

The logo for VIET NARROW features a square icon with diagonal hatching on the left, followed by the text "VIET NARROW" in a bold, sans-serif font. "VIET" is in dark grey and "NARROW" is in green.

Finishing centre



# When competitiveness means high-quality specific machining operations



Made **In** Biesse

## The market demands

the possibility of **handling orders** for specific machining operations, most often requested in the building and doors and windows industries, with guaranteed **delivery times and high quality standards**.

## Viet responds

with **technology solutions** that can be customised depending on manufacturing requirements and deliver high product quality without compromising productivity. **Narrow** is a finishing centre designed for big industry, and allows for the machining of long, narrow pieces (skirting, wood flooring, strips, frames, building beams, windows). It is the ideal solution for line production and for high-quality specific machining operations.

- ✓ **This modular solution is highly customisable, in accordance with the needs of each individual customer.**
- ✓ **Machining operations are optimised, with the option of machining the top and bottom of two panels simultaneously.**
- ✓ **High productivity for line environments.**
- ✓ **Maximum finish quality.**



# The line solution for reduced profiles



**NARROW**  
Finishing centre



# Highly customisable modular solution

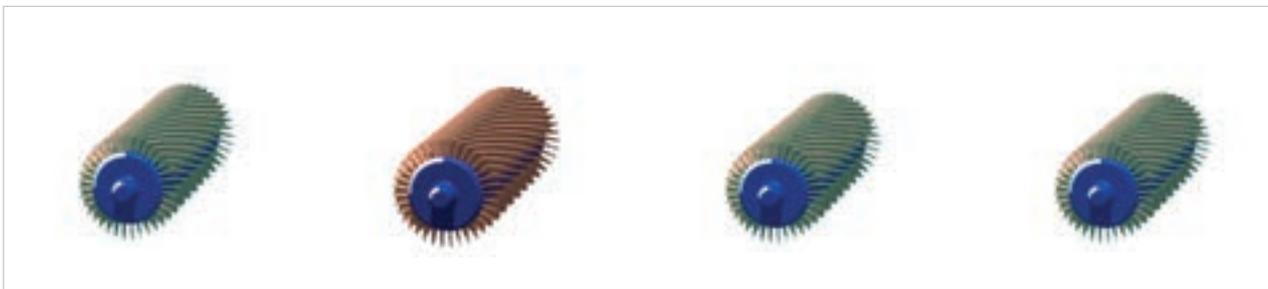
**Narrow is a compact modular solution which can be configured to machining operation requirements.**



It can be composed of a top or bottom machine, or incorporated in-line, with the two machines joined, allowing for both sides of the panel to be machined in a single step.

When inserted within an automatic production line, Narrow can also be installed on shifting tracks, with significant optimisation with regard to abrasive belt use.

A comprehensive range of units can be combined and repeated within the machine and can occupy 4 upper or lower positions, delivering a vastly superior quality across all panel finish types when compared to the market standard.



Buffing roller.

Abrasive brush.

Brushing brush.

Cleaning brush.



Win units.



Pad.



Roller.

# Optimised machining operations

**Narrow is the ideal machine for the building sector, allowing beams of up to 400 mm thick to be machined. Perfect for flooring and disassembled window elements, or long, narrow pieces.**

Roller, pad and abrasive brush units.

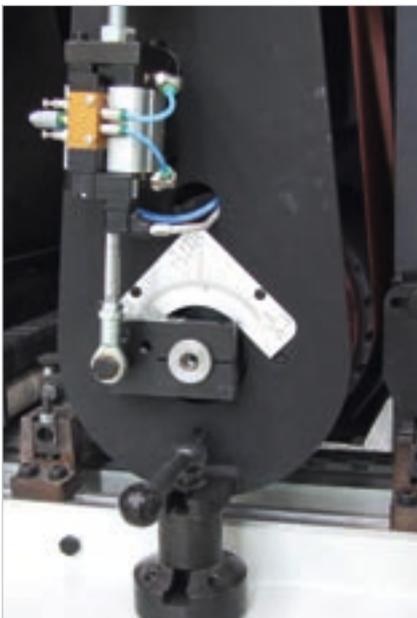


Upper units



Lower units

Narrow can support continuous and intensive machining operations following profiling steps. High performance line operations with forward speeds of up to 100 m/min.



