

# 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



Peter Lohmeyer ●

● Tanja Lohmeyer

### 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

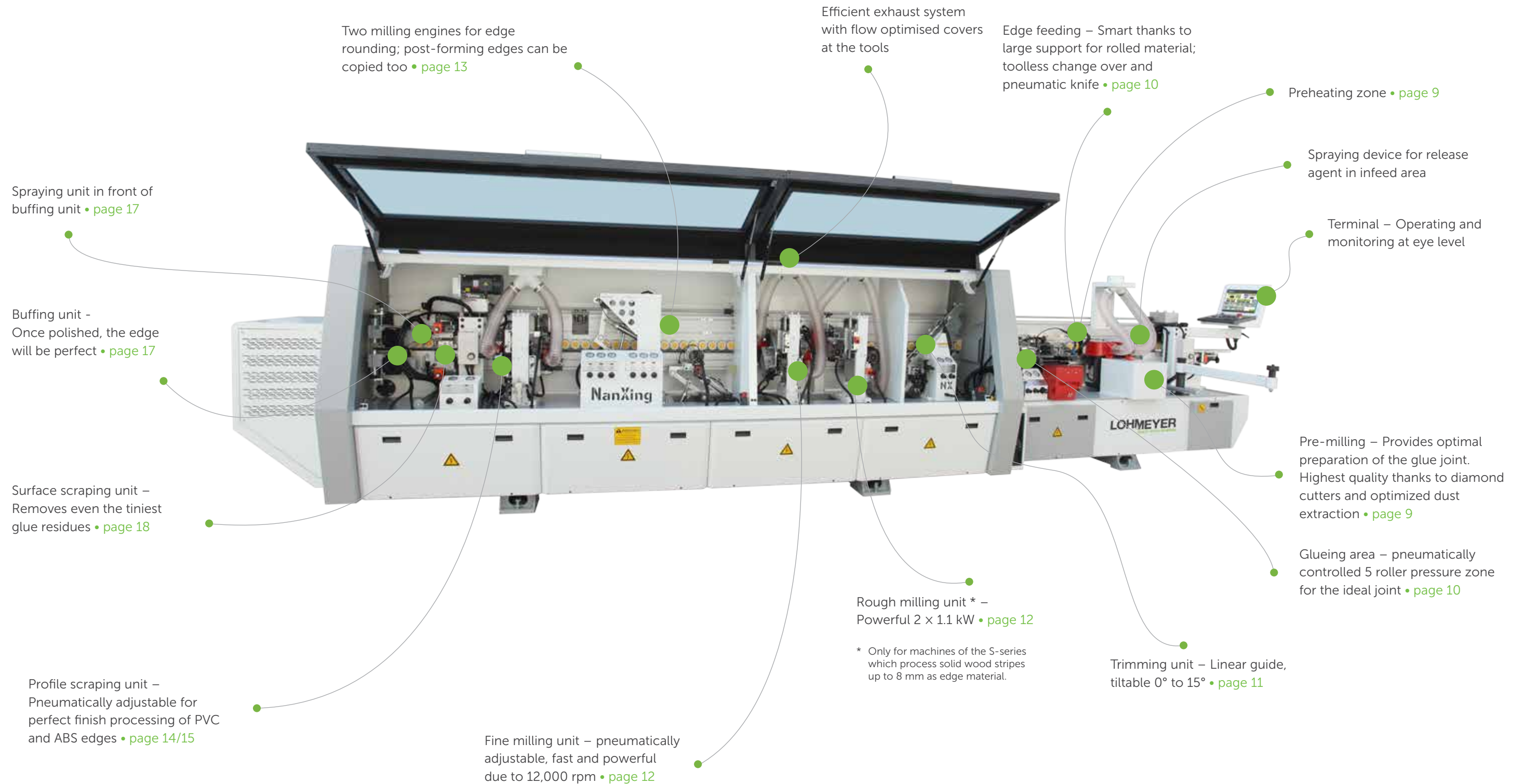
Our smart KAM 7 IQ edgebanders combine established quality with unrivalled cost effectiveness. This works because we cleverly combine various components: German engineering experts implement technical industry standards. European service providers ensure the continuous high availability of our products. 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

