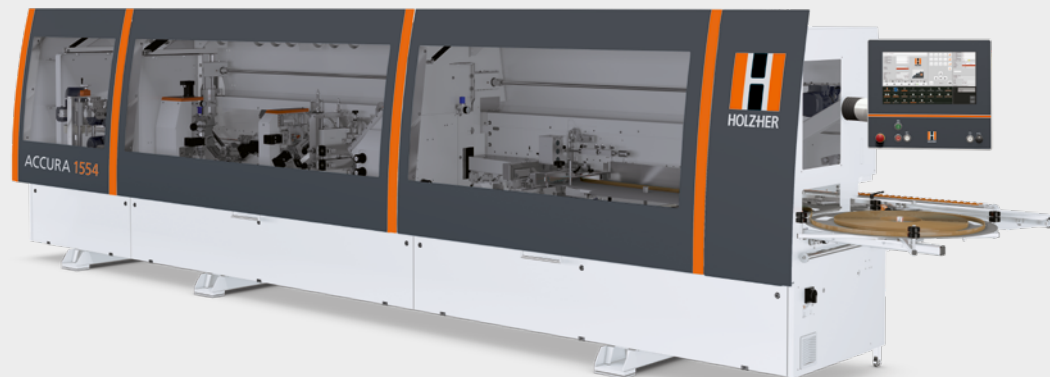


» **HOLZ-HER ACCURA series**  
100 percent repeatable and  
multifunctional ◀

**ACCURA 1554 AUTOMATIC**

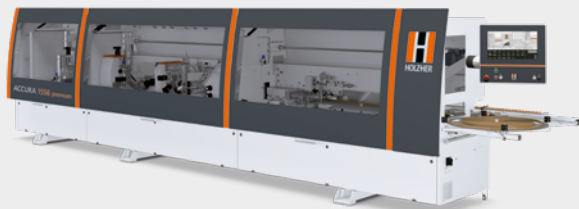


Top class when it comes to edgebanding.  
High-end aggregates for complete as well as professional processing.

## » HOLZHER ACCURA series

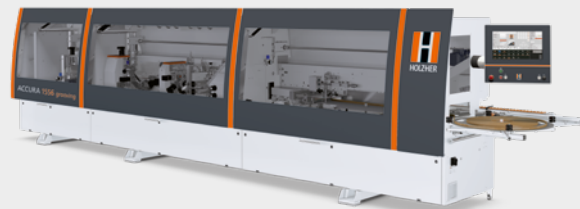
100 percent repeatable and multifunctional ◀

### ACCURA 1556 PREMIUM



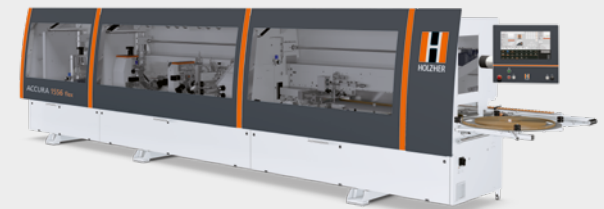
With two milling units for solid wood edgebanding up to 15 mm edge thickness (optional 20 mm)

### ACCURA 1556 GROOVING



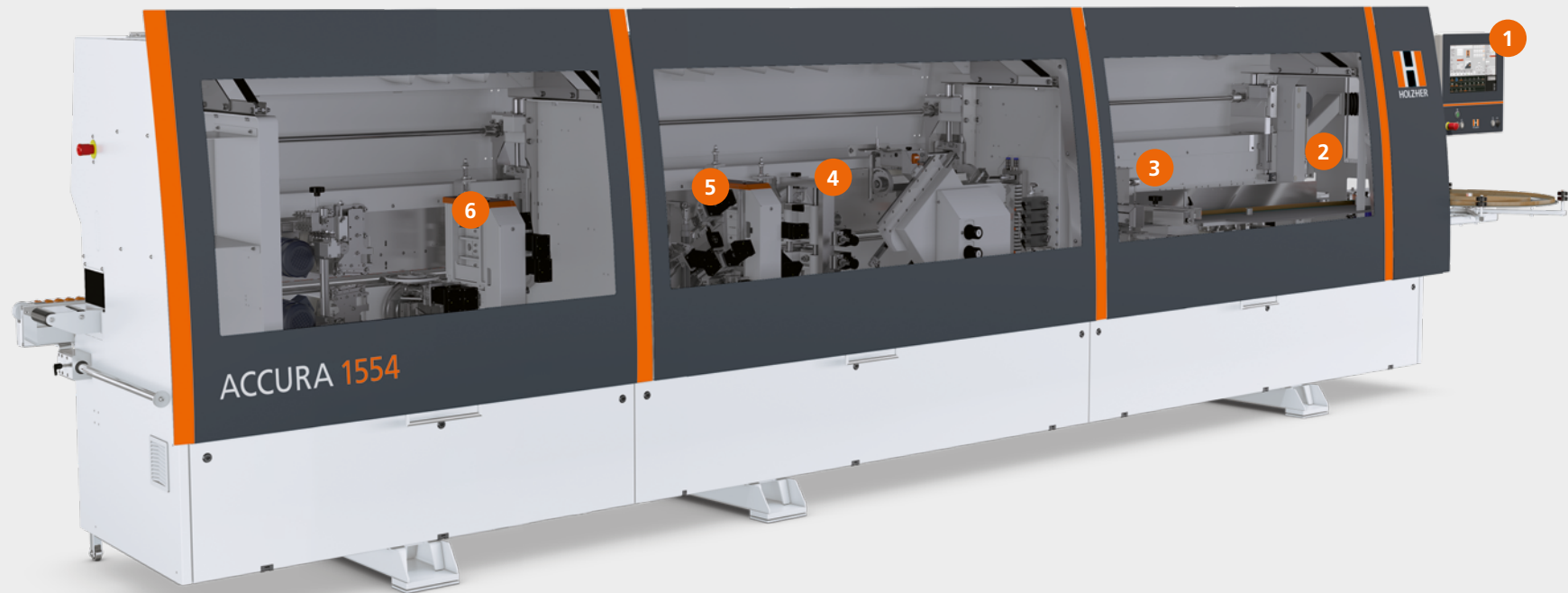
Fully automatic grooving in vertical and horizontal direction. Position and groove depth are freely adjustable via NC servo axes.

### ACCURA 1556 FLEX



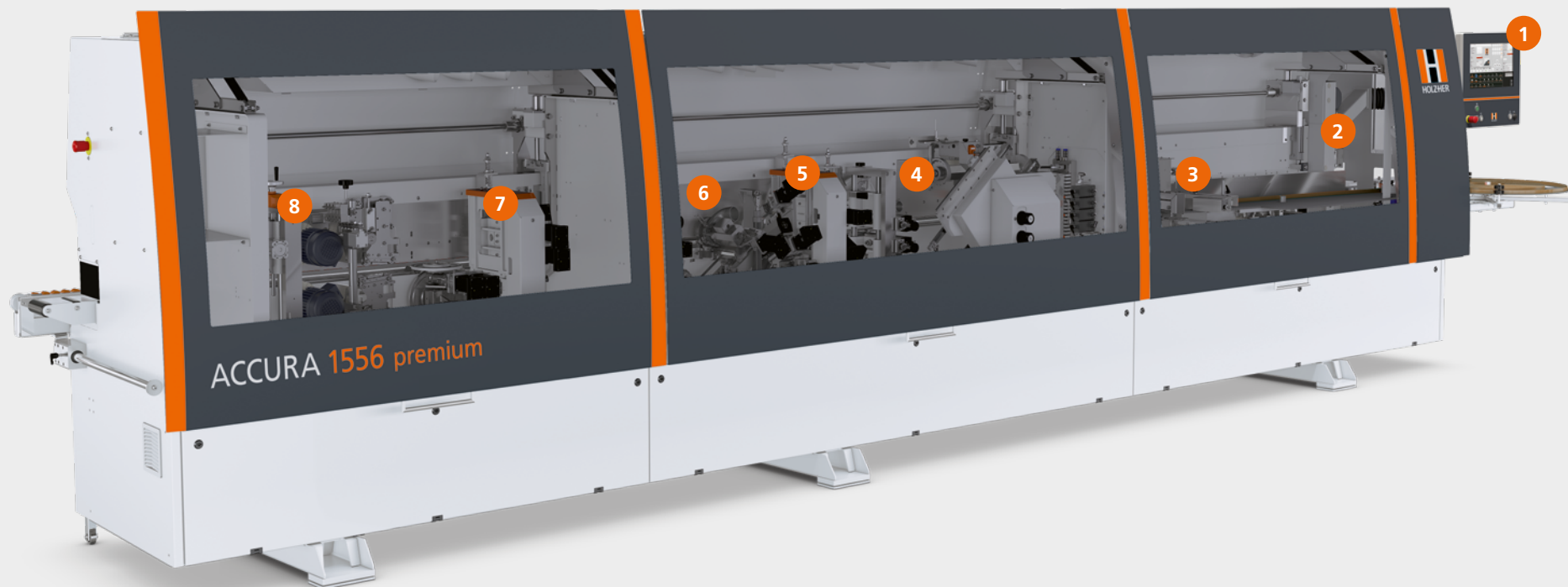
With an additional corner buffing unit as standard. For a perfect edge finish without any post-processing.

