MÖHRINGER
makes timber fit


# EDGING AND RESAWING TECHNIQUES

## EDGING AND RESAWING WITH HIGHEST VALUE ADDING

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# AUTOJET EASYFEED
## THE FLEXIBLE ALL-ROUNDER

**Flexible edging, resawing of cants and accurate ripping of dry timber.**

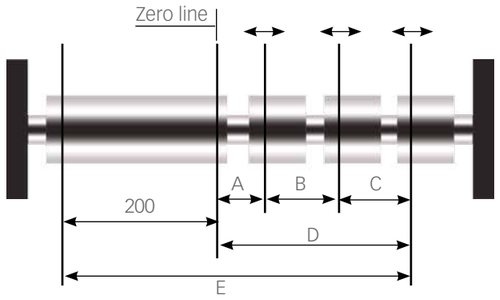
**Applications:**

- Edging of boards
- Lath cutting
- Cutting of cants to frames or scantlings
- Separation of prismatic material
- Production of stacking laths
- Quality cutting of hardwood

**Your advantages:**

- Minimal version for manual edging
- Robust manual edger with solid circular saw housing
- Digital-hydraulic adjustment of the circular saw packs with up to 3 variable saw bushes
- Large outer saw bushes for fixed blade installation to cut laths/frames
- Ergonomic preselection of cutting programs by means of practical user interface

| **Technical data:** | | |
|---|---|---|
| Cutting height | mm | 18 - 80 |
| Wood length min. | m | 1 |
| Incoming width | mm | 100 - 600 |
| Finished width | mm | 24 - 400 |
| Passage width | mm | 700 |
| Saw shaft diameter | mm | 80 |
| Saw shaft drive | kW | 55 -110 |
| Feed speed | m/min | 20 - 100 |




| | |
|---|---|
| A = | 24 - 400 mm |
| B = | 48 - 400 mm |
| C = | 48 - 400 mm |
| D max.= | 500 mm |
| E max. = | 700 mm |



# AUTOJET ECONO 50/80/120
## OUR COMPACT SOLUTION FOR YOUR APPLICATION


**Designed for maximum performance in the smallest area**

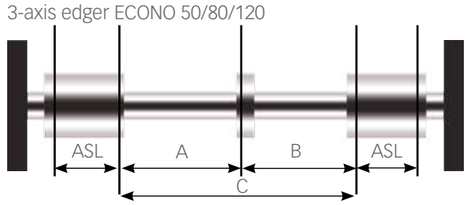
It is place-saving thanks to an integrated continuous cross-cutting station which is specially designed for confined spaces.
Low-cost, space-saving variant, therefore universally applicable for smaller to larger sawmills.

**Your advantages**

- - universally applicable
- - solid technology for flexible cutting
- - cost-effective
- - highly efficient digital positioning controls
- Laser measurement, PC optimization in cross-conveying as well as 3 movable saw bushes (4th movable saw bush optional)
- Manageable investment costs
- Minimum power consumption

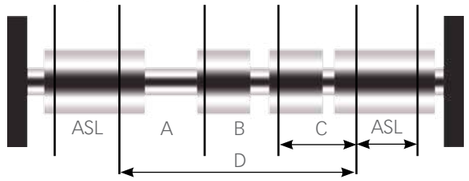
| **Technical data:** | | **ECONO 50** | **ECONO 80** | **ECONO 120** |
|---|---|---|---|---|
| Cutting height | mm | 15 - 50 | 18 - 80 | 18 - 120 |
| Wood length min. | m | 1 | 1 | 1,2 |
| Incoming width | mm | 100 - 650 | 100 - 650 | 100 - 650 |
| Finished width max. | mm | 550 | 550 | 550 |
| Passage width | mm | 700 | 700 | 700 |
| Saw shaft diameter | mm | 80 | 80 | 80 |
| Saw shaft drive | kW | 55 -110 | 55 - 110 | 55 - 110 |
| Feed speed | m/min | 30 - 180 | 30 - 180 | 20 - 120 |

