LOHMeyer
SMART WOOD WORKING

KAM 780 IQ
Horizontal Panel Saw  Sliding Table Saw  CNC Machining Center  Edgebander
Wood IQ is your smart choice
A good foundation means everything

We are Lohmeyer

We are Tanja and Peter Lohmeyer, Lohmeyer machines’ namesakes. As such, we stand for everything that distinguishes our Germany-based company. We comprise decades of brilliant market experience and a bold, uncomplicated approach that is intelligently and directly oriented towards one target: Making your business even more successful.

We achieve this via optimized, standardized best practice machines for smart wood working. That is why our company is called Wood IQ.

Our machines

Our smart KAM 7 IQ edgebanders combine established quality with unrivalled cost effectiveness. This works because we cleverly combine various components: German engineering experts implement technical industry standards. European service providers ensure the continuous high availability of our products. And, our machines are manufactured with German and Japanese precision tools by the Nanxing company in China.

Whether you want to expand your machinery or whether you want to buy replacement machines: Work smart. With Lohmeyer by Wood IQ.
KAM 780 IQ
Equipped for the cabinet manufacture

Two milling engines for edge rounding; post-forming edges can be copied too • page 13

Efficient exhaust system with flow optimised covers at the tools

Edge feeding – Smart thanks to large support for rolled material; toolless change over and pneumatic knife • page 10

Spraying unit in front of buffing unit • page 17

Preheating zone • page 9

Buffing unit - Once polished, the edge will be perfect • page 17

Spraying device for release agent in infeed area

Surface scraping unit – Removes even the tiniest glue residues • page 18

Terminal – Operating and monitoring at eye level

Profile scraping unit – Pneumatically adjustable for perfect finish processing of PVC and ABS edges • page 14/15

Pre-milling – Provides optimal preparation of the glue joint. Highest quality thanks to diamond cutters and optimized dust extraction • page 9

Glueing area – pneumatically controlled 5 roller pressure zone for the ideal joint • page 10

Fine milling unit – pneumatically adjustable, fast and powerful due to 12,000 rpm • page 12

Rough milling unit * – Powerful 2 x 1.1 kW • page 12

Trimming unit – Linear guide, tiltable 0° to 15° • page 11

* Only for machines of the S-series which process solid wood stripes up to 8 mm as edge material.

More output due to high availability based on robust design and maintenance-friendly engineering
Workpiece handling

Workpiece transportation is the foundation for a good edge

Mechanical inflow lock and optical signal

Mechanical inflow lock or optical signal? Why „or“ - we provide both!

Where other makes only have a flashing indicator lamp, we have fitted a mechanical stopper. For smart and reliable edge banding.

By the way: We placed the transport belt very close to the units for particularly narrow workpieces (min. 80 mm) and high precision.

Optionally, also workpieces of min. 30 mm width can be processed – talk to us!

Telescopic workpiece support

Especially wider workpieces can be moved throughout the full processing area of the machine thanks to the telescopic support in scissor design. The support device is laterally guided by ball bearings.

Every detail of the machine design serves only one purpose: Your perfect edge joint!
Workpiece handling

Workpiece transportation is the foundation for a good edge

It all starts at the infeed ruler. The foundation for the perfect glue joint is the accurate infeed of the workpiece into the machine.

The high quality linear guiding system guarantees a high repeat accuracy and precision of adjustment.

The broad infeed ruler in connection with the high precision chain ensure the stressless infeed of the workpiece.

Pre-milling unit

The pre-milling unit is provided with two powerful motors (3.7 kW) and prepares the glueing of the workpiece. The routers jump in/out pneumatically and work in up-cut or climb cut. The chip removal is precisely adjusted with a fine adjustment device.

Before the glue station the workpiece edge is warmed up to approx. 180°C. Thus, the workpiece is perfectly prepared for the glueing with the edge material and another potential source of glueing error is eliminated. The diameter of the cutters is 125 mm, with its 12,000 rpm it rotates at the optimum speed for panel processing.

Let’s start...

... piece by piece to the perfect edge

The broad infeed ruler in connection with the high precision chain ensure the stressless infeed of the workpiece.
Edge feeding and glueing
The easy way of optimal glue application

Pressure zone with five rollers
The first roller runs synchronously to the feeding system. After the first contact, workpiece and edge are transported at the same speed with high pressure. The high-quality pressure zone with five conical pressing cylinders provides a clean and strong pressing of the edge with the workpiece especially in the upper and lower area.

Fully automatic and user-friendly
That's how rolled and tape material is smartly fed into the machine. No tools needed for a change over. The pneumatic feeding roller ensures the edge material supply. A floating element protects the glue application roller against wear and ensures a uniform glue joint.

Clean trimming cuts
The edge projection at the front and rear workpiece edge are neatly removed by a drawing cut.

