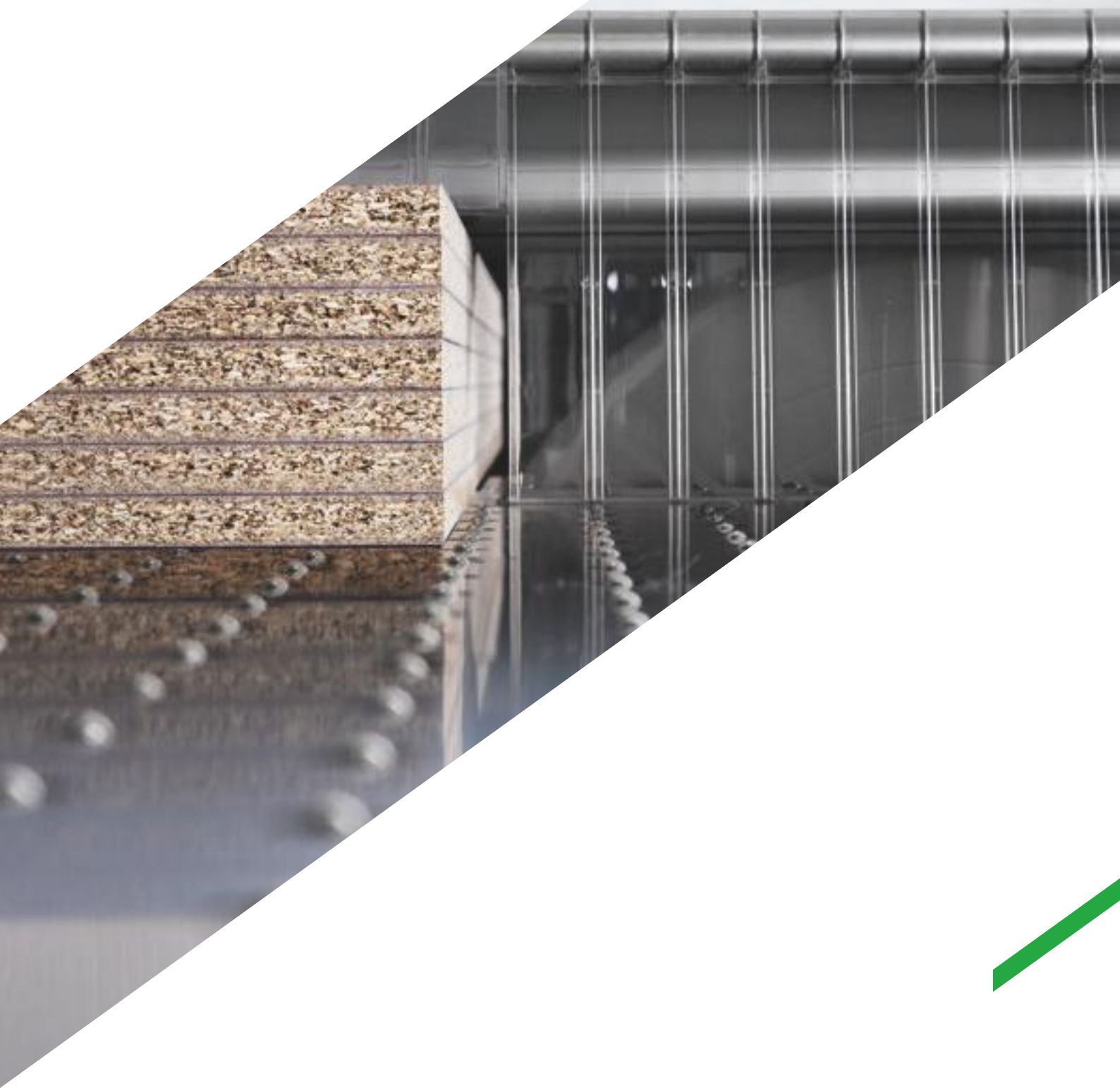
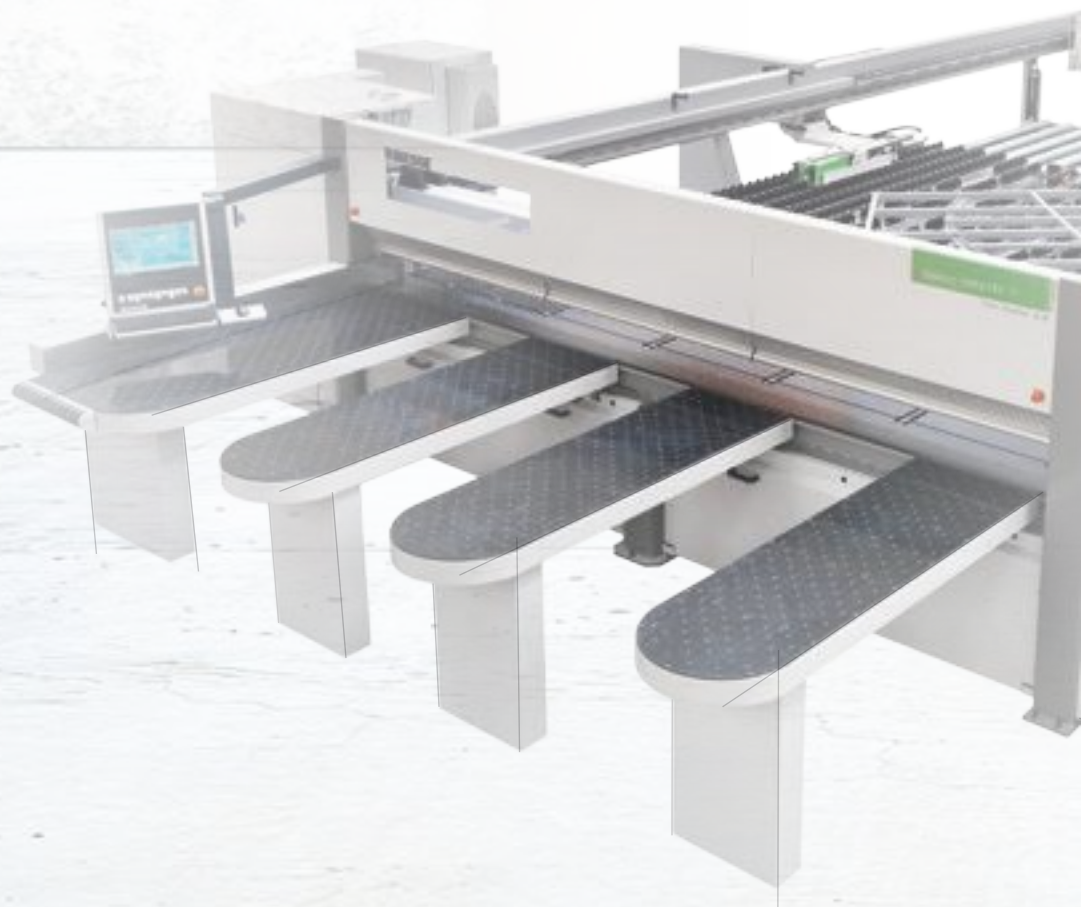


