

Panel Saw Holzma
Type HPP 350 – M.nr: 0-240-14-3749
Used machine - year 2009



HPP 350/43/43

PANEL SAWING, Type HPP 350

Automatic panel dividing saw for tear-free and dimensionally accurate splitting of coated and uncoated boards made of wood materials and those that are to be processed like wood materials. Control panel and angle stop on the right.

1. Rear machine table

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

2. Program slider

By the program slide to cutting materials, using the robust Collets, programmatically to the cutting line positioned.

3. Machine table (saw body)

The machine table is covered with large, abrasion-resistant phenolic resin panels equipped, with corresponding recesses for the collets.

4. Pressure bar

Optimum fixation of the plates on the machine table of the saw body.

- + Two-sided pressure beam guidance via toothed rack:
- + Pressure bar with collet recesses:
- + Automatic print bar height control
- + Optimum extraction performance thanks to minimal pressure bar opening:

5. Saw carriage + angle pressing device

The saw carriage consists of a robust steel construction equipped with a main and scoring saw as well as with the patented one 'Central angle pressing device'.

- + Motorized adjustment of the scoring saw on the control panel
- + Optimized saw blade change thanks to the 'Power-Loc' quick clamping system!
- + Automatic, stepless cutting height adjustment
- + HOLZMA patent: Central angle pressing device:
- Strips can be printed over the entire length of the cut!
- Electrically adjustable pressure from 0 - 1200 N

6. Power Control: CADmatic 4 - Professional -

State-of-the-art control system

a) hardware

- + PLC control according to international standard IEC61131.
- + Operating system: Windows XP (US) embedded.
- + TFT flat screen: 17 inches (optionally 19 inches with touch function).
- + DVD drive.
- + USB connection / modem (analogue).

b) Software

- + Cutting plan display in moving progress graphics (2-D/3-D).
- + Networkable.
- + Integrated tool management with wear data acquisition.
- + Graphic and supported by video sequences error diagnosis.

c) Optimization program 'CAD Plan 4'

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Optimization program for dividing panel-shaped materials directly on the saw control:

- + Ability to save part, plate and parameter lists.
- + Consideration of header and recuts.
- + Up to 99 part positions.
- + Each position up to 999 pieces.
- + 15 different disk output formats.

Technical specifications

Saw blade projection 80 mm
Saw carriage feed:
forward 1-150m/min
reverse constant 150 m/min
Program Slider Speed:
forward 90 m/min
reverse 90 m/min (in EU countries forward = 25 m/min)
Automatic print bar height control yes
Automatic cutting height yes
Adjustable pressure bar contact pressure yes
Adjustable collet contact pressure yes
Completely darkened machine table (saw body) yes
angle pressing device
min. pressing width 0 mm
max. pressing width complete cutting length
Main saw motor 13.5 kW
Scoring saw motor 2.2 kW
Operating voltage 400 V (+10%/-5%)/ 50 Hz
Electrical connection value for HS motor:
13.5kW = 20kW
Working height 920 mm
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
Negative pressure at least 1200 Pa
Exhaust air volume 4400 m³/h
Extraction connection chip channel 1 piece 200 mm
Suction connection pressure bar 1 piece 150 mm
Operating temperature min. + 5 degrees
Operating temperature max. +35 degrees
Quality standards:
- CE tested, GS tested, FPH wood dust tested
- Positioning accuracy: +/- 0.1mm/m
The information refers to voltage-free
Material and a good saw blade quality.

Customized machine data

HPP 350/43/43

Cutting length 4300 mm

Cutting width (program slide travel) 4250 mm

Roller track (10-track element) 1 piece

Roller track (2-track element) 5 pieces

Collets 6 pieces

The first 3 pieces have two fingers, all the others have one finger

Pitch 75/275/475/1050/1850/3450 mm

measured from the angle ruler to the middle of the collet

Air cushion table with roller element

2160 x 800mm 1 piece

2160 x 650 mm 3 pieces

Central fan 1 piece

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Nozzle division of the air cushion tables 70 x 70 mm

N.02 number : 0027 1 piece

HANDLING PACKAGE TYPE 350/410

contains:

- 1) 1st air cushion table 2810 mm long
- 2) Increased blower power (frequency control)
- 3) Driving device for 2nd air cushion table
- 4) 19 inch TFT flat display (touch function)

N.04 number : 0032 1 piece

GROOVE CUTTING PACKAGE TYPE 350/380/410/430

contains:

- 1) Groove program (automatic groove depth adjustment)
 - 2) Cutting program
 - 3) insert grooves
 - 4) Voltage relief (1-stage / 2-stage / 3-stage)
 - 5) Turbo grooves
- > Longitudinal grooves with the main saw in forward and reverse direction
> Note: Grooves in return are not 100% tear-free
Positioning Accuracy:
Groove depth = +/- 0.2 mm
Groove width = +/- 0.2 mm
Groove length (insert grooves) = +/- 2 mm

N.06 Service: 0036 1 time

LABELING PACKAGE TYPE 350/380/410/430

contains:

- 1) Labeling with part graphics
- 2) label program
- 3) Label printer Pica 108

4 MANUAL RIM STOPS 230/250/350/HPL11
consisting of 4 plug-in trimming rakes.

NETWORK WORKPLACE OPTIMIZATION PROGRAM

Per workstation in the network.

DOCUMENTATION AND CONTROL TEXTS: GERMAN

Scope of delivery:

1. Operating instructions in German
2. Screen operating texts in German
3. Spare part designations in German