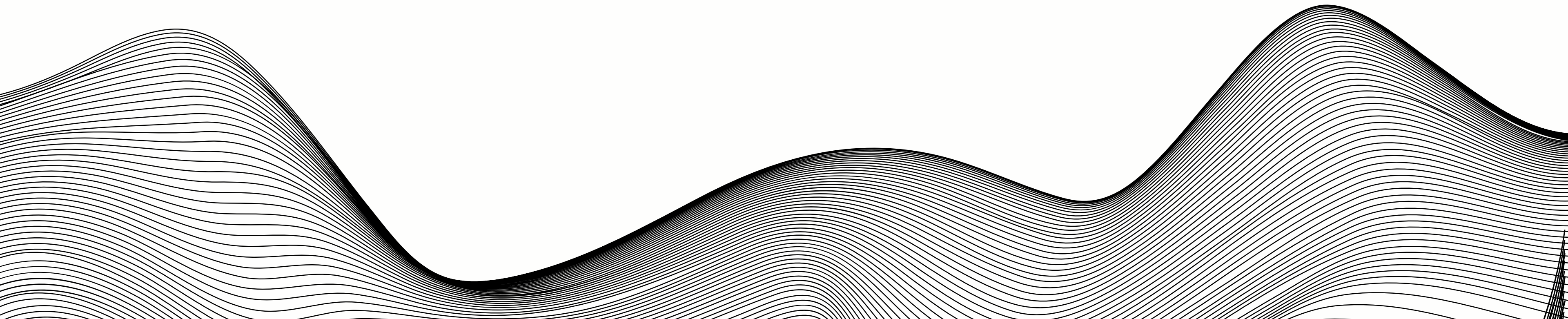




**WOTSO**  
Wood tech Solutions

C O M P L E T E   S O L U T I O N  
S M A R T   F A C T O R Y

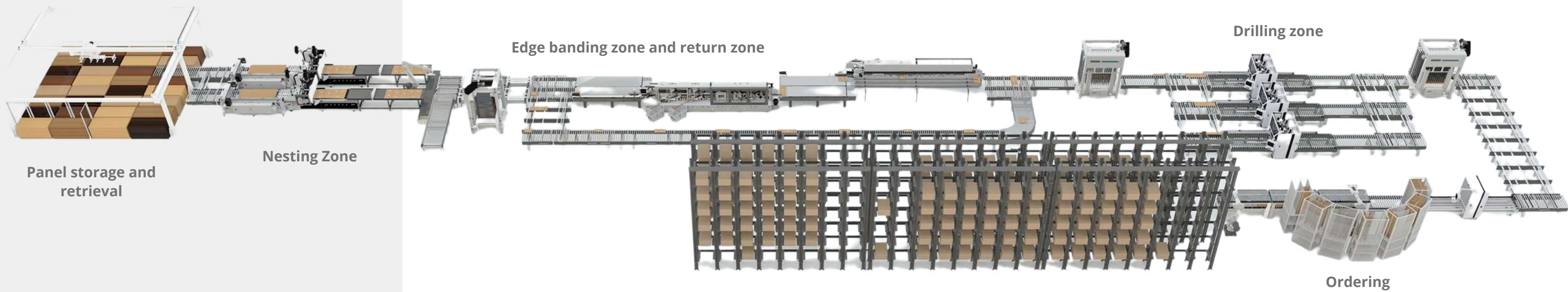


- 
- Smart Factory
  - Dustfree and High-efficiency Nesting Cell
  - High-speed Flexible Edgebanding Cell
  - High-speed Drilling Cell

# Complete solutions for **smart factories**

TAILOR-MADE PRODUCTION SOLUTIONS

① Increase Profitability and Productivity with our complete Service, from project planning to fully automated production lines.





**WOTSO**  
Wood tech Solutions

Dustfree and High-efficiency Nesting Cell

# Nesting Cell WK/ WK-G / W4 Optional

Nesting Cell - One label machine & two Nesting machines

**Output**  
2800-3800 pcs / 8 hours

**Footprint**  
16.5x6m

**Operator**  
1



# Nesting Cell WK/ WK-G / W4 Optional

Nesting Cell (Robot Stacking) - One label machine & two Nesting machines

**Output**  
2800-3800 pcs / 8 hours

**Footprint**  
20.6x6m

**Operator**  
1

**Order-based** For batch size 1 and series production

**Reduce error** Eliminates human errors, reduces panel damage

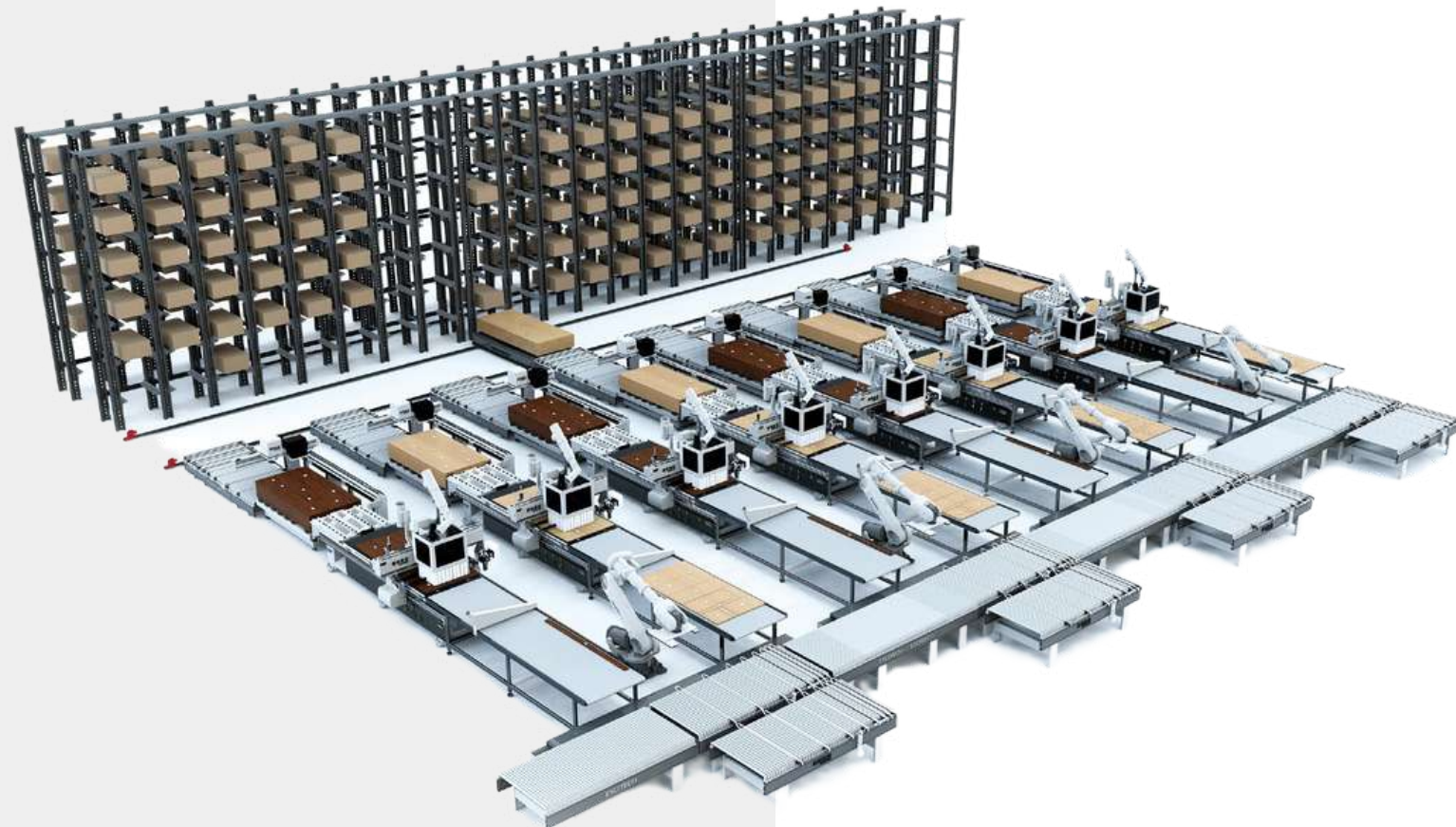
**Enhance Efficiency** Greatly enhances efficiency