### Machine roller unit

The Roller unit is extremely precise and effective. Depending on the hardness of the rubber used and the roller's cross-section, the unit can be used to calibrate, sand or finish.

Available cross-section sizes:

190 mm

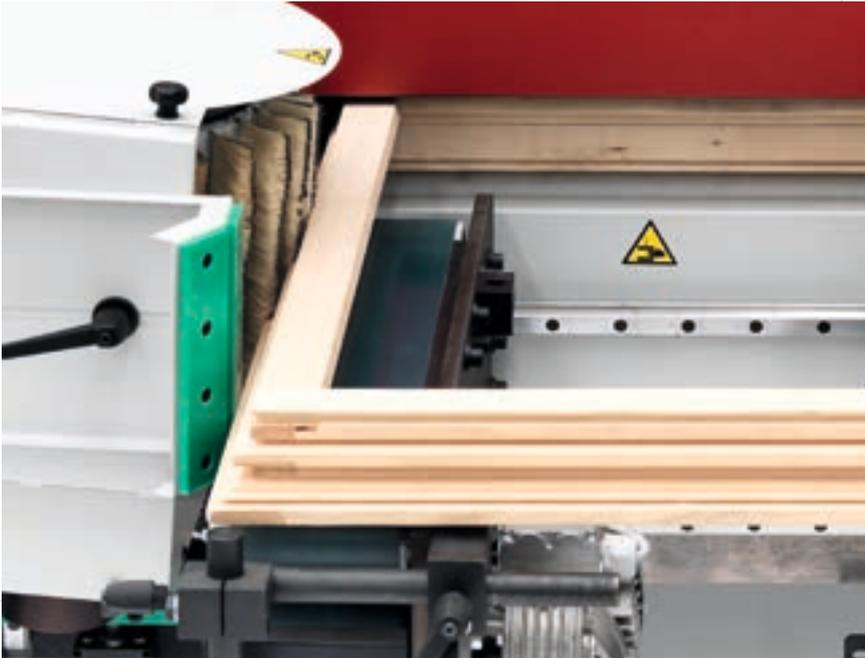
240 mm



### Pad unit

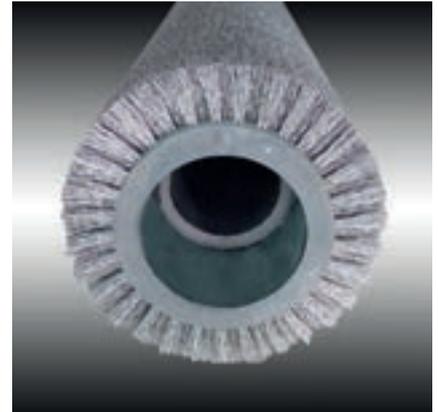
The soothing pad group is the ideal tool for smoothing and finishing with reduced surface roughness.

# Exceptional finish quality

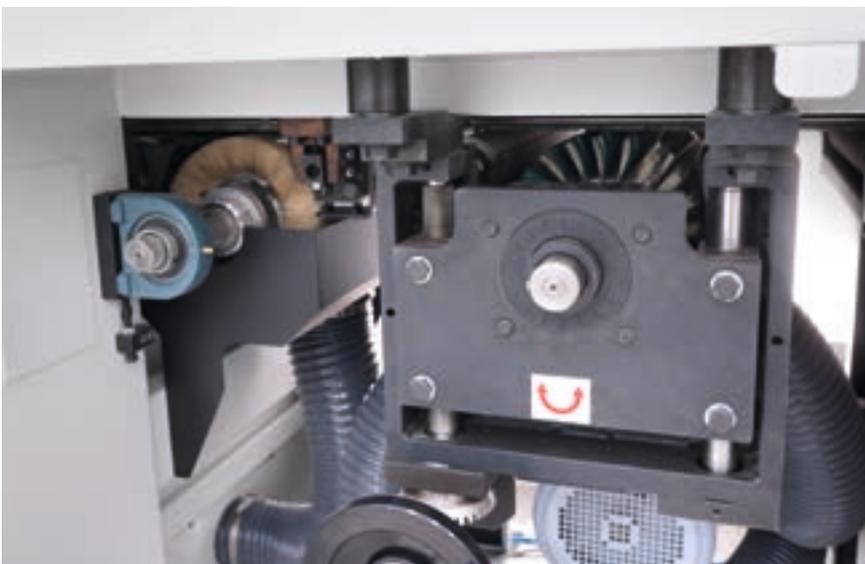


The **unit with vertical win brushes** is a vertical rotating-brush sanding system. The unit enables customers to sand - via a brushing action - the object's profiles and side surfaces, ensuring an even fin-

