

Woodlandia RLM Machines

Functional & Technical overview of
Woodlandia'
RLM line of products

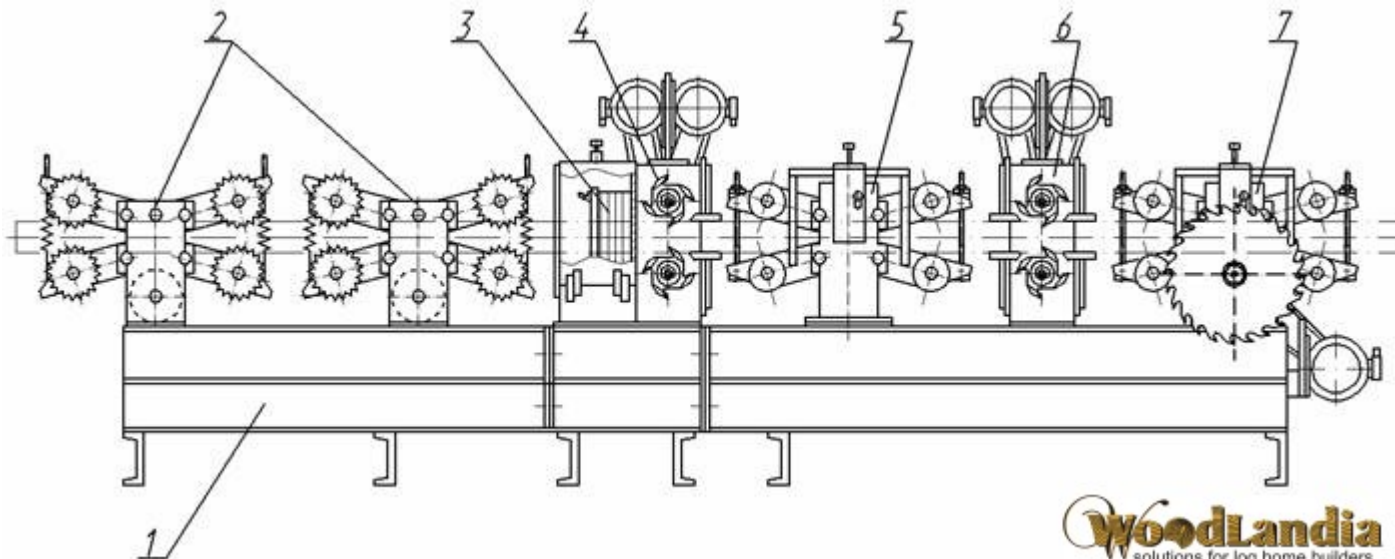
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What is RLM[®] technology?

- RLM stands for Rotary Log Mill
- RLM machines are log milling through-put machines
- High performance one path log processing principal
- Milling head is stationary
- Log automatically fed into the milling head
- Milling head has number of knives which spin around of moving log
- Milled log can be processed to required profile in the same path
- RLM is patented technology
- RLM has been developed and used since 1990

Typical RLM machine consists of:

1. Base frame
2. Log orientation & feeding device
3. Milling Head
4. Log feeding & alignment device
5. Log out-feeding device
6. Milling & cutting unit
7. Additional milling & cutting unit



Woodlandia RLM Product Family

Woodlandia RLM machine family

RLM Machines for processing
of small diameter logs
into dowels for posts, railings,
etc.

