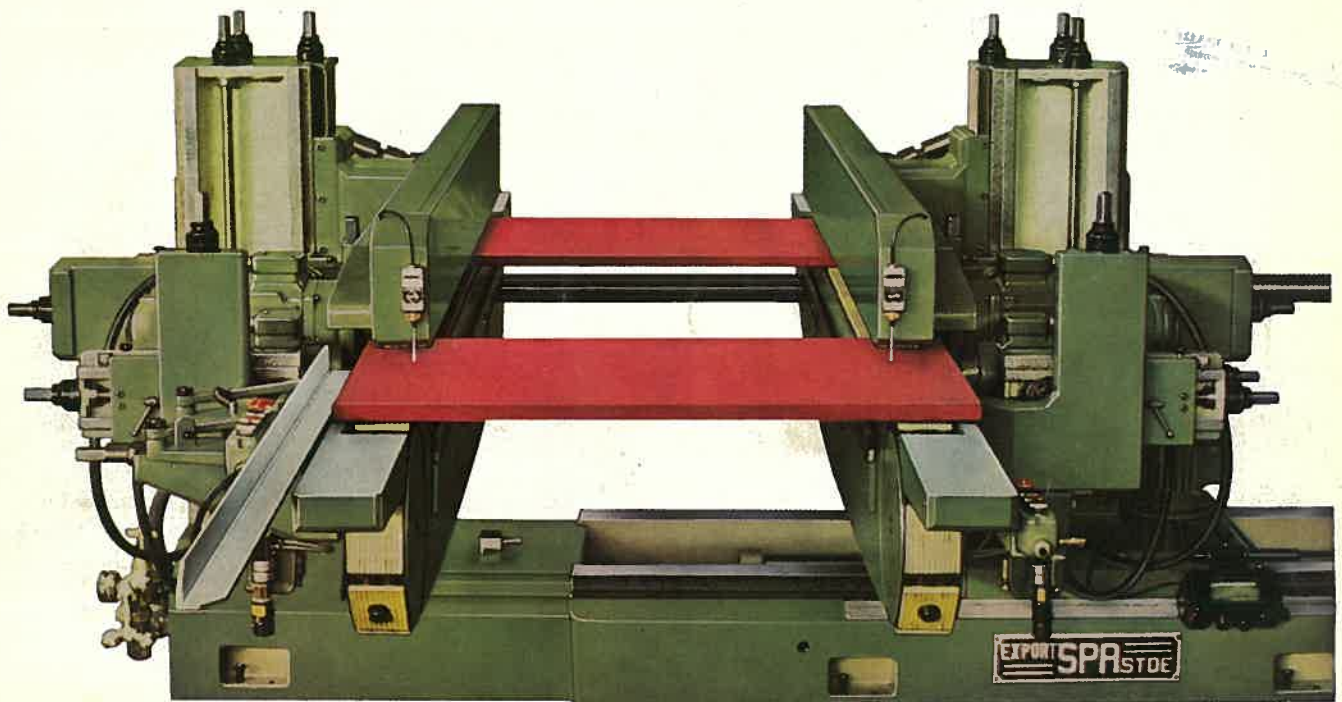


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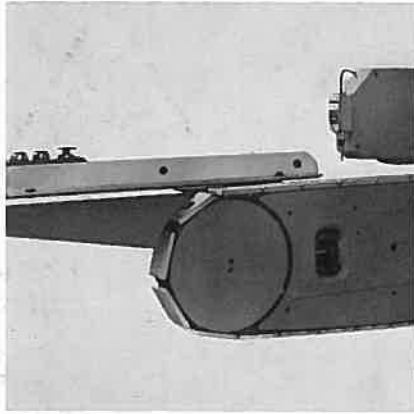


*SPA/STDE, the heavy  
double-end profile and tenoner*



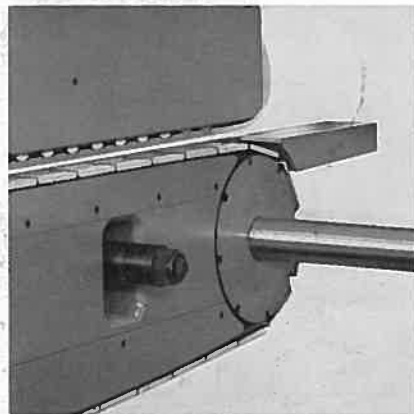
*The universal fully automatic, complete  
machine for the most exacting demands*

SPA Maschinen und Anlagen AG  
Ceresstr. 21 CH-8034 Zürich  
Tel. 01-55 23 77 Telex 55 335



Front part of the chain beam and pressure belt track, inside, with aluminum front extension table and spring-loaded fence. The picture also shows part of the moveable electric controls, the safety micro-switch with a sensor mounted on the pressure belt track and the chain-tensioning device.