3-axis edger ECONO 50/80/120



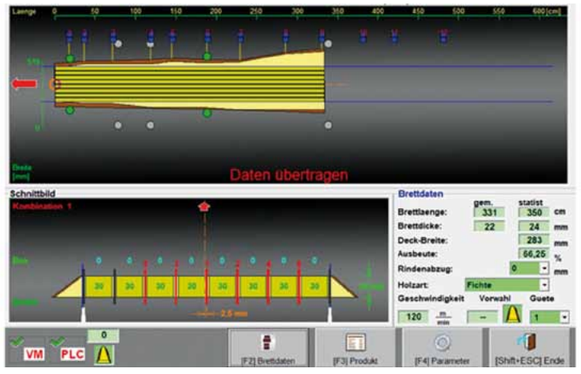

| ASL | 110 | 150 | 170 | 190 |
|---|---|---|---|---|
| A = | 24 - 500 mm | 24 - 450 mm | 24 - 410 mm | 24 - 370 mm |
| B = | 48 - 500 mm | 48 - 450 mm | 48 - 410 mm | 48 - 370 mm |
| C max. = | 550 mm | 530 mm | 490 mm | 450 mm |

4-axis edger ECONO 50/80/120




| ASL | 110 | 150 | 170 | 190 |
|---|---|---|---|---|
| A = | 24 - 500 mm | 24 - 430 mm | 24 - 390 mm | 24 - 350 mm |
| B = | 48 - 500 mm | 48 - 430 mm | 48 - 390 mm | 48 - 350 mm |
| C = | 48 - 500 mm | 48 - 430 mm | 48 - 390 mm | 48 - 350 mm |
| D max.= | 550 mm | 530 mm | 490 mm | 450 mm |

# AUTOJET PRO FLEXIBEL
## HIGHLY FLEXIBLE AND VERSATILE



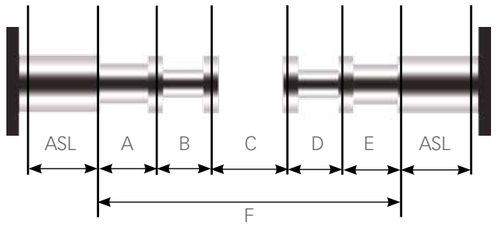

**Edging and resawing circular saw for edging and ripping**
The machine is equipped with 6 movable servo-positionable saw bushes for high adjustment speeds and adjustment accuracies. Likewise available with two bottom saw shafts with bearings on the outside cutting in the counter-rotation (telescopic principle).

**Your advantages:**
- Non-contact precision measurement of the waney edge profile in the cross-conveying
- 15 laser measuring points from above (depending on max. wood length resp. customer request)
- Evaluation unit for laser signals, optimization software, User interface touch screen and operator terminal.
- Optional with 15 additional lasers from below, thus no board, board turning required for double-sided waney edge detection.
- Including pneumatic blow-off device of the measuring points.

**Extensive software package:**
- Automatic feed adjustment, depending on cutting height
- Measurement data evaluation via PC control
- Optimization according to standard, value and surface optimization
- Waney edge or shrinkage measurement input selectable
- Board alignment can be chosen between center, ideal board axis or according to waney side
- Sequential control PLC with remote maintenance and diagnostic functions

**Technical data:**

| | | |
|---|---|---|
| Cutting height | mm | 18 - 120 (*Sonderausführung: 130 mm) |
| Wood length min. | m | 1,2 |
| Incoming width | mm | 100 - 650 |
| Finished width max. | mm | 550 |
| Passage width | mm | 700 |
| Saw shaft diameter | mm | 70 / 130 |
| Saw shaft drive | kW | 2 x 75 - 2 x 132 |
| Feed speed | m/min | 30 - 180 |




| | | |
|---|---|---|
| ASL | 140 | 220 |
| A = | 18 - 200 mm | 18 - 150 mm |
| B = | 18 - 200 mm | 18 - 200 mm |
| C = | 24 - 550 mm | 24 - 400 mm |
| D = | 18 - 200 mm | 18 - 200 mm |
| E = | 18 - 200 mm | 18 - 150 mm |
| F max. = | 600 mm | 500 mm |



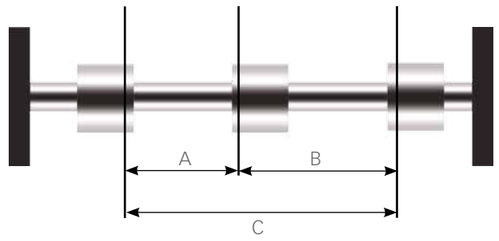
# AUTOJET PRO TURBO
## FOR MAXIMUM PIECE COUNT

**Circular saw edger with increased shaft speed (4000 rpm.) and chain outfeed system**
For high performance and large amount of side products in softwood sawmills.