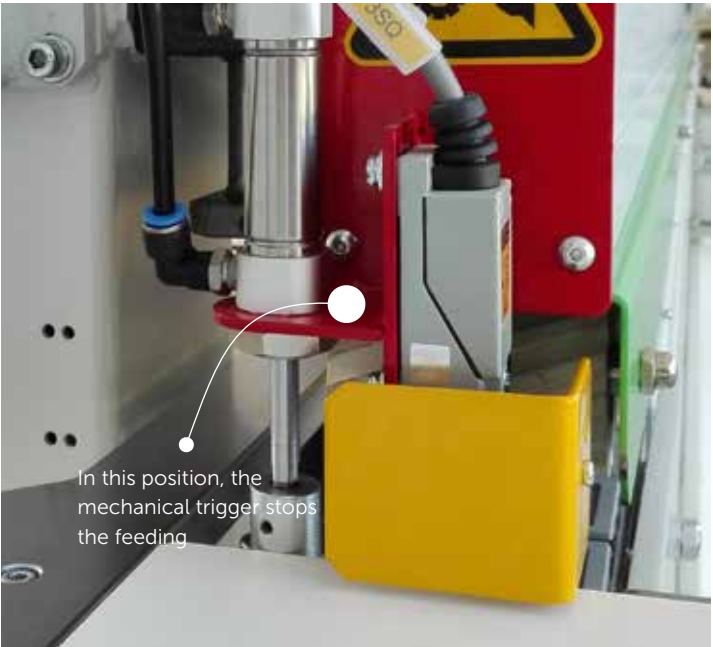
## Equipped for the cabinet manufacture



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.

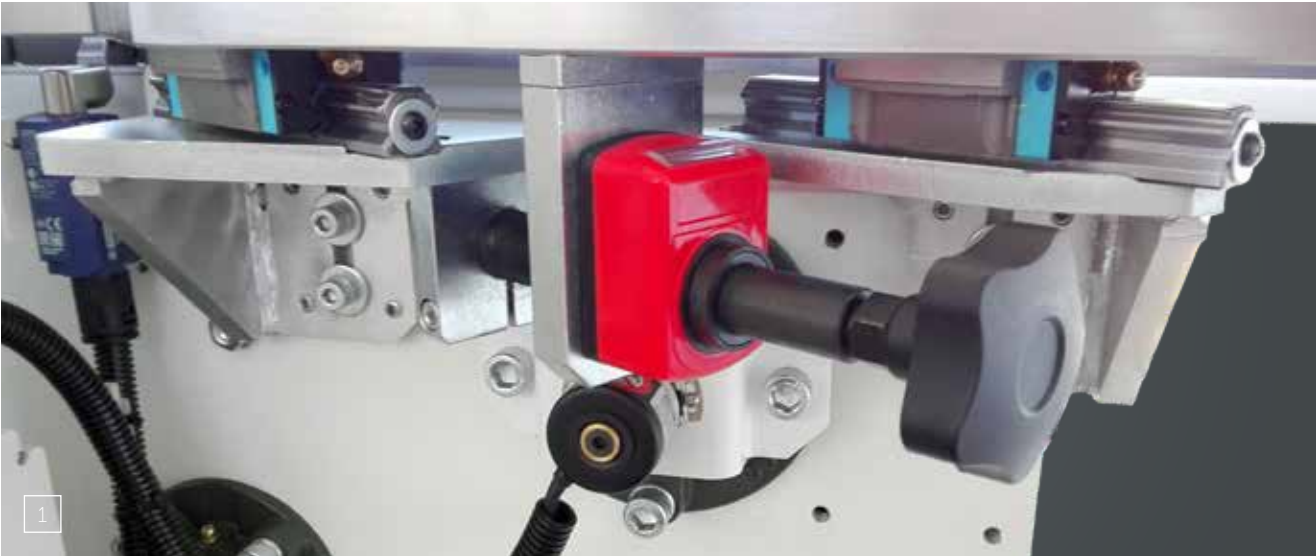
Every detail of the machine design serves only one purpose: Your perfect edge joint!





