



precision machinery  
for wood refining



www.ayen.com

"Patching" - Ayen expertise since 1965



- Automatic plugging machines
- Plug-producing machines
- Boom machines
- Knothole drilling machines

## Machines for Wood refining

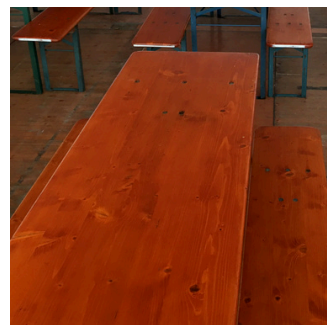
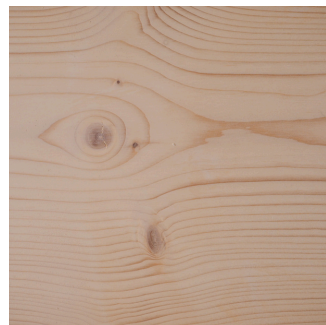
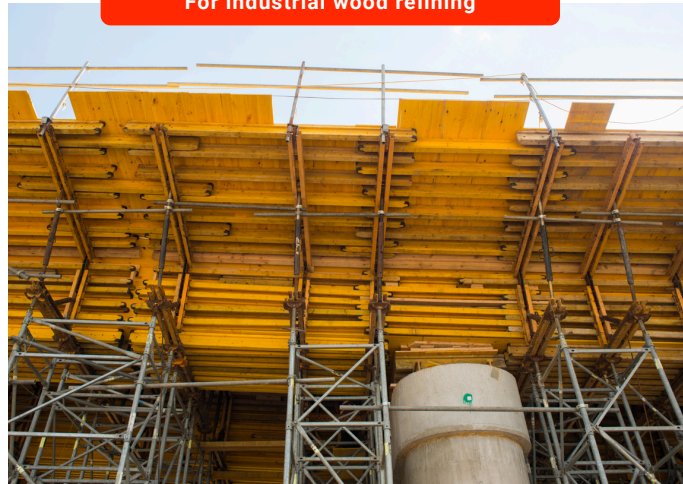
Improve your product quality by patching damaged areas: knots, pitch pockets and other wood defects in boards, beams, solid wood panels, multilayer boards, shuttering panels, etc. can be replaced with normal plugs, natural knot plugs or pitch pocket plugs.

Your costs are reduced by no longer cutting off defective areas in your workpiece, but instead refining them with the help of our automatic plugging machines. This saves resources by reducing waste and gives your workpiece quality, stability, durability and, last but not least, a better appearance.

Decide for yourself whether you want to patch the knots with real knot plugs, normal plugs and/or the pitch pocket with pitch pocket plugs.

With our plug-producing machines, you can produce your own wood plugs to match the workpiece and in highest quality.

For industrial wood refining



## Automatic Plugging machines

Automatic plugging of wood defects with normal plugs (produced from battens within every cycle), real knot plugs or pitch pocket plugs. Choose the right automatic plugging machine based on your requirements and quality standards.



AL310-LZE

## Overview Automatic plugging machines

Type	normal plug	real knot plug	pitch pocket plug
AL310	✓		
AL310L-A	✓	✓	
AL310A-HGF		✓	✓
HGF310			✓
AL100	✓		
AL200	✓✓		
AL100-ASE-HGF	✓	✓	✓

- Short cycle time  
1.8 | 2.2 | 3.5 s; depending on plug type
- Available plug diameters  
15 | 20 | 25 | 30 | 35 mm
- Pitch pocket plugs size G2
- Circumfrancial gluing



AL310A-HGF

## Plug-producing Machines

Our machines for the fully automatic production of normal plugs from batten or pitch pocket plugs produce either up to 2,000 pitch pocket plugs G2 or up to 1,600 normal plugs per hour from your selected wood species.

## Pitch pocket plug producing machine HFA4

- Fully automatic production of pitch pocket plugs  
G1, G2, G3 standard
- Pitch pocket plugs per hour and filling of the stacking magazine  
approx. 2,000 pieces
- Stacking magazine  
for 13 workpieces (for G2 production)
- Special types possible  
G20, G22



## Normal round plug producing machine QZF

- Fully automatic production of normal round plugs  
normal plugs without chamfer
- Available plug diameters  
15 | 20 | 25 | 30 | 35 mm
- Normal plugs per hour  
approx. 1,600 pieces
- Stacking magazine  
for 65 battens (9 mm thick), sufficient for approx. 2.5 h automatic machine running time
- Special types
  - plug diameter
  - plug thickness
- Special version processing type
  - normal plugs with chamfer
  - processed individually or in stacks







## Ayen Boom machines

Ayen boom machines are designed for woodworking in the craft business. They are characterized by the robust and durable construction typical of Ayen and can be used universally depending on the type. The boom machines with hand lever can not only be equipped with a space-saving and moveable machine base, but can also be wall-mounted in any workshop.

The ABMH66 boom machine is THE universal machine for your interior work business, and its durability will probably also play a key role in your purchasing choice. Buy once - use for generations.

## Multi-purpose boom machine ABMH66

### Standard Equipment

- **4-fold drill spindle head** swiveling, for drilling with different diameters and for the production of normal plugs with plug cutters
- **Hand lever operation** or pneumatic stroke
- **Tool holder thread M10**
- **70 mm drilling stroke**
- **660 mm throat depth**
- **120 mm height adjustment** manually by hand wheel

### Optional Accessories

- **Pitch pocket milling head** for G1, G2 or G3 pitch pocket plugs
- **Drill chuck head**
- **Line drilling head** with or without grid device
- **Window fitting drilling head**
- **Drill chuck shaft M10-B16** with spocket chuck 1-13 mm or 3-16 mm
- **Machine base** or wall mounting
- **Working table** with or without fence system
- **Casters for machine base**
- **Swivel joints** type ABMH66-DG with throat depth 1,050 mm



## Specialist boom machine ABMH66-B

- **For drilling out knotholes** and other drilling tasks
- **Hand lever operation** or pneumatic stroke
- **Drill chuck** for drill bits with cylindrical shaft
- **70 mm drilling stroke**
- **660 mm throat depth**
- **120 mm height adjustment** manually by hand wheel
- **Machine base** or wall mounting

### Available Types

- **With rotational speed 1,400 rpm**
- **With rotational speed 2,800 rpm**
- **With frequency converter** infinitely adjustable from 1,200 rpm to 2,800 rpm



## Specialist boom machine ABMH66-F

- **For milling out pitch pockets** on flat workpieces
- **Hand lever operation** or pneumatic stroke
- **720 mm throat depth**
- **120 mm height adjustment** manually by hand wheel
- **Machine base** or wall mounting

## Specialist boom machine ABMP66-L

- **For milling out pitch pockets** in profiled workpieces
- **With pneumatic stroke**
- **720 mm throat depth**
- **120 mm height adjustment** manually by hand wheel
- **Machine base** as standard



Masterpieces start  
with precision

[www.ayen.com](http://www.ayen.com)

**Ayen**

## Contact us

- ☎ +49 7473 9493 0
- 📠 +49 7473 9493 60
- ✉ [info@ayen.com](mailto:info@ayen.com)
- 🌐 [www.ayen.com](http://www.ayen.com)

## Where to find us

Karl Ayen Maschinenfabrik GmbH  
Heerweg 19  
72116 Moessingen  
Germany