## ACCURA 1554 AUTOMATIC



- 1 fa.s.t. Setting Technology
- 2 Pre-milling unit with Air-Stream-Technology
- 3 Glu Jet-Hybrid-Technology
- 4 Fine trimming unit FR701 MOT6
- 5 Corner rounding unit FF701 MOT4
- 6 Radius scraper ZK501 MOT5

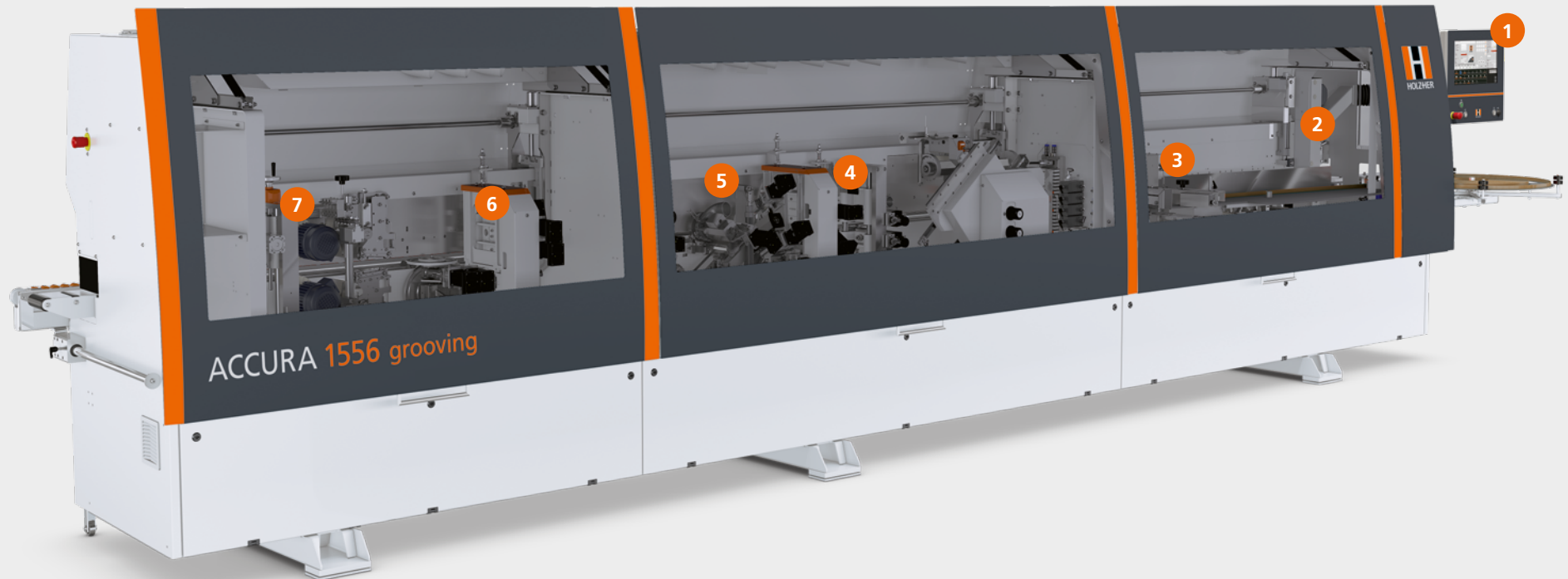
## ACCURA 1556 PREMIUM



- 1 fa.s.t. Setting Technology
- 2 Pre-milling unit with Air-Stream-Technology
- 3 Glu Jet-Hybrid-Technology
- 4 Flush milling unit BF501
- 5 Fine trimming unit FR701 MOT6
- 6 Corner rounding unit FF701 MOT4
- 7 Radius scraper ZK501 MOT5
- 8 Corner buffing unit



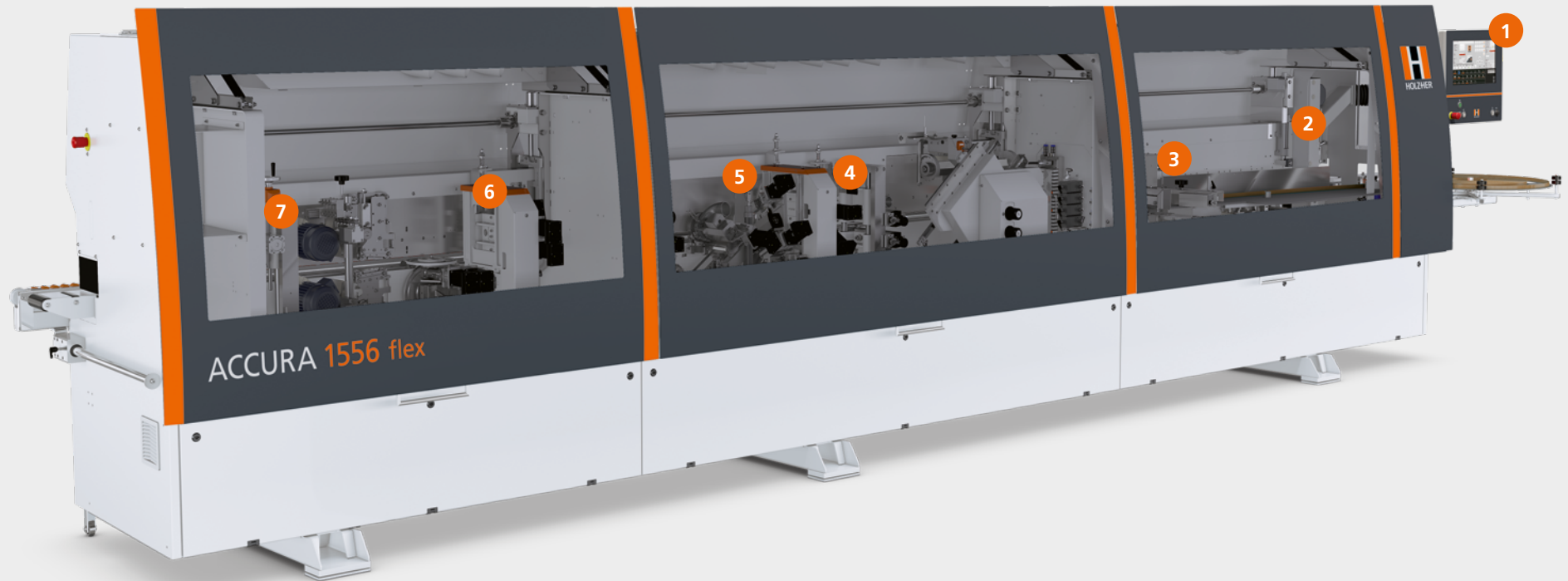
## ACCURA 1556 GROOVING



- 1 fa.s.t. Setting Technology
- 2 Pre-milling unit with Air-Stream-Technology
- 3 Glu Jet-Hybrid-Technology
- 4 Fine trimming unit FR701 MOT6
- 5 Corner rounding unit FF701 MOT4
- 6 Radius scraper ZK501 MOT5
- 7 Grooving unit MOT2



## ACCURA 1556 FLEX



- 1 fa.s.t. Setting Technology
- 2 Pre-milling unit with Air-Stream-Technology
- 3 Glu Jet-Hybrid-Technology
- 4 Fine trimming unit FR701 MOT6
- 5 Corner rounding unit FF701 MOT4
- 6 Radius scraper ZK501 MOT5
- 7 Corner buffing unit



## BASIC MACHINE

### Premium class with top performance

The ACCURA series was designed by HOLZ-HER for discerning manufactures requiring premium quality industrial parts production. The modular system allows flexible adaptation to customer requirements and future furniture trends.

ACCURA stands for maximum ease of use, productivity and precision.

Solid and robust machining units and diamond-tipped milling technology provide high-quality edge processing for 100% repeatability.

- Edge height max.: 65 mm
- Workpiece thickness: 8 – 60 mm
- Workpiece width: min. 60 mm
- Workpiece length: min. 140 mm
- Stepless feed 10 – 20 m/min (25 m/min. feed possible, with the synchronously driven belt bridge)
- Pneumatic locking roller at the infeed
- Space-saving, sound-insulated safety hoods
- Solid high-tech units
- Glu Jet-Hybrid-Technology
- Integrated, easily accessible control cabinet



## TECHNICAL DATA

At a glance

ACCURA 1554 AUTOMATIC		
Control	21.5" touch screen	
Bridge	Roller bridge	Synchronized belt bridge
Magazine	SYNCHRO	MOT3 SYNCHRO
Pre-milling	60 mm, Ø 70 mm	60 mm MOT2, Ø 100 mm
Glue application	GluJet automatic	GluJet automatic NC
Pressure unit	4 rollers, motorized	
Trimming	Twin-motor	
Milling 1	x	
Milling 2	2 mm radius	Multifunction package for milling, corner rounding, radius scraper
Corner Rounding	60 mm, MOT4	
Radius scraper	MOT	
Surface scraper	With pre and post tracing	
Buffing	Mission controlled	Oscillating
Corner buffing	x	
Grooving unit	x	
Spraying device		



