

WIN

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Decors

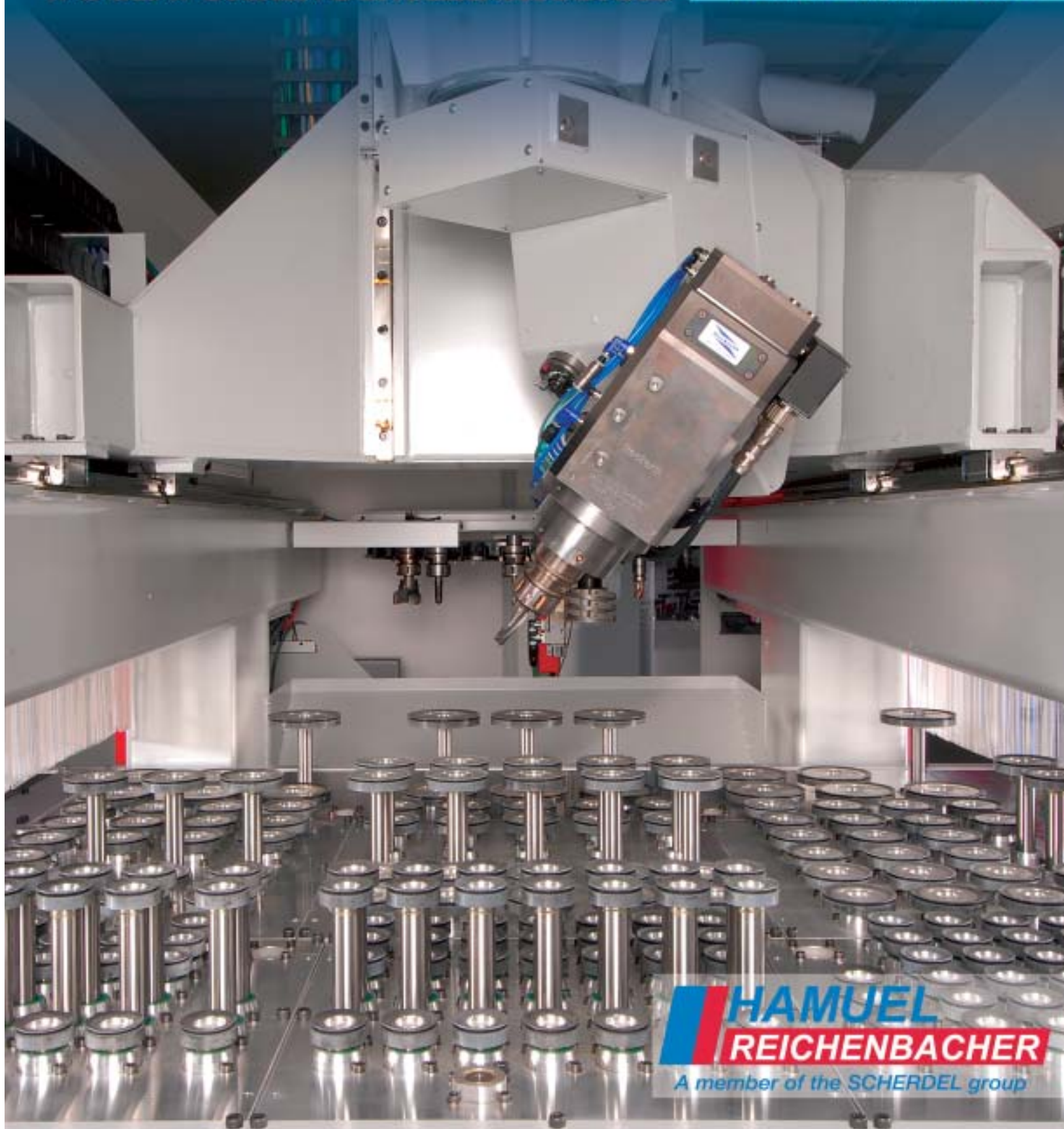
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**HAMUEL
REICHENBACHER**

A member of the SCHERDEL group

Furniture Production

Three new Hamuel Reichenbacher CNC machining centers at Staircraft's newly opened stair making facility.

Sprint Trio Set The Pace At Staircraft

Three new Hamuel Reichenbacher CNC machining centers have taken place in a brand new, custom-built stair making facility, owned by leading staircase manufacturer Staircraft (Midlands, UK) Ltd.

Staircraft has invested over £3.7m in the newly constructed 38,000ft² factory at Nuneaton, Warwickshire, which has the capability to manufacture in excess of 200 staircases per week. Around £700,000 has been spent acquiring the very latest machinery, including three custom-built Vision Sprint 5-axis CNC machining centers from Hamuel Reichenbacher.

Three dimensional machining combined with fast set-up and positioning accuracy of the working aggregate has helped make these machines the first choice for stairs manufacturers.

