

1. General Machine Identification

|                                 |                                                         |
|---------------------------------|---------------------------------------------------------|
| Reference Code                  | IT116                                                   |
| Manufacturer / Industrial Group | BIESSE S.p.A. (Via della Meccanica 16, Pesaro - Italy)  |
| Brand / Division                | BIESSEEDGE                                              |
| Model / Series                  | STREAM B1 8.5                                           |
| Machine Category                | Heavy-Duty Industrial Single-Sided Automatic Edgebander |
| Year of Construction            | 2003                                                    |
| Serial Number                   | 35504                                                   |
| Total Machine Net Weight        | 7,140 kg                                                |

2. Pneumatic, Dust Extraction & General Specs

|                                    |                                         |
|------------------------------------|-----------------------------------------|
| Operating Pneumatic Pressure       | 6.5 Bar                                 |
| Suction Air Flow Speed             | 30 m/sec                                |
| Total Dust Extraction Outlets      | Multi-point collection manifold system  |
| Conformity & Quality Certification | ✓ CE Certified / DAR (DAT-ZE-007/94-00) |

3. Workpiece & Edging Capacity

|                                        |                                                    |
|----------------------------------------|----------------------------------------------------|
| Panel Thickness Range                  | 10 mm - 60 mm                                      |
| Coil Edge Thickness (PVC, ABS, Veneer) | 0.4 mm - 3.0 mm                                    |
| Solid Wood Strip Thickness             | Up to 12 mm - 15 mm                                |
| Variable Track Feed Speed              | 12 - 24 m/min (continuous heavy chain drive track) |
| Minimum Panel Width / Length           | 80 mm / 140 mm                                     |

4. Detailed Processing Groups & Machining Stations

|                                                      |                                                                                          |
|------------------------------------------------------|------------------------------------------------------------------------------------------|
| Infeed & Support Track                               | Adjustable infeed fence, top heavy-duty pressure belt & side roller support              |
| 1. Pre-Milling Unit ("FI-502 / Rettifica")           | 2 high-frequency motors with diamond milling cutters & timed pneumatic entry/exit        |
| 2. Anti-Adhesive Liquid Spray Unit                   | Pneumatic spray nozzles preventing glue adhesion on top/bottom panel surfaces            |
| 3. Gluing & Magazine Unit ("SP-10")                  | Hot-melt glue pot, quick pre-melter, motorized glue spreader roller & auto coil magazine |
| 4. Heavy Pressure Zone                               | 1 driven main pressure roller + pneumatic secondary steel pressure rollers               |
| 5. End Trimming Unit ("IN-801 / Intestatori")        | 2 high-frequency motors with linear guides for straight & chamfer end cuts               |
| 6. Rough Fine Trimming Unit ("Rifilatori")           | Top/bottom high-speed motors for coarse excess edge removal                              |
| 7. Fine Radius Trimming Unit ("Spigolatori")         | Precision top/bottom profiling motors with copying tracer wheels for 2mm radius          |
| 8. Corner Rounding Unit ("AR-80 / Arrotondatore")    | Multi-motor automatic corner rounding unit for leading/trailing panel edge profiles      |
| 9. Profile Scraping Unit ("RB-400 / Raschiabordo")   | Precision radius scrapers with copy wheels for PVC/ABS chatter-free finish               |
| 10. Glue Line Scraper Unit ("RC-200 / Raschiacolla") | Flat scraping knives for removing excess glue squeeze-out from panel surfaces            |
| 11. Buffing Unit ("SZ-300 / Spazzole")               | 2 independent motor-driven cloth buffing wheels for cleaning & polishing                 |
| 12. Hot Air Blowers ("Phon")                         | Thermal blowers to reactivate color and shine on worked plastic edges                    |

5. Structure, Control & Safety Specifications

|                            |                                                                                   |
|----------------------------|-----------------------------------------------------------------------------------|
| Control System & Interface | Industrial Numerical Control panel with swivel arm & visual diagnostic screen     |
| Safety Enclosure Hood      | Full-length sound-insulating cabin with interior lighting & pneumatic lift assist |
| Extraction Piping          | Dedicated chip collection hoods at all milling, trimming, and scraping stations   |

Detailed technical specifications compiled directly from the BIESSEEDGE CE nameplate (Serial 35504) and Stream B1 series technical manual.