

CabinetMaker CNC

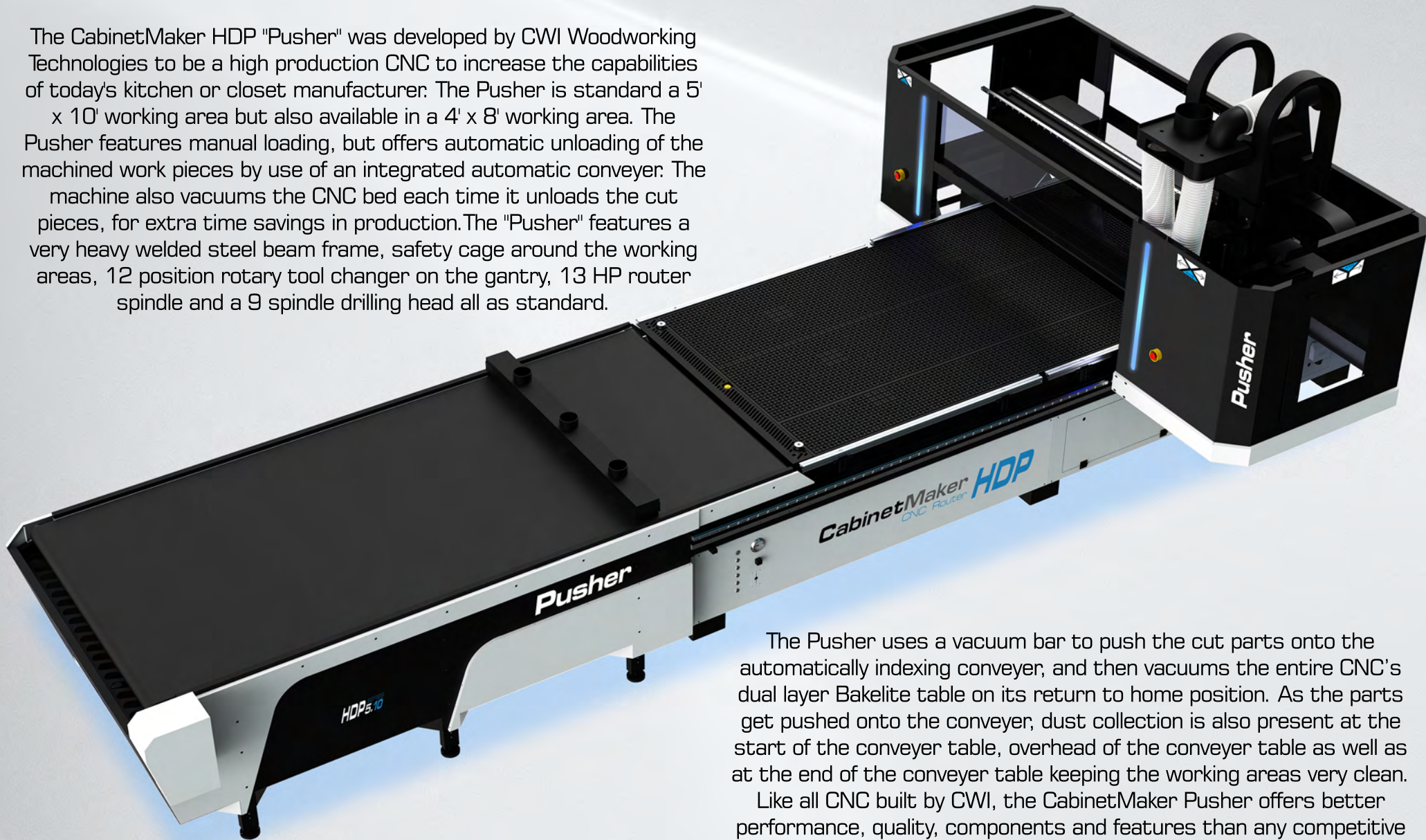
World Class Industrial CNC Routers



CabinetMaker HDP5.10

CabinetMaker HDP

The CabinetMaker HDP "Pusher" was developed by CWI Woodworking Technologies to be a high production CNC to increase the capabilities of today's kitchen or closet manufacturer. The Pusher is standard a 5' x 10' working area but also available in a 4' x 8' working area. The Pusher features manual loading, but offers automatic unloading of the machined work pieces by use of an integrated automatic conveyor. The machine also vacuums the CNC bed each time it unloads the cut pieces, for extra time savings in production. The "Pusher" features a very heavy welded steel beam frame, safety cage around the working areas, 12 position rotary tool changer on the gantry, 13 HP router spindle and a 9 spindle drilling head all as standard.