RLM-100	RLM-160	RLM-160S
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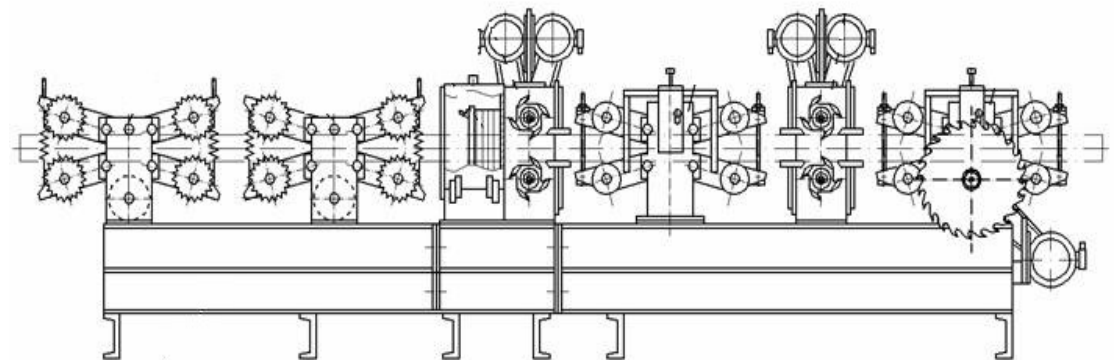
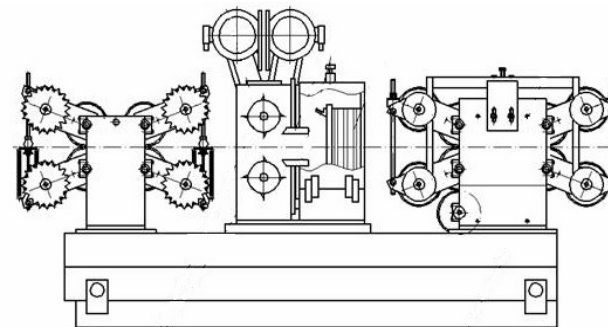
RLM Machines for log home
builders

RLM-240	RLM-280	RLM-320 & 320MF
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Differences between RLM machines

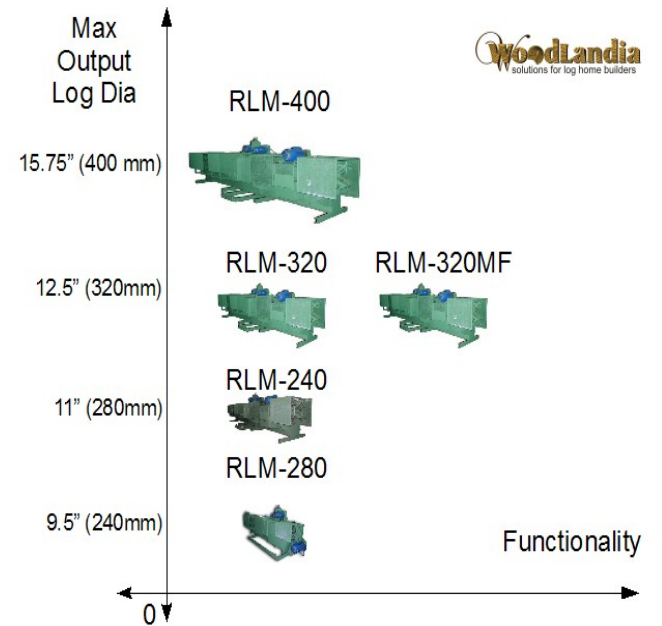
- Purpose
 - Log home building industry
 - Lumber & saw mills
- Input log diameter range
- Output log diameter range
- Number of functionalities
 - Cylindrically shaped (full round) dowel
 - “Swedish cope” – style log profiles
 - Tongue&groove – style log profiles
 - “Bevel edge”-style log profiles
 - Round and flat (D-style) profile
 - Squarish & rectangular log profiles
 - Siding
 - Lumber



Overview of Woodlandia RLM machines for log home builders

Model line:

- RLM-240 (economical variant for small & individual business)
- RLM-280 (bestseller)
- RLM-320 (big range output mill)
- RLM-320MF (universal multi functional mill)
- RLM-400 (for exclusive log homes, by special order only)

