



FRAME PROCESSING

Solutions for frame processing – Shaker, Miter and French Cut

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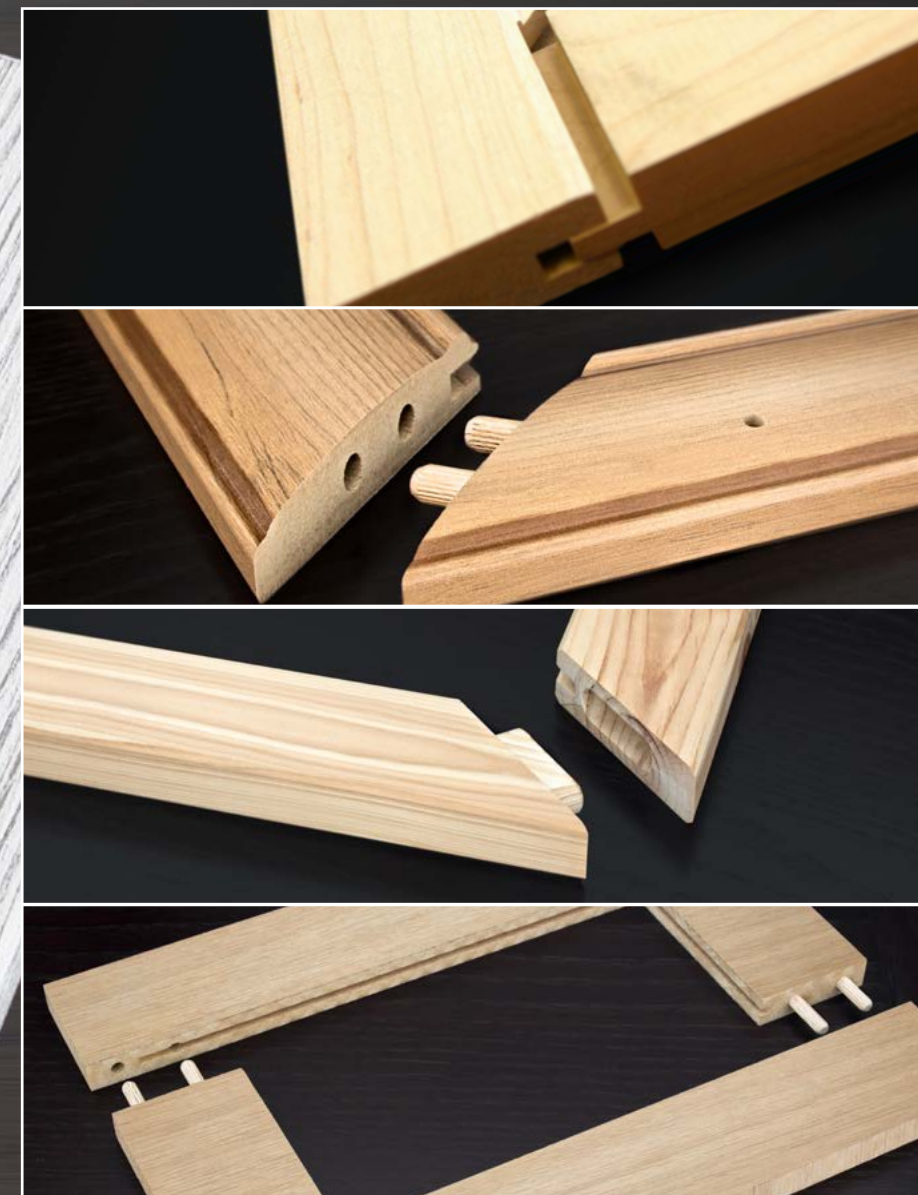
Solutions for frame processing – Shaker, Miter and French Cut

The efficient production of cabinet and furniture components requires a lot of know-how and machines that are specially adapted to the application. High flexibility and precision are necessary for all stages to achieve the desired added value.

KOCH offers various concepts for the production of doors and their components. The range of solutions includes manual fed single-sided machines for low volume or just-in-time production in work cells to fully automated through-feed machines for larger batch production. All machines can process a variety of profiles and materials.

Our product lines – base, pro and select – provide users with production lines perfectly fine-tuned to suit their needs, and with optional equipment enhancements, they can be ideally tailored to optimize production. Depending on the machine type, the machines can be used for the production of

- ✓ Shaker doors with dowel joints
- ✓ Miter doors with dowel joints or mortise and tenon construction
- ✓ French Cut with dowel joints or mortise and tenon construction



Product video



THE K-SYSTEM

You can rely on KOCH to answer all your needs with expertise, precision and passion. With KOCH as your partner, you are offered the full range of possibilities, where transparency and consistency are guaranteed. From our clearly structured range of products, we provide you with the perfect solution to match your requirements.