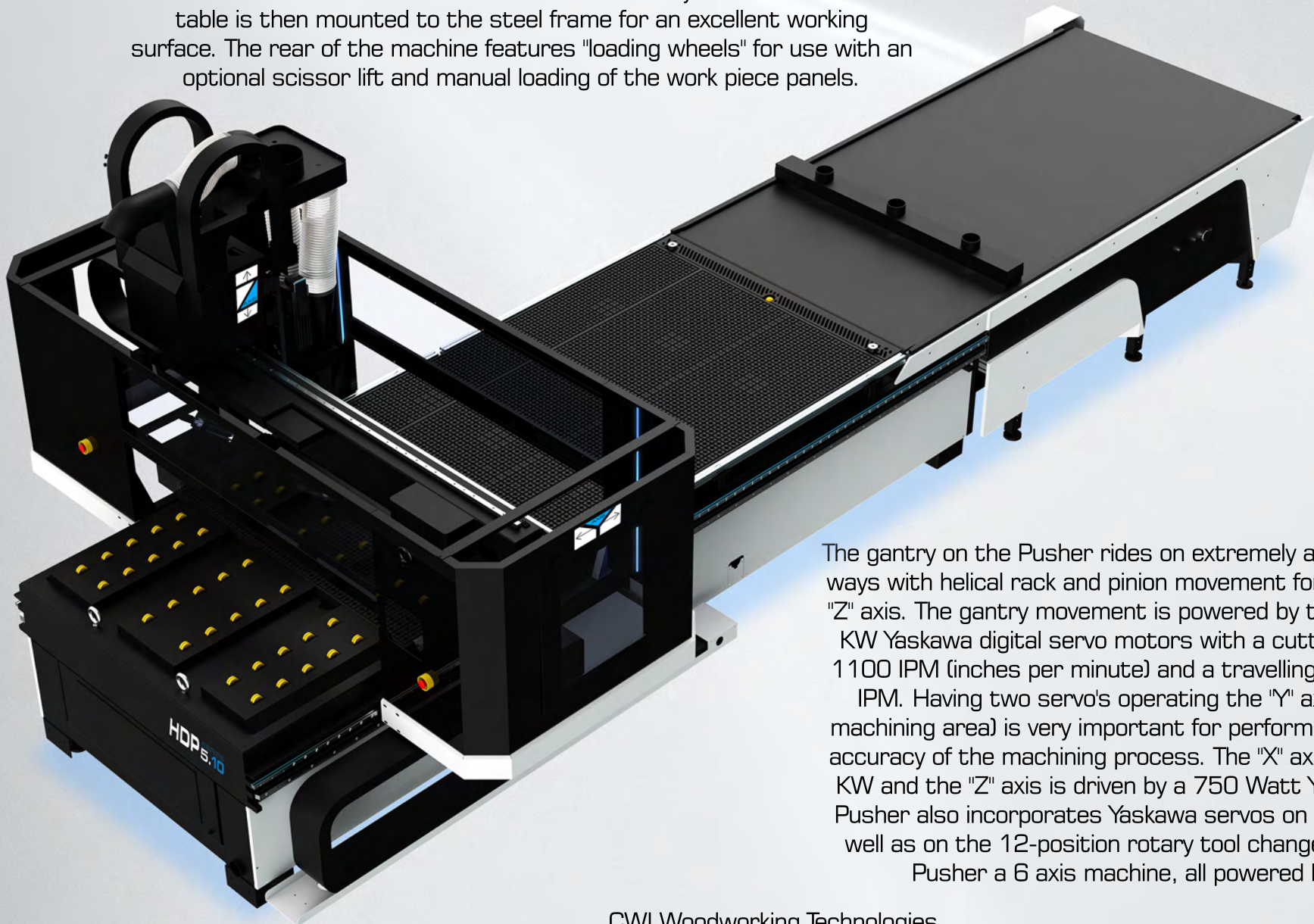


The Pusher uses a vacuum bar to push the cut parts onto the automatically indexing conveyor, and then vacuums the entire CNC's dual layer Bakelite table on its return to home position. As the parts get pushed onto the conveyor, dust collection is also present at the start of the conveyor table, overhead of the conveyor table as well as at the end of the conveyor table keeping the working areas very clean.

Like all CNC built by CWI, the CabinetMaker Pusher offers better performance, quality, components and features than any competitive machine in its class.

CabinetMaker HDP

The foundation of the machine is a 6000 pound very heavy duty welded steel beam floor model frame. The Six Zone dual layer Bakelite vacuum table is then mounted to the steel frame for an excellent working surface. The rear of the machine features "loading wheels" for use with an optional scissor lift and manual loading of the work piece panels.

