

Top Layer Splitting Saw S - 4

High Speed 4 Spindle Circular Saw Split System

Top performance at high feed speed with minimized saw kerf. The S-4 combines all required features for high volume, high quality hardwood top layer lamella production.

Designed with 2 scoring saw spindles and 2 splitting saw, to reduce tear-out and chipping.

Equipped with edging blades on top and bottom as well as automatic On / Off of the saw spindles to reduce saw burning.



4 roller feeding unit with pneumatic control and automatic feed speed control system.

Pneumatic side fences and hold-over with optimized lamella guiding system (without riving knives), motor current display of all 4 saw spindle motors for tool wear control.

High resolution, vertical adjustment of the saw spindles with direct measuring system and digital display.

S-4 XL-version with up to 200 mm wood width.

Thin kerf saw blades with tip width down to 0,8 mm (scoring) and 1,0 mm (splitting).

Heavy edging saw blades for perfect quality even of the top and bottom lamellas.

High production capacity with up to 6 (S-4 XL max. 8) lamellas and feed speed 10 - 40 m/min. adjustable.



Special thin kerf saw blades for 4, 5 or 6 top layer lamellas supplied by:



Parquet **SCHROEDER** Machines

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Splitting Saw S-4 / S-4/3 / S-4/2 / S-4 XL

High Speed 4 (3 or 2) Spindle Circular Saw Split System

Technical Specifications:

Horizontal, circular saw splitting / ripping unit with 4 (S-4/3 with 3, S-4/2 with 2) vertical saw spindles for scoring and splitting (50 % per side, S-4/3 full cut), prepared for edging (calibrating of top and bottom slat), with auto feed speed control and auto spindle start / stop, according infeed volume of material. Standard version with large CE-safety hood, hydro-tool-clamping and Siemens S-7 PLC with touch panel operation. Feed system with 4 (8) high-friction rubber rollers (pneumatic pressure control), pneumatic side fences and top pressures system as well as direct length measuring systems for height adjustment of the saw shafts

Width of planed blocks: 50 - 125 mm (depending on version up to 200 mm)
 Thickness of planed blocks: 10 - 35 mm (max. 7 saw blades per shaft = 6 lamellas)
 Length of parquet blocks: min. 250 mm (depending on saw blades, max. length unlimited)

Feed speed (adjustable): 10 - 40 m/min. (depending on saw blades and wood width)

Dust exhaust (air speed 35 m/sec): 2,6 m³ / sec. (S-4/3: 2,0 m³ / sec.; S-4/2: 1,3 m³ / sec.)

Pressurized air (6 bar): approxim. 100 - 250 NL/min.

Total electrical power: 80 kW (S-4/3: 67 kW; S-4/2: 57 kW; S-4 XL: 117 kW)

Motors (standard S-4):

2 pcs. 25 kW, 3000 U/min. for split saw spindles (S-4/2 & S-4/3 11 - 18,5 kW, S-4 XL 35 - 40 kW)

2 pcs. 7,5 kW, 3000 U/min. for scoring spindles (S-4/3: 7,5 kW)

1 pc. 5,5 kW, 1500 U/min. for the feed drive (option up to 7,5 kW)

Saw spindles: 50 mm diameter, about 100 mm usable length
 5.000 - 8.000 rpm, (depending on saw blade diam. to achieve optimum cutting speed at required feed speed)

Options: - Saw spindles with frequency converters (for adjust. cutting speed, standard S-4 XL)
 - Motorized saw spindles slides (horizontal slides)
 - Infrared temperature control system for the saw blades

Tooling (e.g.):

For X slats and wood width max. 75 mm, mounted on ETP-hydro-sleeves:

Scoring (S-4 only):

X-1 pcs. 200 x 1,1/0,9 (0,9/0,7) x 60 or 65 mm, 24 teeth (thin kerf straight blade)

Splitting:

X-1 pcs. 220 x 1,4/1,0 (1,2/0,9) x 60 or 65 mm, 24 - 32 teeth (thin kerf straight blade)

Edging:

4 pcs. 220 x 3,8/3,0 x 60 or 65 mm, 24/6 or 24/12 alternating teeth

Depending on wood width and saw blade type, the blade dimensions (kerf, diameter, no. of teeth, etc.) may vary upon application.

Weight: approxim. 4000 kg

Dimensions (L x W x H): approxim. 2600 x 1600 x 2100 mm (plus electrical cabinet)