Whether gearing up for a profitable launch, optimizing production to increase flexibility or configuring a unique system for maximum performance – no matter how you decide, each option is designed with the core competencies of the industry's leader and results in top quality. We call it the K-SYSTEM.

At its manufacturing facilities in Germany, KOCH produces cutting-edge technology for wood processing. Our product lines, consulting expertise and services are available around the world at any time through our extensive network of branch offices and business partners.

Product lines to optimize productivity and success

base

base.line

effective planning. efficient production.

- ✓ Pure function and top quality combined in concentrated form
- ✓ Convenient handling and reliable performance guaranteed
- ✓ High-quality equipment at an attractive package price

pro

pro.line

flexibly featured. designed for growth.

- ✓ Enhanced functionality for targeted optimization
- ✓ Boost in flexibility thanks to additional features
- ✓ Select machines at an attractive package price

select

select.line

customizable configuration. smart optimization.

- ✓ Tailored configuration to maximize performance
- ✓ Utmost flexibility through perfectly customized functionalities
- ✓ Seamless integration into production processes

Solutions for frame processing

From just-in-time manufacturing to high volume production

Just-in-time manufacturing – Single-sided machines with manual feed

			S-1000	ENDMASTER-K base.line	ENDMASTER-P base.line	SPRINT-Multi	SPRINT	SPRINT-MT
Features								
Shaker door	DJ		✓	✓	✓	(✓)	✓	—
	MT		✓	—	—	✓	—	—
Miter door	DJ		✓	—	—	—	—	✓
	MT		✓	✓	✓	—	—	—
French Cut door	DJ		✓	✓	✓	—	—	—
	MT		✓	✓	✓	—	—	—
			Cut to size	Edge-banding, Hot-foiling		Sawing, Shaping, Drilling, Glueing, Dowel insertion etc.		

			FLEX-45	FLEX-45-ML	FLEX-FC	SPRINT-FC	Press
Features							
Shaker door	DJ		✓	—	—	—	✓
	MT		✓	✓	—	—	✓
Miter door	DJ		✓	—	—	—	✓
	MT		—	—	—	—	✓
French Cut door	DJ		—	—	✓	✓	✓
	MT		—	—	—	✓	✓
			Sawing, Shaping, Drilling, Glueing, Dowel insertion etc.				

DJ – Dowel joint MT – Mortise and Tenon

High flexibility, wide variety, with low production costs and a high degree of utilization of the machinery at the same time are of particular importance in the component and cabinet industry. KOCH offers concepts for component production utilizing the machines for several types of doors:

For high volume production – Double-sided through-feed machines

			S-200	S-250	ENDMASTER-K	ENDMASTER-P	SBD	UNIDRILL
Features								
Shaker door	DJ		—	✓	✓	✓	✓	✓
	MT		✓	—	—	—	—	—
Miter door	DJ		✓	—	—	—	—	—
	MT		✓	—	—	—	—	—
French Cut door	DJ		✓	—	✓	✓	—	—
	MT		✓	—	—	—	—	—
			Cut to size		Edge-banding, Hot-foiling		Sawing, Shaping, Drilling, Glueing, Dowel insertion etc.	

			BL	SBD-45	SMT-45	SBD-FC	Press
Features							
Shaker door	DJ		✓	✓	—	—	✓
	MT		—	✓	—	—	✓
Miter door	DJ		—	—	✓	—	✓
	MT		—	—	—	—	✓
French Cut door	DJ		—	—	—	✓	✓
	MT		—	—	—	—	✓
			Sawing, Shaping, Drilling, Glueing, Dowel insertion etc.				

 Sawing  Dowel insertion  Edge-banding  Drilling  Shaping  Hot-foiling



S-1000 / S-200 / S-250

Trimming of multiple length material

Speed, flexibility and the highest precision – With KOCH trim saws you can increase your production output and reduce your costs.



S-1000
Trim saw for trimming of multiple length material (final cut)



Highest quality for maximum availability



Trimming station

S-1000

Trim saw with manual feed for final cut

✓ Cut to size

S-200

Trim saw for pre-trimming of multiple length material

✓ Rough cut with +/- 2 mm tolerance

S-250

Trim saw for trimming of multiple length material (final cut)

✓ Cut to size



S-200
Trim saw for pre-trimming of multiple length material



S-250
Trim saw for trimming of multiple length material



ENDMASTER

Reliable solutions for edge-banding

Whether for single-sided processing with manual loading or for double-sided processing with through-feed, KOCH ENDMASTER machines are designed for versatility. They can be used to efficiently process a variety of workpiece profiles, edging materials or any standard adhesive.