BIESSE SELCO WN 7

Numeric controlled panel sizing centre



When competitiveness
means boosting
performance




Made **In** Biesse

The market demands

a change in manufacturing processes that enables companies to **accept the largest possible number of orders**. This is coupled with the need to maintain high quality standards while offering product customisation with **quick and defined delivery times**, as well as responding to the needs of most automated companies.

Biesse meets these requirements

with technological solutions that highlight and support technical expertise as well as process and material knowledge. **SELCO WN 7** is the result of continuous innovations aimed at increasing productivity and guaranteeing the overall quality of the machining operations. **SELCO WN 7** is positioned at the top of the range of beam saws with one cutting line: high performance in reduced times, to meet the needs of medium and large furniture-making companies.

- 
- A large industrial beam saw machine, the SELCO WN 7, is shown in the background. It has a long, horizontal cutting table with a grid pattern and a large, white, box-like structure on the left side. The machine is set in a clean, industrial environment.
- ✓ **Top cutting quality.**
 - ✓ **Machining precision.**
 - ✓ **Quick, simple adjustments.**
 - ✓ **Load optimisation for large volumes.**
 - ✓ **Productivity increase of up to 60%.**

High productivity technology

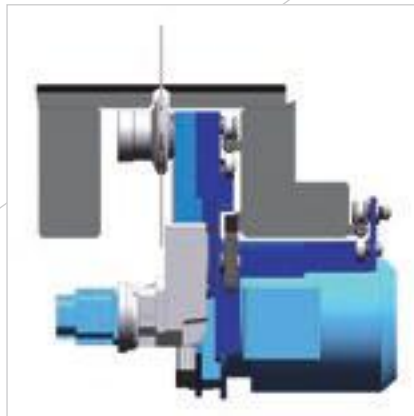


SELCO WN 7
Sezionatrici a controllo numerico



Top cutting quality

The solid structure of the base guarantees consistent quality and reliability, thanks to the perfect machining stability.



The optimum balancing and weight distribution on the two guides ensures the total absence of vibrations and perfectly straight cuts.

Top product quality, thanks to the air cushioned working surface, which protects delicate materials. In addition, this characteristic ensures the surface next to the blade is kept constantly clean.



The anti-slide device controls the blade position and number of rotations, intervening to adjust the advance speed. **Maximum cutting quality, a longer blade lifespan, and reduced maintenance costs.**



The motorised vertical blade adjustment ensures **precise, quick adjustment** of blade protrusion.



The single presser blocks the panels to be cut with evenly distributed and controlled pressure, guaranteeing excellent cutting quality.

The pressure systems have an efficient suction system that guarantees the cutting quality, ensuring the area is always kept clean during the machining operation.

