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# INDUSTRIAL WOODWORKING

## & PANEL PROCESSING

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APRIL 2021

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## JOINING FORCES

IMA and Schelling have worked under a network umbrella for many years until some six years ago when Schelling Anlagenbau of Austria purchased IMA in Germany to form the IMA Schelling Group.

It is therefore exciting news that we are able to announce the merger of IMA Klessmann UK and Schelling UK Ltd into a single company with its new base being located in Wetherby in West Yorkshire. The new company name is to be known as IMA Schelling UK Ltd.

As well as the Schelling cut-to-size saws and

complimentary equipment available available from the head office in Wetherby, the company is pleased to be joined by the world renowned manufacturers of throughfeed single- and double-sided IMA Combima edge-banding machines with the world famous IMA BIMA range of CNC machining centres and the IMAGIC range of throughfeed point-to-point drilling and dowel insertion machines.

For the full story please turn to Pages 2 & 3 of this issue.



## CLIMATE CHANGE

OVER 100 entries were received from around the world for the Conversations About Climate Change design competition launched by The Timber Trade Federation (TTF) in conjunction with the Building Centre to showcase innovative, playful and thought-provoking designs using responsibly sourced tropical timber.

Six winners were eventually selected by a panel of expert judges.

'Responsibly forested timber is an essential part of the climate change solution. However, tropical forests have too often been undervalued and their forest land cleared for other uses,' says chief executive officer of the Timber Trade Federation, David Hopkins (pictured right).

For the full story, please turn to Pages 8 + 9 of this issue.



## LAMONT WORKING WELL FOR HIGHAM FURNITURE

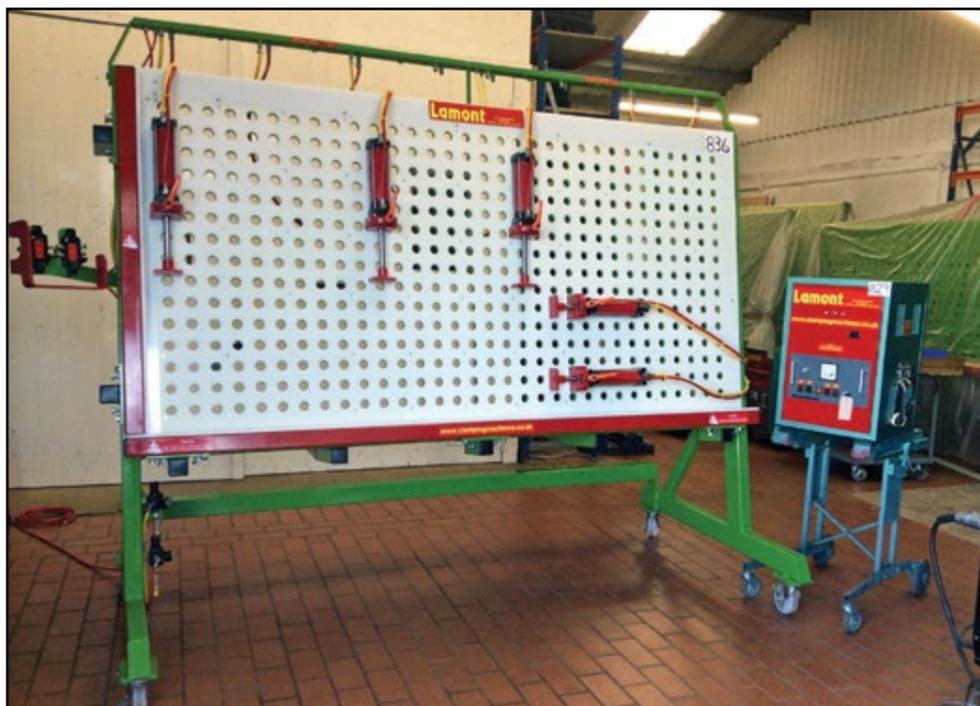
HIGHAM Furniture has grown organically since inception and has recently moved its workshop to larger premises in Denmead in Hampshire.

Recently, Tim Higham responded to the need to increase productivity whilst respecting the need for social distancing by those staff not on furlough by purchasing a refurbished matrix table and Woodwelder from Lamont. He is so pleased with it that he has already ordered a larger model.

'The table was so good and so effective at what it was doing that I have decided to replace it with a double-header, which is twice as big,' says Tim Higham.

Alan Lamont has offered to take the old one back, not because there is anything wrong with it, but because I don't need two: I just want a table that will have twice the area,' explains Tim Higham.

For the full story, please turn to Page 5.



Whatever your Wood Welder or clamping requirements, we can help!

# Lamont



Tel 01461 40017

Email alanlamont2@gmail.com

www.clampingmachines.co.uk

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# IMA KLESSMANN UK LTD AND



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Impressive 285mm max cutting depth + 2 x cutting speeds (380 & 820 rpm) + cast iron table & fly-wheels + blade tension check window + pro triple bearing top & bottom guides + 6-25mm blade widths.

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Delivery lead times can vary. Please check before ordering.

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HISTORICALLY IMA (Germany) and Schelling (Austria) have always been close players in the industry.

The two companies have worked under a network umbrella for many years until some six years ago when Schelling Anlagenbau of Austria purchased IMA in Germany to form the IMA Schelling Group.

Since that time, the IMA Schelling Group (or ISG, as it is commonly known) has been busy on a global basis to consolidate the separate IMA and Schelling companies into one company to show a united front to all customers and to present itself as a single group.

The company is therefore pleased to announce the merger of IMA Klessmann UK and Schelling UK Ltd into a single company with its new base being located in Wetherby in West Yorkshire. The new company name is IMA Schelling UK Ltd.

As well as the Schelling cut-to-size saws and complimentary equipment available available from the head office in Wetherby, the company is pleased to be joined by the world renowned manufacturers of throughfeed single- and double-sided IMA Combima edge-banding machines running at up to 120m/min feed speed, together with the world famous IMA BIMA range of CNC machining centres (both with and without edge-banding and finishing facilities). The company also designs and manufactures the IMAGIC range of throughfeed point-to-point drilling and dowel insertion machines.

IMA UK and Schelling UK service engineers are all factory trained, with experience in mechanical, electrical and electronic fault diagnostics.

All routine maintenance, machine repairs and servicing can be carried out without the expensive costs commonly associated with the employment of overseas engineers.

In the interim, both companies will be run side by side to ensure continuity of business for its customers and will immediately start trading as IMA Schelling UK Ltd.

Customers and suppliers are assured that it is "business as usual" and there will be no change to either the support received, or the customer service experience from both IMA Klessmann UK and Schelling UK.

All the contact numbers etc, will remain the same through this transition period and any changes will be announced in due course.

However, readers should note the new email address [info.uk@imaschelling.com](mailto:info.uk@imaschelling.com)

Managing director of IMA Schelling UK Ltd will be Markus Freuis, who has been part of the Schelling business in the UK since 1999.

Andy Howell and Ashley Cooper (formally of IMA UK Ltd) remain on hand with their experience and expertise to support the newly merged businesses

Here's to a very exciting and prosperous future.

For further information tel. IMA Schelling UK on 01937 586340.  
Visit [www.imaschelling.com](http://www.imaschelling.com)



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# WOODWORKING MACHINERY

## Introducing the NEW ATACAM CNC Routers

Prices from £38,000

This new range of affordable CNC Routers from ATA Engineering offers the same high quality build that you come to expect from a company that has been supplying CNC's for over 20 years, along with support and technical back up.

Standard sizes:  
8 x 4, 10 x 5, 3m x 2m  
(Special sizes available on request)

Standard Features:  
HSD HSK Spindles, Rotary ATC, Location Pins, Tool Digitizer.

3 and 4 Axis machines in stock.

Call us today to arrange a Demonstration!

## Castle Pocket Routers from ATA Engineering

### New Improved Model TSM22 Pocket Router

Model TSM22, the most popular Pocket Router in the Castle range has been re-designed with a new lift up table top to provide the following features:

- Easier and quicker access when replacing the router cutter, drill and other parts during routine servicing and repair.
- Additional safety feature which automatically disconnects the electrical supply to the Bosch motors.

This long established and widely used model continues to provide the quickest and strongest method for kitchen and bedroom carcass manufacture, retail display stands and other interior fitting applications.

Call us today to arrange a demonstration.

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# A SIMPLE PIECE OF KIT WORKS WELL FOR HIGHAM FURNITURE

FOUNDED IN 2004, Higham Furniture features a talented team of designers and furniture makers, specialising in kitchens.

