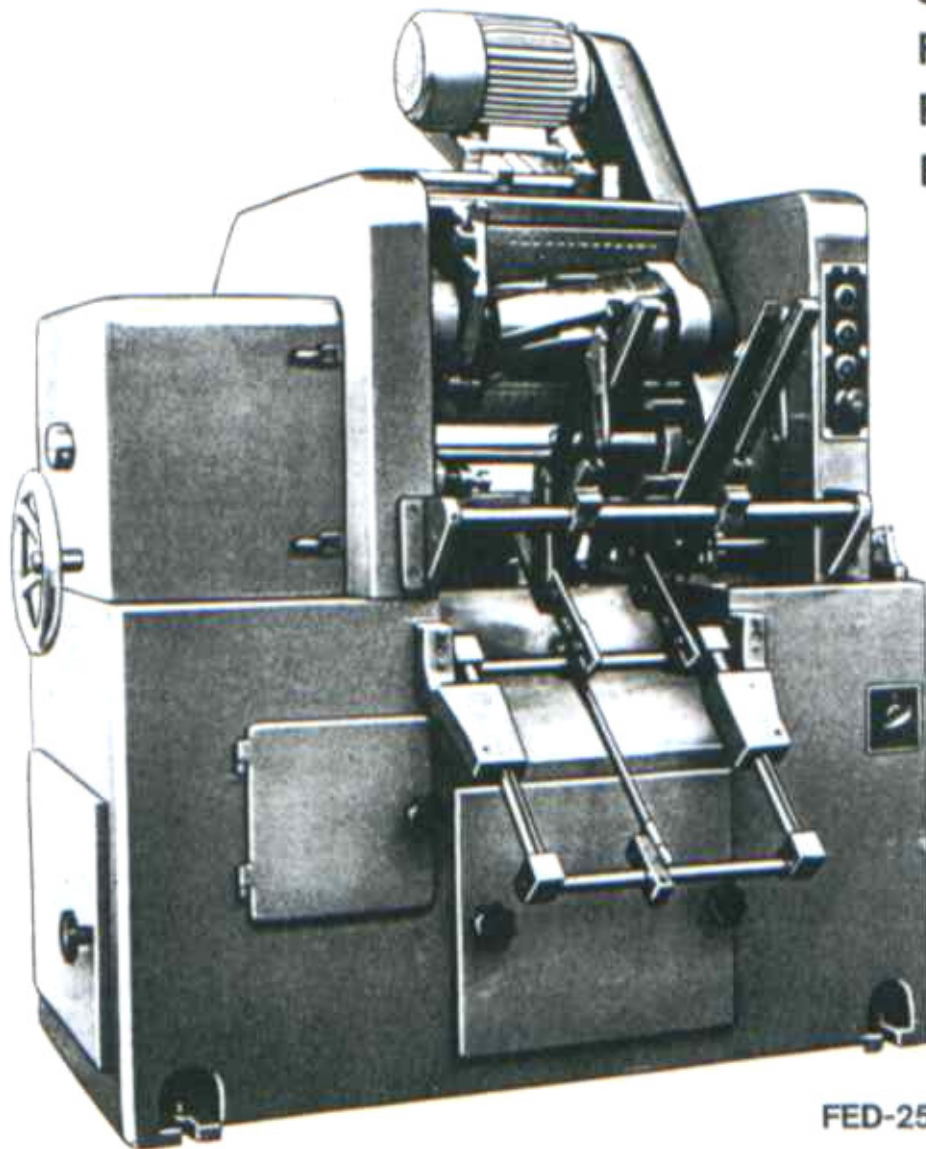
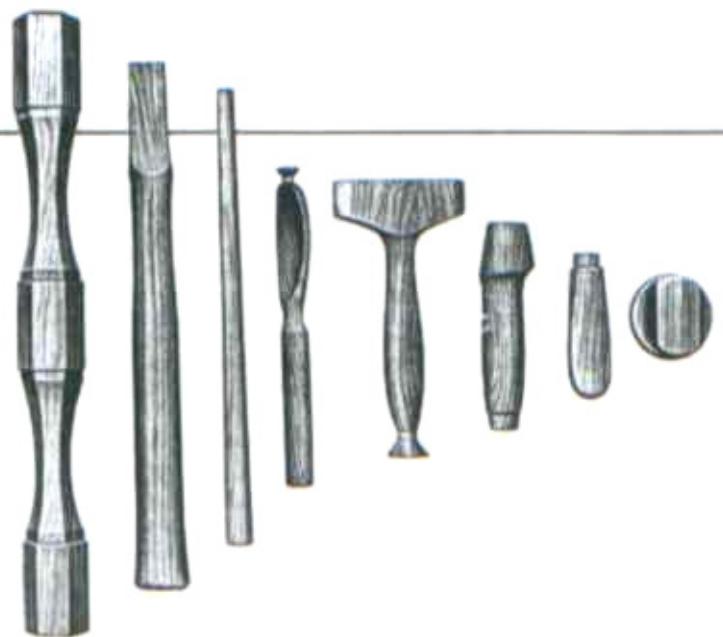


Fräsautomat FED

Shaper
Fraiseuse
Fresadora
Fresatrice



FED-25



Cutterheads for the Milling Machine, Type FED

The Milling Machine FED can be equipped with cutterheads (see III. 1) instead of profiled cutters.

