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SCHEER Panel Sizing Plants. High Precision. Cut After Cut.

SCHEERs Models PA 6000 and PA 7000.
A New Machine Generation. A Leading Design.





Welcome to SCHEER! A company that originates from a country which has a tradition in producing inventors and innovators. Enjoying an excellent reputation all over the world in manufacturing quality wood working machines. Ground breaking ideas, modern technologies and a dedicated team committed to sensible progress.

This philosophy shows on the models PA 6000 and PA 7000. A new arrival of panel sizing plants with an impressive performance. Designed with an emphasis on efficient panel sizing. Adding to the economical production process of small and medium sized industries.

LET SCHEER TAKE CARE for us is not a slogan, but a challenge reflected in our products. Every day. No matter if you are cutting solid timber, wood based panels, PVC or aluminum, the machines from the product range PA 6000 and PA 7000 will take care of your daily manufacturing necessities with unrivaled precision.

Built up modules as standard available in cutting lengths from 3100 mm up to 5700 mm. Mirror image version with r.h. side fence?

No problem, no extra cost. And mentioning cost: can you imagine a machine on the market with a comparable value for money ratio?

Make the computer your assistant, make things easier.

These panel sizing plants have direct access to the operators PC. Additional manipulations often incorporated in conventional PLC controls are not required. Facts and functions of this concept can be seen in a variety of details:

WINDOWS based interface with a visual display of new and memorised cutting plans, a program for special applications (ventilation slots, back panel grooving, mitre cuts etc.) and optimising solutions offer the operator a complete support package for his every day requirements.

A choice of two cutting heights

The range offering flexibility, precision and quality at an affordable investment.

PA 6000

- Cutting height 80 mm
- Main saw motor power 9 KW
- Main saw blade dia 350 mm
- Scoring saw blade dia 200 MM
- Cutting lengths 3100 mm
- Cutting lengths 4200 mm
- Cutting lengths 5700 mm
- Post forming as an option
- Rear lifting table as an option

Heavy duty machines combining flexibility, precision and quality with a complete scope of equipment.

PA 7000

- Cutting height 115 mm
- Main saw motor power 11/15 KW
- Main saw blade dia 450 mm
- Scoring saw blade dia 200 mm
- Cutting lengths 3100 mm
- Cutting lengths 4200 mm
- Cutting lengths 5700 mm
- Post forming as an option
- Rear lifting table as an option



SF KSB AQ10

The Art of Panel Sizing - Models PA 6000 and PA 7000 in detail

Solid machine base in compact design. Wear and tear free hardened and polished round guide bars for the saw carriage and for the material pusher in two parallel guide ways guaranteeing precise chip free finish cuts for years. High travel speeds result in excellent work performances.

Post forming unit as an option

to cut post formed panels chip free.

When the saw carriage has reached the post formed panel positioned next to the side fence, the post forming saw blade jumps up and scores the panel with a wider kerf than the main saw blade, to ensure a chip free finish cut. SCHEERs post forming system features a scoring saw and a main saw unit with easy alignment of the two saw blades. The post forming device can be used for all cutting lengths and can also be added to the new models at a later stage. The maximum cutting height for post formed panels is 60 mm (PA 6000) and 90 mm (PA 7000).

One man operation. On the machine or on-line from the office. Always from the keyboard. Always a visual display of all operations.

Rack and pinion drive of the material pusher located under at the parallel guide ways.

