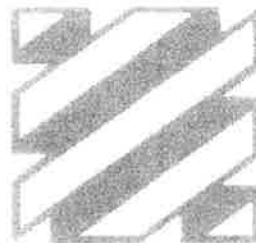




Akron 855

Serial # 68162

PROPOSAL
#9623-06
December 11, 2006
FOR:



Contour Countertops

Chuck Maiwurn
24602 Pacific Hwy South
Kent, WA 98089
Phone: (253) 681-6403
Fax: (253) 572-4625

Distributor
T&G Machinery LLC
Gene Rousseau
Tel. 425-396-5939
Mobile 206-730-0029
tngrousseau@yahoo.com

**Biesse Product
Area Manager**
Dan Radusinovich
Ph. 704-357-3131
Fax 704-357-3130
Mobile 206-595-4649
Dan.radusinovich@biesseamerica.com

V.P. Sales/ Marketing
Craig Sexton
Tel. 704-357-3131
Fax 704-357-3130
Mobile 704-299-6829
Craig.sexton@biesseamerica.com

**Polymac Product
Area Manager**
Ed Moran
Ph. 704-357-3131
Fax 704-357-3130
Mobile 704-968-9045
Ed.moran@biesseamerica.com

President / CEO
Federico Broccoli
Ph. 704-357-3131
Fax: 704-357-3130
Mobile 704-968-1954
Federico.broccoli@biesseamerica.com

Akron 855 Edgebander



E9001100 AKRON 800

Automatic, single sided industrial edgebanding machine for the application and processing of flat edgebanding material in rolls (melamine, PVC, ABS, veneer) and in strips (solid wood, Formica, planed veneers etc.).

STANDARD features:

NC control and command system

The NC mod. **NC 407** is used to write and run programs (max. 320) that automatically carry out the machining operations foreseen; the functions include:

- Automatic start-up of the units and motors foreseen by the program.
- Button for direct selection of 2nd run without needing to access the menu.
- **Max 6 NC AXIS**
- Lists of programs with manual and/or automatic start-up.
- Error diagnostics with codes and comments.
- Keyboard with 67 keys, of which 24 for direct call-up of the working units and 6 function keys.
- 1.44 Mb Floppy-disk drive.
- 6» graphic colour display.
- Production statistics and tool wear.
- Programming in 5 languages resident in the NC.
- Units of measurement in millimetres or in inches.

The device is installed on an adjustable overhead control panel.

Structural components

- **Base:** provides the whole machine with stability and strength to allow precise, accurate machining even under intensive use. The base is made entirely of steel with a closed structure, and it uses a hollow «T» fixing system for the working units in order to optimise the positioning of the working units according to the customer's requirements.

Maximum cleaning of the machine is possible thanks to the integrated automatic chip removal system along the whole machine.

Panel movement: provided by a conveyor **track** and **top presser** combining a system that ensures optimum clamping of the panel being processed, straight movement and resistance to side loads resulting from pressure when applying the edges.

The conveyor **Track** uses an industrial chain with a 31.75 mm (1 ¼») ratio, with special self-lubricating nylon-graphite slide blocks. The slide blocks slide on two hardened steel guides, one with a circular

Buyer Initials: 

Akron 855
#68162

section and the other flat, complete with greasing nipples. The panel being edged is held by special low wear rubber pads with a high friction coefficient, which are individually interchangeable (dimensions 80x60 mm). The track can also advance when the gluing unit is turned off.

The **Top presser** is made of extruded aluminium with a special profile; the panel being edged is held in position by a double row of staggered wheels mounted on bearings. The top working units are hooked to the top presser and adjust automatically with the positioning of the presser itself moves. The top presser slides on linear guides when adjusted; the vertical adjustment is manual by means of a centralised system.

Large dimension **Infeed fence** to facilitate proper infeed of the panel to be edged (the machines fitted with the pre-milling unit have a manually adjustable fence or, as an option, an automatically adjustable guide). Complete with light to set the most efficient panels infeed pace.

Side panel support with extruded aluminium guide including support wheels. Quick manual positioning and locking system.

- **Gluing, edge feeding and pressing unit VC-710:** Applies the hot melt glue on the panel, feeds the edge to be applied to the panel being machined, automatically cuts the rolls of edge-banding material to length and presses the applied edge ensuring that it adheres perfectly to the panel.

