

1. Machine Identification & General Data

Reference Code	IT119
Manufacturer / Brand	CML Machine Tools (Italia)
Machine Category	Automatic Double End Tenoner & Profiling Line ("Squadratrice-Tenonatrice Bilaterale")
Structure Layout	Left Fixed Column + Right Movable Column on Linear Guides with Standalone Control Cabinet
Conformity & Safety Standards	✓ CE Compliant (Sound-proof safety cabins with doors and viewports)

2. Feed System, Drive & Mechanical Structure

Conveyor Track System	Dual continuous feed tracks with high-grip vulcanized rubber pads
Upper Hold-Down System	Dual continuous overhead pressure belts with pneumatic vertical tensioning
Opening / Width Drive System	Motorized lateral movement driven by precision ball screw on hardened linear guides
Infeed Chain Dog System	Precision push dogs/lugs for automatic panel squaring and synchronized feeding
Dust & Chip Extraction	Top-mounted multi-port extraction hoods per operating unit connected to central exhaust

3. Detailed Working Stations & Spindles ("Gruppi Operatori")

Scoring / Cut-off Saw Units (1st Station)	High-frequency scoring motors for anti-chipping panel edge cuts
Hogging / Squaring Units (2nd Station)	Main sizing saw blades + hogging cutters for rapid material removal
Milling & Profiling Spindles (3rd & 4th Stations)	High-speed vertical & multi-axis tiltable electro-spindles with stackable cutter heads
Internal Component Tooling	Equipped with Celaschi/SCM original tool-holder assemblies and spindle units
Precision Micro-Adjustments	Manual adjustment handwheels paired with mechanical SIKO digital position readouts
Pneumatic Timed Actuation	Pneumatic cylinders for automatic tool insertion/exclusion on corner profiles

4. Electrical Cabinet, Automation & Safety Features

Electrical Control Enclosure	Standalone double-door cabinet with integrated forced ventilation cooling system
Control Interface / PLC	Integrated electronic PLC terminal with multi-line status display and parameter keypad
Control Panel Components	Individual motor ammeters, start/stop pushbuttons, selector switches & warning lamps
Pneumatic & Lubrication System	Centralized FRL air treatment unit (Filter, Regulator, Lubricator) + track chain lubrication pump
Safety Enclosures & Interlocks	Full acoustic sound-proofing cabins with inspection windows and door safety interlocks
Emergency Stop Systems	Infeed/outfeed mushroom E-Stop pushbuttons with key lockout switch

Technical data verified from direct visual inspection, CML logo on outer chassis, and internal spindle group photographs (Code IT119).