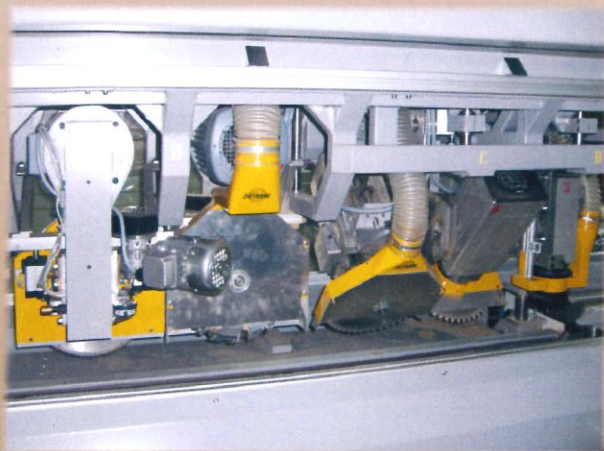


STM

TECHNICAL DATA:	STM/2T 2400x3300	STM/P/4T 3000x3300
Motors Folding head type 2cr (kW)	4 at 5200 rpm	5,6 at 5200 rpm
Motor horizontal head type t (kW)	6,5 at 2500 rpm	9 at 2500 rpm
Motor vertical head type p (kW)		4,5 at 18000 rpm
Working head advancement speed (m/min)	From 2 a 30, quick return at 75	
Pincers advancement speed (m/min)	From 10 a 30 pushing, from 20 up to 60 pulling	
Taping advancement speed (m/min)	From 20 a 60, quick return at 150	
Productivity	2 cycles for minute (V grooving, with taping, on 3000 of capacity at 20 m/min)	
Working height level (mm)	990	
Ø Max. tools (mm)	250	310
Ø Max. adhesive tape bobbin diameter (mm)	280	
Max. adhesive tape width (mm)	32	
Max. work-piece width (mm)	2400	3000
Min. work-piece width (mm)	75	100
Max. distance between two cuts (mm)	3300	
Max. work-piece thickness (mm)	32	62
Ø Inlet suction hoods	3 x Ø 160	5 x Ø 160
Dimensions L x W x H (mm)	5500 x 8100 x 2200	7500 x 8300 x 2300
Approx. Weight (kg)	5500	7000