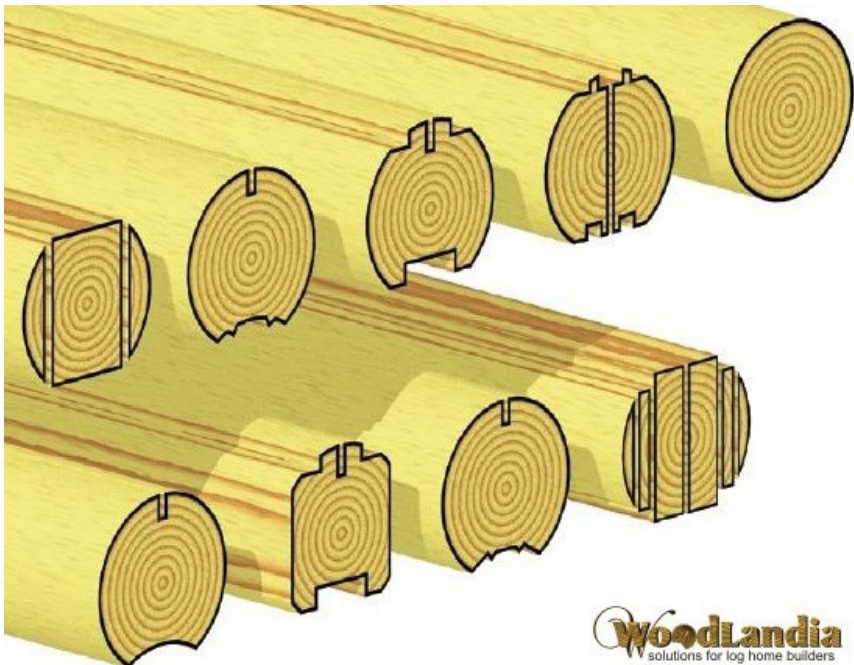


Input - Output Log ranges of RLM-240, 280, 320, 320MF, 400

Input log diameters

RLM-240:	D=5.5-12.5"	(140-320mm)
RLM-280:	D=7-14"	(180-360mm)
RLM-320:	D=7-15.75"	(180-400mm)
RLM-320MF:	D=7-17.25"	(180-440mm)
RLM-400:	D=9.5-21.5"	(240-550mm)

Some popular log profiles
(for detailed dimensions refer to
product specification sheet)



Lumber and boards



Housing logs of different profiles



Output log diameters



RLM-240:	D=4.75-9.5"	(120-240mm); H= 2.5-7.75"	(60-200mm)
RLM-280:	D=6.25-11"	(160-280mm); H= 4.75-9.5"	(120-240mm)
RLM-320:	D=6.25-9.5"	(160-320mm); H= 4.75-11"	(120-280mm)
RLM-320MF:	D=6.25-9.5"	(160-320mm); H= 4.75-11"	(120-280mm)
RLM-400:	D=8.5-15.75"	(220-400mm); H= 7.75-14"	(200-360mm)

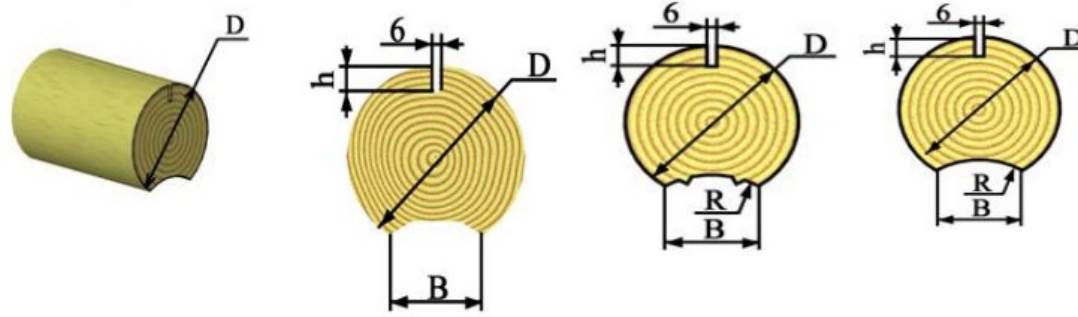
Comparison of RLM Machines Specs

		RLM-240	RLM-280	RLM-320	RLM-320MF	RLM-400
Max Input Log Diameter	mm	320	360	400	440	550
	in	12.6	14.17	15.75	17.32	21.65
Min Log length	m	2	2	2	2	2.5
	ft	6.56	6.56	6.56	6.56	8.2
Output dowel diameter range	mm	120-240	160-280	160-320	160-320	220-400
	in	4.72 – 9.45	6.3 – 11.02	6.3 – 12.6	6.3 – 12.6	8.66 – 15.75
Max sawing cut	mm	150	150	150	300	-
	in	5.91	5.91	5.91	11.81	-
Log feeding speed	m/min	2.5 – 8	2.5 – 8	2.5 – 8	1-10	1-6
	ft/min	8 – 26	8 – 26	8 – 26	3 – 32	3 – 19
Power of Milling head motor	KW	37	55	55	55	55
	HP	50.31	74.8	74.8	74.8	74.8
Power of milling unit	KW	2 x 11	2 x 11	2 x 15	2 x 11 + 2 x 15	2 x 11 + 2 x 15 + 22
	HP	2 x 15	2 x 15	2 x 20.4	2 x 15 + 2 x 20.4	2 x 15 + 2 x 20.4 + 29.9
Power of feeding system motor	KW	1.1	2 x 1.5	2 x 1.5	2 x 1.5	2 x 2.2
	HP	1.5	2 x 2	2 x 2	2 x 2	2 x 3
Length of the machine	m	4.95	7.3	7.3	7.6	10.35
	ft	16.24	23.95	23.95	24.93	33.96
Width of the machine	m	1.65	2	2	2	2.5
	ft	5.41	6.56	6.56	6.56	8.2
Height of the machine	m	1.9	2.15	2.15	2.15	1.5
	ft	6.23	7.05	7.05	7.05	4.92
Weight of the machine	kg	4000	5500	5700	6000	10000
	lb	8818.49	12125.42	12566.35	13227.74	22046.23

