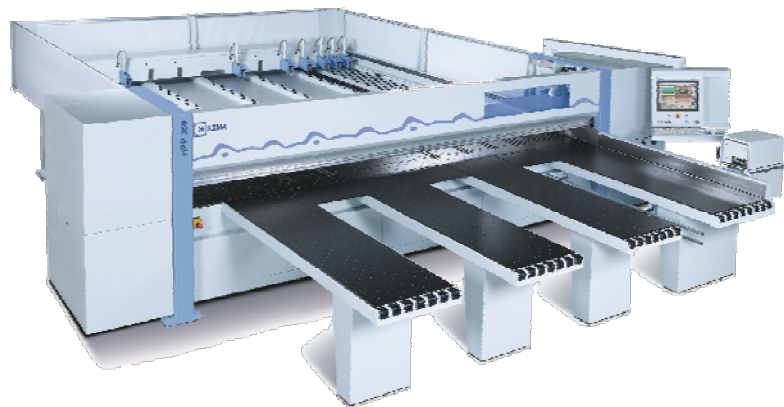HOLZMA U.S.
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Panel Cutter Type HPP 300 Profiline, CADmatic 4

Holzma's HPP 300 is a flexible saw center. This CNC controlled machine features fast, simple programming coupled with high operating speeds to meet today's varied production requirements. Designed for clean and accurate cutting of finished and unfinished panels. Equipped with main saw and scoring saw. Run by a single operator, the saw is capable of cutting angles, grooves, rabbets, and dados as well as conventional ripping and cross cutting.

- Unique Holzma EcoPlus System offers energy savings up to 20% and includes:
  - Standby button
  - Motors of energy efficiency grade 1 (EFF1)
- The heavily built machine body provides a stable base for vibration free cutting.
- Holzma's patented frame leg for perfect alignment of the saw tables in reference to the material being cut.
- Positioning systems on both the saw carriage and the clamp-equipped, programmable fence are driven by brushless AC servomotors, digital drives, and rack and pinion. This system is the best solution for the quick positioning and fast cutting required in today's manufacturing environment.
- The machine cuts right to left to the right angle fence.
- Saw dust collection for pressure beam and saw carriage on the right side of the machine.

Main saw motor		21 kW	28 HP
Scoring saw motor		2.2 kW	3 HP
Opening of clamps	Max.	95 mm	3.7″
Projection of main saw blade	Max.	95 mm	3.7″
Saw carriage speed forward		0-150 m/min.	0-492 fpm
Saw carriage speed reverse	Constant	150 m/min.	492 fpm
Program fence speed	Forward/reverse	90 m/min.	295 fpm

CADmatic 4 Professional Controller with swiveling movement. This flexibility of positioning allows the greatest range of positioning for the operator.

Hardware of the CADmatic 4 Professional Control

Computer: Industrial PC, Intel Core2Duo 2.8 GHZ processor
               1 GB RAM or higher (working memory)
               SATA 2 80.0 GB hard drive or higher
               DVD ROM Drive
               Intel extreme video graphics card
               2 Ethernet interface 10/100
               19 ″ Flat LCD Color Monitor (Touch Screen)
               Keyboard connection

- The CADmatic 4 is based on an industrial PC with Windows XP embedded operating system and is equipped with a 19″ Flat LCD color monitor (Touch Screen) and DVD ROM.
- The PC provides real time machine control eliminating the need for a separate PLC. This allows the saw to operate quicker and optimize and control all machine functions.
- Holzma CADmatic 4 interface provides the most intelligent interface between the operator and the saw. The 3D graphics and intuitive menus make it easy for inexperienced people to learn how to be productive on the Holzma saw quickly key board skills are at a minimum with the touch screen.
- The control settings are personalized for each operator at log in. Each user's profile customizes such settings as language, measurement mode (decimal inch, fractional inch and millimeter) screen layouts and colors.
- The easy to understand menu gives the saw operator the tools necessary to perform the various jobs the panel saw can handle throughout the day.
- Single Part: Utilize this feature for quick and easy programming of a single part in a pattern

Hardware of the CADmatic 4 Professional Control (continued)

- Fixed Position: The panel saw becomes an electronically controlled cut off saw. This can be used with fixtures for specialty cutting needs.
- Cut-to-Length: This handy capability will measure the panel as it is pulled back and tell the operator how much is left after making each cut. Especially useful when processing strips.
- Edit pattern: A powerful graphic interface for manually entering complicated patterns. The graphic interface gives the operator a visual reference to his input, and eliminates the need for function codes.
- Select patterns: Allows the operator to view and select patterns for cutting. The operator can select a complete job of a series of patterns or random patterns from different jobs, to tailor the sequence to specific production needs.