**Reduced labor cost** Require less operators than manual processing



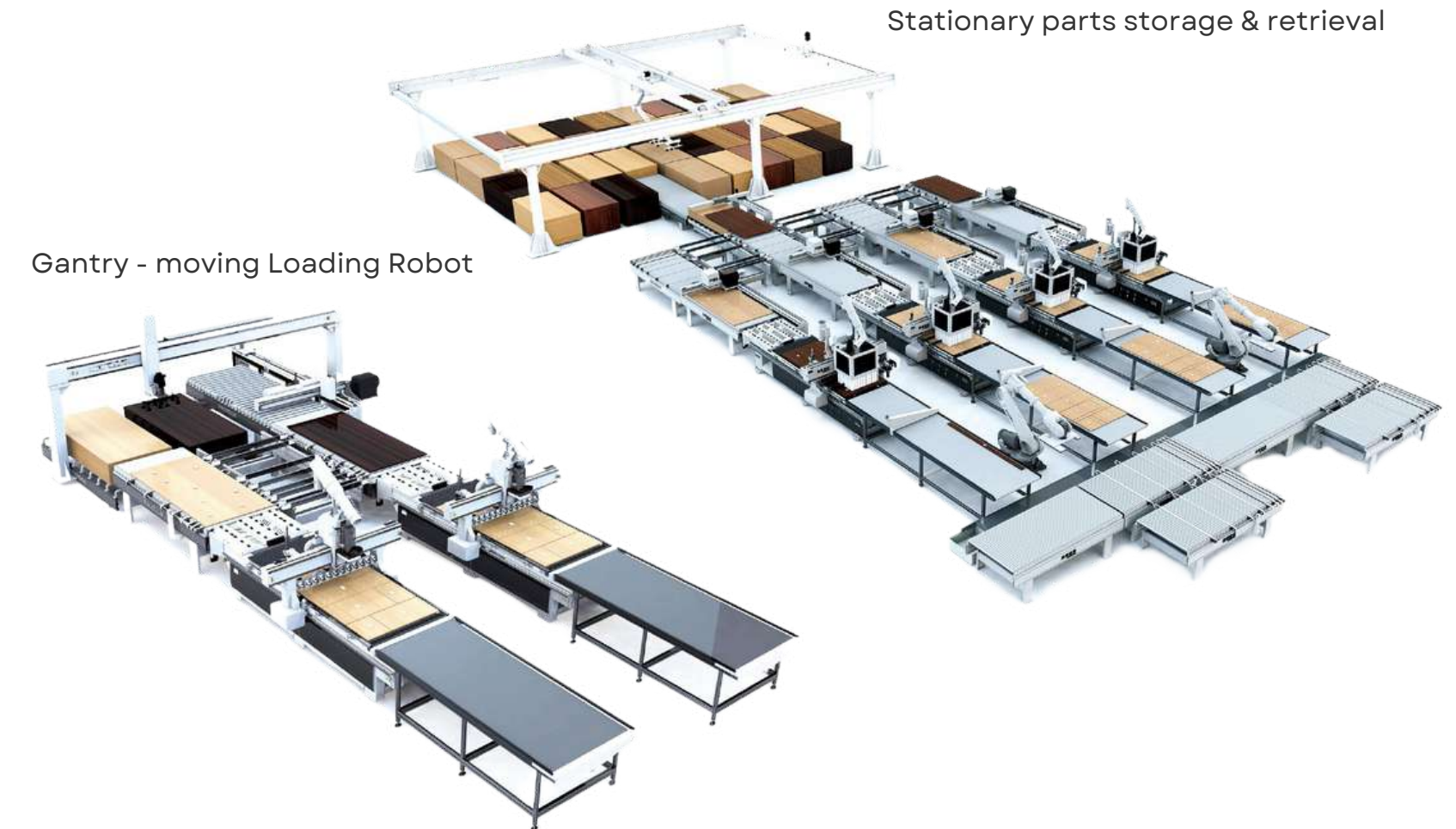
## Nesting Cell RGV/AGV + Vertical Storage

Batch size 1 nesting with series conditions.  
Unstaffed panel supply system



## Nesting Cell Panel supply by Gantry - Moving Robot

Solutions for order-based production: great flexibility  
and automated sequences for production with a wide  
range of colors, materials, sizes, etc.



# Dust-free Technologies

Up to 98% of dust extration effect, ideal for all commonly used materials such as MDF board, chipboard and plywood board.

**173** To create a better, dust free and healthier working environment for your production space, we have made **173** upgrades to the machines.  
Improved air duct design allows unobstructed air flow.