ENDMASTER-K base.line

Single-sided edge-banding machine

- ✓ Edge-banding
- ✓ Long edge drilling (optional equipment)

ENDMASTER-P base.line

Single-sided hot-foiling machine

- ✓ Hot-foiling
- ✓ Horizontal drilling (optional equipment)
- ✓ Dowel insertion (optional equipment)



ENDMASTER-K base.line
Single-sided edge-banding and drilling machine

ENDMASTER-K pro.line

Double-sided edge-banding machine for through-feed processing

- ✓ Edge-banding
- ✓ Further processing units such as trimming, routing and drilling are available

ENDMASTER-P pro.line

Double-sided hot-foiling machine for through-feed processing

- ✓ Hot-foiling (of straight, chamfered and profiled workpiece ends)



ENDMASTER-K pro.line
Edge-banding machine, double-sided through-feed processing



ENDMASTER-K base.line
Edge-banding and trimming unit



ENDMASTER-P base.line
Single-sided hot-foiling, drilling and dowel insertion machine



ENDMASTER-K pro.line
Trimming unit



Processing of a variety of workpieces



Complete part processing with optional equipment



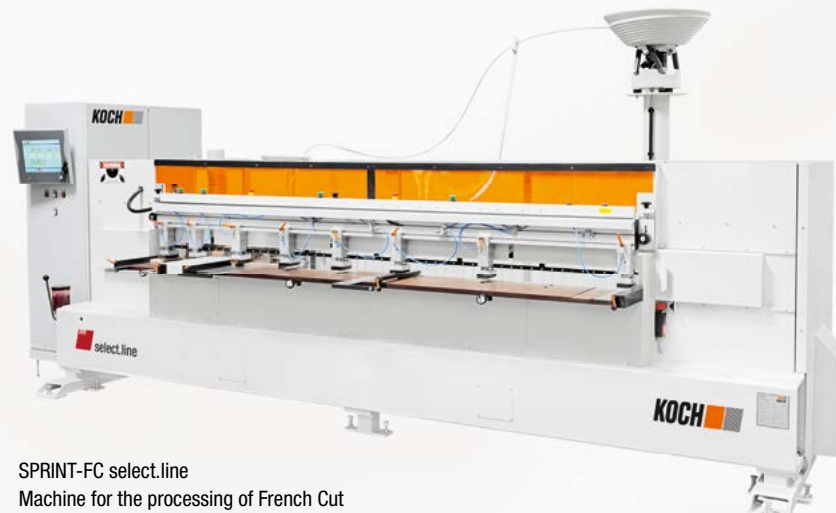
SPRINT

For a wide variety of applications

Well-engineered technology, convincing performance parameters and easy handling are characteristics of our SPRINT series. It guarantees fast and cost-efficient solutions for the production of small and medium-sized batches in renowned KOCH quality. Depending on the product line – base, pro or select – along with additional equipment enhancement options, the machines in our SPRINT series can be ideally adapted to suit your production needs.



SPRINT
Drilling and dowel insertion machine



SPRINT-FC select.line
Machine for the processing of French Cut door components

SPRINT

Drilling and dowel insertion machine

- ✓ Horizontal drilling
- ✓ Vertical drilling
- ✓ Dowel insertion

SPRINT-MT select.line

CNC mortise and tenon machine with three axes

- ✓ Shaping unit for tenons
- ✓ Shaping unit for grooving

SPRINT-Multi select.line

Sawing, drilling and dowel insertion machine

- ✓ Cut to size (for 45° or 90° cut)
- ✓ Horizontal drilling
- ✓ Dowel insertion



SPRINT-Multi select.line
Sawing, drilling and dowel insertion machine

SPRINT-FC select.line

Machine for the processing of French Cut door components. The machine is equipped for the processing of stiles and rails

- ✓ Horizontal haunching for French Cut
- ✓ Shaping unit for tenons
- ✓ Shaping unit for grooving

or alternatively

- ✓ Horizontal drilling
- ✓ Dowel insertion



SPRINT base.line
Drilling and dowel insertion station



SPRINT-FC select.line
Unit for the processing of French Cut door components (dowel joints)



SPRINT-FC select.line
Shaping/haunching unit for the processing of French Cut door components (mortise and tenon)