Characteristics of the Cadmatic

- New cutting patterns can be entered or down loaded while the machine is in the process of cutting a previously entered pattern.
- A large memory capacity hard drive for cutting patterns is virtually unlimited. It includes simple utilities to maintain files.
- 3-D Moving Graphics-the 19″ LCD flat screen monitor (Touch Screen) displays the cutting sequence in real time. As the cutting of each part is finished, the monitor displays the actual part information as a graphic, as well as such textual information as part description, size, and edgebanding information. This clearly displayed information allows a truly paperless operation.
- Parametrically controlled saw carriage speed for narrow front or rear trim cuts. This feature keeps the saw cutting at optimal speeds regardless of operator experience.
- Integrated tool tracking software – prompts operator when to change blades, and improving blade life
- The Cadmatic speaks your language: multiple languages available: The control can be configured to have your language displayed when you log in.

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Error Diagnostics

Holzma machines are extremely reliable but even they can have a problem. To help find problems on the machine, Holzma has incorporated a comprehensive error diagnostic system in the Cadmatic 4.

- Errors are first displayed in plain text.
- The CADmatic 4 maintains a file of the last 15 errors to occur on the machine. This feature helps to track and fix small problems before they become serious.
- Supplemental steps to correct the problem are displayed on the control monitor.
- Additional photo and videos show actual location of the errors.
- The ability to review in real time the actual status of inputs or outputs along with the status of the switches is available on the screen of the Cadmatic.
- Additional screens show the status of the counters. Counters show the programmed position of such moving components of the saw as the saw carriage or the program fence, which can be compared to the actual position.
- With modem hardware for remote diagnostics.
- Maintenance display and tracking are standard. The machine prompts the operator when the saw needs maintenance. The operator logs in that it has been performed; so, there is an actual tracking system.
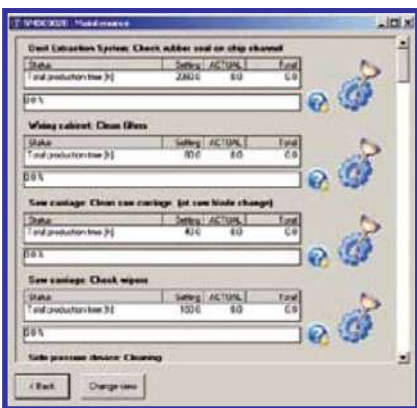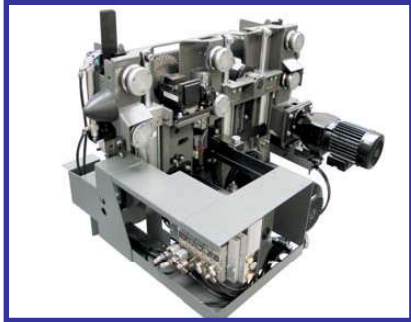
Saw Carriage

- Solid steel construction for long working life.
- Saw blade assembly guided on both sides by precision, hardened steel guides, unaffected by dust and dirt, no lubrication necessary.
- Saw carriage guided by chromed, hardened steel guide rods and hardened steel, precision V-groove rollers; Holzma's unique "monorail" locked-in guidance system. Over the last 40 years, Holzma's "monorail" saw carriage guide system has been proven world-wide to provide clean, accurate cuts in even the most difficult to cut, prefinished materials.
- Excellent saw blade life and cut quality due to the monorail guide system.
- Precision machining guarantees absolute parallel positioning of the guide ways in relationship to the surface of the machine bed, hence to the panels being cut, which prevents the scoring saw from running untrue.
- Saw carriage guides are positioned closer to the cutline than on any other saw, eliminating any effect that the drive system vibrations could have on the cut quality.
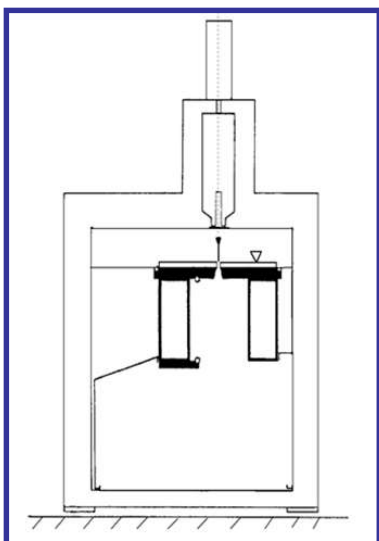
Saw Carriage (continued)

- Automatic cutting height adjustment provides optimal blade exposure.
- Automatic continuous cutting length control by sensor provides optimal saw carriage travel distance, regardless of strip width.
- Cutting speed infinitely variable; adjustable from control panel.
- Rack and pinion driven via AC servo motor.
- Scoring saw adjustment from control panel during operation. Safe and fast for the operator.
- Extraction via sawdust channel.

