes. "Again, in this range we are offering a few Riex brand alternatives, like the GP58 (F001828) corner unit, for example. This unit comes as standard in dark grey, with matching 16kg basket capacity and a soft-closing mechanism.

"We offer base units in many different combinations including full bottom or wirework baskets in sizes from 150mm to 600mm, push-to-open options, chrome, anthracite or white.

"Our Kesseböhmer range includes their No.15, Comfort and Dispensa junior options, including accessories such as spice racks, dividers, and Youboxx storage. The Riex range is also quite comprehensive and features soft close, matching baskets and a push-to-open option."

The Hranipex approach to Kesseböhmer storage is different to most companies in that Hranipex has taken the decision to

supply the components individually rather than as kits. "Our reasoning for this is that it allows for more cost-effective supply, with the customer only receiving what they need rather than unnecessary additional components. Also, if a replacement part is needed, we can send it out. There's no need for the whole kit to be replaced."

To complement the larger storage systems available, Hranipex is also stocking smaller accessories such as cutlery trays, anti-slip mats (pre-cut or available in rolls), ventilation grids and hanging systems. As Adam says, "We have a storage solution for you and your customer. Within our broad range there is an option for everyone."

For more information on the new kitchen storage collection, visit Hranipex UK at www.hranipex.co.uk/en or call 0121 767 9180.



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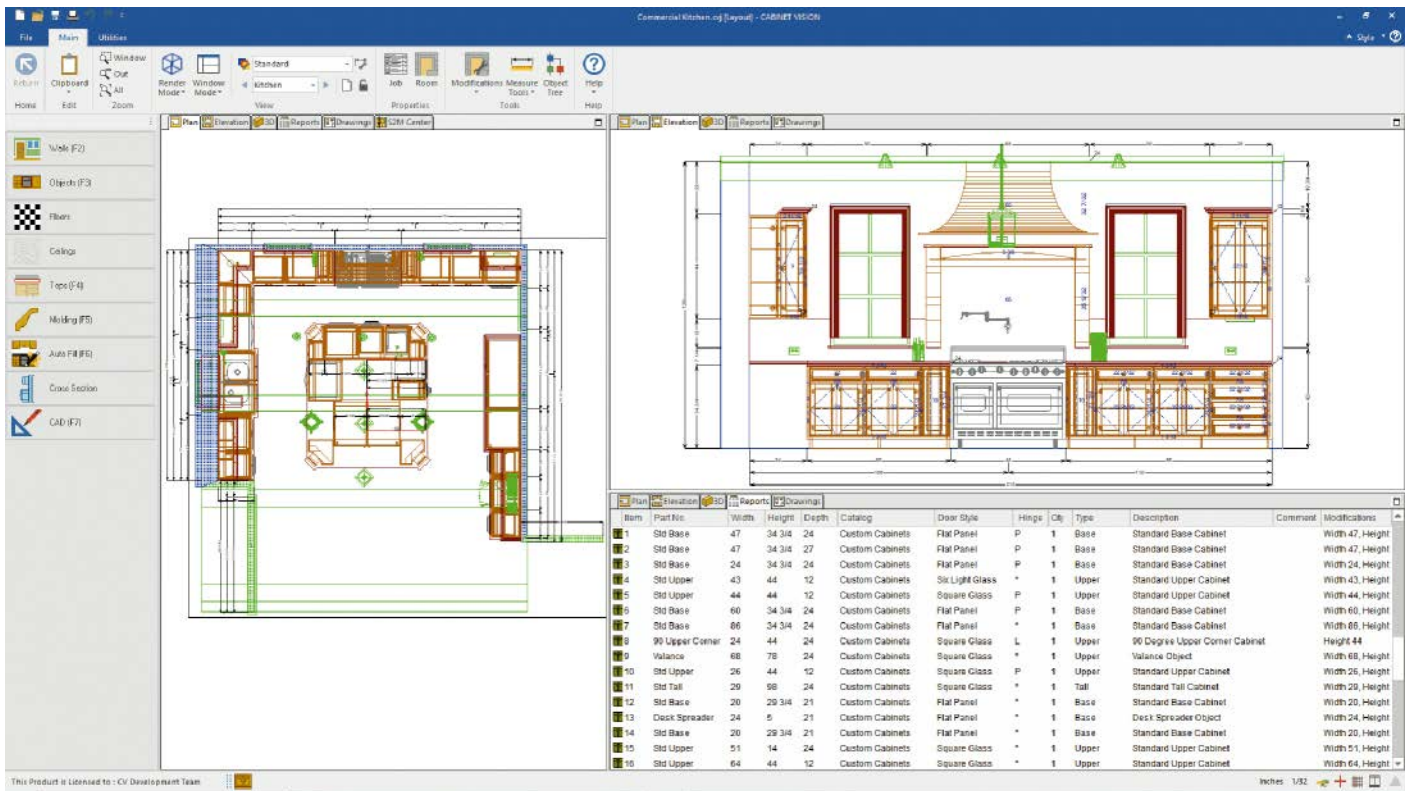
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Data automation reduces bottlenecks

With design and engineering challenges addressed before production begins, how do you remove bottlenecks downstream to make up time on the back end of a project?

Manufacturers of bespoke furniture face challenges unique to each project. From differences in designs, materials and product sizes, to shapes, finishes and configurations, variances among jobs call for a solution with tools capable of fulfilling each requirement. However, this doesn't mean that each project requires different processes for designing and manufacturing bespoke products. In fact, most companies have a relatively similar workflow that allows them to efficiently keep operations running smoothly.

With a significant amount of time spent on the front end of each bespoke project, where design and engineering challenges are addressed before production begins, the question becomes how to remove bottlenecks downstream to make up time on the back end of the project. This is where automation can help.

When we think about automation, many of us picture robots and Willy-Wonka-style factory flows — which at times does reflect reality. However, the term automation also describes automating data flow so bottlenecks can be removed from the transition from each step of the manufacturing workflow to the next.

For companies with workflows powered by unconnected systems, countless hours of productivity are lost each time data must be re-entered or created from scratch at each phase of the process. This could mean, for example, using one software solution to design a project and another to create

renderings, or sending data from engineering software to another system that generates G-code for machining. Not only is this unnecessarily time consuming, but the potential for error increases at each step and can result in costly mistakes. These pitfalls are further compounded when changes in orders occur, a common scenario in bespoke manufacturing.

Utilising a comprehensive solution for design through manufacturing helps automate the flow of data because the information generated for use at each stage is derived from a single data source. This increases efficiency by both speeding up the process and eliminating the potential for error. Design changes are automatically cascaded down to each subsequent step in the workflow, which significantly helps save time and cut costs.

To automate your data and reduce bottlenecks, call Hexagon on 01245 542040 or visit [hexagon.com](https://www.hexagon.com)



Keep track with CAD+T

CAD+T has launched a fully-customisable RFID parts-tracking software solution that can be tailored to your company's production needs.

If you think an automated parts tracking system is only suitable for large-scale manufacturers, think again. Austrian software specialist, CAD+T has launched a fully-customisable RFID parts-tracking software solution that can be tailored to your company's production needs, whatever its size.

With contactless parts-tracking, you can have your production cycle at your fingertips. CAD+T's digital network allows you to keep track of every part going in and out of your factory at any one time – and the whole process is live, so you can see the exact status of each part from your computer, laptop or mobile device.

Regardless of your production output, the ability to manage and optimise your production processes in this way represents a significant time and cost saving while real-time insight into your company's workflow and resources helps you improve efficiency from human operation and machinery running times to material usage.

So how does it work? The scale of your production will determine the level of automation required. Strategically-placed gateways work with RFID tags or labels that are attached to individual parts during the manufacturing process. When scanned by a mobile scanner or automated reading device, part numbers will allow you to identify

where the item is. Depending on the structure of your business, this could start with the raw materials being delivered to your factory, followed by step by step tracking that shows you what stage of the cycle a specific part is currently in, if it has been assembled or packaged and if the order has left the warehouse.

Martina Schwarz, CEO of CAD+T says: "There are huge cost savings to be had when using a RFID system and it is proven to reduce losses, limit human error and improve customer service. Whether you want an all-encompassing tracking system that tracks parts throughout your entire production cycle or want to track specific areas within the business, CAD+T works with you to create the most effective solution that includes both software and hardware. For smaller businesses, parts can be manually scanned but still offer live data feedback at any time and highlight delays in production. Alternatively, larger manufacturing facilities could benefit from automatic reading devices that follow the parts from the warehouse all the way through to shipping. The level of tracking is unique to you and CAD+T's specialists are here to help you create a digital network that is specific to your production facility."

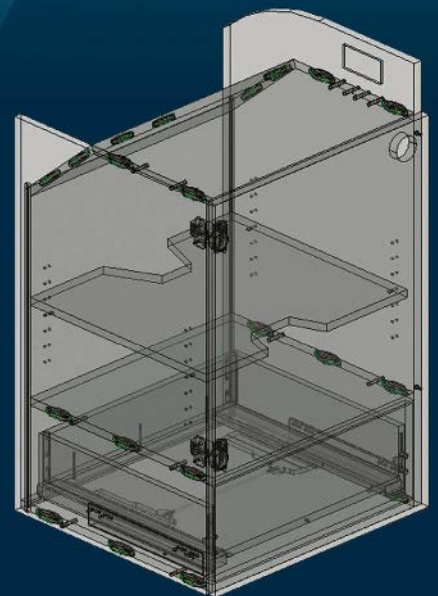
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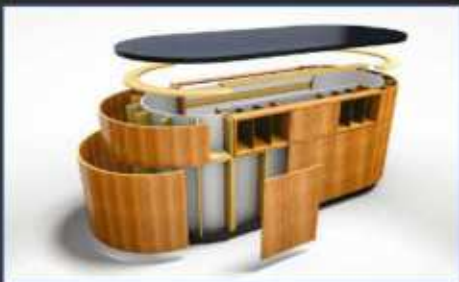
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Barbaric: good for Gooding

The Gooding Group, established over 25 years ago, concentrates on the supply and installation of fitted furniture to the new build sector. Wardrobes account for the majority of the company's production but requests for home office and under stairs solutions are growing. In need of advice on how to increase production numbers, improve quality and streamline the production process in Gooding Group's new £5million, 60,000 square foot, purpose-built state-of-the-art factory, Managing Director Lloyd Gooding called in Bicester-based RV Machines Ltd.

RV supplied two Anderson GS linear routers – each capable of routing at 90 metres per minute – that offered extremely high drilling cycles unavailable from comparable machines. High production speeds demand efficient supply, so working hand in hand with the Andersons, Lloyd also ordered a board storage system from Barbaric, an Austrian company with a track record that includes multiple installations in Canada, America, Australia and many other countries.

The combination of the Anderson GS and the Barbaric storage system allows programmes from the design office to be sent straight to the storage system, which in turn automatically loads the required size and colour of panel to the infeed of the

Anderson GS. Panels are labelled with the Anderson's automatic laser label printer before being transferred with a vacuum loading system onto the router bed for processing. On completion, each panel is then driven to the unloading area, allowing the next to be processed.

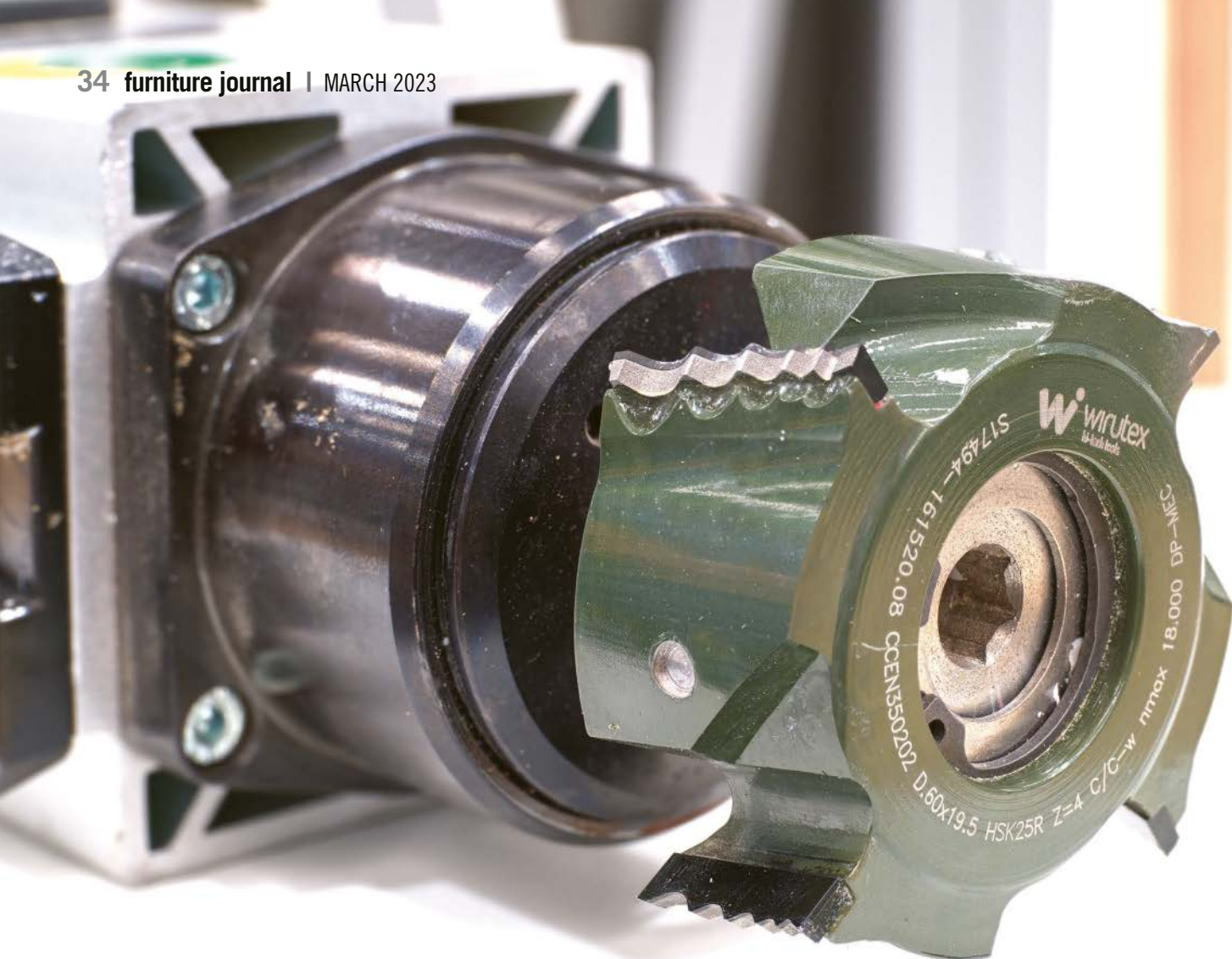
The manual system Gooding Group was using before the Andersons arrived required five members of staff to operate it. The new automated system requires only two. Lloyd Gooding is delighted with his investment and has nothing but praise for the machines and the impeccable installation overseen by RV and the Barbaric technicians.

