

## Planing

Kallfass delivers planing machine feeders, as well as complete planing machine mechanizations. The planing machine feeders are built with electric drives.

Feed speeds range from 20-300 m/min and mechanisms with feeds to a max. of 500 m/min have been realized.



Possible timber lengths are approximately 600 - 16,000 mm. There are virtually no limits to the possibilities of the mechanization. Usually the closely formed packets are supplied to the planing machine feeder via tilting destackers and transverse chain conveyors. Planing machines can also be fed via vacuum technology or push-off technology. Also use of various scanner systems, for measuring moisture, cupping, quality, and for testing strength, as well as attaching barcodes, is possible.

Kallfass also offers the possibility of bringing strips and boards to the desired length before or after

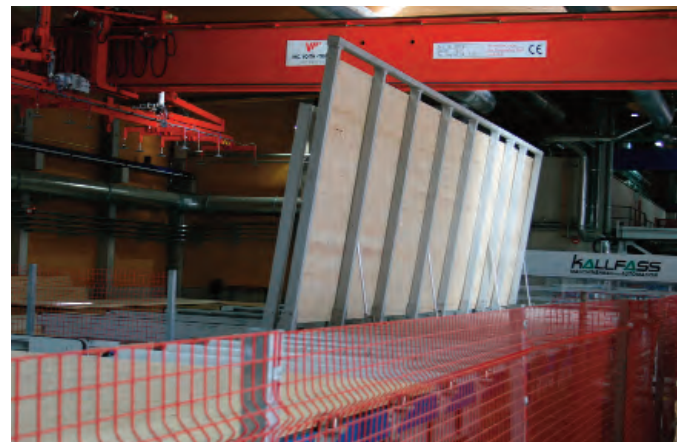
planing, with the aid of the multiple crosscut saw. The strip bundling system developed by Kallfass (patented) can be placed downstream from a planing machine and thus enables clean bundling and subsequent stacking of split boards and strips.

## Gluing

### Mechanization of your project

Kallfass GmbH offers individual components, as well as complete mechanisms for production of glued-laminated timber, solid structural timber, duo/trio beams, and single-layer or multi-layer panels.

For our customers, independence is an important element in the collaboration. Consequently we offer custom-tailored solutions regardless of the manufacturer of your finger jointing system, planing machine, or gluing station.



Talk to us. We look forward to hearing from you.

### Main Plant:

Röterstrasse 44  
72270 Klosterreichenbach  
Germany  
Fon: +49 74 42 / 84 46 - 0  
Fax: +49 74 42 / 84 46 - 50  
e-Mail: [info@kallfass-online.com](mailto:info@kallfass-online.com)

### Subsidiary plant:

Otto-von-Guericke-Strasse 4  
38855 Wernigerode  
Germany  
Fon: +49 39 43 / 5 59 31 - 0  
Fax: +49 39 43 / 5 59 31 - 23  
e-Mail: [info@kallfass-online.com](mailto:info@kallfass-online.com)

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## Machinery and installations for sawn timber



- Sorting
- Cutting
- Stacking
- Planing
- Gluing



## Sorting

### Sorters in different versions

Sorting machines are used for sorting sawn timber. Production can be rationalized, value creation and flexibility in manufacturing can be significantly increased through the use of sorting machines. They are the connecting link between the saw line and the packetizing system.



Depending on the requirement and timber dimensions, capacity is 50-160 parts/min. Spatial requirements depend on the length of the timber and the number of boxes. The standard timber length is 2-6 meters.

For evaluation and increasing the value of the wood, different devices, such as scanners/trimmers, evaluation conveyors, with and without turners, as well as moisture test, quality test, and strength test units, can be installed.

There are two main versions of transverse sorting!

**Box sorting:** Boxing sorting machines are the most popular devices for sorting sawn timber by dimensions and quality; the number of sorting boxes is determined based on the variety.

**Tray sorting:** Tray sorting is used to better protect the wood; the level of protection can be further increased in the arrangement as film layer, particularly for planed goods. However this arrangement is extremely space-intensive.

## Cutting

### Multiple-Crosscut-Saw

As the market leader in the area of multiple crosscut saws, with our machines we achieve a high degree of length accuracy at maximum capacity with manual or automatic positioning of the saw aggregates.

Prismatic, panel-shaped, or round workpieces are cut to length with millimetric precision in single-piece or layered processing.

The number of saw aggregates can be freely selected to meet customer requirements:

For part widths to 100 mm the multiple crosscut saw reaches a capacity of up to 200 workpieces/min!



The optional CNC controller enables automatic changeover of the machine in running production. The changeover time (with 6 saw aggregates) is approx. 20 seconds!

Special equipment includes swing-away saw blades, chain top-pressure units, as well as frontal milling aggregates. Machining of unedged goods is also possible in a special design.

## Cutting

### Trimmer saw

As a rule the trimmer saw is located upstream of a sorting machine. It is used for cutting workpieces to preset raster lengths and for notching out defective areas or waney edges, which have been previously specified by an operator or a waney-edge scanner.



The trimmer saw is available in two configuration levels, the pneumatic version of the saw linkage enables a cycle count up to 80 pc./min.

The version of the saw linkage with servo drives enables a capacity of up to 170 pc./min depending on the dimensions.

Each saw unit is equipped with its own drive and can be moved on ball guides for length adjustment and service purposes. Thus changeover times and maintenance times are reduced. Due to its solid construction the trimmer saw is unusually quiet in operation.

## Destacking and stacking

Kalfass can draw upon more than 40 years of experience in building stacking machines. It is possible to stack in single lengths or multiple lengths for shipping or for drying. Dried goods can be made ready for shipment via a restacking system, in which a sorting function can also be integrated. For dried goods, the use of cardboard strips instead of wood strips is an advantageous solution for stabilizing the shipping stacks.

When using a multiple crosscut saw, several fixed length stacks are formed next to each other directly downstream from the machine.

Naturally long parts in special design, up to 16 m in length, can be stacked up in this machine, with and without notching.

The maximum capacity is 18 layers/min. The stacking process can be fully mechanized and thus can be integrated in different production lines. The stacking machine is characterized by a high production rate, as well as minimal changeover time.