The STDE double-end profile and tenoner is suitable for any job in the furniture and panel industry as well as in window and door manufacturing. It can be used together with the small series tenoners. Due to its simple construction and accessibility to the other operating assemblies, change over times are minimal.



Rear part of the chain beam and pressure belt track, inside, with the aluminum extension table and drive shaft for the feed chains. The motor spindle passes through the hole in the chain beam, so that it is possible to work on the inside of the chain beam as well.

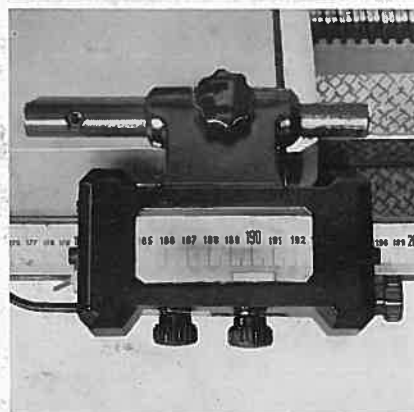
In its simplest version, it is a double-sided automatic sizing saw. The unit construction principle makes it possible to supplement the basic model with other available assemblies and develop this machine to do a complete variety of work. Machine and control desk, even in the basic model, have provisions for the subsequent additions of assemblies which can be done at any time without difficulty.

All cutter head motors can be used for clockwise or counterclockwise rotation and can be used with or without a frequency changer. The separate electrical control desk is, on all models, provided for subsequent addition of a frequency changer.



Jump shaping unit with a pneumatically controlled slip on head for jump movement and for doubling the motor speed. Control by adjustable microswitches, or by numerical programmator.

With regard to operational safety, accident prevention and simplicity in operation, the electric motors, switches and wiring are in line with the latest technical knowledge and international regulations. On every machine, the control panel is supplemented by two moveable control units which make it possible to control and monitor the machine from various positions.



Illuminated vernier with micrometric graduation for checking the measurement between chain beam.

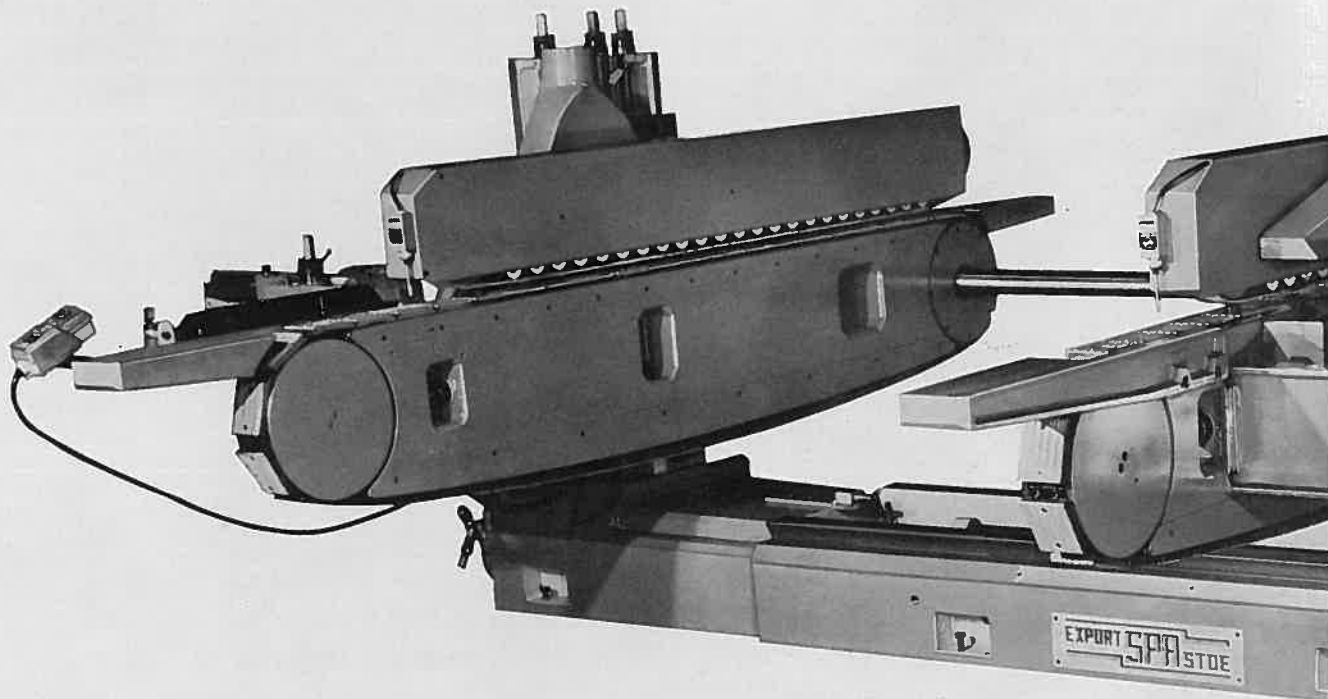
The feed chains are driven by a separate electric motor through a variable speed gearing offering infinitely variable control of the feed. For particular manufacturing conditions, our machines can be designed for extremely low or especially high rates of feed.