If you'd like to find out what difference an Anderson could make to your production, or for more information on the solutions provided by RV Machines, call 01869 244943 or email sales@rvmachines.co.uk. Alternatively, visit RV's website, www.rw-machines.co.uk

Two Anderson GS linear routers and a Barbaric handling system increase production numbers, improve quality and streamline the production process at Gooding Group.



The Anderson GS 71



Smooth on

A superb finish to edges and corners, endless flexibility and fast changeovers are just three of the benefits of Biesse's new AR70 single-motor corner-rounding unit.

When was the last time you took a close look at the edges of your finished panels – a really close look? Were the radii absolutely smooth and free from chatter marks? Did you notice any chipping? Did the corners pass the thumbnail test or did you notice a tiny raise in the edging material that snagged?

With the emphasis firmly on imperceptible glue lines, it makes little sense to ignore imperfections on the edging materials – and to combat such imperfections is one of the key reasons Biesse has introduced its AR70 single-motor corner-rounding unit as an option on its Stream A and Stream A Smart mid-range edgebanders.

The technology behind the AR70 isn't new; in fact, it's filtered down from Biesse's larger industrial models. But while the most obvious benefits when you run your fingers

over a panel edge are exemplary smoothness, no chatter marks and no snagging on the corners, what the AR70 brings to the party is much more: I'm talking about versatility; the kind of versatility that enables you to switch instantly and automatically between any of four different radii and a chamfer and even create your own unique edge profile while running at speeds of up to 25m/minute. Features like these in a mid-range edgebander are quite something.

"Machines equipped with an AR70 will appeal to customers who want total flexibility on the corner-rounding," Malcolm Storey, Biesse UK's Brand Sales Manager for Edgebanding explained. "The machines we've sold since the first one arrived in our showroom last autumn have gone into trade suppliers who never know what they are going to produce next and need the



the corners

versatility to switch in an instant. They could be edging a laminated post-formed panel one minute, a batch of panels edged in 1mm or 2mm the next. Every order could be different. With the AR70 you get the flexibility to cope with that and produce work of the highest quality. There's no longer a compromise."

So, what's an AR70?

The AR70 is a single-motor corner-rounding unit that gives you the advantage of being able to do top and bottom corner rounding with just the one unit. Historically, mid-range edgebander users have had to decide on the edge thickness and select a radius to apply to it – generally 2mm, 1.5mm, or 1mm, sometimes 3mm. With a two-motor corner-rounder there's invariably a compromise: "Typically, when you change from 2mm to 1.5mm you don't change the

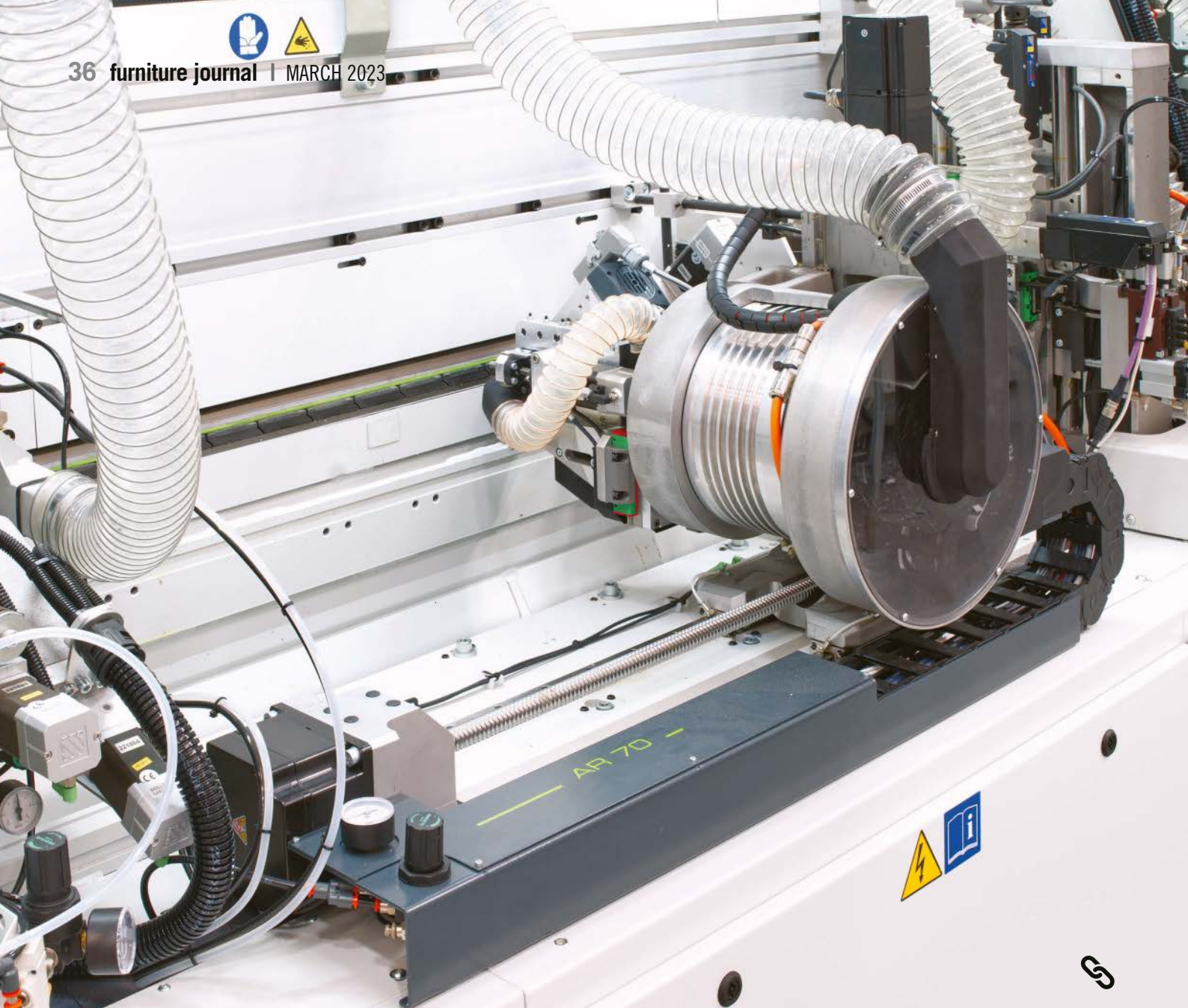
radius on the corner-rounder; you compromise on it so the result is a 2mm with a 1.5mm radius or a 1mm radius on the corners, or whatever setup you have on your corner-rounder.

"The beauty of the AR70 is it comes as standard with a multi-profile tool that includes four radii and one 25-degree chamfer, so you have five options that can be used to process the edge. You have standard 3mm, 2mm, 1.5mm, and 1mm all on one tool, which means you have enough radii to cater for a 1mm on slab effect panels for kitchens and switch instantly to larger radii for such as office and educational furniture, care homes or hospitals."

Most quality-conscious manufacturers want to improve the blend on the corner as well as the glue line and by combining servo-positioning with a multi-profile tool, Biesse's



Malcolm Storey



The AR70 is a single-motor corner-rounding unit that gives you the advantage of being able to do two-radius corner-rounding.

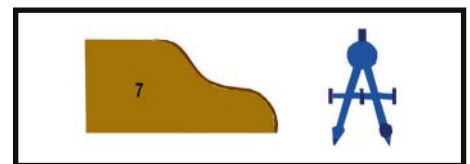
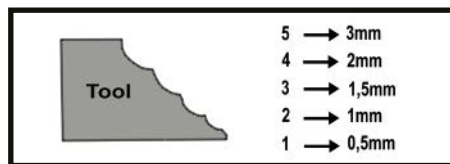
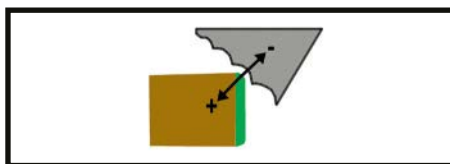
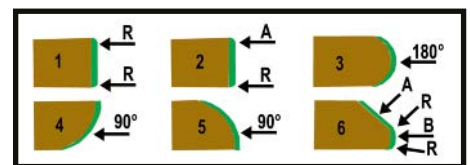
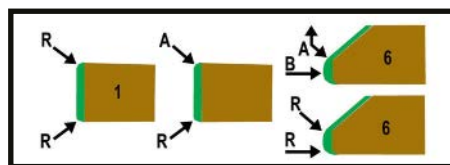
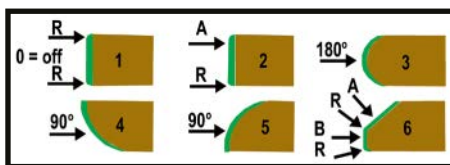
AR70 provides the best of both worlds. Add in a processing speed of up to 25m/min and non-mechanical software-driven adjustment to change the profile over on the Stream A and Stream A Smart and it's not difficult to see why these machines have already become quite a hit with small to medium-sized furniture manufacturers since the AR70 was launched.

"With the servo and the NC control, we can regulate the position where the corner-rounding unit engages the panel," explained Malcolm. "It's not so much on general profiling but when you are doing bull-nosed profiles, depending how the material is constructed, there can be a weaker area at the core of the panel and that can cause deflection. With the servo, we can put less pressure on and control that. Instead of being hard up against the board, the pressure is reduced – but that's not something the operator needs to think about. Everything is controlled automatically

from the front end of the machine. Select the program and the machine does everything for you.

"With an AR70 you can process with four standard radii and a chamfer but you can also accommodate all postforming applications and create your own complex profiles simply and easily from the menu. There is even a feature where you can import your own CAD profile into the machine software and select that at the touch of a button."

The exceptional smoothness of finish along the panel edge and around the corner is the result of a combination of factors: "The fact we are engaging the panel with the correct forces and we're copying the panel exactly are key. The copying shoe engages with the panel and because the profile cutting block is independent of that, it provides greater control to give a higher quality finish. That's the beauty of the NC control. It's fully NC, not part mechanical. That really adds to the quality.



"In addition, we're using an electrospindle with the cutting block. It has really tight bearing and run-out tolerances that come from Biesse's HSD router spindle technology and that allows it to run at a higher rotational speed, reducing vibrations that might ordinarily cause chatter marks. Most machines with a conventional motor run at 12,000rpm. HSD technology allows us to use a rotation speed of 18,000rpm. Combine that with the four-wing cutter block and cutter marks are vastly reduced.

Because machines equipped with an AR70 unit can run at 25m/min, Biesse has enhanced the end trim saw unit with the addition of a servo to cope with the higher track speeds. A hybrid glue head that allows faster switching between adhesive types/colours has also been added in combination with an NC glue gate that automatically regulates coat weight on the roller relative to the core material. When processing MDF the coat weight is reduced; conversely, more adhesive

is applied when processing MFC – and through NC control, the result is a higher quality glue line. "We get no contamination of units further down the machine, which means the finishing sections don't have to work as hard," Malcolm explained.

From an operator perspective, programming the machine is a simple matter of following prompts on the control. The program asks where you want to apply the radius – top or bottom – whether it will be postformed, what angle you want and what radius you prefer. If you want a 90 degree on the bottom, or a full bull-nose, you input four pieces of data. There is no mechanical setup. If the radius has been imported as a CAD profile, everything is displayed on the control screen ready for one-touch selection.