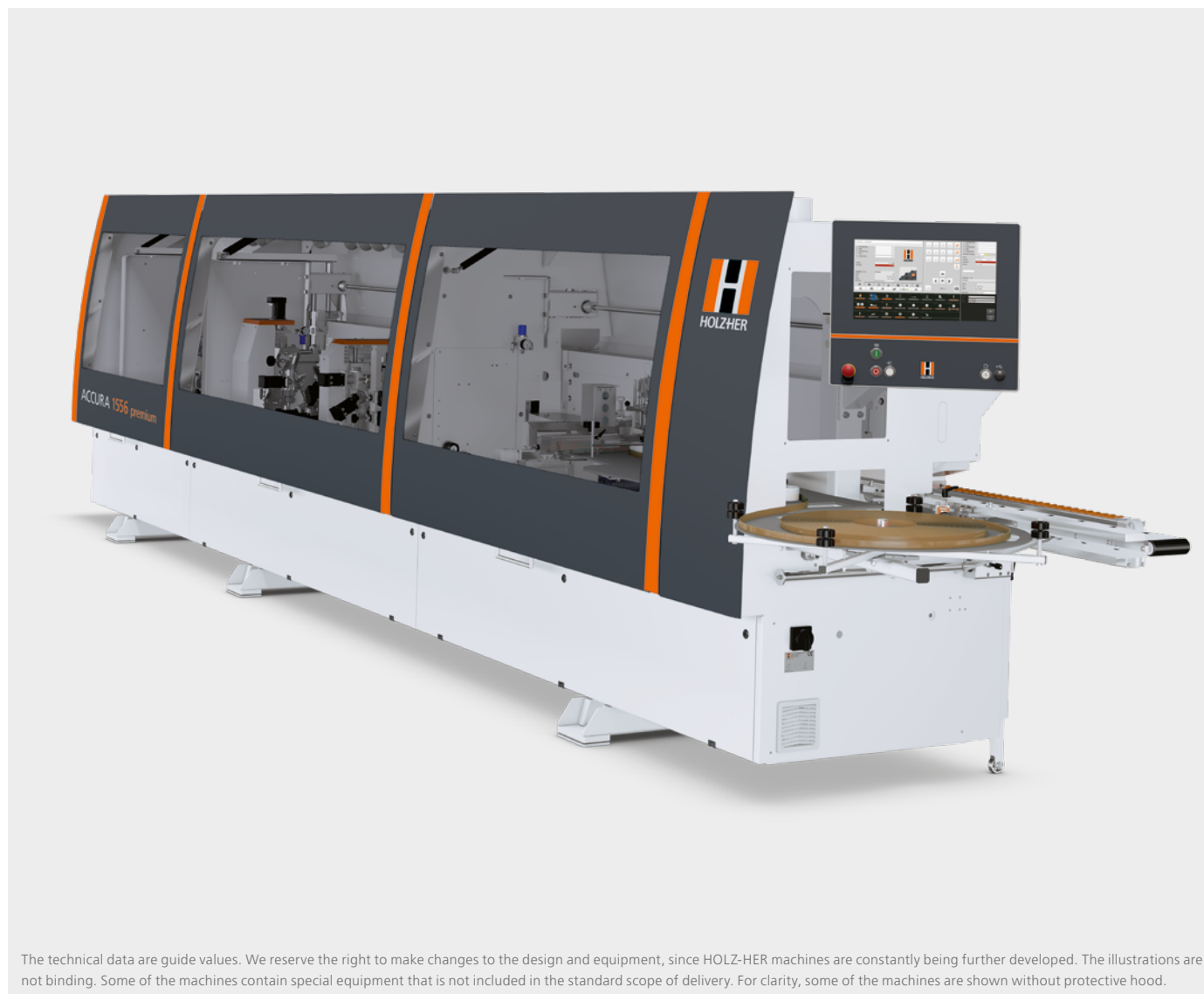
The technical data are guide values. We reserve the right to make changes to the design and equipment, since HOLZ-HER machines are constantly being further developed. The illustrations are not binding. Some of the machines contain special equipment that is not included in the standard scope of delivery. For clarity, some of the machines are shown without protective hood.

  Standard  
   Optional  
 x Not possible  
   Free space

## TECHNICAL DATA

At a glance

	ACCURA 1556 PREMIUM	
Control	21.5" touch screen	
Bridge	Roller bridge	Synchronized belt bridge
Magazine	SYNCHRO	MOT3 SYNCHRO
Pre-milling	60 mm, Ø 70 mm	60 mm MOT2, Ø 100 mm
Glue application	GluJet automatic	GluJet automatic NC
Pressure unit	4 rollers, motorized	
Trimming	Twin-motor	
Milling 1	Flush 15 mm	+ MOT variants 20 mm
Milling 2	2 mm radius	Multifunction package for milling, corner rounding, radius scraper
Corner Rounding	60 mm, MOT4	
Radius scraper	MOT	
Surface scraper	With pre and post tracing	
Buffing	Mission controlled	Oscillating
Corner buffing	Mission controlled	
Grooving unit	x	
Spraying device		



The technical data are guide values. We reserve the right to make changes to the design and equipment, since HOLZ-HER machines are constantly being further developed. The illustrations are not binding. Some of the machines contain special equipment that is not included in the standard scope of delivery. For clarity, some of the machines are shown without protective hood.

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   Optional  
 x Not possible  
   Free space

## TECHNICAL DATA

At a glance

ACCURA 1556 GROOVING		
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Pressure unit	4 rollers, motorized	
Trimming	Twin-motor	
Milling 1	x	
Milling 2	2 mm radius	Multifunction package for milling, corner rounding, radius scraper
Corner Rounding	60 mm, MOT4	
Radius scraper	MOT	
Surface scraper	With pre and post tracing	
Buffing	Mission controlled	Oscillating
Corner buffing	x	
Grooving unit	MOT2	
Spraying device		



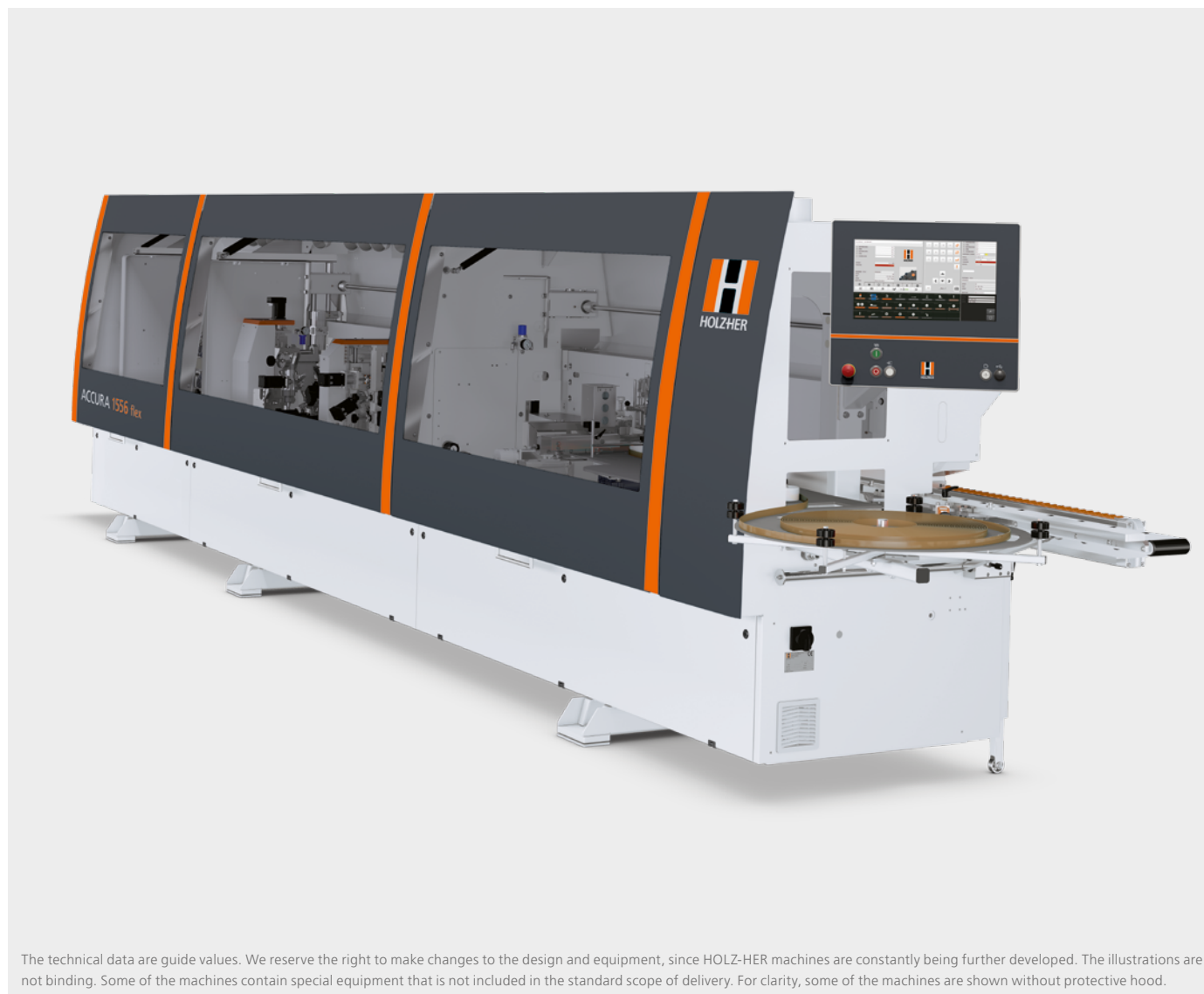
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Standard
  Optional
 x Not possible
  Free space

## TECHNICAL DATA

At a glance

	ACCURA 1556 FLEX	
Control	21.5" touch screen	
Bridge	Roller bridge	Synchronized belt bridge
Magazine	SYNCHRO	MOT3 SYNCHRO
Pre-milling	60 mm, Ø 70 mm	60 mm MOT2, Ø 100 mm
Glue application	GluJet automatic	GluJet automatic NC
Pressure unit	4 rollers, motorized	
Trimming	Twin-motor	
Milling 1	x	
Milling 2	2 mm radius	Multifunction package for milling, corner rounding, radius scraper
Corner Rounding	60 mm, MOT4	
Radius scraper	MOT	
Surface scraper	With pre and post tracing	
Buffing	Mission controlled	Oscillating
Corner buffing	Mission controlled	
Grooving unit	x	
Spraying device		



The technical data are guide values. We reserve the right to make changes to the design and equipment, since HOLZ-HER machines are constantly being further developed. The illustrations are not binding. Some of the machines contain special equipment that is not included in the standard scope of delivery. For clarity, some of the machines are shown without protective hood.

