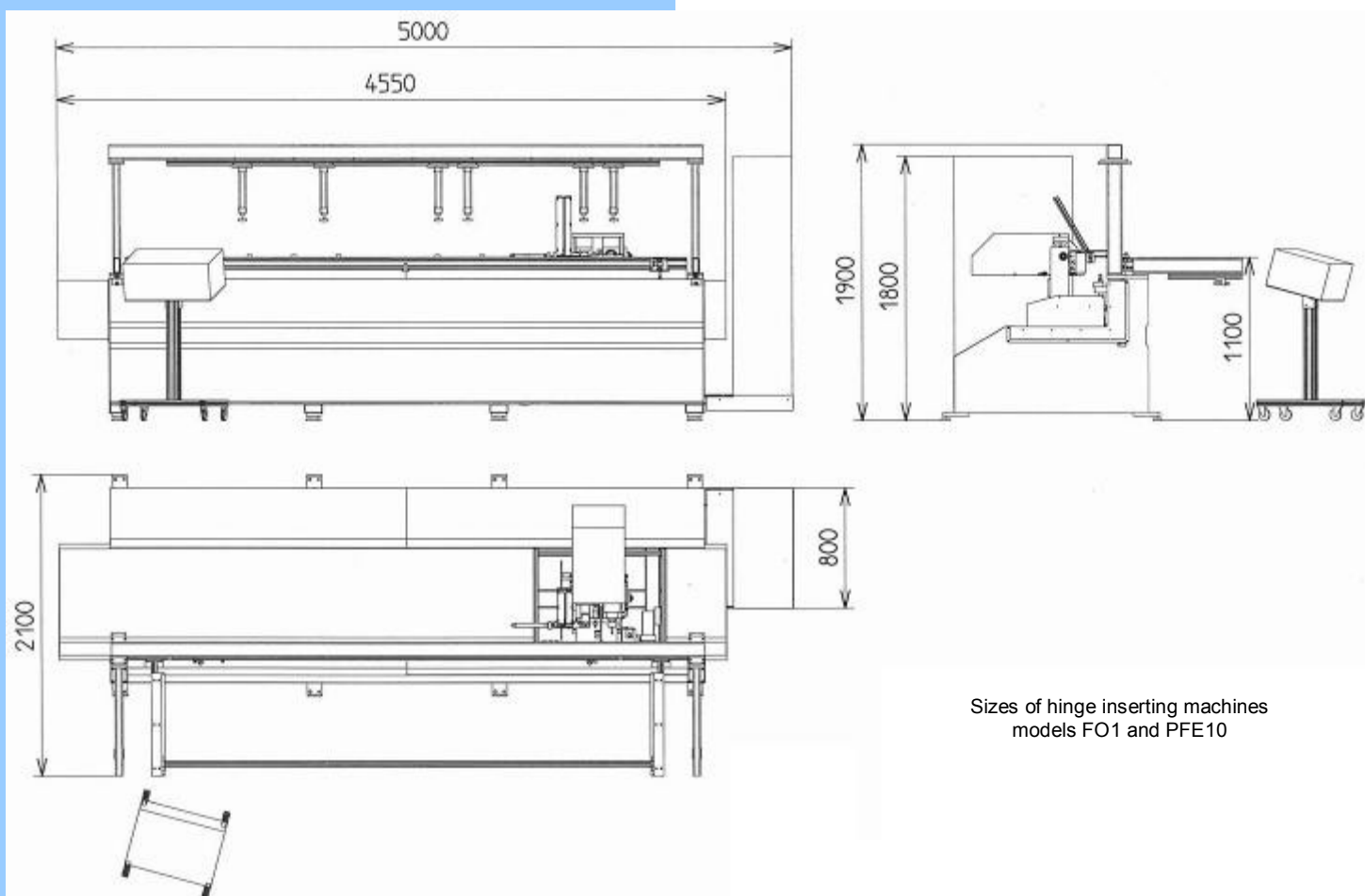


## GENERAL CHARACTERISTICS

- Structure ..... steel welded frame
- Aluminium table ..... width 230 mm, height 900 mm
- Max. piece length ..... 2650 mm
- Max. length between the 2 hinges (opening) ..... 2490 mm
- Max. distance between 2 drillings (fixed) ..... 2490 mm
- Vertical pressers ..... pneumatic
- Reference stops ..... right and left with cell detection
- Hinge storage unit ..... Anuba hinges for sashes
- Axis movement speed ..... 0 to 60 m/min.
- Longitudinal travel of the hinge unit ..... 2500 mm, digital
- Hinge insertion spindle rotation ..... digital
- Hinge inserting head angularity ..... 5° adjustable
- Protection case ..... full protection with screens (EC standards)
- Compressed air ..... 6 bars
- Voltage ..... 380 three-phased Volts
- Weight ..... 1250 Kg
- Sound emission ..... 70 dB while charging - NFE 6410 ; NFS 31069
- Average hinge insertion time ..... 8 seconds (head movement + inserting)
- Average drilling time for 2 plate holes ..... 6 seconds (head movement + drilling)
- Drilling unit ..... 2800 t/min. – 0,37 kW – electrical rotation
- Anuba hinge inserting unit ..... CNC Motor
- Plate drilling unit (Ref. PFE10) ..... 3000 t/min. – 0,4 kW – pneumatic rotation
- Interchangeable magazine for sash hinges with automatic distribution

