

EDGE SHAPING MACHINE

RELDA® 2000

DESCRIPTION

The **RELDA® 2000** edge shaping machine is ergonomically designed and easy to adjust. It is preset for conventional shaping jobs : flat and rounded edge forming and chamfering and bevelling.

It is design for manually shaping the edges of glass sheets from 2 to 19 mm thick. The adjustable belt speed optimizes the use of the different qualities of abrasives and polishing bands currently available on the market : diamond, carbide, aluminium oxide, cork, cerium oxide, etc.

Its modular design allows it to be customized for each user.

The **RELDA® 2000** machine is self-certified by the manufacturer **CE** mark.

The preproduction run was approved by Bureau Veritas.

TECHNICAL DATA

Weight :	195 kg
Dimensions H x Wx D in mm :	1860 x 1200 x 1000
Band width x length in mm :	100 x 2000
Belt speed :	6 - 30 m/s
Contact wheel dia. :	200 mm
Driven pulley dia. :	200 mm
2 types of power supply depending on version:	220 VAC Single phase or 380 VAC Three-phase

A single type of motor, power rating : 1,5 kW



Configuration of castor roller table and guides rails

USE

1) Many possibilities of edge shaping and very easy to use :

The **REIDA® 2000** machine is designed for conventional shaping jobs :

- . Polished flat edges,
- . Chamfered edges,
- . 45° chamfers and 30°, 20° and 10° bevels with an angular accuracy better than $\leq 1^\circ$.

The machine is designed to be as easy as possible :

- . 5 preset angular positions;
- . Contact roller and guide roller assembly height adjustable;
- . Band installation facilitated by a system for immobilizing the pulley under tension and when slack and excellent band accessibility.

The edge of the glass is shaped :

- . By pressing it against the contact roller,
 - For flat edges on thick glass sheet (≥ 6 mm)
- . By the free section of band between the contact roller and guide roller,
 - For flat edges on thin glass sheets (< 6 mm),
 - For rounded edges, chamfers and bevels.

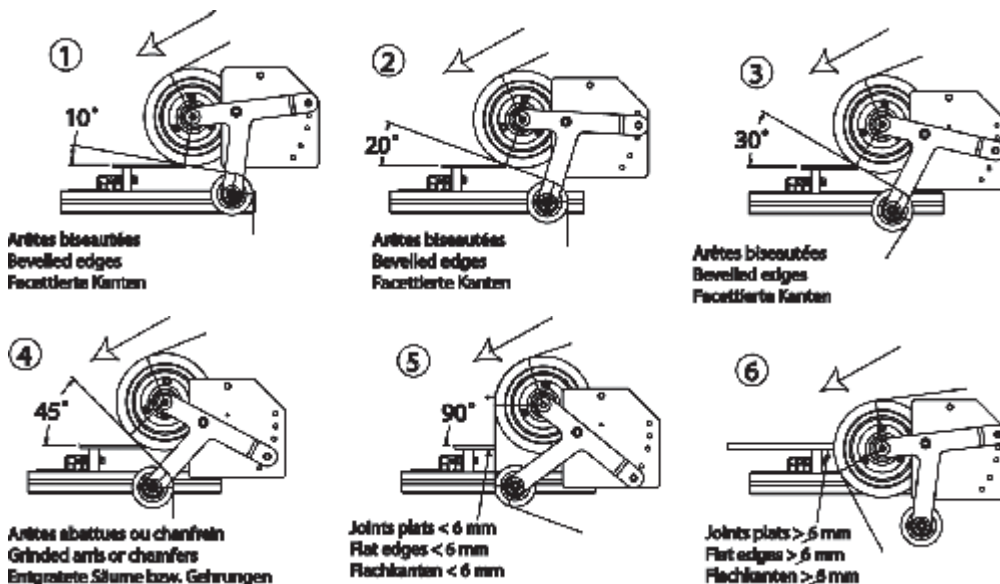
The following diagrams show the five angular positions and six working positions :

- . **Positions 1, 2 et 3** : Bevelled edges **10°, 20° et 30°**;

- . **Position 4** : Grinded arris or chamfers ;

- . **Position 5** : Flat edges < 6 mm ;

- . **Position 6** : Flat edges ≥ 6 mm.



To obtain these working positions, the machine includes two independent setting systems :

- . Contact roller and guide roller assembly height adjustment, variable over a range of 120 mm;
- . Angle of the free section of band, to be selected from five preset positions on the sector corresponding to the most widespread edge angles, i.e. 10°, 20°, 30°, 45° and 90° from horizontal.

Positions 1, 2, 3 and 4 are obtained by first setting the angle, then the height.

