

EASY-SET MULTI-HEAD PRESS



ADVANTAGES

- *Multiple press heads.*
- *Quick pressing cycle.*
- *Short set up time.*
- *Suitable for short production runs.*
- *Automatic Nail Plate feeders.*
- *Retractable press heads.*

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EASY-SET MULTI-HEAD PRESS

Description:

The Easy-Set Multi-Head press combines the rapid pressing cycle of multi head presses, with the speed and ease of setup associated with the popular Flo-jig Systems. Flo-jigs have been the main production facility of many truss plants, as they can readily handle a wide variety of truss shapes.

The Easy-Set Multi-Head press has been developed for short production runs and is capable of efficiently manufacturing many of the more complex truss shapes for which conventional multi-head presses are not suitable. Generally, multi head presses have not been considered suitable for production runs of 10 trusses or less. However, on the Easy-Set, with quick action air clamps and measuring tapes incorporated in the jig, truss runs of one or two are feasible.

The production cycle time is also improved compared with other multi heads, as the Easy-Set Multi-Head press incorporates nail plate placement. Typically, cycle time for an A Type truss, including placing of timber and unloading finished truss, is 50 seconds. The flow of material to the press and the removal of finished trusses will determine the overall productivity of the machine.

Features:

Press:

- Multiple press heads, all joints pressed simultaneously.
- Press heads not required to be used may be isolated and set to one end of the jig.
- Very fast cycle time (40 to 50 seconds).
- Automatic nail plate feeders:
 - interchangeable cartridges to suit different nail plate sizes.
 - adjustable plate pusher to accurately position the nail plate.
 - nail plates picked up and held in position with magnets.
- Anti-tilt press head suspension prevents displacement of connectors and webs during pressing operation.
- Press heads retract following pressing allowing operators to easily lift the finished truss clear of the jig.
- Emergency stop button on each press head.

Jig:

- Fast set-up (3.5 to 4.5 minutes).
- Clear working area.
- Movable operator console with interlocked controls, cat-track tracking on air and hydraulic lines.
- Walk-in design.
- Pneumatic locking of press head positioning along rail.
- Camber adjustment on each press head.
- Pneumatic timber clamps.
- Tooling provided for clamping of truss members.

Specifications:

- Configuration - C-Frame press heads each mounted on an individual carriage. Carriage is manually orientated and moved along steel rails to the truss panel point. Cartridge on press head for automatic feeding of nail plates. All hoses and cabling under timber floor.
- Overall equipment dimensions:
Length 15400mm, Width 5135mm, Height 1120mm.

Press details:

- Eleven press heads: 9 x 18 T standard heads, 2 x 25 T bottom chord splicing heads.
- Seven auto nail plate feeders supplied with a standard system.
- Power requirements: 3 Phase and neutral, 415 Volt, 20A.
- Air requirements: 850 kPa, 120 psi (minimum).
- Press hydraulic power pack motor: 11 kW.
- Maximum operating pressure: 165.5 bar (2400 PSI).
- Press head throat opening (between top and bottom platens) - 95mm.
- Press platen size (top and bottom - width x depth): 300 x 250mm.

Jig details:

- 14m heavy duty base rail,
- Four movable arms,
- One fixed apex arm with a 3310mm maximum apex height.

Tooling details:

- 2 x pneumatic bottom chord clamps,
- 2 x splice box (bottom chord) clamps,
- 4 x camlocks,
- 2 x heel clamps.

Truss information:

- Maximum span of truss: 14m (or customer specified).
- Maximum height of truss: 3310mm.
- This press is able to press any truss that has all its panel points joining with a chord.
- Any truss with internal plates cannot be pressed.
- Any truss that has plates that require more than 25 Tonne pressing force cannot be pressed.
- Any joint that is closer than 400mm from an adjacent joint cannot be pressed.
- Commonly installed with a Gantry Press, this allows larger plates, internal joints and plates that are close together to be pressed.

Options:

- 15 press heads.
- 30 Tonne press heads.
- Extra optional automatic nail plate feeders, which have an adjustable magazine with thumb screw adjustment and will fit most size nail plates up to 150 x 150. MiTek does not recommend the use of auto nail feed on very small plates used at T1 points, as the positioning of these points creep, depending on variation in tolerance of timber sizes and accuracy of sawing. Where unusual plate locations are required, the auto nail plate feed can be simply turned off as required, and the nail plates placed manually.

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