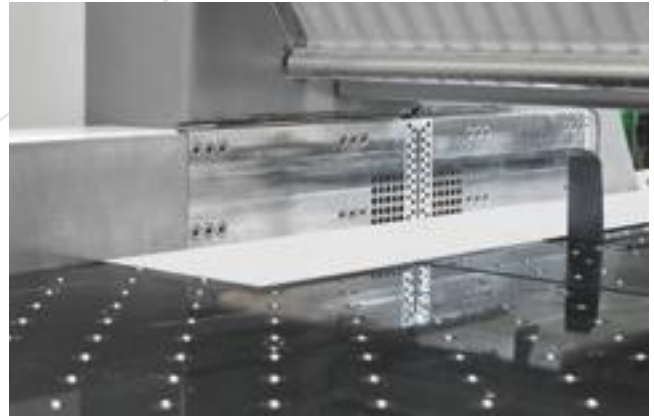


The double presser has a split, independent structure that ensures even, controlled pressure on the book of panels to be cut thanks to the absence of openings for the grippers. It creates a real airtight chamber for rough trim cuts, allowing the dust to be completely removed.



Machining precision

Thanks to the side aligners integrated in the blade carriage, perfect positioning is possible even with very thin and/or flexible panels, thereby minimising cycle times.



Cutting line closure system, to prevent the longitudinal trim cuts from falling into the machine and fouling the blade path.



The robust pusher carriage accurately and quickly positions the panels thanks to its brushless motor. The slide surface below the pushing device is fitted with independent rollers to avoid making any marks on panels with a delicate surface.



Independent and self-levelling grippers ensure the book of panels is firmly secured and aligned. The design of the system completely ejects the cut panels making it easier for the operator to handle both the panels and waste.



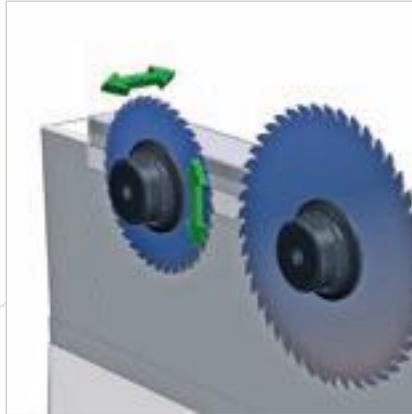
Powerful front aligners align the book of panels against the pushing device collets.

Tooling in just a few seconds

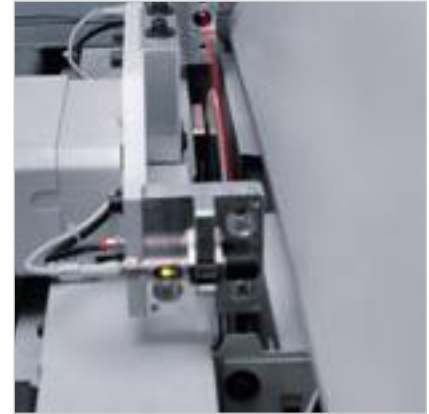
Patented systems for quick, simple adjustments.



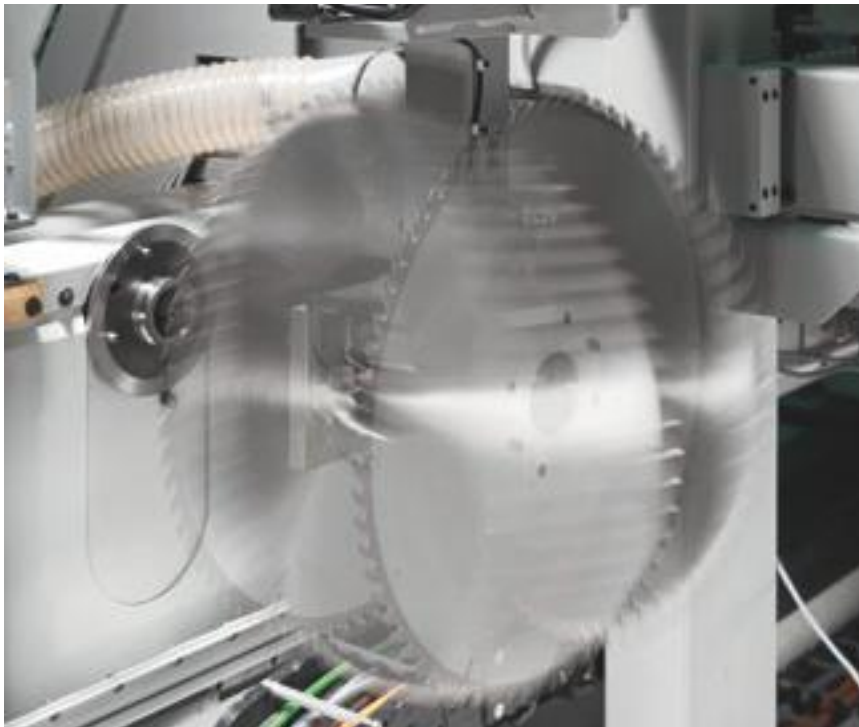
The “Quick change” system is the **fastest, safest and most ergonomic** device for replacing the blades without using tools.



Fast, accurate setting of the scoring and main blades, using Digiset system.