**Special features:**
- Weight-optimized saw bushes (3 movable saws)
- High-performance drive with 4000 rpm
- Chain outfeed system for separating good material and waste without riving knives
- Feed speed up to 300 m/min.

**Technical data:**

| | | |
|---|---|---|
| Cutting height | mm | 18 - 50 |
| Wood length min. | m | 2 |
| Incoming width | mm | 100 - 500 |
| Finished width | mm | 48 - 450 |
| Passage width | mm | 600 |
| Saw shaft diameter | mm | 80 |
| Saw shaft drive | kW | 132 |
| Feed speed | m/min | 120 - 300 m/min. |
| Piece count max. | pcs./min. | 35 |




| | |
|---|---|
| A = | 24 - 450 mm |
| B = | 48 - 450 mm |
| C max. = | 500 mm |

# KOMBIFLEX BN160
## THE FLEXIBLE EDGING AND RESAWING CIRCULAR SAW


**The versatile edger and resawing line with 6 mobile saw heads for cutting heights up to 160 mm**

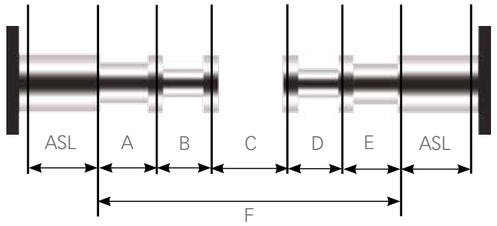
- Singulator and 2nd deck for cants
- optionally with cabin control

**Extensive software package:**

- Automatic feed adjustment, depending on cutting height
- Measurement data evaluation via PC control
- Optimization according to standard, value and surface optimization
- Waney edge or shrinkage measurement input selectable
- Board alignment can be chosen between center, ideal board axis or according to waney side
- PLC sequence control with remote maintenance and diagnostic functions

**Technical data:**

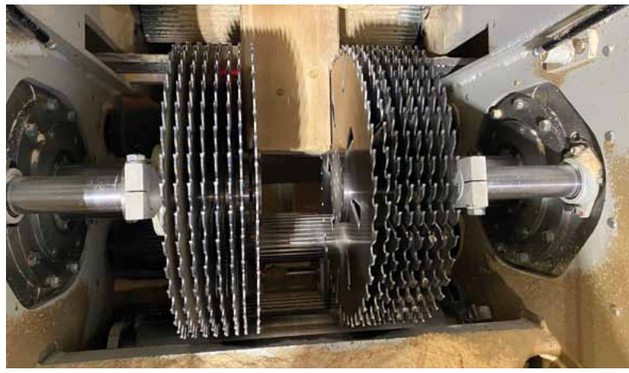
| | | |
|---|---|---|
| Cutting height | mm | 18 - 160 |
| Wood length min. | m | 1,2 |
| Incoming width | mm | 100 - 700 |
| Finished width | mm | 24 - 600 |
| Passage width | mm | 750 |
| Saw shaft diameter | mm | 70 / 130 |
| Saw shaft drive | kW | 2 x 75 - 2 x 132 |
| Feed speed | m/min | 20 - 120 |




| | |
|---|---|
| ASL | 140 |
| A = | 18 - 150 mm |
| B = | 18 - 250 mm |
| C = | 24 - 500 mm |
| D = | 18 - 200 mm |
| E = | 18 - 150 mm |
| F max. = | 700 mm |



# KOMBIFLEX BN225 OPTIONAL WITH CHIPPER CANTER
## EDGING AND RESAWING CIRCULAR SAW WITH PROFILING

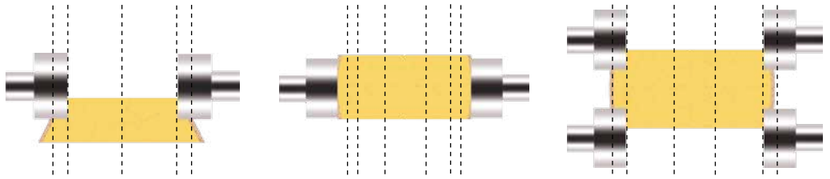


**The unique edging and resawing line for cutting heights up to 225 mm and optionally equipped with 4 additional profiling heads:**

- It can be used to profile additional side boards or to chip slab sides completely
- You save the complete return for edging the resulting side boards
- Trouble-free cutting, due to non-existing waste edgings
- Offers the possibility for half-board sawing

