

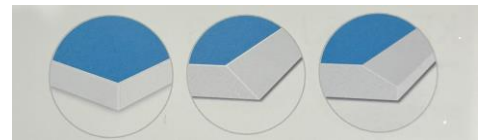


**Combination:  
STRAIGHT AND BEVEL EDGEBANDER  
KE 399**





## KE399 EDGEBANDER all in one. Conventional and bevel Edgebanding



## **KDT** – an Introduction:

KDT are a major manufacturer of panel-based machinery with over 20 years of technical knowledge and experience. They export successfully to all major world markets a comprehensive range of Edgebanders, Beamsaws, Panelsaws, Flow through production lines, CNC routing and Drilling machines. Annual production capacity is 28,000 machines. Click here and take a look...

<https://www.youtube.com/watch?v=xoqp9XiLNds&t=10s>

***KDT machines are built to work hard and designed to last.***

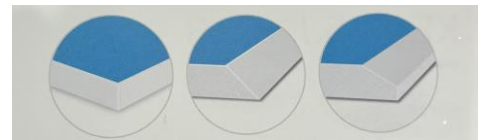


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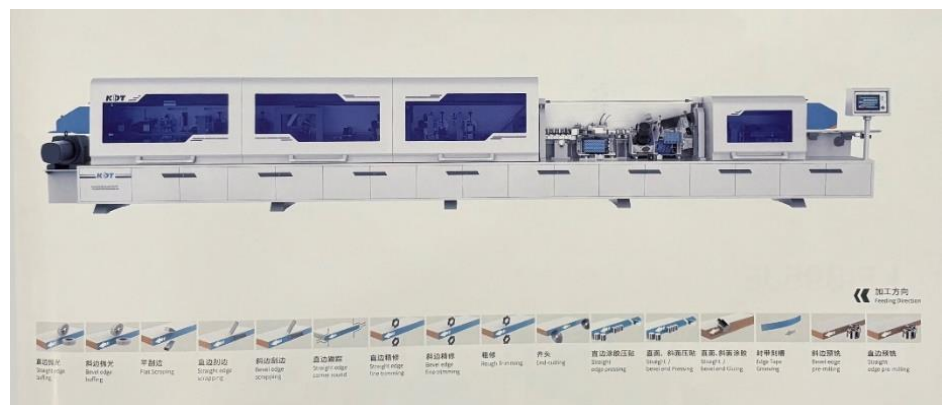
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### KDT399 WORKING GROUPS

The complete specification for bevel and straight edge banding on a single machine with instant changeover from the touchscreen

straight edge pre-milling  
bevel edge pre-milling  
edge tape grooving for bevel/straight combi edge  
straight/bevel end gluing (3 glue stations)  
straight/bevel end pressing (2 independent roller sets)  
end cutting twin saws  
rough trimming top and bottom  
bevel edge fine trimming  
straight edge fine trimming  
straight edge corner rounding  
straight edge scraping  
bevel edge scraping  
flat glue scraping  
bevel edge buffing  
straight edge buffing.

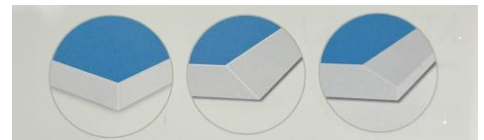


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### **KEY FEATURES**

- Full safety covers over motorized cutting and trimming units.
- Convenient and intuitive touch screen setting at infeed position.
- Fluorescent lights and Large windows in safety hoods for better visibility.
- High feed rates to 24m/min (15-18 for angular, 15-24 for straight)
- Feed jogging button to assist setting up.
- Diamond tipped cutter heads on twin spindle pre-milling stations.
- Electronic 'gate' prevents panels being fed in too close to one another.
- Motorized height setting of top beam for different panel thicknesses.
- High precision THK slide ways on cut-off saws with lubrication
- Efficient high frequency belt free motors on saws and trimmers – Inverter controlled
- Twin Buff units and mounted on 40 and 50mm round bars
- Auto, programmed lube system for feed chain. Quick and easy
- Quick and efficient switching between bevelled and straight edge banding via Touchscreen, increasing machine utilization.
- Equipped with high-quality components from well-known brands, which ensures high reliability
- Auto infra-red device heats the workpieces before pressing the straight edges to ensure the bonding strength between the edge banding strip and the workpieces.
- Double glue-pressing unit, independently configured for bevelled and straight
- Flat scraping unit and double buffing unit to scrape off excess glue lines and polish the edge banding strip.
- Corner rounding unit: twin motor for versatility and speed
- Steel top pressure beam with V-belt ensures stable feeding