SPRINT-Multi select.line
Trimming, drilling and dowel insertion at 45°



SPRINT-MT select.line
Horizontal routing for mortise and tenon construction



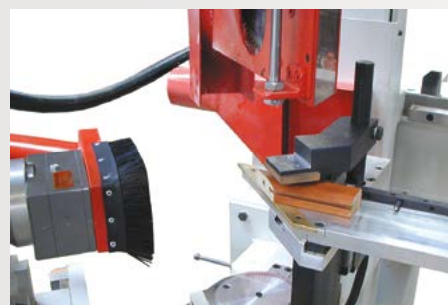
FLEX

Solutions for sawing and drilling

Our FLEX series is particularly suited for the fast and flexible production of smaller batches of framed doors. Like all KOCH products, these powerful sawing and drilling machines are characterized by short set-up times and user-friendly operation – and their solid construction and engineering ensure high-precision results.



FLEX-45-ML
Sawing and drilling machine for 45° processing
(double-sided processing)



FLEX-45
Sawing and drilling station at 45°

FLEX-45-ML

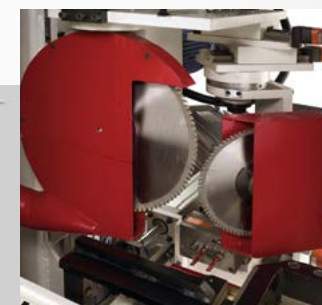
Sawing and drilling machine for 45° processing, double-sided processing

- ✓ Cut to size with miter cut (multi-length)
- ✓ Horizontal drilling
- ✓ Automatic feeding of multi-length material

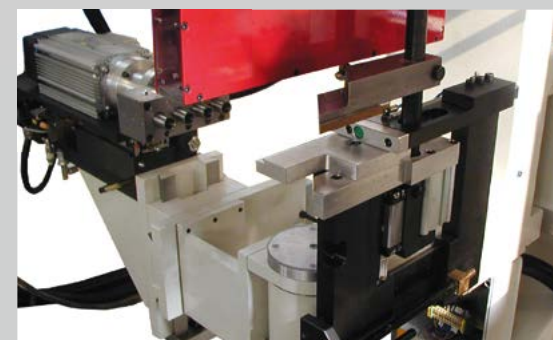
FLEX-45

Double-sided sawing and drilling machine for 45° and 90° processing of small and narrow parts

- ✓ Sawing (swivel capacity +/- 45°)
- ✓ Horizontal drilling (swivel capacity 0° / 90°)



FLEX-FC
French Cut sawing and horizontal long edge drilling



FLEX-45
Sawing and drilling station at 90°

FLEX-FC

French Cut sawing and drilling machine

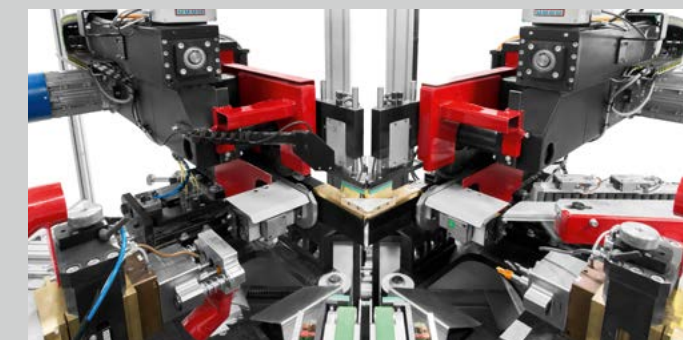
- ✓ French Cut sawing
- ✓ Horizontal edge drilling



FLEX-45-ML
Sawing and drilling station at 45° (multi-length)