All RLM machines require 380V, 50Hz, 3 phase electricity

Comparison of output (1)

Swedish cope

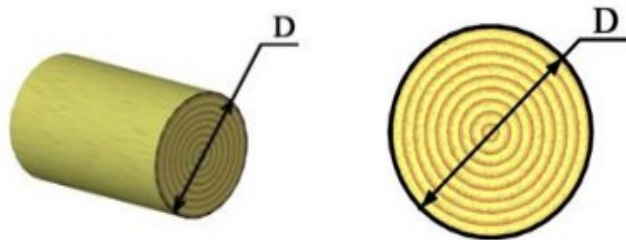


Swedish cope

				Dia, in	Dia, mm	B, mm	h, mm	R, mm
			RLM-240	-	-	-	-	-
			RLM-240	4.72	120	63	18	60
			RLM-240	5.51	140	74	21	70
	RLM-320MF	RLM-320	RLM-280	RLM-240	6.3	160	24	80
	RLM-320MF	RLM-320	RLM-280	RLM-240	7.09	180	27	90
	RLM-320MF	RLM-320	RLM-280	RLM-240	7.87	200	30	100
RLM-400	RLM-320MF	RLM-320	RLM-280	RLM-240	8.66	220	33	110
RLM-400	RLM-320MF	RLM-320	RLM-280	RLM-240	9.45	240	36	120
RLM-400	RLM-320MF	RLM-320	RLM-280	RLM-240	10.24	260	39	130
RLM-400	RLM-320MF	RLM-320	RLM-280		11.02	280	42	140
RLM-400	RLM-320MF	RLM-320			11.81	300	45	150
RLM-400	RLM-320MF	RLM-320			12.6	320	48	160
RLM-400					14.57	370	55	185
RLM-400					15.75	400	60	200

Cylindrical dowl

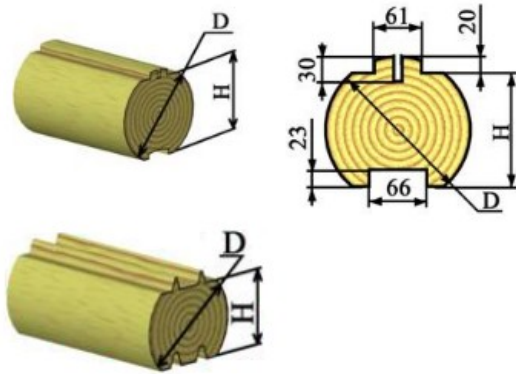
Cylindrical dowl



				Dia, in	Dia, mm
			RLM-240	3.94	100
			RLM-240	4.72	120
			RLM-240	5.51	140
	RLM-320MF	RLM-320	RLM-280	RLM-240	6.3
	RLM-320MF	RLM-320	RLM-280	RLM-240	7.09
	RLM-320MF	RLM-320	RLM-280	RLM-240	7.87
RLM-400	RLM-320MF	RLM-320	RLM-280	RLM-240	8.66
RLM-400	RLM-320MF	RLM-320	RLM-280	RLM-240	9.45
RLM-400	RLM-320MF	RLM-320	RLM-280		10.24
RLM-400	RLM-320MF	RLM-320	RLM-280		11.02
RLM-400	RLM-320MF	RLM-320			11.81
RLM-400	RLM-320MF	RLM-320			12.6
RLM-400					14.57
RLM-400					15.75

Comparison of output (2)

