

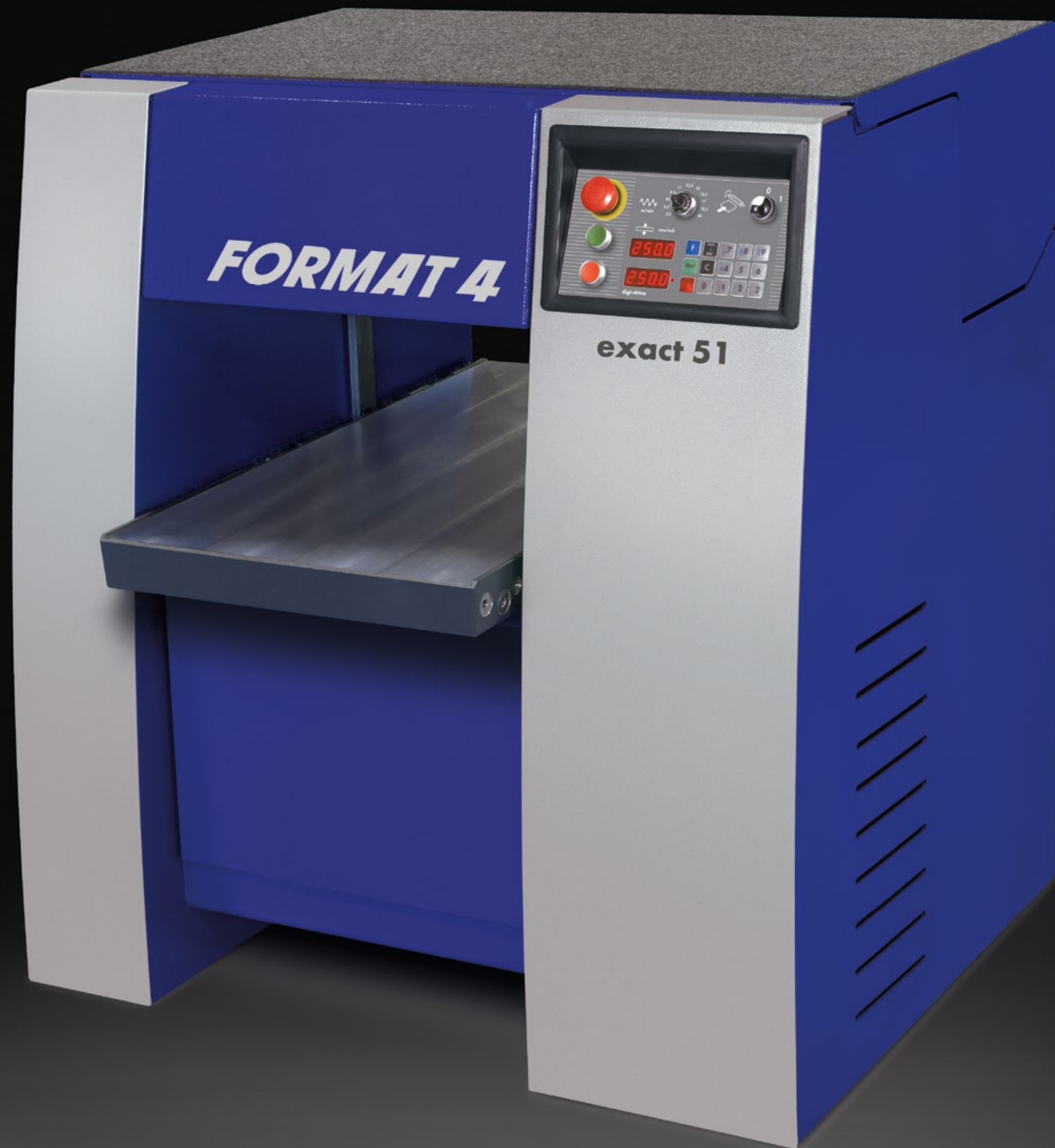
***FORMAT 4***®

**exact 51**

PRECISION AND  
COMFORT FOR  
HEAVY USE



**FORMAT 4®**



## exact 51

### Precision and comfort for heavy use.



Solid wood



If you have the highest demands for perfectly planed wood surfaces, thickness planers from Format4 are exactly what you need. Functionality and user-friendliness, sophisticated technology, perfect processing and unique planing features should not have to be expensive. Come and see for yourself by taking a closer look at the machines!