Maximum flexibility for smaller batch sizes



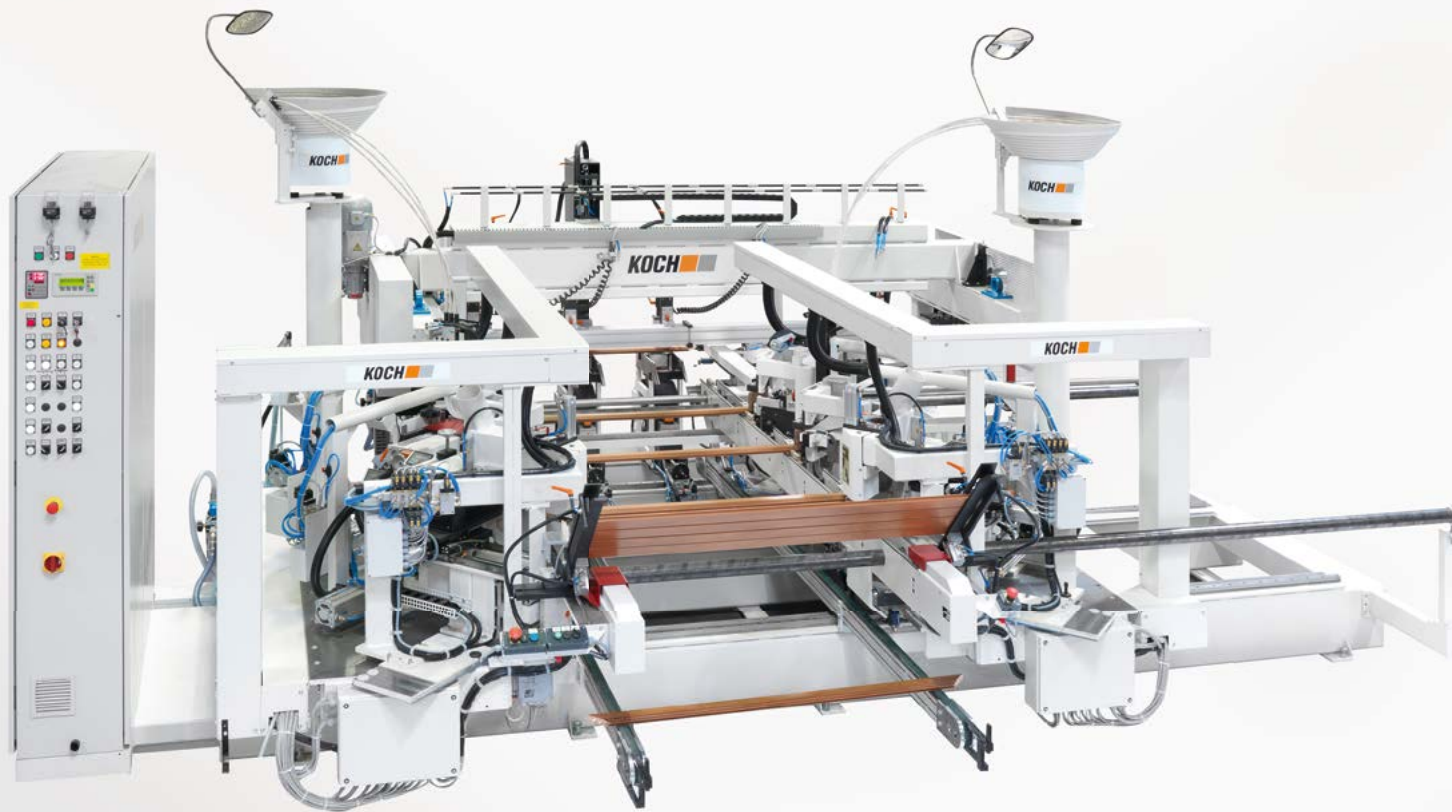
Even short workpiece lengths can be processed with peak precision



UNIDRILL + BD/SBD

Sawing, drilling and dowel insertion –
Double-sided through-feed processing

The sturdy construction of the equipment in our BD/SBD series forms the foundation for high-precision processing and consistent reproducible accuracy. Thanks to their modular design, the stations for multiple operations – from sawing and shaping through to drilling and/or dowel insertion – can be seamlessly combined in one continuous, double-sided process. Reliable performance, short set-up times and absolute safety are the hallmarks of this system design.



SBD-45
Double-sided sawing, drilling
and dowel insertion machine
for 45° processing



SBD
Sawing, drilling and dowel insertion stations



SBD-FC
French Cut sawing station

UNIDRILL

Double-sided drilling machine

- ✓ Horizontal drilling
- ✓ Vertical drilling from above and/or below
- ✓ Long edge drilling
- ✓ Dowel insertion (optional)
- ✓ Sawing (optional)

SBD

Double-sided sawing, drilling and dowel insertion
machine for 90° processing

- ✓ Sawing
- ✓ Horizontal drilling
- ✓ Vertical drilling from above and/or below
- ✓ Long edge drilling
- ✓ Dowel insertion

SBD-45

Double-sided sawing, drilling and dowel insertion
machine

- ✓ Sawing at 45°
- ✓ Drilling at 45°
- ✓ Dowel insertion at 45°
- ✓ Working stations swiveling to 45° and 90° (optional)

SBD-FC

Double-sided sawing and drilling machine for
French Cut doors

- ✓ French Cut sawing
- ✓ Drilling
- ✓ Haunching/shaping for center cut

SMT-45

Double-sided sawing, shaping and drilling
machine for miter doors (dowel joints as well as
mortise and tenon)

- ✓ Cut to size 45°
- ✓ Shaping of grooves and tenons
- ✓ Horizontal drilling
- ✓ Long edge drilling

