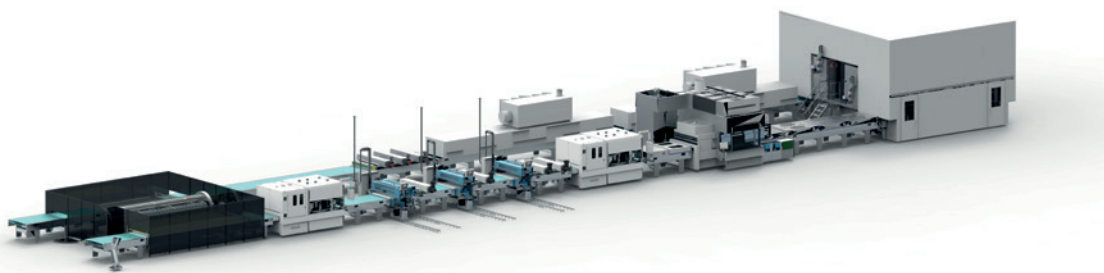


ROLLER COATING - THE MOST EFFICIENT COATING SOLUTION FOR FLAT PARTS AND COMPONENTS

The most efficient solution to coat flat parts is the roller coating technology. Nearly 100% transfer efficiency at a high productivity and short processing times due to the use of UV cureable coatings are the benefits of this technology. Venjakob offers roller coating lines for flooring (hardwood, engineered flooring, veneered flooring, LVT etc.), for full size boards, for doors and for furniture components.

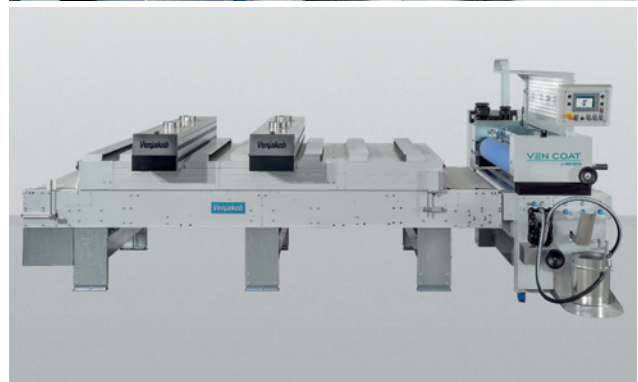


SYSTEM ADVANTAGES

- highest transfer rate of all coating technologies, nearly no lost material
- ideal coating technology for flat parts
- pigmented and clear coating materials available
- flexible configuration of coating lines due to modular design. Line can be expanded according to needed output
- combination with spray application possible
- all components for a coating line from one single source. Cleaning, pre-treatment, application, drying, curing, material handling

ROLLER COATER:

- coating process with zero vibrations due to rigid machine frame, perfect application for highest quality levels
- scraper units to be taken out of the machine completely. Smoothing roller in filler machine moveable. Scrapers pressed on pneumatically, scraper oscillation motorized
- easy access for adjustments and maintenance



Line parameters

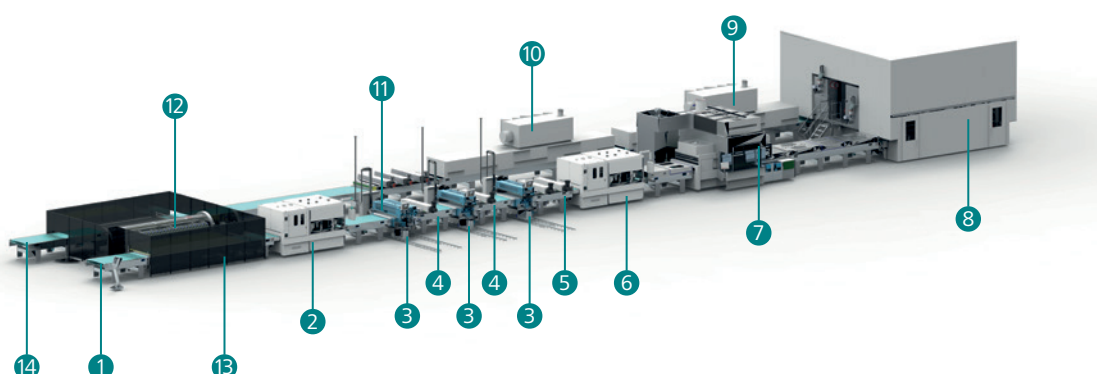
working width:	700, 1300, 1600 mm
feeding speed:	5 – 30 m/min

We think along with you in every project phase and offer professional solutions for every application - with us you get everything from a single source!

SURFACE PRE-TREATMENT | COATING | DRYING | AUTOMATION | EXHAUST AIR CLEANING

COMBINED COATING LINE FOR DOORS

Combined coating line with roller and spray application for coating interior doors with base coats in the roller coating process and top coats by spray coating process. Processing of UV cureable base coats and water-based UV top coats. Coating of edge and surface. Use of efficient roller application as far as possible supplemented by spray application for the entire surface and edge. Upgrades for fast color change, paint recovery of the sprayed coating material, UV-LED etc. possible. Different levels of automatisisation, data processing and data management possible.



PROCESS DESCRIPTION

- 1 semi- or fully automated feeding in batches
- 2 white-wood sanding of surface and profiles
- 3 base coat application. UV coating material, approx. 15 g/m²
- 4 partial curing
- 5 full curing
- 6 intermediate sanding surface and profiles
- 7 top coat application, water-based UV, approx. 120 g/m²
- 8 soft drying in multi-level dryer. Drying time approx. 30-45 min, temperature 40-60 °C (100-140 °F)
- 9 forced drying in air jet dryer. Drying time approx. 1min, temperature 60 °C (140 °F)
- 10 if needed cooling with ambient air or with actively cooled air
- 11 curing of UV part of top coat material
- 12 turning of parts for second pass
- 13 return of parts for second pass
- 14 semi- or fully automated stacking

Line parameters*¹

working width:	1300 mm
feeding speed:	2 – 10 m/min
production speed:	6 – 8 m/min
production volume per shift* ² :	2000 m ²
exhaust air volume:	8400 m ³ /h* ³
space requirements:	750 m ²
connected electrical load:	200 kW
feeding/stacking capacity:	1 – 2/min
hot water requirements:	12 m ³ /h



*¹ without sanders
 *² Shift: 7 h à 60 min., 50% Efficiency. Output strongly depending on number of color and thickness changes and drying time of top coat.
 *³ plus hot air from dryers

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