FORMAT 4®

tempora F800

SAVING YOU TIME
IS OUR MOTIVATION



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Saving you time is our motivation

Panel material

tempora F800 60.12

» Installation length: 5287 mm
» Edge thickness 0.4–12 mm
» Workpiece thickness: 8–60 mm
» **advantEdge zero joint glue unit**
» Automation: e-motion
» Complete edge processing
» Changeable gluepot with tool free quick change system



VIDEO

Time, the most important resource in a modern workshop, was the focus in the development of the tempora machine concept. Processing edges needs to be as quick, easy, and efficient as possible. To achieve this, the Format4 tempora models combine the core competences of speed, productivity, flexibility and ease of use in a convincing overall package. The final finishing results when processing both coiled and strip material convince with incredibly high standards, that fulfil the ever increasing demands of edgebanding complete processing.

Solid edge processing aggregates and an optimised machine chassis guarantee absolute stability even when running at maximum speed. The user friendly control options, "x-motion plus" and "e-motion" ensure absolute repeatability and individual configurable operating programs enable quick change of the aggregates and edge material. With the processing packages "Professional" and "Performance" as well as the individual selection of aggregates for the two finishing stations, the Format4 tempora can be customised to meet specific company requirements.

More time with your customers in the future, the Format4 tempora allows you to achieve the production in record time.

» Premilling unit with separately controlled diamond milling cutters for chip free glue joints
» First-class operating comfort with the e-motion package and motor controlled units
» Complete stability even at maximum processing speeds due to the solid machine chassis

FORMAT4 Premium Machines for Premium Requirements

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

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The most important highlights at a glance



Format4advantageEdge for a visual zero joint

The patented advantEdge aggregate from Format4 allows for a visual zero joint when processing co-extruded edge and laser edge materials. The aggregate is controlled by the workpiece and can be activated and deactivated directly from the control unit. advantEdge offers the homogenised optic finish of the workpiece with the panel and edge material, in particular with high gloss material. An edge material suited exactly to the material ensures a zero-joint line and as no time-consuming glue change of various colours is required, you profit from considerably reduced changeover times.



Corner rounding unit – An indispensable option for increased productivity

No time consuming post processing of the workpiece! The Format4 corner rounding unit provides the perfect "finish" of workpiece corners (including softforming and postforming materials) for edge material from 0.4–3.0 mm and a processing height of 60 mm at a feed speed of 12 m/min. The solid cast iron construction, linear guides and TC cutter with start-up coupling ensure long-lasting precision. The control of the corner rounding unit is done via the control panel – with the choice as to which corners are to be rounded (only on the front side of the workpiece, only the rear, or the front and rear).



smartouch Control with e-motion

» The smartouch control unit and network connection reduces manual settings to a minimum and enables fast, simple and intuitive selection and control of the units as well as complete monitoring of all machine functions directly from the screen. The features of the smartouch include:
» Unlimited memory for user-defined edge programs
» Maintenance plan, odometer for total meters of material used
» Simple, self-explanatory representation of all units and functions
» Selection and precise fine adjustment of the motorized
» positioning controlled units (setting accuracy 1/100 mm) from the control panel
» Glue temperature setting and automatic temperature reduction in standby mode. Now available with a 21" screen

Details



edgeControl: Edge and workpiece measurement with Bluetooth
Format4 edgeControl now provides even easier and more precise operation and adjustment of tempora edgebanders.

The values for edge and workpiece thickness that are recorded to the hundredth of a millimetre with the wireless measuring unit are transferred to the machine's smartouch operating unit via Bluetooth (workpiece thickness only with e-motion models). The controller recognises the measured values and sorts them automatically according to workpiece or edge thickness. The operator then selects the desired setting values from the measurement data log that contains the five last measured values. Smartouch automatically calibrates all required units to the exact dimensions.

With edgeControl, production losses due to typing or measuring errors as well as tolerance deviations of the edge dimensions are eliminated.



