

Title (en)

Method and apparatus for machining and dividing a cant into pieces of timber

Title (de)

Verfahren und Einrichtung zur Bearbeitung und zum Zerlegen von Kantenhölzern in Holzstücke

Title (fr)

Méthode et appareil pour usiner et couper une bille équerrie en pièces de bois

Publication

**EP 2439030 B1 20160217 (EN)**

Application

**EP 11184638 A 20111011**

Priority

FI 20106043 A 20101011

Abstract (en)

[origin: EP2439030A1] The invention relates to a method for processing a balk and dividing the same into pieces of lumber. A balk (P1) has been made from a log (T) by trimming (105) it for two vertical sides (s1, 2). The method comprises advancing a balk on a processing line (201) through subsequent treatment steps, comprising a) milling (106) a side slab groove (u11, u21; u12, u22) near top and bottom edges of the balk's (P1) each vertical side (s1, s2), said groove having its first groove flank (uh1, uh2, uh3, uh4) set in substantially perpendicularly to the balk's vertical side and its second groove flank (uv1, uv2, uv3, uv4) substantially co-directionally with the balk's vertical side, and said side slab grooves serving to define side slabs (L1, L2) on the balk's trimmed sides; and b) sawing (108) each side slab (L1, L2) off of the balk's (P1) vertical side (s1, s2) by means of a saw machine (208). According to the invention, after step a, wood material is removed from the second groove flank (uv1, uv2, uv3, uv4) of each side slab groove (u11, u21; u12, u22) by milling, and a third groove flank (uv1 a, uv2a, uv3a, uv4a) is produced which is parallel to the balk's vertical side (s1, s2), and during the course of step b, one or more saw blades of the saw machine (208) are adapted to trace the third groove flank in its immediate proximity. The invention relates also to an apparatus applying the method.

IPC 8 full level

**B27B 1/00** (2006.01); **B27B 31/06** (2006.01)

CPC (source: EP FI)

**B27B 1/00** (2013.01 - EP); **B27B 1/007** (2013.01 - FI); **B27B 7/00** (2013.01 - FI); **B27C 1/08** (2013.01 - FI)

Cited by

CN107042545A; US11135735B2

Designated contracting state (EPC)

AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

DOCDB simple family (publication)

**EP 2439030 A1 20120411**; **EP 2439030 B1 20160217**; FI 123382 B 20130328; FI 20106043 A0 20101011; FI 20106043 A 20120412; FI 20106043 L 20120412

DOCDB simple family (application)

**EP 11184638 A 20111011**; FI 20106043 A 20101011