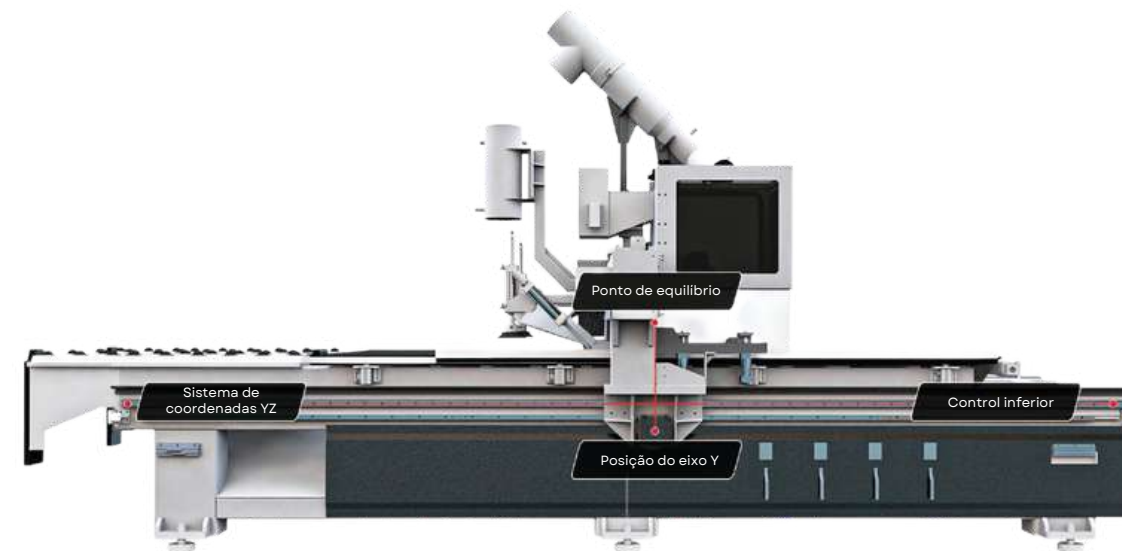
**Sistema inteligente** Intelligent control of air duct on/off and air flow direction.

**22** Truly dust free even cutting at 22m/min.  
Visibly dust free effect.

Heavy duty & welded unibody Gantry and frame.

High precision transmission system

High stability electrical system



# Dynamic balance

Velocidade de processamento de m/min para manter o padrão de alta precisão



Armazenamento de alta resistência



Alta resistência e precisão completa



Aço estrutural de liga engrenagem 100% de alta resistência e dureza.

## Sistema de execução

O núcleo de equipamento, as funções e o processo são perfeitamente apresentados, garantindo um processamento de alta qualidade.

## Sistemas estruturais

Design dinâmico otimizado da máquina inteira, amortecimento de choques e redução do intervalo de serviço comum para alcançar a estabilidade do processamento.

## Sistemas de transmissão

A saída de potência crescente, transmissão estável, limite de fadiga alta e alta resistência ao impacto.

# Heavy – duty Nesting W4

Heavy-duty Nesting with [Dustfree Processing](#)

<b>With option to upgrade to new labeling device</b>	3.8 secs per label
<b>With option to upgrade to rotate labeling device</b>	Automatically adjusts position to stick label on narrows parts
<b>Uninterrupted work cycle</b>	Automatic pre-labeling, infeeding, nesting, outfeending in one cycle to enhance productivity

[Patented dust-free nesting technologies](#)



# High speeded machine WK-G Series

[High speed](#) nesting machine

<b>Auto tool charger</b>	High-power spindle to process different materials
<b>Carousel tool magazine</b>	16 servo tool changers optional
<b>Application</b>	Cabinet, flat door, molded door, etc.





# Linear tool changer WK-C Series

Dust nesting machine with [Linear tool changer](#)

- Auto tool charger** High-power spindle to process different materials
- Linear tool magazine** Linear tool magazine travels with the bridge, tool changing is faster and easier
- Application** Cabinet, flat door, molded door, etc.



Series	Traveling Size	Working size	Dimension	Net.W eight	Travelling speed	Working speed	Loading and unloading speed	Spindle Info.	Tool Magazine	Table Structure	Power	Dust Extration Info.
<b>W4 Series Heavy-duty nesting machine with Pre-Labeling</b>												
1224	2500x1260x200mm	2440x1220x50mm	10500x3200mm	3700kg	80m/min	20-25m/min	15m/min	9kW 24000r/min	Carousel 8	Vacuum Table	30kW	Φ200*1 Φ150*1
1230	3140x1260x200mm	3050x1220x50mm	12600x3200mm	5500kg								
1530	3140x1600x200mm	3074x1550x50mm	11200x3500mm	6500kg								
1537	3700x1600x200mm	3685x1550x50mm	14400x3500mm	6800kg								
2128	2900x2160x200mm	2850x2130x50mm	11700x4100mm	6000kg								
2138	3860x2170x200mm	3800x2130x50mm	14000x4100mm	7100kg							35kW	
<b>WK-G Series standard nesting machine with Pre-Labeling</b>												
1228	2900x1260x300mm	2850x1220x50mm	12450x2700mm	4500kg	100m/min	18-23m/min	15m/min	9kW 18000r/min	Carousel 8	Vacuum Table	30kW	Φ200*1 Φ150*1
<b>WK-C Series Linear tool-changing nesting machine (Pre-Labeling)</b>												
1228	2900x1260x300mm	2850x1220x50mm	12000x2700mm	4000kg	80m/min	15-20m/min	15m/min	9kW 18000r/min	Linear 12	Vacuum Table	27kW	Φ200*1 Φ150*1
<b>WK-C Series Linear tool-changing nesting machine (Auto Loading and Unloading)</b>												
1228	2900x1260x300mm	2850x1220x50mm	10000x2700mm	3000kg	80m/min	15-20m/min	15m/min	9kW 18000r/min	Linear 12	Vacuum Table	25kW	Φ200*1 Φ150*1
<b>WK-C Series Linear tool-changing nesting machine</b>												
1224	2500x1260x300mm	2440x1220x50mm	3600x2300mm	1300kg	80m/min	15-20m/min	N/A	9kW 18000r/min	Linear 12	Vacuum Table	22kW	Φ200*1
1228	2900x1260x300mm	2850x1220x50mm	4200x2300mm	1800kg								
1530	3140x1600x300mm	3100x1560x50mm	4500x2750mm	2100kg								
2128	2900x2160x300mm	2850x2130x50mm	4200x3250mm	2300kg							27kW	

For specific machine configurations, please refer to your technical agreement

# Edgebanding cell

Four Edgebanders cell-high speed, batch size 1 edge processing (>50mm)

Output	Footprint	Operator
4500-6500 pcs / 8 hours	36x12.5m	2

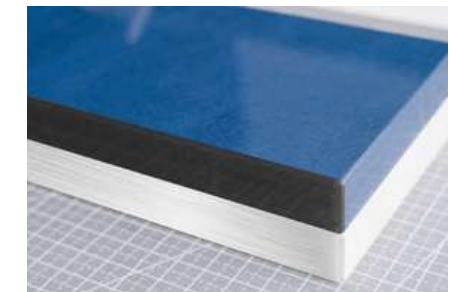
<b>Intelligent and extensible</b>	Flexible change-over of different edges
<b>Partner Patent</b>	Automatic production of small parts >50-250mm in with
<b>Automatic production</b>	Multi shift production
<b>Reduced labor cost</b>	Require less operators than manual processing



## Fast and flexible

High speed infeed,  
stable changeover

Changeover between glue tanks, different edges, corner round types and buffing unit. Batch size 1 solution without compromising output.