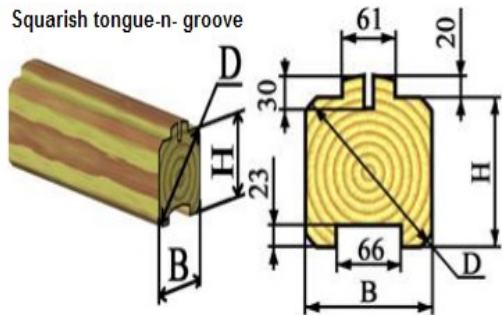
Round tongue and groove



Round tongue and groove

					Dia, in	Dia, mm	H, in	H, mm
				RLM-240	3.94	100	2.36	60
				RLM-240	4.72	120	3.15	80
				RLM-240	5.51	140	3.94	100
	RLM-320MF	RLM-320	RLM-280	RLM-240	6.3	160	4.72	120
	RLM-320MF	RLM-320	RLM-280	RLM-240	7.09	180	5.51	140
	RLM-320MF	RLM-320	RLM-280	RLM-240	7.87	200	6.3	160
RLM-400	RLM-320MF	RLM-320	RLM-280	RLM-240	8.66	220	7.09	180
RLM-400	RLM-320MF	RLM-320	RLM-280	RLM-240	9.45	240	7.87	200
RLM-400	RLM-320MF	RLM-320	RLM-280		10.24	260	8.66	220
RLM-400	RLM-320MF	RLM-320	RLM-280		11.02	280	9.45	240
RLM-400	RLM-320MF	RLM-320			11.81	300	10.24	260
RLM-400	RLM-320MF	RLM-320			12.6	320	11.02	280
RLM-400					14.57	370	12.99	330
RLM-400					15.75	400	14.17	360

Squarish tongue-n-groove



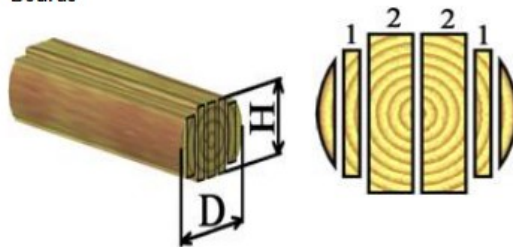
Squarish tongue-n-groove

					Dia, in	Dia, mm	H, in	H, mm	B, in	B, mm
					0	-	0	-	0	-
					0	-	0	-	0	-
				RLM-240	5.51	140	3.94	100	3.94	100
	RLM-320MF	RLM-320	RLM-280	RLM-240	6.3	160	4.72	120	4.72	120
	RLM-320MF	RLM-320	RLM-280	RLM-240	7.09	180	5.51	140	5.51	140
	RLM-320MF				7.87	200	6.3	160	6.3	160
	RLM-320MF				8.66	220	7.09	180	7.09	180
	RLM-320MF				9.45	240	7.87	200	7.87	200
	RLM-320MF				10.24	260	8.66	220	8.66	220
	RLM-320MF				11.02	280	9.45	240	8.66	220
	RLM-320MF				11.81	300	9.84	250	8.66	220
	RLM-320MF				12.6	320	9.84	250	8.66	220

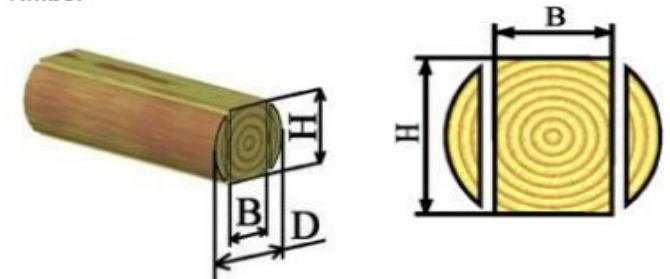
Comparison of output (3)

