

Panel saw Holzma  
Type HPP 350 43/43 M-no: 0-240-14-2417  
Used machine - year 2008

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**HPP 350/43/43**

**Panel Dividing Saw, Type HPP 350**

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Automatic panel dividing saw for tear-out-free and dimensionally accurate dividing of coated and uncoated panels made of wood-based materials and those that can be processed like wood-based materials.

#### **1. Rear Machine Table**

The input material is positioned via the rear machine table, equipped with high-quality roller rails.

Advantage:

+ Gentle material transport.

#### **2. Program Slider**

The materials to be cut are positioned at the cutting line by the program slider using robust collets, according to the program.

Advantage:

+ Program slider guide in double T-beam design -> positioning accuracy for the entire lifespan!

+ Rack and pinion drive -> no lubrication required!

+ AC servo motor drive -> high program slider speed!

+ Non-contact electromagnetic measuring system:

- Positioning accuracy +/- 0.1 mm/m!

- No wear!

- Maintenance-free!

- Measurement is independent of the drive system!

+ Short, robust collets:

- No negative leverage effects!

- Material is pressed into the base of the collet

-> no slippage!

+ Active safety system from HOLZMA -> no

obtrusive safety fence required!

#### **3. Machine table (saw body)**

The saw body's machine table is equipped with large, abrasion-resistant phenolic resin plates, with corresponding recesses for the collets.

Advantage:

+ No milling of the machine table -> full stability of the steel table is maintained!

+ Easy, cost-effective replacement of the phenolic resin plates when worn!

+ Fully sprayed machine table:

- Gentle material transport!

- Optimal strip handling!

#### **4. Pressure Bar**

Optimal fixation of the panels to the machine table of the saw body.

Advantages:

+ Torsionally rigid aluminum pressure bar:

- Low weight, therefore minimal wear

of the cylinders!

- The pressure set by the manometer is maintained precisely!

+ Pressure bar guide on both sides via rack and pinion:

- Identical pressure across the entire surface!

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- No tilting movement (parallel compensation)
- > no material damage!
- + Pressure bar with collet recesses:
- Minimal cut = scratch cut
- > optimized material removal!
- + Automatic pressure bar height control
- > significant cycle time savings!
- + Optimal extraction performance through minimal pressure bar opening:
- BG emission values are clearly below the limit!

#### **5. Saw Carriage + Angle Pressure Device**

The saw carriage, constructed of robust steel, is equipped with a main saw and a scoring saw, as well as the patented 'Central Angle Pressure Device'.

Advantages:

- + Solid steel saw carriage body (approx. 300 kg):
- Torsionally rigid for life!
- Cutting direction against the angle stop -> no slippage of the panels!
- + Balanced saw carriage:
- Minimal wear on the prism rollers!
- No counter rollers required!
- + Rack and pinion drive:
- No lubrication required!
- No vibration build-up/precise positioning
- = Top cutting quality!
- + 10-year warranty on the saw carriage guides (single-shift operation)!
- + Motorized adjustment of the scoring saw at the control panel
- > minimal setup times!
- + Optimized saw blade change thanks to the 'Power-Loc' quick-release system!
- + Automatic, stepless cutting height adjustment
- > Reduces cycle time!
- + HOLZMA patent: Central angled pressure device:
- Reduces cycle time by up to 25% compared to conventional systems!
- Strip pressure possible across the entire cutting length!
- Pressure force electrically adjustable from 0 to 1200 N -> thin and delicate panels can be pressed automatically!

#### **6. Power Control: CADmatic 4 - Professional -**

State-of-the-art control system, specially developed for the requirements of a production facility.

a) Hardware

- + PLC control according to international standard IEC61131.
- + Operating system: Windows XP (US) embedded.
- + Industrial PC.
- + 17-inch TFT flat screen (optional 19-inch with touch function).
- + DVD drive.
- + USB port / modem (analog).

b) Software

- + Cutting plan display in animated flowcharts (2D/3D).
- + Network-compatible.
- + Integrated tool management with wear data acquisition.
- + Graphical and video-supported troubleshooting.
  
- + Virus protection.

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**Technical Data**

Saw blade projection 80 mm  
Saw carriage feed:  
forward 1-130 m/min  
reverse constant 130 m/min  
Program slide speed:  
forward 80 m/min  
reverse 80 m/min  
(in EU countries forward = 25 m/min)  
Automatic pressure bar height control yes  
Automatic cutting height control yes  
Adjustable pressure bar contact pressure yes  
Adjustable collet contact pressure yes  
Fully sprayed machine table (saw body) yes  
Angle return device  
Min. contact width 0 mm  
Max. contact width complete cutting length  
Main saw motor 13.5 kW  
Scoring saw motor 2.2 kW  
Operating voltage 400 V / 50 Hz  
Electrical connection rating with main saw motor:  
13.5 kW = 20 kW  
Working height 920 mm  
Paint: Textured 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 consumption: 150 NL/min  
V at extraction port: approx. 26 m/s  
Vacuum: min. 1200 Pa  
Exhaust air volume: 4400 m<sup>3</sup>/h  
Extraction port: Chip duct, 1 piece, 200 mm  
Extraction port: Pressure bar, 1 piece, 150 mm  
Operating temperature: min. +5°C  
Operating temperature: max. +35°C  
If these temperatures are exceeded or fallen below, a cooling unit (sales no. 6750) must be used.

**Quality Standards:**

- CE certified, GS certified, FPH wood dust tested
- Positioning accuracy: +/- 0.1 mm/m

These specifications refer to stress-free material and a high-quality saw blade.