**See it in action>Video:**

**[https://www.youtube.com/watch?v=vVRC4hJ5g\\_k](https://www.youtube.com/watch?v=vVRC4hJ5g_k)**



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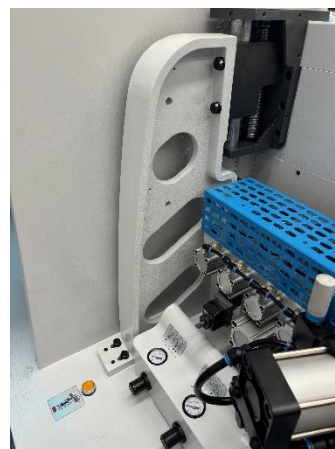


### DESIGN IN DETAIL

#### Built in strength

Everything on an Edgebander relies on the design, strength and rigidity of the machine frame and work unit mountings and this is an area where KDT refuse to compromise. Wherever you look you see this

*- Just a few examples:*



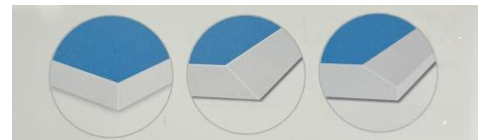
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### You're in control

The functionality and user-friendly format of KDT's touch screen control sets new standards in Operator friendly operation

Most importantly – you switch from conventional 90 degree edging to bevel 'finger pull' edging instantly from the touch screen

You're in total control- selecting functions, setting the 3 feed track speeds, Up/down of the feed beam, glue temperature setting the machine to 'standby' while you have lunch etc.

You can even pre-program start up and shut down times – so your edgebander is heated up and ready for you when you arrive at work!

There's a comprehensive parameter setting function allowing you to adjust settings –e.g. front edge overhang

Tape and piece counting function – the list goes on

*Technicians love this controller- as it has comprehensive diagnostics and fault-finding functions and reports with reset methods and 'fix it steps that often mean no Technician is required.*



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### Handle the heaviest tapes

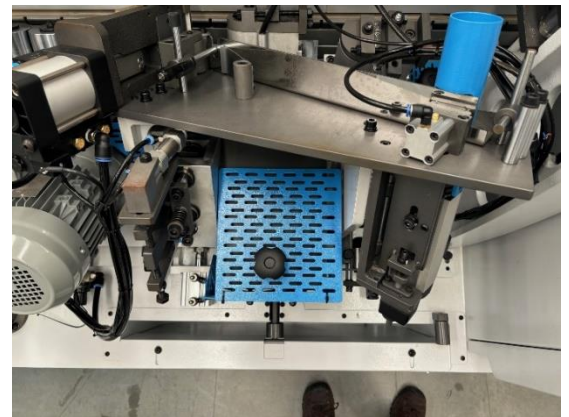
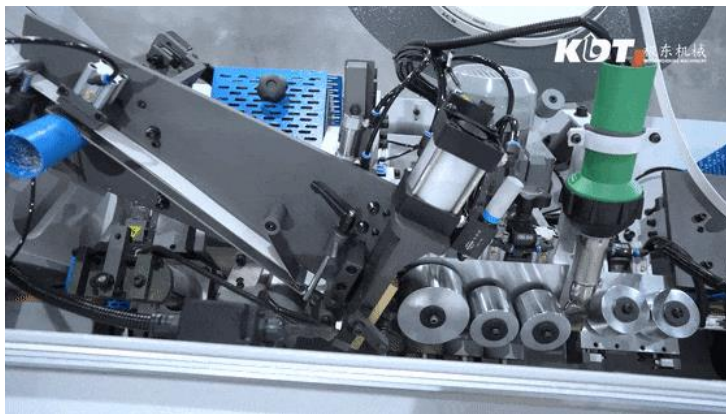
The tape coil holder is a great example of KDT's uncompromising focus on strength.