SBFD-P-FC

Sawing, shaping, drilling and dowel insertion
machine

- ✓ Cut to size
- ✓ Hot-foiling
- ✓ French Cut sawing
- ✓ Horizontal drilling
- ✓ Dowel insertion



SBD-FC
Haunching/shaping for center cut



UNIDRILL pro.line
Drilling units



SBD-45
45° processing



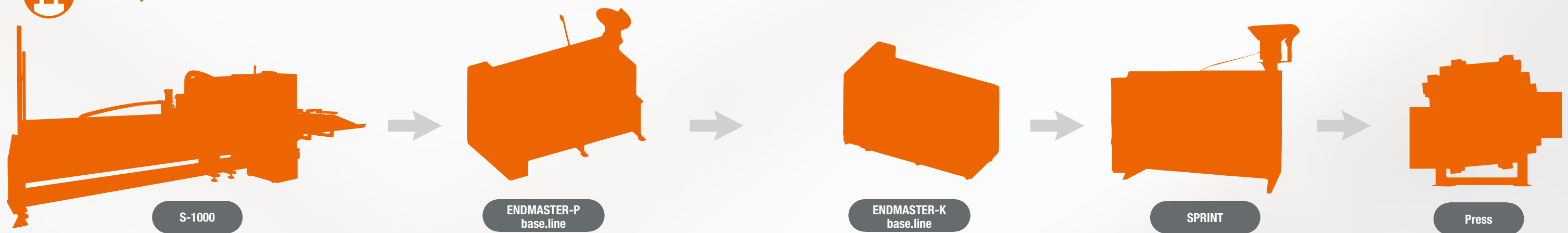
WORKFLOW

Shaker doors

Just-in-time production



Dowel joint



Processing:

Stiles:

- ✓ Cut to size
- ✓ Edge-banding
- ✓ Long edge drilling

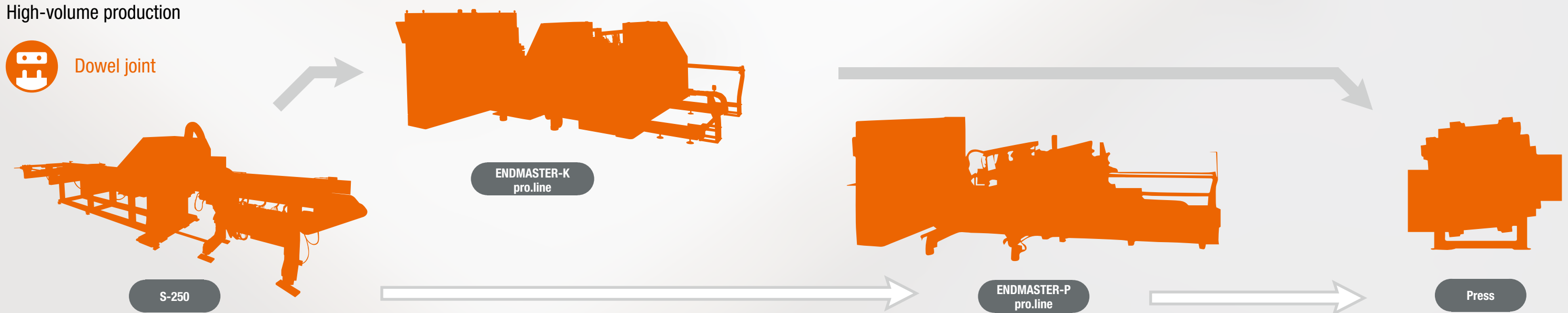
Rails:

- ✓ Cut to size
- ✓ Chamfering
- ✓ Hot-foiling
- ✓ Drilling and dowel insertion

High-volume production



Dowel joint



➡ Stile ➡ Rail



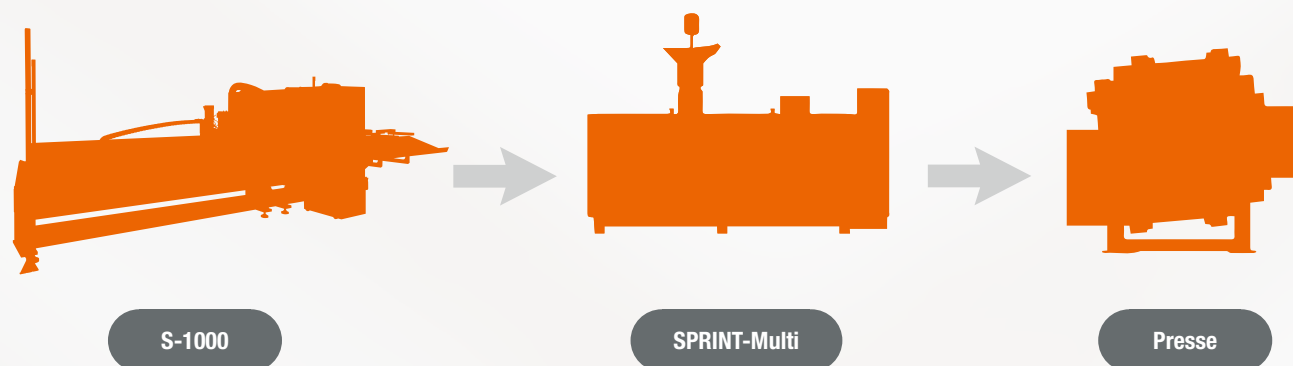
WORKFLOW

Miter doors

Just-in-time production



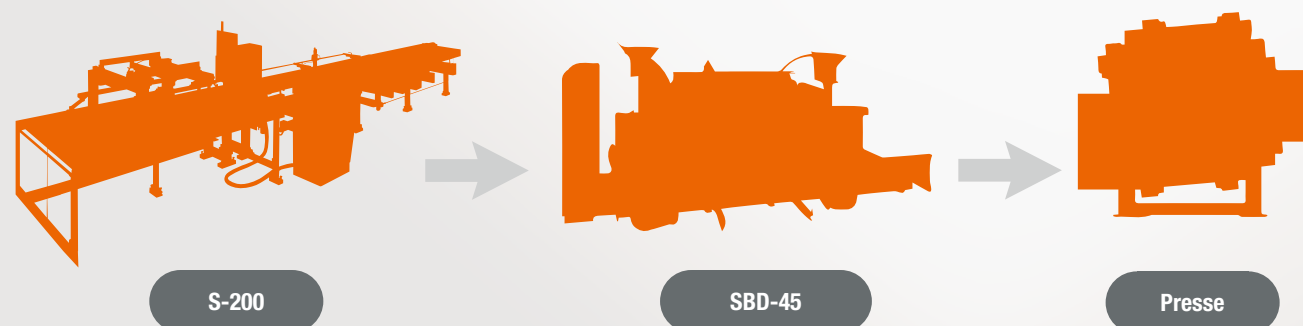
Dowel joint



High-volume production



Dowel joint



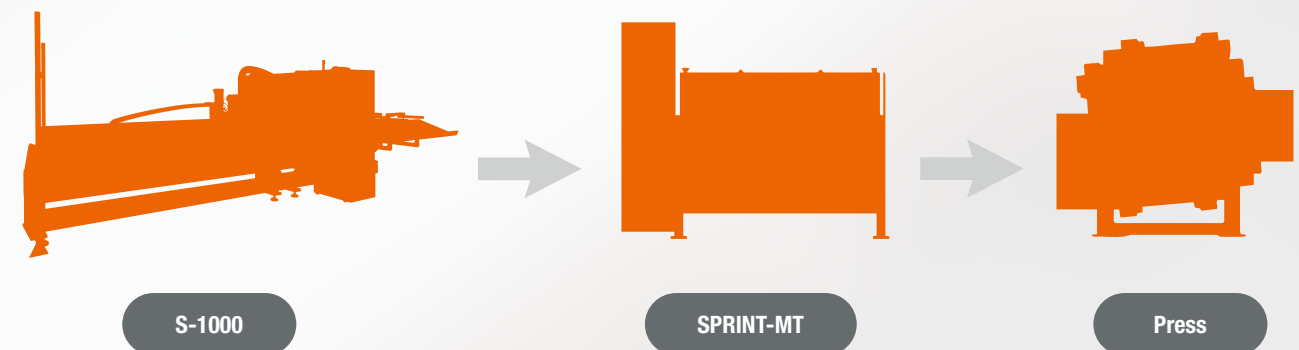
Processing

- ✓ Cut to size
- ✓ Miter cut
- ✓ Mortise and Tenon or Drilling and dowel insertion

