

HANS KOCH GMBH

Holzbearbeitungsmaschinen und Werkzeuge
Woodworking machinery and tools

Herstellung
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Service



**SCHEER
KOCH**

BFS Woodpecker BFS 8111 - BFS 8133-V



**BFS 8132 latest drive technology
– improved speed –**

Woodpecker BFS 8111 - BFS 8133-V

- Drilling
- Gluing
- Doweling, 54 dowels/min
- Doweling on numerous levels

Routing all frontal routing work, including

- dovetails
- burrs
- slots
- routing of free outlines and pockets

How is that possible with this machine and what guarantees are there long term?

- The machine is extremely compact, it requires minimum space.
- The electrical connections are designed for low energy demand.
- The compressed air requirement is reduced, depending on the workpiece.
- The extraction technology for disposal of drilling and routing chips is easy to assemble and requires low air consumption.
- Adjustments are simply explained and supported on the monitor.
- The machine has pre-programmed, close to practice standard programmes that can be easily adapted to operational requirements. This facilitates operation start-up.
- All settings can be stored safely for future use.
- For similar workpieces, stored values can be changed quickly.
- All workpiece dimensions are displayed on the screen, as are the set dimensions of drilling and routing operations.
- Operative programmes can also be transferred directly to the machine by an external workplace, i.e. production planning.
- The machine can process solid wood, engineered wood, many plastics and composites. We will find special solutions for special cases.

The machine and the described technology are based on our longstanding experience in mechanical engineering. The foundation is based on the experience from C.F. Scheer & Cie.

We constantly refine current technology at Scheer - Koch. The continuous contact with our customers in Germany, Europe and overseas facilitates this task.

All machines in this series are supplied as "ready to plug in". After unpacking the machine at its location and connecting it to electricity, compressed air and wood chip extractor, you are ready to go.

The spindle guided Z-axis provides maximum flexibility on all three levels, where the linear guides, which are sealed and retain the wood dust, prohibit the build-up of wood chips.

The drill support will be provided by 1 drill/routing motor, supported by the dowel insertion unit.

As an option further drill motors and/or dowel insertion units can be configured.

Separate flip fences offer alternating operation.

Sensor start-up for work without time delay and increased productivity.

Adjustable clamps for good grip, also applicable for small work pieces.

The core of the machine (the hard-wired control cabinet) contains the latest drive technology from BECKHOFF compact controllers as well a BECKHOFF industrial computer, offering smooth operation by uninterruptible power supply (UPS) and safety-PLC, even after disruptions like power cuts or power surges.

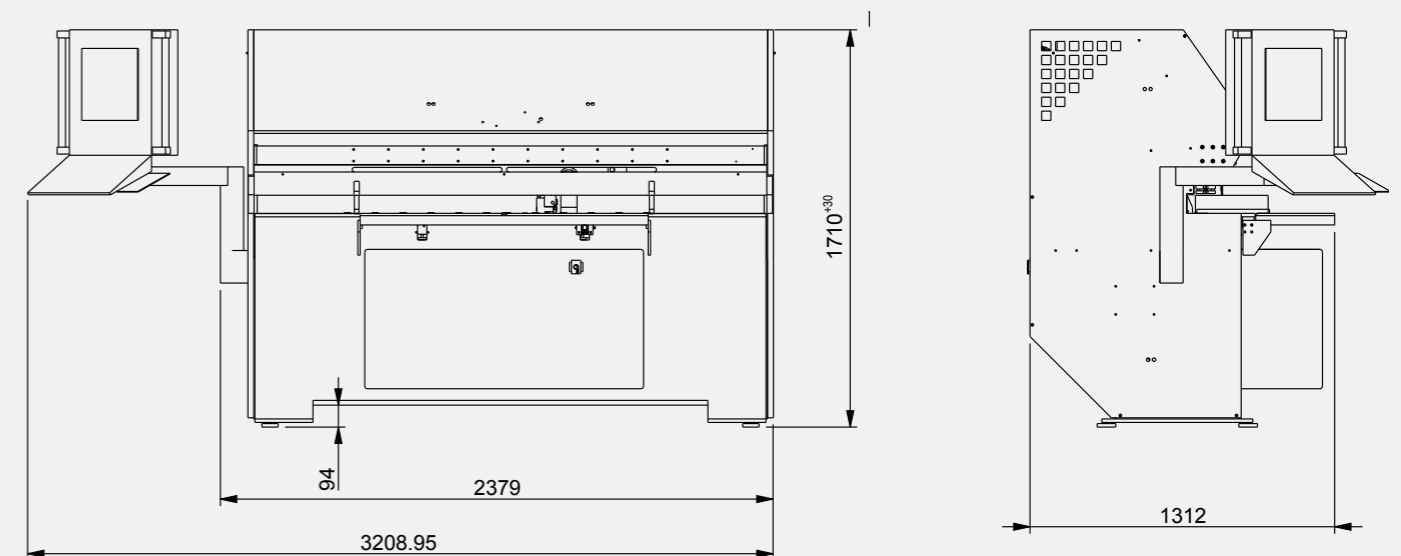
The operator controls the machine using the tried and tested NC Studio within Windows Embedded 7.