**1.4 Million**

Stable performance even with 1.4 million times of changeover every year

● **Minimized gap between workpiece**



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High-speed Flexible Edgebanding Cell

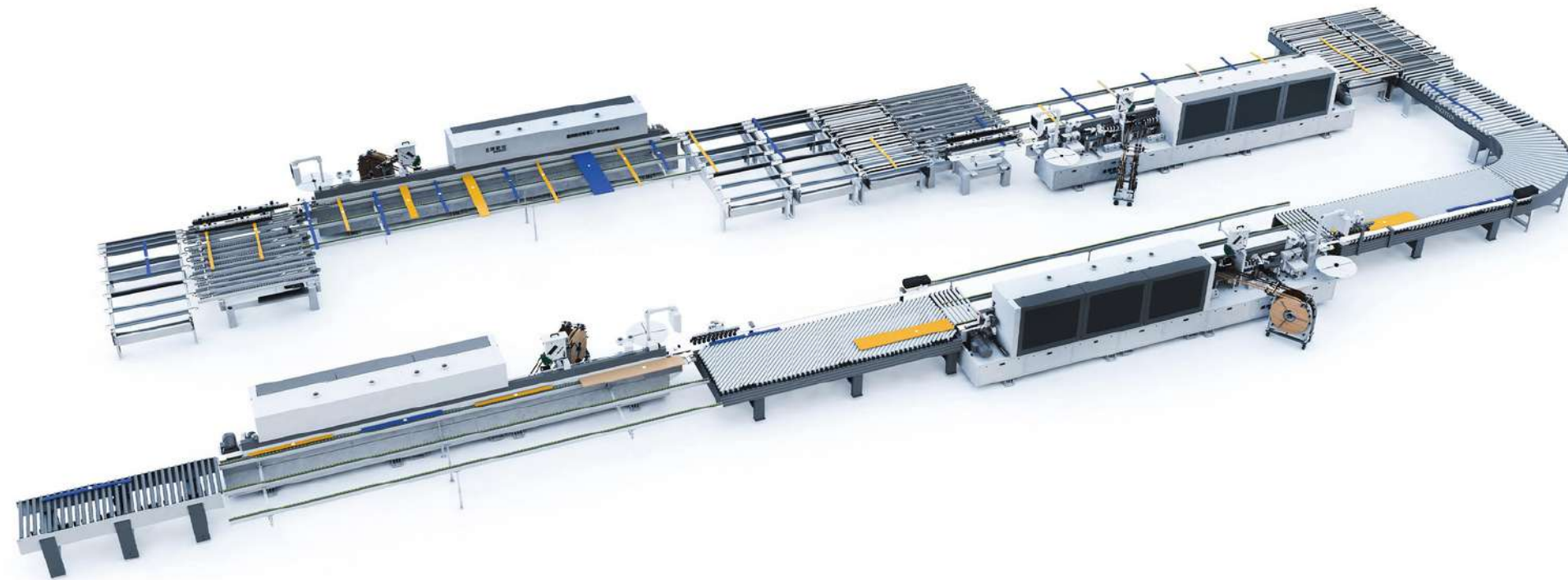
# Edgebanding cell

Four Edgebanders cell-for **Narrow components processing (>50mm)**

**Output**  
3500-4000 pcs / 8 hours

**Footprint**  
27.5x12.5m

**Operator**  
2



High quality solution to overcome the biggest challenges in automation



We supply integrated solutions including softwares

Produce  
with  
intelligence

- Interactive and intuitive operation
- Cell control and machine monitoring (display of production data, machine occupation, errors message, troubleshooting, etc, and solutions)
- Batch size 1 and order-oriented (automatic component identification via barcode)
- Tailored to fit your solution

# Edgebanding cell

Four Edgebanders cell-for interlinked Edgebanders  
(for components >250mm)

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<b>Output</b> 4500-6500 pcs / 8 hours	<b>Footprint</b> 38x12.5m	<b>Operator</b> 2
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# Edgebanding cell

Two single-sided Edgebanders in a cell

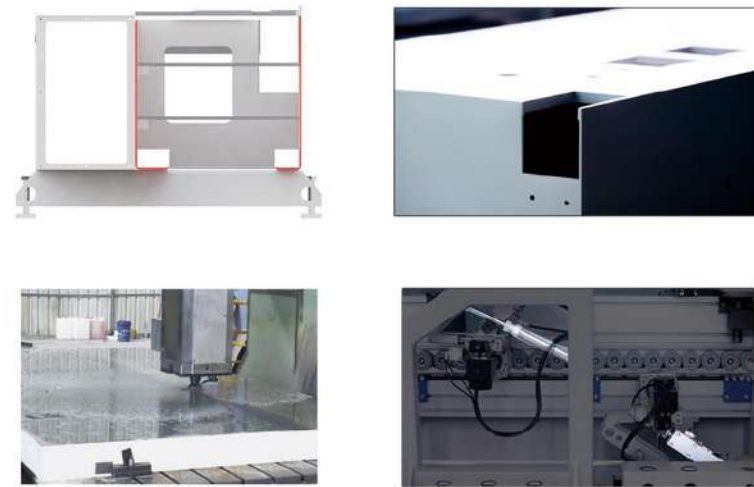
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<b>Output</b> 3000 pcs / 8 hours	<b>Footprint</b> 43x7.5m	<b>Operator</b> 1
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# Longer service life, greater ROI

- **Design** Structurally strengthened frame guarantes stability over long service life
- **Procedures** The unibody welded frame is annealed, heat-treated and machined
- **Stability** Aero-aluminum and god quality steel -- only the best raw materials for the best performance
- **Accuracy** CNC machined frame
- **Control** Upgraded encoder control of snipping and corner round unit increases work efficiency and effect.