The company has grown organically since inception and has recently moved its workshop to larger premises in Denmead in Hampshire.

As Higham Furniture carries out both the design and manufacturing element itself, it is able to offer a high degree of personalisation, quality and service to its customers in the South East of England.

During the first lockdown in April/May 2020 director, Tim Higham responded to the need to increase productivity whilst respecting the need for social distancing by those staff not on furlough by purchasing a refurbished matrix table and Woodwelder from Lamont. He is so pleased with it that he has already ordered a larger model, due to be delivered shortly.

'I have a tendency to be careful with how I invest in the business: I am after value for money. For the original table, I wanted a refurbished "cheap-as-I-could-dip-your-toe-in-the-market" table in order to give it a try: the table was so good and so effective at what it was doing that I have decided to replace it with a double-header, which is twice as big,' says Tim Higham.

Alan Lamont has offered to take the old one back, not because there is anything wrong with it, but because I don't need two: I just want a table that will have twice the area,' explains Tim Higham.

The first table and the Woodwelder were purchased, as Higham Furniture sought to increase productivity in unprecedented times.

'I just felt that it was a good time to experiment. We had heard good things about matrix tables and Woodwelders. There were not many on the market but, once I started talking to Alan, I found him to be helpful and felt that I was in a safe pair of hands. He is a good communicator and has a good level of knowledge,' continues Tim.

'We make kitchens and we primarily use the matrix table and Woodwelder for putting together the doors. We tend to make panelled painted Shaker kitchens: there are lots of different types and many different door styles, but we are known for our traditional styles.

'The table adapts well to the different sizes of the doors and the original table takes 90 per cent of the work: the bigger table will be able to take 99 per cent of the work. We will also be able to load on one end while zapping at the other,' explains Tim.

Tim was keen to stress that the smaller table, which has already paid for itself, was exactly what he had asked for from Alan Lamont at the time:

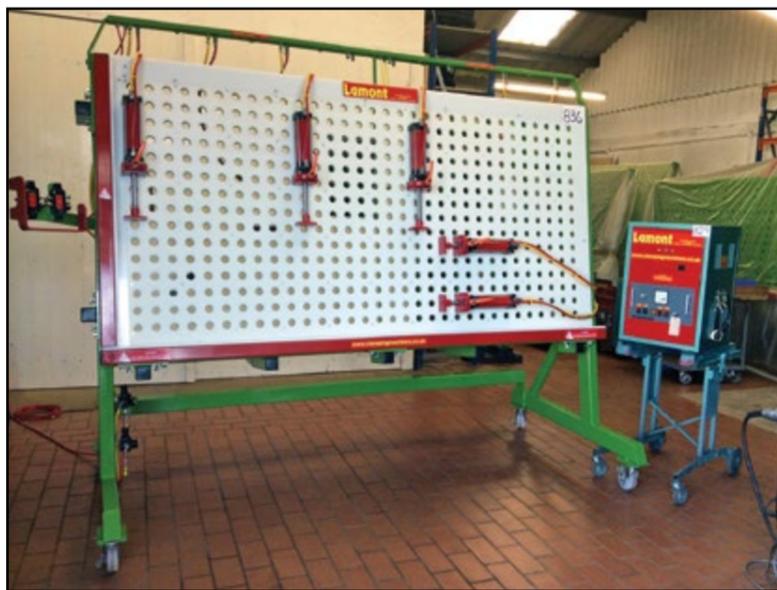
'It worked so well, we wanted the larger machine! It speeds up production. Previously, we would have glued up doors and put them in sash clamps and left them to dry for a day, or overnight: now in less than a day we can get a whole kitchen door made and through to the next stage,' says Tim.

'The process is less labour intensive and is also faster than it was before. It is a simple bit of kit that works well,' concludes Tim,

Asked if he would recommend Alan Lamont, Tim replied: "Yes, I would: I have already recommended him to my mate, Nick Anderson of Guild Anderson, who took

delivery of his machine last year. Alan is great and the machine is also great!' concludes Tim.

For further information tel Alan Lamont on 07785 268992. Visit [www.clampingmachines.co.uk](http://www.clampingmachines.co.uk)



## Cleverly combined.

With the T54 surface planer and the T45 thickness planer you have two specialists who complement each other perfectly. Each of the two machines is designed for uncompromising fulfilment of their roles and ensures optimum working results. Each of the required machines is available immediately and without time-consuming conversions, and thanks to the spacesaving installation both machines together hardly require any more space than a combi machine. Also in contrast to the combi machine both machines can be operated in parallel without any restrictions. Extraction can be optionally connected to all T45 machines, depending on production environment, right or left, without restricting material and work flow in your facility.

With the duo we open up unique possibilities to you, which go far beyond the previously known combinations. Extensive accessories and equipment are available for both machines. So it's really easy to perfectly adapt the machines to your respective requirements.

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# MARTIN

[www.martin.info](http://www.martin.info)

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Email us at: [bill.willowe@gmail.com](mailto:bill.willowe@gmail.com)

# DUST EXTRACTION & RECYCLING – HAND & GLOVE

OVER the past 30 years Hutchings Timber has established itself as one of the South East's premier timber merchants due, in part, to the expansive portfolio and also to continued investment in the company's production capabilities.

During its latest round of investment, rather than look at any one, singular, aspect of production, the company took a satellite view of its entire operation, to ensure that its clients were serviced with the broadest range of products, with the smallest possible production carbon foot-print.

With a brief to improve its dust extraction systems, bulk handling facilities and optimise the performance of its automated biomass heating system and use all production waste materials, Hutchings Timber engaged Fercell.

Following a series of site surveys and client consultations, Fercell presented its recommendations and design.

A solution was arrived at whereby Hutchings Timber's MDF production waste was kept separate from its timber waste and the wood waste generated in the summer months was converted to solid fuel was selected.

At the heart of the new system was the Fercell supplied MVD silo filter, with a buffer storage capacity of 12m<sup>3</sup>.

While the MVD would deal with the majority of the production waste, the Fercell supplied UF-Series filter would control the MDF dust, collecting filtered waste in multiple



The MVD9 silo filter supplied by Fercell offers a buffer storage capacity of 12m<sup>3</sup>.

and type of machine tools in operation at any one time - all of which optimised performance, reduced maintenance costs and minimised sound output and power usage.

Along with performance aids, the MVD has a package of safety features, including, certified ATEX explosion relief panels, a non-return explosion valve and H2O sprinkler system.

Although, the MVD can accommodate up to four discharge points, Hutchings Timber utilise three - one discharging to the biomass heating system fuel store, via a pneumatic transfer system.

Another, to plastic collection sack, as a contingency, if other elements of the system are ever inoperable and the third, to a Fercell supplied, Weima, briquette press, via a screw-conveyor.

Considering the material and volumes, the TH820 briquette press was the ideal solution. Designed for high-volume wood briquette production, this was the perfect addition.

It doesn't require additives, or thermal treatment, it simply uses the power of compression, to reduce dust and chipped material volume by up to 90 per cent.

In the summer months, material is delivered to the briquette press, with output stored, until the winter months.

During the winter months, the production waste is directed to the biomass system, when the stored briquettes are loaded into the shredding system and directed to the biomass heating system to supplement fuel.

Along with the intrinsic benefits of briquetting, producing a profitable secondary commodity, reduction in volume of wood waste, maximising valuable storage space and minimising fire/explosion risks, for Hutchings Timber the arrangement makes the absolute maximum of the company's production waste.

It also ensures that Hutchings Timber achieves the benefits for all of the colder months, without running out of fuel and rather than burning it in the warmer months, to simply dispose of the material and discharge the heat to atmosphere.

Fercell has been successfully delivering complete industrial recycling and size reduction systems and industrial ventilation equipment for over four decades.

Fercell can design a solution to meet customers' exacting requirements.

For further information tel Fercell on 01622 791414. Visit [www.fercell.com](http://www.fercell.com)



Fercell, exclusive UK distributor of Weima, installed a Weima WL13 single-shaft shredder to recycle wood waste on site.

poly bags. Along with the production dust, other production waste, in the form of offcuts, scrap and pallet materials were converted, by the Weima WL13 single-shaft shredder, supplied by Fercell, into uniform chip as biomass for the heating system.

The WL13 shredder is perfect for shredding all types of wood waste, including linear to lump wood waste, where high-throughput, efficiency and reliability are required.

Whether from the production mill, or the shredding plant, the material is captured at source and transported through the centralised ducting system to the externally sited MVD silo filter.

