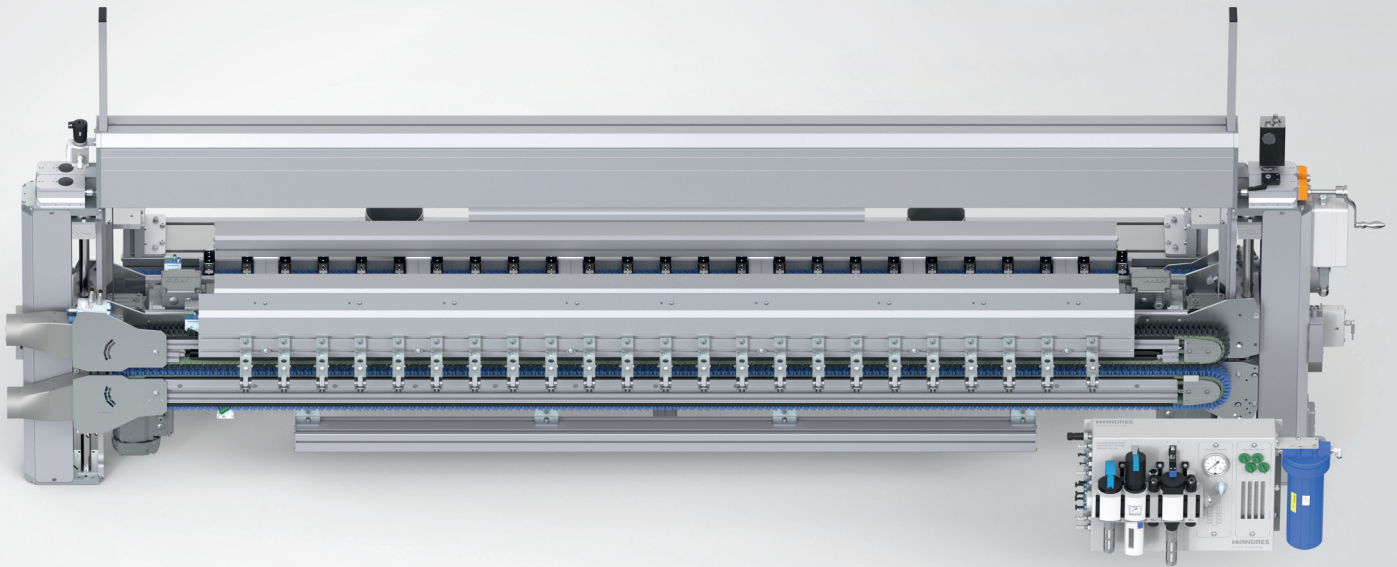


C-Line

Combi Sword Brush Una H-XFT 145 / Una H-XFT 146



Cleaning of wood-based panels prior to video inspection



Double-sided cleaning



Micro-moistening

With Una H-XFT 146:



Lifting of linear brushes at material edges



Tactile control elements and flexible pressure buffer



Pressure buffer

Optional:



Trans-Vac-Unit TKLO 100

The **Combi Sword Brush Una H-XFT 145 / 146** cleans wood-based panels from above and from below, e. g. after short cycle presses or prior to video inspection. Tactile control elements lift the upper linear brushes if there are sudden changes in the panel's thickness such as bursts. To provide for a consistent wiping pressure, the linear brushes are mounted on a pressure buffer

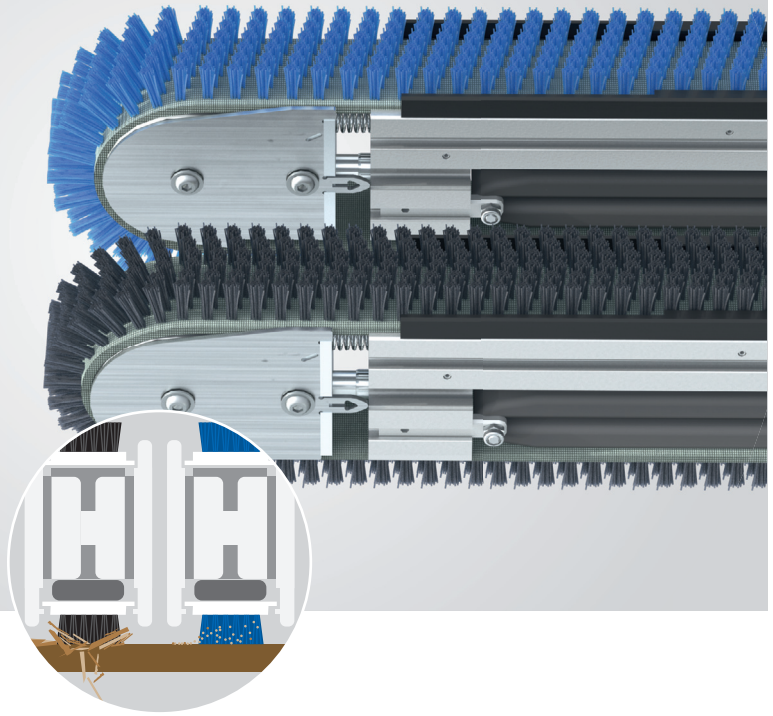
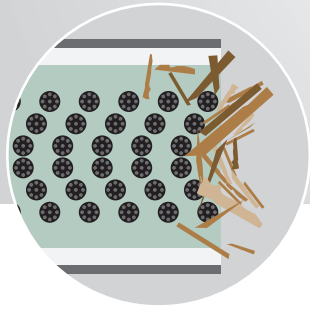
or a flexible pressure buffer that is controlled pneumatically. The Sword Brushes at the infeed of the machine eliminate edge strips and fragments. The Sword Brushes at the outfeed remove the remaining fine dusts. All linear brush filaments are micro-moistened according to the Ingromat® system thus allowing them to remove particles and dust effectively.