For additional precision - axes and RPM are individually adjustable.

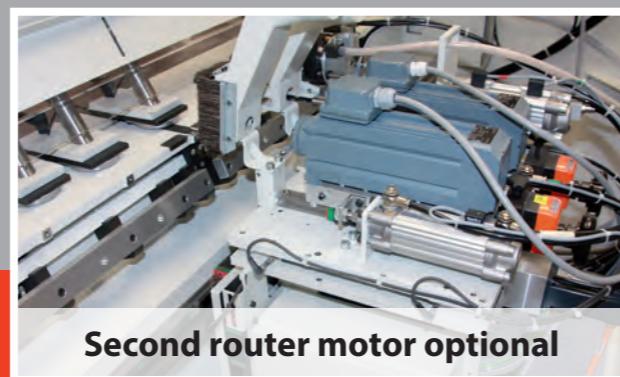
The machine for face and surface machining of panelled materials and frame parts.

The purpose of this machine is to work on individual and serial parts at reasonable cost. Prerequisite for this are simple operation, short setup times and great repeat accuracy.

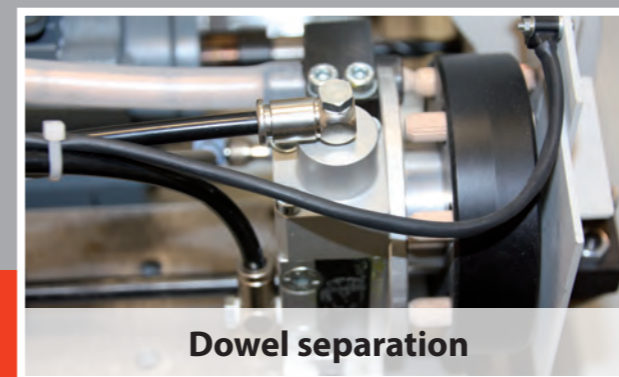
In our permanent exhibition we offer you the chance to get an overview and experience the performance of the BFS Woodpecker, using your own workpieces on one of our "ready to use" machines. Your satisfaction is our success.