Automatic alignment. The patented system automatically aligns the scoring blade in seconds, which completely eliminates test cuts, reduces set-up time which increases efficiency and reduces production costs.



Thanks to the automated main blade change system, and the relative software, the blade can be replaced **completely automatically in just a few seconds, ensuring precise adjustment** and reducing cycle times.

Optimised loading for large volumes

On request special solutions are available for the movement of packs and to permit the loading and unloading of panels.



The rotating station (patented) rotates the book of panels, maintaining the alignment with the point of reference both before and after the rotation. Panel clamping devices avoid the misalignment of the stack during the rotation phase.



The lift table consists of a strong frame and is equipped with a special structure to load the pack of panels directly by forklift.



Infeed conveyors with free-running or powered rollers allow the loading and side or rear unloading of the panels.



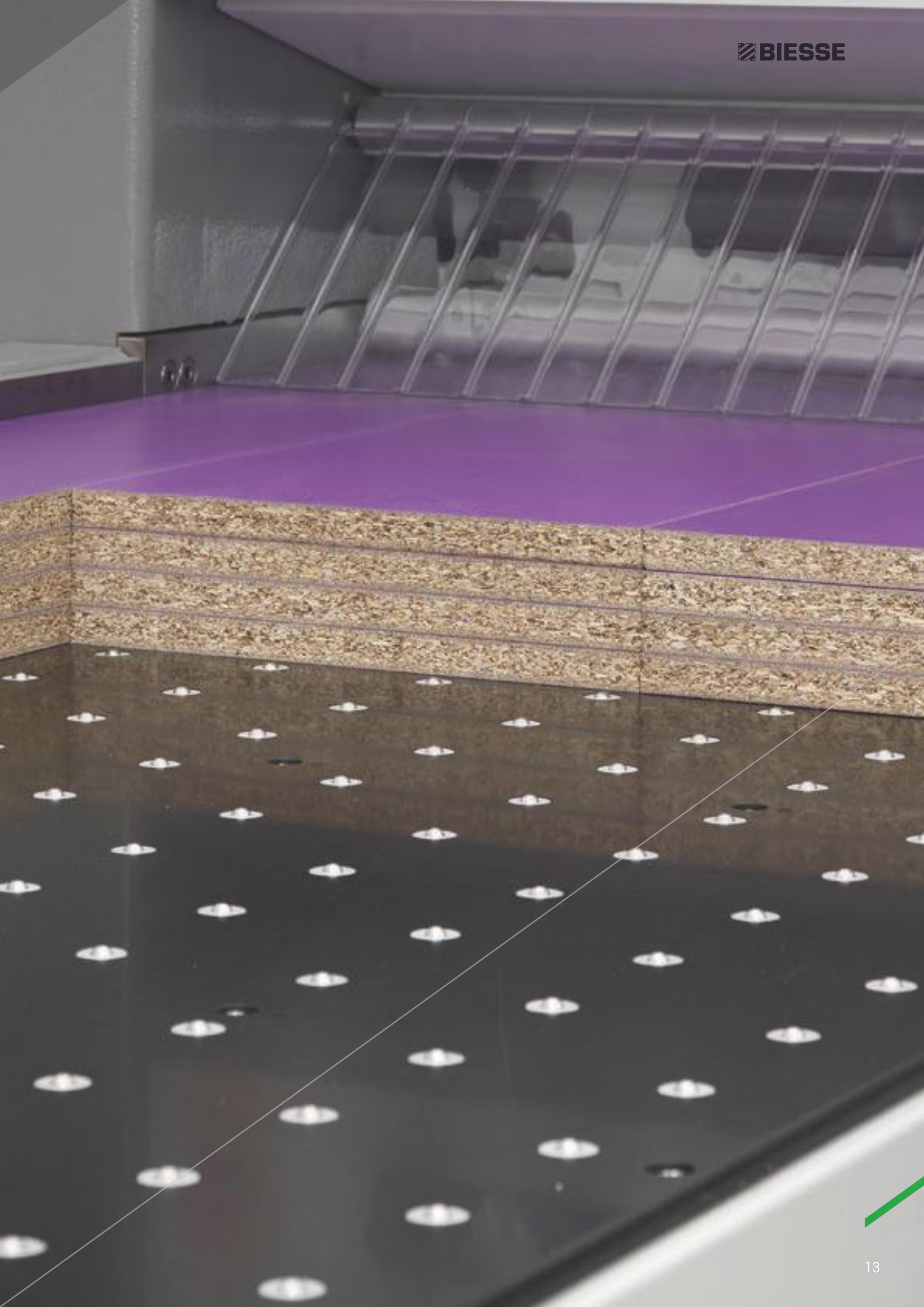
Double-level infeed conveyor. Thanks to the reduced footprint, which utilises height, the double-level infeed conveyor enables the optimisation of space and is perfectly suited to production sites that cannot accommodate two conveyors side by side.

Two panel saws in one

The Twin Pusher, an exclusive patent for all Biesse beam saws, consists of two complementary pushing devices. An additional stop allows the independent sectioning of strips up to 1200mm wide.