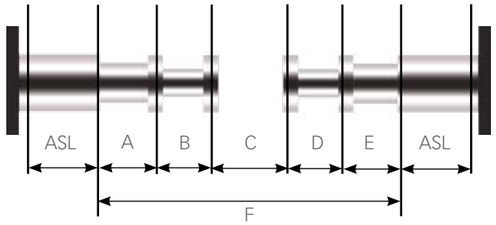
**Equipment features::**

- - completely remote controlled
- - with 6 variable circular saws
- - optionally with 4 profiling heads



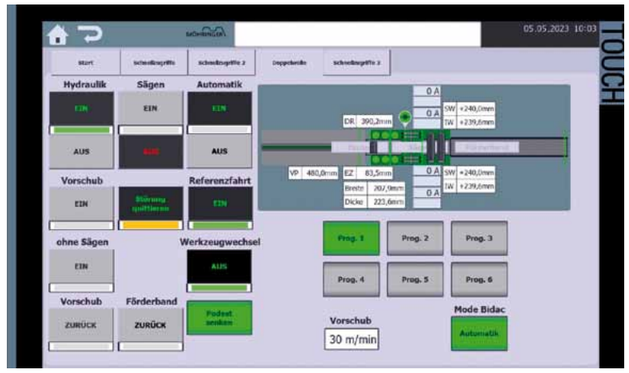
**Technical data:**

| | | |
|---|---|---|
| Cutting height | mm | 18 - 225 |
| Wood length min. | m | 2 |
| Incoming width | mm | 100 - 700 |
| Finished width | mm | 24 - 600 |
| Passage width | mm | 750 |
| Saw shaft diameter | mm | 70 / 130 |
| Saw shaft drive | kW | 2 x 90 - 2 x 132 |
| Feed speed | m/min | 20 - 120 |




| | |
|---|---|
| ASL | 140 |
| A = | 18 - 150 mm |
| B = | 18 - 250 mm |
| C = | 24 - 500 mm |
| D = | 18 - 200 mm |
| E = | 18 - 150 mm |
| F max. = | 700 mm |

# AUTODUO 300
## DOUBLE-ARBOUR RESAW WITH 6 MOVABLE HEADS

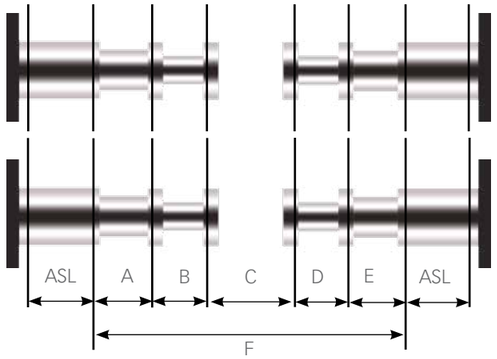



**The powerful resawing line for ripping squared timber**

- 6 mobile axes in telescopic arrangement and double-arbour execution
- Height-adjustable saws
- Large opening for comfortable saw change
- Complete housing with extraction (on site)
- Roller infeed and outfeed system for precise timber guidance

**Technical data:**

| | | |
|---|---|---|
| Cutting height | mm | 60 - 300 |
| Wood length min. | m | 2 |
| Incoming width | mm | 100 - 700 |
| Finished width max. | mm | 24 - 600 |
| Passage width | mm | 750 |
| Saw shaft diameter | mm | 70 / 130 |
| Saw shaft drive | kW | 2 x 90 - 2 x 132 |
| Feed speed | m/min | 20 - 100 |




- for blade change can be moved to one side -

| | | |
|---|---|---|
| ASL | 140 | 220 |
| A max. = | 150 mm | 170 mm |
| B max. = | 200 mm | 200 mm |
| C max. = | 600 mm | 600 mm |
| D max. = | 200 mm | 200 mm |
| E max. = | 150 mm | 170 mm |
| F max. = | 700 mm | 700 mm |



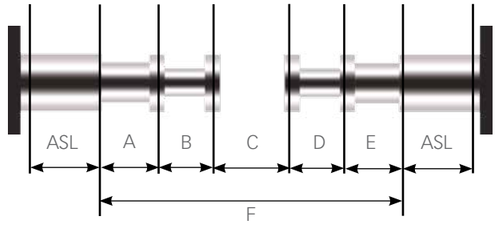
# AUTOJET RIP CUTTING LINE
## FULLY AUTOMATIC RIPPING LINE WITH SURFACE SCANNER

**Quality-oriented edging and cutting of hardwood and value timber**

**Procedure:**
The boards are de-stacked with a suction robot and a sticker scraper and fed into the two-sided **surface scanner** for optimized board division and definition of the final product according to dimension and quality. Optionally, curved boards can be cut transversally into two optimized pieces before being ripped lengthwise. The high performance computer determines the ideal alignment of the board on the basis of the measurement results and quality features. The highly flexible circular saw unit with **6 movable saws** then takes care of the longitudinal ripping of the board. Here, too, it is possible to choose between **waney-edge parallel** to the detected core as a half board or a full optimization with full yield.