ish. Individual units, equipped with large cross-section brushes (300 mm), can be adjusted independently as far as side position, angle ( $-10^{\circ}$   $+35^{\circ}$ ) and height.



The **brushing unit** enables the customer to highlight the wood grain of processed panels.



Sturdy and reliable, the **longitudinal brush** is fitted with a cross-sectional oscillation system to provide a uniform finish quality for the end piece, as well as with electronic interference adjustment managed from the control panel. Abrasive bristles can be replaced quickly and without the need of removing the unit from the machine. 200 mm cross-section abrasive brush.

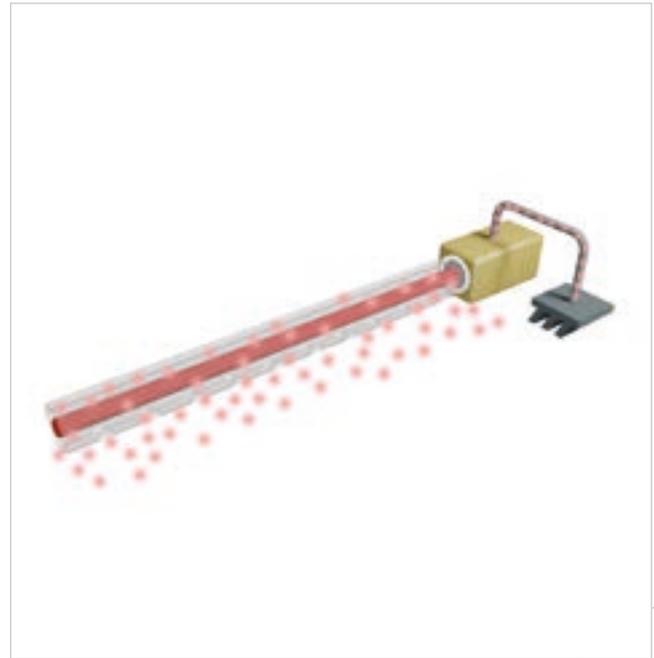
# Optimum panel cleaning



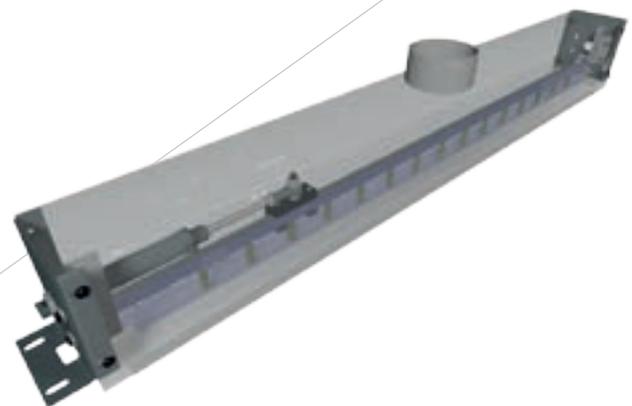
The panel cleaning brush is ideal for thoroughly cleaning the machined panels.



The anti-static bar eliminates electrostatic charges on painted panels.



The **rotating blower**, positioned downstream of the machine, enables optimal cleaning of the panel's surface at the end of the sanding cycle.



The **linear blower** is used to finish cleaning the panel's edges. Ideally, it should be coupled with the rotating blower.

# Eco-friendly smoothing

A close-up photograph of a hand wearing a white nitrile glove. The hand is holding a bright green, three-dimensional letter 'E' on a light-colored wooden surface. In the background, several other three-dimensional letters are scattered, including a grey 'E', a dark wood 'A', and a light wood 'E'. The lighting is soft and focused on the hand and the green letter.