Additionally to the solid standard features as for example the spring loaded, segmented pressure bar on the infeed, as well as outfeed side, and the continuously adjustable feed rate, which is variable from 5 to 20 m/min, the new exact 51 can be adapted flexibly to the respective customer demands from a long list of options. Wood is a living material, therefore we have the perfect solution for every application, depending on the type of wood, wood moisture and in which dimension around the globe it is planed. Proven system solutions such as the segmented infeed roller, rubberized feed rollers and a under table roller make the new Format4 exact 51 a cost-effective solution for professional planing.



#### exact 51

- » Planing width: 19<sup>3</sup>/<sub>4</sub>" (504 mm)
- » Cutterblock: self-aligning planer knives; Silent-Power® Spiral Blade Cutterblock (optional)
- » Jointing table length: 35<sup>3</sup>/<sub>8</sub>" (900 mm) (59<sup>1</sup>/<sub>16</sub>" = 1,500 mm)
- » Max. depth of cut: <sup>25</sup>/<sub>64</sub>" (10 mm)
- » Thicknessing height <sup>1</sup>/<sub>8</sub> - 11 <sup>13</sup>/<sub>16</sub>"
- » Variable feed speed adjustment 5–20 m/min

### FORMAT4 Premium Machines for Premium Requirements

- |  |   |
|--|---|
| » Constantly high performance in industrial continuous operation | » Quality and precision from AUSTRIA                            |
| » Customer specific optimised production solutions               | » Uncompromising productivity                                   |
| » Solid design with premium components                           | » Perfect service package before, during and after the purchase |
| » Wide range of configuration packages with high-tech solutions  | » Tailor made financing solutions                               |
| » Complete engineering precision                                 | » Mechanical engineering experience since 1956                  |
| » Premium user comfort   |   |



# The most important highlights at a glance



## Silent-Power®

Exclusive for jointer/planers from the Felder Group. The Silent-Power® spiral blade cutterblock cuts noise levels during planing by well over half and provides a continuous pulling cut for tear-free planing patterns in any type of wood. With this revolutionary new development from Format4 you are obtaining all of the advantages of a spiral cutterblock at considerably lower operating, investment and adjustment costs. The benefits of the Silent-Power® spiral blade cutterblock at a glance:

- » Sensationally quiet, noise is reduced by 50%!
- » Blade life up to 20 times longer
- » Four highly precise cutting edges on each knife
- » Optimised chip extraction and reduced chip volume
- » Tear-free planing results
- » Reduced power consumption when compared to similar systems



## "Digi-Drive"

Enter the thickness required, press Start and the jointing bed adjusts exactly to the desired position. LED displays for the required and actual values. Additional functions: incremental adjustment, 4 programmable jointing table positions.



## Feeder device

Variable feed speed of between 5–20 m/min. Whether its a perfect finish or quick thickness calibration that is required, the correct feed speed can always be set to match.

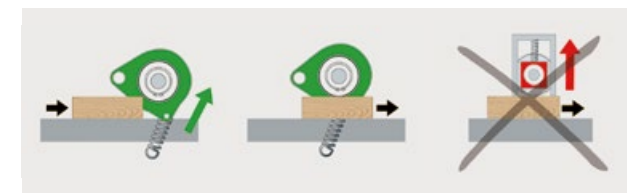
# FORMAT 4®

## Details



## Change the blades in record time

4-knife system cutterblock, knife change in less than two minutes, self-aligning knives resulting in high accuracy when changing blades, no resin build-up on clamping screws. Positive locking ensures ultra-smooth operation, maximum blade life, savings thanks to economical blade price.



