



Technical Description

Scope of function

Vacuum-Chamber-Press System for lamination multilayerboards with vacuum assistance. With a maximum pressure force of up to 125 tons and temperatures up to 400° Celsius , this laminationpresses are able to be used for all mayor material types and for all fields of operation. High quality of pressure and temperature control, together with a high mechanical parallelism , guarantee a high repeatable process quality.

Operation

The operation of the presssystem is handled by a connected pc terminal on which the necessary press parameters will be input on a process mask.

The system is able to store up 50.000 recipe files. The automatic process is handled by the press recipe, which controls pressure, heaters and vacuum by an connected processing unit. During the process the system generates an process protocol in real time that contains all data about pressure, heating & cooling and vacuum level as well. During each process cycle the levels of pressure, heating & cooling will be controlled regarding to the loaded process file in up to six programmable steps on each function. Herein the pressure control is done by infinitely variable proportional valve. The platen heaters are controlled in three zones for each platen. The heating as well as the cooling functions can be adjusted in a temperature – time – ramp.

Technical Data	LP 100-2-VK	LP 100-3-VK	LP 100-4-VK
Quantity of Openings	2	3	4
Width of Opening (mm)	157	87	85
Dim. of Heatingplatten (mm)	600 x 690 (Option 750)	600 x 690 (Option 750)	600 x 690 (Option 750)
Max. Lamination Surface (mm)	560 x 650 (Option 690)	560 x 650 (Option 690)	560 x 650 (Option 690)
Pressure Force (kN)	1000 (Option 1250)	1000 (Option 1250)	1000 (Option 1250)
Heating & Cooling			
Max. Temperature (°C)	300 (Option 400)	300 (Option 400)	300 (Option 400)
Heatup from 40° to 175°C	Ca. 25 Min.	Ca. 25 Min.	Ca. 25 Min.
Cooling Time	programmable	programmable	programmable
Energy Consumption			
Heatingplatten (kW)	12,6 to 16,2	12,6 to 16,2	12,6 to 16,2
Main Consumption (kW)	72	92	108
Main	3 x 400 V ; 50 Hz	3 x 400 V ; 50 Hz	3 x 400 V ; 50 Hz
Current (A)	72	92	108
Fuse (A)	100	100	125
Processing Unit			
PLC Control	Yes	Yes	Yes
Analog / Digitalcontrollers			
Processterminal w. OS	Yes / Windows 10	Yes / Windows 10	Yes / Windows 10
Heater Controls	Programmable /up to 6 Steps	Programmable /up to 6 Steps	Programmable /up to 6 Steps
Cooling Controls	Programmable /up to 6 Steps	Programmable /up to 6 Steps	Programmable /up to 6 Steps
Pressure Controls	Programmable /up to 12 Steps	Programmable /up to 12 Steps	Programmable /up to 12 Steps
Cooling Water Consumption	Ca. 500 l per Cycle	Ca. 680 l per Cycle	Ca. 840 l per Cycle
Compressed Air Consumption (Pressure 4 bar)	Ca. 90 l per Cycle	Ca. 120 l per Cycle	Ca. 150 l per Cycle
Dimension L x B x H (mm)			
Machine	1420 x 1150 x 1600	1420 x 1150 x 1600	1420 x 1150 x 1740
Hydraulic & Vacuum	980 x 700 x 800	980 x 700 x 800	980 x 700 x 800
Weight (kg)			
Machine	3800	4000	4300
Hydraulic & Vacuum	150	150	150

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