Panel Saw Holzma, used – year 2005
Type: OPTIMAT HPP 380/43/43
Machine Number: 0-240-06-6426
Working Hours: 7150

PANEL SAWING, Type Optimat HPP 380
Automatic panel dividing saw for splinter-free and dimensionally accurate dividing of coated and uncoated panels made of wood-based materials and those that are to be processed like wood materials.
Special materials after previous cutting tests.
1. Rear machine table
The input material is positioned via the rear machine table, equipped with high-quality roller rails.

2. Program slider
By the program slide to
cutting materials, using the robust
Collets, programmatically positioned at the cutting line.
+ Centrally arranged servo three-phase drive
as well as guidance via precision racks and pinions

3. Measuring system
The program slide travel is measured
via a non-contact electromagnetic measuring system.

4. Machine table (saw body)
The front machine table is equipped with large,
abrasion-resistant pads equipped with
corresponding recesses for the collets.

5. Pressure bar
The torsion-resistant pressure beam (aluminum profile)
is guided on both sides via toothed racks.

6. Saw carriage + angle pressing device
The saw carriage is based on a robust steel construction,
equipped with main and scoring saw.
The angle pressing device is in
Form of a raisable sword in the saw carriage
integrated. The pressing device rises under program control
through the cutting gap upwards
and presses against the material to be cut
the solid steel angle ruler.

7. CADmatic control
The CADmatic is a PC based one
steering
+ Display of the cutting plans in moving progress graphics (2-D/3-D).
+ Almost unlimited number of cutting plans can be saved.
+ CD and floppy disk drive is integrated as standard.
+ Separate input and working memory.

Technical specifications
Saw blade projection 95 mm
Saw carriage feed:
forward 5-130m/min
reverse constant 130 m/min
Program Slider Speed:
forward 80 m/min

reverse 80 m/min
(in EU countries = 25 m/min)
Control Power Control, PC
Operating software CADmatic 4.0
Operating software Windows XP
Monitor 17 inch TFT flat display
analog modem
angle pressing device
min. pressing width 0 mm
max. pressing width complete cutting length
Main saw motor 13.5 kW (frequency controlled)
Scoring saw motor 2.2 kW
Operating voltage 400 V / 50 Hz
Electrical connection value for HS motor: 13.5 kW = 20 kW
Working height 920 mm
Paint textured paint gray RDS 240 80 05
Main saw blade 380 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 4600 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
- Angular accuracy : +/- 0.1 mm/m

Customized machine data
Optimat HPP 380/43/43
Cutting length 4300 mm
Cutting width (program slide travel) 4250 mm
Collets 7 pieces
of which the first 3 pieces have two fingers,
all others single-fingered
Pitch 75/275/475/1050/1850/2650/3450 mm
measured from the angle ruler to the middle of the collet
4 trimming rakes on collets
Pos. 75/475/1050/2650 mm
Air cushion table 2160 x 650 mm 1 piece
Air cushion table 1760 x 650 mm 3 pieces
Blower 1 piece
Nozzle division of the air cushion tables 70 x 70 mm

N.02 number : 1695 1 piece
SCRIPPING SAW UNIT (VVSH), TYPE 380
Rising vertically from below in the run,
activated via machine parameters. For shatterproof
Scoring of edge-glued workpieces
as well as postforming parts.
Saw motor 2.2 kW.
50 mm saw blade protrusion with saw blade HM
280 x 4.6 x 45. 1 saw blade included in the price.

N.04 number : 1235 2 pieces
COLLET 2 FINGERS TYPE 380
Pos, 175, 375mm
E.02 Service: 6050 1 time
GROOVING PROGRAM (AUTOMATIC) TYPE 380/11/510/33
Grooving program with graphic input and process graphics.
Positioning accuracy +/- 2 mm
Groove depth continuously definable via control.

E.04 Service: 6065 1 time
CUTTING/STRESS RELEASE PROGRAM
for types 350/380/510/33
Consisting of: - Cutting program
- insert grooves
- Stress relief cut
(1-stage/2-stage/3-stage)
Positioning accuracy +/- 2 mm

E.12 Service: 6100 1 time
MATERIAL DEPENDENT PARAMETERS
This software package controls under consideration
of material-related parameter lists:
- the feed speed of the saw carriage
- Entry points for postforming
- Saw blade protrusion
- bleeds
- Slow down bet
- Rotational speed of the HS blade

E.16 number : 6083 1 piece
Modification LABEL PRINTER TYPE PICA 108
Thermal / thermal transfer label printing station
Technical specifications
Label width: max. 110 mm
at least 15 mm
Print Width: 108mm
Resolution: 300dpi
Printing speed: 100 mm/sec
Core diameter (label): 40 mm
Roll diameter: max. 180 mm
Automatic dispensing device: yes
Automatic winder: yes
The printer is in a separate housing
installed in the area of the angle ruler.

E.18 Service: 6075 1 time
LABEL PROGRAM TYPE 350/380/11/510/33
With this program, labels are made simultaneously
printed directly on the machine for finished parts.
- Printout either per piece, per package or
per definable stack

E.20 Service: 6070 1 time
LABELING WITH PARTS GRAPHICS
includes the following options:
1. Graphic representation of edge information.
Miter and joint are clearly recognizable
2. Graphic representation of processing drawings
from cutting profit (e.g.
Drilling patterns, sections, LPC images, etc.)
3. Printout of parts drawings from parent
Systems

D.95 Service: 8321 1 time
DOCUMENTATION AND CONTROL TEXTS: GERMAN
Scope of delivery:
1. Operating instructions in German
consisting of operating and maintenance manuals
on DIN A4 paper and CD-ROM
2. Screen operating texts in German
for machine operators, for the control
CADmatic 3.0
3. Spare part designations in German
consisting of CAD drawings and circuit diagram
plans on CD-ROM