



 **RILESA**

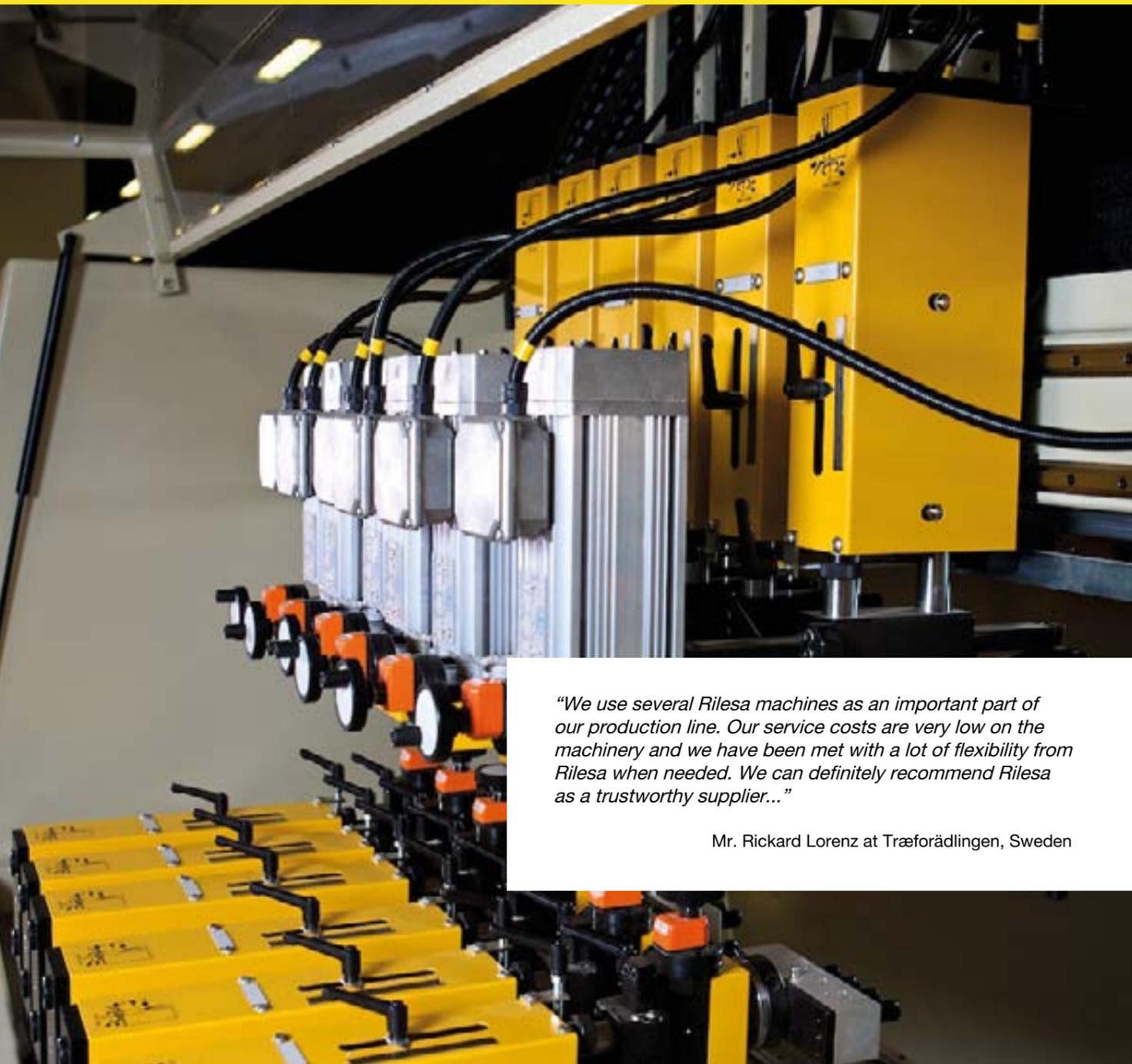
Company introduction  
and product overview





# Welcome to Rilesa

Supplier of high quality cutting-, drilling- and milling machinery to the woodworking industry.