"You can do solid corner lippings or any kind of edgebanding. Whatever you use, you simply create the program so the operator can pull it up. The machine does everything

else, positioning units and giving you exactly the finishing you want.

"Compared with a conventional corner-rounding unit, the AR70 is an eye-opener. The finished panel feels so much better, so much smoother. The standard has always been to have a bottom corner that's difficult to set and maintain. That's been eliminated with the AR70 because we are working off the centre of the cutter and the centre of the motor. Traditionally, we've always had a mechanical copier which floats when it positions. That's gone too, replaced with a servo-driven system. Everything is software driven and if you want the absolute best quality you can get, this machine will deliver it."

For a demonstration at Biesse's Tech centre, call 01327 300366 or for more information visit www.biesse.com/uk/ Readers with the free Furniture Journal app can watch a video of the AR70 in action by touching the image marked with a link sign.



The door to success



Chris Holland

Think you can't afford a CNC? Weinig's Pro-Master has been a game-changer for Chris Holland and his team.

If you're running a traditional joinery company, you're looking at ways to expand your offer but think a CNC machine isn't a viable option for a smaller business, maybe it's time to think again.

Meet Chris Holland, owner of Bespoke Wooden Luxury and the driving force behind his company's ambitious growth plans. Purchasing his very first CNC machine in 2022 from Weinig, the solid wood door and window company has increased his production five-fold in just six months and he is now set to launch his very own e-commerce website as the company continues to modernise its Bridgnorth-based workshop.

"Every joinery workshop in the UK is experiencing the effects of the skills shortages and we are no different," says Chris, a joiner of 20 years. "Following the

pandemic, two of our most experienced joiners left the company and 18 months later, we were still unable to find suitable replacements. Our options were limited. We either needed to adapt our manufacturing methods and invest in new technology or admit defeat and eventually shut up shop."

The latter was not an option for the pioneering businessman and after securing a grant through Birmingham City Council's Birmingham Growth Programme, which is intended to help businesses in the local area grow, Chris began his quest for change.

"My idea was to invest in machinery that could improve our manufacturing efficiency and reduce our reliance on skilled workers. After a lot of internet research, I thought I knew what we needed. It wasn't until I picked up the phone to get some quotes that I realised a miniature window line



would not streamline my business or offer me the flexible machining I needed to replace two experienced joiners and assist my existing team in the production of a wide range of hardwood doors and windows.

"It became increasingly obvious that the business needed a CNC machine but I thought CNC's were for large-scale manufacturing companies with deep pockets and a lot of floor space. How wrong was I? After a few calculations, I quickly realised owning a CNC wasn't an unattainable pipe dream for a small business like mine."

After talking to several manufacturers, Chris was sold on Weinig's Pro-Master 7125-495 5-axis CNC machine. "The adaptability of the Pro-Master blew us away and it was surprisingly affordable. Not only could it help us produce solid wood and engineered wood window and door frames more quickly and with a higher level of accuracy, it would also allow us to move away from traditional mortise and tenon joints to

engineered, drill and dowelled construction and other contemporary joining solutions by simply changing the tooling."

The CNC's generous working dimensions (up to 5420mm x 1350mm with a machining height of 210mm) meant working with different profiles was also possible. Chris says, "We didn't want to be restricted by material lengths or thicknesses, which is why we chose a bigger machining table with intelligent suction cups and stops at front and rear. Although we currently produce frames no deeper than 120mm and 4600mm in length, we wanted to future proof our investment. Trends change, which means our designs do too and we needed a CNC that could keep up. The Pro-Master offered us the perfect solution and could produce precision-milled workpieces flawlessly whilst still fitting in our modest 8,000sqft workshop."

The machine's technology needed to be flexible and easy to learn and the integrated



Will McGarry



Campus NC Hops package and versatile macros on the Pro-Master didn't disappoint: "Depending on who is programming the machine, we have the option to work remotely or directly on the machine's 21.5" monitor so both our operator and technical designer can create the required plans and component lists. It's a really adaptable piece of software and this appealed greatly to me. We can also put a WiFi dongle into the machine if we want engineers to access the machine remotely, eliminating an engineer call-out and saving valuable time and costs."

Describing himself as a CNC novice, Chris and his team were trained on the Pro-Master at Weinig UK's facilities in Abingdon. "Our trainer left no stone unturned but it was presented in a manageable format. He got to understand our business so our training was unique to us and with a background as a CNC wood machinist, he was easy to relate to," says Chris.

"For any joiner looking to take their first tentative steps into CNC machining, my advice would be never to underestimate the process and to expect the odd stumbling block. We were realistic in our thinking and knew it would take a little while to get to grips with the new technology. After all, we were used to creating everything by hand and our only experience of working with machinery was traditional spindle moulders, thicknessers and planers. We needed to adapt the way we were thinking and

approach projects differently. Weinig helped us with that.

"Take the way we cut-out espagnolette locks as an example," says Chris. "When we first got the machine, we were cutting the multi-point locks to their exact measurements, but they kept catching. We tweaked the machine so it left an extra 0.5mm at the back of the lock – a tolerance even the most experienced joiner would struggle to gauge – and now each lock is cut perfectly every time. These little adjustments take time to get your head around but we're now flying through our orders and it saves us hours every week."

From the raw material being cut to the parts being assembled, Chris' team can now have a door assembled in 1.5 hours instead of the two days it would have taken before the Pro-Master arrived. "We were completing two to three hand-made doors a week," he says. "With the introduction of the CNC, we tripled this number in a single day, increasing production five-fold and there is still room for growth as we don't run the machine to its full capacity."

The Pro-Master's cutting and drilling accuracy has also slashed installation time on-site and reduced material waste throughout the production process. "We allow over-length on the machine but we can minimise this on each component we cut. Engineered wood lengths are also very accommodating which, when teamed with

the CNC, have helped us reduce waste considerably. It's this, plus the Pro-Master's speed, that has helped us see a return on our investment within eight months. It has given us the confidence to take on more orders and remain competitively priced."

But the benefits of the Pro-Master are not just in the present day, as the forward-thinking company continues to explore new ways to grow and diversify. "Later this month, we're set to launch a brand-new e-commerce door company which will allow us to maximise the machine's running capacity. We're also looking at some commercial projects too. It's certainly a long way from where we were in 2020 when we were faced with a staffing shortage. Without making the leap and modernising our production methods, I'm certain we wouldn't be in business today. At best, we'd have been running at a seriously reduced rate. Now, we're pumped to see what the future will hold as we continue our ambitious five-year growth plan. One thing is for certain though, we couldn't have achieved any of this without the guidance and support of Weinig UK's team and we couldn't produce our range of solid and engineered wood products at this level without our robust Pro-Master CNC. For those people looking to take the next step, talk to Weinig. Their advice really was a game-changer for us and I couldn't recommend them more highly."

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Ticking all the boxes

The new Olympic 500 edgebander has been purpose-engineered to provide best-in-class features and affordability in a compact format.

You're in the market for a compact, single operator edgebander and you've done your homework. You know who offers what and how much each machine costs. You still haven't made a decision on which to go for because the machines you've seen tick some of the boxes but not others. They either don't have the features, the flexibility or the performance you need, or they meet some of your needs but don't fit your budget. It's a dilemma that many people find themselves in, one which often leads to the wrong choices being made out of necessity – but

it's a dilemma SCM's recently-launched Olympic 500 has been purpose-designed to solve. And feedback in the weeks and months after its Xylexpo launch confirms it ticks more boxes for more manufacturers than any other currently available machine in its market segment.

When SCM decided to revise its Olympic range, it took into consideration many of the concerns of its small-to-medium-sized manufacturing customers and came up with a solution that included working units from several of its high-end machines. By rationalising production and using



economies of scale, it was possible to create a very flexible machine with the right flexes and level of throughput for the sector at a price point that was hitherto unachievable – and the result, the Olympic 500, looks set to become the new leader in a much-contested segment of the market.

Although it was launched at Xylexpo, I was first introduced to the new Olympic 500 after the show by Salvina Capraro, Edgebanding Product Manager at SCM's Stefani factory in Thiene. "At the moment, we have three models in the Olympic range," she explained to me. "The Olympic K230 will remain but the new Olympic 500 will replace the main configurations of the other two models, the K360 and the K560.

"The Olympic 500 is ideal for smaller companies that need high quality

edgebanding because we took solutions, technologies and working groups we had already developed for some of our high-end machines and brought them into the lower segment, making them more affordable. The K360 had a rounder with one motor but we have been able to give the Olympic 500 two motors for corner rounding and chamfering of the top and bottom of the panel and we've made them independent. The HMI on the K360 was an older model, so we have provided the Olympic 500 with the latest 15" Eye-S control panel, Maestro Active Edge software and the same interface functions and connectivity that you get with the Eye-M. Another new feature is the automatic edge infeed device, which allows the operator to insert the edgebanding material from outside the cabin, reducing set-up

times. And we have given the Olympic 500 many more new features."

Three versions of the Olympic 500 are currently available and all will edge panels from 8mm up to 60mm thick with materials between 0.3mm and 6mm in thickness and offer a production speed of up to 12m/min. That's on a par with, or a couple of m/min quicker than the other machines currently in this market segment. The three versions are a pneumatic version, an electronic version that positions all the units automatically according to the program selected on the Eye-S, and a hybrid version, which provides a level of automatic set-up at a price point that sits between pneumatic and fully automatic. Later, probably in autumn, there will be an Olympic 500plus model with more new features but I'm not at liberty



The automatic edge infeed device sits outside the cabin just beneath a 15" Eye-S monitor.

to divulge more about it at this stage. Sufficient to say, it will be the new flagship in the Olimpic range.

With the pneumatic version, you get SCM's SGP-E, fast changeover gluepot for use with EVA and PUR (or different colours), the RT-VI pre-milling unit, a K-2 radius and cutting unit, an R-HP trimming and chamfering unit, the Round 2-A rounding unit, a RAS-A edge scraper as well as an RC-N glue scraper, an SP-V brushing unit and an ID3000 hot air edge-brightening unit.

If your budget allows, step up to the Olimpic 500 with electronic set-up and the R-HP trimming and chamfering unit comes with the Multiedge 2R for rapid changeover between two different radii, or thin edges and solid wood. The Round 2-A

rounding unit is replaced with the Multiedge version of the Round 2-A and has two motors and a three-position Multiedge kit to work with two radii. The edge-scraping unit is also the Multiedge version of the RAS-A. Within the specification of each Olimpic 500 variant there is a degree of flexibility, so you could, for example, opt for a quick motor release kit on some units, or add in a 45-degree machining kit, or a Multiedge kit for two different radii and various thin edges, as required.

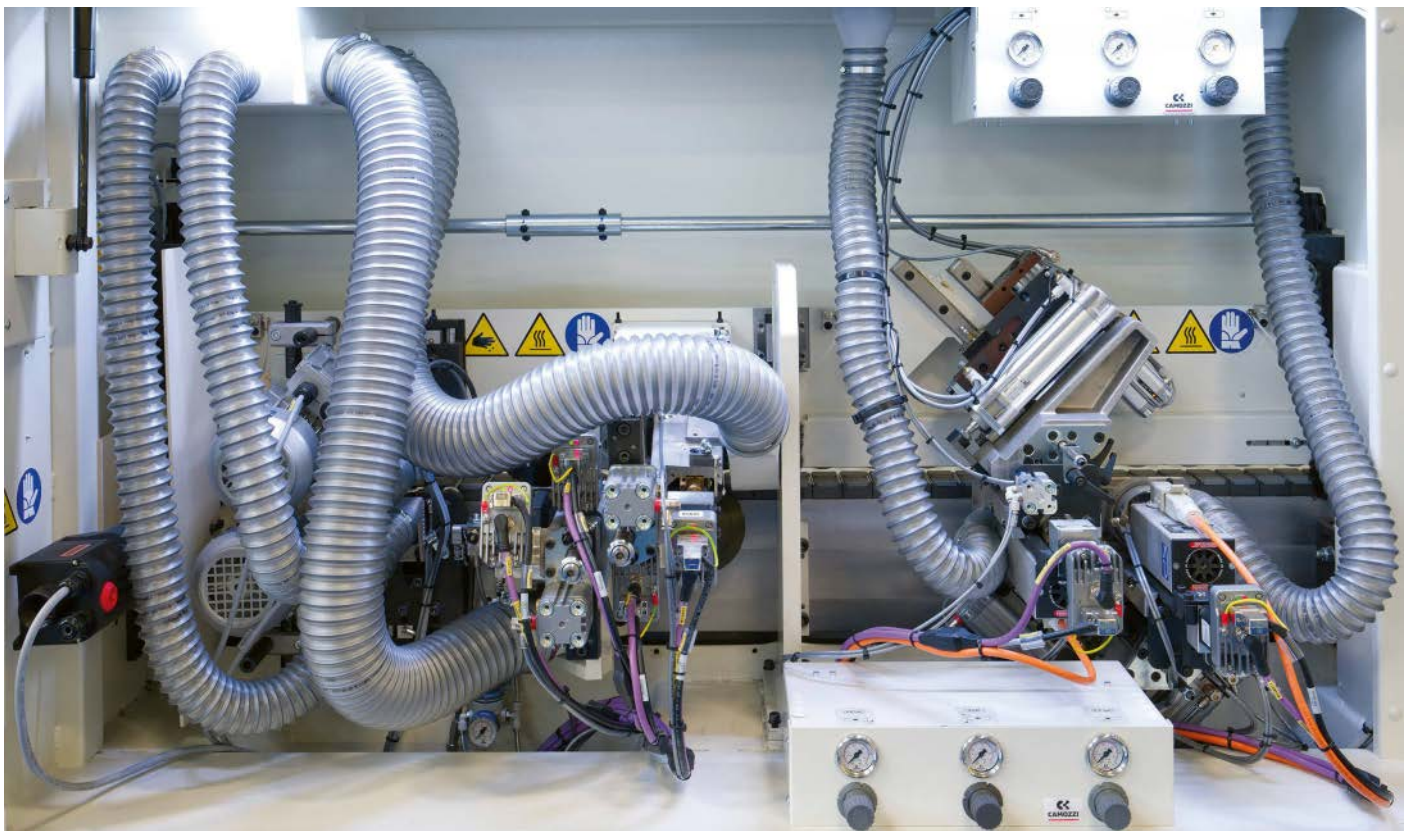
"The Olimpic 500 is complete and versatile," Salvina confirmed. "It will work 60mm wide panels and we have reduced the minimum and increased the maximum so it can work more types of pieces than the previous model. For those who need it, we

also offer an Extra Size Kit for processing very large panels. Air cushions make this really easy. We can also include FastBack panel return devices that make it possible for one worker to manage the entire edgebanding process.