Air cushion table for easy and gentle material handling
Easy and careful handling of large-size and surface-sensitive workpieces Placed directly on the machine's infeed ruler and equipped with a 0.75 kW blower motor, a constant air cushion between the machine table and the resting workpiece ensures easy and gentle workpiece feed. The solid table construction with a 1050 x 400 mm supporting surface (with an additional air cushion table expandable to 2000 x 400 mm) and the flexible extendable frame guarantee maximum stability during workpiece feed.

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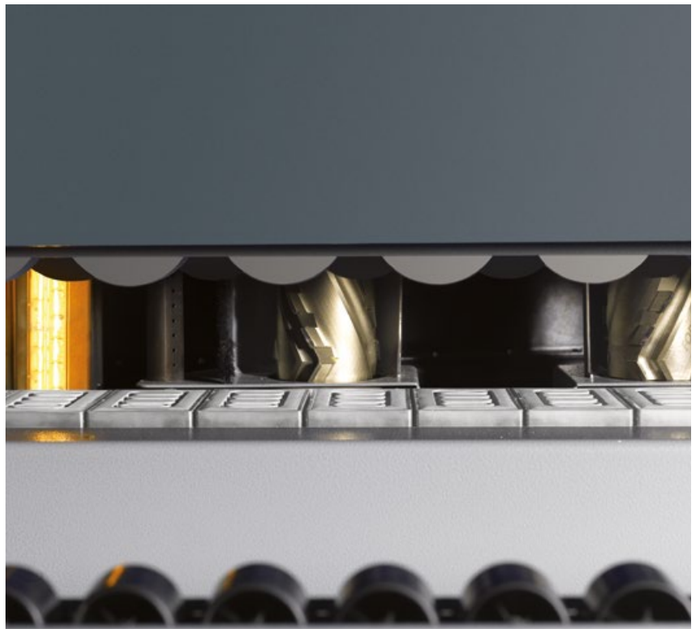
Premilling unit
Ensures a perfect "finish"
Two counter rotating, activation controlled and individually adjustable premilling units with diamond laminated spiral cutters ensure first class edge processing before the material is glued to the edge. With the premilling unit you will achieve chip free edges when processing laminated material. With exact dimensional allowance in the raw cut, the premilling unit takes over the dimensionally accurate formatting of your workpieces. On the e-motion models, the adjustment of the depth of cut is done through motorised positioning control.



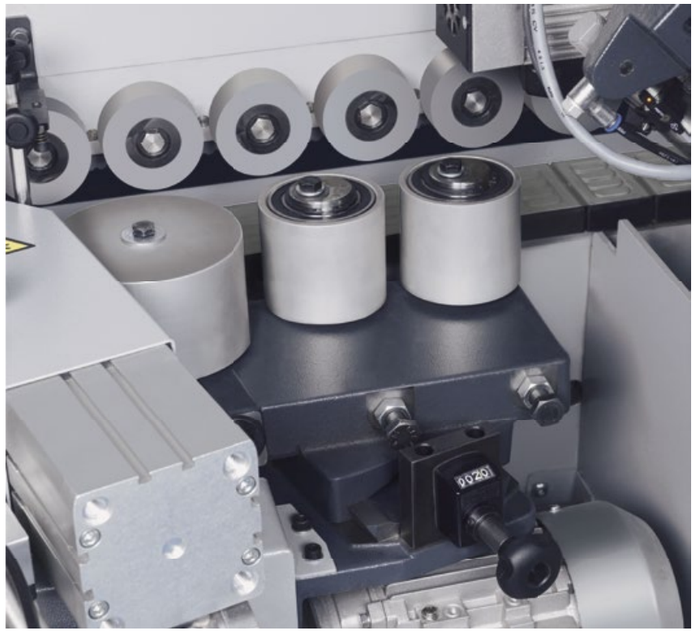
Edge feed and guillotine
scissors for coiled and strip material up to 60 mm in height
Depending on the application, coiled material from 0.4 to 3.0 mm and strip material up to 12 mm can be glued to panel materials up to 60 mm in thickness. An infrared sensor detects whether edging material is available for processing. The guillotine cutters for the precutting of coiled material is designed for the maximum edge dimension of 3 x 64 mm. The magazine for the automatic feeding of strip material using the needle roller has a capacity of 120 mm. The height settings on the pressure bar and the contact pressure manometer placed next to the edge infeed ensure quick changeover times.