Positions 5 and 6, are set by first passing the band in front of the guide roller, then setting the angle to 90°, then setting the height such that the glass sheet is between the contact roller and guide roller .

2) Adjustable belt speed :

The **REIDA® 2000** is characterized mainly by a feed rate adjustable between 6 and 30 meters per second using a frequency variator.

Recommended belt speed for the different types of bands :

- . Silicon carbide abrasive bands : 20 m/sec ;
- . Diamond abrasive bands : 30 m/sec;
- . Cork polishing bands : 20 m/sec;
- . Aluminium or cerium oxide polishing bands : 10 m/sec.

3) A Highly modular rail system and castor roller table

The machine is equipped with a system of **extruded aluminium roller rails**, very easy to adjust.

The system is **modular** : and can be added to or customized by each user.

- Basic version : a 1200 mm rail with 11 rollers.

Standard Configuration



Many options are available : (see parts list for details)



- . Additional bearing rails (with double crosspiece and indexable positioning lever).
- . Roller half-rails for guiding in depth.



- . Castor roller table kit with jigs providing a large work surface 1200 mm x 800 mm for shaping the edges of large size sheets. The castor rollers facilitate effortless crosswise and lengthwise movements of the sheets.
- . Stainless steel collecting tray for the castor roller table.
- . Guide roller half-rails in depth. The two half-rails provide a depth stop for making long straight cuts, especially for bevelled edges.



- . Linear guide trolley 500 mm x 250 mm for shaping small volumes facilitates straight cuts.



- . Kit for making circular cuts, with two vertical axis guide rollers mounted on the first rail to provide circumferential guidance when shaping the edges of circular plates. The roller position is adjustable according to the plate diameter (min. dia.: 400 mm).
- . Castor roller table.
- . Stainless steel collecting tray for castor roller table.

4) A performing coolant system :

The machine can be supplied with tap water or by closed circuit. The pump for closed circuit use is available as an option.

The coolant spray is directed onto the glass/band contact area by articulated pipes and two swivel nozzles.

(see photo opposite)



MAINTENANCE

Maintenance of the machine is easy and reduced :

- . Excellent accessibility of the stainless steel setting tank ;
- . The pulleys are easily accessible and removable ;
- . The drive and driven pulleys are interchangeable ;
- . The bearings are sealed and protected by packing rings.

SAFETY

The machine has an on/off switch and an emergency stop switch. It is turned back on by rotary switch.

In case of a power failure, the machine stops and does not restart automatically.

Furthermore, the machine power supply is disabled when the band access door is unlocked.

WARRANTY

The **REIDA® 2000** machine is covered by a six-month warranty for normal use.

PARTS LIST

PART NUMBER	NOMENCLATURE	SOLD BY
145 59A	100 x 2000 mm diamond band, medium grain	x1
145 65H	100 x 2000 mm diamond band, fine grain	x1
150 00F	Abrasive, wet, 100 x 2000 mm, G 60	x1
150 01G	Abrasive, wet, 100 x 2000 mm, G 80	x1
150 02H	Abrasive, wet, 100 x 2000 mm, G 120	x1
150 03J	Abrasive, wet, 100 x 2000 mm, G 180	x1
150 04K	Abrasive, wet, 100 x 2000 mm, G 220	x1
150 09Q	Cork band, wet, 100 x 2000 mm	x1
151 05U	TRIZACT band, 100 x 2000 mm, A5	x1
152 38P	Abrasive, wet, 100 x 2000 mm, G 60	x10
152 74C	Abrasive, wet, 100 x 2000 mm, G 80	x10
152 88T	Abrasive, wet, 100 x 2000 mm, G 120	x10
152 89U	Abrasive, wet, 100 x 2000 mm, G 180	x10
152 90V	Abrasive, wet, 100 x 2000 mm, G 220	x10
15291W	Cork band, wet, 100 x 2000 mm	x10
224 05D	RELDA 2000 - 220 VAC single-phase	x1
224 08H	RELDA 2000 - 380 VAC three-phase	x1
224 09J	Additional bearing rail, length 1200 mm	x1
224 12M	Water pump for closed circuit coolant flow	x1
224 15Q	Set of two guide rails	x1
224 16R	Castor roller table in kit form	x1
224 17S	Grinding sledge	x1
224 18T	Coolant collecting tray for roller table	x1
224 19U	Sheet protection	x1
224 20V	Kit for grinding circular sheets	x1
224 21W	Decantation tank	x1
224 22X	Guide roller diam 85 x 120	x 1
224 23Y	Tension wheel, \varnothing 200 with square axis 25 x 25	x1
224 24Z	Complete drive Wheel	x1
224 25A	Complete work wheel	x1

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