



	<b>Article</b>	<b>Quant.</b>
1.1	<b>KOCH Drilling and Dowel Insertion Machine Model BD-A Double Cycle</b>	<b>1</b>

Double end automatic operation, for straight, right-angled workpieces

**Stock dimensions**

Stock length	250 - 1500 mm
Stock width	38 - 250 mm
Stock thickness	16 - 30 mm (adjusted to 19 mm)

The specified dimensions do not allow all possible combinations.

Material: chip board/MDF

The stationary machine side is on the left side (seen in transport direction) and not adjustable.

Infeed and outfeed height: 920 mm / see floorplan.

The workpieces are transported through the working stations by means of a cam transport system.

Stock is worked in clamped position.

**Machine base equipment**

- with hopper feed
- with horizontal drilling station incl. extractor hoods
- with lateral blow-out jets to clean dowel holes
- with linear path control for stock transport
- with low profile machine bed and linear guides, fixed stock stops, adjustable working stations
- with motorized width adjustment
- with SPS control Beckhoff
- max. stock length 1500 mm (59')
- **with security fence**
- **without noise protection**



<b>Article</b>	<b>Quant.</b>
1.2 <b>Hopper feed with separation</b> The number of pieces in the hopper depends on the weight of the workpiece. Max. height of pile 250 mm.	<b>1</b>
1.3 <b>BD Double cycle</b> <ul style="list-style-type: none"> <li>• enlarged machine mounting</li> <li>• each side 2 horizontal drilling stations</li> <li>• spring-mounted dogs for stock transport</li> <li>• max. stock width: 300 mm</li> <li>• capacity: up to 48 workpieces/min.</li> </ul>	<b>1</b>
1.4 <b>Central lubrication for working units</b> hand pump for grease lubrication	<b>1</b>
1.5 <b>Positioning of adjustable machine side (X)</b> 1 NC-axis	<b>1</b>
1.6 <b>Station 1</b>	<b>1</b>
1.7 <b>Horizontal drilling station</b> each side 1 drilling unit with 1 drilling motor 2 kW drill speed 3400 (60 Hz) RPM	<b>1</b>
1.8 <b>Drilling head with rotating device</b> <b>Type D-1277</b> with 3 drilling spindles Drill bit mounting: 10 mm Centers: 16 mm	<b>4</b>
1.9 <b>Total length of drill bit</b> 70 mm	<b>1</b>
1.10 <b>Center stock support</b>	<b>1</b>
1.11 <b>Station 2</b>	<b>1</b>
1.12 <b>Vertical drilling</b> <b>support at the right side in the drilling station</b> for drilling from above at the edge, with (acc. to drilling pattern) mm adjustment in X-direction and adjustment in feed direction (Y)  1 drilling motor 2 kW with extractor hood	<b>2</b>



	<b>Article</b>	<b>Quant.</b>
1.13	<b>Second adjustable drilling motor for each vertical boring unit</b> with extractor hood	<b>2</b>
1.14	<b>Drilling head with rotating device</b> <b>Type D-1277</b> with 1 drilling spindle Drill bit mounting: Quick change chuck mm	<b>4</b>
1.15	<b>Exhausting hood for vertical drilling unit</b> Removable for drillings at the right and left stock edge.	<b>4</b>
1.16	<b>Lateral stock alignment</b>	<b>2</b>
1.17	<b>Static frequency converter</b> motor speed continuously adjustable from 3.000-6.000 RPM	<b>2</b>
1.18	<b>Collecting hopper at the machine outfeed</b>	<b>1</b>
1.19	<b>SPS-control</b> extra price for control cabinet type USA	<b>1</b>
1.20	<b>Price reduction for machine equipment without dowel insertion station</b> (but empty station with stops)	<b>1</b>
1.21	<b>Prices do not include any tools</b>	<b>1</b>
1.22	<b>CSA conformity</b>	<b>1</b>
1.23	<b>Capacity</b> up to 48 workpieces/min.	<b>1</b>
1.24	<b>Operation manual English/French</b> <b>Machine inscription: French</b>	<b>1</b>



<b>Article</b>		<b>Quant.</b>
1.25	<b>Electric supply</b>	<b>1</b>
	Electric connection	480 V, 60 cps, 3 phases
	Voltage fluctuations	max. + 6 % to - 10 %
	If the fuse protection by F1 protective switch is effected by the customer, an A.C.-D.C. sensitive (R CCB, type B) F1 protective switch with rated residual current $\geq 300$ mA has to be used.	
	Pneumatic connection	7 bar
	Air speed of dust extraction	min. 30 m/sec.
	The dust extraction diameters are given in the floor plan. The indicated values have to be re-confirmed by Koch before the extraction device is installed by the customer.	
	Ambient temperature at the place of installation	min. 10° C ( 50° F) max. 40° C (100° F)
1.26	<b>Lacquer</b>	<b>1</b>
	machine	RAL 9002 grey-white
	protective hoods	RAL 3001 red
	control cabinet	RAL 7035 grey
	security fence, gratings	RAL 9005 black
	security fence, stays	RAL 3001 red

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