Gluepot – short heating up time, tool-free quick-change system
The "tempora" requires only 8 minutes to reach operating temperature. The Teflon coated gluepot and its tool-free quick change system is suitable for EVA (ethylene vinyl acetate copolymers) and PUR (Polyurethane resin) hot melt adhesive granulates. The fine-adjustable glue roller ensures that the correct amount of glue required is applied and can adapt perfectly to different edge materials.

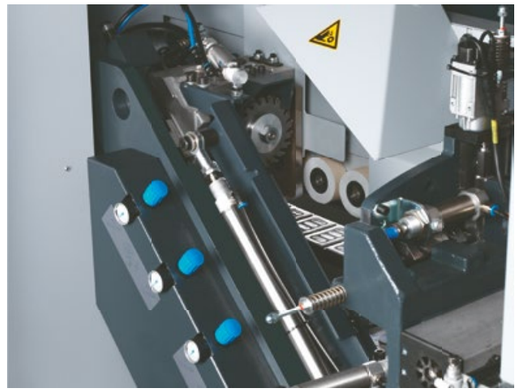


Infrared lamp so the edging adheres better to cold workpieces
The activation controlled, high quality infrared quartz heating lamp heats the edge surface before the panel reaches the glueing unit, ensuring maximum process reliability with improved adhesion, particularly on cold workpieces.

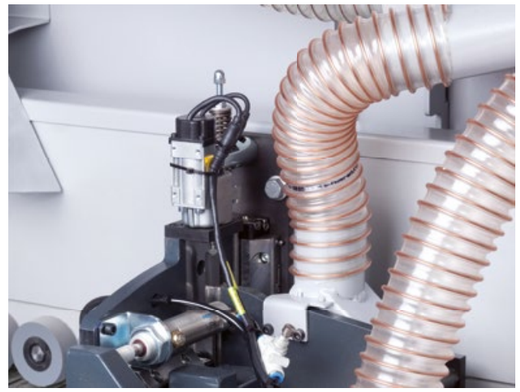


Pressure zone with three rollers
The powered, pneumatically controlled first roller presses the edging material cleanly, perfectly evenly and precisely onto the workpiece. The two conical pressure rollers close the glue joint evenly above and below.

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End Trimming Unit
Precision cuts in every application
The end trimming unit consists of two independent saw trimming units with high frequency motors (12,000 rpm). Linear guides ensure maximum precision. The end trimming unit can be tilted from 0°–15° manually or pneumatically depending on the type of control from the control panel (e.g. end trimming 15°, front edge trim only, rear edge trim only or both front and rear).



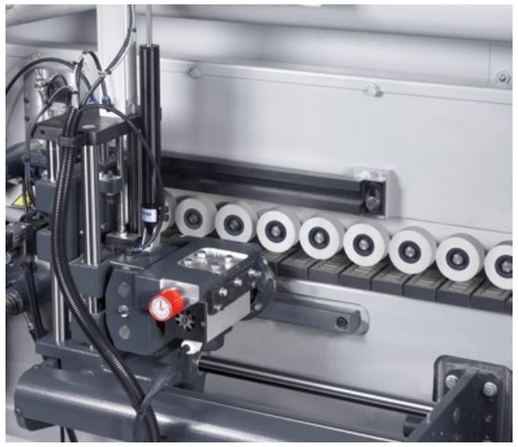
Multi-functional Trimming Unit
Innovative precision with quick setup
Multifunction unit for bevel, flush and radius trimming, as well as the processing of thin edges, consists of two independent routing units with high frequency motors (12,000 rpm). Linear guides ensure highest precision and lowest maintenance. The structural optimisation of the adjustment axes for edge strength and profile ensures quickest adjustment. Depending on the configuration, the multifunction aggregate is brought into position manually or pneumatically via the control panel. The motorised positioning control on all e-motion models is set via the colour touchscreen.