The Energy Saving System is a series of devices designed by Viet to minimise energy consumption during machining. They are engineered and designed to ensure a high degree of efficiency, as well as optimising production, with effective suction thanks to the automatic opening of the collectors, in accordance with the units in operation; in addition, an automatic system stops machines and places them on standby after a pre-determined period of inactivity, and the vacuum table system, which operates by means of an inverter, optimizes the vacuum for holding the panel, according to the size of the panel being processed.



**ESS**  
VIET ENERGY SAVING SYSTEM

With every attention to saving energy, the Viet range of machines includes the E.S.S. system, which allows for energy savings of up to 30% with regard to both electricity consumption and CO2 emissions. A perfect combination of Biesse technology and Italian genius.

# Service & Parts

Direct, seamless co-ordination of service requests between Service and Parts. Support for Key Customers by dedicated Biesse personnel, either in-house and/or at the customer's site.

## Biesse Service

- ✓ Machine and system installation and start-up.
- ✓ Training centre dedicated to Biesse Field engineers, subsidiary and dealer personnel; client training directly at client's site.
- ✓ Overhaul, upgrade, repair and maintenance.
- ✓ Remote troubleshooting and diagnostics.
- ✓ Software upgrade.

500 / Biesse Field engineers in Italy and worldwide.

50 / Biesse engineers manning a Teleservice Centre.

550 / certified Dealer engineers.

120 / training courses in a variety of languages every year.

The Biesse Group promotes, nurtures and develops close and constructive relationships with customers in order to better understand their needs and improve its products and after-sales service through two dedicated areas: Biesse Service and Biesse Parts.

With its global network and highly specialised team, it offers technical service and machine/component spares anywhere in the world on-site and 24/7 on-line.



## Biesse Parts

- ✓ Original Biesse spare parts and customised spare kits depending on machine model.
- ✓ Spare part identification support.
- ✓ Offices of DHL, UPS and GLS logistics partners located within the Biesse spare part warehouse, with multiple daily pick-ups.
- ✓ Order fulfilment time optimised thanks to a global distribution network with de-localised, automated warehouses.

87% / of downtime machine orders fulfilled within 24 hours.

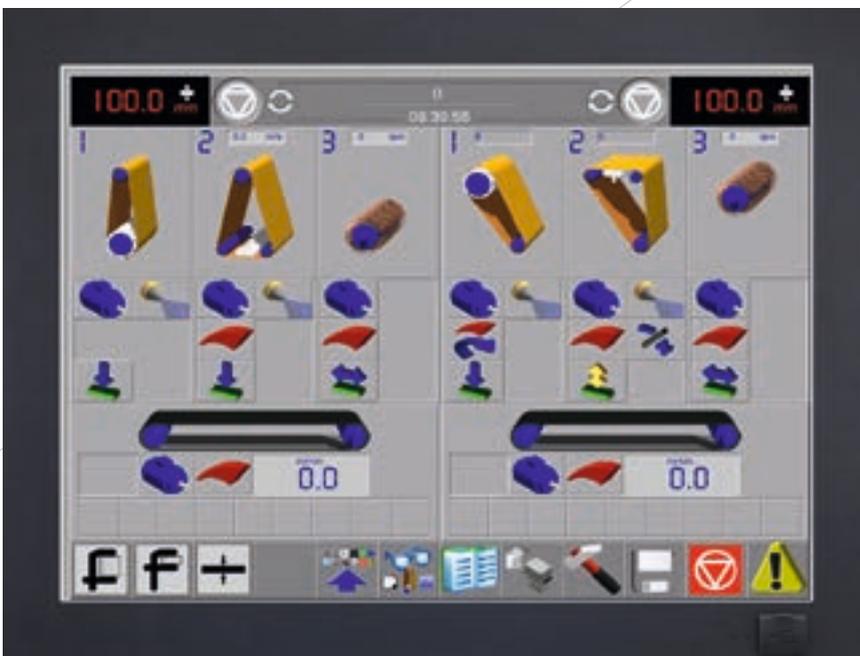
95% / of orders delivered in full on time.

100 / spare part staff in Italy and worldwide.