Pressure Beam
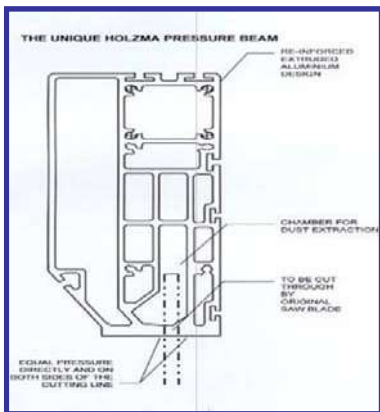
- Minimum opening for blade passage to exert pressure right at the cutting line, where it is needed.
- Guided equally on both sides by racks and pinions, which guarantee that the pressure beam remains parallel, even when cross cutting a single stack of narrow strips.
- Pressure applied equally on both sides of cut line resulting in superior cut quality.
- Optimum extraction of sawdust by means of an extraction outlet and a separate extraction channel.
- Pressure beam opening defined by book height, saving distance traveled and reducing time lost.

Automatic Side Pressure Device

- Integrated into saw carriage.
- Precisely positioned by the saw carriage to reduce cycle times.
- Pressure infinitely variable.
- Automatic positioning via sensor, no pre-adjustment required.
- Quick alignment for single strips.
- Double alignment for multiple strips
- Alignment width: Min. 0 mm -Max: complete cutting length of machine.
- Heavy steel right angle fence is part of the machine frame leg for consistent, square cuts.

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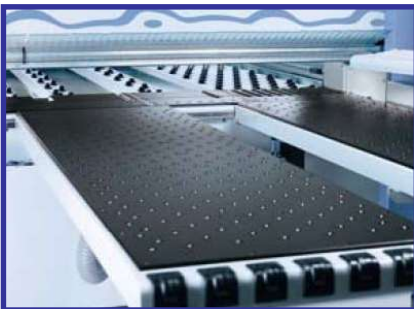## Clamp-Equipped Program Fence

- AC servo drive electronically controls the program fence for quick, accurate positioning, with minimal wear and tear.
- The saw control constantly drives the program fence at the optimal speed of travel, regardless of distance traveled for short cycle time.
- Strongest clamping pressure, regardless of book height; clamp jaws feature parallel motion which keeps material in clamp for better position accuracy.
- Holzma's unique clamp design keeps single panels or complete books of panels clamped and under control of the program fence until the rip or crosscut operation is completed.
- Upper clamp jaw is covered with a special, non-marring pad, preventing any possible damage to the surface of the panel material.
- Easy access to all pneumatic and electrical switches for easy maintenance.
- Magnetically based measuring system, completely independent from the drive system of the program fence with no wear, or even touching parts for long working life.
- Tighter tolerance resolution, longer working life, less adjustment than with optical encoders.

Machine Tables

- Rear support table consists of rails with narrow pitch rollers for friction-free panel movement and protection from scratches.
- Machine bed is covered with large, friction-free plates with gaps at the positions of the clamps.
- Because of these plates, machine bed remains at full thickness and strength, providing maximum stability.
- Air tables at the front of the machine for easy material handling.
- Air floatation in machine bed to reduce drag on sensitive materials at the cut line.
- Dustex System with air floatation valves on outfeed side of cut line to produce air flow parallel to cut line in direction of right angle fence. Assists in control and extraction of dust.

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Cutting length		4300 mm	169.2″
Cutting Width		3200 mm	126″
7 Two Finger Clamps		75 mm 275 mm 475 mm 1075 mm 1525 mm 2325 mm 3125 mm	2.95″ 10.82″ 18.70″ 42.32″ 60.04" 91.53" 123.02"
Optional 2- finger clamps available for	175 mm 6.87″ 375 mm 14.86″ 675 mm 26.57" 775 mm 30.51" 2725 mm 107" 3625 mm 123"		
1 Air Table		2160 x 800 mm	85″ x 31.5″
3 Air Tables		2160 x 650 mm	85" x 26"
Total connected load	27.5 kW		
Air pressure required		6 bar	86 lbs.
Total air volume	Based on 6 bar	120 l/min.	4.24 cfm
Extraction	Minimum (Velocity)	3800 m3/h (26 m/sec.)	2237 cfm 85 f/s
Diameter of dust connectors	Pressure beam	140 mm	5.51″
Diameter of dust connectors	Saw carriage	160 mm	6.30″

Data Link to Storage System

Complete communication interface between saw and stock control system according to logic "store controls saw". Off-cut communication for storing of reusable off-cuts within the storage system according to Holzma data format definition. Data exchange through Ethernet-TCP/IP File- I/O comm

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Prestacking and Labeling Table

The panel labeling system will be placed above the feed-stacking table. Thus it is possible to save space while stacking, labeling and feeding the positioned panel or parcel.