Spray equipment for the application of solutions to leave a finished work-piece that requires no further processing
Low consumption thanks to application-controlled spray nozzles for the application of release agents for PUR adhesives, antistatic coolants and lubricants for sensitive edge materials as well as cleaning and buffing agents for clean components ensure a perfect "finish" without touch-ups.



„Nesting" Package
The "Nesting" Package optimizes the processing of workpieces with cup hinge holes or surfaces with acute angles.

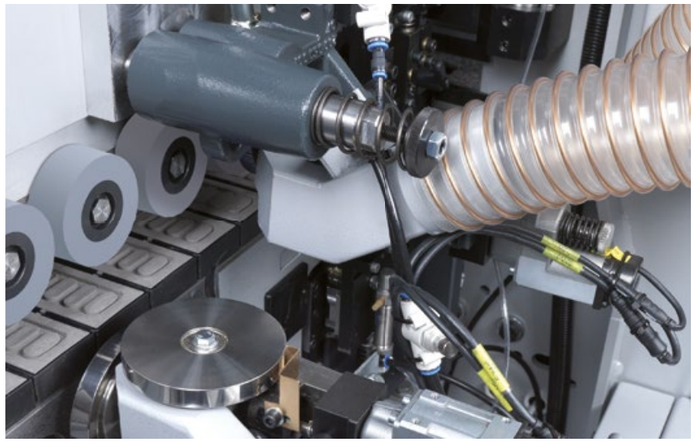


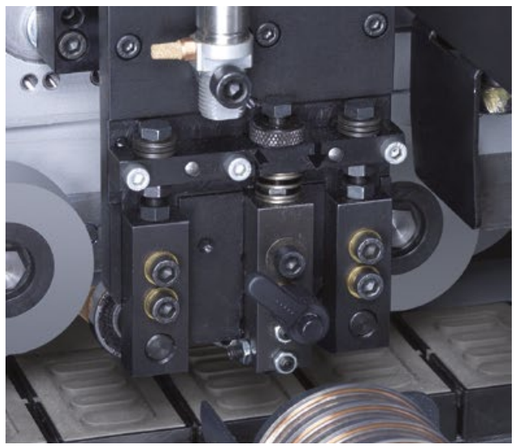
Corner rounding unit – An indispensable option for increased productivity

No time consuming post processing of the workpiece! The Format4 corner rounding unit provides the perfect "finish" of workpiece corners (including softforming and postforming materials) for edge material from 0.4–3.0 mm and a processing height of 60 mm at a feed speed of 12 m/min. The solid cast iron construction, linear guides and TC cutter with start-up coupling ensure long-lasting precision. The control of the corner rounding unit is done via the control panel – with the choice as to which corners are to be rounded (only on the front side of the workpiece, only the rear, or the front and rear).

Radius glue scraper

Radius mill marks are removed using a slight pulling cut resulting in a perfect, smooth "finish". The fine adjustment is done manually; depending on the version, the On the e-motion models, the fine adjustment of the depth of cut is done through motorised positioning control from the 10.4" colour touch screen.