"In terms of flexibility, the Olimpic 500 works with different colours using EVA or PUR and the gluepot enables fast changeover. It will work solid wood and thin edges, again with fast changeover. We can offer a unit for chamfering at 45 degrees and several other possibilities that until a few months ago we could only offer with models much further up the range. We have even introduced a chamfering, edge and glue-scraping system for the Olimpic 500 that allows you to work with nested panels that have been pre-drilled



SCM's SGP-E fast changeover gluepot is standard on all Olympic 500 machines.



with hinge holes. In addition, having two radii available means you can work 1mm and 2mm with automatic or manual switching. The motors can be removed together with the copier on the pneumatic version to keep costs down. And we offer the option of hot air for finishing the panel in order to improve the quality after the milling. It is a very comprehensive offer – exactly what the market has been asking us for.”

To ensure a high-quality finish, the Olympic 500 is equipped with an anti-adhesive spray unit at the infeed followed by three other sprays for edge finishing, delicate edges, and for cooling and anti-static. That in itself might not be unique but by adding an ID 3000 plastic edge brightening unit, the Olympic 500 goes the extra mile: any faint marking from

the scraping process, or discolouration of darker tapes is eradicated by a hot air blower that's adjustable in power up to 3,500W. “The hot air recovers the edge whatever the colour,” Salvina explained. “On gloss, the edge becomes imperceptible. This is normally an option in higher cost machines. We are the only ones to offer this.”

And that's really what the new Olympic 500 is all about: it's been purpose-engineered to tick more of your 'must have' boxes, provide you with everything you could possibly need in one package and do so at a price that's competitive. If you'd like to find out more, call 01 15 977 0044 or, if you are reading this article with the free Furniture Journal app, touch the image marked with a link sign for additional information.

The 3500-watt ID 3000 plastic edge brightening unit provides adjustable hot air for perfect finishing of plastic tapes.





Appreciating

It's not just the machines that keep drawing ABI's Jez Dent back to IMA-Schelling, it's also the exceptional levels of service he receives.

There can be few IMA-Schelling customers more appreciative of the brand than Jez Dent. Jez, the Machine Shop Manager at Beverley-based caravan manufacturer ABI UK Ltd., has responsibility for supplying the entire assembly plant in Beverley with cut, edged and routed furniture panels for the five-and-a-half thousand luxury static caravans ABI makes every year – and with six production lines providing materials for an assembly line that's producing a finished caravan every 18 minutes, it comes as no surprise to learn that reliability and service come pretty close to the top of Jez's must-have list when buying machinery.

"We have three Schelling FH6 beam saws, two FH4s, a third FH4 in our panels department and another FH4 on order," Jez told Furniture Journal in a rare quiet moment away from the shop floor. "We bought our first Schelling saw 11 years ago. We bought another four years ago, then another was installed last year. We also have two IMA Novimat Contour edgebanders. One is seven years old, the other is new and we could do with two more. I've always liked IMAs, ever since I worked at Hygena because that's what they had and they were very reliable."

Take a look inside an ABI caravan and you'll be amazed at just how luxurious it is. Inside an area not much larger than 36 feet by 12 feet,





Three FH6 saws



IMA-Schelling

there's a fully-fitted lounge with a fitted seating area, a dining area, maybe a window seat; a kitchen area that could have an in-built microwave, a dishwasher, even an American fridge-freezer according to what the client wants; one or more bedrooms, also with fitted furniture; and a bathroom, again with furniture. In any caravan, there could be as many as 200 different furniture panels (considerably more in a four-bedroom twin unit) and with ABI customers enjoying the freedom to customise extensively, as many as one out of every three caravans to leave the factory could have a different specification. Understandably, Jezz needs flexibility in the machines he chooses every bit as much as he needs reliability across all six of the panel production lines on his side of the operation.

"We have MFC stored down the back end of the factory and we have three Schelling

FH6 saws installed across the factory floor. We also have two FH4s in an area to the side and they are fed with the same material. We get through about 500 sheets of melamine of various thicknesses and sizes every day. After the saws we have four edgebanders, two of which are IMAs.

"We cut the panels on the FH4s and FH6s and they are palletised according to whether they need to go to the CNC routers, or whether they need kregging. After they've been edgebanded, there will be a pallet for the routers, a pallet for the kreg guys and a pallet for the breakdown area where the loads are split into individual furniture pallets. There could be up to 40 pallets for one job. After the edgebanders, the panels go to the CNCs, then on to notching. Some of the notches need to be square cut but cutting the corners out is done on a band saw.

Others need a small corner round, which we do on a pin router. Some will then go to an edgebander for 0.4mm edging application. The forklift takes them to Cab Shop One or Cab Shop Two where they are lined up ready for installation.

"On some caravan models the carcase work is 18mm thick with 25mm worktops but mostly we are using 15mm. We use a lot of 25mm MFC for bedroom and kitchen lockers, fire cabinets, etc. It really depends on what the customer asks for. We are very flexible with customers and our batch sizes can go from two or three up to 17 or 18. We only build to order."

The saws ABI chose were the Schelling FH4 430/430 with manual front loading and the Schelling FH6 430/220 with automatic rear loading and turntables at the front. The 18kW FH4s have a blade projection of



Jezz had the FH6 saws equipped with a roller loading system on the back and a turntable (right) on the front.



105mm and included in the specification is dual side strip-aligning, which is independently controlled both before and after the saw line. Alignment is possible throughout the total cutting process. To prevent the operator from having to reach into or over the saw line, the feeder clamps push the boards out beyond the saw line. The machine table is designed as an air flotation table that's moveable at the out-feed to improve material support. All the FH4s are controlled by Schelling MCS Evolution software with on-screen operator guidance, while optimisation is taken care of with IMA-Schelling HPO optimisation software from the office. Each saw is equipped with label printing at the control desk for part identification.

"Tim, in our drawing office, optimises everything with HPO and sends it directly to the machines, or we can plug in a memory stick. Some of the batches we do will have 200 panels from a batch of 20 boards. We

can have up to six batches running at any one time."

IMA-Schelling's FH6 models come with more powerful 21kw main saw motors and an increased 145mm saw blade projection – something Jezz and his team make full use of: "These machines have a book height of seven 15mm sheets and they have turntables at the front. If it's really good material, the FH6s will cut eight sheets rather than seven but it's rare we push them so far.

"We had the FH6 saws equipped with a rear loading system on the back and a turntable on the front. We get 32 sheets in a pack and the guys will load two packs. One pack is loaded and one is stood waiting. Depending on the batch size, each saw will get through 90 to 110 sheets in a shift and we run two shifts. They are running pretty much constantly.

"When the machine does its head cut and pushes the panels out, the operator presses a

button and the turntable turns the whole stack around so it can be pushed in again. There is very little manual handling of the heavy part of the product. The turntables aren't standard on the FH6 but they are a great addition." Sideways movement of the turning device also makes the cutting of small parts during the cross-cut operation much easier.

Like the FH4s, the FH6s have dual side strip-aligning that's independently controlled before and after the saw line as well as feeder clamp push-out past the saw line but they also have a separate push-off device at the infeed to increase machine capacity. IMA-Schelling MCS Evolution control with on screen operator guidance and HPO optimisation are included on the FH6 and like Jezz's FH4s, the FH6 saws have label printing.

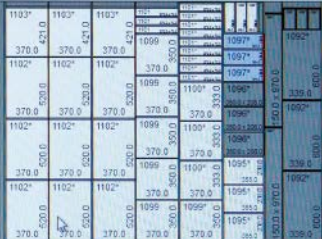
Having almost identical software on all his saws means Jezz can move operators around,



When the machine does its head cut and pushes the panels out, the operator presses a button and the turntable turns the whole stack around so it can be pushed in again.



The FH6s have feeder clamp push-out past the saw line

Infeed device		Manual	Book	Plan	English		Metric
Order	SANDCASTLE 36 3B		0	6			
Schedule	SANDCASTLE 36 3B		0	6			
Plan	140		Stack 1				
Board type	chip		9999				
Thickness	15.00 mm						
L x W	2800.00 x 2070.00 mm						
Saw		Manual	Book	Plan			
Order	SANDCASTLE 36 3B		6	6			
Schedule	SANDCASTLE 36 3B		6	6			
Plan	140						
Board type	chip						
Thickness	15.00 mm						
L x W	2800.00 x 2070.00 mm						
min. L x W	2744.20 x 2062.00 mm						
Storage desig.	Desc. MusterBoard						
Finished part info							
Serial no.	Description	Finish-Der-A	Finish-Der-B	Pos. no	Line no	Proc. descr.	Lib
▶ 1093	> 1096 <	93.0	260.0			IX	
1093	> 1096 <	93.0	260.0			IX	
1093	> 1096 <	93.0	260.0			IX	
1095	> 1096 <	355.0	238.0			IX	
1095	> 1096 <	355.0	238.0			IX	
1095	> 1096 <	355.0	238.0			IX	
1101	> 1101 <	370.0	70.0			IX	
1101	> 1101 <	370.0	70.0			IX	
1101	> 1101 <	370.0	70.0			IX	
1101	> 1101 <	370.0	70.0			IX	

so if one of his FH6 machine operators is away he can divert another from an FH4 and know they can operate it. The FH4 has a lower output but operation of the FH6 requires no additional knowledge or training.

“Our most recent purchase is an IMA edgebander – a Novimat Contour,” continued Jezz. “The first one has run extremely well since we bought it seven years ago; it’s really well engineered and gives an excellent finish. When we went to Ligna and saw the latest version with the corner-rounding unit, we put in a request to buy a second IMA.”