TWINPUSHER

Increased productivity by up to 60%, optimum management of production efficiencies and a ROI within the first year. A perfect combination of Biesse optimisation and Italian genius.



Increase productivity by up to 60%

Two independent cutting stations on a single beam saw.



An auxiliary pushing device consisting of two independent grippers with numerical control side positioning. An additional stop allows the independent sectioning of strips up to 1200mm wide.



Differentiated cross cut, also for narrow strips.



Cross-cut of the last strip, with advanced loading and rotation of the next book of panels.



Rip and cross-cuts made in one single working cycle.

Competitive customisation

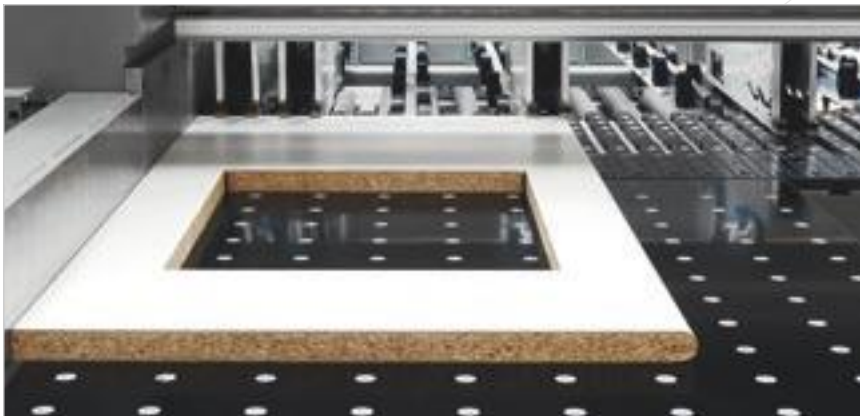
Biesse Systems is a team of highly trained engineers for large scale production processes. Biesse Systems offers integrated cells and systems which are capable of maximising customer competitiveness by combining mass production techniques with a high degree of customisation to meet customers' exact requirements.



PRODUCTION LINES

Made-to-measure turnkey factories, plus the integration of Biesse Group solutions with complementary software and machinery with over 300 systems installed worldwide. A perfect combination of Biesse Group experience and Italian genius.

An answer for every need



Software and electronic devices for making window cuts and grooves on panels. The layouts can be stored on the numerical control.

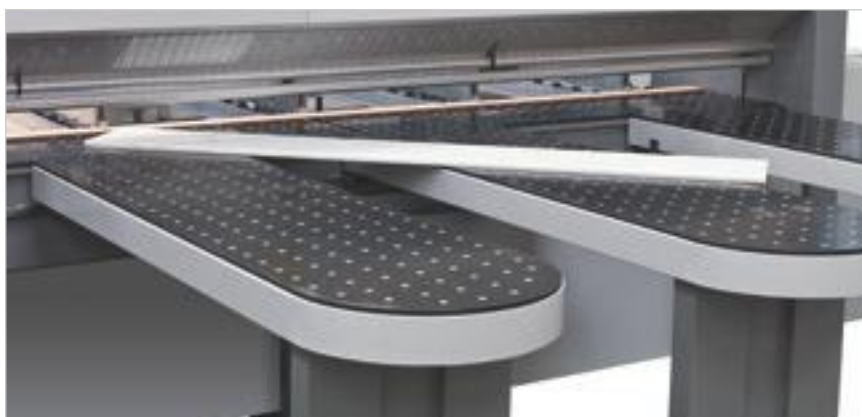


System for the automatic execution of grooves, whose width can be programmed via the numerical control. The groove depth can be adjusted manually from the outside of the machine and with the blades moving, or via an electronic device.



Thin panels can be loaded from the lifting table, using independent floating pushing points that are electronically controlled. A specific logic together with the front pop-up stops prevent the risk of mis-feeding (by means of attrition) those panels that don't belong to the book being fed.

Technological solutions for every machining need.



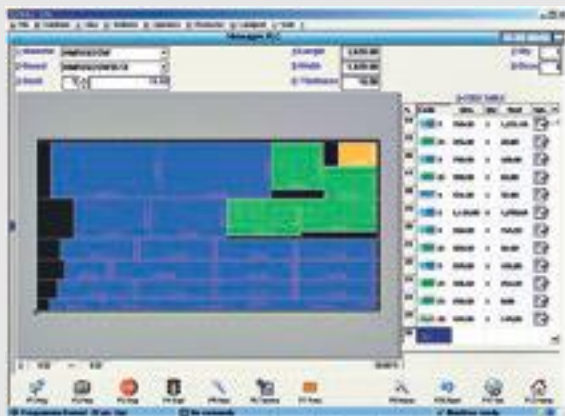
Automatic device for making angled cuts.



PFS function for making cuts on soft and post-formed panels. A special NC program that ensures the perfect finish of both the entrance point and the exit profile, preventing any splintering of fragile, delicate materials (patented).