  Standard  
   Optional  
 x Not possible  
   Free space

## SYNCHRONOUSLY DRIVEN BELT BRIDGE

The top-running belt bridge shows several major advantages compared to the roller bridge.

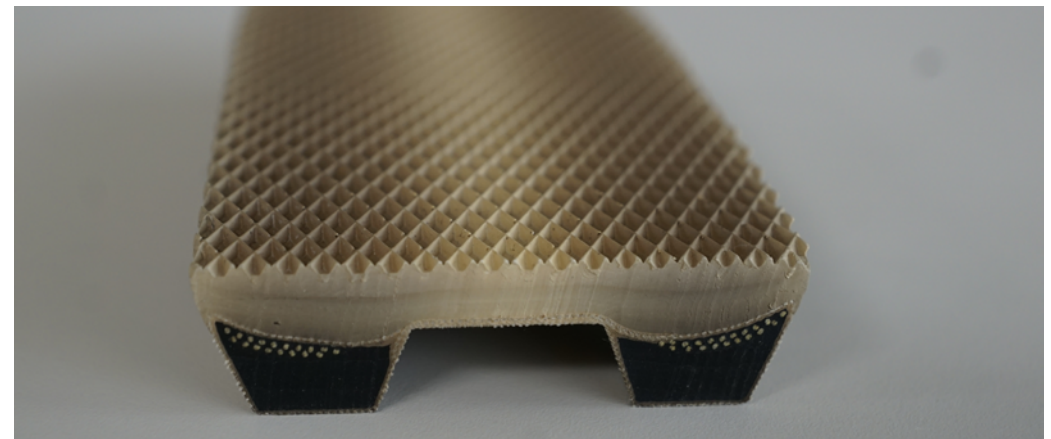
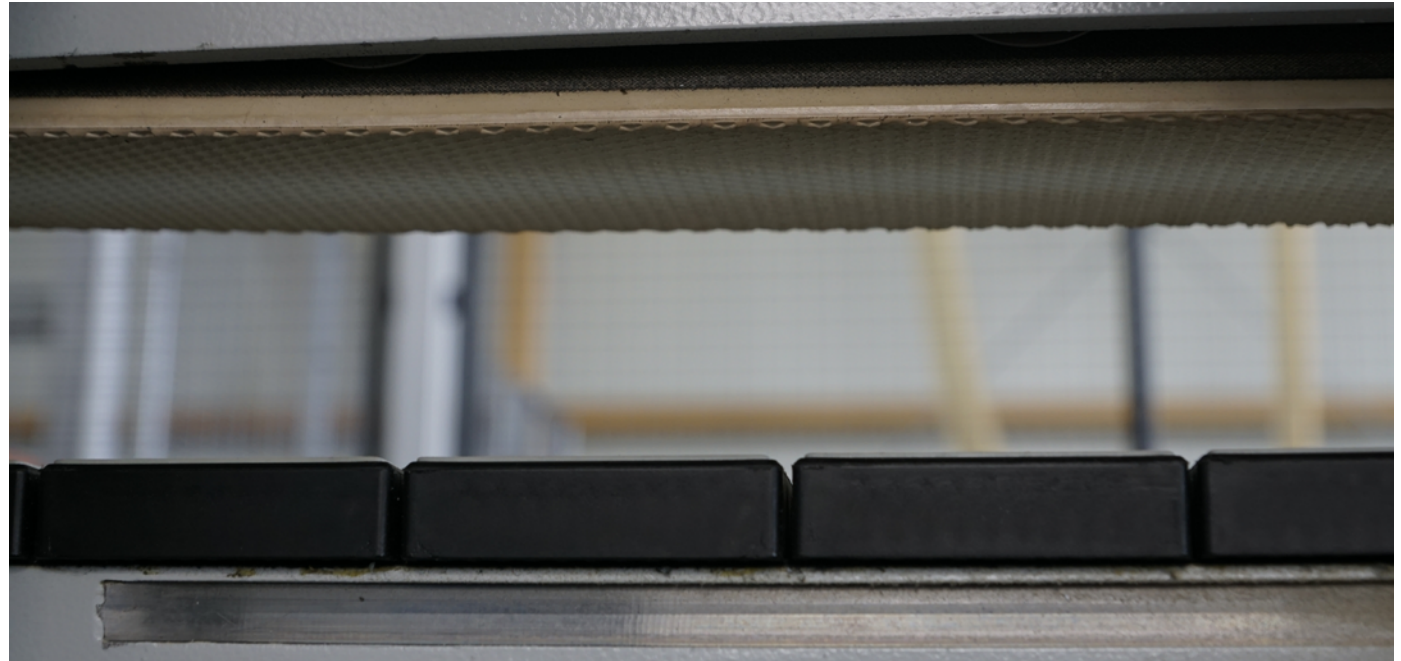
On the one hand, the continuous belt creates an even and gentle pressure distribution on the workpiece. Smaller parts in particular are additionally slightly overlapped by the soft transport belt at the front and thus held better.

The upper belt bridge is controlled and driven synchronously with the lower transport chain by its own motor. This prevents slippage. The workpiece is guided even more safely past the machining units.

In addition, the continuous belt can be cleaned much easier and faster.

- 36 Kevlar inserts prevent stretching of the double composite V-belt
- Extremely gentle to the workpiece surface
- Avoidance of slippage during machining
- Particularly advantageous when processing high-gloss materials with protective film attached

Without synchronization, there is a risk that the protective film will crumple or even peel off during processing. The uneven surface of the workpiece therefore appears in the form of small waves when the edges are machined.



## LED OPERATING STATUS INDICATOR

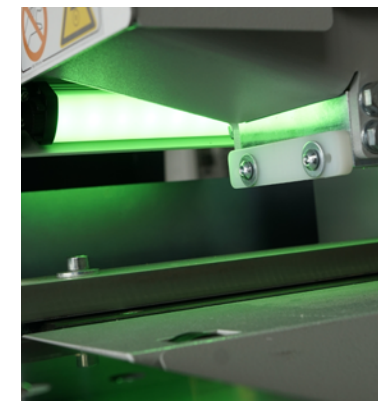
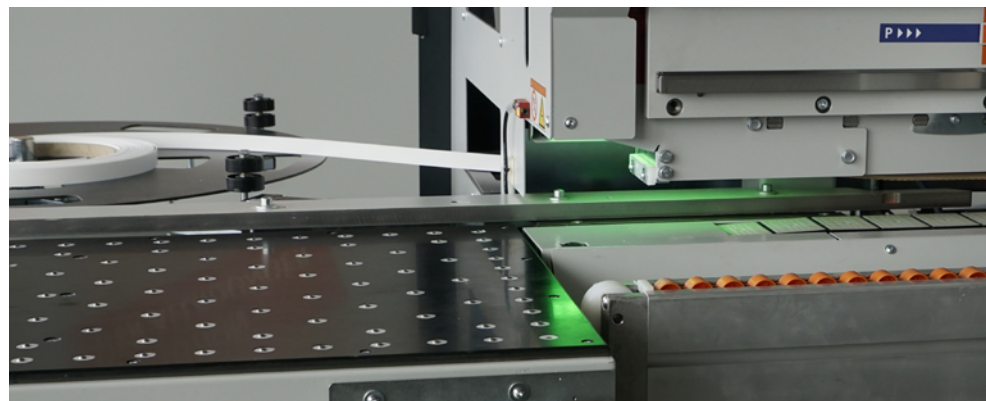
Thanks to the optical LED operation indicator, you can always keep an eye on the status of your machine.

The upper lights on the machine hood indicate the corresponding machine status.

- White: Control voltage to
- Orange: Feed to
- Yellow: Glue or edges reload
- Green: Workpieces in production
- Red: Error message

The lights in the infeed area serve as signaling devices for the operator and indicate when the next workpiece may be fed into the machine.

- Green: Workpiece input
- Off: No release



## EXTENDABLE SCISSOR SUPPORT RAIL

Optional extra, for optimum  
workpiece support.

The fully cantilevered scissor support rail is designed for use with both large and heavy workpieces and provides optimum workpiece support.

The scissor arm can be extended to a width of 1800 mm with ease.

Thanks to the extremely stable cantilever design, the support rail remains permanently at correct working height. This saves the operator from having to adjust the height.

For gentle material handling, the support is equipped with a continuous rollers, as well as large rollers in the infeed and outfeed areas.