## OPTIONAL EQUIPMENTS

- Adjunction of a drilling unit for screw rams
- Automatic load and unload of the frames to place them behind a trimmer (Ref. AFO1)
- Double loading storage unit
- Data entry by the bar code reader
- Plate drilling device mullion frame



Sizes of hinge inserting machines  
models FO1 and PFE10

The data and features indicated in this document are prone to improvements or modifications and cannot engage our responsibility

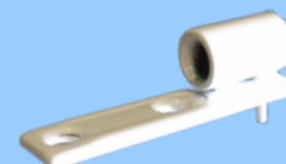
# CNC hinge inserting machines for PVC joinery



Réf. **FO1** Drilling and hinge inserting machine  
for Anuba hinges, on sashes.

Réf. **PFE10** Drilling and hinge inserting machine  
for Anuba hinges, on sashes and hinge plate  
drilling on frames.

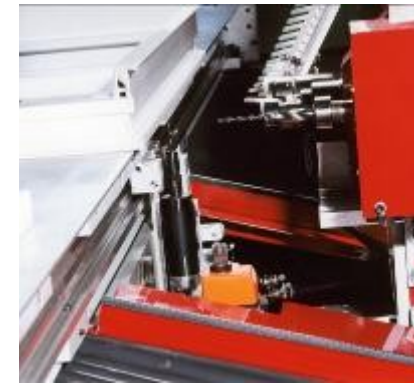
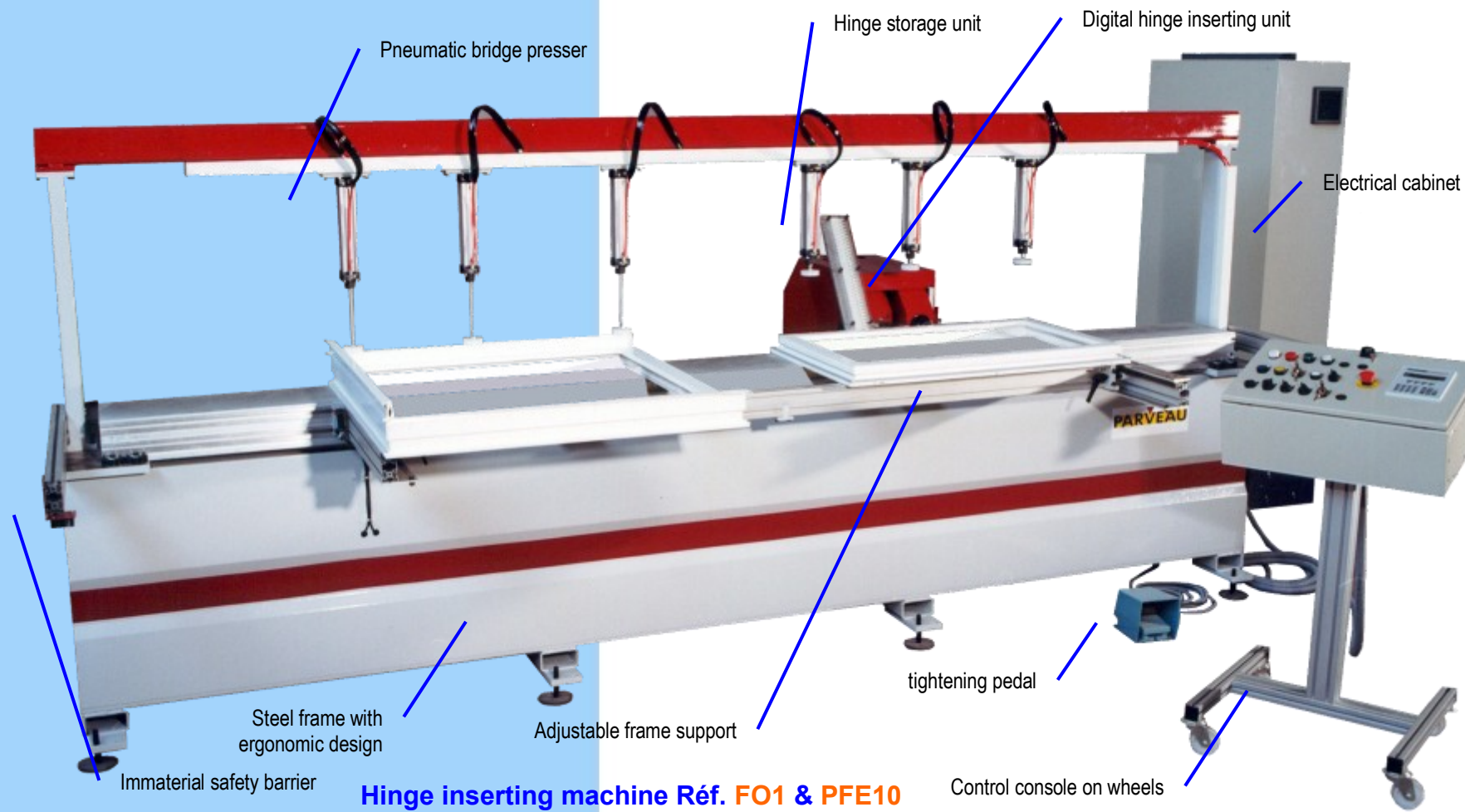
Réf. **AFO1** In line drilling and hinge inserting  
machine for sashes.