Ease of use and practicality

The **OSI (Open Selco Interface) numerical control** guarantees the management of the execution of cutting patterns, and optimizes all movements relative to controlled axis (i.e. Pusher and Saw Carriage, pressure beam, blade height). It ensures the blade protrudes from the book to the correct degree during sectioning, and calculates the most suitable cutting speed on the basis of the book height and trim cut width. It helps ensure the best cutting quality at all times.



Easy cutting pattern programming.



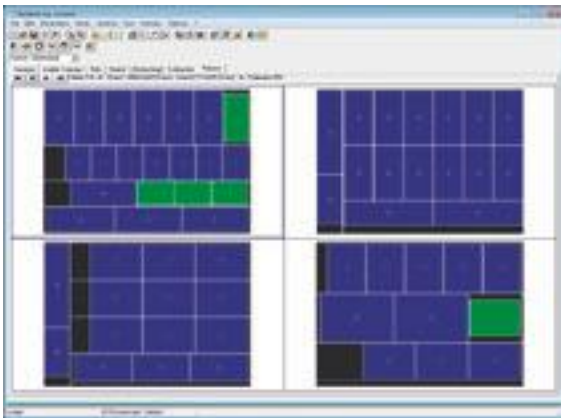
Graphic simulation in real time, with messages and information for the operator.



Interactive program for the quick, easy execution of cuts and grooves, even on recycled panels.

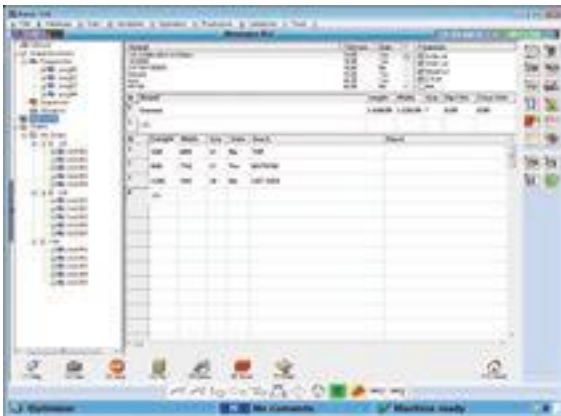


An effective diagnosis and troubleshooting program provides complete information (photos and text) to ensure that any problems are quickly resolved.



OptiPlanning.

Software to optimise cutting patterns and maximise efficiency for both material costs and cutting times. The cutting lists can be set manually (Data input) or imported via ASCII files (Data import).



Quick Opti.

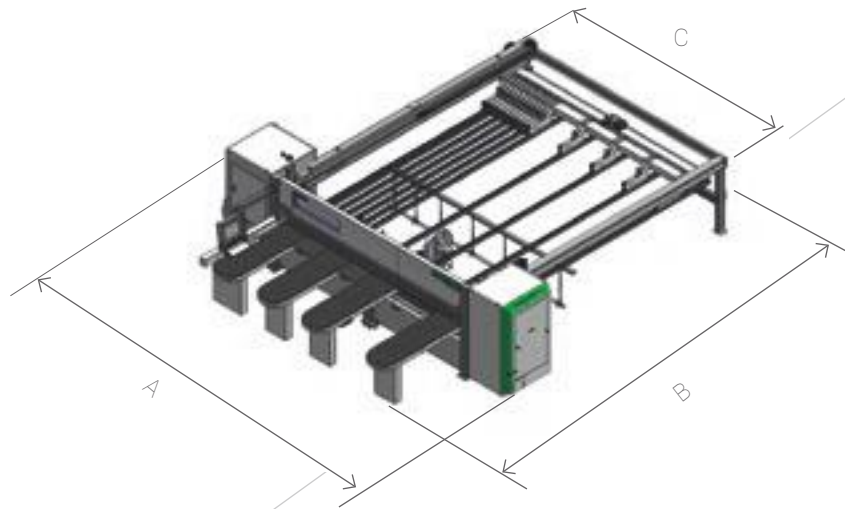
Simple, intuitive software for optimising the cutting patterns directly on the machine.



Labelling.

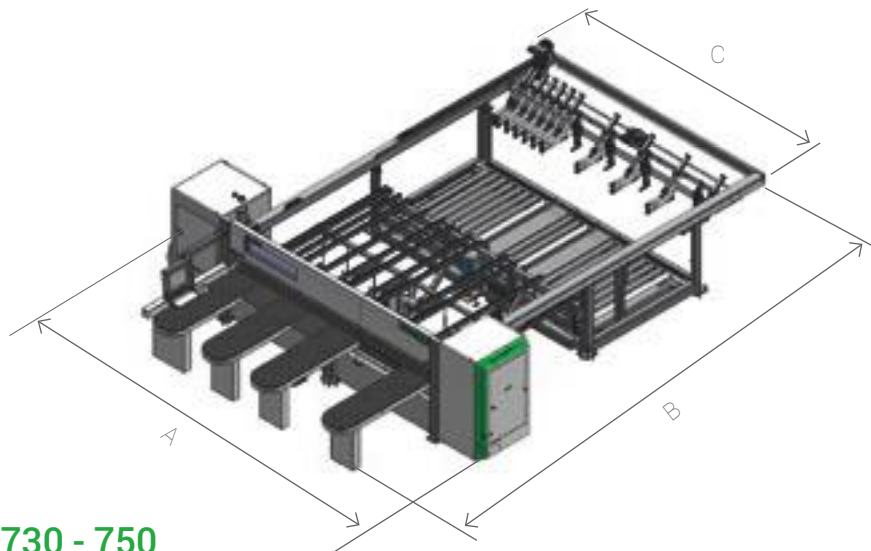
A special software creates individual labels and prints them in real time, on the machine. The information available can also be printed in bar code form.