The MVD, configured as a negative-pressure, has the fan set located on the clean side of the filter, which kept it away from the waste materials, increasing service life, whilst reducing both energy-consumption and noise.

Coupled with this, the system performance is automated, with filter monitoring and cleaning and suction based upon demand.

Air-volume ramps up and down, according to the number

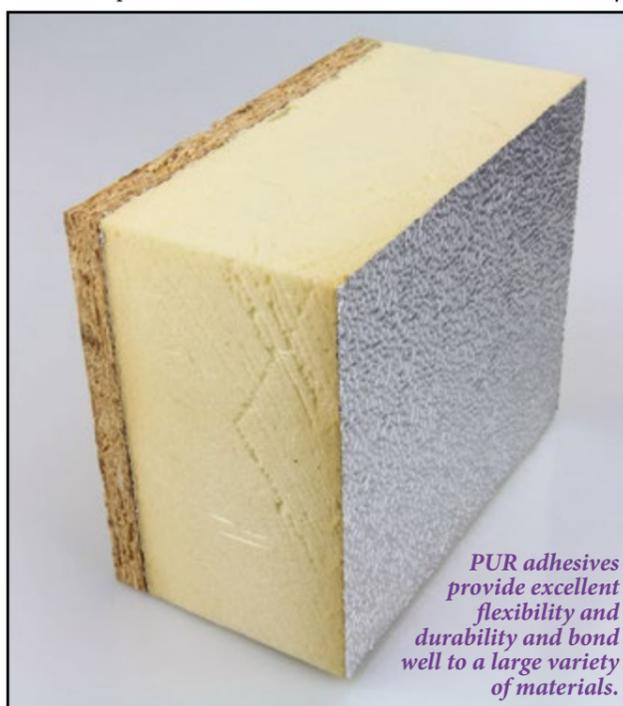
## NEW RANGE OF SINGLE AND TWO COMPONENT LIQUID POLYURETHANE ADHESIVES

THE Kenyon Group brings to the market a range of single- and two-component liquid polyurethane adhesives for bonding architectural panels, fire doors, aluminium and honeycomb panels, door panel fabrication, insulation and caravan panels under the trusted brand Henkel Loctite.

These adhesives compliment the range of Henkel technologies that the Kenyon Group offers, opening doors to many new markets and new applications.

Kenyon's technical team like to solve gluing problems and possesses the know-how and support to deliver the right product for your application.

One-component PUR adhesives are used in areas where easy



PUR adhesives provide excellent flexibility and durability and bond well to a large variety of materials.

application, reliability and durability are required. The concept of one-component PUR adhesives is based on the water reaction of the individual polyurethane compositions. They react with substrate moisture, or ambient humidity.

PUR adhesives provide excellent flexibility and durability and bond well to a large variety of materials

One-component Henkel Loctite UR adhesives, such as Loctite UR 7225, are mainly used for panel production and can be applied on larger surfaces with medium strength requirements.

The products provide a foamed adhesive layer and, therefore, have gap filling properties, giving room for manufacturing tolerances.

Henkel Loctite UR products are free of VOC and they are therefore applicable in normal - but well-ventilated industrial environments.

Two-component PUR adhesives consist of a resin (component A) and a hardener (component B), which are mixed in a defined ratio.

Most of the two-component polyurethane adhesives are used

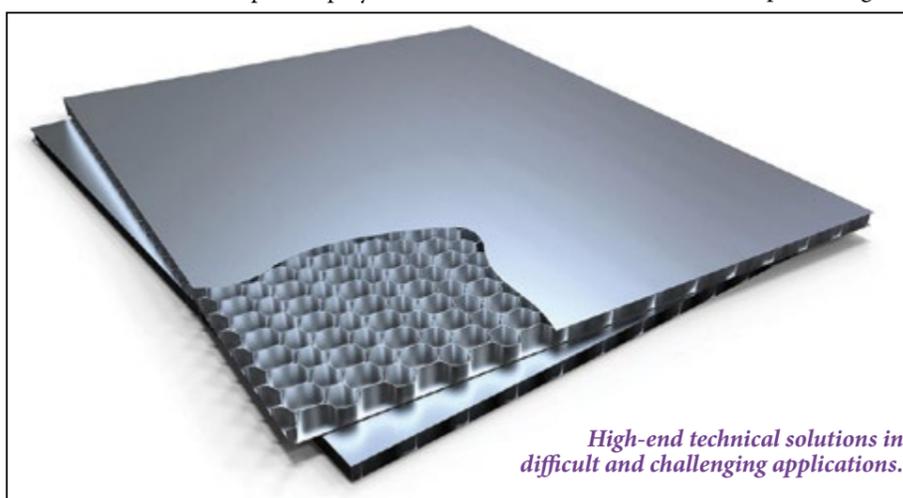
with Henkel Loctite UK 5400, or 5401 hardeners.

The customers' needs and the resin component used determine which hardener should be chosen.

Two-component systems are characterised by high tensile and shear strength, as well as elasticity. They are perfectly suited for joints that are exposed to dynamic loads, such as vibrations, or heavy impacts. Low-temperature durability and corrosion resistance are additional advantages.

The benefits of the single- and two-component liquid polyurethane adhesives include:

- Solvent-free.
- Good aging properties.
- Low calorific value for use in fire-retardant panels.
- Wide variety of physical properties.
- High process reliability.
- Designed for use at elevated and very low temperatures.
- Fast processing for high productivity.



High-end technical solutions in difficult and challenging applications.

The Kenyon Group has been supplying adhesives since 1979, covering all aspects of manufacturing and assembly predominantly in the furniture manufacturing and related markets.

The company's expertise and knowledge has been gained over the years by offering a comprehensive range of market-leading adhesives technologies, UK stock-holding across three warehouses and delivery when the customer needs it.

For further information tel Kenyon on 0161 627 1001. Visit [www.kenyon-group.co.uk](http://www.kenyon-group.co.uk)

# MINIPRESS TOP FROM BLUM IS WELL-EQUIPPED FOR THE FUTURE

MINIPRESS top is the new enhanced version of Minipress P – with even more features to aid all vertical and horizontal drilling operations within a single machine.

## Horizontal drilling unit

Minipress top means only one machine for all vertical and horizontal drilling operations. The horizontal drilling unit of Minipress top allows precision drilling operations, making it useful for dowels and connectors.

Speed and depth have been enhanced, with a new feature whereby, after breaking the drilling surface, the drill will slow down, giving a much more precise and cleaner hole.

New features enable fast and accurate handling, helping you optimise your work processes, for greater precision, efficiency and quality.

Combined with Easystick for dynamic handling of the X & Y axis, Minipress top is a perfect package for all drilling operations on cabinets, doors and fronts.

## Digitalised work processes

Minipress top combines with Easystick to digitalise planning and manufacturing. You can either plan directly on to the machine, or use a USB memory stick to transfer your data from Cabinet Configurator – quickly and simply. Imported manufacturing data can be easily retrieved and edited.

The Easystick computer also allows you to enter settings

directly on to Minipress top. Enter the cabinet data, front dimensions, select your fittings and Easystick will calculate the drilling positions for you.

## Vertical drilling unit moves automatically to the right position

Minipress top combined with Easystick automatically gives you the right stop positions.

The vertical drilling unit moves along the Y axis automatically while the work-table and ruler stay in the same position –

simple set-up for precise results. Minipress top allows you to carry out centre line drilling for deep cabinets made possible by the large depth adjustment of the vertical drilling unit (up to 350mm).

The Minipress top also has an optional full suite of swappable heads that allow for different drilling patterns.

For further information tel Blum on 01908 285700. Visit [www.blum.com](http://www.blum.com)



# FREUD EXTENDS ITS TOOLING RANGE

FREUD, one of the worldwide leaders in premium cutting tool manufacturing, celebrates the start of 2021 with the extension of its LSB X range, the outstanding quality circular saw blade for panel sizing applications.

This next generation portfolio – prestigious icon of Freud's superior manufacturing know-how and industrial engineering – replaces the former LSB range and offers a wider diameter choice, with over 150 blades, compatible with more than 130 panel sizing machines.

As a result of Freud's 60-year expertise and mastery in producing the finest and most performing cutting tools, the LSB X range is crafted and continuously improved to overcome the toughest challenges posed by the sector.

The introduction of new generation cutting materials; the transition from stand-alone machines to fully integrated production lines; the growing number of machine manufacturers with their demanding application needs; the fierce competition from cutting tool manufacturers developing

new solutions, as well as the extreme specialisation experienced by the market, demanded the creation of a super-hero blade.