*"We use several Rilesa machines as an important part of our production line. Our service costs are very low on the machinery and we have been met with a lot of flexibility from Rilesa when needed. We can definitely recommend Rilesa as a trustworthy supplier..."*

Mr. Rickard Lorenz at Træförädlingen, Sweden

Welcome to Rilesa. We supply high quality drilling- and milling machinery to the woodworking industry. From our factory in Denmark, we design, develop and manufacture standard and custom designed woodworking machinery, for companies all over the world. With nearly 30 years of experience in the woodworking industry, Rilesa is a major developer of drilling- and milling machinery with special focus on furniture and window production. Combining the knowhow and manpower to take on both small- and large scale projects, Rilesa is the preferred partner for numerous woodworking companies.

For many years, Rilesa has designed, developed, manufactured and installed woodworking machinery for customers worldwide. From the factory in Ribe, the oldest town in Denmark, we manage the entire process of planning and building our products from scratch, using the latest technology and highly skilled employees secure our position as one of the market leaders.

### Our products

Our product range includes a selection of standard machinery, from the X-line and Pro-line cutting-, drilling- and milling series to the small Vlg 1524 series. As well as our standard product series, Rilesa also design and produce a large number of tailor made machinery, developed for customers with special needs. Through close cooperation with our clients, our staffs of engineers take on special projects all the way from the initial workflow analysis to the final instalment of the machinery and service. Along with producing our range of standard and custom build machines, we also sell pre-owned Rilesa products. 15 years old machines from Rilesa work like new ones. A machine from Rilesa is built to last.

### Our philosophy

At Rilesa we strongly believe in producing products of the highest quality, with focus on safety, longevity and ease of use. We strive to deliver the best possible machinery on time and on budget, and to develop the ideal solution for every requirement. We pride ourselves in being big enough to take on large scale projects, but small enough to act fast and to know our clients special needs. That's why we call us "Experts in woodworking machinery".

We run a healthy and stable business with focus on long term relationships with our customers in the industry. This ensures that Rilesa is a stable partner for many years to come. We are looking forward to working with you.



Søren Andersen



## Product overview

### Rapid 1500 & Rapid 2200

A new benchmark in price / capacity for one-man-operated dowel drilling machines.

Rapid 1500 / 2200 can be equipped with drill groups from both ends and from the top. There are two models, one with maximum length of 1500 mm and one for 2200 mm. The drill groups are placed close to the workpiece and optimized mounted to allow easy throughput when drilling from the sides.



The Rapid machines have a special throughput system where the components are moving in a half circle and returning to the operator on a return conveyor. The Rapid machines are well suited for automation and linking with other machines.

### Modul II

Modul II is extending our Rapid 1500/2200 drilling machines.

Modul II can drill in the front- and back sides of the workpieces and makes it possible to drill in 5 sides in one process.

The Rapid 1500 / 2200 is equipped with a buffermagasine, that leads the workpieces with a belt in the Modul II. Here, the workpieces are positioned from 4 sides, drilled and transported back to the operator on a belt conveyor.



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#### Features

- Drilling from 3 sides
- Linked to Modul II: Drilling from 5 sides
- Optional: Side displacement of drilling units

- Materials: Solid wood, MDF, chipboard and plywood
- Components: f.x. drawer sides and fronts

#### Technical data

Workpieces:  
 Height: 10 - 40mm  
 Width: 20 - 250mm  
 Length: 160 - 1500mm (Rapid 1500)  
 Length: 160 - 2200mm (Rapid 2200)

### UNI-X 2200

Our flexible dowel drilling machine with a large range of different special equipment.

The UNI-X 2200 is specially designed for solid wood and has a unique system of clamping cylinders designed to adjust and hold the components. The UNI-X 2200 is also excellent for components in MDF, chip board, plywood and even aluminium. The resetting of the machine is easy and the flexible clamp units, together with the slim design of the drill groups, make it possible to drill almost all components in one pass. As with most Rileisa machinery, the UNI-X 2200 is well suited for automation and linking with other machines.