**Technical data:**

| | | |
|---|---|---|
| Cutting height | mm | 15 - 70 |
| Wood length min. | m | 1,2 |
| Incoming width | mm | 100 - 650 |
| Finished width | mm | 24 - 300 |
| Passage width | mm | 800 |
| Saw shaft diameter | mm | 70 / 130 |
| Saw shaft drive | kW | 2 x 55 - 2 x 110 |
| Feed speed | m/min | 30 - 120 |

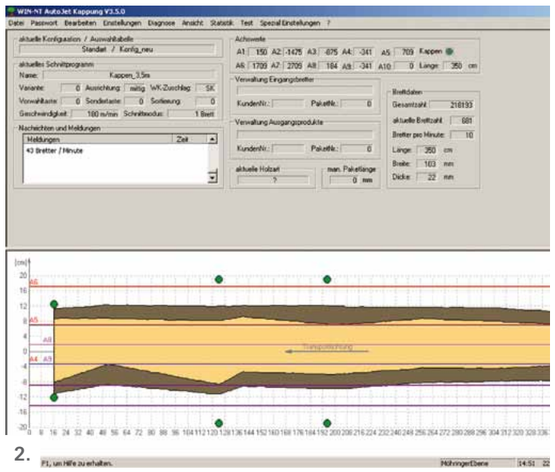



| | | |
|---|---|---|
| ASL | 140 | 120 |
| A = | 18 - 200 mm | 18 - 200 mm |
| B = | 18 - 200 mm | 18 - 200 mm |
| C = | 24 - 550 mm | 24 - 320 mm |
| D = | 18 - 200 mm | 18 - 200 mm |
| E = | 18 - 200 mm | 18 - 200 mm |
| F max. = | 600 mm | 400 mm |

# PRECISE MEASUREMENT TECHNOLOGY
## THIS IS HOW IT WORKS IN DETAIL

**Automatic high-performance edging - Maximum economic efficiency**
Fast, flexible and economical cutting and edging of products was the goal in the development of the new Autojet generation. Modern measuring electronics and reliable computer technology form the basis for maximum output.

1.



2.

**1. Measurement**
The precise measurement of the boards and planks is carried out in a space-saving manner during cross transport. The measurement is carried out **from top and bottom** using the **latest laser technology**. The time-consuming manual turning of the boards by the operator is thereby omitted. With this method, the contour of the board and the condition of the waney edge, in the best case even of twisted boards can be determined. Upgrade: If desired, the Autojet can also be upgraded to include quality detection by means of a **quality scanner**.

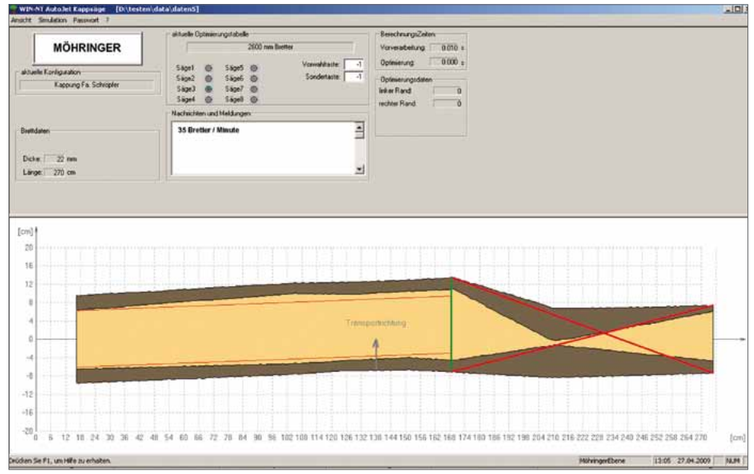
**2. Calculation**
The measured data is passed on to a **microprocessor computer**. Via an user-friendly screen terminal, you can select your **individual cutting programs** according to various criteria (size, price, quality). Of course, you can also select full wood utilization, grid cutting and the proportion of the wane, as well as set quantity limits. The optimization computer calculates the **ideal cutting line**, taking your specifications into account.