The unit includes:

- **Glue container and glue spreading roller. The spreading roller is complete with a copying system to apply the correct amount of glue to the panel.**
TEKNO-GLUE System: for perfect gluing in under any condition it includes: - controlled training movement of the glue spreading roller; - automatic glue container exclusion when the track stops; - pneumatic exclusion of the glue container. No adjustment required when the panel thickness changes. Quick heating and double thermostat for differentiated temperature control. The glue container is completely coated with non-adhesive material. Electronic device for automatic temperature reduction of the glue container when the machine has been idle for a set period of time. Glue spreader which can turn with or against the direction of the panel. Quick change of the glue container for an easy maintenance or changing colour/type of glue.
- **Automatic Edge feeding system** for edges in rolls or strips, complete with: roll holder disk diameter 900 mm. The edge-banding strip is fed «meeting» the panel as it advances, avoiding any slipping of the edging material. The edge magazine table features a cooling system. The edge magazine table has a manual vertical adjustment.
- **Cutter knife for the automatic cutting of edge-banding material in rolls with a maximum thickness of 3mm and with a maximum section of 140mm².** Automatic adjustment of working pressure according to the thickness of edge-banding material being used. Placed before of the 1st edge pressing roller.
- **Edge pressing system** consisting of:
 - a first large diameter motorised roller (with clutch) coated with non-adhesive material with independent pneumatic pressure adjustment.
 - 5 idle rollers, diameter 60 mm, coated with non- adhesive material with pneumatic adjustment; the first 2 are opposing cones (on request the rollers can be 4 but with diameter 80 mm).

The machine is complete with Protective Cabins coated with sound absorbing material.

TECHNICAL CHARACTERISTICS

Panel height
Panel height with corner rounding unit
Height of edge-banding material
Thickness of edge-banding material in rolls

AKRON 800

: from 10 to 60 mm
: 10 to 35/60 mm (depending on profiles)
: from 14 to 64 mm
: from 0.4 to 3 mm

Buyer Initials: 

Akron 855
#68162

Thickness of edge-banding in strips	: from 0.4 to 15 mm (depending on the units selected)
Panel protrusion from track	: 25 mm
Min panel length	: 140 mm
Min panel width (with length 140 mm)	: 85 mm
Min panel width (with length 250 mm)	: 50 mm
Track feed speed	: 10 -14 - 20 m/min.
Gear motor	: 4000 W
Centralised dust extraction for operating units	: 1 hood Ø 200 mm
Dust extraction for glue fume removal	: 1 hood Ø 80 mm
Dust extraction system for pre-milling unit	: 1 hood Ø 120 mm
Pneumatic connection	: 7 bar
Working voltage	: 400V /50Hz three phase + neutral
Control voltage	: 24 V - DC
Static frequency inverter	: 200 Hz
Glue container capacity	: 3 Kg (approx.)
Glue container heating time at ½ load	: 10 minutes (approx.)

E9001155 AKRON 855

Automatic, single sided industrial edgebanding machine for the application and processing of flat edge-banding material in rolls (melamine, PVC, ABS, veneer) and in strips (solid wood, Formica, planed veneers etc.).

Complete with Noise-proof cabin Gluing system VC-710 with TEKNO GLUE system.

Space for working units mm 5300

E8000011

SURCHARGE FOR VOLTAGE CHANGE

For any power supply other than STD.

E8000039

Kit for NC controlled adjustable infeed fence with 4 positions revolver

Including NC controlled 4 positions revolver on the 1st copying pad of the Pre- milling unit (Pre-milling unit Cod. E8000300 is mandatory).

E8000100

PRE-MELT UNIT QM-701 for EVA hot-melt glue.

Facilitates glue colour/type changing and feeds the glue container according to consumption. The glue is melted at 180°C and then sent to the glue container.

Includes the following:

- Granulated glue container with capacity of approx. 5 Kg,
- pre-melt unit,
- small capacity glue container (approx. 700 g) replacing the standard one.
- outlet for rapid draining of the granulated glue container.

E8000300

PRE- MILLING UNIT FI-701 - W 1800 - With widia cutters H=75 mm. Space required mm 500.

Rectifies the face that has to be edged before applying the glue. The use of this unit produces a flat, even surface ideal to apply the proper amount of glue with a thin glue line. The machining of the PRE-MILLING unit ensure a chip-free finish thanks to:

3/4" thick (19mm) of ice Feed upside gm

Buyer Initials: *gm*

- horizontal and vertical movement of the 2 motors on linear guides,
- independent automatic temporized intervention of the two motors,
- independent copying pads on each unit, with manual adjustment and mechanical digital indicator (movement on linear guides),

The AUTO-SET device with which the unit is fitted ensures optimum positioning of the cutters according to the thickness of the panel being machined.

It is complete with 3 mechanical high precision mechanical digital indicators on the main adjustments or, on request, with automatic NC. Complete adjustment.

With 2 high frequency motors. Complete with 2 cutters \varnothing 100 Z = 3+3.