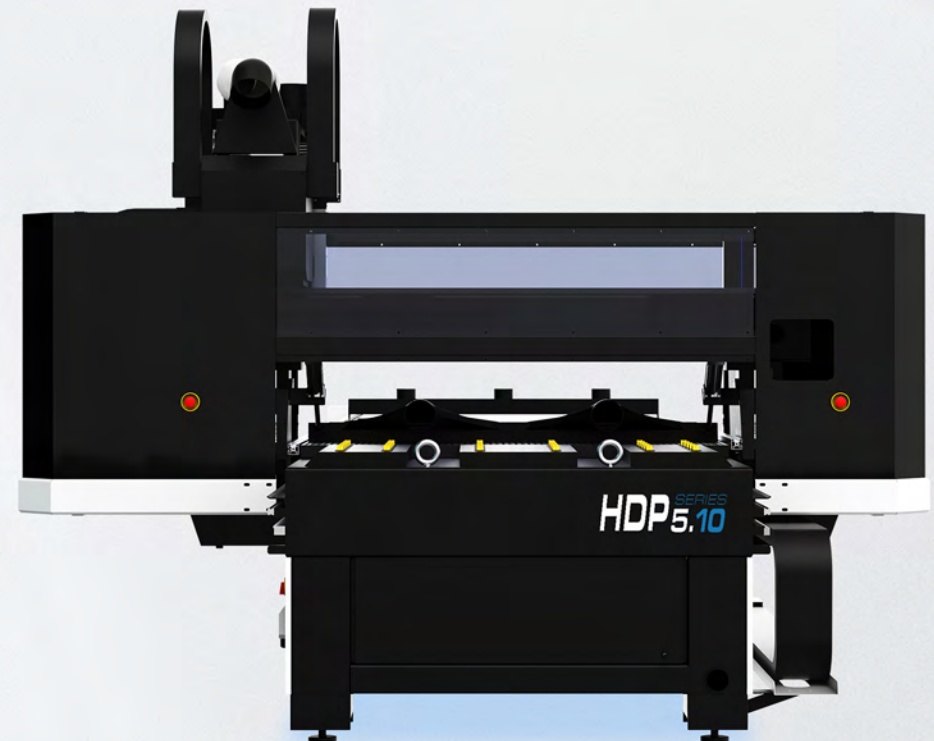
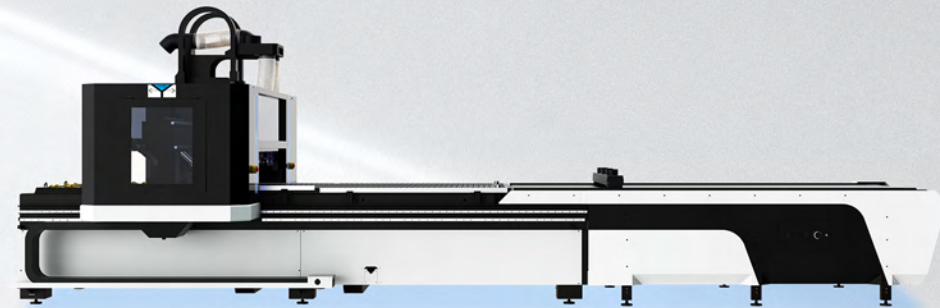


The gantry on the Pusher rides on extremely accurate linear guide ways with helical rack and pinion movement for each of "X", "Y" and "Z" axis. The gantry movement is powered by two very strong 1.3 KW Yaskawa digital servo motors with a cutting speed of up to 1100 IPM (inches per minute) and a travelling speed up to 3500 IPM. Having two servo's operating the "Y" axis (length of the machining area) is very important for performance, strength and accuracy of the machining process. The "X" axis is driven by a 1.3 KW and the "Z" axis is driven by a 750 Watt Yaskawa servo. The Pusher also incorporates Yaskawa servos on the drilling head as well as on the 12-position rotary tool changer. This makes the Pusher a 6 axis machine, all powered by Yaskawa.

CabinetMaker HDP

The gantry and working areas of the machine are surrounded by a safety cabinet with emergency stops on all four sides of the machine. Each of the spindles use automatic dust hoods with 6" hoses to a main 8" dust collection inlet above the machine. There are pneumatically controlled connections to the drill head, router spindle and pusher bar for cleaning the table surface.