# FOR HIGH PERFORMANCE LINES
## INTEGRATED AUTOMATIC CROSS-CUTTING

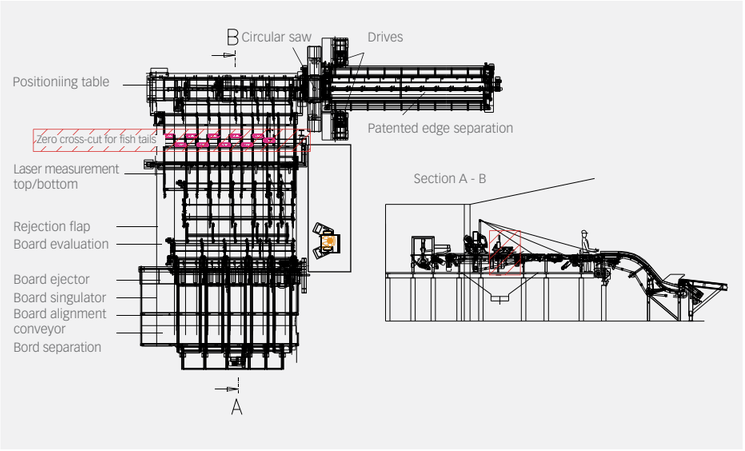
**3. Automatic cross-cutting**
In almost all sawmills, the performance of the edger is limited by the operator. The manual cross-cutting of the fish tails by the operator is therefore replaced by an automatic zero cross-cut saw. Here, the board is measured by **laser from top and bottom** and **optimized** by the PC according to specifications such as price and quantity depending on **width/length**. The integrated cross-cut during cross-conveying then allows an **ideal zero cross-cut of the fishtails**, before the actual edging, already taking into consideration the yield. The operator observes the procedure from the cabin and only intervenes in exceptional cases by a joystick.

Cross-cut of crookedness



Zero cross-cut for fish tails

**Cross-cut of crookedness:**
In order to achieve a maximum yield e.g. by also **cross-cutting curved** pallet boards, the boards are being cross-cut according to PC data and then put on a special infeed table which is separated in the middle. A simultaneous acceleration of the curved cross-cut boards allows **huge board quantities** of up to **55 boards/min.**, reaching an ideal edging result.




**Basic construction Autojet Pro**

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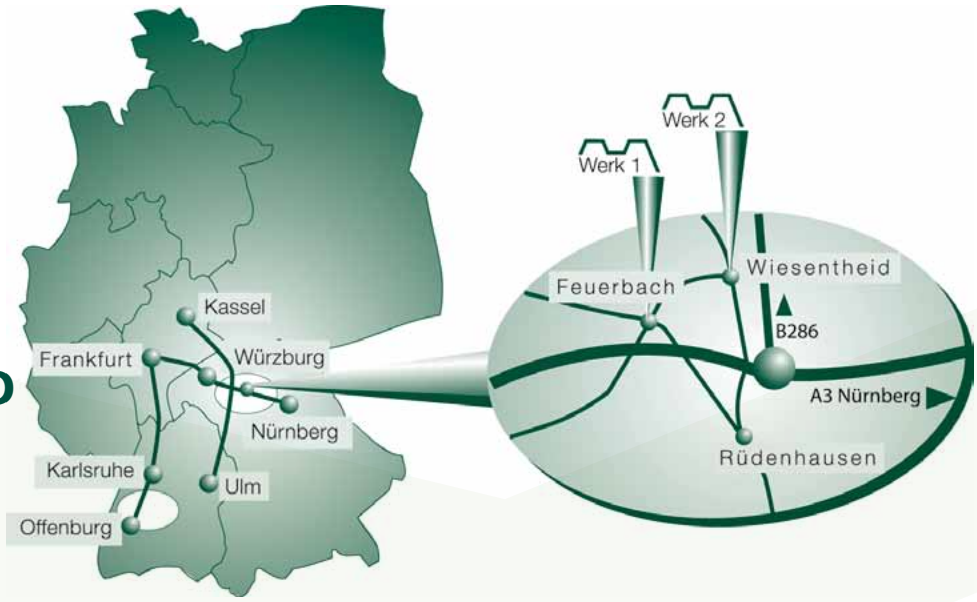


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