Lateral adjustment of the right-hand moveable working part is likewise performed by a separate electric motor with a handwheel for fine adjustment. An illuminated vernier facilitates reading and makes it possible to adjust the desired position accurately.

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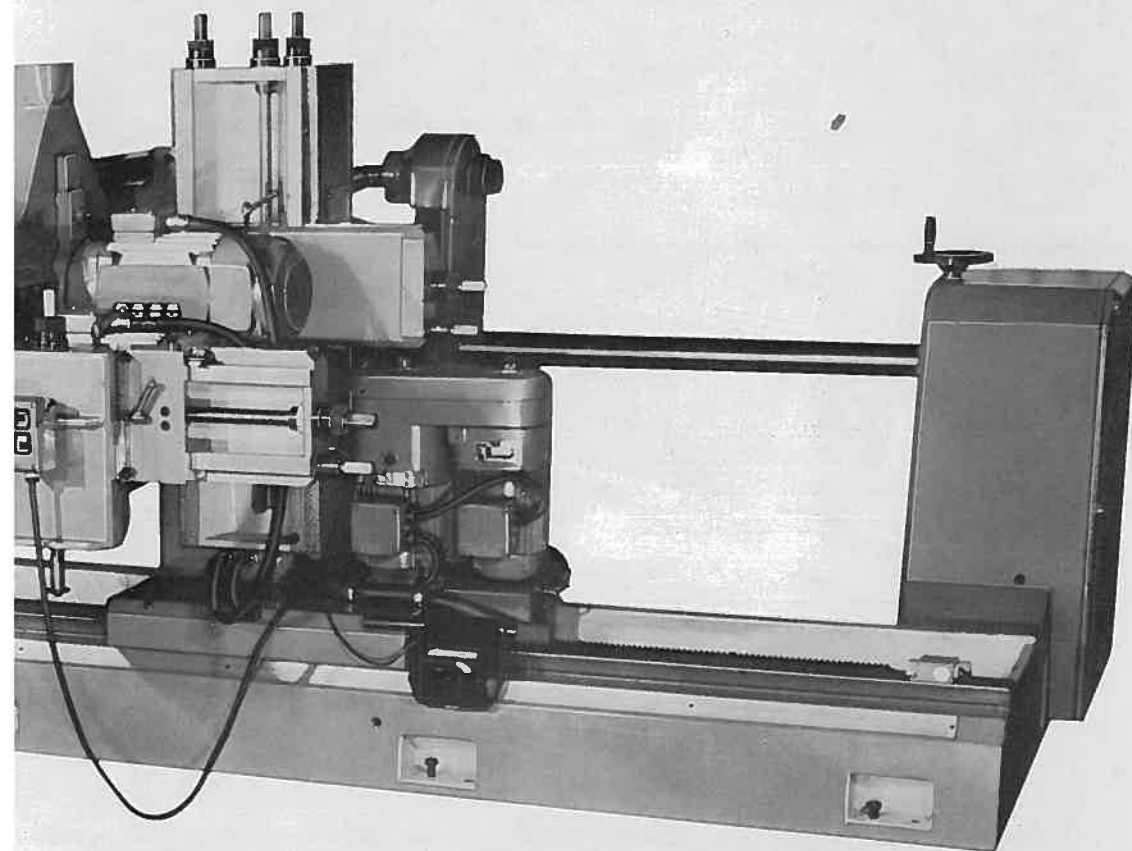
*SPA double-end profile and tenoners are operating on all five continents under the most widely diverse conditions – probably the best proof of their quality and reliability.*

SPA double-end profile and tenoners are suitable not only for manual feeding but also for incorporation into automatic production lines.