**PARVEAU**  
Profitable machining\*

**PARVEAU MAB**  
33, Avenue de la Gare  
19130 VIGNOLS  
**FRANCE**  
Tél. +33 (0)5 55 25 80 01  
Fax +33 (0)5 55 25 06 29  
Internet : <http://www.parveau.fr>  
E.Mail : [infos@parveau.fr](mailto:infos@parveau.fr)

# High points



View from the bottom vertical pneumatic drilling head destined to the plate drilling. This one is located under the hinge inserting spindle (on the right). No accessories nor tool is necessary according to the thickness of the fixed frames.



View from the reference thrust block with its part detecting cell.

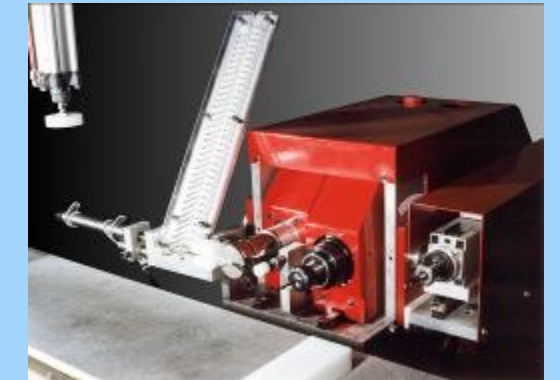
## HINGE INSERTING UNIT

This new hinge inserting unit benefits of the latest technological advancements. The hinge inserting spindle is controlled by a CNC motor. The machining becomes more precise as it is simple, so it's also more reliable.

The drilling unit is independent from the hinge inserting unit. The switching between the drilling/screwing unit is automatic.

The sash hinge storage unit is interchangeable. The hinge distribution towards the spindle is automatic.

The hinge inserting head unit is mounted on a prismatic rail guidance with recyclable roller casings. Its longitudinal drive (from 0 to 60 m/min.) is ensured by a rack and pinion system controlled by a CNC motor connected to the calculator.



View of the entire hinge inserting unit with an extra drilling unit on the right (option), destined to the drilling of the screw rams.

## SEMI-AUTOMATIC HINGE INSERTING MACHINES

Our **F01 & PFE10** hinge inserting machines drill and insert the Anuba hinges in the sashes and drill the plate hinges in the frames.

The insertion rate is of **8 seconds/hinge** only. The drilling of the plate hinges is made without **any adjustment**, nor tool replacement, nor tilting of the machining head. The programming is **very easy** (only the dimension of the sash is entered), the hinge repartition is automatic. It's possible to insert reinforced hinges and also to associate a **bar code** reader, which avoids any data entry by the operator.



View of the entire hinge inserting unit, with the Anuba hinge magazine, the drilling unit and the digital rotation hinge inserting unit.

## FUNCTIONNING PRINCIPLE

The sashes are placed on the top covering edge, the hinge inserting head unit's pitch is of 5°.

The frames (without mullion) are installed such as the drilling of the plate slots is made from below.

The frames are vertically locked by pneumatic rams, positioned above the table, on a bridge. The ram positioning is rapidly made by the operator.

The machine is equipped with right and left stops, on the table. Thanks to cell detection, the machine recognizes automatically if the frame is a right one or a left one. No error by the operator is possible.

This hinge inserting machine can work in double. In this case, the total length of the 2 frames must be under 2500 mm.



Anuba hinge

## THE CONTROL PANEL

The control panel is equipped with a numeric control calculator that manages the longitudinal axis and the machine sequential.

The conversational program allows several types of programming :

- By entering the hinge positioning values.
- By entering the length of the parts. In this case, the calculator classifies the hinges following a value table.

It allows also the double hinging.



View of the control panel

## AUTOMATIC HINGE INSERTING MACHINE

Our **AFO1** hinge inserting machine allows to automatically embed hinges in sashes. It's to be inserted behind a welding trimming line, **without requiring an operator**. An automatic frame transporting system also avoids any user handling. A bar code reader allows the machine to know the work to perform.



AFO1 automatic linear hinge inserting machine