# Independently developed units

- **Stationary snipping unit**
- **Servo corner trimming**
- **Servo edge feeding**
- **Dust free Pre-milling**



# Laser Edgebanding technology

# High-speed Edgebanding



WF687P – laser

WF683GI

High speed flexible edge processing technology with laser unit | Special designed end cutting unit

Double top glue pots + Quick melt | Corner rounding with 4 motors | High speed V-belt top pressure sliding chain

Spray separate agent > Pre Milling > Pre Heating > Top Hotmelt > Top melt gluing > Laser > Infeed > Pressing > End cutting > Rough Trimming > Fine Trimming > Heavy-duty corner rounding with motors > Scrapping > Flat Scraping > Spray clean agent > Buffing\*2

Spray separate agent > Pre Milling > Pre Heating > Bottom Hotmelt > Tap Magazine > Pressing > Pre Heating > Top Hotmelt > Top Melting Gluing > Tape Magazine > Pressing > End Trimming > Rough Trimming > Fine Trimming > Corner rounding with 4 motors >

Scrapping > Flat Scraping > Spray clean agent > Buffing\*2

Rectangular spot system



Adopting semiconductor fiber coupled output laser, the laser is focused to the adhesive layer of the edge banding through the rectangular spot system, beautiful and seamless, bid farewell to the glue line

Rectangular spot system



Uniform heating, no scanning blind area

Top glue station (Quick-melt) + laser



Convenient and flexible to connect with EVA or PUR glue station

Dust-free Pre Milling



Top glue pot with Quick Melt + Bottom glue pot optional



Optional  
Double top glue pots + Quick Melt

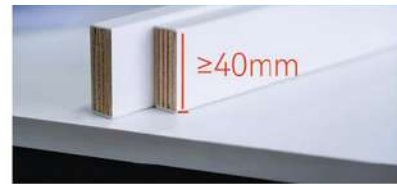


Optional  
Double fine trimming + Double scraping



# Edgebanding for both doors & carcasses

Unique Advantage



Designed to process long, narrow (>40mm) parts



## WF583GI

Top glue pot with Quick Melt + Bottom glue pot    Corner rounding

Spray separate agent > Pre Milling > Pre Heating 1 > Bottom glue pot > Tap Magazine 1 > Pressing 1 > Pre Heating 2 > Top Hotmelt > Tap Magazine 2 > Pressing 2 > End Trimming > Rough Trimming > Fine Trimming > Corner Rounding > Scraping > Flat Scraping > Spray clean agent > Buffing\*2



## WF581GI

Top glue pot with Quick Melt + Bottom glue pot    Pre Milling

Spray separate agent > Pre Milling > Pre Heating 1 > Bottom glue pot > Tap Magazine 1 > Pressing 1 > Pre Heating 2 > Top Hotmelt > Tap Magazine 2 > Pressing 2 > End Trimming > Rough Trimming > Fine Trimming > Scraping > Flat Scraping > Buffing 1 > Buffing 2

# Narrow Parts Edgebanding technologies

## WF583 Series

WF583GIMW  
WF583GIW  
WF583GW  
WF583W  
WF582W

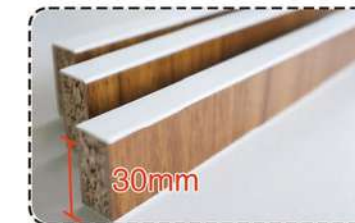


Small part infeed rollers

Small part infeed pusher

## W30

WF581W30  
WF580W30



Designed to process long, narrow (>30mm) parts



# Options



Pur adhesive melting unit available for water-proof and zero joint requirements



Easy to clean PUR glue reservoir is optional



2/4/6/12 slot servo tape magazines available for upgrade. Smooth guidance, servo driven, the edge infeed is both precise and swift



Automatic glue refill device available



Edgebander with return conveyors, greatly helps reducing down time while improving productivity



Top, bottom and side grooving available

Series	Dimension	Power	Net. Weight	Working Speed	Panel Thickness	Panel Length	Panel Width	Edge Thickness	Edge Width	Dust Extration Info.
<b>Edge Bander for Intelligent processing</b>										
783GC	11400x1900x950mm	38kW	4800kg	20-26m/min	9-60mm	250mm	100mm	0.4-3mm	13-65mm	Φ100*7
781GC	9600x1900x950mm	37kW	4200kg							Φ100*5
583GIW	8230x1600x900mm	25kW	3000kg	18-24m/min	9-60mm	≥250mm	0.4-3mm	13-65mm	≥50mm	Φ100*7
581GIW	6390x1600x900mm	17kW	2350kg						≥50mm	Φ100*5
581GIW30	6390x1600x900mm	17kW	2350kg						> 30mm	Φ100*6
<b>Laser Edgebanding technology</b>										
687P-Laser	10530x1800x970mm 835x610x249mm	27kW	3850kg	20-26m/min	9-60mm	> 150mm > 250mm	> 80mm > 100mm	0.4-3mm	13-65mm	Φ100*8
<b>WF6 Series high speed Edge Bander</b>										
683GIIM	10330x1800x970mm	29kW	3900kg	20-26m/min	9-60mm	≥150mm / ≥250mm	≥80mm / ≥60mm	0.4-3mm	13-65mm	Φ100*9
683GIM	10330x1800x970mm	28kW	3850kg							Φ100*9
683GM	10330x1800x970mm	27kW	3800kg							Φ100*9
683GII	9620x1800x980mm	29kW	3750kg							Φ100*8
683GI	9830x1800x970mm	28kW	3750kg							Φ100*8
681GII	8180x1800x970mm	28kW	3350kg	Φ100*6						
583GIM	8700x1600x900mm	25kW	3300kg	18-24m/min	9-60mm	≥120mm / ≥250mm	≥60mm / ≥40mm	0.4-3mm	13-65mm	Φ100*6
583GI	8410x1600x900mm	25kW	3150kg							Φ100*6
583GK	8410x1600x900mm	25.5kW	3150kg							Φ100*5
583G	8410x1600x900mm	25kW	3150kg							Φ100*5
581GI	6390x1800x980mm	17kW	2350kg							Φ100*5
583	6600x1600x900mm	16kW	2500kg							Φ100*5
582	5960x1600x900mm	12kW	2250kg							Φ100*3
581	5390x1600x900mm	16kW	2000kg							Φ100*4
580	4460x1600x900mm	11kW	1500kg							Φ100*2