Apart from the corner-rounding unit, which is quite special, and the addition of a grooving saw, the new edgebander Jezz chose is a standard machine – IMA’s most popular model – and in most respects it’s very similar; so Jezz can switch operators between edgebanding machines just as easily as he can between the saws in his sizing department. “The reason we needed another machine was

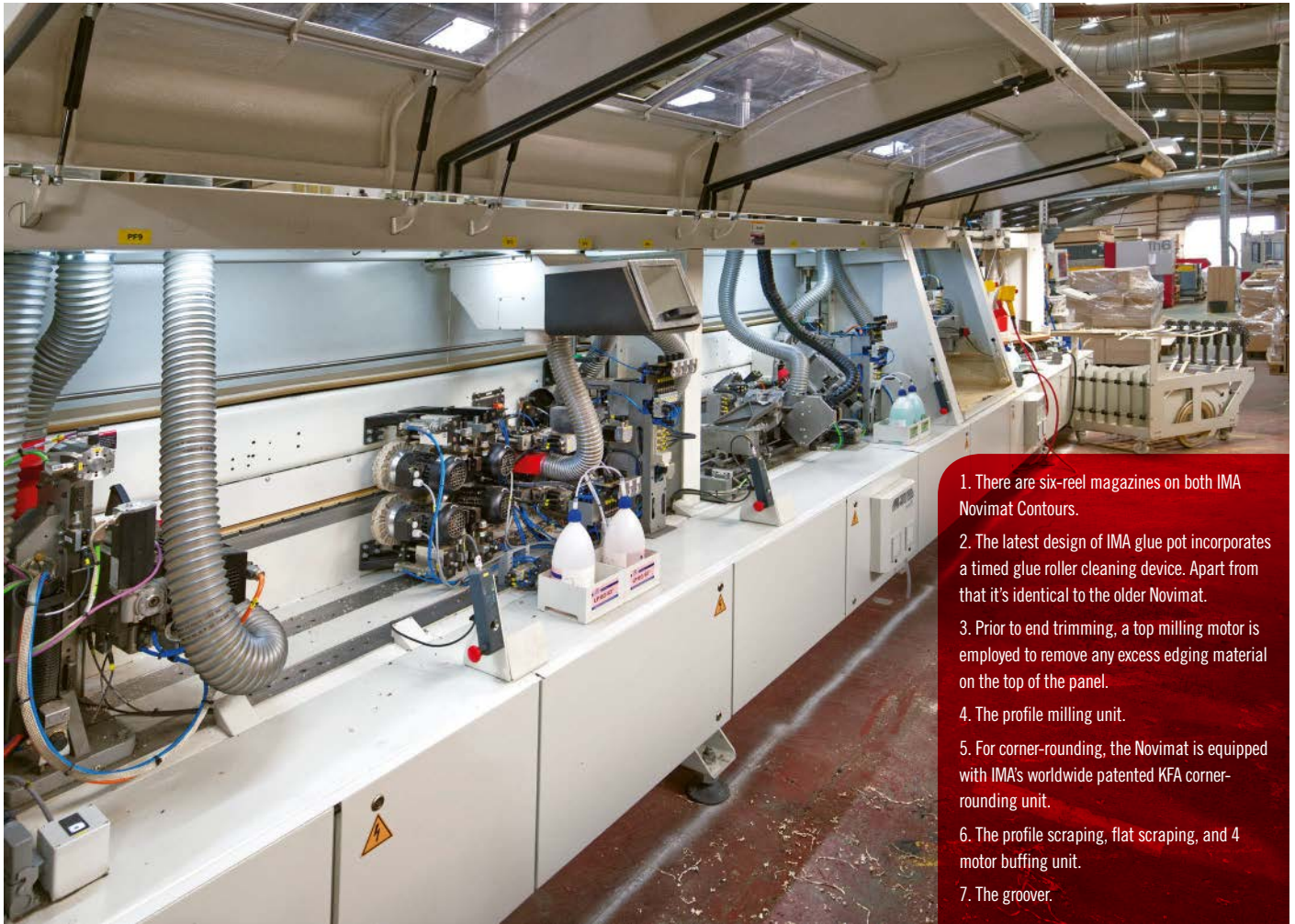
because we had only one edgebander in the factory that could do two or three mil edgebanding and that was the IMA,” admitted Jezz. “Many of the units we were making used 0.4mm or 0.8mm edgebanding but when 2mm started taking over it gave us a problem with bottlenecks that meant rescheduling production. Many clients are specifying 2mm now because it’s more robust and it can take a knock. The IMA is designed for 3mm, so it copes easily with the 2mm we wanted to put through it. You can do thick edging or thin edging with it but it has a six-reel magazine so it will apply all the different materials we use and change quickly when we need it to.”

The machine at ABI is fully automatic in operation and setting and all adjustments are carried out using NC axes from the operator position. This system is aided by a six-reel tape magazine with automatic lane follow-on, which is very useful when running large batches without interruption.

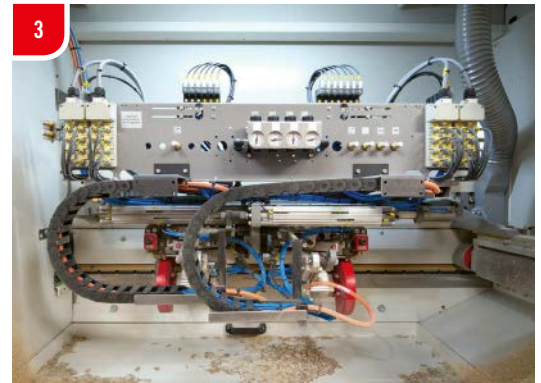
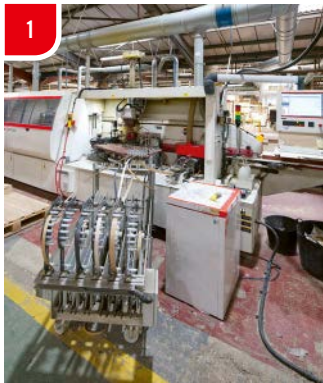
Jezz’s Novimat Contour is running at up to 25m/minute in the first pass and up to 20m/minute with full corner-rounding on all panel thicknesses. For corner-rounding, the Novimat is equipped with IMA’s worldwide patented KFA corner-rounding unit. It runs within its own CNC-generated path for minimum contact and damage to panels during processing.

When it was first developed, the KFA unit was designed to run at 50m/min but because it was so successful on the larger machines IMA decided to offer it on all its edgebanders. The KFA unit machines the vertical parts of the panel, then matches into the top and the bottom in the corners, moving in a CNC-controlled ellipse.

On the Novimat, the machining process begins with anti-stick solvent sprayed onto the top and bottom surfaces prior to edge pre-milling. Loose particles are blasted from the machined edge to allow for greater glue



1. There are six-reel magazines on both IMA Novimat Contours.
2. The latest design of IMA glue pot incorporates a timed glue roller cleaning device. Apart from that it's identical to the older Novimat.
3. Prior to end trimming, a top milling motor is employed to remove any excess edging material on the top of the panel.
4. The profile milling unit.
5. For corner-rounding, the Novimat is equipped with IMA's worldwide patented KFA corner-rounding unit.
6. The profile scraping, flat scraping, and 4 motor buffing unit.
7. The groover.



adhesion. Prior to glue application, the panel edge is heated by an infra-red radiator, which controls the open time of the glue in order to achieve the smallest possible glue line thickness whilst maintaining the strongest bond with PUR.

The latest design of IMA glue pot incorporates a timed glue roller cleaning device that ensures the glue roller is always providing clean, hot glue for an absolutely consistent glue line. To maintain the best possible coating weight, all fine adjustments of the glue pot are made from the operator side.

Anti-stick, anti-static and polishing fluids are automatically applied throughout the processes in order to create the ultimate edge finish. Anti-stick fluid is also applied to

the edging material, so if edgings with protective films are used, the film will not be detached from the edging material when side pressure is applied during pressure and tracing processes.

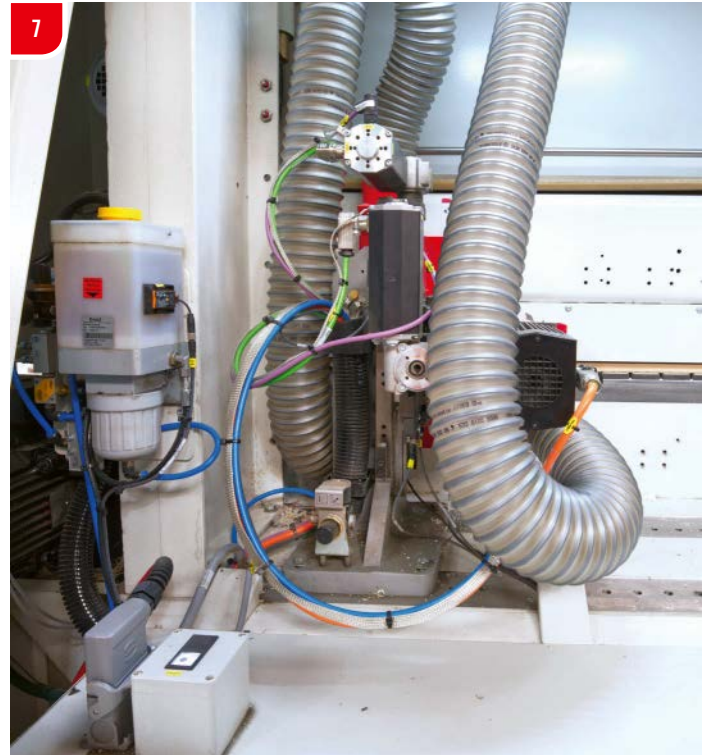
Prior to end trimming, a top milling motor is employed to remove any excess edging material on the top of the panel so the same height of edging can be used on different panel thickness, reducing the number of necessary changes.

Top and bottom profile milling of the edging material is carried out with up to four different profiles that can be changed by programme from the operator position in exactly the same way as the four positions of the profile scrapers. Flat

scraping is carried out by a twin-blade system that allows trimming of the surface protection film up to 10mm from the edge of the panel. This scrapes the edge down to the level of the surface material but leaves the rest of the film intact so it continues to protect the panel.

Edge profile finishing is with a powerful four-motor buffer consisting of different materials that remove any burrs or sharp edges and provide a fine polish for a perfect finish that needs no further finishing.

The machine at ABI is fitted with an optional grooving unit for under-grooving. The groover is equipped with horizontal and vertical NC axes controlled by the programme.



To say ABI is pleased with its new IMA Novimat Contour might be something of an understatement: "We run two shifts and we can get up to 4,000 metres through the Novimat," Jezz confirmed. "We're running at about 23m/min using PUR. The glue we use is a cream even though we're edging black with graphite but the glue line is so good you can't see it. It's an exceptional finish."

"The corner-rounding unit is a really nice piece of kit. If it's set up right, you can just see the joint but you can't feel it. When I get a bit stressed out I go and watch it. It's really clever. Both edgebanders have the same unit and the first one has run really well since we got it seven years ago. We get it serviced twice a year and the engineers always bring the parts

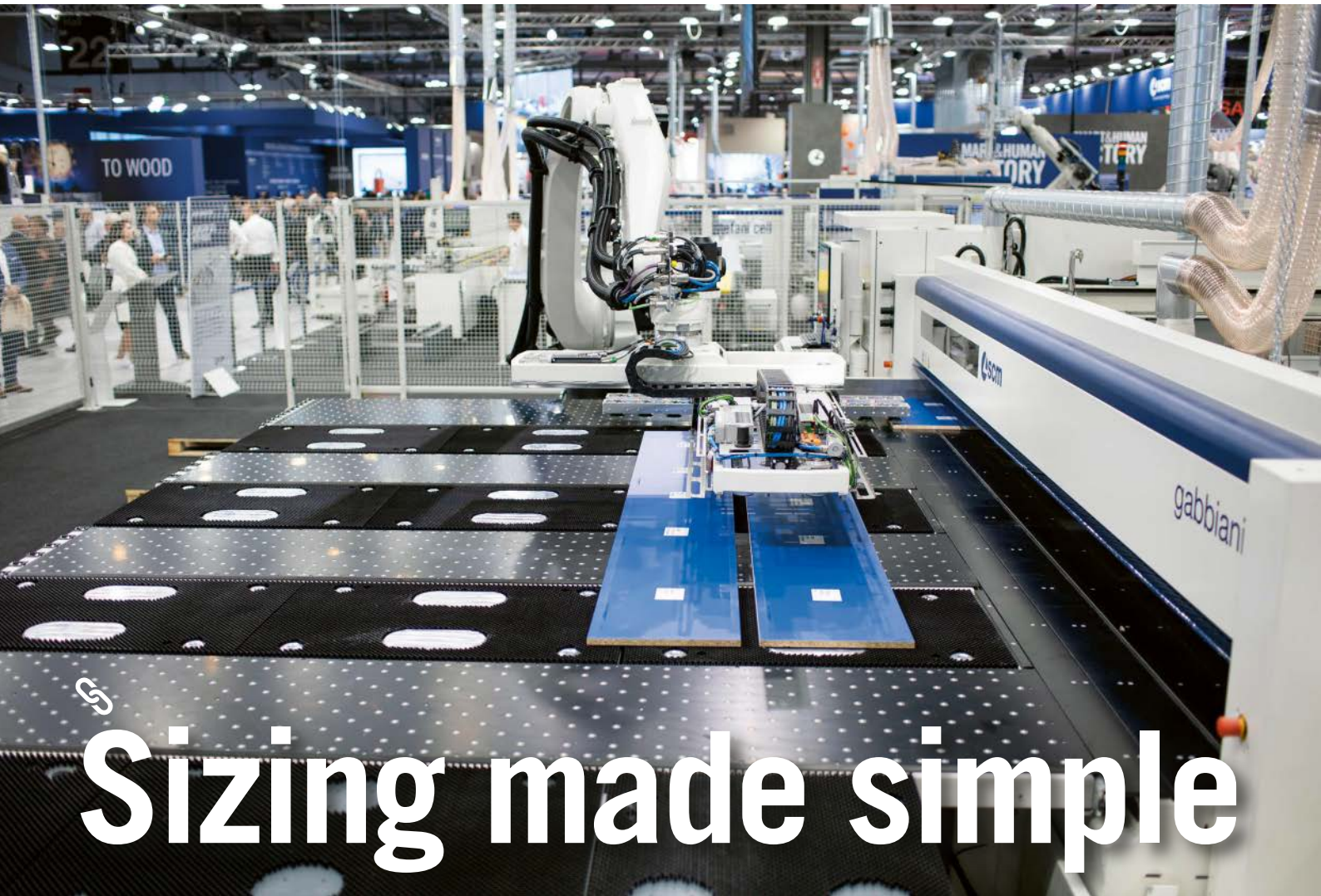
they know will need changing periodically. It's never let us down.