# Workpiece handling

Workpiece transportation is the foundation for a good edge

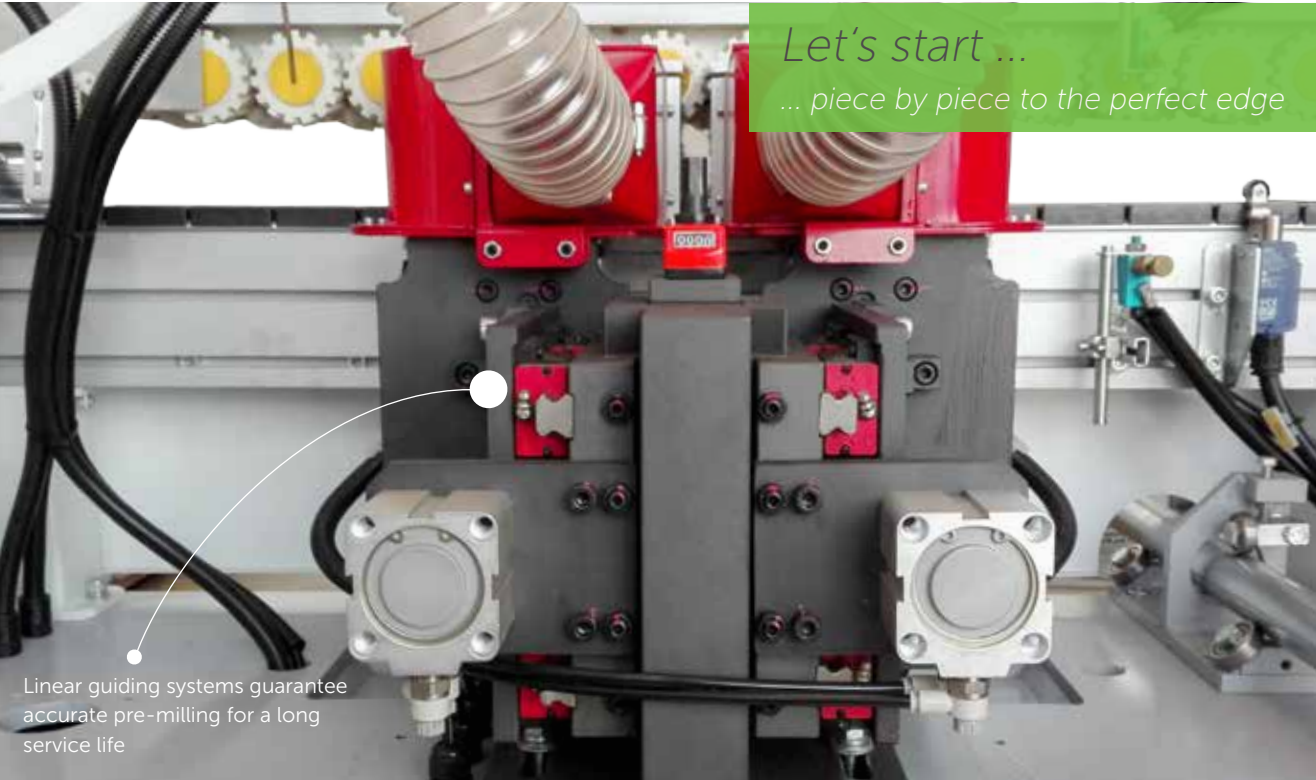


It all starts at the infeed ruler. The foundation for the perfect glue joint is the accurate infeed of the workpiece into the machine.

- 1 The high quality linear guiding system guarantees a high repeat accuracy and precision of adjustment.
- 2 The broad infeed ruler in connection with the high precision chain ensure the stressless infeed of the workpiece.