- Extension width = 1800 mm
- Completely self supporting

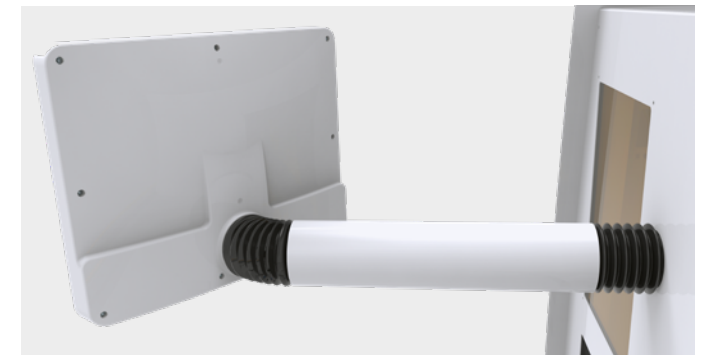
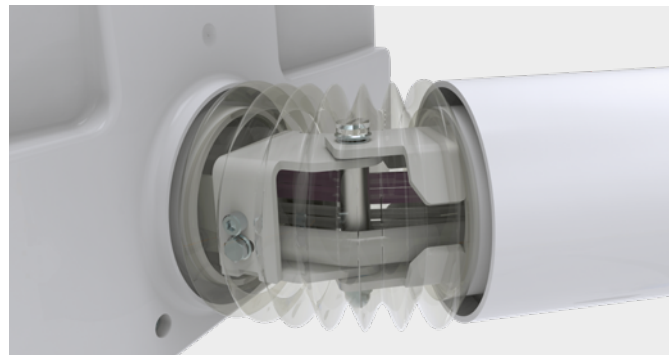


## EDGE CONTROL TOUCH

Extremely simple operation for efficient setup of the machine

Fully automatic operation of the processing units on an ergonomic 21.5" touch display. With Edge Control you keep an overview of all parameters.

- 21.5" HD touch screen
- Graphical user interface
- Rotating and swiveling control panel at eye level
- Simple program call
- Extensive program memory
- Individual selection of the units
- Industrial PC with LINUX OS



## INTELLISET

### Graphic setup aid – without test workpieces

You can see graphically at any time which corrections are made in each direction. The values entered at the control are converted to the actual axis values fully automatically in the background. This makes sample workpieces a thing of the past.

- Easy visual recognition of correction settings through intelligent graphics
- Easy adjustment of the axes in the 0.01 mm range
- Ideal for material with protective film
- Compensation of edge tolerances
- Sample workpieces are not needed



## FA.S.T. SETTING-TECHNOLOGY

All capacities are fully utilized

### FAST-SETTING-TECHNOLOGY

- Efficient edgebanding by "setting up in the gap"
- Various machining operations can be run simultaneously
- No more waiting to run the machine empty



## ECO MODE

The intelligent energy management for HOLZ-HER edgebanders

This energy saving mode is an automatic standby circuit that puts all drives out of operation as soon as no workpiece is fed into the machine. The motors comply with the new energy efficiency class IE 3. If no workpiece is entered for a longer period of time (6 minutes), the heating of the glue station is also switched off automatically. The machine then no longer consumes energy.



## BARCODE SCANNER

### Smart Factory

HOLZ-HER's compact labels contain all the information the operator needs. The appropriate edging program can be called up via the applied DataMatrix code. The machine automatically sets up all units and pressure gauges (with adaptive pressure and adhesive quantity control).

- Standard scannable barcodes:
  - Code 39
  - Code EAN 128
- Scannable 2D codes:
  - DataMatrix
  - PDF417
- Networking with industry software
- Calling up the edge programs by barcode
- Individual QR codes for each edge
- Fully automatic setup of the machine



## VIACOCKPIT – HOLZ-HER MACHINE MONITORING

Full transparency for your  
future workshop

Productivity shown transparently on the master  
computer and also on your mobile device, moni-  
tor and analyze at anytime.

The WEINIG App-Suite and viaCockpit offer you  
the possibility to always keep an eye on your  
production flow and material management. The  
system enables the monitoring and evaluation  
of order data, increases production reliability  
through maintenance instructions and optimizes  
production. Thanks to open interfaces, the  
system is future-proof and can be seamlessly  
integrated into existing IT landscapes.

The viaConnector Edge is your link between the  
machine and the viaCockpit. It offers you con-  
venient access to your machine data and makes  
it available locally or in the cloud at a destination  
that you define individually.

### EXPORT



For advanced data analysis, viaConnector  
Edge lets you export your collected data as  
a CSV file for transfer to ERP or SQL data-  
bases at the touch of a button.



#### viaMonitor

For monitoring and  
evaluation



#### viaNotify

Reports possible  
errors



#### viaOrder

Provides an over-  
view of the order  
progress



#### viaMaintain

Informs about due  
maintenance



#### viaCondition

Optimizes machine  
utilization

## RETURN-MASTER 5920

### Your entry into convenient material handling

Automation is becoming increasingly important even in smaller workshops, to ensure they remain competitive and operate profitably. The RETURN-MASTER sets the stage for automated edgebanding, regardless of whether mass production or batch one. This HOLZ-HER return system provides for efficient one-person operation for higher productivity and maximum flexibility.

- One-man operation
- Manufacturing cell with fully integrated safety concept
- Sturdy construction, low maintenance and durable

#### CONNECTION PACKAGE CONSISTING OF:

- Emergency stop linkage
- Feed adjustment
- Light barriers with control modules
- Adjusted workpiece support
- Safety devices according to valid machine guideline CE compliant



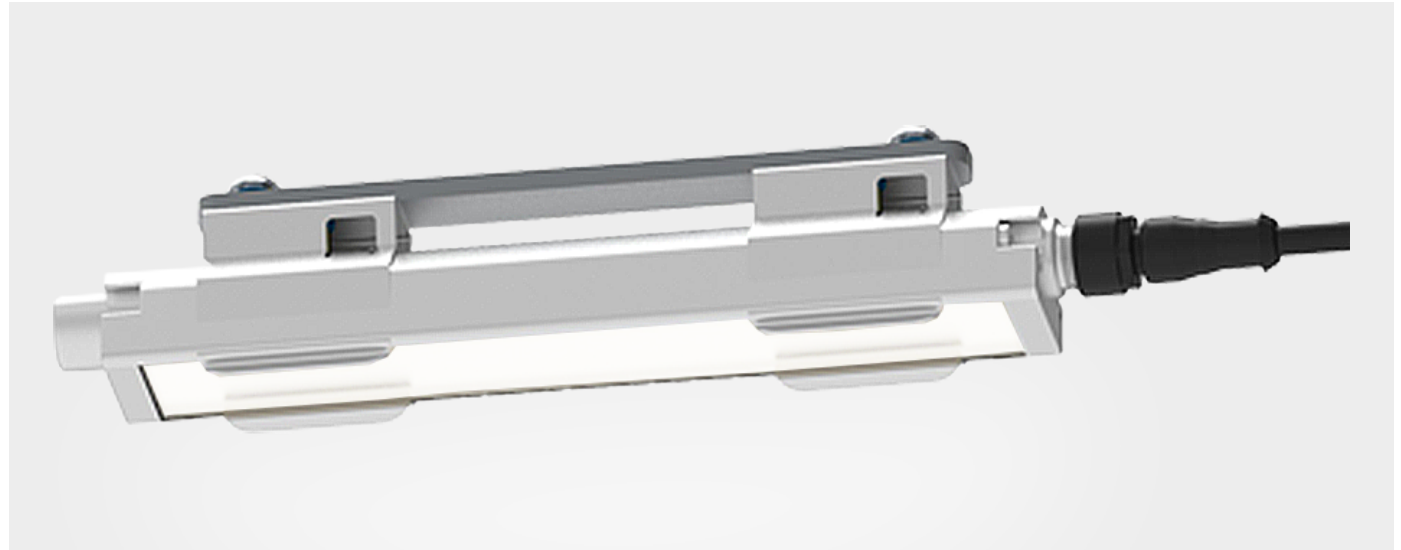
## PROTECTIVE HOOD AT INFEEED AREA

Continuous design with multiple  
protection function

The protective hood provides additional noise  
protection. Airborne dust in the infeed area is  
avoided, especially in dusty production areas.  
The pressure unit remains protected and perma-  
nently ensures that the highest demands are met.

- Additional noise and dust protection
- Optical upgrade of the machine
- No CE obligation





## LED LIGHTS

Modern LED technology with tempered, shatterproof glass

- In the infeed and finishing areas
- Explosion proof safety glass
- Optical workpiece sequence display on the locking roller
- Machine status display (malfunction, emergency stop, etc.)