Electronically controlled glue scraping unit

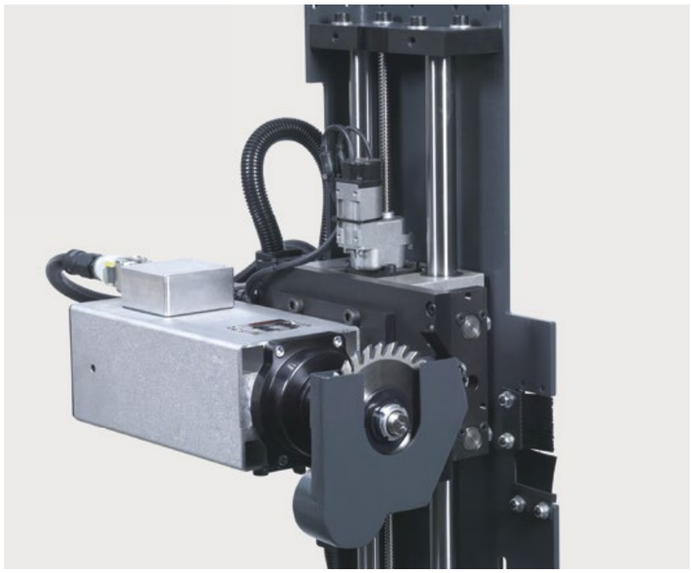
For a perfect workpiece surface "finish". The light scraping function of the surface scraper knives removes all glue residues from the glue bond on the workpiece surface. One more step towards the perfect and completely finished workpiece.

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Buffing Unit

The device consists of two independent electric motors, each fitted with cotton brushes. The task of the buffing unit is to clean and polish the top and bottom part of the edge. Superior "finish" for ABS and PVC edging material. The machine can, on request, be equipped with spraying equipment to apply polish onto the workpiece.





Grooving unit for horizontal and vertical grooves

The new grooving unit of the "tempora 60.12" ensures even higher productivity. Used in a vertical position for rear wall grooves and horizontally for tongue and groove connections, it reduces post processing steps on the spindle moulder. The change of position (vertical or horizontal), is carried out manually and can be done in seconds. The settings for the position and depth (0–15 mm) of the groove can be easily selected on the colour touch screen and set with 1/100 millimetre precision. Depending on desired groove thickness, (4–7.5 mm) special grooving saw blades are used.

puReady – Nitrogen box for glue pots with PUR bonding agents

The puReady nitrogen box offers greater flexibility when using PUR adhesives. In the future you can stay relaxed during production breaks, colour or glue changes. With puReady, your PUR adhesive, stored in nitrogen, remains fresh and processable for a long time. This keeps you flexible in edgebanding and also facilitates the cleaning of the glue pots.

- Delays reaction processes in the PUR adhesive and thus prolongs its processing time
- Facilitates and speeds up the cleaning process
- Increases flexibility when using different PUR colours and PUR adhesives
- Provides space for the storage of two glue pots
- Simple operation and clear control displays
- Mobile and space saving without power- and compressed air connection
- Compatible with all glue pots of the tempora edge banders F600 / F800





Save twice the space. Format4 – storedge
The Format4 storEdge offers space saving storage of your edge material, replaces the edgebander support plate and can be placed next to the machine as and when required.

PUR melting unit
- » Process PUR-adhesive longer, more efficient and free of maintenance
- » The airtight design extends the service life of the PUR adhesives many times over
- » Efficient adhesive application ensures optimum results at low PUR consumption
- » No machine downtime when changing the adhesive (from EVA to PUR) thanks to the PUR tank reservoir
- » Ideal for processing larger quantities of PUR (2 kg) over a longer period of time
- » Very small cleaning effort
- » Exclusively for tempora F800 series edge banding machines



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Technical specifications

	Electrics	**tempora F800 60.12 e-motion**
001	3x 230 V motor voltage, 60 Hz motor frequency	S
002	3x 230 V motor voltage, 60 Hz motor frequency	O
29	CSA certificate	O
77	Tempora air conditioning unit (for continuous external conditions of over 40° C)	O