At 800mm diameter and supported by a massive 60mm diameter column this will keep even the heaviest tape coils perfectly aligned with the infeed guides and rotating smoothly.

A separate 'vertical' tape coil holder feeds your tapes to the bevel edge work units



### Perfect tape feed and application

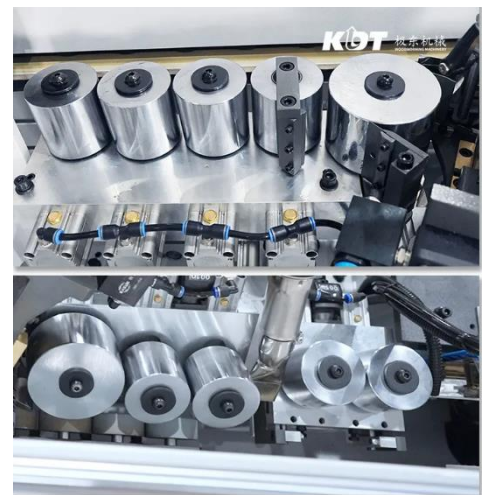


Perfect alignment and uninterrupted feed of your tapes is an essential first step in achieving a great edge. This needs to be complimented by uncompromised application pressure.

KDT infeed guides and feed roller are mounted on 10mm steel plate. A pneumatic pressure roller assures the tape is firmly pressed against the feed roller

This is followed by 2 oversized pneumatic guillotines that cleanly shears even the heaviest tapes from the roll smoothly and easily.

The tape is then pressed onto your panels on the straight and bevel by twin independent pressure roller groups each roller with its own pneumatic cylinder operation.

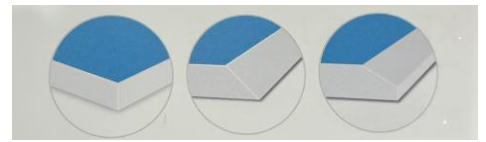


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### Triple glue tanks.

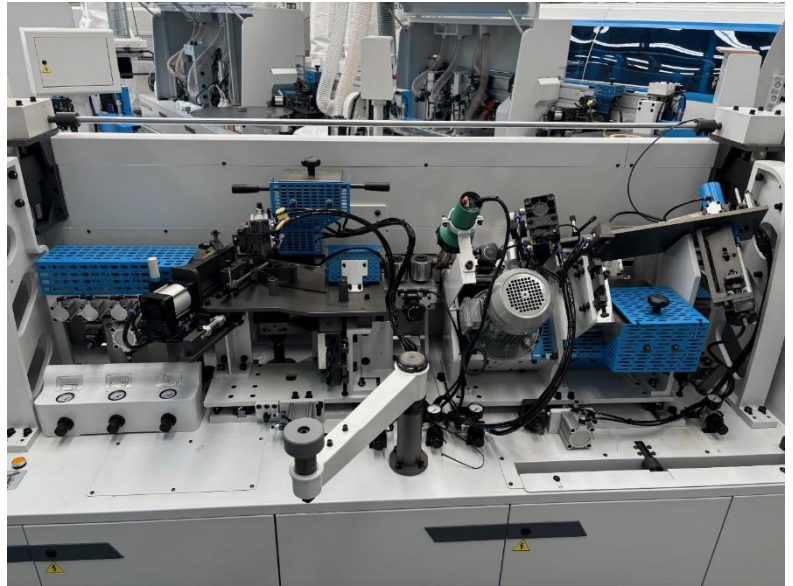
Multiple elements ensure quick and even heating of the glue and a convenient automatic 'standby' is activated if panels have not been processed for a set period. This lowers the glue temperature to maintain colour and strength.

3 Independent glue tanks apply the glue to the straight and bevel panel edges – not to the tape. This is a really important feature as it avoids sticky tape



trimmings accumulating throughout the feed path.