# Pre-milling unit



Linear guiding systems guarantee accurate pre-milling for a long service life



Precise spraying of adhesive in front of the premilling aggregate prevents the glue from adhering on the plate.

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.



Flow optimized guiding plates ensure a chip free glue joint and a clean glue pot.





## 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.



## Trimming aggregates with high repeatability

The base for the following processing steps



### 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.





## Rough and fine milling

With 2-point-adjustment

Rough milling für KAM 780 S IQ only



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.



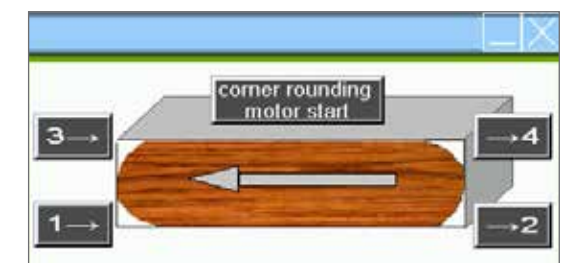
## Corner rounding unit



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



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.



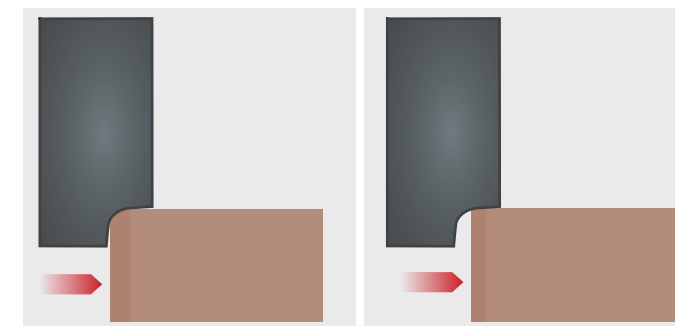
### Spraying device

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



## Lohmeyer finishing aggregates for your perfect joint

### Buffing unit



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 adhesive in front of the buffing unit. By using the appropriate adhesive (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