Two of the advanced technology machines incorporate Hamuel Reichenbacher's unique vacuum pin-table configuration, representing the first of their type to be installed in England. Each pin-table com-

prises individually controlled vacuum pods (pins) and pneumatically controlled disappearing setting stops. Both pin-tables have a staggering 876 pins and



Twelve winder plates produced in just 12 minutes, including set-up, on the Hamuel Reichenbacher custom-built Vision Sprint

16 setting stops and their 6m long tables accommodate four working stations.

"Everything about these high-speed machining centres is designed to slash set-up times and to maximise the time that the head is in operation," says Albert Thompson, managing director at Hamuel

Reichenbacher Ltd. "The pin-table configuration means that boards are instantly positioned for machining and set-up is restricted to the length of time it takes to place the boards onto the work table - just seconds."

The third Vision Sprint has a 7.1m long table to facilitate reciprocal machining of multiple newel posts. Like the other two Vision Sprints, this high-specification router has a 24-position tool changer and was tailored to

meet Staircraft's individual needs. Albert Thompson added, "Close collaboration between Staircraft's managing director, Andy Hamilton, and our engineering people in Germany has contributed greatly to the success of this installation. Andy's clearly defined requirements and his visionary approach to production,



Pin-table configuration reduces set-up time for machining strings to just seconds.

combined with our application experience in 5-axis machining, enabled us to provide a solution that fully exploited the potential of both the machines and the software."

"These are incredible machines," says Andy Hamilton, "they can accurately machine four nests of winder plates in just 12 minutes or four sets of strings in 15 minutes. Had we bought conventional CNC routers these processes would take around 90 minutes each. It means we can achieve in less than two hours, what would normally take a full shift. Investing in the new facility and the Reichenbacher machines has now positioned the company to set new standards of quality and supply into the house building sector."



Left working station with clamping areas and pins in.

VISION II Sprint
Midlands Ltd

with PIN table for Staircraft

Technical data VISION II Sprint with PIN table „Staircraft“:



Routing head

1 cardanic working head with routing spindle with automatic tool change for routing, drilling, sawing and sanding processing. Performance 15.0 kW, constant from 12,000 – 24,000 min⁻¹.

Tool magazine

1 automatic tool changer with magazine plate for 24 tools. The magazine is mounted behind the working head and runs with the X-axis. .

Clamping unit

1 clamping unit for the use of additional heads from the tool magazine is mounted at the cardanic working head.

Blast nozzle

2 blast nozzles mounted to the routing spindle, with automatic control by program function.

Extraction

The working unit has 1 extraction connection with a diameter of 400mm. The connection of the working unit can be locked by a slide. To the left and the right side of the gantry enclosure an additional extraction nozzle is mounted between safety bumper and gantry enclosure parallel to the Y-axis. The extraction nozzle is pneumatically moveable.

PIN table

The fixed machine table has a vacuum clamping area executed as a pin table with individually moveable vacuum pins. The pin table consists of 4 working stations.

Total number of PINs / machine: 876 pieces, stroke of PINs: 100mm

Stops

Each working station 4 pneumatically sinkable stops are available with automatic control. Stroke 130mm. Control manually or by NC-program.

Supporting beams

Each working station 2 (a total of 8 on the machine) pneumatically moveable supporting beams are available with automatic control. Stroke 120mm. Control manually and by NC-program.

Table size: 6,200 x 1,500mm

PIN area size: 6,140 x 1,325mm.

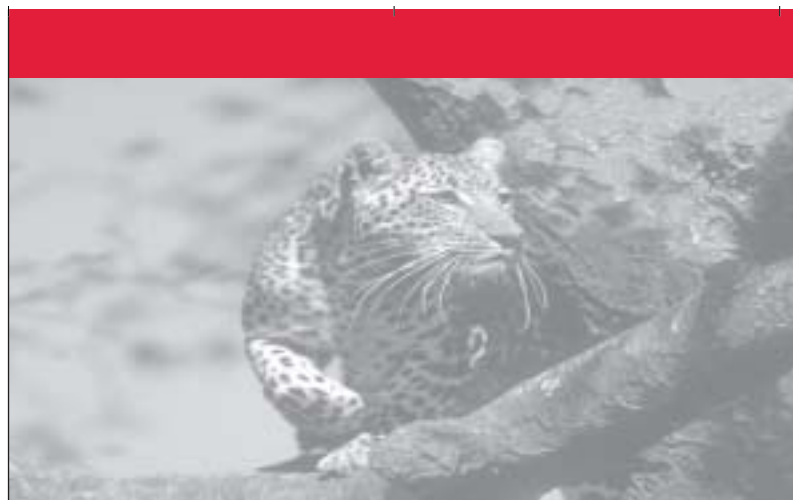
Working areas

The following working areas are available with vertical position of the cardanic head:

with simple loading: max 6,140 x 1,600mm with a free area of approximately 5,200 x 1,600mm with reciprocal loading: approximately 2 x 2,700 x 1,600mm

For more information
please quote

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- increased variety for parallel and single operation by way of U-shaped gantry construction with two independent Y-slides
- application of two high performance 5-axis working heads with extensive additional equipment
- maximum flexibility with chain magazine (up to 120 places)
- optimum time savings by parallel tool changing

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