Glue stations are pneumatically excluded along THK guides when not in use



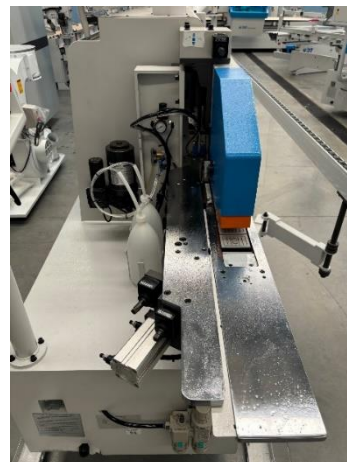
### Panel feed is precise, reliable and foolproof

Simple reliable alignment, support and feeding of your panels keeps your operator happy while ensuring panels arrive and travel through the workstations evenly and perfectly aligned.

KDT start with on oversize chromed infeed plate and an 18mm thick infeed fence with accurate digital servo setting of the premilling allowance. A safety barrier/ switch prevents panels too thick for the track setting to be fed in.

Electronic monitoring eliminates any chance of the gap between panels being too short. The timing is varied automatically dependent on what working stations you have activated. This is better than a 'red light/ green light' system which relies on the operator obeying the light!

Once the panel enters the feed track the electronic 'line control' knows exactly the front and back position of the panel on the track – this eliminates the need for troublesome micro switch control of the working units and allows precise activation setting from the control panel. This is a huge plus for set-up and precise operation of the work units.



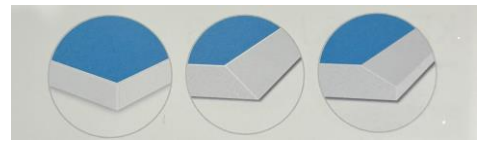
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### Overhead belt for precision feed

The infeed ensures your panels enter the feed track perfectly aligned, spaced and with the line control knowing where they start and stop. Now the feed track must ensure they stay that way as they pass through the machining groups.

The first step is setting the feed track height and KDT have made this effortless and accurate with powered feed track height adjustment coupled to a digital readout and preset heights selected from the touchscreen. A clever tensioning system guarantees the feed track positioning

Above the feed chain is a continuous belt feed- your assurance of precision feeding of even small and slippery panels.

6 oversize columns along the edger support the overhead roller track and ensure alignment without flexing under load

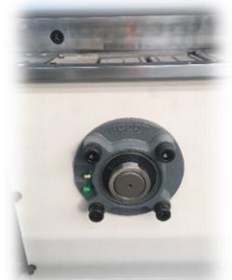


### The bottom feed track

The bottom driven track run on combined square and round guide rails. This is the best guide system as it ensures the track cannot move sideways or tilt under load. Cast bearing housings and heavy chain feed ensure long life, low maintenance and accurate trouble free feed of even your largest and smallest panels.

An automated lubrication pump for the feed track is included – simple and effective.

The bottom track is driven by a powerful 5.5kw motor

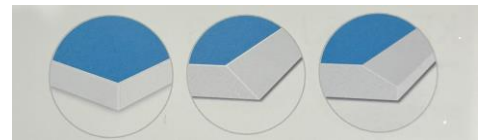


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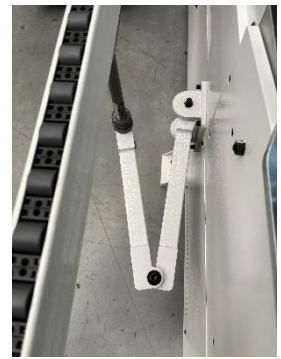


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### Well supported

The panel support easily extends on 4 support arms out to 850mm from the feed track to support wider panels.