**Customer-specific machine data**

HPP 350/43/43  
Cutting length 4300 mm  
Cutting width (program slide travel) 4250 mm  
Roller rail (10-track element) 1 piece  
Roller rail (2-track element) 5 pieces  
Collets 6 pieces  
of which the first 3 pieces are two-finger,  
all others single-finger  
Graduation 75/275/475/1050/1850/3450 mm  
measured from the angle ruler to the center of the collet  
2 additional two-finger collets possible  
Pos. 175/375 mm  
2 additional single-finger collets possible  
Pos. 650/2650 mm  
Air cushion table with roller element

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2160 x 650 mm 4 pieces  
Central blower 1 piece  
Nozzle pitch of the air cushion tables 70 x 70 mm

No. 2 Number: 1385 1 unit

**4 Pneumatic Trimming Rakes Type 350/380**

Necessary for trimming sheet material  
with protruding face sheets.

The trimming rakes are integrated into the following collets: Positions  
75/475/1050/2650 mm.

Activation via the control panel.

Number: 1690 1 unit

**Scoring Saw Unit (VVSH), Type 250/350/380**

For tear-out-free scoring of soft-formed and post-formed parts  
as well as edge-glued workpieces.

Program-controlled vertical from the bottom in continuous operation.

... Technical Data

Max. Postforming Height: 40 mm

Saw Blade: HM 280 x 4.6 x 45 mm

Item No. 2506 (1 unit)

**INCREASED FAN POWER (LKT)**

through integrated frequency control

Max. pressure increase compared to standard version

- on 50 Hz mains: factor 3.5

- on 60 Hz mains: factor 2.5

The air cushion table pressure can be continuously adjusted at the control  
panel

via rotary knob.

Item No. 2515 (1 unit)

1 DRIVE DEVICE FOR LKT

Item 2 LKT

Item No. 2536 (1 unit)

**ANGLE CUTTING DEVICE (MANUAL)**

Angle cuts faster and more precisely than ever before.

Technical Data

Max. Panel Thickness: Saw Cutting Height

Min. Leg Length at 45°: 245 mm

Angle Accuracy at 1000 mm: 0.1°

Min. Cutting Angle: 16.0°

N.12 Number: 2541 1 time

**ANGLE CUTTING DEVICE (AUTOMATIC)**

Angle cuts faster and more precisely than ever before,  
with patented angle cutting collet.

Technical Data

Max. Panel Thickness: 48 mm

Min. Leg Length at 45°: 115 mm

Angle Accuracy at 1000 mm: 0.1°

Min. Cutting Angle: 0.0°

E.02 Service: 6050 1 time

**NOTTERING PROGRAM (AUTOMATIC)**

For Type 350/380/11/510/530/550/570/33.

Grooving program with graphical input and flow graphics.

Positioning accuracy:

Groove depth = +/- 0.2 mm

Groove width = +/- 0.2 mm

Groove length for insert grooves = +/- 2 mm

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Groove depth infinitely adjustable via control  
(Hydraulic stop).

Service: 6057 1 time

**TURBO GROOVES** TYPE 350/380/510/530/550/570

Longitudinal grooves with the main saw in forward and  
reverse direction.

Especially suitable for bent parts.

Note: Grooves in the return direction are not 100% tear-out-free.

E.06 Service: 6065 1 time

**CUT-OUT/STREATMENT-FREE CUTTING PROGRAM**

Consisting of: - Cut-out program

- Insert grooves (Option 6055  
or 6050 required)

- Stress relief cutting  
(1-stage/2-stage/3-stage)

Positioning accuracy +/- 2 mm

Service: 6070 1 time

**LABELING WITH PART GRAPHICS**

includes the following options:

1. Graphical representation of edge information.
2. Graphical representation of machining drawings  
from Schnitt-Profi(t).
3. Printing of part drawings from higher-level  
systems.

E.10 Service: 6075 1 time

**LABEL PROGRAM 350/380/11/510/530/550/570/33**

Label printing for finished parts directly at the saw.

- Printout optionally per piece, per package, or  
per definable stack

Number: 6080 1 time

**LABEL PRINTER TYPE PICA 104**

Thermal / Thermal Transfer Label Printing Station  
Technical Data

Label width: max. 110 mm

min. 15 mm

Print width: 104 mm

Resolution: 200 dpi

Print speed: 80 mm/sec

Core diameter (label): 40 mm

Roll diameter: max. 180 mm

Automatic dispenser: yes

Automatic rewinder: no

The printer is installed in a separate housing  
in the area of the angle guide.

E.14 Service: 6085 1 time

**ANGLE CUTTING MASK CADMATIC**

For angle cuts, this software provides automatic stop control,  
eliminating the need for time-consuming manual alignment of the material at the  
cutting line.

` ... Service: 6200 1 time

**Online Data Transfer + USB Port**

Data exchange via a network. Both the network connection and the installation  
of the network-specific drivers are performed by the customer. A precise

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technical clarification of the network connection between the customer's network and the Holzma saw is absolutely necessary (see network checklist).

(USB stick not included)

Number: 6290 1 unit

**19-inch TFT flat display with touch function**  
instead of 17-inch without touch function

D.95 Service: 8321 1 unit

**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. On-screen operating texts in German for machine operators, for the control system CADmatic 3.0 or 4.0
3. Spare parts designations in German consisting of CAD drawings and circuit diagrams on CD-ROM