"The service we get from IMA-Schelling is really excellent. All the Schelling machines are on TeamViewer, so in the event of a problem an engineer can dial in and take over. The IMA machines are accessible through our network so IMA in Germany can connect.

"You can't put a value on the service you get from a company. It's critically important. I've been in this industry for a lot of years and some companies struggle to get to you in a week. When I've requested parts, sometimes I've waited three months. To give you an idea of the service we get from IMA-Schelling, I had a problem with one of the saws and they dialled into it and discovered it

was an inverter that had gone down. That was about 2pm in the afternoon. By 10 the next morning, I had the part and an engineer followed it. You can't get much better than that. Sometimes, we've had engineers down here within 90 minutes. It really is second to none and that gives a lot of reassurance and peace of mind. It's what you need in a business like this. But to be fair, everything about IMA and Schelling is superb – the machines, the service, the backup... You cannot get better."

For more information on Schelling saws and IMA edgebanders, call IMA-Schelling on 01937 586340 or visit www.imaschelling.com/en/ima-schelling-group/company/locations/uk



Sizing made simple

The Gabbiani GT2 solution from SCM: automatic and manual processing to revolutionise your sizing operations, provide absolute flexibility and boost your productivity.

In response to the ever-growing demand for machinery that will produce both in batch size one as well as in larger runs and retain absolute flexibility to switch rapidly between the two, SCM has developed a new sizing process that could revolutionise your production and boost your productivity just when you need it most. The new solution involves the use of a Gabbiani GT2 single-blade panel saw in combination with an anthropomorphic robot positioned on the floor at the front left of the machine. It is believed to be unique and the only integrated solution currently on the market that allows switching between automatic and manual processing with an operator in a matter of seconds.

The transition between automatic mode with robot and manual mode is both immediate and automatic with the robot placing or removing the additional modules between the in-feed tables that are necessary for its operation. In automatic mode with the robot, the cell operates without shift limits, relieving the operator from low-value activities. It will handle even small finished parts with the utmost ease,

providing a significant increase in productivity and quality. When manual operation with an operator is required, jobs like stack cutting become simple, ensuring the best possible productivity in manual as well as automatic mode.

The cell is configured with all the options required for a complete process: automatic labelling, a rotary table for pre-cut management, automatic ejection and management of off-cuts, automatic cleaning of the worktable, automatic scoring blade alignment and automatic anthropomorphic robot functionality for handling and palletisation of finished panels and off-cuts. The solution can also be integrated with horizontal warehouses like SCM's FlexStore ELR, enhancing productivity still further while freeing operators to perform other tasks.

For more information call SCM on 0115 977 0044, or visit www.scmgroup.com/en_GB/scmwood. Users of the free Furniture Journal app will be able to access a very informative video demonstration by touching the image above on their smartphone or table.

The robot places/removes the additional modules between the in-feed tables that are necessary for its operation.





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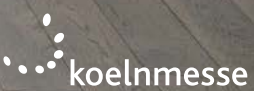
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Vesta Space goes compact

Vesta Space Ltd isn't your average wardrobe manufacturer. Over the last six years, Jon Meek and co-owner, Mark Davies have created a business model that sees them work extensively with housing developers, contractors, the trade and general public to provide an end to end service from tender to completion. Keen to build on its solid reputation and maintain growth, Jon has invested in a new Striebig Compact vertical panel saw and AL-KO Mobil Jet 160 dust extraction unit from TM Machinery.

"A vertical panel saw had always been on our radar," begins Jon, Director of Vesta Space Ltd. "When we set-up the business six years ago, we purchased a sliding table saw. This was mainly because of the up-front cost of the machine but we quickly realised that there was much more to buying a machine than its price tag."

Making the most of the company's 4,750sqft workshop was a huge factor behind the purchase of a Striebig vertical panel saw. "We follow a just-in-time production model, making sliding wardrobe

doors on a short lead time. This is a really efficient way of working but, with limited floor space available and our racking often reaching capacity, we needed to utilise every metre of space we had available to us. This meant investing in machines that allowed us to scale up without being restricted by space."

With a sliding table saw taking up a large section of their workshop, Jon knew a Striebig vertical panel saw could offer him a fantastic space-saving solution and he was right. Requiring just seven square metres of working space – a third of the space required by an equivalent sliding table saw – the Striebig Compact not only offered Vesta Space a significantly smaller footprint, it offered quicker production times and increased output.

"When we originally purchased our sliding table saw, we were making 30 doors a day. We are now on course to make hundreds a week. Trying to handle sheets of MFC on a sliding table saw was challenging and required a lot of working space around the machine. Cutting panels was also a two-

Vesta Space invests in a Striebig Compact with AL-KO Mobil Jet 160 dust extraction unit from TM Machinery.



Jon Meek



person job. Full size 8mm thick MFC sheets are not heavy but they are flexible, making them awkward to manoeuvre. On our old saw, the blade remained stationary so we had to manually position and feed the material through the blade. The pliability of the material made it difficult to hold in place, which ultimately had a knock-on effect on the accuracy of each cut and the time it took to machine.

"These problems simply don't exist with a Striebig," says Jon. Its moving saw head makes it a sleek one-person operation and its Swiss build quality and scoring blade guarantees a clean, precise cut within 0.1mm with no breakouts.

"The Striebig is not just for rough cuts," he says. "It has dramatically speeded up the cutting process of our wardrobe interiors and makes light work of shelf towers that require six identical shelves in one design. It's also a much cleaner job thanks to the AL-KO dust extraction unit. There is no dust whatsoever, which makes for a clean and healthy working environment."

It's also offered Vesta Space an opportunity to maximise production

efficiencies and future proof its manufacturing: "Our door frameworks have a certain throat size. Before we had the Striebig, we were routing down the edges on a spindle moulder so they would go into the frame. With the Striebig, we are buying a different style of frame with a different size of throat that accommodates our design without additional machining, slashing production time. This has allowed us to scale up and increase our current production by 25%, while still having the potential to increase our production capabilities by a further 30% in the next two years."

The machine's flexibility was also a selling point. Jon explains: "If our manufacturing requirements change, there are a number of retro-fittable options available to us, including additional mitre capabilities and optimisation software. This meant we didn't need to invest in extra cost options we were not sure we needed at the point of sale. Instead, we only opted for a 400mm strip-cutter for fuss-free repeat cuts and a scoring blade. Going forward, we can add certain things onto the machine instead of

upgrading it completely. We found this to be unique to Striebig."

It was this no-nonsense approach that made Jon want to buy from TM Machinery. "The sales process was straightforward," he says. "There wasn't any flounce or over-selling. They sold us a machine that was right for us, with a dust extraction unit that worked effectively with the saw. The team clearly had a great knowledge of the Striebig range and understood us as a business."

With the machine duo now being put to good use, there are new projects in the pipeline. "We have just secured a large contact in Birmingham that requires the design, manufacturer and install of over 800 sliding doors," he confirms. "Instead of glass fronts, the contractors want wooden panels. This will certainly up-scale the volume of panels we are processing but we know we are in a position to be able to deliver to a high standard and on time. Looking ahead, it's our goal to continue on this path and win more work. With the right machinery in place, we know this is achievable."

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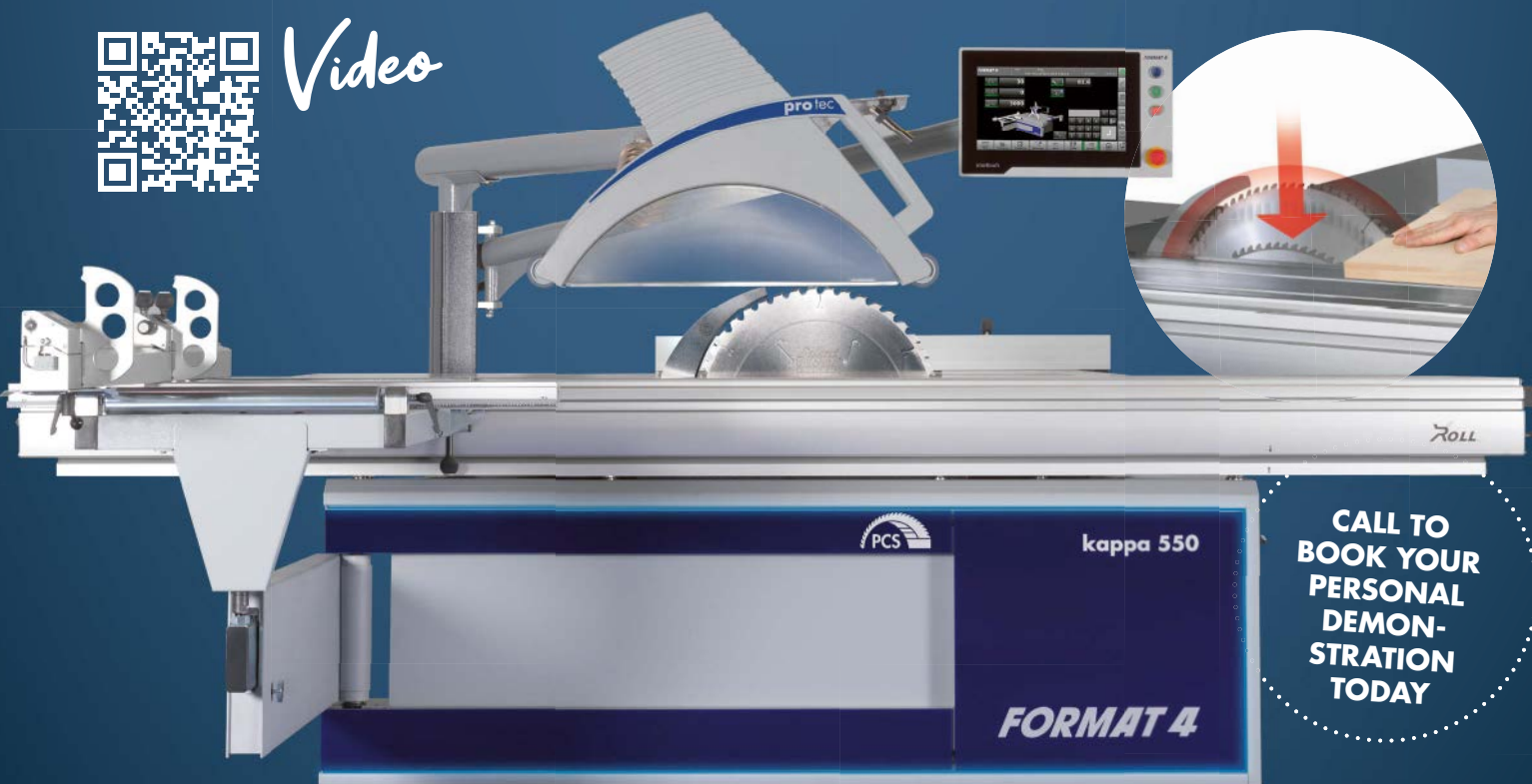
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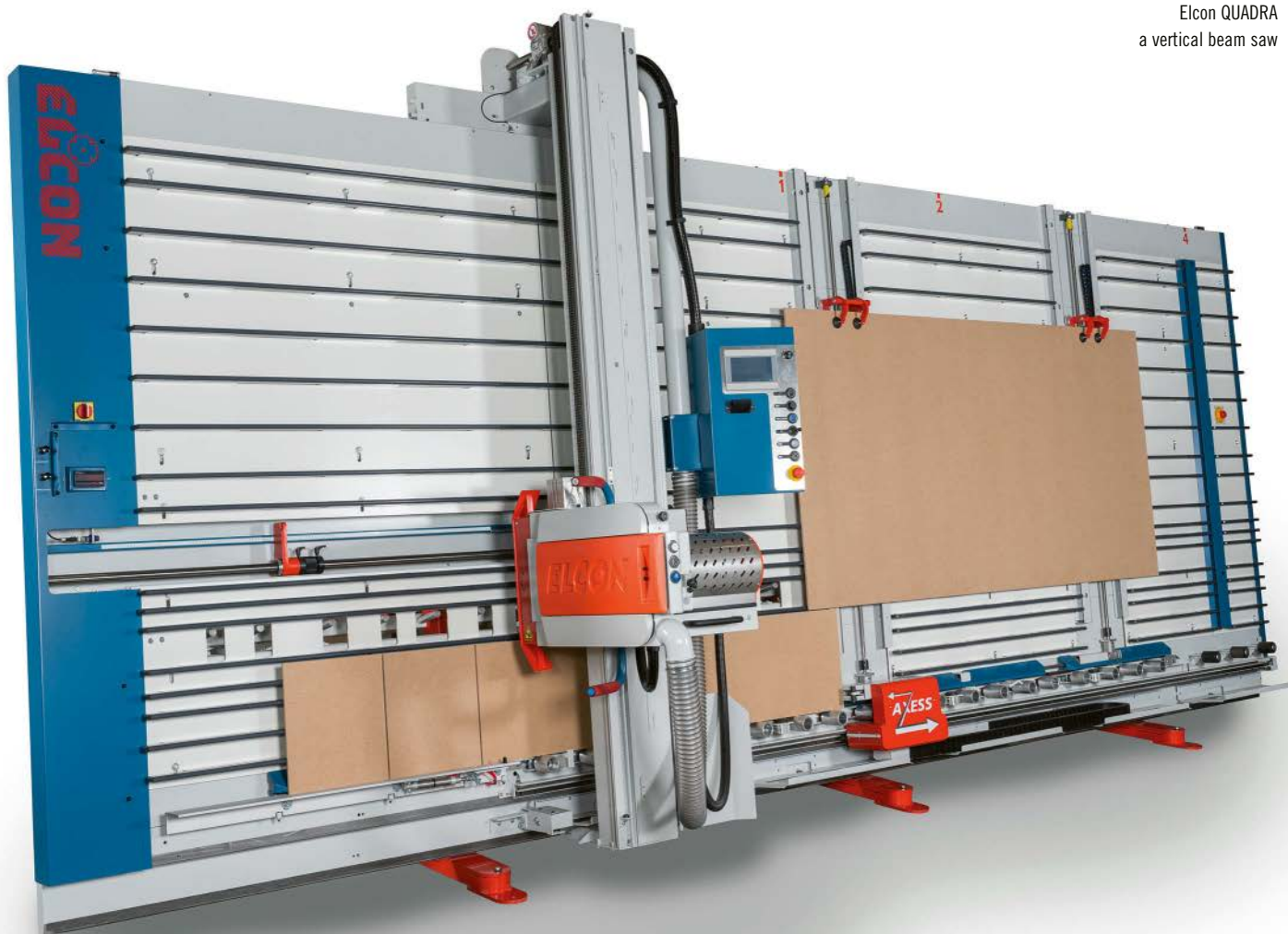
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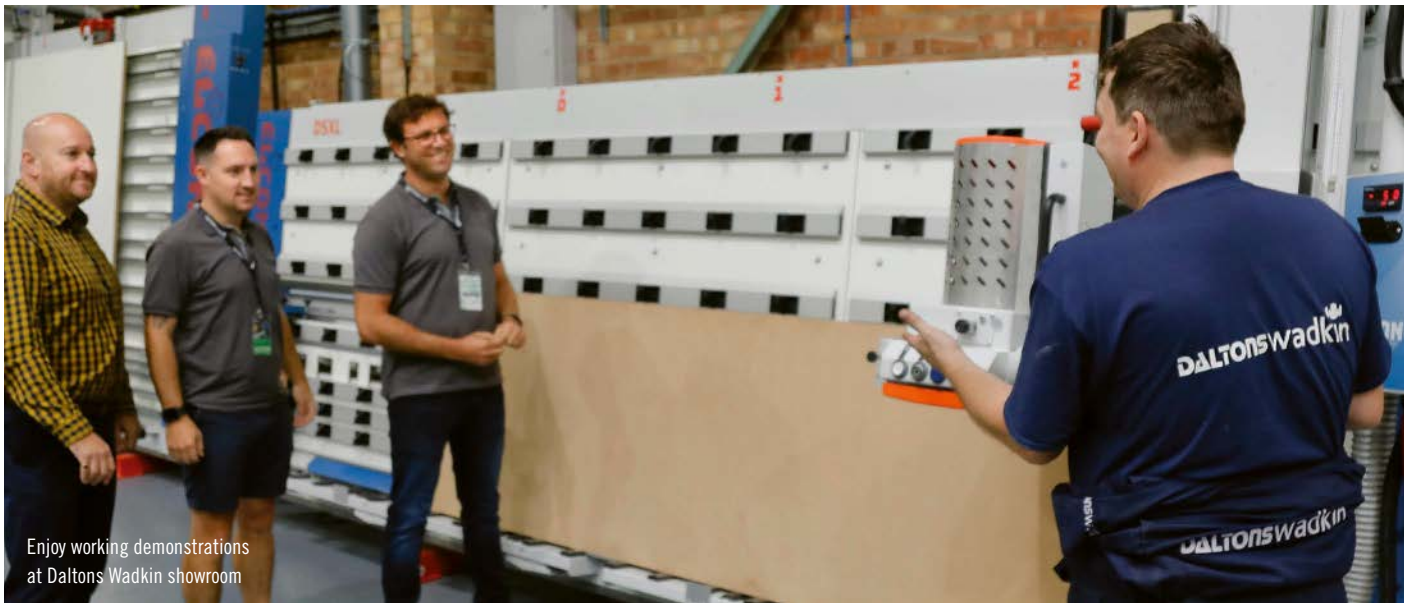
Go vertical with Daltons