The LSB X range answers to these growing needs, featuring ultimate technologies and the finest raw materials.

Its teeth – made of top quality Carbide, 100 per cent in-house manufactured by Freud – are crafted in a dedicated recipe, formulated and engineered to deliver exceptional performance and extreme cut precision in panel sizing applications.

In addition, the square tooth design delivers up to 25 sharpenings, providing a prolonged life-time, almost unmatched in the market.

On the top, Freud's anti-corrosive Silver ICE Coating technology protects from rust and provides an anti-friction shield. In addition, Freud's distinctive and exclusive anti-vibration slots reduce vibrations and minimise noise.

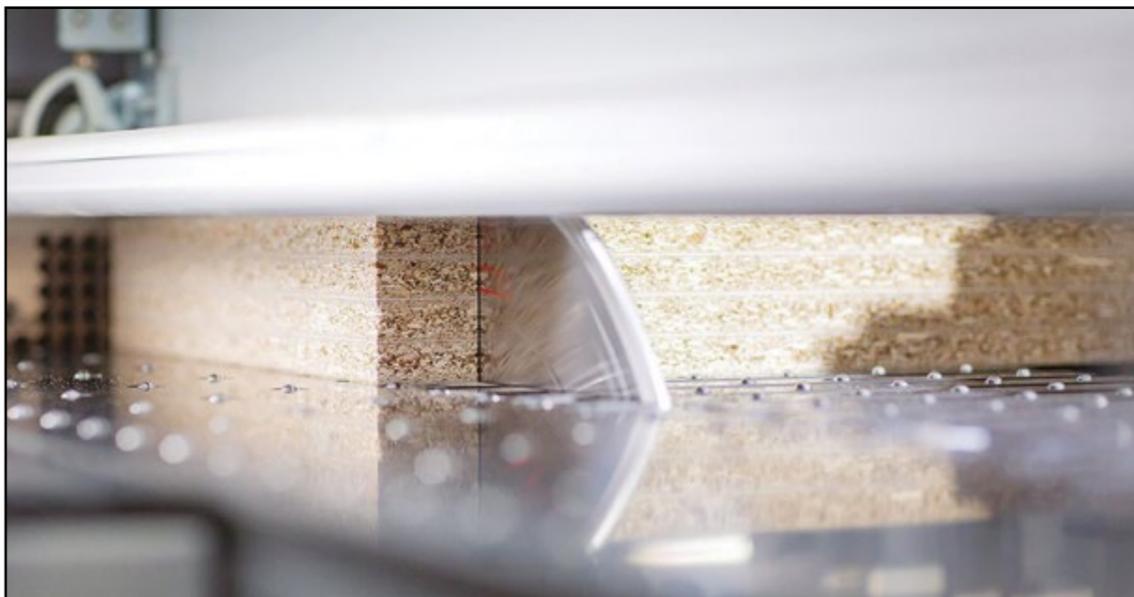
Flawless cut precision, prolonged life-time and a silent work-environment are, therefore, the most significant advantages

provided by this superior quality blade, thanks to exclusive features, mastered throughout an ongoing collaboration with the leading machine manufacturers and Freud's ownership and control of the full manufacturing process.

Moreover, preliminary performance tests and strict controls are the additional ingredients to secure the most stringent compatibility between blade and panel sizing machines.

When choosing a LSB X blade, all users – ranging from furniture and kitchen manufacturers to panel sizers and leading machine manufacturers, eager to equipping their machines with reliable and top performing cutting tools – will have the peace of mind to have invested in a highly performing and long-lasting solution, produced with the finest material and delivering impeccable results.

For further information tel Freud Tooling (UK) Ltd on 0870 770 4275. Visit [www.freudtools.co.uk](http://www.freudtools.co.uk)



Freud LSB X while cutting on a sizing machine.



Freud LSB X offers a wide range of panel sizing saw blades.

To find all the latest news online go to [www.industrialwoodworking.co.uk](http://www.industrialwoodworking.co.uk)

Email us at: [bill.willowe@gmail.com](mailto:bill.willowe@gmail.com)

# NEW CONVERSATIONS ABOUT HAS BEEN LAUNCHED BY THE

CONVERSATIONS About Climate Change is a virtual exhibition and event series presenting six installations, all made from tropical hardwoods from countries embarking upon FLEGT-licensing.

All the exhibits all are “conversation pieces”, which reflect on our relationship to our natural world.

The Conversations About Climate Change design competition and exhibition from the Timber Trade Federation (TTF) has launched online with the Building Centre to showcase innovative, playful and thought-provoking designs using responsibly sourced tropical timber.

Over 100 entries were received from around the world. The entries were anonymised and chosen based on their response to the climate change conversation brief, the celebration of the properties of tropical wood, the quality of their design and their collective impact as an exhibition.

Six winners were eventually selected by a panel of expert judges, including architects and designers, Adam Brinkworth, Julia Barfield and Andrew Waugh, London-based artist, Yinka Ilori and the British Retail Consortium’s sustainability policy advisor, Leah Riley Brown.

‘Responsibly forested timber is an essential part of the climate change solution. However, tropical forests have too often been undervalued and their forest land cleared for other uses,’ says chief executive officer of the Timber Trade Federation, David Hopkins.

The EU/UK FLEGT initiative helps combat illegal logging, subsequent illegal

timber trade and deforestation.

In return for aid and technical support, tropical forest countries can progress through the vital stage of VPA (Voluntary Partnership Agreement), which supports the overhaul of their legal and regulatory governance frameworks.

‘This landmark shift in governance and procurement means that FLEGT-licensed timber is safe, responsible and legal.

‘Our competition asked designers to respond to tropical timber, think about the materials they usually work with and consider how the role of materials specifier is vital for implementing change. We hope you come away inspired!’ Exclaims David Hopkins.

The winning entries are on display at the Building Centre in London. The exhibition is online with a 360 deg tour, complete with commentary about FLEGT and interviews with the winning designers.

The TTF helps designers and manufacturers learn more about responsible timber sourcing and FLEGT and how the materials you choose today can have a positive impact on the world’s forests

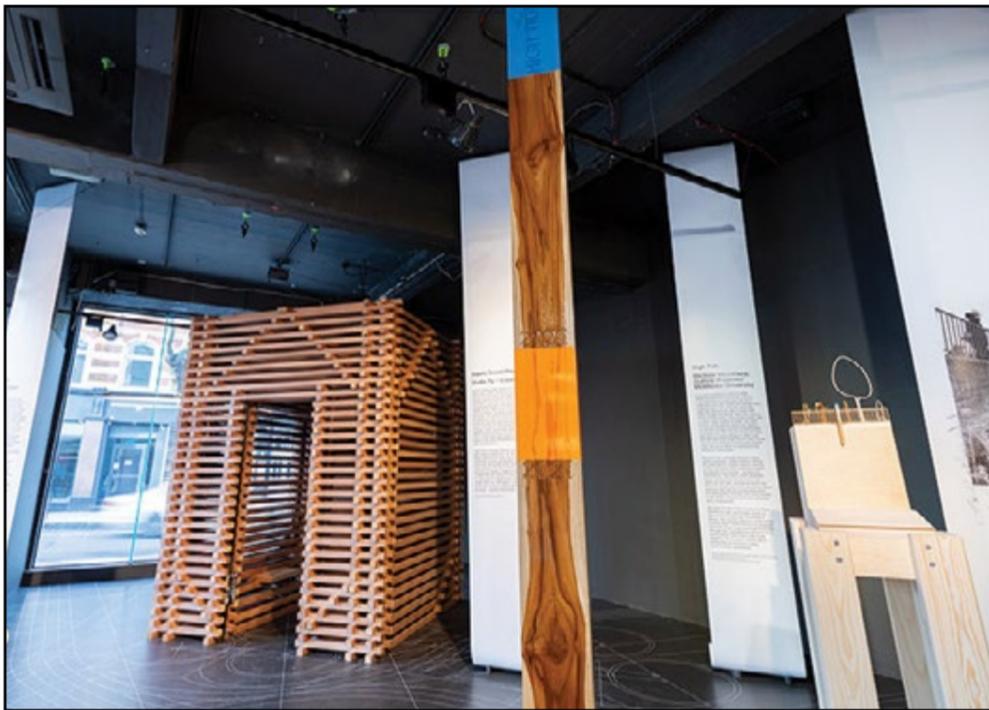
## What is FLEGT?