Do you know that at the present time SPA is the only concern in the world which, entirely in its own plant, plans, designs and manufactures entire fully automatic production lines with stackers, double-end profile and tenoners, rotary stations or angle transfer stations and delivery units?

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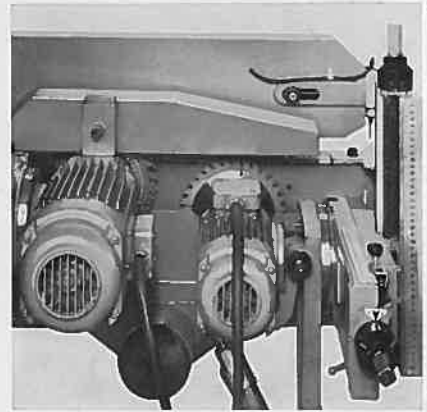
The most important requirement of a double-end profiler and tenoner is accuracy. This depends on a number of factors: the base of the machine, the guides used for the adjustable working parts, the feed chain and the dogs, the upper pressure belt, the drive shaft for the feed chain, etc.

All SPA double-end profile and tenoner models have heavy torsion-free cast iron bases. The adjustable working parts slide in large-dimensioned dovetail guides with minimum tolerance; automatic lubrication prevents any wear on the guides. The high accuracy adjustable tension feed chains run clearance-free in rexilon guides. Cylindrical eccentrically mounted and adjustable dogs permit instant and accurate adjustments for squareness. The strong, profiled top pressure belts run over a number of double nylon pressure rollers, to achieve an even pressure with the narrowest workpieces. Special gear units allow the pressure belt to run with a speed of approximately 3% higher than the feed chains; thus, the workpieces are kept tight up against the dogs while passing through the machine. Transmission of the drive to the pressure belt is through a strong disengageable clutch. When feeding material with the dogs pushing, the clutch is disengaged. The feed chain drive shaft is particularly heavy and is made from virtually torsion-free special steel machined to a high degree on accuracy.

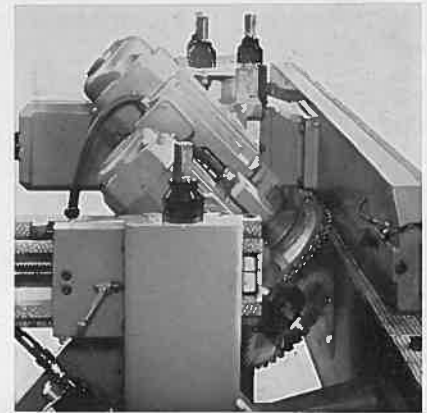
All these factors, combined with maximum care in manufacture and assembly and many years of experience in the manufacture of this equipment make a substantial contribution to the accuracy of the SPA double-end profile and tenoner.

What makes SPA units top flight products in the world market, however, is not only their working accuracy but also their high efficiency: even in the most demanding situation of continuous operation, it is always possible to work at high speeds without failure.

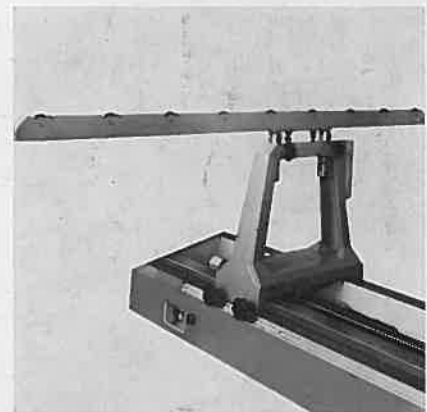
Motor assembly with scoring saw. The pneumatically controlled jump scoring saw is mounted on the chain beam, independent of the circular saw. Both motors can be tilted. The scoring saw is also available without pneumatic control.