Vertical panel saws are a lot more than space-saving. The Elcon Quadra with Advance clamping is almost a vertical beam saw.

Daltons Wadkin offers one of the most diverse ranges of sawing technology in the UK and Ireland. For over 120 years the family run business has specialised in supplying industrial woodworking machinery for processing solid wood, wood-based panels and composite material, always with a focus on quality and service. Band resaws, sliding table panel saws, dimension saws, vertical panel saws, circular saws and beam saws from Europe's leading manufacturers can all be found in the extensive Daltons Wadkin machinery portfolio.

"Our complete offering of all types of panel saws gives us a unique perspective in the market," explains Daltons Wadkin MD, Alex Dalton. "Most importantly, our customers can be sure of receiving unbiased advice when it comes to the best sawing solution for their needs. Each sawing method has its own advantages and disadvantages and we are always keen to discuss these in detail."

Vertical panel saws, or wall saws, are one of the most interesting and innovative of all the sawing methods. Vertical panel saws, such as those manufactured by Elcon, provide



Enjoy working demonstrations
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Precise, ergonomic controls
on the Elcon DSX sawing head



CNC pusher for panel
positioning on the
Elcon QUADRA

space-saving panel-sizing solutions that cater for all types, sizes and thicknesses of panels. With a cutting accuracy of 0.1 mm/mm, electronic digital scales, programmable setting and automatic cutting cycle, Elcon machines can be tailored to suit the most exacting production requirements.

One of the key advantages of an Elcon vertical panel saw is the optional Advance handling system. With vertical panel saws the panels are processed from the top down. First, strips are cut horizontally, removed from the machine and stacked. Once the required number of strips have been cut they are loaded back on the machine for vertically cross-cutting to the finished component size. The disadvantage with this method is that the operator must use his trailing hand (or wedges) to support the strip during the horizontal cut to stop it falling back onto the blade. This is not such a problem with smaller sheet sizes but when working with large panels the weight and height can be awkward for the operator to handle.

Elcon's Advance system turns the cutting process on its head: once the machine is loaded, two (or more) clamps descend and grab the panel(s) from above taking the full

weight and allowing the operator to work the material from the bottom up. Strip cuts sit on the base of the machine needing no additional support. Each strip can then be immediately cross-cut while the rest of the board remains in the clamps, eliminating the need for wedges and repeat panel handling.

For the ultimate in productivity, the Elcon Quadra model takes Advance clamping to the next level with the addition of a CNC controlled pusher system. The Quadra almost becomes a vertical beam saw with the CNC pusher positioning each cut strip for cross-cutting. The whole process is automated, only requiring the operator to start each process with a single button press. Multiple cutting lists can be programmed directly at the machine or remotely from an office PC and in conjunction with optional optimising software, components can be effectively nested prior to generating the cutting lists for maximum material yield.

Another important feature of Elcon saws is the patented and award-winning Limpio dust capture system. Greatly reducing dust emissions by simultaneously extracting waste from both the front and rear of the panel, the Limpio system keeps the saw blade running in

an almost completely enclosed area, reducing dust emission values to less than 0.5 mg/m³ – particularly advantageous when cutting large volumes of fibrous or cementitious material, as it minimises airborne waste entering the operating area.

Safety is a constant theme from Elcon. Vertical panel saws are generally considered one of the safest panel-sizing methods available when used by trained operators. Elcon goes further still and includes a series of electronic safety systems that monitor the machine's saw beam position and head tilt orientation. It will not start if it is not correctly set up with the beam locked/unlocked and the head positioned correctly for horizontal or vertical cutting.

Daltons Wadkin is the sole distributor for Elcon vertical panel saws in the UK and Ireland. The extensive Nottingham showroom gives you the opportunity for live demonstrations and the chance to compare Elcon vertical panel saws with more traditional sliding table panel saws from Altendorf and SCM. For more information or to arrange a visit, contact Daltons Wadkin on 0115 986 5201, email info@daltonswadkin.com or visit www.daltonswadkin.com



Cut out the waste!

Clever software makes optimisation of material and defecting a cinch when you have a Salvador.

The Salvador range of automatic crosscut saws includes optimising and defecting facilities as standard. But what does this actually mean?

A programmable Salvador runs on a Windows operating system with the usual keyboard and mouse interface. A large 19" screen is ergonomically mounted at eye level with a clear graphic representation of the machine's functions, cutting lists, material being processed, output data and more.

Cutting lists are fed into the machine manually at the machine, or remotely from an office Excel spreadsheet via network connection or USB stick. Once the Salvador has a cutting list, it's ready to go.

A high-performance NC system manages the material scanning, cutting parameters and finished work piece selection to maximise throughput efficiency. Any length of timber can be placed on the infeed table. The Salvador will then automatically scan to determine its exact length. It will then refer to the cutting list and choose the optimal combination of work pieces to cut that will minimise waste—all within a fraction of a

second. The operator continues to feed the machine until the cutting list is complete.

Multiple cutting lists can be processed at the same time with the Salvador optimising all lengths simultaneously. The impact on waste is dramatic, saving 15% or more. Offcuts can be automatically separated through a waste trap door leaving only finished components on the outfeed.

The defecting option works in a similar way but allows irregularities in the timber to be excluded from the finished workpieces. The operator chooses which sections of a timber length are to be considered waste, knots etc., and excludes them by marking each side of the defect with a fluorescent crayon. As the Salvador scans the timber length at the point of infeed, it recognises the fluorescent marks and optimises the cutting lists to avoid the defect. The Salvador SuperAngle 600 takes defecting to the next level, even optimising and nesting angles to further reduce waste.

For more information, contact Daltons Wadkin on 0115 986 5201, email info@daltonswadkin.com or visit www.daltonswadkin.com

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The teeth on LSB X sawblades are made in TiCo Carbide.

Flawless Freud

Freud's high performance LSB X blades are rapidly becoming the benchmark for panel sizing operations – and with good reason.

Precision, longevity, high performance and best value for money are the key words to describe Freud's top selling LSB X blades for panel sizing applications.

Freud, a worldwide leader in the cutting tool industry with more than 60 years of experience behind it, is one of the largest manufacturers of circular saw blades. Understandably, it pays great attention to the performance of its tools, starting with the use of the very finest raw materials.

Since 1980, the Italian brand has produced its own TiCo Carbide in house. Specially engineered and customised for the panel sizing applications, this unique mixture

of Titanium and Cobalt Carbide forms the basis of superior quality teeth and provides maximum cutting precision as well as extending blade life.

In addition, an innovative tooth design – the Freud Super Square Tooth – provides the finest cutting precision and extended durability. The opportunity to resharpen up to 25 times makes the LSB X a cost saving solution, which is why a growing number of furniture manufacturers and panel processors are choosing Freud LSB X to boost production, increase efficiency and maximise their investment.

Longevity is an important factor influencing purchasing decisions and in this respect, Freud's industry-first Silver I.C.E. Coating has a lot to offer. This superior protection technology improves chip ejection and, at the same time, maintains a low blade temperature, reducing pitch build-up and friction. The result is extended durability.

The renowned cutting precision of Freud's LSB X circular saw blades is the result of a unique 'Tri-Metal Brazing' technology – a process that bonds the carbide tips to the steel blade body. The use of a copper alloy sandwiched between layers of silver alloy increases flexibility and provides superior impact resistance.

LSB X blades also feature an anti-vibration solution that significantly reduces noise levels during cutting operations. Special body slots that have been laser cut and filled with thermoplastic polyurethane minimise vibrations, ensuring low noise and perfect finishing.

LSB X blades are available in diameters from 250mm to 720mm. The range is suitable for different materials, including wood, chipboard, MDF, HPL and Plexiglas and is compatible with all popular panel sizing machinery brands.

For more information check out their website www.freudtools.co.uk

Horses for courses

For a finer finish on MDF and significant savings when sawing, Kyocera-Unimerco has a solution or you.



EQS: designed to harden edges and smooth the surface of MDF boards.

Whatever the material you are working with you will need the right kind of saw blade to get best possible product quality. That means choosing the correct tooth type and cutting speed. To achieve the precision and surface quality you expect from a circular saw blade, the performance and stability is crucial. Using high-performance blades will increase the time between blade changes as well as providing better production flow. Kyocera-Unimerco stocks most standard sizes but will tailor a solution for a particular machine or production.

Cross-cut blades are designed to produce a smooth cut across the grain of the wood without splintering or tearing. The higher tooth count on Kyocera-Unimerco blades means each tooth removes less material. The result is a cleaner cut on edges and a smoother surface finish. With the right combination of material, blade, rpm and feed speed, the cut surface can even appear polished.

When MDF boards are milled, the fibres tend to swell. If you want the edge to have a surface of the same quality as the board,

expensive priming is required before you can topcoat the edge. Kyocera-Unimerco's EQS (for CNC and through-feed machines) has been designed to reduce high after-treatment and priming costs and has a unique edge-sealing and hardening system to save you time.

