

"Heavy-Builts"

Hasko

Flooring and Woodworking Machinery Since 1930

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DESCRIPTION

(Subject to Conditions of Sale)

Hasko FSM MatchMaster™ FLOORING SIDE MATCHER

FEATURES:

The New **Hasko** Model **FSM MatchMaster™** Hardwood Strip Flooring Side Matcher represents the first major improvement to flooring machinery in the past 40 years and utilizes revolutionary technology to achieve record production rates within weeks of installation. This is a 5-head, 6" x 3" true matcher (with directly opposed side heads) and a hydraulic feed system with choices of either 400 or 575 FPM (maximum) feed rates. The standard machine is equipped with a 12-knife (optional to 16 knives) high-speed steel bottom cylinder built into the machine and houses eleven-inch long knives to provide four cuts on 2-1/4" flooring before replacing. Close-coupled design, built-in jointing and the availability of up to 16-knife top and bottom cutterheads ensures high-grade finish and accuracy on random length strips at high feed rates.

The **Hasko** Model **FSM MatchMaster™** is heavily constructed and incorporates a steel fabricated stress relieved main frame, cast iron side head slide box with dovetail ways, and cast iron dovetail matcher main plates.

The **Quick-Clear™** system combined with the machine's ability to pass mis-manufactured low-grade lumber can potentially add a profit margin edge of 30, 45, 60 extra production minutes a shift. The **Quick-Clear™** incorporates pneumatic quick release of upper infeed and outfeed rolls, hydraulic quick release of left side head and pneumatic quick release of hollow back head. Precise repositioning of feed rolls and of top, bottom, left side head and hollow back cutterhead units when clearing is achieved by returning to positive stops. When combining the above features with variable frequency inverter driven cutterhead and spindle braking, this machine is cleared of the jam safely and quickly, precisely resetting and producing product in about a minute - despite the severity of a jam. The machine is equipped with a motor control center and features controls with inverter braking on all cutterheads and spindles. Standard voltage is 460/60/3.

The **MatchMaster™** has proven to be an easy machine to maintain. It offers easy accessibility to working parts without major disassembly. There are no gears, sprockets, or chains in the feed drive and many replacement parts are "off-the shelf" items. Service from the full staff at **Hasko** is legendary.

MACHINE SAFETY, GUARDING, OSHA - Subject to Conditions of Sale

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SPECIFICATIONS:

Capacity: Rough Boards In- 6.375" x 3.75" Max. Standard, (Optional to 7.375" x 3.75" max.)
Finished Max. *Face Width*- 6.00" x 3.00" Standard, (Optional to 7.00" x 3.00" max.)
Finished Min. *Face Width*- 2.25" Standard, (Optional to 1.50")
Thinnest- .500"
Shortest- 10"

Dimensions: Bed Height - 34.50"
Length - 127.50"
Overall Width - 79.00"

Weight: 22,500 pounds (estimated) excluding hydraulic unit.

Power: Top Head - 50 H.P. 3450 RPM Direct Coupled (standard)
Top Head - 75 H.P. 3450 RPM Direct Coupled (optional)
Top Head - 60 H.P. 3450 RPM Direct Coupled (optional)
Bottom Head - 30 H.P. 3450 RPM Direct Coupled (standard)
Bottom Head - 50 H.P. 3450 RPM Direct Coupled (optional)
Bottom Head - 40 H.P. 3450 RPM Direct Coupled (optional)
Left Sidehead - 30 H.P. 3450 RPM Direct Drive (standard)
Left Sidehead - 30 H.P. 4800 RPM High Speed Direct Drive (optional)
Right Sidehead - 25 H.P. 3450 RPM Direct Drive (standard)
Right Sidehead - 30 H.P. 3450 RPM Direct Drive (optional)
Right Sidehead - 30 H.P. 4800 RPM High Speed Direct Drive (optional)
Hollow Back - 20 H.P. 3450 Direct Coupled (standard)
Hollow Back - 25 H.P. 3450 Direct Coupled (optional)
Feed Works - 75 H.P. Direct Coupled Hydraulic Variable Vane Pump (standard)
Feed Works - 100 H.P. Direct Coupled Hydraulic Variable Vane Pump (optional)

Voltage: 460/60/3 Standard
230/575 VAC optional

Order of Cut: Top, bottom, opposed sides, hollow back

Amount of cut: Top head - 0 - .750"
Bottom head - 0 - .250"
Left Side Head - 0 - .500"
Right Side Head - 0 - .250"
Hollow Back - 0 - .320"

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Feed Works: Four top and four bottom, 10" O. D. hydraulically driven feed rolls. Top rolls have pneumatic tensioning

Feed Speeds: 250-400 feet per minute infinitely variable (Up to 575 FPM optional)

Cutting Circles: Top Head - 9.25" maximum cutting circle
Bottom Head - 9.25" maximum cutting circle
Left & Right Side Heads - 9.50" & 9.00" maximum cutting circle respectively
Hollow Back - 8.50" maximum cutting circle

Bottom Cylinder: 12 knife (up to 16 knife-optional) x 11" long integral bottom cylinder gives 4 cuts on 2-1/4" flooring

Top Spindle: Stub taper and keyed (standard) or optional smooth finish for Hydro-Lok

Sidehead Spindles: 1-13/16" diameter smooth finish - Fluted (Optional)

Hollow Back Spindle: 1-13/16" diameter smooth finish - Fluted (Optional)

<u>Jointers:</u>	Top Head-	Built-in
	Bottom Cylinder-	Built-in
	Sideheads-	Optional
	Hollow-Back Head-	Optional

Cutterhead Locks: All hydraulically clamped, hollow back pneumatically clamped

Quick-Clear™: Top Head - Hydraulic Cylinder
Left Sidehead - Hydraulic Actuator
Hollow Back - Pneumatic Cylinder
Center Match Hold Down - Pneumatic Cylinder
Top Infeed Rolls - Pneumatic Cylinder
Top Outfeed Rolls - Pneumatic Cylinder

All units return to positive stops for precise resetting

Spindle Brakes: All inverter drive controlled & programmed

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Guards:

Feed Rolls: Enclosed by fabricated steel and open steel mesh. Access doors are electrically interlocked to machine control logic to prevent operation of feed drive system and cutterheads when access doors are opened. Specific hazards indicated by warning signs and placards.

Cutterheads and cutter spindles: Enclosed by fabricated steel plate hoods and or dust chutes. Openings are limited to those needed to allow normal flow of material being machined. Specific hazards indicated by warning signs and placards.

Electrical,

Controls and Logic: NEMA 12 Enclosures, with built in interlocked disconnect. A PLC provides control logic. Touch screen operator console, magnetic relays, variable frequency inverter drives, and motor controls. Fused protection for all motor control relays and PLC.

Updated Guarding And Safety Circuitry

System:

The **Hasko FSM** and **FSP** now incorporate a "state of the art" Guarding and Safety Circuitry System designed to provide a very high level of safety for your operators without sacrificing production.

The **FSM** control package incorporates circuitry for the five cutterheads utilizing two safety rated relays per cutter head unit wired in compliance with ANSI B11.19 and OSHA 1910.147 regarding Risk Category 3 and "Alternative measures" where safe jam clearing is required. The use of dual channel safety relays and expansion modules coordinated with zero speed sensors for all cutter heads in conjunction with solenoid activated access door locking switches, prevent operator access to dangerous areas while the machine is running and during orderly shutdown.