Multi-stage cleaning

Special linear brushes

The upper Sword Brush at the infeed pushes away coarse debris such as fragments or edge strips. This brush belt has stiff filaments ($\varnothing = 0.3 \text{ mm}$) that are positioned in a **V shaped** configuration across the belt surface. The upper and the lower brush at the outfeed work with the Ingromat® system. Their micro-moistened filaments ($\varnothing = 0.127 \text{ mm}$) remove even minute particles.



Adjustment to surfaces

Tactile control elements TSE 51

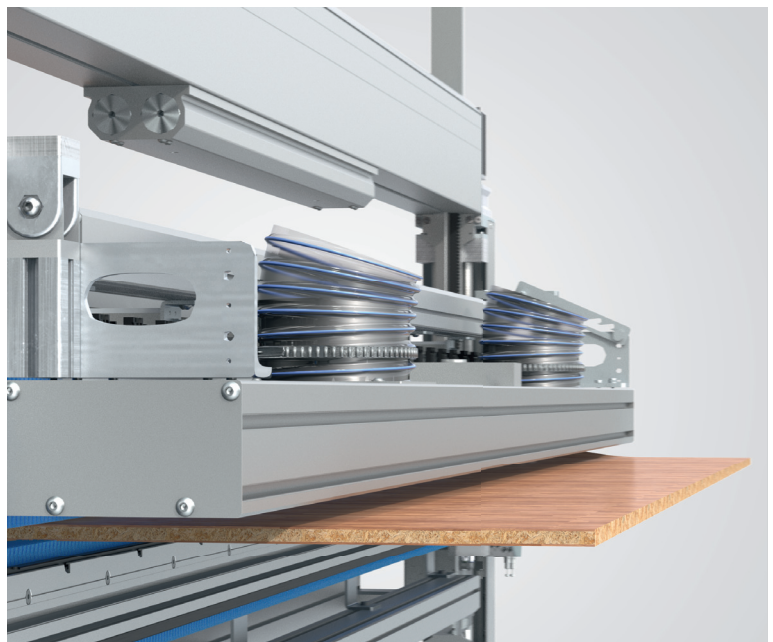
The **tactile control elements** will lift the linear brush guide up to 20 mm if faulty panels with thickness variations occur. The flexible pressure buffers of the upper Sword Brushes and the pressure buffers of the lower Sword Brushes provide for a consistent wiping pressure thus ensuring a high-quality cleaning performance. A **pneumatic quick adjustment (HVP)** is recommended. If production stops, it lifts the brushes via a short stroke and thus spares the material surface. If a crash is imminent, the HVP may rapidly raise the cleaning module into a safe position.

Optional

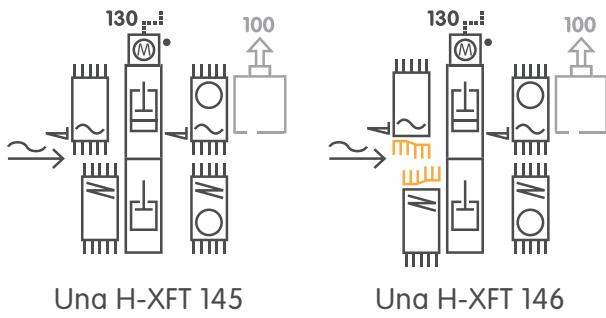
Non-contact cleaning

Trans-Vac-Unit TKLO 100

This unit may be mounted at the upper Sword Brush at the outfeed of the machine. It does not touch the surface, but efficiently sucks particles off the panel's surface. Particles that have previously been detached from the material's open edges and that have fallen onto the panel's surface can be removed reliably with this additional element. For maintenance purpose, the entire suction channel can be moved upwards.



