

Panel Saw Holzma
Type HPP 350 31/31
Used machine – year 2005
Machine number: 0-240-06-6748



OPTIMAT HPP 350/31/31

Panel Saw, Type Optimat HPP 350

Automatic panel dividing saw for tear-free and dimensionally accurate dividing of coated and uncoated panels made of wood materials and those that are to be processed like wood materials. Special materials after previous cutting tests.

1. Rear machine table

The positioning of the input material takes place via the rear machine table, equipped with high-quality roller rails.

+ Automatic, gentle material transport.

2. Program slider

The program slider positions the materials to be cut on the cutting line in a program-controlled manner using the robust collets.

+ The centrally positioned servo three-phase drive and the guidance via precision racks and pinions guarantee absolute parallel running of the program slider.

+ The active safety system from Holzma ensures the necessary protection without annoying fencing.

3. Measuring system

The program slider travel path is measured using a contactless electromagnetic measuring system.

+ The measuring system developed by Holzma is not subject to mechanical wear, which means that dimensional accuracy is guaranteed even after many years of use.

+ Completely insensitive to dust.

+ The electromagnetic measurement is completely independent of the program slider's drive system.

4. Machine table (saw body)

The front machine table is equipped with large, abrasion-resistant supports with corresponding recesses for the collets.

+ No weakening of the machine table, full stability is maintained.

+ Easy replacement of the supports.

+ Saw blade feed direction against the solid steel angle ruler, which prevents the panels from slipping.

+ An integrated row of air nozzles ensures optimal panel handling.

5. Pressure beam

The torsion-resistant pressure beam (aluminum profile) is guided on both sides over racks.

+ Even pressure on the entire surface of the panel package.

+ The pressure is therefore applied directly on both sides of the cutting line, this results in optimum cutting quality.

+ The profile of the pressure beam results in optimum suction of the resulting chips.

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+ The integrated safety curtain offers the required protection for the machine operator.

6. Saw carriage + angle pressure device

The saw carriage is based on a robust steel construction, equipped with a main and scoring saw. The angle pressure device is integrated in the saw carriage in the form of a liftable sword. The pressure device rises through the cutting gap in a program-controlled manner and presses the material to be cut against the solid steel angle ruler.

+ The positioning of the angle pressure device is carried out by the saw carriage, which significantly minimizes the cycle time.

+ The pressure force of the angle pressure device can be continuously adjusted on the control panel.

+ The patented, vertically arranged saw carriage guide system (monorail) in the immediate vicinity of the cutting line prevents the build-up of vibrations and their effects on the cutting quality.

+ 10-year guarantee on the precision guides of the saw carriage.

+ Drive via rack and pinion:

- High feed speed.

- Dry running, without lubrication, therefore maintenance-free.

- No build-up of vibrations.

- Precise positioning.

+ Main and scoring saw guided on both sides, therefore the saw blades do not stray.

+ Efficient production thanks to the following technical features:

- Automatic, stepless cutting height adjustment.

- Automatic cutting length limitation via the workpiece using a sensor.

- Motorized adjustment of the scoring saw from the control panel.

- Simple and quick changing of the saw blades using the 'Power-Loc' quick clamping system.

- Stepless adjustable feed speed from the control panel.

- Extraction takes place via a chip channel.

7. CADmatic control

The CADmatic is a PC-based control system that was specially developed for the requirements of a production facility.

+ Display of the cutting plans in moving process graphics (2-D/3-D).

+ Almost unlimited number of cutting plans can be saved.

+ The CADmatic control is fully network-compatible, so optimized cutting plans can be transferred to the saw using a diskette or online (option).

+ The standard integrated 'slow-down' function can prevent tears, especially with sensitive materials.

+ CD and diskette drive are integrated as standard.

+ Separate input and working memory.

This means that data can be entered or transferred cutting plans can be read in during cutting.

+ Graphic and video sequence-supported error diagnosis.

The CADmatic is a control system based on the latest technology, which guarantees you efficient production now and in the future.

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Technical data

Saw blade projection 80 mm
Saw carriage feed:
forwards 5-130 m/min
backwards constant 130 m/min

Program slide speed:
forwards 80 m/min
backwards 80 m/min
(in EU countries = 25 m/min)

Control Power Control, PC
Operating software CADmatic 4.0
Operating system Windows XP
Monitor 17-inch TFT flat display
Modem analog

Angle pressing device
min. pressing width 0 mm
max. pressing width complete cutting length
Main saw motor 9.0 kW
Scoring saw motor 2.2 kW
Operating voltage 400 V / 50 Hz
Electrical connection value for HS motor:
9.0 kW = 15 kW
13.5 kW = 20 kW
Working height 920 mm
Paint finish textured paint gray RDS 240 80 05

Main saw blade 350 x 4.4 x 60 mm
Scoring saw blade 180 x 4.4 - 5.4 x 45 mm

Required air pressure 6 bar
Compressed air requirement 150 NL/min
V at the extraction nozzle approx. 26 m/s
Underpressure min. 1200 Pa
Exhaust air volume 4400 m³/h
Extraction connection chip channel 1 piece 200 mm
Extraction connection pressure beam 1 piece 150 mm

Operating temperature min. + 5 degrees
Operating temperature max. + 35 degrees
If the temperature is below or above this limit, a cooling
unit (sales no. 6750) must be used.

Quality standards:
- CE-tested, GS-tested, FPH wood dust tested
- Positioning accuracy: +/- 0.1 mm/m
- Angle accuracy: +/- 0.1 mm/m
The information refers to stress-free material
and a good saw blade quality.

Customer-specific machine data

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Cutting length 3100 mm
Cutting width (program slide travel) 3100 mm

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Collets 6 pieces
of which the first 3 pieces have two fingers,
all others have one finger
Division 75/275/475/1050/1850/3450 mm
measured from the angle ruler to the middle
Collet
2 additional two-finger collets possible
Item 175/375 mm
2 additional one-finger collets possible
Item 650/2650 mm
Air cushion table 2160 x 650 mm 1 piece
Air cushion table 1760 x 650 mm 2 pieces
Blower 1 piece
Nozzle division of the air cushion tables 70 x 70 mm

Number 6091 1 time
CAD-PLAN, CADMATIC 4.0 `Just in Time`
Optimization program for dividing sheet materials.
Possibility of entering and saving lists of parts, sheets and parameters.
Optimization taking head and follow-up cuts into account.
Entry of up to 99 part positions (each position up to 999 parts)
with up to 15 different output formats.

Number 8321 1 time
DOCUMENTATION AND CONTROL TEXTS: GERMAN
Scope of delivery:
1. Operating instructions in German
consisting of operating and maintenance instructions
on DIN A4 paper and CD-ROM
2. Screen operating texts in German
for machine operators, for the control CADmatic 3.0
3. Spare parts names in German
consisting of CAD drawings and circuit diagrams on CD-ROM