Boards				Dia, in	Dia, mm	Thikness1, in	Width1, in	Thikness1, mm	Width1, mm	Thikness2, in	Width2, in	Thikness2, mm	Width2, mm
				0	-	0	0	-	-	0	0	-	-
			RLM-240	4.72	120	0.59	3.15	15	80	0.98	3.94	25	100
			RLM-240	5.51	140	0.59	3.94	15	100	0.98	4.72	25	120
RLM-320MF	RLM-320	RLM-280	RLM-240	6.3	160	0.98	4.72	25	120	0.98	5.51	25	140
RLM-320MF	RLM-320	RLM-280	RLM-240	7.09	180	0.98	5.12	25	130	0.98	5.91	25	150
RLM-320MF				7.87	200	0.98	6.3	25	160	6.3	6.3	160	160
RLM-320MF				8.66	220	0.98	7.09	25	180	7.09	7.09	180	180
RLM-320MF				9.45	240	7.87	7.87	200	200	7.87	7.87	200	200
RLM-320MF				10.24	260	8.66	8.66	220	220	8.66	8.66	220	220
RLM-320MF				11.02	280	8.66	9.45	220	240	8.66	9.45	220	240
RLM-320MF				11.81	300	8.66	9.84	220	250	8.66	9.84	220	250
RLM-320MF				12.6	320	8.66	9.84	220	250	8.66	9.84	220	250

Boards



Timber

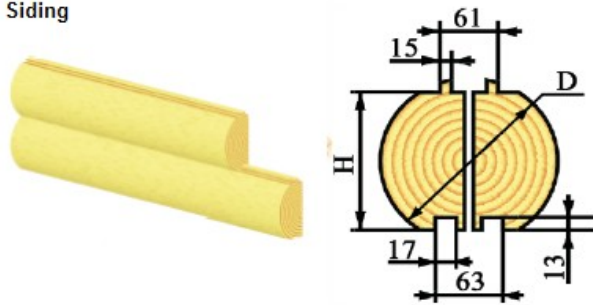


Timber

Timber				Dia, in	Dia, mm	H, in	H, mm	B, in	B, mm
				0	-	0	-	0	-
				0	-	0	-	0	-
			RLM-240	5.51	140	3.94	100	3.94	100
RLM-320MF	RLM-320	RLM-280	RLM-240	6.3	160	3.94	100	4.72	120
RLM-320MF	RLM-320	RLM-280	RLM-240	7.09	180	4.72	120	5.91	150
RLM-320MF				7.87	200	5.51	140	5.91	150
RLM-320MF				8.66	220	6.3	160	6.3	160
RLM-320MF				9.45	240	7.09	180	7.09	180
RLM-320MF				10.24	260	7.87	200	7.87	200
RLM-320MF				11.02	280	8.66	220	7.87	200
RLM-320MF				11.81	300	9.45	240	7.87	200
RLM-320MF				12.6	320	9.84	250	7.87	200

Comparison of output (4)

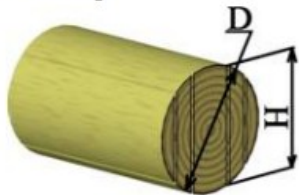
Siding



Siding

				Dia, in	Dia, mm	H, in	H, mm
			RLM-240	3.94	100	2.76	70
			RLM-240	4.72	120	3.54	90
			RLM-240	5.51	140	4.33	110
	RLM-320MF	RLM-320	RLM-280	RLM-240	6.3	160	5.12
	RLM-320MF	RLM-320	RLM-280	RLM-240	7.09	180	5.91
	RLM-320MF				7.87	200	6.3
	RLM-320MF				8.66	220	7.09
	RLM-320MF				9.45	240	7.87
	RLM-320MF				10.24	260	8.66
	RLM-320MF				11.02	280	9.45
	RLM-320MF				11.81	300	9.84
	RLM-320MF				12.6	320	9.84

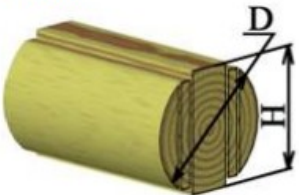
Bevel edge



Bevel edge Lumber

				Dia, in	Dia, mm	H, in	H, mm
			RLM-240	3.94	100	2.76	70
			RLM-240	4.72	120	3.54	90
			RLM-240	5.51	140	4.33	110
	RLM-320MF	RLM-320	RLM-280	RLM-240	6.3	160	5.12
	RLM-320MF	RLM-320	RLM-280	RLM-240	7.09	180	5.91
	RLM-320MF				7.87	200	7.09
	RLM-320MF				8.66	220	7.87
	RLM-320MF				9.45	240	8.66
	RLM-320MF				10.24	260	9.45
	RLM-320MF				11.02	280	10.24
	RLM-320MF				11.81	300	11.02
	RLM-320MF				12.6	320	11.81