Technical details and dimensions



Una H-XFT 145

Una H-XFT 146

2 x **Sword Brush BIF 51/1M/A** with flexible pressure buffer (from above)

Tactile control elements TSE 51 to lift the upper linear brush guide

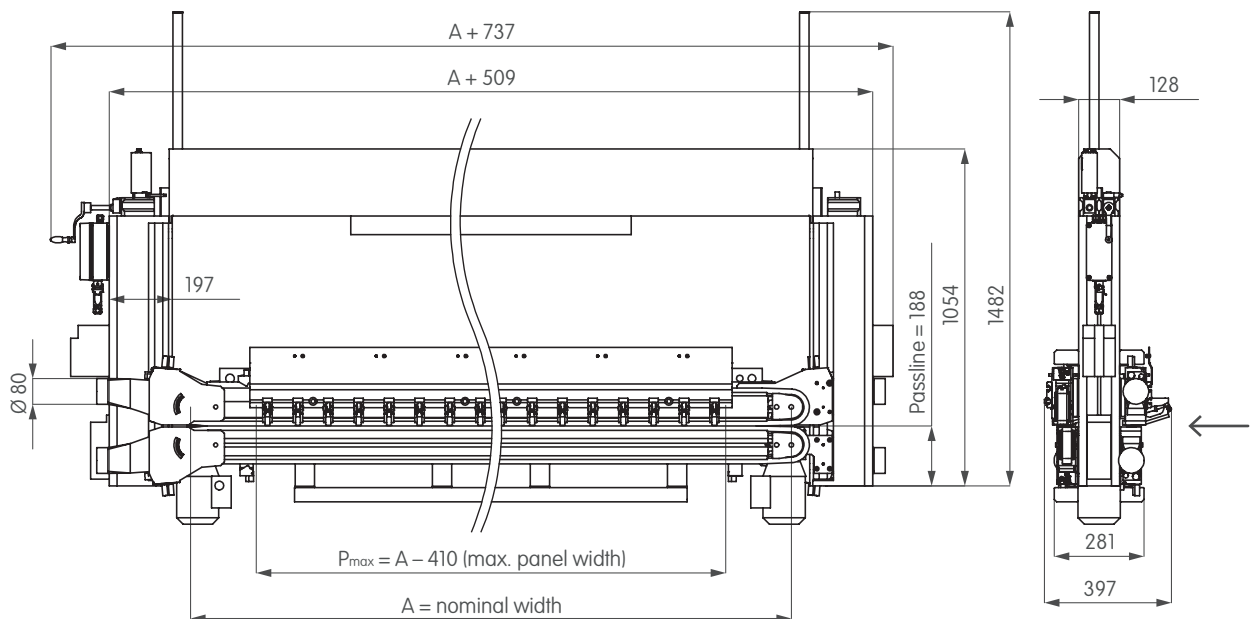
2 x **Sword Brush BIX 51/1M/A** with pressure buffer (from below) to ensure consistent brush pressure

With Una H-XFT 146 only: **Retaining clips** to lift linear brush guide at the machine's edges

1 x **Trans-Vac-Unit TKLO 100** (option)

Ingromat® system for the micro-moistening of the brush filaments including a regulator and filter unit (IR 100)

1 x **adjustment frame VEG 130** with or without electrical height adjustment HVE or pneumatic quick adjustment HVP (options)



A Nominal width of Sword Brush = distance between deviation roller shafts
 P_{max} max. width of panel = $A - 410$ mm

A in mm	1500	1650	1700	1750	1900	2000	2100	2200	2300
A in inches	59,06	64,96	66,93	68,89	74,80	78,74	82,68	86,61	90,55

A in mm	2500	2700	2750	2800	2900	3000	3100	3200	3400
A in inches	98,43	106,29	108,26	110,23	114,17	118,11	122,05	125,98	133,85

Technical data

Electrical details

Sword Brush drive motor	4 x 0.25 kW SEW motor, IP 54, compatible UL + CSA 50 Hz; Δ 220–240 V; 1.14 A; Υ 380–415 V; 0.66 A 60 Hz; Δ 240–266 V; 1.03 A; Υ 415–480 V; 0.6 A
Main valve (at IR unit)	2/2-way valve; 1 x 24 V DC each; 1.5 W
Electrical height adjustment HVE (option)	Motor PSE33; 24 V DC; 150 W; PROFINET intersection
Pneumatic quick adjustment HVP (option)	5/3-way valve: 2x 24 V DC; 1.08 W

Pneumatic details

Compressed air quality	filtered (particle size < 40 μ m), oil free (residual oil < 1.5 mg/m ³ at 24°C)
Compressed air connection	1 x G 1/2" female thread; 6 bar
Total compressed air consumption	960 l/min (at 1.013 bar and 20°C)

Fluidics

Ingromat® hose connection	1 x \varnothing 8 mm
Ingromat® consumption	0.8 l/h–3.2 l/h

Suction

Suction connection	4 x \varnothing 80 mm
Suction capacity	36 m ³ /min
Operating parameter	min. –500 Pa vacuum; min. 28 m/s (at suction connection)

Acoustic emission

Acoustic emission LPA	approx. 80 dB(A) depends on surface features and geometry of the subject panel
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Linear brush

Type of linear brush	at infeed above: Quadro V6; below and at outfeed: Quadro R6
Filament material	Polyamide 6.12
Filament length	17 mm
Filament- \varnothing	at infeed above: 0.3 mm; below and at outfeed: 0.127 mm

Transport speed

Max. transport speed	100 m/min
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Dimensions of subject panel

Min. panel length	$L_{\min} = 600$ mm
Min. panel width	$P_{\min} = 120$ mm
Max. panel width	$P_{\max} = A - 410$ mm

Technical data are subject to change