	Working dimensions	**tempora F800 60.12 e-motion**
-	Min. workpiece width (mm) *The minimum workpiece width varies depending on the workpiece length, height and type of surface	70
-	Min. workpiece length (mm)	140
-	Min. workpiece height (mm)	8
-	Max. workpiece height (mm)	60
-	Processing of coiled material in thick PVC/ABS from 0.4 to 3.0 mm in thickness	S
-	Processing of strip material 0.4–12 mm in thickness	S

	Aggregates	**tempora F800 60.12 e-motion**
-	„e-motion" control with a 10.4" colour touchscreen, featuring integrated maintenance software as well as network connectivity	S
79	21" smartouch instead of 10.4" touchscreen	O
80	Edge thickness measurement with Bluetooth transmission device (!80A)	O
80A	Edge thickness and workpiece thickness measurements	O
76	Fan for electrical control box	O
72	Operating hour summary for multiple users	O
-	Solid machine chassis made from steel	S
-	Pull-out workpiece support – facilitates working with large workpieces	S
-	Motorised positioning-controlled pressure beam with 2 offset roller conveyors for even pressure distribution on the workpiece	S
-	Chain feed with 12 m/min feed speed and rubber covered pads for optimum grip of the workpiece	S
59	Automatic lubrication of the guide tracks chain feed (!60)	O
60	Chain feed with 12 and 20 m/min feed speed and rubber covered pads for optimum grip of the workpiece	O
64	Pneumatic/mechanic barrier prevents a premature feeding of a panel into the machine	O
-	Ball bearing mounted Ø 770 mm coiled material support plate;	S
-	Infeed fence with castor wheels for sensitive materials	S
46	Extended feed guide (+ 400 mm)	O
48	Air cushion table with fan as workpiece support (!46)	O
49	additional air cushion table with extendable workpiece support (#48 / #46)	O
89	Mitre fence for narrow parts (#48)	O
41	Premilling unit with activation controlled diamond cutters and 2 independent motors each with 1.5 kW, 12,000 rpm, manually adjustable depth of cut from 0–3 mm, incl. 2 diamond cutters (Ø 80 mm, H 49 mm, Z 2+2)	S
44	Price reduction tempora 60.12 without premilling unit	O
45	Premillers 64 mm height instead of 49 mm, 2 motors with 2.2kW each instead of 1.5kW each (!44)	O
47	Premillers with replaceable knives 64 mm height instead of 49 mm, 2 motors with 2.2kW each instead of 1.5kW each (!44/!45)	O
43	Infrared heating lamp to preheat the panel edges	O

S ... Standard Equipment | O ... Optional | W ... Choice | - ... not available

-	Edge infeed for coiled and strip material from 0.4–12 mm in thickness, edge recognition via infrared sensor	S
-	Guillotine cutters for the pre-cutting of thick PVC/ABS edge material from 0.4–3.0 mm in thickness	S
-	Teflon coated gluepot with 1.5 kg capacity, glue applied using a fine-adjustable glue roller and quick change system as well as monitoring of the heating cartridge (approx. 250 running metres per 1kg glue granulate on a 19mm panel)	S
65	Preparation for retrofitting of a premelter (!66)	O
66	Premelter for glue granulate, capacity 3.5 kg; Glue pot 0.4 kg with level sensor and quick-change system, heated glue roller (!65)	O
67	Reverse function for the glue applicator roller	O
50	Additional changeable gluepot (!67)	O
50A	Additional changeable gluepot reverse operation (#67)	O
73	Pneumatically controlled gluepot	S
63	easy-clean cleaning device for the standard gluepot	O
-	Motorised positioning-controlled pressure roller unit with 1 large driven pressure roller and 2 subsequent conical pressure rollers, pneumatically operated	S
70	End trimming unit with 2 independent motors each with 0.50 kW, 12,000 rpm, pneumatically tiltable 0°–15°	S
-	Multifunction trimming unit for radius, flush and bevel trimming of thin edges with 2 independent motors each with 0.75 kW, 12,000 rpm, motor-driven positioning-controlled edge adjustment and pneumatic disengagement from the control panel	S
51	Multifunction milling unit with vertical multiple copy rollers for machining workpieces with hinge bores (#64)	O
90	„classic" multifunction trimming and radius scraping unit e-motion with radii of 1 + 2 mm	O
69	Corner rounding unit for soft and postforming workpieces for the processing of the ends of the panel with 0.4–3.0 mm thick edge material and 10–60 mm workpiece height	S
68	Corner rounding unit with 2 independent motors for soft- and post-forming workpieces, designed for machining end and longitudinal edges with edge thicknesses of 0.4–3.0 mm and workpiece heights of 10–60 mm; motorised positioning of the corner rounding cutters instead of a corner rounding unit with 1 motor	O
78	Changeable copy roller for the 2 motor corner rounding unit for edge thickness 1.5mm (!68)	O
71	Motorised adjustment and positioning of the corner rounding cutters	O
56	advantEdge aggregate for the processing of co-extruded edge material up to 40mm workpiece height In conjunction with Option 60, the machine is supplied with feed speeds of 12 m/min or 16 m/min instead of 12 m/min and 20 m/min	O
58	external bag melter for the processing of PUR-glue on the machine	O