The cutterheads consist of hexagon carrier heads (see III. 2), on which there can be fitted cutter holders (see III. 3). The cutters (III. 4) are screwed onto these cutter holders.

According to the demand the cutterholders and cutters can be oblique towards the left or the right hand side and in various widths. The width of the cutters depends on the profile of the workpiece and the obliquity has to be chosen in such a manner, that, when operating, the cutter always cuts from the biggest towards the smallest diameter of the workpiece.

The cutters are individually produced according to the required shape.

The **Marking Device, type FED/A (III. A)** is designed for marking the shape. The marking of each cutter is made according to a template, which is fixed on the front side of the device.

When mounted on the rear side of the device, the same template can be used for checking the shape or for adjusting the cutters after resetting or grinding.

Weight of the Marking Device FED/A: about 310 lbs.

After producing or grinding the cutters the whole cutterhead with all cutter holders and cutters has to be balanced, in order to avoid an unbalance (vibration of the machine).

The Balancing Device, type FED/W serves for this purpose (III. B).

It is recommended to counterbalance the two opposite cutters and cutter holders, including the corresponding screws and washers before fitting the cutters.

In case of greater unbalance there can be fixed counterweights.

Weight of the Balancing Device FED/W: about 50 lbs.

We reserve the right to amend or modify the design!

Model FED-50 Automatic Shaper

This machine of sturdy construction is designed for the production of parts having a round, oval or polygonal cross-section.

The machine comes in two sizes:

FED-25 for work from 2 to 10" long
FED-50 for work from 2 to 20" long

(For shorter pieces, please ask for further information.)

The **max. work diameter** is 4. 3/4" on both models.

The machine has 4 clamping spindles, and the shaping is done on 2 working stations with 2 independent milling arbors so that parts with two different cross-sections can be produced all in the same cycle.

A special feature of the machine is its 4-phase working cycle providing a very high output. These four phases, operating simultaneously, are:

1. Loading and clamping the wood blank
2. First shaping operation
3. Second shaping operation
4. Unclamping and ejecting the finished part

The machine is mechanically operated and made fully automatic by an automatic hopper feed system.

The two cutter arms are mounted in swivelling ball bearings and can each be controlled by two different cams to enable the shaping of components with varying cross-sections (such as spatula handles or square section furniture legs with rounded edges).

The **output** is continuously variable from 400 to 1200 pieces per hour, depending on the type of work being done.

The milling tools can either be solid profile cutters in one piece or cutterblocks with bolted-on knives. Making one's own knives and mounting them on the cutterblock requires the use of the following two accessories: the **FED/A scribing device** and the **FED/W balancing device**.

The machine is supplied complete with the following motors:

FED-25: Two 5.50 kW, 2800 rpm cutter motors
One .55 kW infinitely variable gear motor
FED-50: Two 7.50 kW, 2800 rpm cutter motors
One .55 kW infinitely variable gear motor

Approximate weight with motors

Model	Net weight	Incl. seaworthy case
FED-25	2820 lbs.	3520 lbs. (170 cu. ft.)
FED-50	3190 lbs.	3960 lbs. (318 cu. ft.)

On request, the machine can be supplied as **Model FEDP** with a combined shaping and sanding arrangement. This version, however, is only suited for the production of parts having a **straight line** profile (tapered or cylindrical), with a circular, oval or angular cross-section.

NOTE:

On the machine illustrated the guards covering the cutters and the loading device have been removed to allow a better overall view.

We reserve the right to amend or modify the design.

Abb. 1



Messerkopf FED

Abb. 2



Abb. 3



Abb. 4

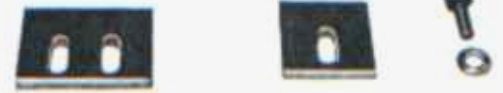


Abb. A

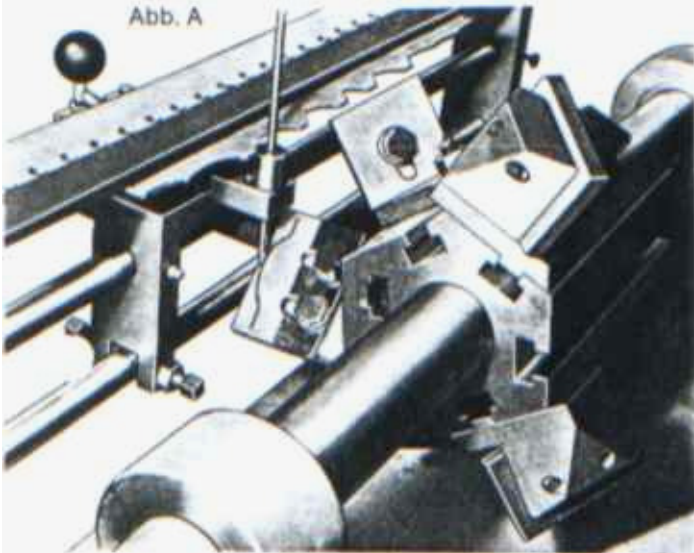


Abb. B



← Type FED/A

▲ Type FED/W

Messerköpfe zum Fräsautomaten Cutterheads for the Milling Machine