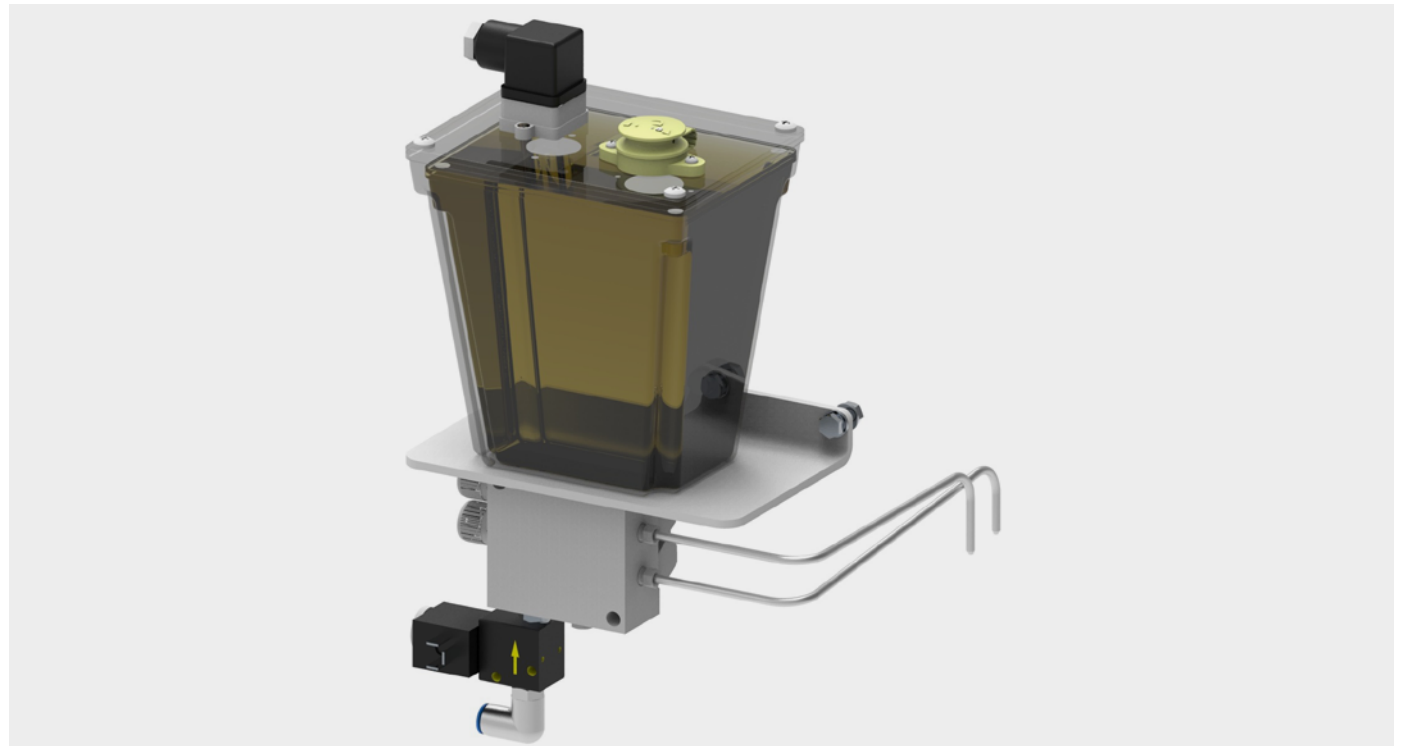




## AUTOMATIC CHAIN LUBRICATION

- Intelligent automatic transport chain lubrication
- Sensor-controlled unit, for metering lubrication to match load

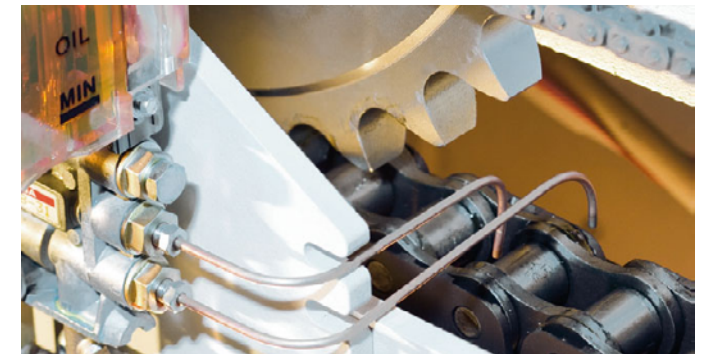




## INJECTION LUBRICATOR

For lubrication of the links and pins on the roller chain.

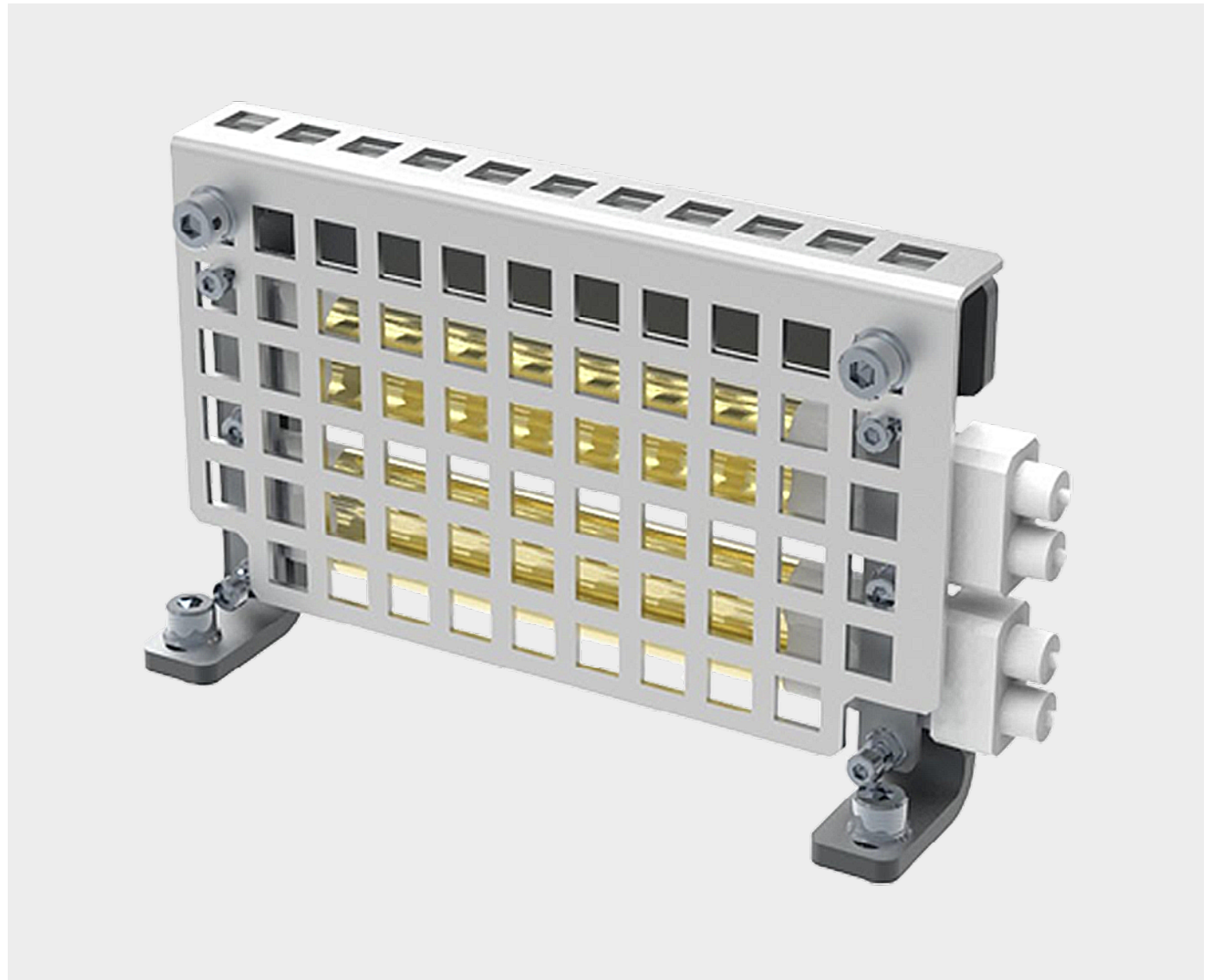
- Incl. operating hours counter for automatic lubrication cycle
- Filling capacity approx. 1 litre
- Increases the longevity of the transport chain



## INFRARED HEATER ZH701

The IR heater heats the front edges of the workpieces before the glue is applied. Temperature and glue strength are always related. The panel temperature should not be below 15°C for edging. Especially during the cold season when panel material is moved from different locations. In the worst case, the panel material is not yet warm enough. Preheating the workpiece edge ensures the correct temperature and can be decisive in terms of glue strength.

- Heats panel edges to the ideal temperature before glue application
- Better adhesion
- Especially useful in cold workshops



## ITRONIC

Your intelligent edge assistant!

At the push of a button, the gluing station is spotlessly clean. Always know what's left with the residual adhesive quantity monitor. Whether thin edge or thick veneer edge – always the right power at the guillotine. Solid wood or thin edge – the pressure combination at the pressure unit is always correct.

- Adaptive crosscut knife
- Automatic glue quantity control
- Automatic flushing and cleaning cycle
- Automatic pressure unit
- Residual adhesive quantity monitoring




The advertisement banner features three icons at the top: a guillotine blade, a pressure unit with three circles, and a cleaning cycle with horizontal lines. Below these icons is the text: "ADAPTIVE CROSS-CUT KNIFE. AT THE PUSH OF A BUTTON, THE GLUING STATION IS SPOTLESSLY CLEAN." To the right, the text "iTronic inside" is displayed in a large, stylized font. The main image shows a white and orange industrial machine with a control panel and a circular orange component. On the right side of the machine, there are two inset diagrams: the top one shows a guillotine blade cutting a piece of wood, and the bottom one shows a pressure unit with a "74 m" label and a bar graph.