The router spindle is a high quality continuous duty cycle, Italian made HSD 9.6kw (13 HP) HSK-63 three phase motor which comes with 1/4", 3/8", 1/2" and 20mm high precision ER32 collets. HSD is one of the leading manufacturers of CNC spindles throughout the world and are used on all CWI high production CNC's. The Italian made HSD 1.7 KW 9 spindle drilling head offers 32mm increments in an "L" shape allowing up to 5 shelf holes to be drilled at a time. The advantage of the drilling head alongside the router spindle is it allows the machine to drill shelf holes, 8mm and 35mm holes without the machine having to take the time to change tool holders. Also improving machining speed is the rotary tool holder attached to the gantry with 12 holder positions (16 and 20 Positions Optional) for the HSK-63 chucks and tooling. Having the tool changer on the gantry saves time in the machining process so the spindle only travels to the end of the gantry to load tools instead of traveling to the back of the machine. At the back of the machine is a tool changing station and wrench for quick and easy changes of tooling. There are two tool measuring devices on the machine, one at the back of the machine for automatic measures and a second moveable one for measuring tools "on the go". An automatic centralized lubrication system is standard making maintenance on the Japanese THK linear guideways a simple process.



CabinetMaker HDP

The machining area of the HDP5.10 Pusher is oversized for convenience at 61 3/4" x 121 1/2" with a clearance height under the pusher bar of 2".

For ease of loading panels on the machine there are two pneumatic guide rails (one of each side of machine) as well as two pneumatic pins at the top end of the machine. This allows operators to load and square sheets to the right side or left side of the table. No mistaking where your router bit will find the work piece.



CabinetMaker HDP

The electrical components and controls of the Pusher are conveniently enclosed in the base of the machine with easy access doors. Here you will find Siemens CSA contactors, fuses and holders, Delta Inverter, Omron safety switch controls, and Yaskawa Digital Servo controls. We use Omron micro limit switches for controlling stops and movements of the home positioning.

The Pusher is fully CSA certified for use in Canadian commercial applications or anywhere users need higher quality electrical protection. The Syntec 21MA-E controller and keyboard are mounted to a separate mobile operations stand for ease of control of the operations of the machine. Also included is a magnetic hand held manual controller. The manual controller lets the operator make trial runs of a program with a hand operated dial. This allows testing of a program or cutting height without danger or to make quick to adjustments in the program for accidental tooling issues.



Options:

- Working Area 4' x 8'
- Automatic Loading
- Single Phase Electrics
- Software
- Tooling
- Delivery and installation
- Training



Also included with the Pusher is the German made Becker 300 cubic meter per hour vacuum pump which offers plenty of holding power to keep parts in place while machining. The six vacuum zones are operated by 6 electrical push button actuated valves for simple operation.

CabinetMaker HDP

Machine Specifications:

Working size: 61 3/4" x 121 1/2" x 2" (5' x 10') (Optional 4' x 8' Available)
13 HP (9.6 KW)(S1) HSD HSK-63 Italian ATC Industrial Air Cooled Spindle
Servo Controlled 9 Spindle HSD 1.7 KW Italian made Drilling head
Pusher Bar with Vacuum to unload panels and clean work table
Pneumatically Controlled Vacuum Connections (8" Port)
Servo Controlled 12 Positions Rotary Tool Holder Magazine (16 or 20 Optional)
Automatic Tool Measuring System w/Pneumatic Clean Device
Additional Moveable Manual Tool Measure
Automatic Lubrication System
HSK-63 Tool Holders (One Included w/machine)
ER32 Collets (1/4", 1/2" 3/8" and 20mm Included with machine)
Tool Holder Wrench
Convenient Tool Changing Station
Bakelite Dual Layer Vacuum Table w/Six Zone Control
Electronic Valves 6 Push Button Zone Activation
Becker 300 cm/h German Made Vacuum Pump
Syntec 21MA-E Control System
Under Table Electronics Cabinet w/Easy access Door
USB Information Transfer Ports
Magnetic Manual Machine Movement Controller
Yaskawa Digital 1.3 KW x 3 and 750 Watt x 3 Servo Drivers and Motors
Pneumatic Guide Rails and Reference Pins (for aligning work piece)
Japanese Omron Limit Micro Switches
DELTA Three Phase Motor Inverter
SHIMPO Servo Gear Reducers
German Helical Rack & Pinion
Robust Cable Holding Carrier Rated for over 300,000 bends
Traveling Speed 90M/min (3540"/min)
Siemens CSA Contactors and Breakers
Japanese Omron Limit Micro Switches
CSA Certification
THK Linear Rails
3PH 220V 60HZ (80 amp Breaker Required)
Shipping Weight 6000 lbs



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