High-quality linear guide system and the tiltable trim units (0.5 kW, adjustment 0° to 15°).

This ensures high precision, long life cycle and flush-trimmed edges.

Travel and resistance can be adjusted separately via a manometer.

Trimming aggregates with high repeatability
The base for the following processing steps
The fine milling aggregate can automatically switched from 0.4-1.0 mm to 1.2 - 2.0 mm.

Once adjusted the robust aggregates of KAM 780 IQ remain in their position and ensure the required repeatability.

The efficient aggregates are supported by a high precision pressure system to prepare the edge for the scraping unit and the corner rounding unit. The aggregates are arranged close to the feeding system, so that workpieces of minimal width can be processed.

Chips are falling. No problem, since an optimized extraction hood and an efficient exhaust suck the chips off the machines. Without any detours.

Two units process the variants – upside, downside, back, front – in order to make exact copies of profiles created before or of post-forming shapes. And all that at a maximum feed rate of 13 m/min.

The units are neatly arranged and easily accessible. With an engine power of 0.3 kW and 18,000 rpm, the copy units process everything in the corner section.

The aggregates are activated and deactivated via the terminal. It is possible to activate each aggregate individually, so that front; rear, upper or lower edge can be processed separately.

Corner rounding unit

Two units process the variants – upside, downside, back, front – in order to make exact copies of profiles created before or of post-forming shapes. And all that at a maximum feed rate of 13 m/min.

The units are neatly arranged and easily accessible. With an engine power of 0.3 kW and 18,000 rpm, the copy units process everything in the corner section.

The aggregates are activated and deactivated via the terminal. It is possible to activate each aggregate individually, so that front; rear, upper or lower edge can be processed separately.
Profile scraping unit

Almost there ...
... only a few more steps to the perfect edge

The profile scraping unit is mounted on the base body of the machine and excels through its high stability.

The large diameter of the starter discs in combination with the stiffness of the aggregate guarantees a perfect edge!

The unit processes the previously fine routed edge. The drawing cut removes the planing blows and planes the cut edge for an optimal appearance.

Thanks to the scraping units, the synthetic edges get a uniform surface.

Spraying device

The spraying unit exactly at the profile scraping unit facilitates the application of antistatic cooling agents, e.g. Riepe LP289/99®. That prevents the glue from adhering to the aggregate, the edge radius adapts itself to the brilliance of the surface and the edge as well as the glue joint are cooled down. This protects the workpiece and prevents stress whitening at the edges.

Dust extraction at the tool

The efficient exhaust device straight at the tool ensures the chip-free operation within the machine and prevents from chip impact. Hence, an excellent surface quality is produced and the wear of the tool is reduced.

Pneumatic 2-point-adjustment

The pneumatic 2-point-adjustment allows the changeover of this aggregate as a decisive factor for the edge quality.

Thanks to the tilted arrangement of the aggregates various edge thicknesses can be processed with the same tool.
Lohmeyer finishing aggregates for your perfect joint

Surface scraping unit

The surface scraping unit removes the last remaining glue residues. Integrated air nozzles remove the loosened material. The sophisticated aggregate is pneumatically controlled via the operator terminal.

Buffing unit

The final stretch ...
... finally buffing

With 1,325 rpm, the edge material receives its final touch. All conventional fabric, sisal, and leaf wheels can be used.

Precise spraying device

Precise spraying of the abhesive in front of the buffing unit. By using the appropriate abhesive (Lohmeyer recommends Riepe products) the edge radius is brought back to its original brilliance. Hence, you achieve a high-end appearance in a smart way.
User-friendly operation

Software and mechanics

The operating software

KAM 780 IQ can be easily and intuitively operated via a touchscreen. The integrated software components inform about the current status of the machine.

In combination with the Lohmeyer hotline this facilitates the quick and reliable error diagnosis and trouble shooting.

Start/stop switch

A start/stop switch outside the machine enables the operator to stop the workpiece anytime during the working process.

Thus it can be exactly determined which aggregate needs readjustment. Particularly the interaction between the milling aggregates and the scraping units can thereby be optimized.

During adjustment works the feed can be started, while the operator stands near the aggregate.

Processing of inclined edges with KAM 780 D IQ

Pre-milling - inclined edge
Pre-milling - straight edge
Grooving
Pressure zone and snipping
Trimming
Rough milling
Fine milling
Profile scraping
Surface scraping
Buffing

partially inclined edge
The KAM 780 IQ series
Numbers, data, facts · everything at a glance