Initiatives such as the FLEGT Action Plan (Forest Law Enforcement, Governance and Trade) are legal frameworks for sustainable timber production.

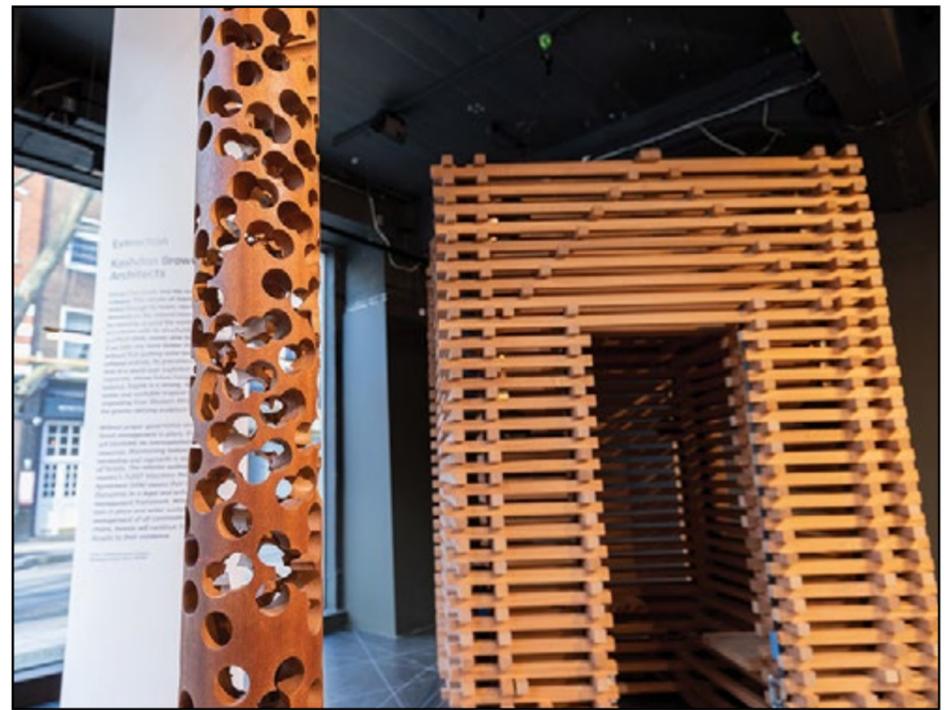
The aim is to reduce illegal logging and keep forests standing by creating sustainable incomes and livelihoods for local communities, thus reducing



Chief Executive officer of the Timber Trade Federation, David Hopkins.



Sapele Sound Pavilion, by Jeremy Yu and Tomos Owen, uses sapele - traditionally used for musical instruments - to create a pavilion “soundbox” playing a “soundscape based on the lifecycle of the tree”.



Extraction, by Julia and Julian Kashdan-Brown features a sapele column with horizontal holes drilled through its heart, representing the environmental instability that results from uncontrolled, unmanaged timber extraction.



Tom Wilson created miniature Forest Dwellers in multiple wood species. Having previously avoided tropical timber, he was impressed with what he’d learned about FLEGT through the competition, notably its “governmental level and holistic approach to sustainability, both environmental and economic”.

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# CLIMATE CHANGE EXHIBITION TIMBER TRADE FEDERATION

emissions and protecting bio-diverse habitats.

Indonesia is the first country to issue FLEGT licensed timber to the UK and EU and others, including Ghana are working to follow.

So far, 15 countries have entered the formal Voluntary Partnership Agreement (VPA) process of overhauling the legal, social, business and environmental infrastructure of their nations.

In order to help ensure lasting success, this process engages with communities and civil society on an unprecedented scale.

Combined, VPA forests cover an area the size of the EU and account for around 80 per cent of UK and EU tropical timber imports.

Conversations about Climate Change is a partnership between the Timber Trade Federation and the Building Centre, supported by the Foreign, Commonwealth & Development Office and the Built Environment Trust. All the timber for the winning designs was sourced through TTF members.

\*All images © Chris Jackson, Building Centre

For further information

visit [www.buildingcentred.co.uk/whats\\_on/conversations-about-climate-change-the-virtual-exhibition](http://www.buildingcentred.co.uk/whats_on/conversations-about-climate-change-the-virtual-exhibition)



Michael Westthorp's *High Tide* makes its impact through its starkness. It is a simple teak column marked with the sea level today and that projected for 2120 if man-made climate change continues at its present pace.



*Carbon Print*, by Joseph Pipal underlines the role of the forests and wood in sequestering and storing CO2 from the atmosphere. It comprises print blocks in meranti, sapele and iroko, made more durable by using the Japanese preservation technique of charring.



Architect, Tom Wilson who created miniature *Forest Dwellers* in multiple wood species, such as this little elephant had previously avoided the use of tropical timber, but was impressed with what he'd learned about FLEGT through the competition.



*Tree Whisperer*, by Sheryl Ang, comprises a range of tactile tree sculptures, which emit pulsing beats, reflecting how different species respond to climate change.

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# PALAMATIC PROVIDES GANTRY CHOICES FOR ALL

**MANUAL handling injuries in the workplace within the woodworking industry are often due to the repetitive lifting and moving of timber and boards.**

Palamatic has been supplying vacuum lifter systems to the woodworking industry for over 35 years.

Vacuum-lifting technology is a widely recognised solution for lifting and rotating wood product, with thousands of systems in daily use.

Common panel handling problems relate to the awkward nature of the payload – particularly so for CNC, router, edge-bander and beam saw loading operations.

Palamatic's board, panel, door and furniture lifting systems take the strain away from the operator, replace it with a user-friendly vacuum-powered lift assister and protect product from accidental damage.

'The operator lowers the vacuum lifter on to the product and controls the vacuum flow using a simple, finger-touch operating valve, making the work physically easier and safer,' explains regional sales manager for Palamatic, Stuart Ingledew.

'Increasing the vacuum draws air out of the tube and the load is lifted.

'Reducing the vacuum allows air to enter the tube and the load is lowered.

'It really is that simple!' adds Mr Ingledew.

Palamatic offers an optional LOMO lift-off, bike brake-style lever, that can be added to the control handlebar.

This is simply squeezed in to allow for an easier release.

The lift-off bike brake cannot be pressed in normal operation to release the board and will only work when the board is on a hard surface – the machine bed, or floor.

A common safety concern of customers is whether a board can be dropped.

'The main safety feature which prevents a product from being dropped is the power safety valve,' says Stuart, explaining the safety features which eliminate this risk.

'This allows a steel plate to fall into place over the main

hole very simply with gravity if the power shuts down which, in turn, allows the vacuum to be maintained inside the tube and pads – with the result that the board won't drop off,' adds Stuart.

Asked what would happen if an operator tried to lift product above the weight capacity of the lifting system, Stuart adds:

'In summary, it won't lift. We include a vacuum relief valve that limits how hard the pump can work meaning that the lifter would be set to your individual parameters and specified to lift the weight it has been designed for.'

If the application is just a straightforward lift from A to B, Palamatic would recommend a 4m or 5m swing jib.

Invariably, the support post would be positioned to the left, or right of the machine bed, but can be placed centrally if there is no risk of a fork-lift truck colliding with the post.

In general, the support posts for the gantry are 3600mm tall and 150-250mm square for a standard woodworking application, on a base plate, which would be 450-600mm square and require 6-8in of concrete to bolt into.

If moving ducting/pipework is a concern, the operator



All vacuum lifters require a gantry crane system to be suspended from, and choosing the correct type is critical.

The lifting system runs up and down the swing arm, which moves side to side, giving 270 deg coverage and up to 350kg working load and can be offered in lengths of up to 5m.

The swing jib is most commonly supported from a centre-post support pillar, but can also be hung from existing steelwork, wall mounted, ceiling mounted, or as a mobile base option. Where headroom is an issue, an inverted, or articulated jib can be offered.

would swing the jib away from the machine bed after loading the board, which would move the jib out the way of the moving parts.

The operator would normally attach the lifter to the next board to be lifted on the stack while the machine is cutting – with some companies also building their own stand in which to put the lifters between uses.

For applications where four stacks need to be loaded on to a double machine bed, a swing jib may not be the best option.



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# VACUUM LIFTER AND WOOD HANDLING PROCESSES

'It's best to consider an H-style gantry for jobs with more than an A-to-B or A-to-C lift,' explains Stuart.