For specific machine configurations, please refer to your technical agreement



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High-speed Drilling Cell

# Drilling Cell

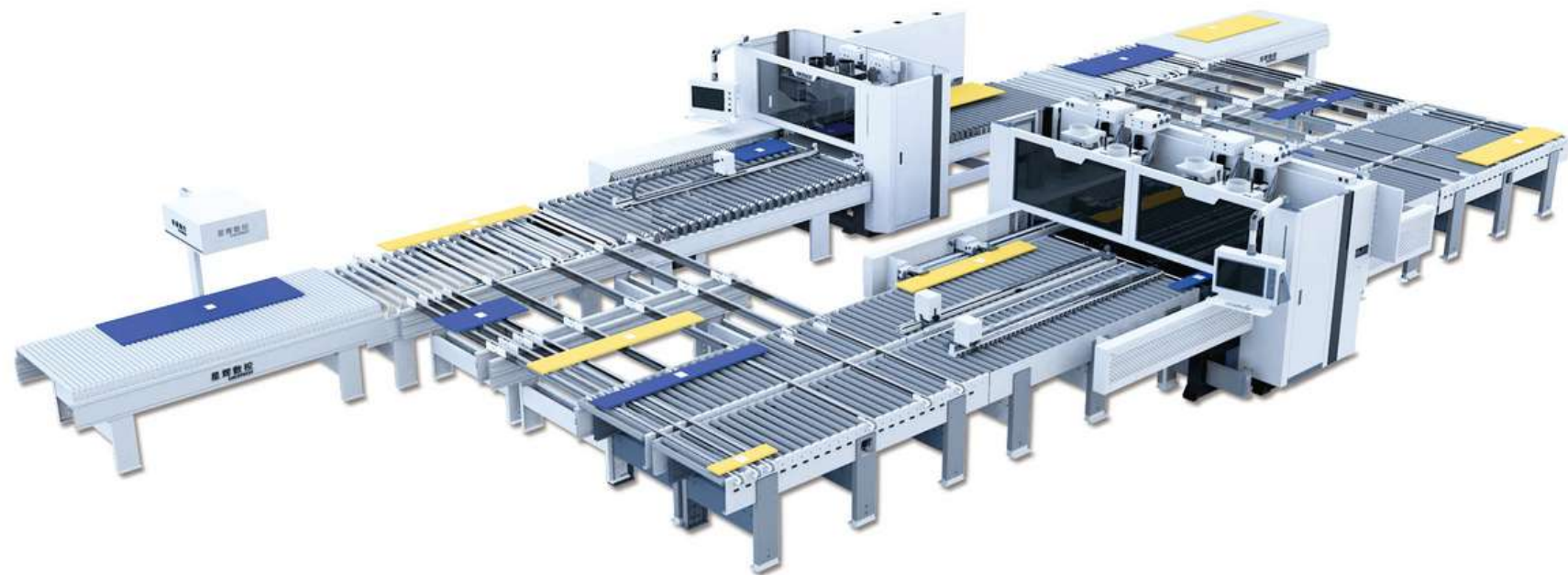
Different application scenarios

Tailored to suit your needs

---

<b>Output</b> 3400-3800 pcs / 8 hours	<b>Footprint</b> 20x7.5m	<b>Operator</b> 2
--	-----------------------------	----------------------

- |                             |   |
|-----------------------------|---|
| <b>Automatic Production</b> | Multi shift production                                    |
| <b>Reduced Labor Cost</b>   | Require less operators than manual processing             |
| <b>Eliminates Errors</b>    | Reduce processing error and panel damage                  |
| <b>Informatization</b>      | Integrated solutions, real-time production data recording |



# Drilling Cell

Different application scenarios

Tailored to suit your needs

---

<b>Output</b> 3000-4000 pcs / 8 hours	<b>Footprint</b> 20x10m	<b>Operator</b> 1
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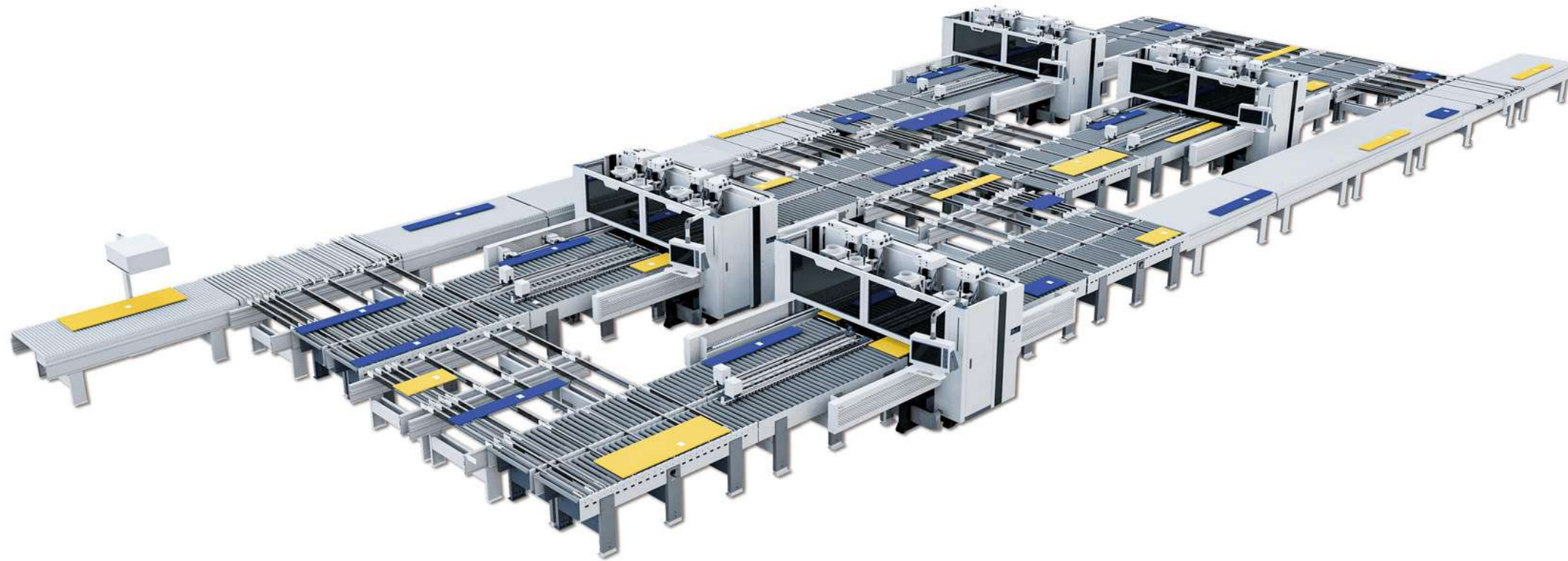