It is possible to reset the machine in minutes, all data regarding drill heads, tools, position in x, y and z direction etc. are stored in the control unit. A digital measuring system combined with a lightsignal guides the operator to position the drill groups in the x-direction. During production the machine continuously controls the position in x-direction to reduce faults.

#### Features

- Drilling from 4 sides
- Optional: Longhole milling  
 Drilling of round components  
 Side displacement of drilling units

- Materials: Solid wood, MDF, chipboard, plywood
- Components: Frame components, bed sides, drawer sides and fronts etc.

#### Technical data

Workpieces:  
 Height: 10 - 85mm  
 Width: 20 - 250mm  
 Length: 250 - 2200mm

### Pro-Line

Our most universal type of machine, designed for highly sensitive components.

The Pro-line dowel drilling machine is equipped with an advanced control system with a lot of options. It is easy to reset the machine and all the necessary information regarding the components are available on the display. The resetting of the machine is easy and the flexible clamp units, combined with the slim design of the drill groups, makes it possible to drill almost all components in just one pass. The Pro-line dowel drilling machine is designed with different loading system options.



The basic version is designed with a special in- and outlet for the components as they are placed side by side. The components pass through the machine very gently and are handled without any scratches. Resetting the drill groups is done easily and precisely with the magnetic positioning system. When the Pro-line is being fed from other machinery, the pieces are being transported on a conveyor system and transferred crossways into the drilling machine.

#### Features

- Drilling from 6 sides in one step
- Optional: 45° drilling  
 Longhole milling  
 CNC milling and drilling  
 Doweling  
 Side displacement of drilling units

- Materials: Solid wood, MDF, chipboard, plywood.
- Components: Frame components, bed sides, drawer sides and fronts etc.

#### Technical data

Workpieces:  
 Height: 10 - 80mm  
 Width: 20 - 350mm  
 Length: 250 - 2200mm

# VLGD 1524 & VLGD 2224

One-man-operated dowel drilling machines.

The VLGD machines have a special throughput system where the components are moving in a half circle, before returning to the operator on the return conveyor. The machine is controlled from the display placed on the front of the machine. Drilling, glue applying and doweling is done in 2 steps. The glue pump continuously circulates the glue and the daily cleaning is reduced to just a few minutes. You also have the option of an electronic setup system that provides a quick setup and precise settings. The two large dowel separators are placed on top in the frontside of the machine, in order to have the dowel flow as direct as possible.



The VLGD can be equipped with drilling units from the top, both ends and from the backside. The width of the units is only 95mm. The VLGD machine can be ordered for a maximum length of 1500 mm or 2200 mm.

## Features

## Technical data

- Drilling from 2-3 sides
- Doweling from 2 sides
- Materials: Solid wood, MDF, chipboard and plywood

- Components: Drawer sides and fronts, cabinets, small and narrow pieces.

Workpieces:  
 Height: 10 - 40mm  
 Width: 20 - 190mm  
 Length: 170 - 2200mm

# X-Line

Cutting-, drilling- and milling machine, developed to be flexible and with short reset time.

Rilesa X-Line is our multi step machine.

Several working stations are allowing to combine different options, f.x:

1. cutting- drilling - milling - doweling - inserting of mountings
2. cutting- milling - milling
3. cutting - CNC-milling - drilling



The workpieces are stopped and exactly positioned in every step. After processing, the chain conveyor leads them to the next station.

X-Line is often linked with other machines in larger lines.

The X-line is equipped with an advanced control system with numerous possibilities. It is easy to operate the machine and all the necessary information is shown with clear symbols on the display.

There are several possibilities of extensions for the machine f.x: Workpiece magazine at the infeed side, Transport conveyors at infeed and outfeed and integration of other machines (Moulder, Rilesa X-Line, Rilesa Proline, Rilesa cross-cutting saw etc.)