Production lines with Lohmeyer edgebanders

<table>
<thead>
<tr>
<th>Feature</th>
<th>KAM 780 IQ</th>
<th>KAM 780 S IQ</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pre-milling unit</td>
<td>pneumatic control · 2 motors</td>
<td>pneumatic control · 2 motors</td>
</tr>
<tr>
<td></td>
<td>CW and CCW turning · 2 x 3.7 kW · 12,000 rpm</td>
<td>CW and CCW turning · 2 x 3.7 kW · 12,000 rpm</td>
</tr>
<tr>
<td>Edge banding magazine</td>
<td>endless and strip material</td>
<td>endless and strip material</td>
</tr>
<tr>
<td>Trimming unit for endless edges</td>
<td>knife</td>
<td>knife</td>
</tr>
<tr>
<td>Glue station</td>
<td>EVA glue from beneath</td>
<td>EVA glue from beneath</td>
</tr>
<tr>
<td>Pressure zone</td>
<td>5 roller pressure zone, one cylinder driven</td>
<td>5 roller pressure zone, one cylinder driven</td>
</tr>
<tr>
<td>Trimming unit</td>
<td>pneumatically · tiltable 0-15° · 2 x 0.37 kW · 12,000 rpm</td>
<td>pneumatically · tiltable 0-15° · 2 x 0.37 kW · 12,000 rpm</td>
</tr>
<tr>
<td>Rough milling unit</td>
<td>--</td>
<td>--</td>
</tr>
<tr>
<td>Fine milling unit</td>
<td>2 x 0.55 kW · 12,000 rpm</td>
<td>2 x 0.55 kW · 12,000 rpm</td>
</tr>
<tr>
<td>Corner rounding unit</td>
<td>2 motors · 2 x 0.3 kW · 18,000 rpm</td>
<td>2 motors · 2 x 0.3 kW · 18,000 rpm</td>
</tr>
<tr>
<td>Profile scraping unit</td>
<td>✔</td>
<td>✔</td>
</tr>
<tr>
<td>Flat scraping unit</td>
<td>✔</td>
<td>✔</td>
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<tr>
<td>Buffing unit</td>
<td>0.25 kW · 1,325 rpm</td>
<td>0.25 kW · 1,325 rpm</td>
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<tr>
<td>Spraying unit</td>
<td>in front of pre-milling</td>
<td>in front of buffing</td>
</tr>
<tr>
<td>Feed rate</td>
<td>3 kW · 12-22 m/min · stepless</td>
<td>3 kW · 12-22 m/min · stepless</td>
</tr>
<tr>
<td>Reference edge</td>
<td>left</td>
<td>left</td>
</tr>
<tr>
<td>Set-up dimensions</td>
<td>7,200 x 1,450 x 1,650 mm</td>
<td>7,700 x 1,450 x 1,650 mm</td>
</tr>
</tbody>
</table>
Workpiece and edge parameters

<table>
<thead>
<tr>
<th>Parameter</th>
<th>KAM 780 IQ without pre-milling / without corner rounding</th>
<th>KAM 780 S IQ without pre-milling / without corner rounding</th>
</tr>
</thead>
<tbody>
<tr>
<td>Workpiece thickness</td>
<td>min. 10 mm – max. 60 mm</td>
<td>min. 10 mm – max. 60 mm</td>
</tr>
<tr>
<td>Workpiece thickness</td>
<td>min. 10 mm – max. 30 mm</td>
<td>min. 10 mm – max. 30 mm</td>
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<tr>
<td>Workpiece thickness</td>
<td>min. 10 mm – max. 45 mm</td>
<td>min. 10 mm – max. 45 mm</td>
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<tr>
<td>Workpiece width</td>
<td>min. 80 mm</td>
<td>min. 80 mm</td>
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<tr>
<td>Workpiece width</td>
<td>min. 130 mm</td>
<td>min. 130 mm</td>
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<tr>
<td>Workpiece length</td>
<td>min. 120 mm</td>
<td>min. 120 mm</td>
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<tr>
<td>Workpiece length</td>
<td>min. 320 mm</td>
<td>min. 320 mm</td>
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<tr>
<td>Workpiece length</td>
<td>min. 140 mm</td>
<td>min. 140 mm</td>
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<tr>
<td>Edge thickness</td>
<td>0.4 – 3 mm</td>
<td>0.4 – 3 mm for ABS / PVC / thin edges</td>
</tr>
<tr>
<td>Edge thickness</td>
<td>1.2 – 3 mm</td>
<td>1.2 – 3 mm</td>
</tr>
<tr>
<td>Edge width</td>
<td>15 – 65 mm</td>
<td>15 – 65 mm</td>
</tr>
<tr>
<td>Edge width</td>
<td>15 – 43 mm</td>
<td>15 – 43 mm</td>
</tr>
<tr>
<td>Electric equipment</td>
<td>400 V – 3 phases – 50 Hz</td>
<td>400 V – 3 phases – 50 Hz</td>
</tr>
<tr>
<td>Electric equipment</td>
<td>electronically</td>
<td>electronically</td>
</tr>
</tbody>
</table>

For detailed information on the edgebanders and other machines for cabinet manufacturing please refer to www.lohmeyer-iq.com