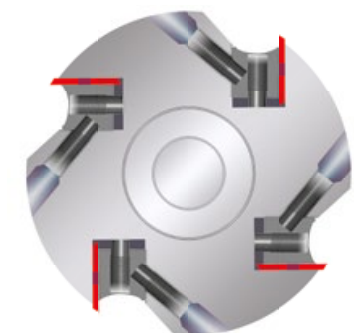
## Infeed rollers

The infeed rollers are suspended which allows them to lift gently when processing with a large depth of cut.



## Power-Drive

Turn knob for quick adjustments, push button for fine adjustments. The LED display shows the actual values.

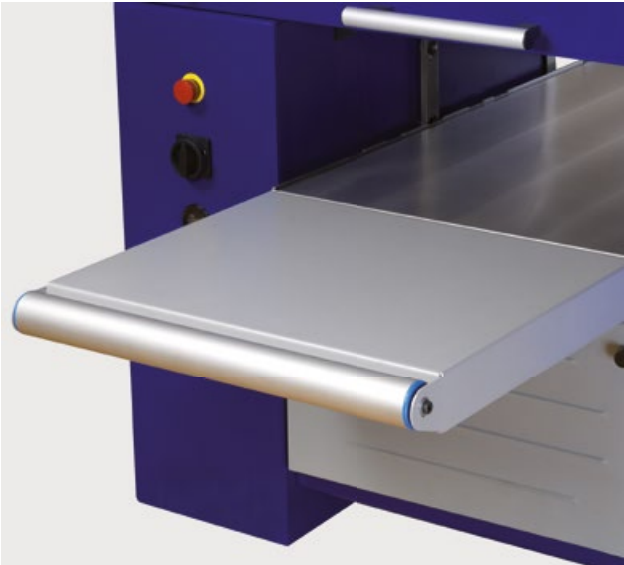


## Thickness planing with 4-knife system cutterblock

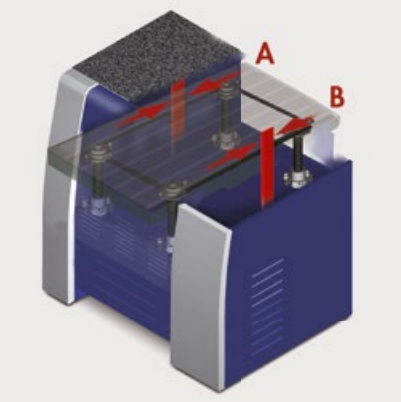
The planer equipped with the Format4 system cutterblock, a 4 <sup>23</sup>/<sub>32</sub>" (120 mm) cutting circle and 4 blades, offers performance, precision and operating comfort all in one.



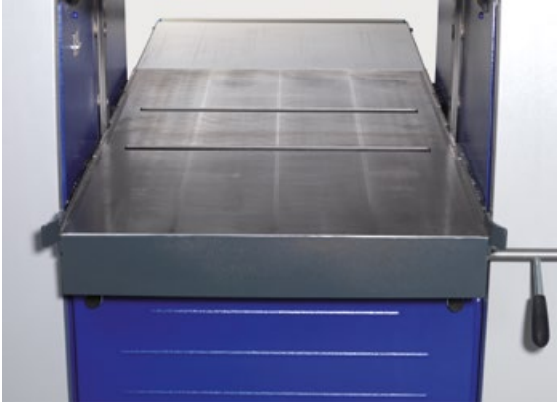
**Workpiece roller on the infeed side**  
Powder coated steel roller for planers with electric jointing table adjustment Mounting is done on the infeed side.



**Table extension**  
Increased comfort: Stable table extensions with workpiece roller on the outfeed side.



**Outstanding stability and long-lasting precision**  
Four trapezoidal support spindles ensure utmost precision and high load bearing capacity. Vertical guides integrated into the side of the machine chassis absorb the resulting outfeed side pressure and guide the jointing table into position with an accuracy of a tenth of a millimeter.



**Adjustable integrated bed rollers**  
Optional integrated adjustable bed rollers are available for processing workpieces with high resin or moisture content.



**Scissor lifting table**  
On request, the planer table can be extended by 45 9/32" (1,150 mm) with a scissor lifting table.