## Features

## Technical data

- Cross-cutting
- Drilling in all sides
- Profile milling and sanding
- Doweling
- Inserting of mountings

- Materials: Solid wood, MDF, chipboard, plywood

Workpieces:  
 Height: 10 - 85mm  
 Width: 20 - 200mm (400 mm)  
 Length: 200 - 2200mm  
 or according to customer specifications





*"I don't know the capacity of drilling machines, connected to the routing line, but we produce more than 300 door-frame pieces per hour and it is more than enough for us. The Rilesa machines are reliable, uptimes average more than 98% and changeover is about 10 min."*

Mr. Priit Koha at Jeld-Wen, Estonia

## Samples



Fingerjoints, rounded corners and milled recesses in frames of solid wood for box-matresses.



Profile- and contraprofile milling in door frames.



Holes for dowels and milled slots in round workpieces.



Frames: 45° angle cutting to length, drilling and dowel inserting.



Glas beads for doors and windows: 45° angle cutting to length and drilling.



Frames of solid wood, MDF and chipboard: 45° angle milling to length and milled dovetail joints



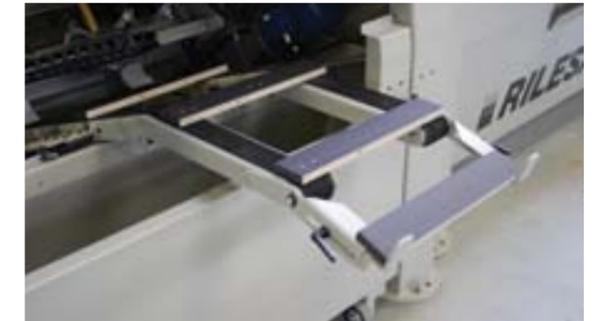
Workpieces of profile wrapped MDF



Cut to length and drilled



Inside the Rapid drilling machine, the workpieces are transported further to the Modul II



After processing, the parts are transported back to the operator on a conveyor belt



Pallet frames with finger joints, milled handle-holes and insert-nuts, processed in one operation, ready for corner mountings



Cross-cutting unit for exact cutting to length, four drilling units, and the milling unit for the fingerjoints



The fingerjoints in the corners are milled in one step



In the last step, four milling units are processing the handle holes in the frame sides from the top and from below



## Why choose Rileisa?

### **Durable products**

Products from Rileisa are produced with longevity in mind and are widely regarded as some of the most durable on the market. Made with proven technology and tested thoroughly before production, over 90% of all Rileisa machinery ever made is still running today. The result is less production downtime, less service time and better economy for our customers.

### **Caring about the details**

We know that even small details can have a major impact on production workflow. That is why we spend a lot of time making sure that everything is checked and tested before production and that the machines are as easy to use as possible. It also means that the software operation system is easily understood and that the machine settings can be quickly changed - even by unskilled workers.

### **Big enough to serve you - small enough to know you**

Rileisa has the production capacity to take on large scale projects but is still small enough to know our clients special needs and putting that extra care and pride in our products. With the manpower to both designs, develop and manufacture our woodworking machinery in-house we are the ideal size to act quickly on new ideas and technology.

### **After sales service**

Our machines usually play an important role as a part of a production line and questions, problems and glitches need to be dealt with quickly and effectively. At Rileisa we have a dedicated service team that know our machinery inside out, and make sure that your Rileisa products perform year after year.

### **A stable partner**

For nearly 30 years, Rileisa has produced woodworking machinery to customers all over the world. We run a healthy and stable business with focus on long term relationships with our customers in the industry. This ensures that Rileisa is a stable partner for many years to come.

*“At Swedwood we have been especially pleased with the precision and longevity of the Rileisa products, combined with flexibility and the quick change of machine settings. We have been very satisfied service provided by Rileisa - both in and outside regular business hours...”*

Mr. Torben Urth  
at Swedwood Tikhvin

*“We need a partner that understands the industry and the special needs we have as a customer. Not only is Rileisa’s machinery top of the line, they also deliver a very fast service when we need drill heads, software updates or hardware service. And since our Rileisa machinery is placed in a critical area of our production, a quick service is very valuable for us...”*

Mr. Adam Golinski  
at Swedwood, Polen



**RILESA** Experts in woodworking machinery