# Drilling Cell

For double work zone drilling machines in a cell

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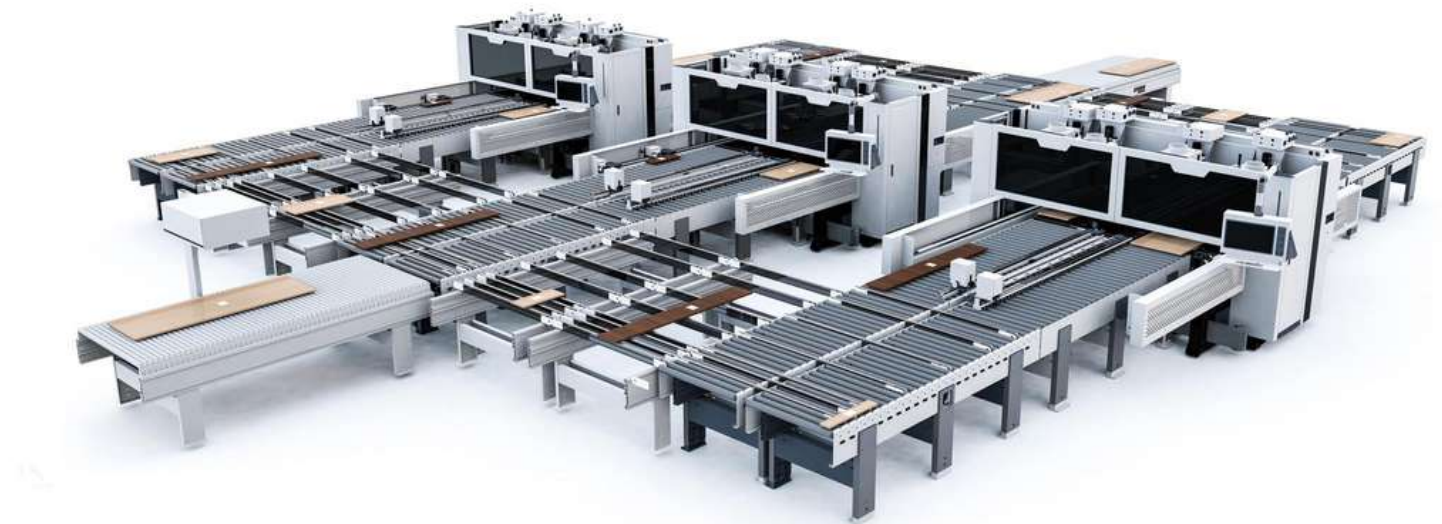
<b>Output</b> 9600-11000 pcs / 8 hours	<b>Footprint</b> 34x12m	<b>Operator</b> 2
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For double work zone drilling machines in a cell

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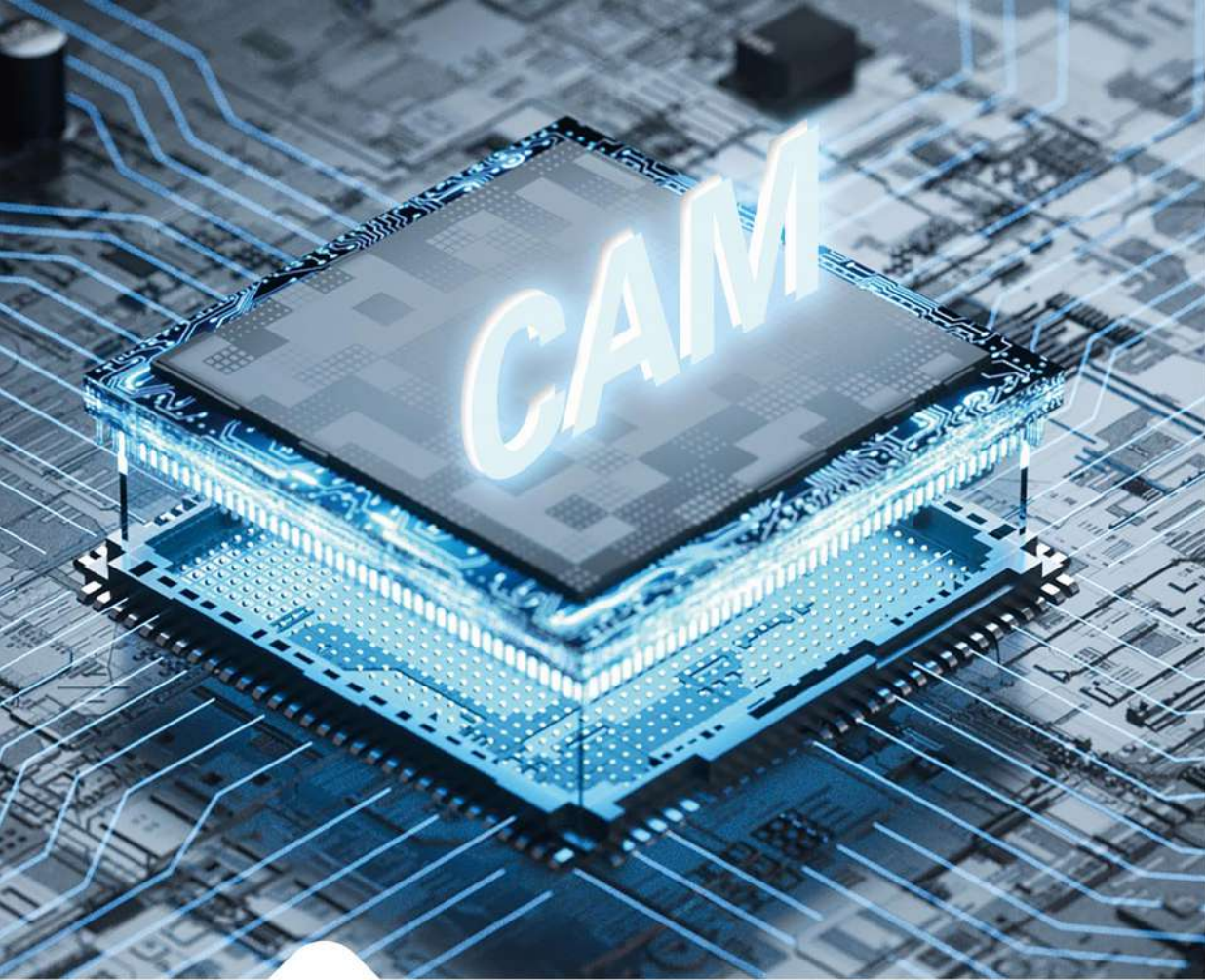
<b>Output</b> 4800-5500 pcs / 8 hours	<b>Footprint</b> 20x8.5m	<b>Operator</b> 2
--	-----------------------------	----------------------



For double work zone drilling machines in a cell

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<b>Output</b> 7200-8300 pcs / 8 hours	<b>Footprint</b> 20x13m	<b>Operator</b> 2
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# Cam Software

One-stop software integrated solutions

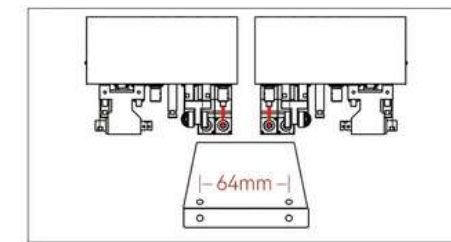
# 35%

35% Efficiency bonus compared to peer machines

## 92% +

**Double drill banks utilization 92%**

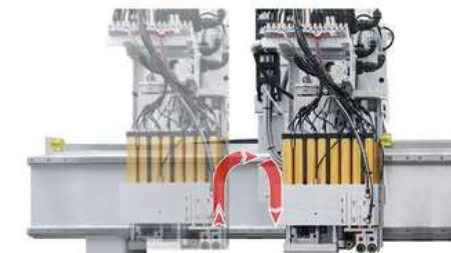
Holes with a spacing of 64mm (both vertical and horizontal directions) are processed with one stroke, featuring high utilization rate of 92% of both drill banks.