Technical specifications

| Electrics |  | exact 51 |
|-----------|--|----------|
| 001       | 3x 400 V motor voltage                         | S        |
| 002       | 3x 230 V motor voltage                         | W        |
| 004       | 50 Hz motor frequency                          | S        |
| 005       | 60 Hz motor frequency                          | W        |
| 007       | 7.5 HP (5.5 kW) S6/40%                         | S        |
| 008       | 10 HP (7.35 kW) S6/40%                         | O        |
| 009       | 13.5 HP (10 kW) S6/40%                         | O        |
| 10        | STAR-delta-START                               | S        |
| 12        | Switch contact for the control of an extractor | O        |
| 13        | Operating hour meter                           | O        |

| Cutterblock |  |     |
|-------------|--|-----|
| 39          | 4-knife Format-4 system cutterblock                | S   |
| 41          | 4 knife TERSA cutter-block                         | O   |
| 44          | Silent-Power spiral cutterblock                    | O   |
| -           | Rotation speed 5,000 rpm                           | S   |
| -           | Number of knives – Silent-POWER spiral cutterblock | 77  |
| -           | Cutterblock diameter in mm                         | 120 |

| Jointer and feed gears |   |       |
|------------------------|---|-------|
| 53                     | Electric height adjustment for planer table ("PowerDrive" D1)                                   | S     |
| 55                     | Electronic digital display for the jointing table adjustment                                    | S     |
| 57                     | Variable speed 5–20 m/min   | S     |
| 59                     | 2 adjustable rollers under the planer table, adjustment range 0–0.5 mm                          | O     |
| 60                     | Option to preselect "Digi-Drive" D1 dimensions for position control of the jointer table height | O     |
| 61                     | Rubber infeed roller Ø 3 11/32"   | O     |
| 62                     | Rubber outfeed roller Ø 3 11/32"  | O     |
| 63                     | Steel segmented infeed roller, spiral toothed (I61)   | O     |
| 64                     | Second steel outfeed roller, micro teeth Ø 3 11/32" (I62)                                       | O     |
| 65                     | Second rubber coated outfeed roller Ø 3 11/32" (85 mm) (#62)                                    | O     |
| -                      | Steel outfeed roller, micro teeth Ø 3 11/32"  | S     |
| -                      | Jointing width in mm  | 504   |
| -                      | Min.-max. jointing height in mm   | 3–300 |
| -                      | Steel infeed roller Ø 3 11/32" (85 mm)  | S     |
| -                      | Spring-loaded pressure bar on the outfeed   | S     |
| -                      | Spring loaded segmented pressure beam, infeed   | S     |
| -                      | Min. workpiece length in mm   | 270   |
| -                      | Maximum depth of cut in mm  | 10    |



| Important accessories |   | exact 51 |
|-----------------------|---|----------|
| 211                   | 432-103 – Workpiece roller on infeed side for planer table  | ○        |
| 224                   | 600-152 – Table extension with workpiece roller for the planer table (20 <sup>5</sup> / <sub>64</sub> " x 22 <sup>7</sup> / <sub>16</sub> " = 510 x 570 mm) | ○        |
| 225                   | 600-151 + 600-153 – Scissor lifting table to be mounted on the planer table   | ○        |
| General               |   |          |
| -                     | Extraction connection Ø in mm   | 140      |
| -                     | Weight kg (with standard configuration)   | 812      |
| Packaging             |   |          |
| 221                   | Preparation for container transport exact 51, exact 63  | ○        |
| 223                   | IPPC packaging  | ○        |

Product range

Sliding Table  
Panel Saws



Shapers



Planer



Edgebanders



Wide Belt  
Sanding  
Machines



Heated Veneer Presses



CNC  
machining  
centers



Nesting-CNC  
Machining  
centers



Industrial  
Panel  
Saws



Vacuum panel lifter  
Return systems  
Feeding Units



# ***FORMAT 4***®

## **FORMAT4 Uncompromising expertise for the highest of requirements**

The Felder Group premium brand has met the highest standards of professional users since 2001.

The customized high-performance solutions are uncompromisingly innovative, offer maximum operating comfort and complete productivity.

### **FELDER GROUP**

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