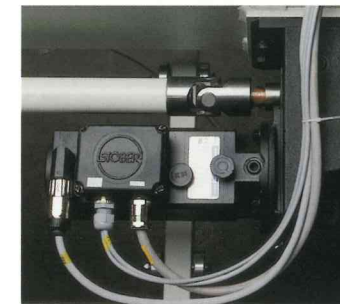
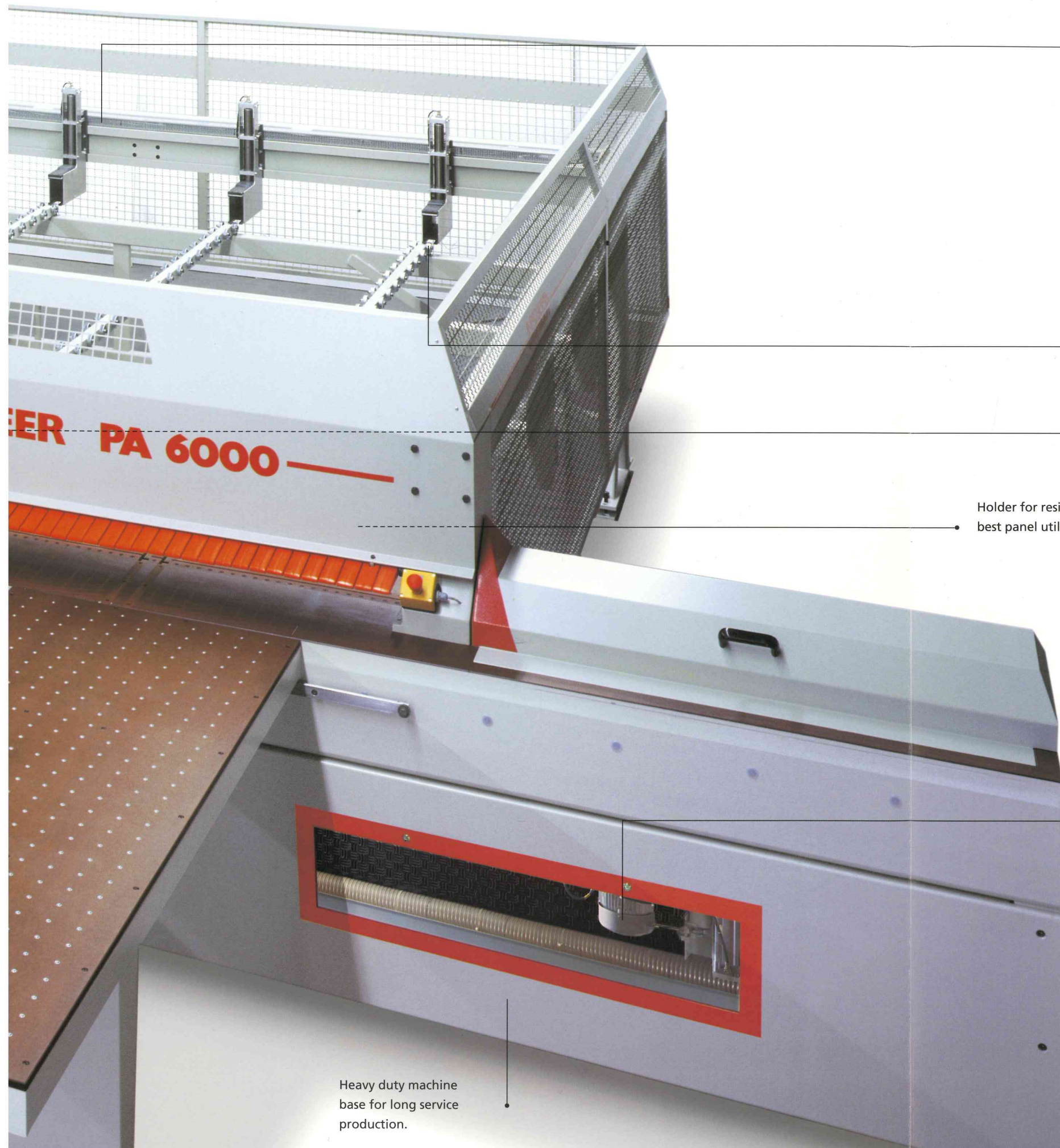
Control cabinet separate from machine base

Double roller tracks, PVC table in side fence area.

Angular fence table with air floating device.

Work piece table with air floating device.

Work piece table with air floating device.



Material pusher, directly driven servo motor with resolver transmission. No separate measuring system required.



Material pusher table with two hardened and polished guide ways, hardened guide rollers, concave, in full contact with guide bars.



Floating grippers with rubber pads.

Holder for residual parts for best panel utilization.

Fully automatic side aligner with pneumatically controlled pressing finger.

Wear and tear free saw carriage with direct gear drive, servo motor with resolver transmission.



Saw carriage with two hardened and polished guide ways moving on Star guide bearing assemblies.



Dust collector system with PU spiral hose directly connected into the closed cutting area. Dust emissions far below the requirements of the safety and health dept.

Heavy duty machine base for long service production.

The Saw Carriage: The Heart of a Panel Sizing Plant.

No two saw carriages are designed equal. And SCHEERS new saw carriage is a cut above the rest. The finest engineering. Two top guide ways made of hardened and polished steel. Mounted parallel with a balanced centre of gravity for maximum precision. Cast iron. The wafered casting design absorbs vibrations and sound. Engineering in SCHEER quality.