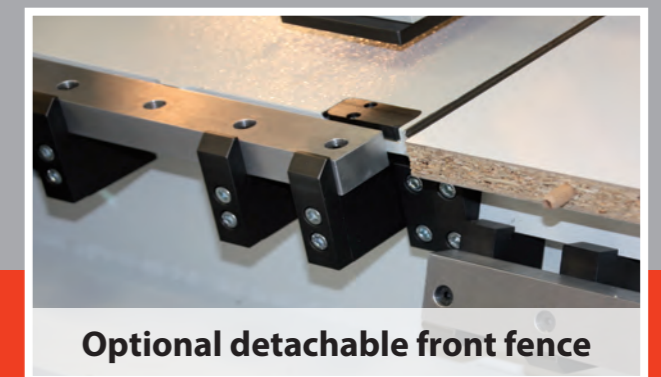
Machining of multiple levels



Second router motor optional



Dowel separation



Optional detachable front fence

Technische Daten



Status: 4/2015, subject to technical modifications

Technical data	Model BFS 8111	Model BFS 8111-V
	With horizontal drilling unit	With additional vertical drilling unit
Work piece width	min. 60 mm; max. 1250 mm	min. 60 mm; max. 1250 mm
Work piece width in tandem operation	max. 600 mm	max. 600 mm
Work piece length	min. 100 mm; max. unlimited with integrated flip fence 2.500 mm	min. 100 mm; max. unlimited with integrated flip fence 2.500 mm
Work piece thickness	min. 13 mm; max. 60 mm	min. 13 mm; max. 60 mm
Drill distance from side fence	min. 10 mm	min. 10 mm
Horizontal working area X	0 – 1.250 / 1500 mm	0 – 1.250 mm
Max. speed servo axis X	120 m/min	120 m/min
Vertical working area Y	0 – 110 mm	0 - 110 mm
Max. speed servo axis Y	40 m/min	
Clamping cylinders	4 short stroke cylinders, á 63 mm Ø, tilted	4 short stroke cylinders, á 63 mm Ø, tilted
Drill motor horizontal	9.000 to 18.000 rpm, adjustable; 1,5 kW	9.000 to 18.000 rpm, adjustable; 1,5 kW
Drill depth adjustment	With digital read out (optional with z-axis adjustable)	With digital display (optional with z-axis adjustable)
Max. drill depth	45 mm (drill 80 mm)	45 mm (drill 80 mm)
Drill adapter	M10 outside or alternative	M10 outside or alternative
Drill motor vertical	only applicable for BFS 8111-V	1,5 kW at 18.000 rpm, 1 spindle,
RPM	-	9.000 – 18.000 rpm, adjustable via programme
Drill feed	-	pneumatic
Drill stroke	-	max. 25 mm
Drill depth adjustment	-	with spindle and mechanical digital display, in relation to end drilling
Distance to reference edge	-	min. 5 - max. 35 mm manual adjustment with digital display (optional motorised)
Drill carrier	-	M10 outside, Scheer-System
Drill	-	length 80mm, max. Ø 35 mm
Dowel dimensions	Ø 8 x 30/50 mm, standard	Ø 8 x 30/50 mm, standard
Adjustment	10 – 30 mm	10 – 30 mm
Dowel quality	According to DIN 68150, Form AM, manually sorted	According to DIN 68150, Form AM, manually sorted
Dowel feed	Spiral conveyer	Spiral conveyer
Glue system (Standard)	Membrane pump 1:1	Membrane pump 1:1
Glue nozzle	0,6 mm, alternative: 0,4 / 0,8 mm	0,6 mm, alternative: 0,4 / 0,8 mm
Glue	Low viscosity PVAc – Glues	Low viscosity PVAc – Glues
Viscosity	150 – 350 Pa s	150 – 350 Pa s
Dust collecting duct	80 mm Ø	80 mm Ø
Required air quantity	540 m ³ /h, at 30 m/sec	540 m ³ /h, bei 30 m/sec
Compressed air connection	10 mm IW at 6 bar	10 mm IW at 6 bar
Compressed air connection	approx. 50 norm l/min, depending on cycle	ca. 80 norm l/min, depending on cycle
Power consumption	approx. 6,0 kW, depending on configuration	ca. 7,5 kW, depending on configuration
Controls	Twin CAT, IPC with colour monitor	Twin CAT, IPC with colour monitor
Safety	acc. to CE-standards	acc. CE-standards