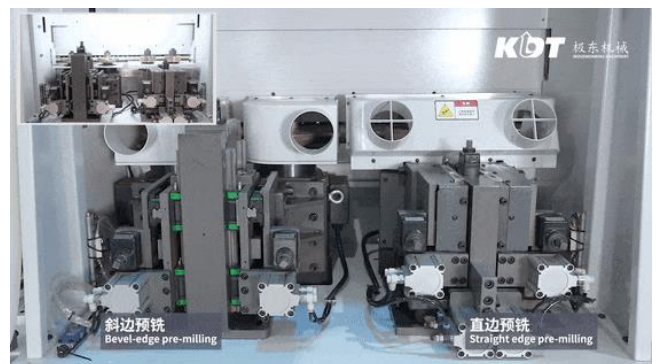
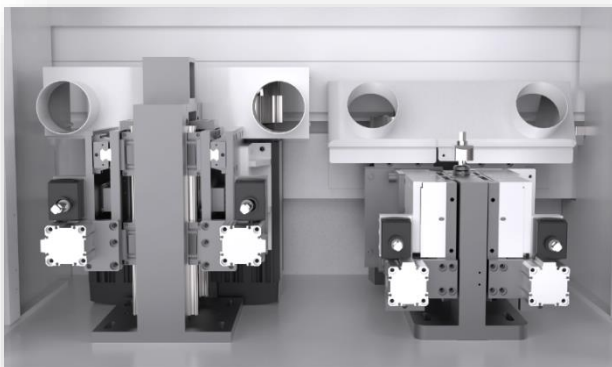


### Unique twin pre-milling system

The heavy-duty twin vertical and bevel trimmers cleanly machine the panel edge vertical or bevel/vertical combination profile.

These are mounted on very solid dovetailed guides and in a separate cabinet from the downstream edging functions to keep dust away from these work areas.

Operation is controlled from the touchscreen with pneumatic exclusion of the Premill not in use



### Clever bevel cut into Tape ensures clean fold

This unit machines out the rebate in the rear of your tapes that is the key to a perfect 'fold' at the point of vertical to bevel. The cutter profile has been carefully designed/ developed to deliver a unique flat/curve groove shape for this requirement



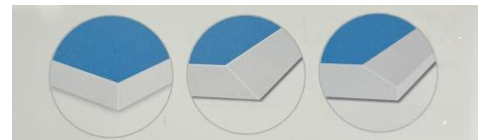
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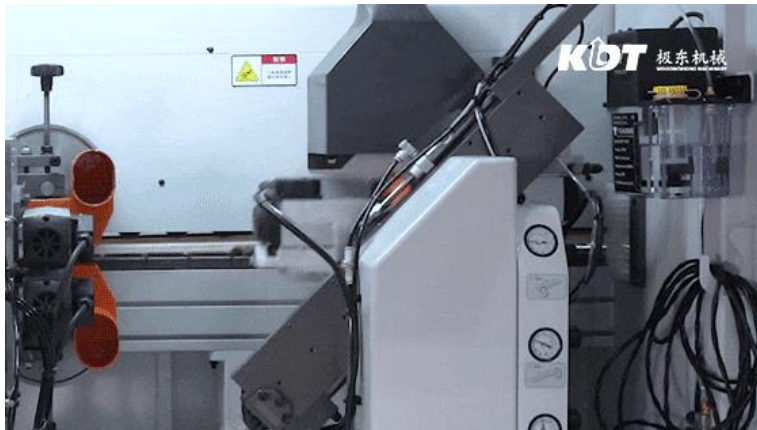




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### End saws precision is guaranteed

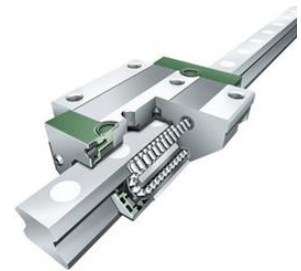


KDT have paid particular attention to their End saw design which like the premill is built the right way.

The saws are mounted on a super strong base and both run on the same high precision THK guide for perfect alignment – and includes auto guide lubrication

Independent 12,000 rpm saw motors ensure clean, effortless trimming of your toughest tapes – with Inverter maintenance of speeds under load