E800038 INFRARED HEATING LAMP IRL-700

The code E8000300 Pre-milling unit is mandatory

Carries out the heating of the panel edge before the glue application.

E8000316 PAIR DIAMOND-COATED CUTTERS H = 65 mm

For the pre-milling unit type FI-701 - \varnothing 100 mm Z=3+3 in replacement of the standard cutters.

E8000200

End trimming unit IN-701V – Sliding on 2 linear 30 mm guides. Space required mm 750.

Cuts excess edge-banding material at the front and rear of the panel being edged.

The cut can be straight or tilted, with an angle of between 0 and 15 degrees: the angle is displayed on a scale.

- Great reliability and precision thanks to the fact that the 2 motors slide on 2 straight guides and oversized ball blocks.
- Rapid tilting of the motors from 0 to 15 degrees; pneumatic tilting with pre-selection from the control panel of 4 different cutting angles (0-3.6-11-15 degrees) is available on request.
- Can be excluded directly from the control panel.

2 high frequency motors (500 W each) 12000 rpm complete with blades.

E8000400

TOP AND BOTTOM EDGE TRIMMING UNIT RS-701; 800W; (straight cutters) – Max. edge-banding strip thickness 15 mm. (Space required mm 350.)

Trims the top and bottom of the applied edge, using 2 high frequency motors complete with self-cleaning rotating vertical copier disks. Can also be used for rough trimming of all types of edge-banding material and does not require adjustment when changing the thickness of the material being applied.

Made from a single, monolithic, high-rigidity structure ensuring: precise machining even at maximum feed speed.

Slides on vertical steel guides with ball bushings.

All adjustment devices are in an ergonomic position, and the device is complete with 4 numerical indicators to facilitate adjustment. The top unit is self-adjusting according to panel height.

Can be tilted up to 1 degree. Motors 12000 rpm complete with suction hoods. Tools \varnothing 80 x 25 x 16 with disposable inserts.

E8000413

RS-701 INCREASED MOTOR POWER FROM 1800W

E8000414 DUO-SYSTEM for Top and Bottom trimming unit RS-701.

CNC command to set pneumatically the edge trimming to 2 different overhanging. It includes the pneumatic exclusion.

Buyer Initials: 

Akron 855
#68162

- ✓ **E8000500** 1st TILTING TOP AND BOTTOM TRIMMING UNIT RI-701; 650 W;
(straight cutters) – Max. edge material thickness 5 mm. (Space required mm 500.)
Carries out top and bottom trimming or fine finishing of the edge being applied, complete with front and vertical rotating self-cleaning disk copiers.
The unit can also machine edges with door sealing gasket.
The unit can be tilted from 0 to 45 degrees (indication of the angle on a graded scale) using the UNIPPOINT system and is complete with 8 numerical indicators to facilitate adjustments.
Made from a single, monolithic, high-rigidity structure ensuring precise machining even at maximum feed speed. The top unit is self-adjusting according to panel height
Horizontal copying with the unit sliding on linear guides.
Motors 12000 rpm complete with suction hoods.
Tools \varnothing 70 x 20 x 16 with disposable inserts.
- ✓ **E8000702** MULTIFUNCTION 2 MOTORS CORNER ROUNDING UNIT CR-202; 350 W (Cutter R=3mm), Space required 900 mm. The unit carries out the CORNER ROUNDING and the TOP AND BOTTOM TRIMMING on panels edged with synthetic material up to max. edge thickness of 3 mm. The CORNER ROUNDING processing is possible both on panels with straight profiles and standard POST-SOFT/formed panels with 90 and 180 degrees. High finishing quality thanks to: movement on linear guides with recirculating ball screws, vertical oscillating copying system, frontal copying device with PRE-COPYING system. Quick and reliable changeover (doesn't require any manual intervention) between thin and thick edges (i.e. between 0,4 mm and 3 mm) with system FAST consisting of 2 positions that can be pre-selected manually (optional PLC controlled). Equipped with R=3mm braze-welded . 2 high frequency motors 12.000 rpm. Complete with pneumatic exclusion from Control board.
Working speed of AKRON 800 CORNER ROUNDING 14 m/min of TOP AND BOTTOM TRIMMING 20 m/min.
- ✓ **E8000711** INCREASED MOTOR POWER FROM 350W TO 650W ON CR-202
- ✓ **E8000800** EDGE SCRAPER RB-701 (knives R = 3 mm) - complete with chips collection box. Space required mm 450 .
Finishing unit for thick PVC/ABS edge material (e.g. 3 mm). With self-cleaning rotating front and vertical disk copiers. Made from a monolithic, high-rigidity structure ensuring precise machining. Complete with 8 numeric indicators to facilitate adjustment. The top unit is self-setting according to the panel height.
The unit can be manually excluded when not needed.
Complete with knives R=3mm.
Dust extraction system with hoods, compressed air jet conveyor and chip collection box.
- ✓ **E8001010** GLUE SCRAPER RCC-700: Space required 200 mm.
The unit removes any glue excess from the upper and lower surface that may result from the jointing point between edge and panel. Self adjusting to the panel surface and panel height. Complete with copying device and flat blade knives.
- ✓ **E8001030** OSCILLATING BRUSHING UNIT SPL-700: Space required 300 mm
To carry out the cleaning and polishing of the applied edge using cloth disc brushes. The unit is tiltable and Self-adjusting to the panel height. The horizontal oscillation assure the optimal finish specifically on thick plastic edges (i.e. 3 mm pvc/abs). It includes Two 370 W motors, 2800 rpm.
- ✓ **E8001000** HOT AIR BLOWER PH-700: Space required 100 mm.
To reactivate the color of thick plastic (i.e. 3mm pvc/abs) after the scraping operation. Fitted with two hot air blowers, 2000 W each, with adjustable temperature control.