## CAM

**Independently Developed CAM Software**

Independently Developed CAM Software Exclusive



New algorithms enable drill banks and clamps to move in a "frog leap" fashion

**Robust Frame**



Unique advantage of Wotso - offcuts clamped and transported to waste bin without the risks of hitting the bottom drill bank and human intervention.

- Supports major design softwares and machines found on market
- Optimized algorithms and dodging movements
- Job editing on site is made possible
- Integratable with various MES/ERP systems

**What makes us special**

We supply integrated solutions including softwares

# Double Work Zone WHA-2T

Double work zone throughfeed 6 sided drilling machine

<b>Double work zone</b>	Processing without interrupting the work cycle, greatly enhances efficiency
<b>Six Drilling Banks (Optional)</b>	Six drilling banks, greater efficiency
<b>Smaller footprint</b>	Same output delivered, only half of the space
<b>Auto tool changer optional</b>	Versatile for all kinds of bespoke applications that may involve different connectors Lamello and more

## Unique Advantage



Parts under 650mm can be processed on two tables simultaneously



Parts above 650mm can be processed with both drill banks on one table



# Throughfeed WHS - Single drill bank WHSW - Double drill bank

Double drill bank throughfeed 6-sided drilling machine

**Synchronous strokes of the two drill banks**

**Highlights** - Holes with a spacing of 64mm (both vertical and horizontal directions) are processed with one stroke, featuring high utilization rate of 92%



**Throughfeed**

Automatic infeed without manual intervention

**Infeed in 1 sec**

Feeding time is reduced to just 1 second, Pre-loading and positioning to eliminate standstill time



# WHS-C

## All-purpose

WHS - Single drill bank  
WHSW - Double drill bank

Auto toll-changer 6-sided drilling machine

**Auto tool changer** Versatile for all kinds of beskope applications that may involve different connectores, Lamelo and more.

**All-purpose** 6 toll changers with all-purpose aggregate or rotation axis opcional



## Technical Data

Series	Traveling size	Max. Working size	Min. Working size	Dimension	Net. Weight	Traveling Speed	Drill bank info.	Spindle info.	Power	Dust Extration Info.
1228	5300x2630x150mm	2800x1200x50mm	200x50x15mm	7300x3700mm	8000kg	130/80/30m/min	Vertical 66+Horizontal 32	3.5kW*4	34kW	Φ200*4 Φ150*2
1228	5300x1750x150mm	2800x1200x50mm	200x50x16mm	7300x2800mm	4500kg	130/80/30m/min	Vertical 33+Horizontal 16	3.5kW*2	22kW	Φ200*2 Φ150*1
1228	5300x1750x150mm	2800x1200x50mm	200x50x16mm	7300x2600mm	4200kg	130/80/30m/min	Vertical 21+Horizontal 8	3.5kW*2	16kW	Φ200*1 Φ150*1
1228	5300x2630x150mm	2800x1200x50mm	70x30x15mm	5900x3700mm	5000kg	130/80/30m/min	Vertical 42+Horizontal 16	3.5kW*4	26kW	Φ200*2 Φ150*2
1228	5300x1750x150mm	2800x1200x50mm	70x30x10mm	5900x3300mm	3300kg	130/80/30m/min	Vertical 21+Horizontal 8	6 kW*2 2.2kW*2	26kW	Φ200*2 Φ150*1
1228	5300x1750x150mm	2800x1200x50mm	70x30x10mm	5900x2800mm	3100kg	130/80/30m/min	Vertical 33+Horizontal 16	6 kW*1 3.5kW*1	26kW	Φ200*2 Φ150*1
1228	5300x1750x150mm	2800x1200x50mm	70x30x15mm	5900x2800mm	3100kg	130/80/30m/min	Vertical 33+Horizontal 16	3.5kW*2	18kW	Φ200*2 Φ150*1
1228	5300x1750x150mm	2800x1200x50mm	70x30x15mm	5900x2600mm	3000kg	130/80/30m/min	Vertical 21+Horizontal 8	3.5kW*2	14kW	Φ200*1 Φ150*1

For Specific machine configurations, please refer to your technical agreement

# Interlinked Edgebanding-Drilling line

For Batch size 1 Production

Robot with vision cameras

Manual

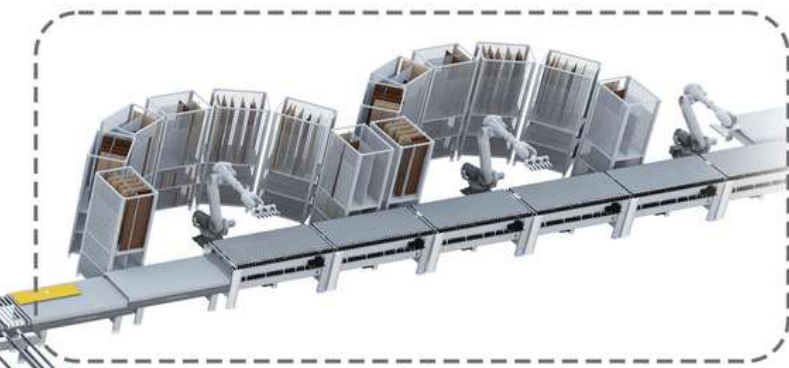
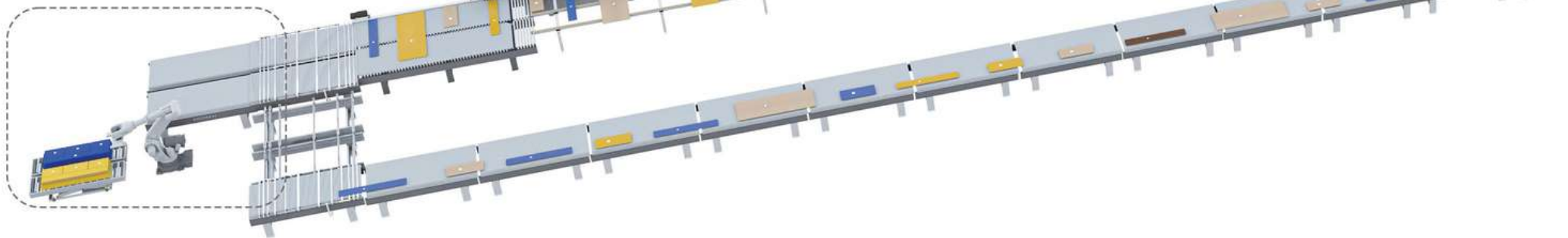


For series production

Gantry Loading and Destacking



Different Loading devices available



For series production



Sorting Unit+Manual Unloading



Vertical sorting unit+robot

# 4.0

## Production Planning

Grow and prosper with our tailor-made production solutions.  
One stop service from project planning to fully automated production lines.  
Count on our expertise and experience!



# WOTSO

**Wood tech Solutions**

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Vila Cova de Carros | Paredes

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