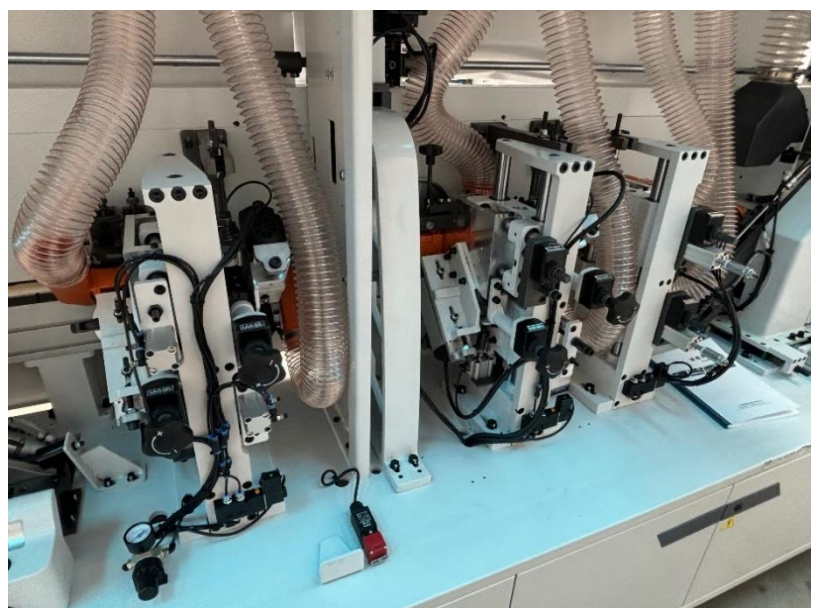
A proximity sensor works in conjunction with the line control to ensure the saws are in position before the next panel arrives – and will shut the feed down if this is not the case avoiding ruining your panel and potentially damaging the saw unit



### Trimmed top and bottom 'spot on' too

KDT use heavy steel construction for the three sets of Trimmers to guarantee the ultra-fine precision required. Large rotating '180mm copy wheels allied with 12,000 rpm HF motors ensure the cutters perfectly trim and radius your edges prior to scraping.

Trimmers are excluded/ engaged pneumatically as required. Digital precision of the engage setting complete the perfect trimming setup.

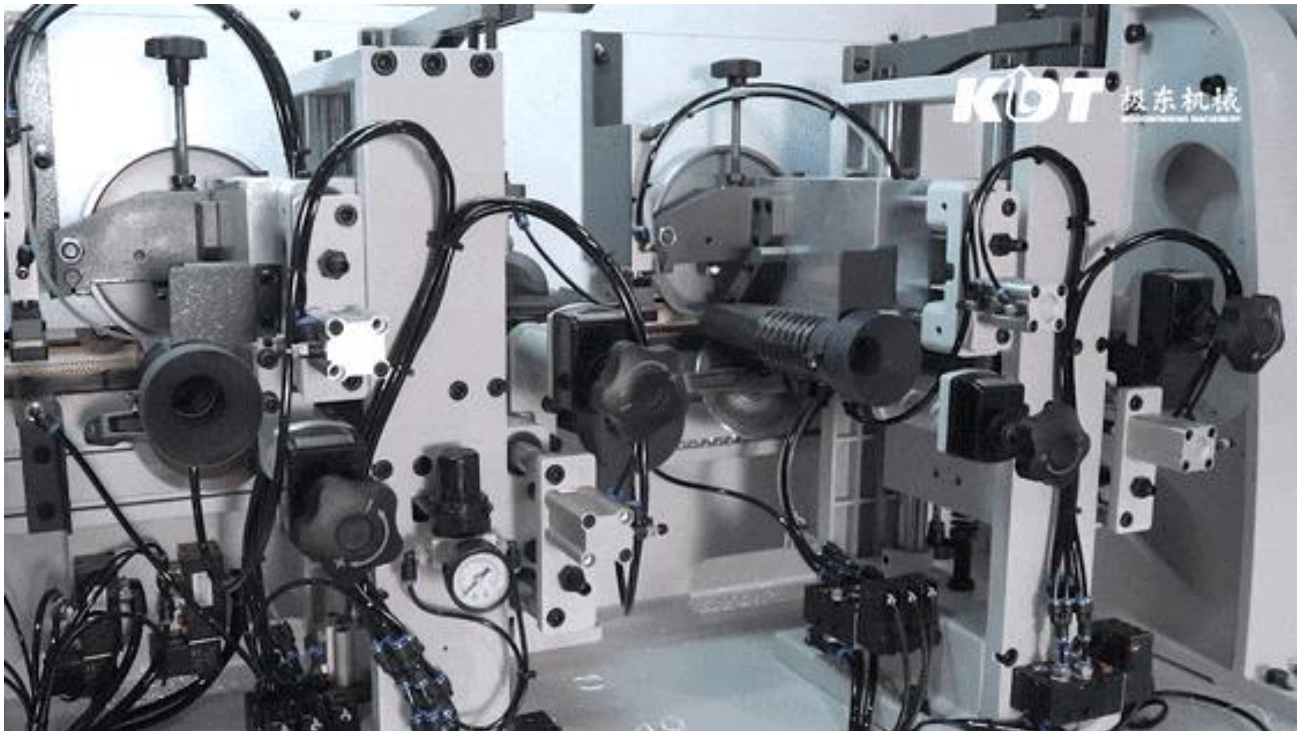
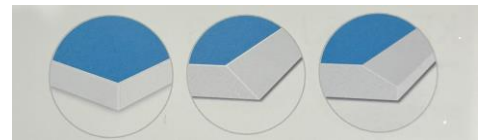