- Raisable Clamps
- 2 aligning devices in front of the cutting line

Technical data:

Panel size:	min.	1200 x 800 mm
	max.	3800 x 2200 mm
Panel thickness:	max.	45 mm
	min.	12 mm
Part sizes:		
Single panels:	min.	170 x 170 mm
Parcel cut:	min.	330 x 330 mm
Book height:	max.	45 mm
Label size:		100 x 80 mm
Printing size:		104 mm
Resolutions:		200 dpi
Number of labels per roll:		1000
Automatic feeding device:		yes
Automatic spooling device:		yes
Separate safety area:		no
Control:		in machine

Features added to Prestacking and Labeling Table:
- Thin Board feature:
  - Min. panel thickness   1 mm
  - Max book height   45 mm
- Book Cutting features:
  - Increase of maximum stacking height on the maximum cutting height of the saw   up to 150 mm
- Label Performance package features
  - Performance increase to :   15 labels/min.

Information Handling Package

- Includes USB transfer/ Downloading via network
- Cadmatic Label Printing Software
- Zebra Label Printer and Stand

Automatic Grooving (Depth set through Cadmatic)

- Grooving position (length/crosswise), grooving width, distance to panel edge and grooving depth are freely programmable through the Cadmatic control.
- Grooving rabbeting or dadoing occurs during the cutting cycle.
- Symmetrical grooving or rabbeting and intermittent grooving and cutting are freely programmable.
- Grooving depth +/- .2mm.
- Grooving width +/- .2mm.

Turbo Grooving

- Capability to groove in both directions
- Reduces time for kerfing

Symmetric Veneer Trimming Software

- Accurate cuts require accurate positioning. This is particularly important, when cutting solid wood panels. Holzma's purpose-designed laser guide line option provides assistance here.
- For single cuts of veneered panel the work piece can be positioned according to the wood grain by means of this special software plus an additional laser light.
- Exact positioning right down the line
- Ideal for positioning solid wood and veneered panels.
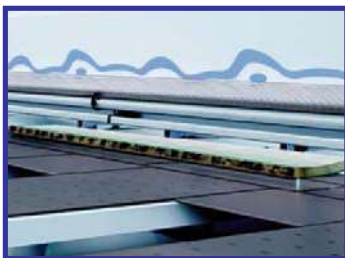
Included in price of machine:

- UL Approved electrical components and switch cabinet
- Air floatation in machine bed
- Dustex System
- Air Conditioning in the Switch Cabinet
- Data Link to Storage System
- Prestacking and Labeling Table
    - Cutting of books
    - Performance package (15 labels per min)
    - Over run of book
    - Thin board feature
- Downloading via Network and USB
- Information Handling Package
- Left Hand Design
- Automatic Grooving (Depth set through Cadmatic)
- Turbo Grooving
- Symmetric Veneer Trimming Software
- Laser Light at the Pressure Beam
- Main Saw Deflection Sensor

Bargstedt Intellistore Modification

One (1) Additional Storage Loading Position/Outfeed for CNC Routers with Frames (#5917) and extension of the system in length of 10 meters

- length = max. 3000 mm (10' max long boards)
- stack supply via fork-lift truck
  - three (3) individual steel structures to mount on the hall floor
  - four (4) individual stop positions to mount on the hall floor
  - one (1) manual locking brake
  - one (1) safety light barrier with manual acknowledgement
  - one (1) protective fence device to protect the storage position
    max. stack height of 1000 mm (39-3/8")
  - max stack weight of 5000 kgs (11,000 lbs)
  - stack dimensions, min. 2000 x 800 mm, maximum 4200 x 2200 mm

Additional Scope of Supply

The modification includes:
- extention of the steel crane rails/legs/cross braces by 10 meters (appx. 33' using existing cable)
- integration of the HOLZMA label table
- update to WOODSTORE V.6.0

Modification Parts:
- 2x belts for X-axis drive
- extension for energy chain and cable tray and C clamps for the cable trays.