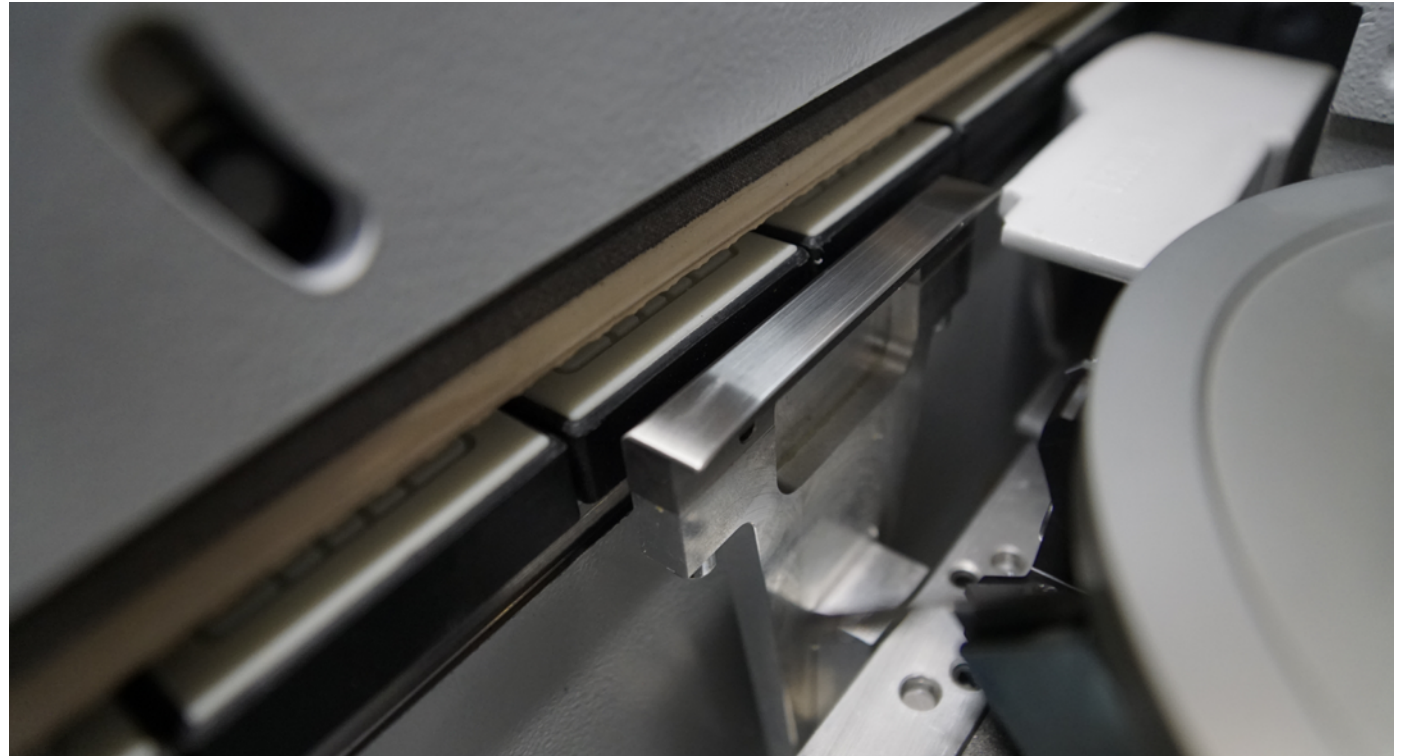
## NESTING TRACER SHOES

For clean and uniform tracing, of already machined workpieces after nesting or CNC machining. At the cutter unit and the radius scraper unit tracer shoes are attached to the underside in place of the tracing rollers.

- For a cutter unit and radius scraper at the underside
- Necessary for hinge holes or larger recesses (nesting process)

Optional

- Top and bottom mounted nesting tracer shoes instead of tracer rollers
- For trapezoidal and pointed workpiece contours
- Also hinge holes and larger recesses



## INFEED FENCE

**WITH 1492 MM LENGTH** designed for precise feeding of very long and heavy workpieces to the pre-milling unit. Easily adjustable via precise SIKO counters. Solid stop on durable, low-maintenance linear guides.

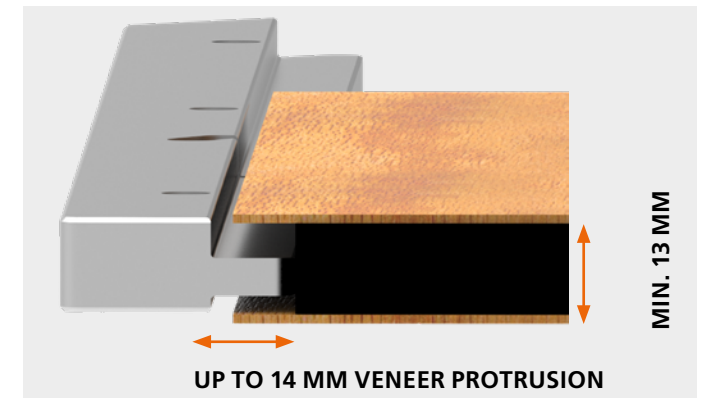
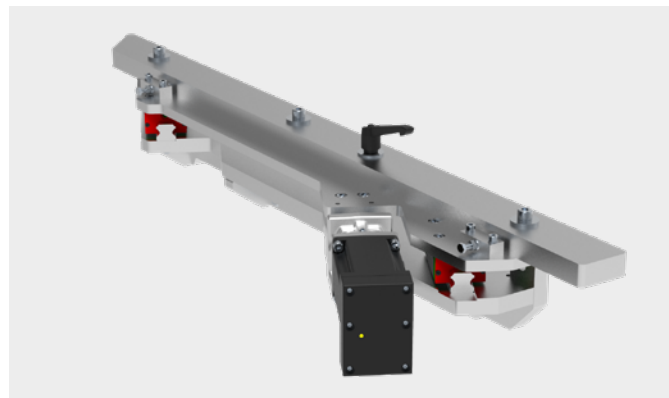
Your upgrade options

### MOTORIZED ADJUSTMENT

- Automatically adjustable via the control unit
- Edge thickness can be set individually as pre-milling dimension resulting in a correctly sized panel

### VENEER STOP

- For guiding materials with protruding face veneer



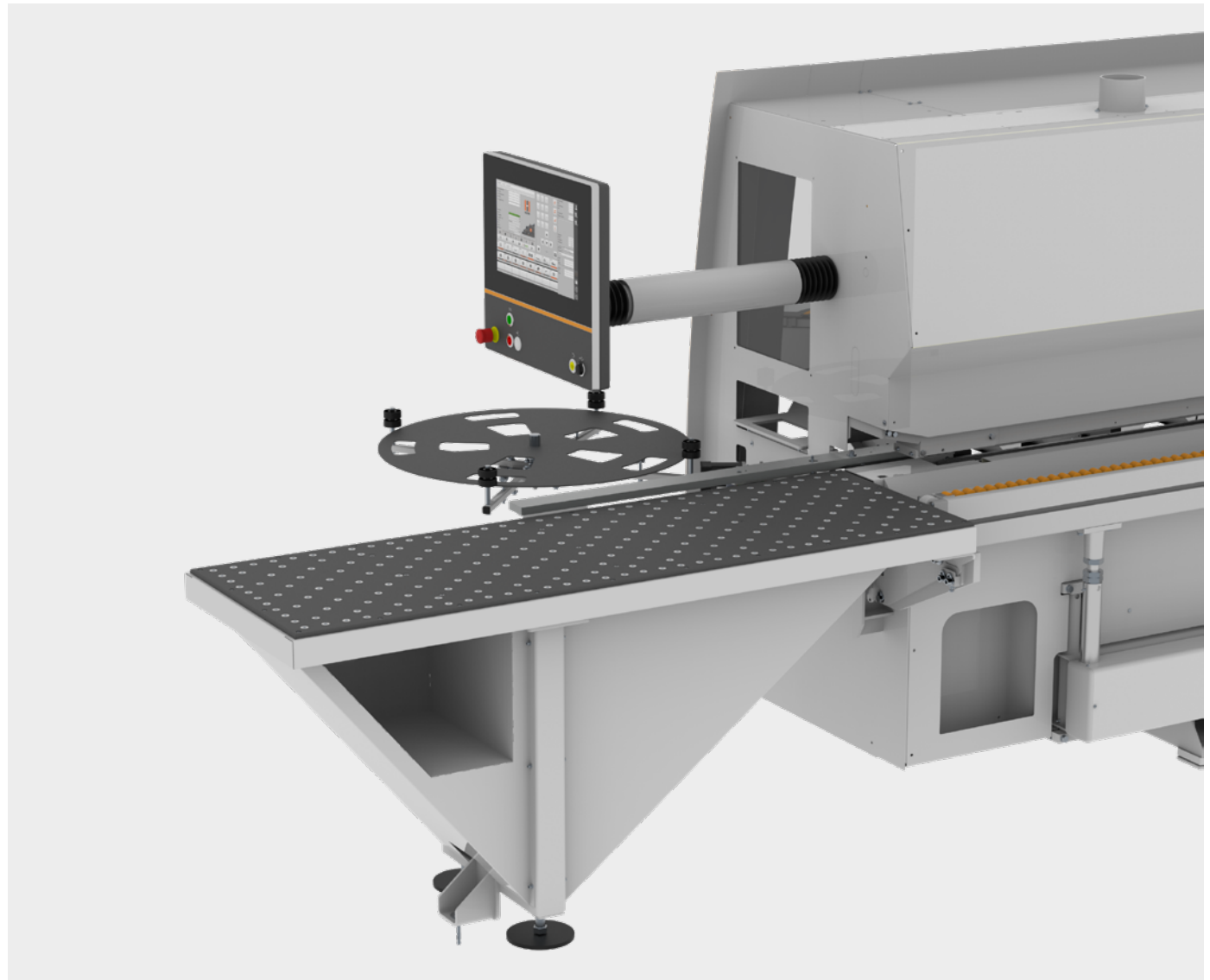
## AIR CUSHION TABLE

Easy and gentle material handling

Additional table to the machine infeed for easy and gentle material handling. Generated air cushions provide a floating material feed.