"Finish aggregates"		**tempora F800 60.12 e-motion**
11	2-axis motor position-controlled radius scraping unit incl. pneumatic disengage function	S
20	Flush scraping unit, pneumatically controlled	O
21	Glue scrapers for nesting (!20)	O
30	Buffing unit with 2 motors	S
32	Spraying unit for cleaning agent before buffing unit	O
42	Spraying unit of releasing agent on the machine infeed side (PUR glue) (!44)	O
52	Application of anti-static agent	O
53	Spraying unit for lubrication agent	O
74	Grooving unit for horizontal or vertical processing, motorised adjustment X+Y axis, limitation on the corner rounding unit 10–45mm workpiece height (#69 / !68)	O
87	Omission of the spray liquids	W
88	Jowat type adhesive incl. 2 kg adhesive granulate	W

Optional equipment		**tempora F800 60.12 e-motion**
81	Tool preparation R=1mm instead of R=2mm	W
86	Tool preparation R = 1.5 mm for corner rounding unit (! 68)	W
83	Tool preparation R=3mm instead of R=2mm	W
86A	Tool preparation R = 1.5 mm for motorised corner rounding unit (#68)	W
33	LED lighting	O

Packages		**tempora F800 60.12 e-motion**
100	Professional package tempora 60.12 e-motion (additional features included: 64, 47, 67, 71, 20, 32, 33)	O
101	Performance package 1 tempora 60.12 e-motion (additional features included: 60, 65, 64, 71, 67, 20, 33, 42, 47, 53, 32)	O
102	Performance package 2 tempora 60.12 e-motion (additional options included: 60, 65, 64, 68, 47, 67, 20, 33, 42, 53, 32)	O
103	Complete Package tempora 60.12 e-motion (additional features included: 20, 32, 42, 47, 53, 60, 64, 65, 67, 71, 74, 33)	O

Important accessories		**tempora F800 60.12 e-motion**
505	Extraction Distributor professional (!56)	O
500	02.0.202 - Distributor for dust extraction system T60.12, 1x 02.0.1616 mounting kit, 2x 02.0.010 hose clamp (D-120 mm) and 14x 02.0.113 hose clamp (D-50–70 mm)	O
502	02.0.412 - H/SE - Industrial extraction hose, diameter 120 mm	O
501	02.0.406 - H/SE - Industrial extraction hose, diameter 60 mm	O
-	200-102 - Filter unit with water separator and two post fine filters with a contaminant indicator for a wall-mounted maintenance unit	O
-	200-105 - Additional support stand for edgebanders; length 2100 mm height adjustable from 870–960 mm	O
-	200-106 - Mobile cleaning trolley for the gluepot incl. temperature regulation and drive for the glue roller incl. adapter for premelter	O
-	200-107 - Storage container for gluepot including dehumidifier for PUR glues	O
-	202-122 - storEdge edge storage including support plate	O
-	202-123 - storEdge edge storage without support plate	O
-	202-129 - puReady nitrogen container	O
-	202-139 - Silicone gluepot insert F800	O