Scoring saw unit:
Scoring saw unit alignment
with operator keyboard. Horizontal and vertical adjustment during idle or cutting cycle.

Main saw unit:
Rising and falling on Star guides.
Infinitely variable main saw unit
adjustment from 0 to maximum
cutting height.

Saw motors:
Saw motors with cyclo spiral
gear drive for direct power
transmission from motor
to the saw blade. SCHEERS
guarantee for long life.

Star guide bearing assembly:
Maximum bearing strength,
minimum travelling friction.
Compensates for misalignment.

Inspiring Technology.

The movements of the material pusher, the alignment systems and the saw carriage are fine tuned. For finest cutting results.

Software, interfacing the operator with the optimiser.

In order to achieve the best possible parts out-put from the existing panel in-out, the optimising program creates the respective cutting plan. The multi function SCHEER software processes the necessary data optimising the best possible cutting patterns. The benefit for the operator is obvious: if he communicates on-line with the machine or from the office, he always works with the keyboard. The monitor supplies a visual display of every operating step. And keeps him in the picture. Spot on.

PA 6000 - PA 7000
A logical development: panel sizing plants with
a rear lifting table. Efficient and reliable.

Alignment pistons for
rip and cross cutting.

Safety control system with el-
ectric sensors.



The lifting tables are loaded from the l.h., r.h. or the rear side. The stack of panels is precisely set squared with driven conveyor rollers. The material pusher travels into loading position. Controlled pins with sensors prepare the exact

number of panels to be cut at a time. Transported on universal rollers the stack of panels is aligned and prepared for the cutting line. Rise and fall of lifting table, stack loading, squaring, aligning and cutting is one automatic cycle.

As an option: computer controlled head cut saw unit. For increased productivity this new product range can be equipped with a computer controlled head cut saw unit in the area of the material table. Cutting plans including head cuts divide the stack of panels in two parts without turning involved. Both stacks of panels are finished subsequently. Perfect High Tech!

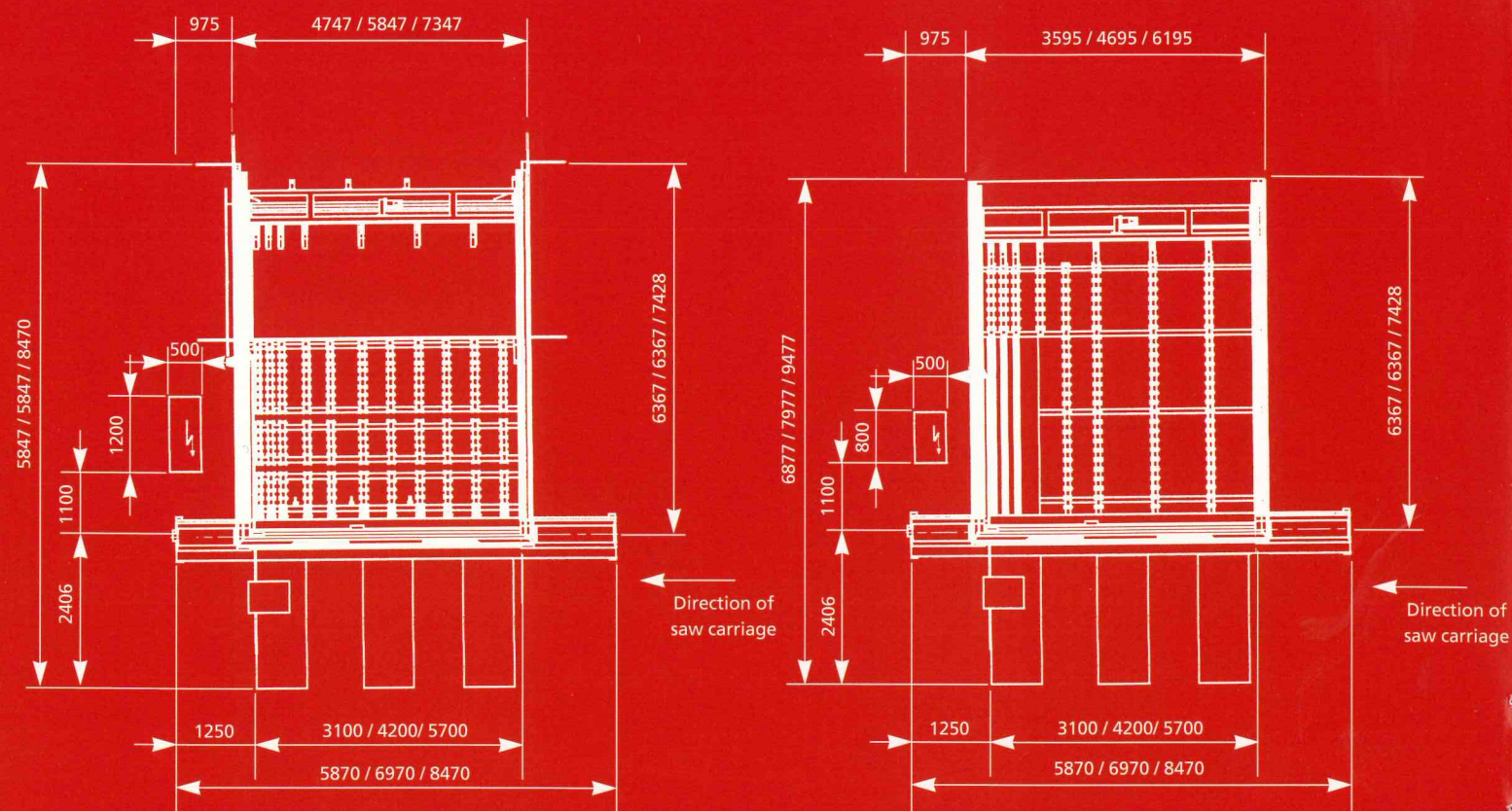
Fully automatic and computer controlled squaring of the panel stack.