500 / orders processed every day.

# Ease of use and power

IPC is a range of Control systems that are integrated into the machine via 8" or 15" Touch Screen monitors. This type of control system supports the management of all machine parameters, providing the operator with timely and intuitive information. The industrial PC processor provides control and feedback information to the machine in real time, making it extremely user friendly for the operator.



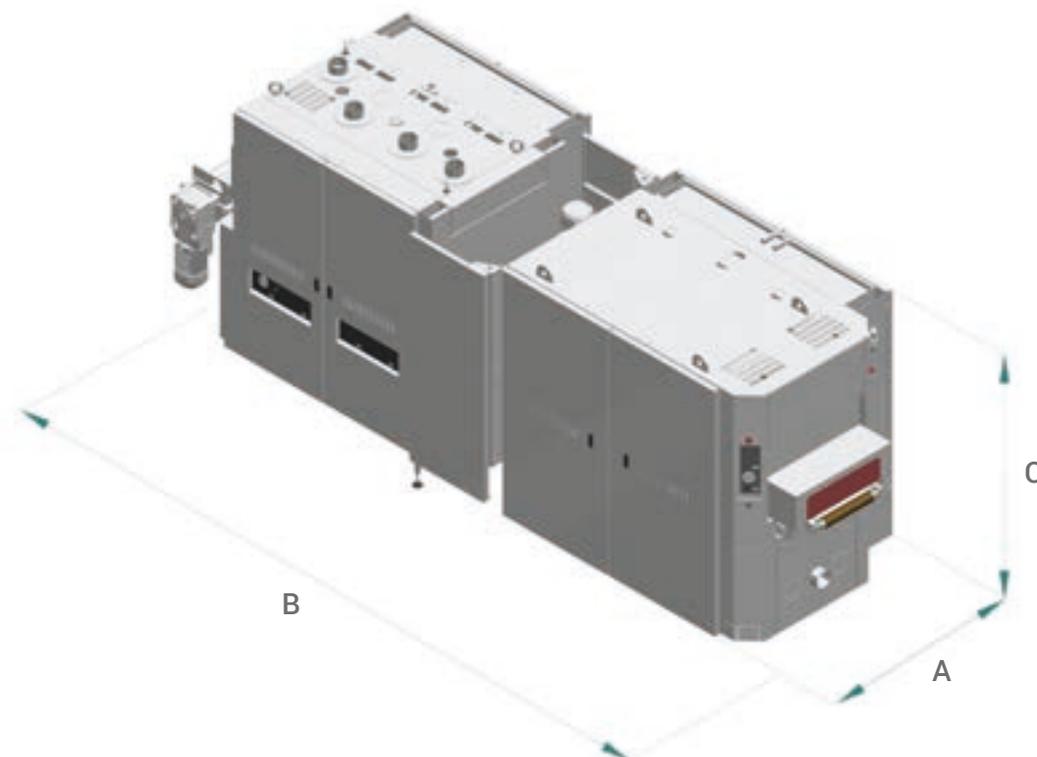
The IPC system is the highest expression of sanding machine management technology available on the market



IPC 15 - a single interface for the management of the entire line

The IPC 15 control manages Narrow even in configurations which consist of both lower and upper machine units.

# Technical specifications



	NARROW 2.4i + 2.4s	NARROW 3.4i + 3.4s	NARROW 4.4i + 4.4s
A (mm / inch)	1515 / 59.6	1515 / 59.6	1515 / 59.6
B (mm / inch)	4450 / 175.2	5350 / 210.2	6300 / 248
C (mm / inch)	1920 / 75.6	1920 / 75.6	1920 / 75.6
Working width (mm / inch)	400 / 15.7	400 / 15.7	400 / 15.7
Min-max processing thickness (mm / inch)	3 - 160 / 0.1 - 6.3	3 - 160 / 0.1 - 6.3	3 - 160 / 0.1 - 6.3
Abrasive belt dimensions (mm / inch)	430 x 1900 / 16.9 x 74.8	430 x 1900 / 16.9 x 74.8	430 x 1900 / 16.9 x 74.8
Forward speed (m/min)	3 - 16	3 - 16	3 - 16
Operating pressure (bar)	6	6	6
Mass (Kg)	4380	4900	7240
Motor power up to (Kw (HP))	15 (20)	15 (20)	15 (20)

The technical specifications and drawings are non-binding. Some photos may show machines equipped with optional features. Biesse Spa reserves the right to carry out modifications without prior notice.