Supported from either floor-mounted support pillars, or existing structural steelwork, the S-LINE H Crane gantry system is suitable for when a large working area needs to be covered and can be specified with one, or two vacuum-lifting systems. The lightweight aluminium overhead rail gantry offers easy movement of the lifting system around the area.

'There's nearly always a way to fit a gantry in somewhere, so we always recommend arranging for Palamatic to carry out a site survey of the area,' says Stuart.

'Where a visit is not possible due to Covid, we can arrange a video call to discuss the application,' concludes Stuart.

Aftersales support, service and spares parts are vital, due to the high level of use a vacuum lifter will have in a busy woodworking factory throughout its life-time.

Annual, or bi-annual services are recommended, as well as regular cleaning of the filtration system. This protects the electric pump from dust within the production area.

Centrally based in the UK in Chesterfield, with a dedicated sales and service team, Palamatic is well placed to guide customers through the decision-making process and to provide support once their system is installed.



For further information tel Palamatic on 01246 452054. Visit [www.palamatic.com](http://www.palamatic.com)

## EXTRACTLY'S GOT ALL ITS DUCT ONLINE

WHEN a leading timber staircase manufacturer recently added a Weinig Powermat 700 moulder to its already impressive line-up of equipment, re-jigging the dust extraction ductwork to accommodate the new high-speed machine was all in a day's work for Extractly Ltd's COVID-secure installation team.

Extractly is a leading UK distributor of Nordfab clipped ductwork and is South Yorkshire-based GD Woodworking's preferred contractor for dust extraction.

Although, on this occasion, the job required little more than a new header and flexible ducting, employing Nordfab's Quick-Fit clip-together ducting components still helped to make this a straightforward and speedy task to complete, creating a win-win situation for GD Woodworking, as the new machine could be commissioned without delay and production continued with minimal interruption.

A complete extraction system had been installed at the premises when Glyn Ducker moved the business there a few years ago.

'Back in 2016, Glyn had the foresight to invest in clipped ducting throughout the factory and his investment has paid dividends when production demands have necessitated the relocation or replacement of existing machines,' explains Extractly's Jake Oldfield.

'As Nordfab's Quick-Fit ducting system simply clips together, without the need for any special tools, installation and down-times are massively reduced in comparison with other types of ducting,' says Jake.

'The rolled edges on the ductwork ends make for a clean connection to other components and the integral gasket on the barrel-type clamp guarantees a leak-tight seal,' adds Jake

When it comes to installing a dust extraction system, Nordfab claims that Quick-Fit ducting is "the world's fastest ducting" but, as GD

Woodworking has found out, it's just as easy to dismantle and relocate when you move machinery, or make other changes to the work area.

'We also have an Ecogate energy-saving system installed so, since Extractly is an approved installer for both Ecogate and Nordfab equipment, we can be certain that any changes made to our extraction ductwork system are completed in the correct manner, without compromising efficiency or safety and that any LEV testing is completed to HSE guidelines,' says Mr Ducker speaking on behalf of GD Woodworking.

As well as providing a full design and installation service, Extractly is also an authorised Nordfab dealer. The full range of QF ducting components can be purchased directly from its online shop.

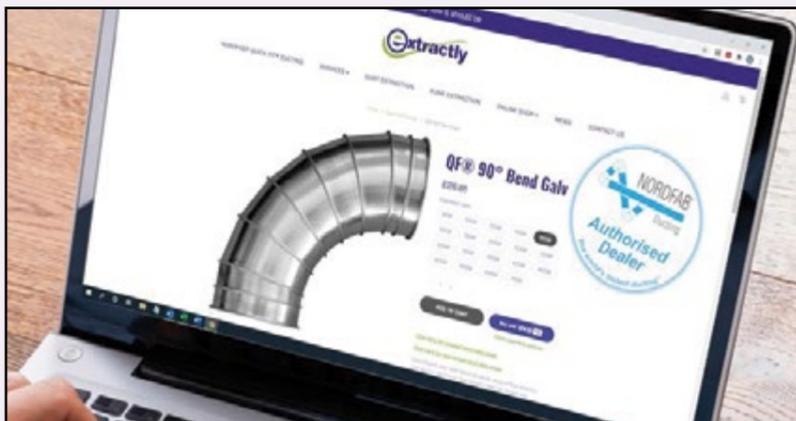
So, whether a customer needs supply only for a self-install project, or purchasing components, for a third party to install, most standard components can be ordered for next day delivery.

'Extractly was established to satisfy demand from both

professional extraction engineers and the self-installer,' says Jake Oldfield.

'Through the online shop, Extractly has the capacity to provide just about any item you could possibly need... whether that's Quick-Fit ducting, replacement filter media, or even a complete new filter unit,' he concludes.

For further information tel Extractly on 01924 520462. Visit [www.extractly.co.uk](http://www.extractly.co.uk)



The full range of QF ducting components can be purchased directly from Extractly's online shop.



Extractly supplied and installed Nordfab QF ducting components for a new Weinig moulder at GD Woodworking.

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# MAKITA IS LAUNCHING BRAND NEW SELF RIGHTING SITE LIGHT

MAKITA has launched a new self-balancing area site light - the latest addition to its range of LED site lighting solutions.

The DML810 18V self righting site light LXT delivers up to 5,500 lumens (lm) and 360 degree illumination with the option for corded or cordless operation.

The self-balancing design means that it remains upright even when knocked, or bumped, making it ideal for busy sites.

The 202 super luminous daylight white LEDs provide high quality illumination without the heat of halogens, or incandescent lights.

It features three operation modes, "High" (5,500 lm), "Medium" (3,000 lm), or "Low" (1,500 lm) and three illumination direction modes - full 360 degrees, or 180 degrees to the left or right.

For versatility, the DML810 offers corded, or cordless

operation. It is both dust and water resistant, with an IP54 rating when using battery power. It is also possible to connect up to eight units together using the AC inlets and outlets to deliver

light across the whole job site area.

Convenient carrying handles and a balanced side position allow for easy movement, transportation and storage.

With over 270 products compatible with Makita's Lithium-ion LXT battery technology, it is one of the largest battery/cordless platforms in the world. This allows users to use just one battery type and seamlessly swap between different pieces of equipment as required.

'The DML810 18V self righting site light has been engineered to provide a robust, durable and versatile lighting solution that is suitable for the toughest site conditions,' enthuses the assistant product manager at Makita UK, Lyndsey Bailey.

The high quality illumination makes work easier and safer, especially as the LEDs eliminate the hazards associated with the heat of halogen and incandescent lights,' she adds.

For further information tel Makita UK on 01908 211678. Visit [www.makitauk.com](http://www.makitauk.com).



operation. It utilises two Makita 18V LXT Lithium-Ion batteries, using one battery at a time.

This means the light delivers up to 15 hours of continuous illumination on "Low" with two 5.0Ah 18V batteries and over 3 hours on "High". When using AC power, the batteries function as a power back-up to keep the area lit, if the power fails.

This durable light unit measures 787mm high and 420mm

## KEEPING COOLER THAN THE REST WITH A LITTLE HELP FROM MAKITA

AS PART of its extensive LXT cordless range, leading power tool manufacturer, Makita has announced the release of its DCW180Z 18V cordless cooler and warmer box. The new release is ideal for workmen on-site who need to keep food and drinks cool, or warm in any season.

Powered by an 18v LXT battery, this handy product has two 18V LXT battery ports, so you can attach two batteries in series for extended operating times. When the first battery is depleted, the unit automatically switches to the second battery.

This model can also be powered via 240v mains, or with an in-vehicle 12v / 24v AC socket. When set at 5 deg C (normal fridge temperature) the cooler will run for up to 17 hours with 2x 6.0Ah batteries.

The 18V cooler and warmer box is a versatile unit with a large 20-litre capacity of storage space and as an example, it can hold approximately 30 cans, or 15 x 600ml water bottles.

The solution can operate at two warming settings of 55 deg and 60 deg, with five cooling settings of -18 deg, -10 deg, 0 deg, 5 deg and 10 deg.

The unit can run at its coldest setting of -18 deg for five

hours and its warmest setting of 60 deg for around four hours.

The box features large 100mm wheels and a pull handle for convenient transport and side grips for easy lifting, as well as a comfortable shoulder strap. It is highly durable for outdoor use with an IPX4 rating.

The solution is fitted with a convenient LED display, to provide users with temperature and battery levels and easily change settings at the touch of a button.

'We're excited to bring the new DCW180Z cordless cooler and warmer box to market as a useful addition to use at home, at work, or for leisure purposes,' says marketing manager at Makita UK, Kevin Brannigan.