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### Corner rounding precision

High precision, high performance 2 motor corner rounding station – handles 90 degree and shaped corner rounding profiles with ease and at speeds up to 18m/min



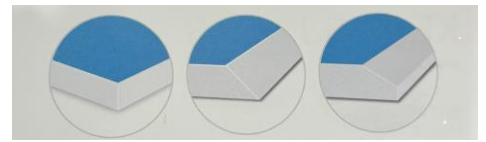
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### Highest precision scraping and finishing too

2sets of heavy duty top and bottom trimming scraping and glue scraping units deliver perfectly finished panels straight from your Edgebander

KDT's scrapers use the same cast iron and steel mounts as the Top and bottom trimmers – it may look like overkill, but scraping is critical to the final appearance of your Panels.

Large rotary copy wheels with air jet blower cleaning deliver the perfect smooth, cutter mark free finish your customers will love.



3-wheel nesting roller system makes these trimmers 'nest friendly'



脱模



清洁



The radius scrapers are followed by a second set of flat glue scrapers.  
Large diameter rod fine thread Digital setting complete these precise scraping units

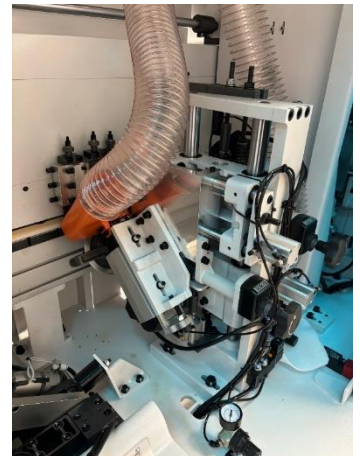
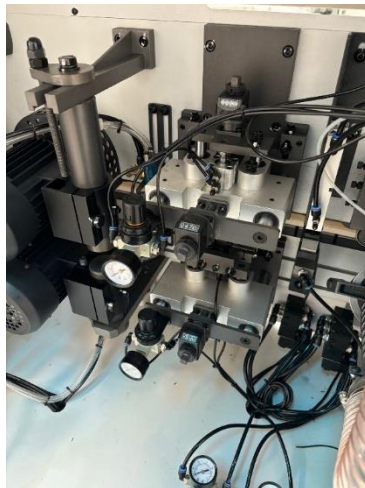
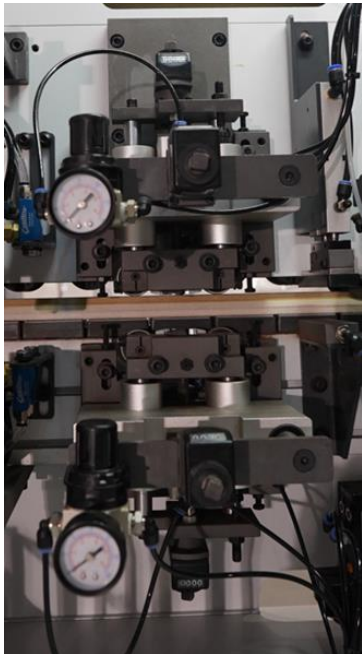
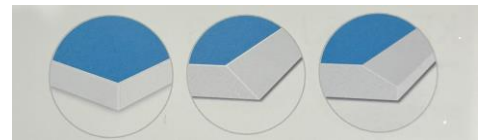


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### Released polished and restored

We include spray unit in front of the buffers.  
There's also a heat gun – to soften the tape  
prior to folding



### The final polish

Final cleaning /polishing and restoration of colour to darker tapes is via 2 sets of large buffs at the  
outfeed. These are mounted on



extra heavy (40 and 50mm  
diameter!) mounts that  
deliver a heavy duty  
vibration free finish.