A-weighted surface sound pressure level (Lp<sub>fA</sub>) during machining for operator workstation on vane-pump machine Lp<sub>fA</sub>=76dB(A) L<sub>wA</sub>=95dB(A)  
 A-weighted sound-pressure level (Lp<sub>fA</sub>) for operator workstation and sound power level (L<sub>wA</sub>) during machining on cam-pump machine L<sub>wA</sub>=76dB(A) L<sub>wA</sub>=95dB(A). K measurement uncertainty dB(A) 5

The measurement was carried out in compliance with UNI EN 848-3:2007, UNI EN ISO 3746: 2009 (sound power) and UNI EN ISO 11202: 2009 (sound pressure levels at workstation) during panel machining. The noise levels shown are emission levels and do not necessarily correspond to safe operation levels. Despite the fact that there is a relationship between emission and exposure levels, this may not be used in a reliable manner to establish whether further measures need to be taken. The factors determining the exposure level for the workforce include length of exposure, work environment characteristics, other sources of dust and noise, etc. i.e. the number of other adjoining machines and processes. At any rate, the above information will enable the operator to better evaluate dangers and risks.

# Made **With** Biesse

## A single solution for sanding and profiling.

Alpilegno, a Leader in the sector of high-quality, high-performance windows and doors, performs sanding operations followed by profiling operations in its Val di Ledro (TN) manufacturing unit. Loris Cellana, an entrepreneur with long-standing experience in this sector, recalls how he evaluated machinery and system suppliers for over two years to find one that could guarantee a cutting-edge finished product: "In the end I chose Biesse". The core of the new manufacturing line is a Uniwin machine, combined with a modern 5-axis Rover C that produces doors. "I think that Uniwin is already a good profiling machine in itself, but what was equally important to me was its interaction with other line components, such as the planer, the sanding machine and the press, and the material flow

between the various machines". Components are custom-cut and stored in a loading device by Biesse's automation programme that feeds the automatic planer. A conveyor belt moves the work pieces from the planer to the sanding machine, a Viet Narrow 334 Bottom also supplied by Biesse. From there, the components are sent to the Uniwin's loader, from which they are picked to be fully processed. 72, 80, 92 and 104 mm thicknesses in wood and wood-aluminium are processed. The magazines house up to 98 tools that are always available. Such tools can be changed in real time during machine operation thanks to a chain-operated tool-changer.

"Assembly precision enables us to avoid having to remove glue residues from the frame", explains Cellana: "in

this way, surface calibration and sanding must be arranged the one after the other, to go to the pressing stage immediately after profiling". Moreover, individual components are not painted before they are pressed, as it is customary. As a matter of fact, Cellana paints the entire frame. The compact production line occupies a footprint of only 15x15 metres; components are always handled forward and backward from the planing to the profiling machine, leaving enough space also for a walkway. "I like Biesse's solution: it is compact, the machines are efficient and, since they all come from the same supplier, it is easy to learn how to operate them", explains a visibly satisfied Cellana.

*Source: Holzkurier Austrian magazine/special Nuremberg Exhibition issue.*



<http://www.alpilegno.com>



# Biesse Group

In

1 industrial group, 4 divisions.  
and 8 manufacturing sites.

How

€ 14 million p/a in R&D and 200 patents registered.

Where

33 branches and 300 agents/certified dealers.

With

customers in 120 countries, manufacturers of furniture,  
design items and door/window frames, producers of  
elements for the building, nautical and aerospace industries.

We

3,000 employees worldwide.

**Biesse Group** is a global leader in the technology  
for processing wood, glass, stone, plastic and metal.

Founded in Pesaro in 1969, by Giancarlo Selci,  
the company has been listed on the Stock Exchange  
(STAR segment) since June 2001.

 **BIESSEGROUP**

 **BIESSE**

 **INTERMAC**

 **DIAMUT**

**MECHATRONICS**