'The powerful, cordless solution is as durable as it is

functional and can run for up to 17 hours on a single charge.

'The DCW180 is a must have if you're looking to keep drinks cold, or to ensure that hot lunches stay warm, regardless of the season. What's more, the product even features a bottle opener and a useful USB output to charge a mobile device if needed,' adds Mr Brannigan.

The new release forms part of a wider collection of new cordless solutions from Makita in 2021.

The company has recently announced a range of new products, including the TW004GZ XGT 40VMax impact wrench, the DUR368LZ Twin 18V (36V) LXT line trimmer and the PDC01 portable LXT power supply back-pack.

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# MARTIN T12 - THE PERFECT SPINDLE CUTTER

BEAUTIFUL interiors always start with excellent design. At Langstaff-Ellis Ltd of Chinnor in Oxfordshire, the company's designers work with its customers to create stunning spaces which really work in everyday life.

Clients are offered photo-quality, 3D renders, so that they are able to see the finished design before anything is cut in the workshop.

The large offices and workshops operated by Langstaff-Ellis are packed full of the latest technology, which is used right from the design stage to the final production.

The company's designers use the very latest software, which programs the CNC machinery - at the same time as providing clients with detailed drawings for their approval.

Once a project is in production, CNC machinery and highly skilled craftsmen and women combine to create work to the highest of standards.

With the company's ongoing investment in its production facilities, Langstaff-Ellis is able to offer work of the highest possible specification.

Customer service is at the heart of the business. At Langstaff-Ellis it is understood that the key to a successful project is a positive and enjoyable relationship with clients, which is why a dedicated, creative and positive team has been created - all of whom work with clients to create their ideal kitchen space.

Langstaff Ellis does not have restricted ranges, colours or ironmongery. Instead, clients are free to choose absolutely anything they desire. The company's design creativity works well with all manner of kitchen styles ranging from traditional Shaker to Modern, or contemporary furniture.

The workshop team is formed by a group of highly skilled and knowledgeable cabinet-makers - all of whom can boast many years of experience in the use of modern CNC automated woodworking machinery and equipment.

The workshop features the very best in terms of modern woodworking machinery all of which is sourced from industry

giants, such as the renowned German manufacturer, Martin.

One recent addition to the Langstaff-Ellis workshop has been a Martin T12 spindle moulder, which has now been in operation at the company's Oxfordshire premises for just over a year.

Although compact in terms of design, the T12 offers a number of premium features as standard. These include a heavy composite frame to ensure maximum stability, along with a 5.7in TFT colour touchscreen control unit. This is positioned economically at eye level and helps reduce set-up times markedly.

From this unit the operator can easily set the required height of the spindle and when additional optional accessories are included, the cutting depth and the cut (infeed jaw) can also be set and controlled.

In addition, the tool data memory provides the facility to store up to 500 different tools, automatically recalling the spindle height position, speed and other program data for the particular tool selected.

A consistent moulded surface cannot simply be ordained. However, it is so simple with the Martin T12, which features a highly functional, but easy-to-use control system and offers excellent value-for-money.



*The Martin T12 spindle moulder is the perfect spindle cutter for a wide variety of applications.*

spindle speeds and sliding tables.

Motorised positioning of the fence enables all the settings to be made comfortably and accurately via the control unit. The fence settings can be approached with pinpoint accuracy owing to reproducibility of +/- 0.025mm, which is extremely high for a compact-class machine. Even critical settings, for example, for counter profiles, can be precisely positioned.

The positioning of the right-hand fence jaw via hand-wheel is displayed on the control unit with a high degree of accuracy.

The electronically recorded position of the fence jaw can also be saved in the controller and quickly accessed when needed. The incremental movement is also easily possible owing to the integration in the controller.

The table extensions are executed in cast iron on both sides and connected to the machine table completely without a transition. The stable, extendable support provides support at the front, thus facilitating the processing of larger components.

The fence opening should be closed as much as possible, so that the work piece can be safely guided and slide along the fence. Both are provided by the tried and tested integral fence.

The bars of the jaws consist of hard-coated aluminium and can be easily folded in position, released and also varied in height. The bar cassettes can also be removed effortlessly, allowing the operator to work with a wooden insert.

In short, the T12 is an ideal spindle moulder for any joinery workshop. With its individual customisation options, it represents the perfect spindle cutter for a wide variety of applications.

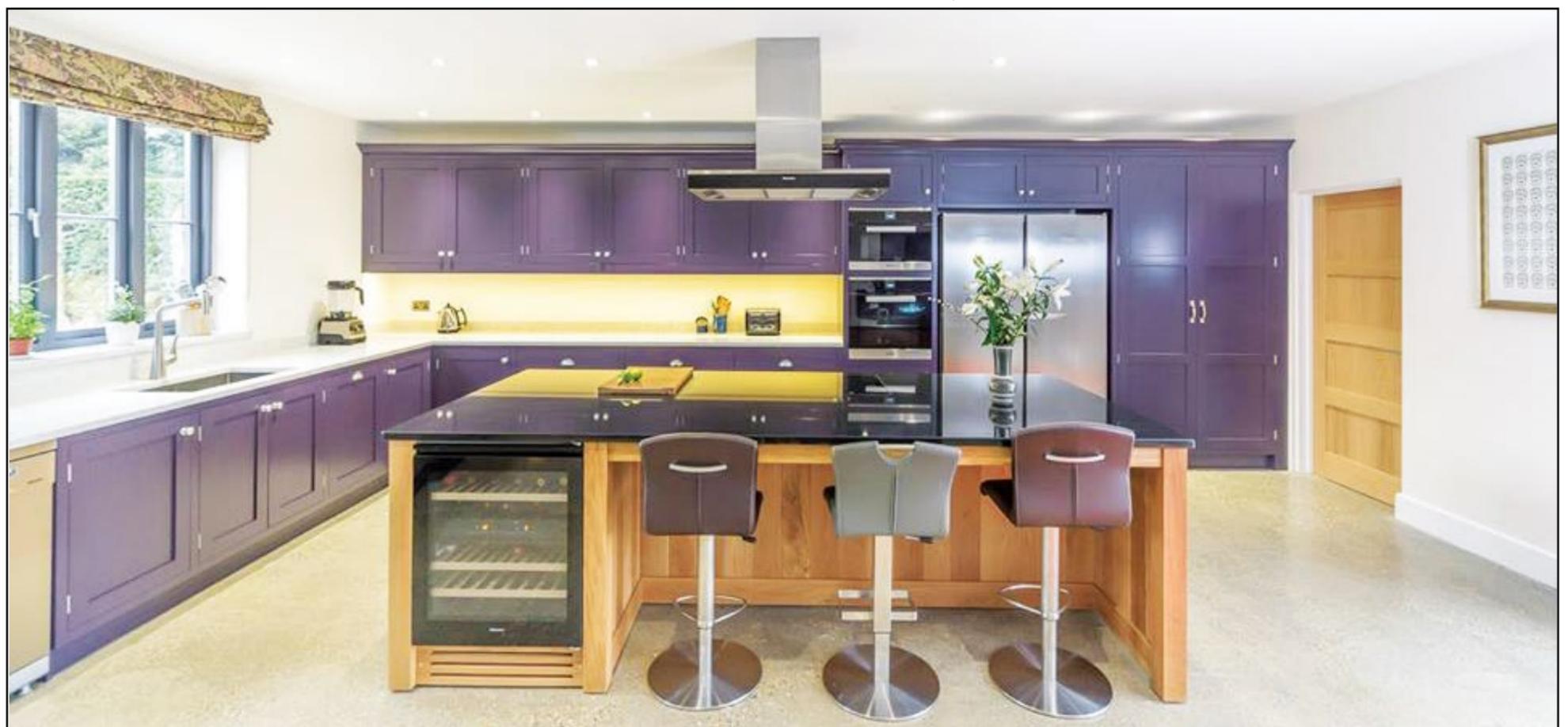
For further information tel Martin on 00 49 8332 9110. Visit [www.martin.info](http://www.martin.info)



Other standard features include a precision fence assembly with hand-wheel adjustment and digital display in the control unit, an electronic soft braking device for the spindle motor and the "Dornfix" quick shaft change system.

On request, the HSK tool change system can be specified, thus allowing the flexibility of having tools that are interchangeable with many CNC machining centres.

Other options include motorised positioning of the fence assembly, variable



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# ALL THE ADVANTAGES NUMERICAL CONTROLLED

A CNC router is a Computer Numerical Controlled machine that uses computer programming to control a high speed rotating cutter to perform cutting and shaping operations.