Just-in-time production



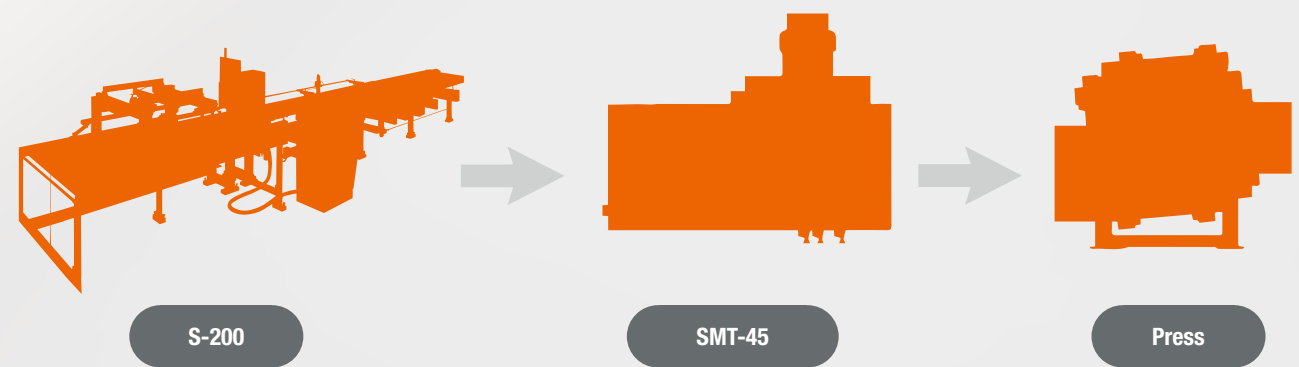
Mortise and Tenon



High-volume production



Mortise and Tenon



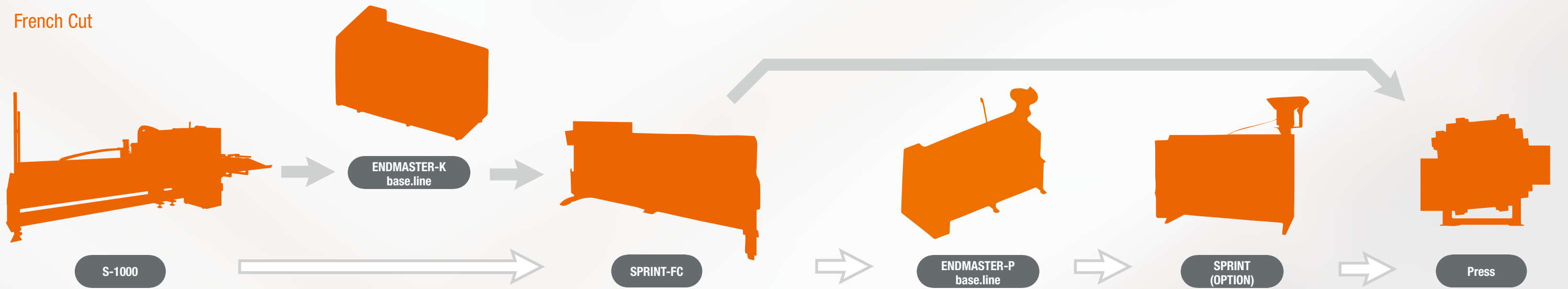


WORKFLOW

French Cut doors

Just-in-time production

French Cut



Processing

Stiles:

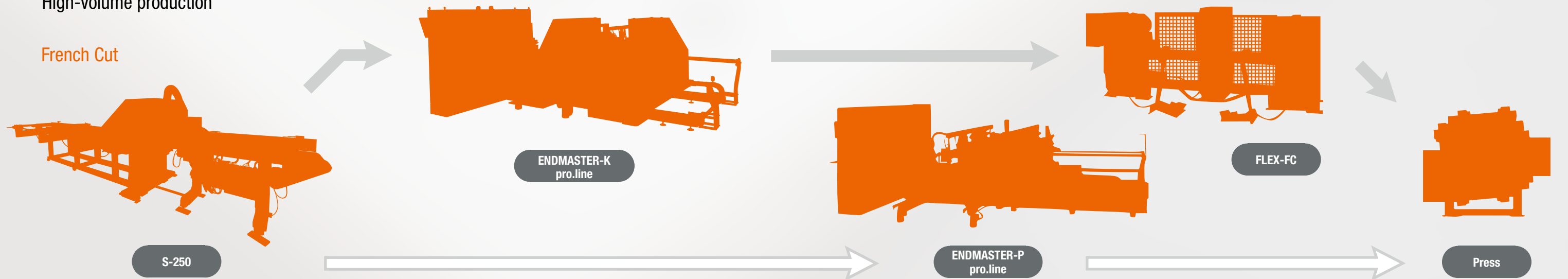
- ✓ Cut to size
- ✓ Edge-banding
- ✓ French Cut
- ✓ Long edge drilling

Rails:

- ✓ Cut to size
- ✓ Chamfering
- ✓ French Cut
- ✓ Hot stamping
- ✓ Drilling and dowel insertion

High-volume production

French Cut



➡ Stile ➡ Rail



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