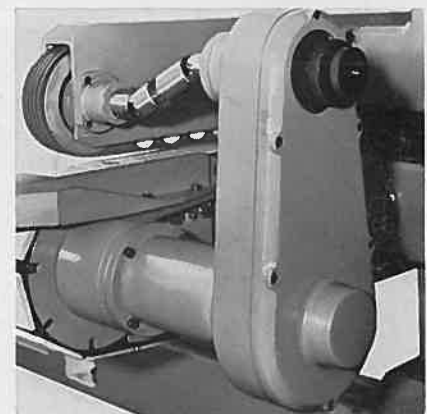
Motor assembly with cutoff and scoring saw, in a tilted position, seen from the front. The scoring saw is independent of the circular saw, and designed for pneumatic jump.



Center table to support heavy material, adjustable vertically and laterally. A similar unit can be supplied with a circular saw motor, as a center cutting circular saw.

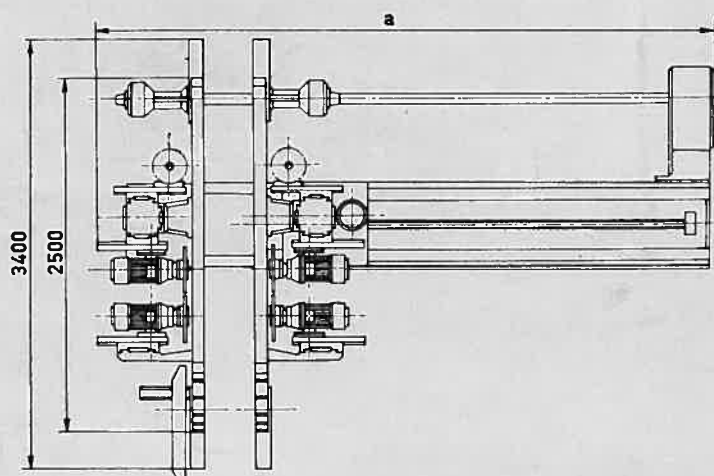


Drive unit for the top pressure belt. Chain drive with disengageable single plate clutch and flexible shaft. The top pressure belts run approximately 3% faster than feed chains, so that the workpiece is kept constantly against the chain dogs as the material passes through the machine.



## Specifications

	STDE 1	STDE 2	STDE 3	STDE 4	STDE 5	STDE 6
Operating width	200–1700 mm	200–2200 mm	200–2700 mm	200–3200 mm	200–3700 mm	200–4200 mm
Operating length	unlimited	unlimited	unlimited	unlimited	unlimited	unlimited
Operating height	150 mm	150 mm	150 mm	150 mm	150 mm	150 mm
Distance between dogs	420 mm	420 mm	420 mm	420 mm	420 mm	420 mm
Rates of feed	3–18 m/min or 5–30 m/min	3–18 m/min 5–30 m/min	3–18 m/min 5–30 m/min	3–18 m/min 5–30 m/min	3–18 m/min 5–30 m/min	3–18 m/min 5–30 m/min
Output from the moveable working motors	6/7.5 hp	6/7.5 hp	6/7.5 hp	6/7.5 hp	6/7.5 hp	6/7.5 hp
Output of the scoring saw motors	1.5/2 hp	1.5/2 hp	1.5/2 hp	1.5/2 hp	1.5/2 hp	1.5/2 hp
Output of the feed motor	2/3 hp	2/3 hp	2/3 hp	2/3 hp	2/3 hp	2/3 hp
Output of the lateral adjustment motor	2 hp	2 hp	2 hp	2 hp	2 hp	2 hp
Working shaft speeds without frequency changer	3000 rpm	3000 rpm	3000 rpm	3000 rpm	3000 rpm	3000 rpm
Working shaft speeds with frequency changer	6000 rpm	6000 rpm	6000 rpm	6000 rpm	6000 rpm	6000 rpm
Weights (according to equipment)	3700 kg	3900 kg	4100 kg	4300 kg	4500 kg	4700 kg
For special working conditions, our machines can be equipped with lower or higher rates of feed.						
Subject to modification in design and specifications, without notice.						



Working width	Dimension a
1700 mm	3660 mm
2200 mm	4160 mm
2700 mm	4660 mm
3200 mm	5160 mm
3700 mm	5660 mm
4200 mm	6160 mm

Look for this sign



the symbol of automation in woodworking