Head-holder carriage type 4T



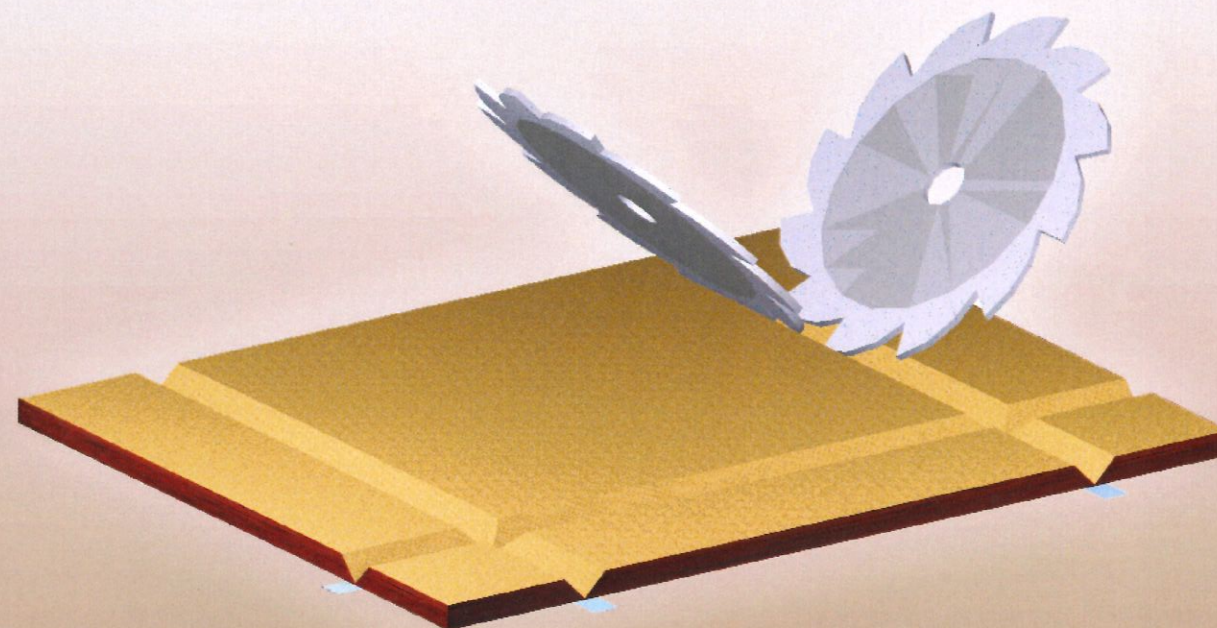
Head-holder carriage type 3T



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STM



Working centre for the FOLDING system

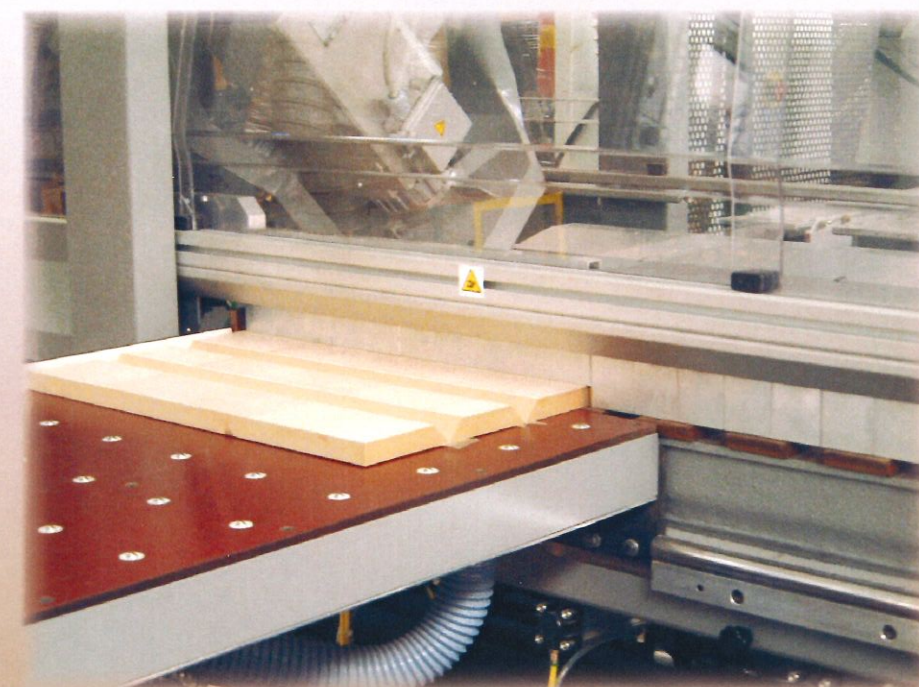
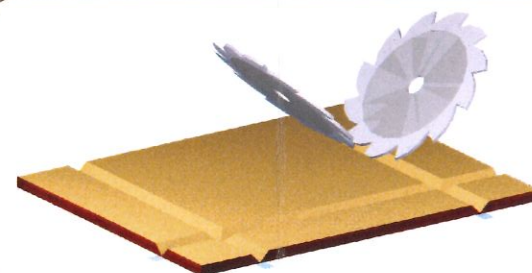
Model

STM

STM



Front view of the STM/P/4T



View of the hands protection Safety system

The Working centre for the Folding system has been studied for executing both longitudinal and transversal precision V-cuts on panels, coated with PVC or also with not bending materials that needs the adhesive tape application.

It is a high flexibility machine, used for the production of low and medium quantities of furniture, Hi-Fi loudspeaker boxes and other particulars assembled with the folding system.

The STM can be supplied with working capacity of 2400 and 3000 mm, as well as with work-pieces positioning capacity of 2700, 3300 and 3900 mm, according to the production requirements of the customer. The machine has a precise and compact steel structure, which gives to it a high sturdiness and, moreover, it is equipped with:

- fixed front table of phenolic stratified for loading and unloading of the pieces, with air pads system and fence for supporting the panel in square;
- supplementary front table, which is mobile and removable, useful as support of big pieces;
- head-holder carriage, which slides on two precision guides with ball guides shoes anchored to the superior beams of the machine;
- heads, installed on the carriage and equipped with automatic lifting system for the automatic return to the point of working start, which can be of the following types:
 - "2c": for V cuts at 90 degrees, with two circular saw-blades.
 - "2cr": for V-cuts with angle adjustable from 30 to 90 degrees, with two circular saw-blades;
 - "t": for cutting or milling.;
 - "p": vertical axis, for milling and blind milling too;

- "pxz": vertical axis spindle with pneumatic vertical overtravel, to make circular and rectangular pockets;
- "8f": boring unit with 8 independent spindles.
- working table, with breastbands of phenolic stratified with air pads system and automatic horizontal hold-downs, which are adjustable according to the panel width;
- contrast, with interchangeable insert and automatic support on the piece edge, which lays automatically under the taped surface, so to avoid the chipping of the cut at output;
- automatic hold-downs, adjustable according to the cutting thickness, for securing the work-piece against the working table;
- rear table, with supports and work-pieces positioning system through automatic pincers controlled by NC;
- automatic tape application group: if the work-pieces are coated with not bending materials that needs the adhesive tape application
- automatic horizontal contrasts (poa), for executing longitudinal and transversal cuts consecutively on the same piece (crossed cut cycle).

The whole operation logic is controlled by a multi-axes continuous path numerical control type CNC model XNC with PLC integrated. the programming takes place in simplified way, inserting the dimensions of the workpiece, with functions visualization on video, sizes and kind of cut, with manual and automatic controls on a push-button panel anchored to the machine shoulders:

- Industrial PC based on Windows - Professional platform
- internal device for mass memory (floppy disk) for saving a

- copy of the programs.
- external device for mass memory (USB - Key)
- TFT color monitor.
- remote-assistance predisposition.
- Software cycle to obtain crossed "V" cuts.
- Software cycle to obtain rounded "V" cuts.
- Software cycle to obtain "V" cuts working in concordance with the advancement of the tool-holder carriage (Axis TE)

- Possibility to create a full personal working cycle



Pincers-holder carriage with air pads system



CNC Controls panel