Lumber



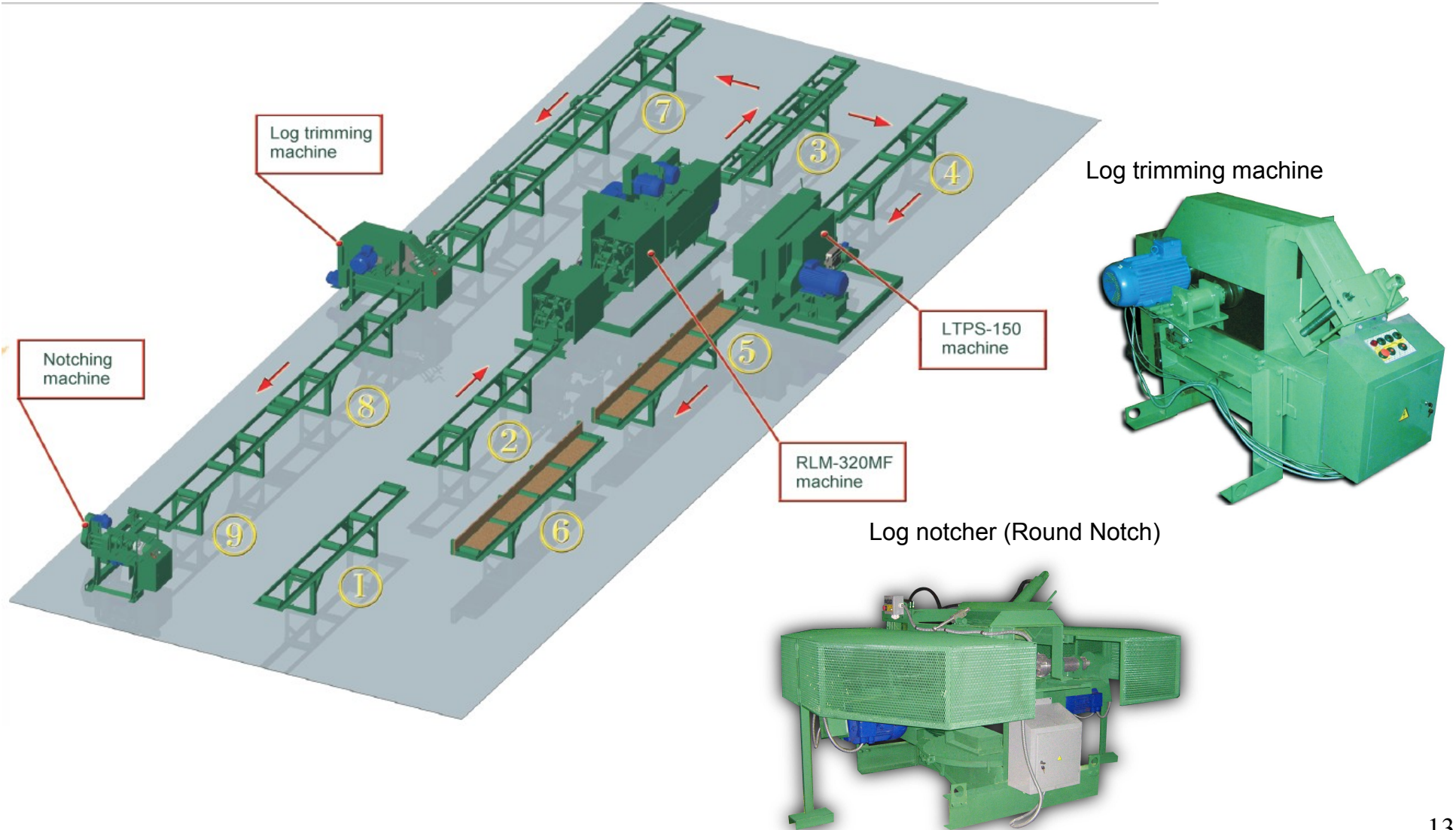
RLM Machines have best in industry cost/productivity ratio

Exceptional productivity:

- average truck load of logs per shift
- Inexpensive maintenance
- 2 man crew (1 on in-feed, 2nd on out-feed)
- Robust & reliable



Woodlandia offers not just machines but solutions for log home builders



Terms & Conditions

- Built by special orders only (no inventory)
- Up to 120 day for manufacturing and delivery
- 1 Year of limited warranty (bearings, electrical components, motors)
- Demonstrations at real manufacturing facility may be arranged
- Training is available