Technical specifications



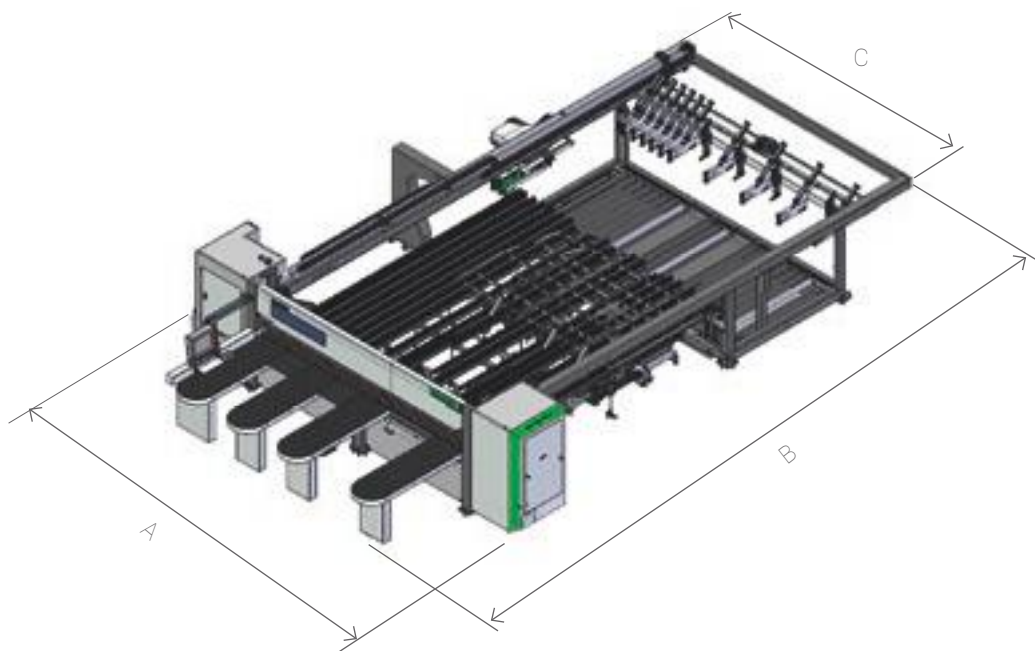
WN 710 - 730 - 750

	3800X3200	4500X4500	5900X5700
	mm	mm	mm
A	6370	7070	8470
B	7070	8370	9570
C	4210	4910	6310



WNT 710 - 730 - 750

	3800X2200	4500X2200	4500X3000	5900X2200	5900X3000
	mm	mm	mm	mm	mm
A	6370	7070	7070	8470	8470
B	9320	9320	11120	10320	11120
C	4210	4910	4910	6310	6310



WNTR 710 - 730 - 750

	4500X2200	4500X3000	5900X2200	5900X3000
	mm	mm	mm	mm
A	7070	7070	8470	8470
B	11570	12920	12920	14270
C	4910	4910	6310	6310

					710	730	750
Maximum blade protrusion	mm	107		127		152	
Main blade motor	kW/Hz	18,5-21,3/50-60				22-26,8/50-60	
Engraver blade motor	kW/Hz	2,2-2,6/50-60					
Blade carriage transfer	brushless						
Blade carriage speed	m/min	0-150		0-185			
Pushing device transfer	brushless						
Pushing device speed	m/min	90		90/130		130	

The technical specifications and drawings are non-binding. Some photos may show machines equipped with optional features. Biesse Spa reserves the right to carry out modifications without prior notice.

A-weighted surface sound pressure level (Lp_{fA}) during machining for operator workstation on vane-pump machine L_{pa}=83dB(A) L_{wa}=106dB(A) A-weighted sound-pressure level (L_{pA}) for operator workstation and sound power level (L_{WA}) during machining on cam-pump machine L_{wa}=83dB(A) L_{wa}=106dB(A) K measurement uncertainty dB(A) 4

The measurement was carried out in compliance with UNI EN 848-3:2007, UNI EN ISO 3746: 2009 (sound power) and UNI EN ISO 11202: 2009 (sound pressure levels at workstation) during panel machining. The noise levels shown are emission levels and do not necessarily correspond to safe operation levels. Despite the fact that there is a relationship between emission and exposure levels, this may not be used in a reliable manner to establish whether further measures need to be taken. The factors determining the exposure level for the workforce include length of exposure, work environment characteristics, other sources of dust and noise, etc. i.e. the number of other adjoining machines and processes. At any rate, the above information will enable the operator to better evaluate dangers and risks.