The EQS system is designed to close MDF edges and replicate the same surface quality as the top of the board. It also hardens the middle layer of the MDF edge, which not only makes the surface edge look and feel smoother, it increases hardness and strength, reducing the risk of edge cracking. Compared with conventional edge treatments, EQS will lower the cost and cut after-treatment significantly.

As an acknowledged expert in everything related to cutting tools, Kyocera-Unimerco understands the processes you use and the challenges you face. The experienced application team is on hand to assist you from Fradley, Staffordshire and will create the right tooling solution for optimising your production process.

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Tips from TAKA

Edgebanding is an important step in the production of most furniture components. To achieve durable and high-quality edge bonding, hotmelt PUR adhesives are recommended for their high resistance to extreme temperatures, water ingress and solvents. Where other hot-melt adhesives have a purely physical strength structure, PUR chemical cross-links with the water molecules in the air, creating an irreversible bond – but even with PUR, some manufacturers still struggle to get a good bond.

Research carried out by the Italian finished product testing laboratory CATAS showed that most of the problems relating to edgebanded products are application-related and the two main issues were expired open time and incorrect pressure.

Open time (the time between spreading the glue and application of pressure) is critical. If the glue becomes too cold before pressure is applied the results will be of poor quality with the risk of defects and significant increase of quality problems further down the line. If you see a knurled pattern in the glue after peeling off the edge,

it means either insufficient pressure was applied or the open time expired. If the temperature of the glue roller is uneven, this will also have an adverse effect on the open time.

Pressure problems usually manifest themselves in holes in the glue line. If you see small holes between the panel and the edge, the pressure (based on the thickness of the edge) most likely needs adjusting. For edges with <1mm width you will need around three bars of pressure, while edges with >1mm width will more probably need five bars.

Open time and pressure account for many of the problems encountered during edgebanding, so knowing the application parameters are as important as using a good adhesive. TAKA and WPR have created the WPR-TAKA Academy that offers specific training courses to help you achieve the best results.

For more information on TAKA's product range or the WPR-TAKA Academy training programmes, contact Anthony Rook from Brit-Ad Ltd on 07484 341294, or email arook.ba@gmail.com. Alternatively, visit www.britishadhesives.co.uk

If you are struggling to get a really good edge finish, the solution could be simpler than you think.

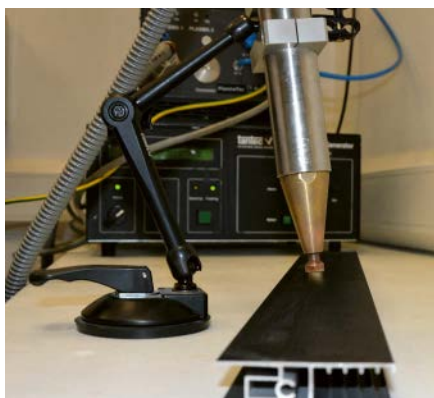
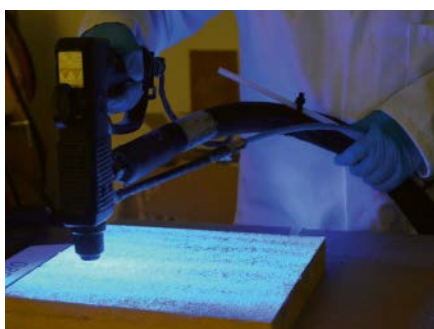


Insufficient pressure or the open time expired.



Bonding with Hybond

Bonds that don't break the bank and access to free process reviews are all part of the Hybond service.



Everyone wants to ensure optimum output is reached, despite ever-tightening budgets and without compromising on quality. Hybond, the adhesive specialist, has over 25 years of industry expertise and works hand in hand with manufacturers to ensure exceptionally high-quality adhesive bonds are consistently achieved without breaking the bank.

Hybond has a passion for meeting customers' bonding challenges and it achieves results through quality adhesive supply, detailed consultation and application trials. Goods are tested to industry standards within Hybond's dedicated laboratory and its Machine Systems Division provides a wide range of application machinery that enables you to benefit from an initial free-of-charge process review, followed by ongoing audits aimed to reduce machine down-time and the associated costs.

Company Director Ross Dalrymple explains the value of Hybond's comprehensive approach to adhesive bonding, which often starts with the popular Process Review Service: "When we visit a customer's site and they have an edgebanding installation, for example, we will carry out a series of checks such as applying reversed

edging to a panel, which we will then deconstruct to examine the bond line. Such examinations can show if the adhesive coating weight is too high or low, maybe the guide plate setting is incorrect with the roller touching the panel, or it's too far away. There are many factors that the experienced eyes of our technical team can identify and correct to optimise output and lower costs."

For those who carry out 3D pressing, Hybond has invested heavily in training, equipment and laboratory test protocols to become an industry-leading, technically competent distributor of 3D pressing adhesives. Their 3D pressing audit includes the use of an intelligent 'dummy' panel along with specialist software, which analyses critical points of the pressing process in real time as they occur within a pressing system. The data gathered, along with decades of technical experience, is used to eliminate potential quality issues such as bubbling, tearing, and delamination.

Hybond supplies adhesive products under its own 'Xtra' branding and distribute for world-recognised corporate suppliers. Explore their products and services at www.hybond.org.uk or contact Hybond on 0800 542 3491.



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Keeping warm

Browns 2000's new Mawera boiler is commissioned after years of reliable service from the Mawera it took delivery of in 2000.

When Cramlington-based Browns 2000 decided to replace the Mawera boiler that had served the company tirelessly for almost 23 years, there was only one option to be considered: *which Mawera?*

"We dealt with Mawera when we first came to this building in 2000, the year we went limited," Graeme Brown recalled. "My father, Peter, has worked with Mawera's John Clissett for more than 20 years and they've always had a good relationship. Because the Mawera product is so good, we didn't really need to change it – it was still working really well – but we wanted to make some changes in the factory so we decided to invest in a new boiler at the same time. There wasn't

really any competition for Mawera because we had such a good experience with our last boiler.

"The factory is around 275,000 square feet. We are producing around 25,000 doors and components every week made up from our vinyl wrapped door range – we have over 750 combinations – and our Glacier edgebanded product. We are doing all the lamination, the cutting and edging in the factory and we're using laser edgebanding technology to give us the best results. Around 50% of what we produce is kitchens, 40% is bedrooms and the rest is bathrooms and home offices. We work with retailers but we also deal with a lot of cabinet manufacturers who mass produce carcasses



Graeme Brown

in Cramlington

and buy in doors. Within reason we can make whatever size and shape they want. Our standard-sized products are manufactured alongside non-standard sizes so we make the most of our nesting capability and keep waste to a minimum.

"Most of our waste material is MDF with some MFC. We buy in raw board and laminate in house. The product we use for vinyl door production comes in with a paper on the reverse, the sheets are nested and the waste material that's left in the skeleton provides fuel for the Mawera. It heats the whole of the factory and the offices. The factory has extended since we put the original boiler in, so one thing we wanted from a new boiler was extra capacity so we

could install more heaters to make it a more comfortable environment and help the machines function better. Especially with some of the extreme winters we've had, it makes for a better environment for production and gluing operations also benefit from the warmth."

To cope with the requirements at Browns 2000, John Clissett recommended a fully automatic Mawera Pyroflex 2100kW VFE with a concrete construction Wolf silo providing 200 cubic metres of storage and an electrostatic filter for dust collection. The installation of boiler pumps and pipework was carried out by John's team at Mawera UK but the scope of works included far more. The old boiler had to be kept running

while a new boiler house was built alongside it to house the VFE when it arrived.

"The old boiler was still working while the installation was taking place," Graeme confirmed. "The preparation was going on throughout most of last year. They had to dig up the back yard and reinforce the ground to allow for all the equipment. John oversaw everything, even the architect we needed for the new building. It was big installation involving a lot of different parties but the whole thing went really smoothly. We now have a state-of-the-art boiler and everything is controlled and monitored via an app, which gives us real peace of mind. We operate Monday to Friday so with the app our guys can check the boiler remotely



over the weekend. If there ever was a problem it wouldn't have to wait to Monday to be dealt with."

The Mawera Pyroflex VFE that was commissioned at Browns 2000 in January 2023 has been specially developed for industrial wood processing, so MDF and chipboard residues never impact on the firing. It's equipped with a low Nitrous Oxide combustion chamber and features like air-staging on the primary side to reduce NO_x emissions. Secondary air is fed in after the reduction zone of the combustion chamber and because of the design of the chamber, the VFE provides optimal oxidation of all combustion gases. There is very little ash in the combustion chamber but what little forms is removed either manually or automatically using a water-cooled auger.

For peace of mind, if the power requirement of the system ever fell below

the minimum power required, the system would switch off automatically and go into stand-by mode. If the flow temperature fell below the target value and there was renewed demand for output, the system would be restarted automatically. And if firing was ever halted for a long period, the automatic pilot burner would move into the combustion chamber, heating it to the temperature required for the fuel supply. Needless to say, the Pyroflex VFE is fully compliant with all current emissions legislation and modulates load regulation from 55-100% in compliance with emission values.

The new Mawera is about as green as a boiler could be, so it fits perfectly with the ethos at Browns 2000. "We've always tried to be as green as possible," Graeme told me. "Given the choice, we'd always go down that route. When we installed the lighting, we opted for the most efficient; we run electric

vehicles; we have an electric van. It's always our goal to be as environmentally responsible as we can be and we are confident the Mawera has added to that."

As for the service Browns 2000 has received from John and his team at Mawera UK, Graeme can't speak highly enough: "John is one of the industry's nice guys. He doesn't try and sell you something you don't need. He's always got your interests at heart and there's never any pressure or urgency to sell you something. John always knew that when the time came to replace our old boiler it would be him we would turn to. We never looked at anybody else's boilers. Mawera has such a good name, John has such a good name, the service he gives is first class... Why would we look elsewhere?"

If the time is approaching when you need to replace your boiler, call John at Mawera UK on 01543 258844 or visit www.mawera.co.uk for more information.



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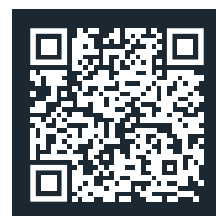
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The new CSC SYS 50 cordless table saw is so compact that it fits into a Systainer. It's just as versatile in use, as it is tremendously convenient in its size. The unique digital operation produces results with maximum precision, down to accuracies within a tenth of a millimetre. The 18-volt dual battery system in combination with the brushless EC-TEC motor will impress you.

Discover our new products:
www.festool.co.uk/products/new-products



SCAN ME



Quick and cordless

The new RSC 18 cordless reciprocating saw joins the growing line-up of Festool battery-powered hand tools.

If you are in the market for a cordless saw that has the flexibility and the power to work on site wherever you are, the new RSC 18 from Festool could be just the tool for you.

The powerful, brushless EC-TEC motor provides the power, while the switch-activated, easily-adjusted, two-level pendulum stroke (0–3 millimetres) ensures rapid progress when cutting soft and medium-hard materials due to higher cutting speeds. Thin or hard materials can be processed without an activated pendulum stroke, resulting in fewer splinters from the material.

The new RSC 18 cordless reciprocating saw is packed with clever details and provides good cutting performance, even when cutting composite materials. It is easy

to regulate and the anti-vibration gearbox provides a 40 per cent reduction in vibrations but faster working progress, as less energy is lost. The special chuck makes saw blade ejection quick and easy without any risk of burning yourself. In addition, the clamped saw blade can be rotated by 180 degrees, so the teeth are facing upwards. This option allows cuts to be made in certain positions up to the wall, ceiling or floor.

As working with reciprocating saws usually creates a large amount of dust, Festool has developed a clever solution for the RSC 18 that allows a dust extraction device to be connected to an extractor. The hose sits securely on the system sleeve and is protected from unintended slipping. The extractor can also be turned on and off





automatically with Bluetooth® via the Bluetooth® battery.

Another comfort feature is the integrated LED light, which illuminates the working area perfectly – very handy when working inside cabinets or in dark corners. As the saw table can be set to engage at several levels, variable plunge depths are also possible.

“Battery technology and battery-powered devices are a significant trend on the tools market,” said Sascha Menges, CEO

of Festool GmbH. “We have tailored our strategy to reflect this and are continuously expanding our portfolio. We are not just blindly pursuing a strategy of using battery technology for the sake of it. We want to take a more purposeful approach to ascertain how battery technology might best serve the application in question. We want to optimise the results so the products are perfect for their applications and we want to make work easier, safer and better for tradespeople.”

This commitment is confirmed by the new additions to the Festool 18 Volt System – additions like the new CSC SYS 50 cordless bench-mounted circular saw, the TSC 55 KEB plunge-cut saw, the Quadrive TPC 18 cordless impact screwdriver and the ExoActive exoskeleton that will be appearing in the course of 2023.

The new RSC 18 cordless reciprocating saw will be available at authorised dealers from May 2023. More information can be found at www.festool.co.uk

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🕒 15 - 19 May 2023

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