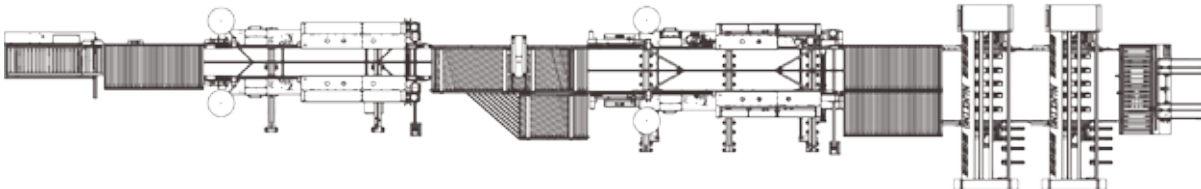
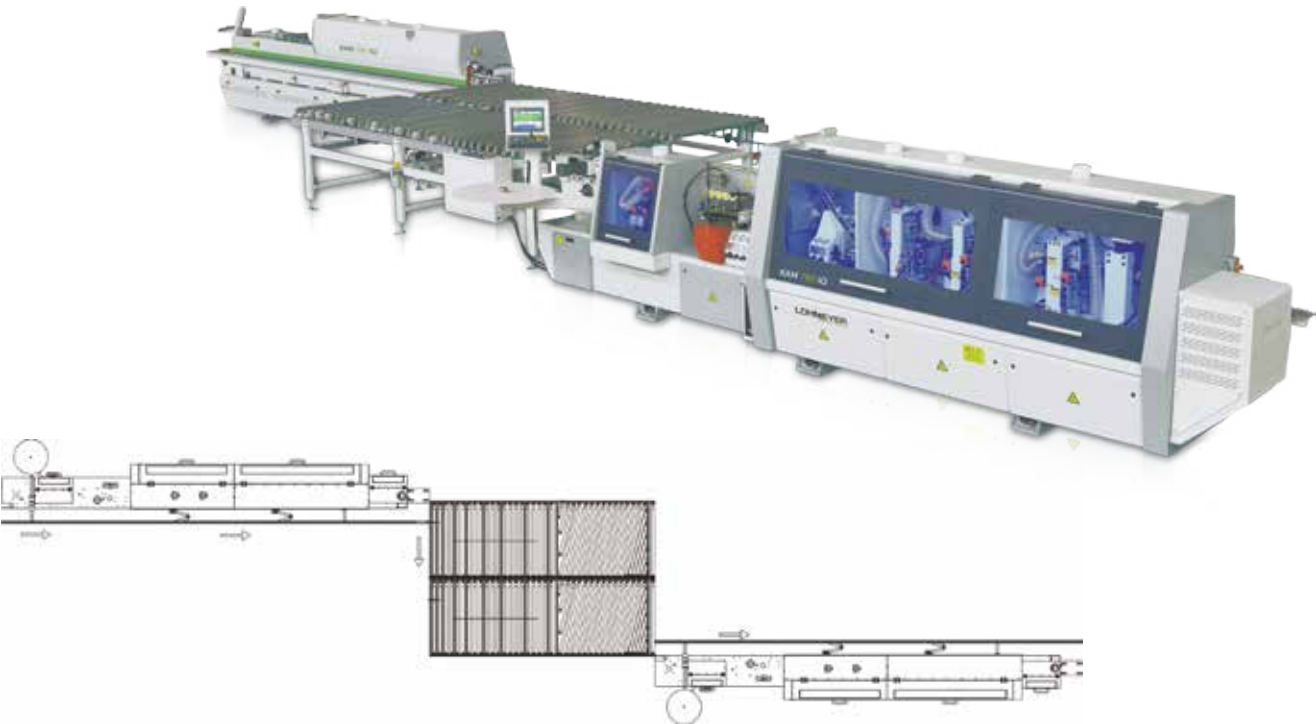
KAM 780 D IQ	
Pre-milling - inclined edge	
Pre-milling - straight edge	
Grooving	
Pressure zone and snipping	
Trimming	
Rough milling	
Fine milling	
Profile scraping	
Surface scraping	
Buffing	





partially inclined edge



Production lines with Lohmeyer edgebanders



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

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



Workpiece and edge parameters

	KAM 780 IQ	KAM 780 S IQ
<b>Workpiece thickness</b>		
• without pre-milling / without corner rounding	min. 10 mm – max. 60 mm	min. 10 mm – max. 60 mm
• with pre-milling	min. 10 mm – max. 30 mm	min. 10 mm – max. 30 mm
• with corner rounding	min. 10 mm – max. 45 mm	min. 10 mm – max. 45 mm
<b>Workpiece width</b>		
• without corner rounding	min. 80 mm	min. 80 mm
• with corner rounding	min. 130 mm	min. 130 mm
<b>Workpiece length</b>		
• without corner rounding	min. 120 mm	min. 120 mm
• with pre-milling	min. 320 mm	min. 320 mm
• with corner rounding	min. 140 mm	min. 140 mm
<b>Edge thickness</b>		
• without corner rounding	0.4 - 3 mm	0.4 - 3 mm for ABS / PVC / thin edges 2 - 8 mm for solid wood edges
• with corner rounding	1.2 - 3 mm	1.2 - 3 mm
<b>Edge width</b>		
• without pre-milling	15 - 65 mm	15 - 65 mm
• with pre-milling	15 - 43 mm	15 - 43 mm
<b>Electric equipment</b>		
• operating voltage	400 V – 3 phases – 50 Hz	400 V – 3 phases – 50 Hz
• frequency converter	electronically	electronically

All machines pictured are CE compliant. The machine equipment may vary from country to country. Subject to technical alterations.  
Wood IQ GmbH · 04/2017

Wood IQ GmbH  
Our Service – just smart



For detailed information on the edgebanders and other machines for cabinet manufacturing please refer to [www.lohmeyer-iq.com](http://www.lohmeyer-iq.com)



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