Transport		**tempora F800 60.12 e-motion**
229	Container packaging	○

Return System U-motion classic		**tempora F800 60.12 e-motion**
605	Return feeding with rotation function for workpieces and unloading bay for Euro pallets; length 300–2800mm; width 80–1500mm; thickness 8–60mm; workpiece sizes with 4 sided edge gluing application; min 300x80mm; max 2800x1500mm; max weight < 700mm length = 30kg; max weight > 700mm length = 60kg; variable feed speed 7–20 m/min; max. 11 cycles/min; convey- or belt for the return transport; the workpieces as well as the outfeed station (2000x800mm); 3x400 Volt / 50–60Hz; 6Bar; 450Nl/min	○
621A	Ergonomics package incl. air cushion lifting table instead of outfeed roller conveyor as well as an air cushion connection table to the machine	○

Options Return System U-motion professional		**tempora F800 60.12 e-motion**
90	additional loading position 1200mm (max. 1 piece) (#84)	○

u-motion classic preparation		**tempora 60.12 e-motion**
84	u-motion classic preparation (!85)	○
85	u-motion professional preparation (!84)	-

Promotional bonus		**tempora F800 60.12 e-motion**
200	1 Bonus Professional package tempora 60.12 e-motion	-537,00
201	1 Bonus Performance package 1 tempora 60.12 e-motion	-1.530,00
202	1 Bonus Performance package 2 tempora 60.12 e-motion	-1.041,00
203	1 Bonus Complete package tempora 60.12 e-motion	-1.460,00

S ... Standard Equipment | O ... Optional | W ... Choice | - ... not available

Product range



kappa 590 x-motion · kappa 590 e-motion · kappa 550 x-motion/PCS® · kappa 550 e-motion/PCS® · kappa 550/PCS® · kappa 450 x-motion/PCS® · kappa 450/PCS®

Sliding Table Panel Saws



profil 92 M e-motion · profil 45 M x-motion · profil 45 M · profil 45 Z x-motion · profil 45 Z

Spindle Moulders



dual 51 · plan 51L · exact 63 · exact 51

Planer



tempora F1000 classic/professional/performance · tempora F800 60.12 e-motion · tempora F600 60.06L · tempora F600 60.06L glueBox® · tempora F400 45.03/L

Edgebanders



industry 1352/1353/1354 · finish 1352/1353 modular · finebrush 1353/1355 · finebrush 953

Wide Belt Sanding & Brushing Machines



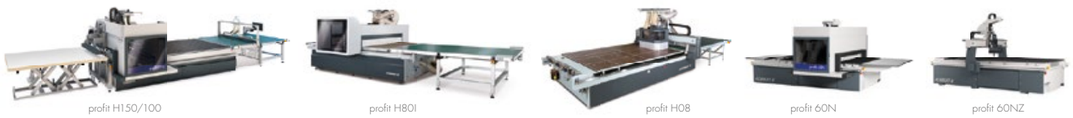
HVP Typ 1/2/3/4

Heated Veneer Presses



creator 1250 · c-express 920 · D-Jet · profit H500R · profit H350R · profit H300R · profit H200R

CNC Machining Centres



profit H150/100 · profit H80I · profit H08 · profit 60N · profit 60NZ

Nesting-CNC Machining Centres



kappa V60 · kappa automatic classic · kappa automatic 85/100 edition

Industrial Panel Saws



v-motion 20.90 classic · u-motion classic · u-motion professional · l-motion · c-motion dynamics · robot-motion

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

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