Loading pins with computer controlled axis and super sonic sensors.

Driven conveyor rollers to load the lifting table from the side.

Worm gear spindle and control unit of lifting table with panel counter.





Technical Specifications

PA 6000

Cutting depth	3150 / 4250 / 5750 mm
Saw blade projection	85 mm
Cutting height	80 mm
Main saw blade dia	350 mm
Working height	930 mm (+10 / -5 mm)
No. of working tables	2 / 3 / 4
Working table size	2408 mm x 800
Main saw motor power	9,0 kW
Scoring saw motor power	2,2 kW
Saw feed motor power	1,1 kW with servo transmission
Fence feed motor power	1,07 kW with servo transmission
Electrics	400 V, 50 Cy, 3 Ph
Pneumatics	10 mm O.D., 6 bar
Air consumption	Approx. 15 l at 6 bar per cycle
Dust collector duct	3 x 120 mm O.D.
Dust collector power	2640 m³ at 20 m/s speed
Material fence	L.H. side

PA 6004

Feed motor power (for alignment)	0,25 kW
Lifting table motor power	4,0 kW
Drive motor power (for conveyor rollers)	0,37 kW

PA 7000

Cutting length	3100 / 4200 / 5700 mm
Cutting depth	3150 / 4250 / 5750 mm
Saw blade projection	135 mm
Cutting height	115 mm
Main saw blade dia	450 mm
Working height	930 mm (+10 / -5 mm)
No. of working tables	2 / 3 / 4
Working table size	2408 mm x 800
Main saw motor power	11,0 kW
Scoring saw motor power	2,2 kW
Saw feed motor power	1,1 kW with servo transmission
Fence feed motor power	1,63 kW with servo transmission
Electrics	400 V, 50 Cy, 3 Ph
Pneumatics	10 mm O.D., 6 bar
Air consumption	Approx. 15 l at 6 bar per cycle
Dust collector duct	3 x 120 mm O.D.
Dust collector power	2640 m³ at 20 m/s speed
Material fence	L.H. side

PA 7004

Feed motor power (for alignment)	0,25 kW
Lifting table motor power	4,0 kW
Drive motor power (for conveyor rollers)	0,37 kW

All technical modifications reserved

**SCHEER
woodworking
machines for
small and
medium sized
industries.**

At SCHEER we believe that nothing tops experience when manufacturing wood working machines. Latest technology, uncompromised quality and highest precision define our standards. For more than 70 years. All around the world. A commitment to excellence.

**SCHEERs
manufacturing
program:**

Panel Sizing Plants
CNC Machine Centres
Veneer Cutting Machines
Mechanical Drilling Machines
Controlled Drilling Machines
Power Tools
Systems for Staircase
Production