Buyer Initials: 

Akron 855
#68162

E7002016 EUROPEAN PALLET FOR AKRON 655-855

ES05037 Trow away knife to RI-701 in place of brazewelded

ES05039 PC FLAT replacing NC 407.

Operating system Windows XP Professional; ENGLISH version

- Colour graphic interface design on 15» flat screen (TFT) with high resolution
- Keyboard and mouse
- Port USB

Software characteristics

- Operating system WINDOWS XP Professional
- Dedicated interface to control edge banders
- Control of numerical axes for the positioning of operating units and devices (PC FLAT DOES NOT include NC axes)
- Writing and running of programs to carry out automatically the foreseen machining operations
- Automatic start of operating units and motors foreseen in the programs
- Error diagnosis with codes and comments
- Execution of lists of programs
- Production statistics and tool wear
- 10 programs with direct call-up complete with button for 1st and 2nd run

✓ **AKRON-MATIC 800/1 - Group of devices that enable the automation of machine set-up. It includes ALL the following devices:**

- Electronic NC controlled top pressure beam positioning for AKRON 800
- RPT- AKRON 800 Edge pressing rollers with temporized intervention
- Pneumatic tilting adjustment for end trimming unit mod. IN-701V
- Up to max. 3 pneumatic exclusion for the operating units
- SYSTEM FAST FOR THE PRE-SELECTION OF 2 POSITIONS FROM CONTROL BOARD (FOR CR-202 or CR-401)

BGAP002

INSTALLATION

The installation consists of up to 5 days (including travel time) of onsite machine installation and training. In the mutual interest to have a successful installation within the 5 days, it is very important that the customer and Biesse America are aware and agree on the following reciprocal duties.

Biesse America Duties:

- Machine unpacking, leveling, and anchoring to the floor (if required)
- Machine installation according to the manufacturer checklist
- Setting the machine to operating conditions
- Operating procedure training
- Safety and maintenance procedure training
- Replacement parts ordering procedures

Buyer Initials: 

Akron 855
#68162



Customer Duties

- Floor preparation according to Biesse Specifications (if required)
- Machine, still sealed, offloading and positioning in the installation location
- Labor Force and handling equipment (crane, forklift, etc.) to unload, uncrate and position the machine
- Tooling required for anchoring machine to the floor (hammer-drill and bit) (if required)
- Electrical connection to the machine needs to be done by a licensed electrician
- Electrical ground is mandatory
- Dust extraction ready for final connection as specified in the machine data
- Pneumatic connection ready as specified in the machine data

If any of above items will be not ready at time of installation causing delays in the installation, Biesse will charge for the additional time required.

Not Included (please call for cost estimates):

- Onsite programming training, application training or programming of customer pattern/samples
- Networking
- 3rd Party software integration
- Material needed for testing (panels, tooling, etc)
- Local electrical requirements such as UL may require inspection by an independent agency, and the cost of any inspection and certification will be the responsibility of the customer (The machine is built in compliance with the International Electrical Code (IEC-204)

Additional training, exceeding the included installation hours, can be provided on site at standard technician daily rates plus expenses.

Warranty: A limited 12 month parts and labor, see details in Terms and Conditions of Sales.

Total Machine Cost	\$142,000.00
---------------------------	---------------------

The price on this proposal is related to the specific machine serial number and is valid only for thirty (30) days and is subject to sale.

This quotation replaces all previous written and verbal understandings, and the specifications and representations contained herein are the sole understanding between your Company and Biesse America.

Buyer Initials: 