Pneumatic exclusion of  
buffing station not in use is  
included



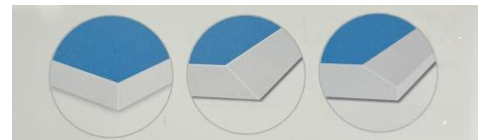
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### Keeping things quiet

The heavy construction of the working units and frame do a great job of noise reduction which is enhanced with the sound dampening hoods.



These are electrically interlocked and operated by large self-supporting gas struts for safety while the large windows allow you to easily keep on eye on things while the machine is working.

Internal lighting can be switched on from the touchscreen control

***It's a small point but they enhance the overall look of the machine – this is a machine that will look great in your workshop and enhance your company's presentation***

### Extraction is important

Good dust extraction is vital to good edgebanding.  
KDT understand this and have paid particular attention to ensuring all hoods and ducts are well designed and function well.



### Quality Electronics

14 Independent Inverters maintain speeds and control functions of each work unit and international quality electrical and pneumatic components are used

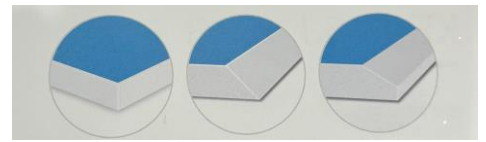


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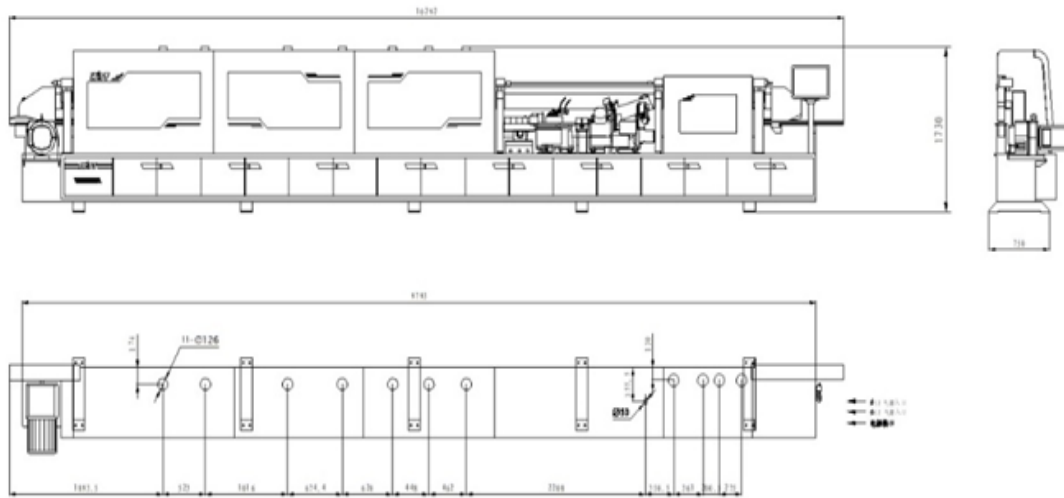
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### Tech Specs:



Feed speed	Straight : 15~24m/min ; Bevel : 15-18m/min
Edge tape thickness	Straight : 0.4-3mm ; Bevel : 0.45~1.5mm
Panel length	Straight : ≥120mm ; Bevel : ≥150mm
Panel width	Straight : ≥90mm ; Bevel : ≥150mm
Total Power (KW)	42.74
Overall size (mm)	10292L*990W*1960H
Extraction connections	φ125*11+φ50*1



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### **OPTIONS:**

Extraction Manifolds.  
Stepped, galvanised construction  
Left- or right-hand discharge



Auto panel return systems to halve your labour costs



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