A broad variety of materials can be cut by these machines, including (but not limited to) wood, plastics, carbon fibre and light metals, such as aluminium.

They are most frequently used for 2D cutting on flat materials. Using programmed tool-paths, which are derived from a vector drawing, a controller instructs the machine to move the tool-head along its X and Y axis.

However, with a fully programmable Z-axis and suitable design file and controller, they are equally capable of machining elaborate 3D profiles and designs into the same wide range of materials.

The progression of CNC technology has been radical, particularly for travel speeds and positional accuracy, automated tool change options and

features for automated operation and software integration.

Recent developments in machine features mean that customers can now purchase a cost-effective, tailor-made machine, configured to suit their exact needs and expectations, faster than ever before.

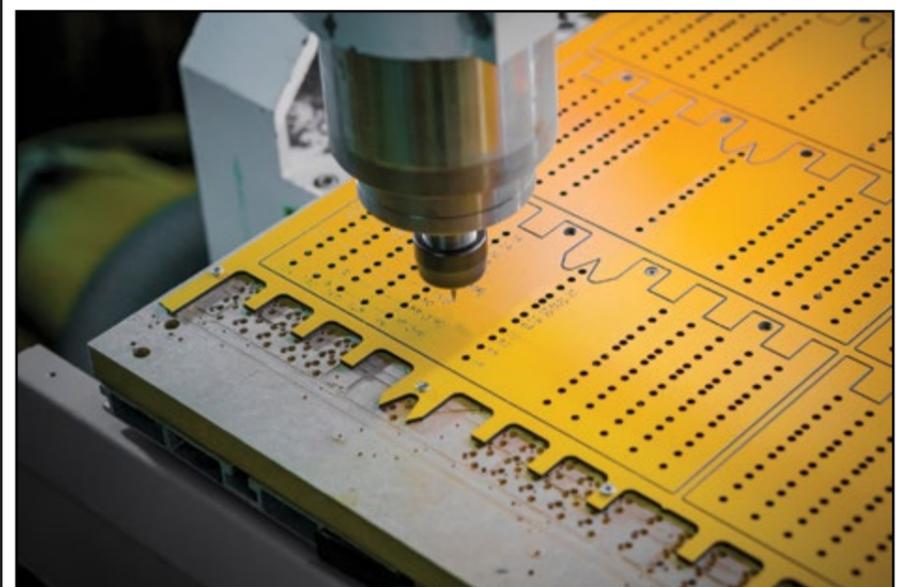
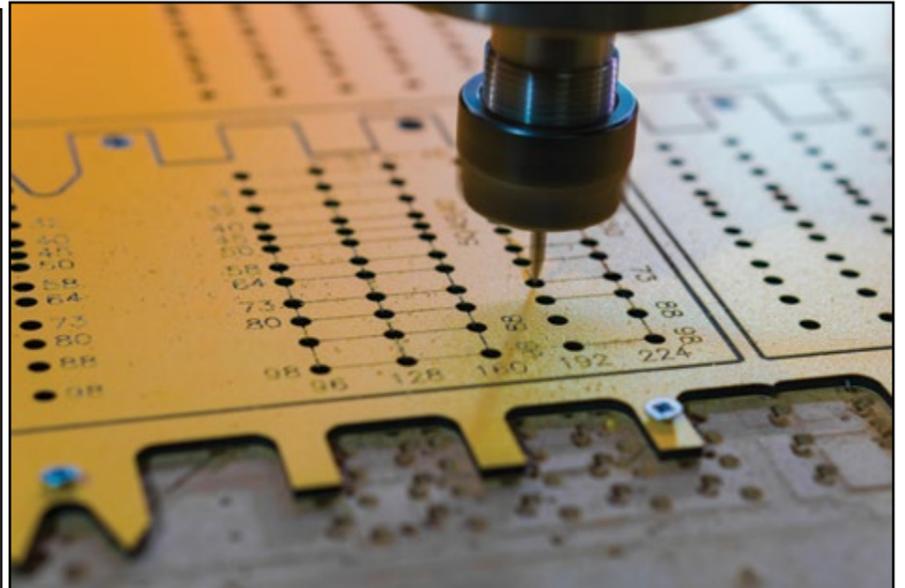
Routers are available in a range of sizes, from small desktop machines, to industrial machines capable of quickly processing very large and thick materials, making them a time efficient and cost effective solution to accurately processing materials.

Industry applications include furniture making, sign making, education, aerospace, automotive, electronics, engineering, set design and exhibition.

#### Benefits:

A major benefit of the router is being able to cut and engrave on the same machine without the need to invest in an alternate tool.

The repeatability of shaping material enables you



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# OF USING A COMPUTER MACHINE EXPLAINED



to cut materials precisely and as many times as needed, thus reducing frequency of errors and wastage.

These machines can be used with just one operator, which cuts down on labour costs. Furthermore, the general operating speed is up to 25,000rpm and the tool-head can move quickly along the X and Y axis with the result that materials can be processed at an exceptionally high rate. These factors make the machine extremely cost-effective after the initial investment.

The cutting tool is usually made of Carbon Steel, High-Speed Steel (HSS) or Solid Carbide, which ensures that very dense materials can be machined.

Adjustable tool-height allows thick materials to be cut without requiring higher power, unlike a laser cutting machine, which is limited by the useful length of the focussed laser prior to it diverging and weakening.

CNC routers generally receive their tool-path instructions from a piece of intermediate software, such as Vectric Cut2Dpro.

This means that operators can continue to use their drawing package of choice. Programming and operating the machine is relatively simple provided that training has been undertaken.

Although CNC routers create significantly fewer fumes than many other means of cutting, such as laser, they can create large amounts of chippings and dust during the cutting process.

However, CNC machines are usually fitted with a dust extraction system comprising of an extractor

fan and filter, to minimise the amount of dust leaving the bed to the surrounding environment.

Some machines can be fitted with vacuum beds that suck non-porous material down on to the bed, usually without the need for additional mechanical work-holding.

However, it is important to note that as the materials cut away, the holding-down force of the vacuum weakens.

Some CNC routers have zone valves in order to concentrate the vacuum on the most appropriate section of the bed.

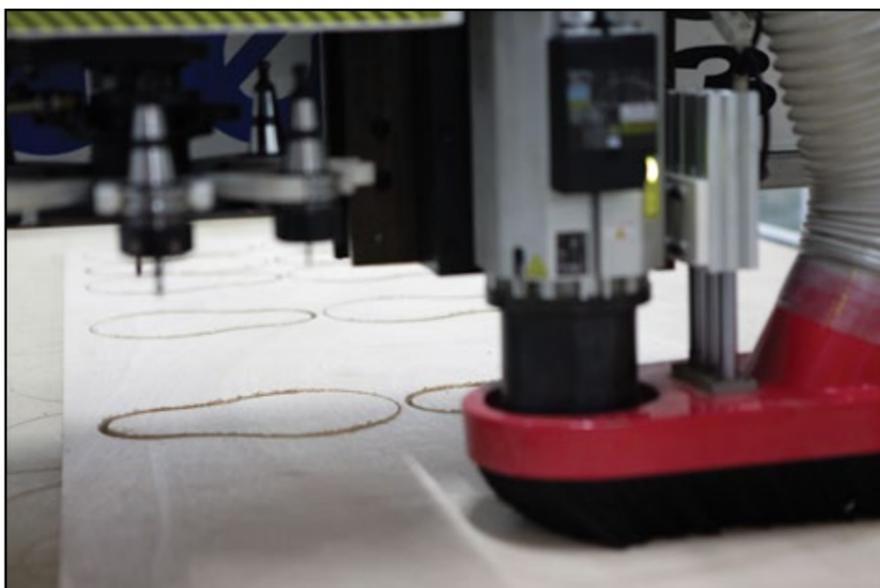
Routers are very safe to use providing training is undertaken and appropriate PPE is worn.

Additional features such as protective enclosures can also be added as a further safety measure, particularly when used in educational environments.

These advancements have solidified the CNC Router as a key machining tool in a number of industries, such as woodworking, panel processing, furniture making and signage.

CNC Router technology leaves little need for modern machines to advance more. Indeed, it almost feels as though we have reached the pinnacle of innovation in CNC router development, as it is difficult to imagine what significant developments could be next.

For further information tel HPC Laser on 01422 310800. Visit [www.hpclaser.co.uk](http://www.hpclaser.co.uk)



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