Service & Parts

Direct, seamless co-ordination of service requests between Service and Parts.
Support for Key Customers by dedicated Biesse personnel, either in-house and/or at the customer's site.

Biesse Service

- ✓ Machine and system installation and commissioning.
- ✓ Training centre dedicated to Biesse Field engineers, subsidiary and dealer personnel; client training directly at client's site.
- ✓ Overhaul, upgrade, repair and maintenance.
- ✓ Remote troubleshooting and diagnostics.
- ✓ Software upgrade.

500 / Biesse Field engineers in Italy and worldwide.

50 / Biesse engineers manning a Teleservice Centre.

550 / Certified Dealer engineers.

120 / Training courses in a variety of languages every year.

The Biesse Group promotes, nurtures and develops close and constructive relationships with customers in order to better understand their needs and improve its products and after-sales service through two dedicated areas: Biesse Service and Biesse Parts.

With its global network and highly specialised team, it offers technical service and machine/component spares anywhere in the world on-site and 24/7 on-line.



Biesse Parts

- ✓ Original Biesse spares and spare kits customised for different machine models.
- ✓ Spare part identification support.
- ✓ Offices of DHL, UPS and GLS logistics partners located within the Biesse spare part warehouse, with multiple daily pick-ups.
- ✓ Order fulfilment time optimised thanks to a global distribution network with de-localised, automated warehouses.

87% / of downtime machine orders fulfilled within 24 hours.

95% / of orders delivered in full on time.

100 / spare part staff in Italy and worldwide.

500 / orders processed every day.

Made **With** Biesse

Biesse technology accompanies the growth of Stechert

"On these chairs sits the world" is the motto of the Stechert Group that can effectively be taken literally. What began 60 years ago as a small manufacturing company for pram mouldings, furniture doors and door locks is today one of the largest international suppliers of contract and office chairs, as well as tubular steel furniture. Moreover, since 2011 the company has a partnership with WRK GmbH, an international specialist in podiums, conference room and grandstand seating, associated with Stechert via the joint commercial company STW. For Stechert management, however, the excellent results obtained are no excuse for resting on their laurels. On the contrary, the company is investing heavily in the Trautskirchen site to make its production even more efficient and profitable. In the search for a new machinery partner, the company's management chose the Italian manufacturer Biesse. "For the project we chose machines that already had certain options and were predisposed for automation", said Roland Palm, Biesse Area Manager. An efficient production cycle was creat-

ed in which workers are able to perform at their best after only a short training period.

At the start of the production line is the panel saw "WNT 710" with one cutting line. "Because", explained skilled cabinet maker Martin Rauscher, "we want to be able to work panels of up to 5.90 metres in order to reduce waste as much as possible." Normal rectangular panels for tables or wall panels are taken directly to the "Stream" edgebander with "AirForceSystem" technology. The Biesse edgebander has a group that activates the laminated edging material no longer via a laser beam but using hot air to obtain the so-called "zero gap". "The quality is just as good as the laser system, if not even better: with a connection power of 7.5 kW, the cost per square metre is much lower", underlined the Biesse Area Manager.

"We want to be ready for when we mould the frame ourselves and we must therefore calibrate the panels" said Martin Rauscher, "The same is true of course for solid wood and multiplex panels, which require grinding before being

painted in an external company. For both types of work a Biesse "S1" sander is used. In order to meet the needs of the future, in the Trautskirchen plant there are also two Biesse numerically controlled machining centres: a "Rover C 965 Edge" and a "Rover A 1332 R", which are perfectly complementary.

The Stechert Group also intends to strengthen sales of innovative solutions for interior fittings, with complete systems for walls, ceilings, floors and mezzanines. For panel sectioning, the Group has purchased a "Sektor 470". For other geometry, groove and spring machining as well as boring and surface milling, there are two Biesse machining centres, an "Arrow" for nesting applications, a "Rover B 440" and more recently a 5-axis machine, the "Rover C 940 R" machining centre in order to be able to produce, in particular, wall and ceiling panels machined in 3 dimensions.

Source: HK 2/2014



<http://www.stechert.de>



Biesse Group

In

1 industrial group, 4 divisions and 8 production sites.

How

€ 14 million p/a in R&D and 200 patents registered.

Where

33 branches and 300 agents/selected dealers.

With

customers in 120 countries, manufacturers of furniture, design items and door/window frames, producers of elements for the building, nautical and aerospace industries.

We

3,000 employees throughout the world.

Biesse Group is a multinational leader in the technology for processing wood, glass, stone, plastic and metal.

Founded in Pesaro in 1969, by Giancarlo Selci, the company has been listed on the Stock Exchange (STAR segment) since June 2001.

 **BIESSEGROUP**

 **BIESSE**

 **INTERMAC**

 **DIAMUT**

MECHATRONICS