**LENGTH:** 1800 mm, **WIDTH:** 600 mm

- Height adjustable frame feet
- Fully integrated air nozzle
- Ideal working height (880 – 900 mm)
- Safe infeed of long components
- Fully controlled via the control panel



## POWERFEEDER

### Infeed roller apparatus BS702

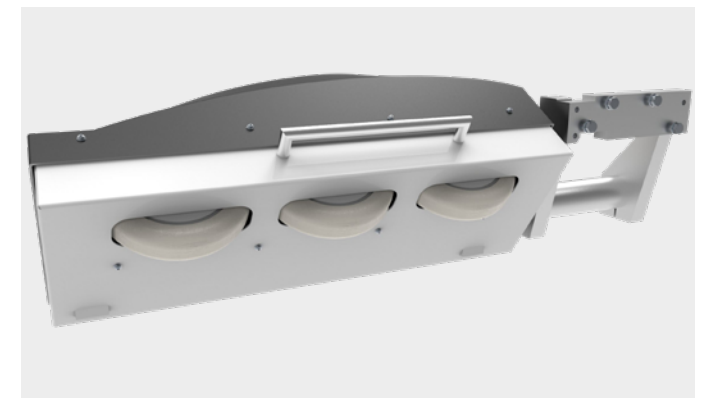
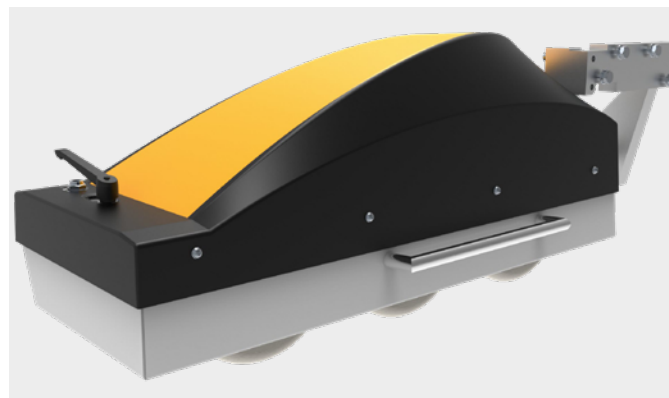
The primary purpose of the infeed roller unit is to guarantee that workpieces are in contact with the infeed fence and are precisely guided to the pre-milling unit. Especially with high quantities, as well as with large-format panels, the operator is strongly supported. Input errors are avoided.

Synchronously running to the feed speed of the transport bridge, the workpiece is gently guided into the machine via rubberised, air-filled pressure tyres at a 3° angle against the infeed guide.

The device is attached to the pressure bridge of the basic machine, it can be adjusted as required and permanently maintains the correct setting height.

#### IDEAL IN COMBINATION WITH THE AIR CUSHION TABLE

- Feeding aid that is gentle on the material
- Contact pressure can be adjusted via a clamping lever
- Pivotable via handle



## GUIDANCE SYSTEM

### BS703

With the guide device, narrow and long workpieces can be fed into the machine at exactly the right angle for end face edging.

The feed rate is automatically reduced to 12 m/min so that perfect machining can take place on the narrow surface.

### FUNCTIONALITY

The workpiece is pressed manually against the stop blocks and the infeed guide until it is in contact with the transport chain. After the workpiece has been gripped by the transport chain, the stop blocks move upward with distance control. Subsequently, the guiding device is automatically returned to the operator for the next workpiece.

- Feed rate is automatically reduced to 12 m/min
- On high quality linear guides
- Fold away

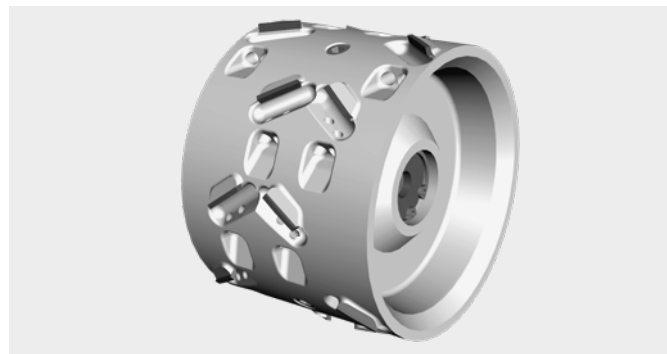
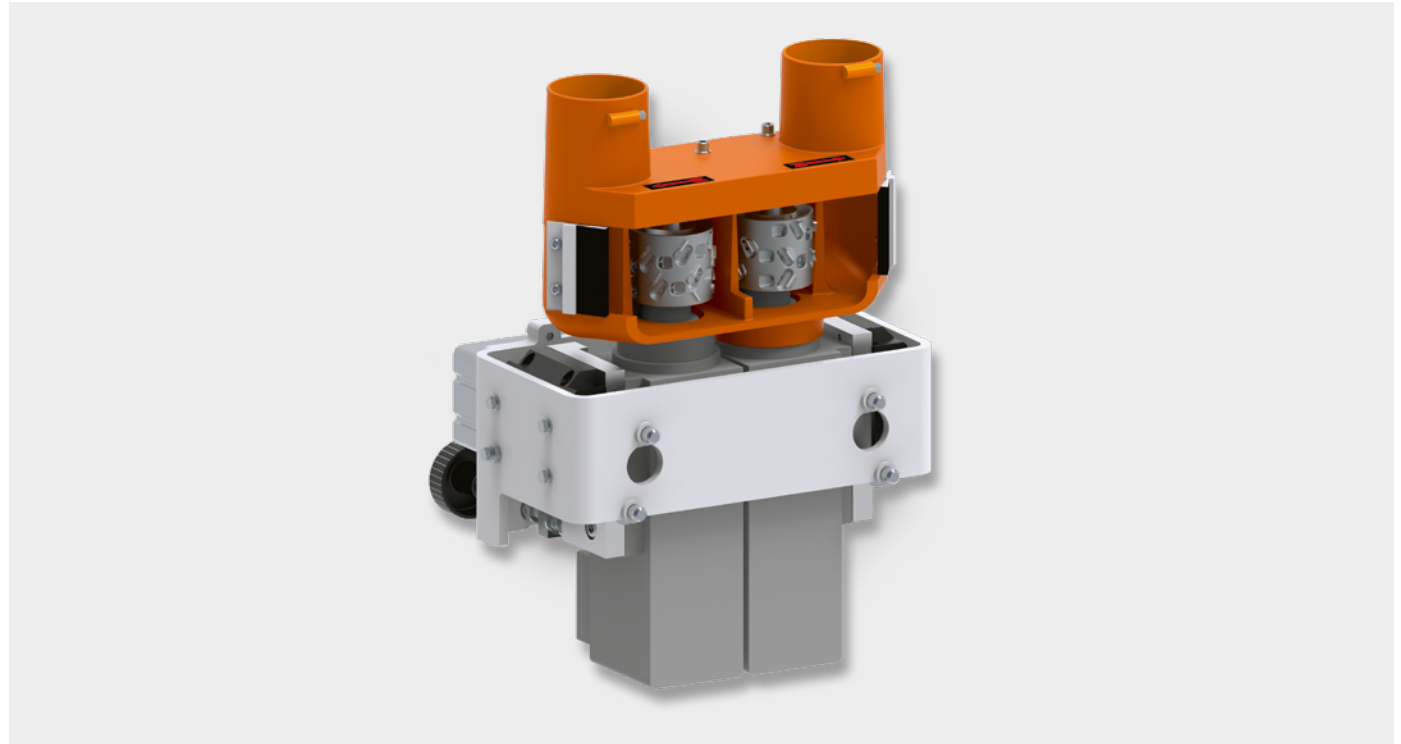


## PRE-MILLING UNIT FG501

Excellent cutting quality during pre-milling

Cut edges often have small tears in the top layer. The pre-milling unit ensures perfect gluing surfaces and prepares the panels for gluing. Equipped with the patented Air-Stream technology and diamond tool. Including height adjustment for optimum cutter utilization.

- Twin-motor pre-milling
- 1 x clockwise / 1 x counter clockwise operation
- Incl. diamond cutter, Ø 70 mm
- Air-Stream technology – HOLZ-HER / LEUCO patent
  - Quiet operation
  - Up to 99% chip capture
  - Significantly reduced double chipping
  - Long service life and low maintenance

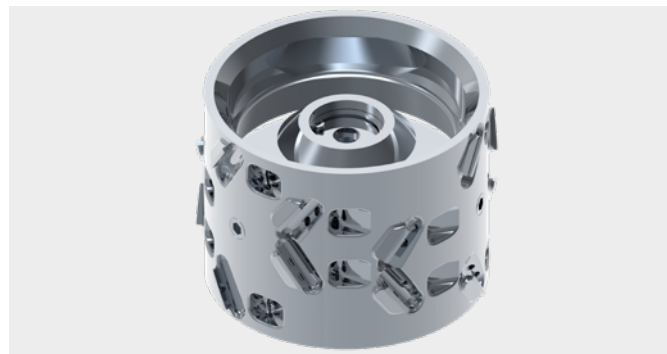
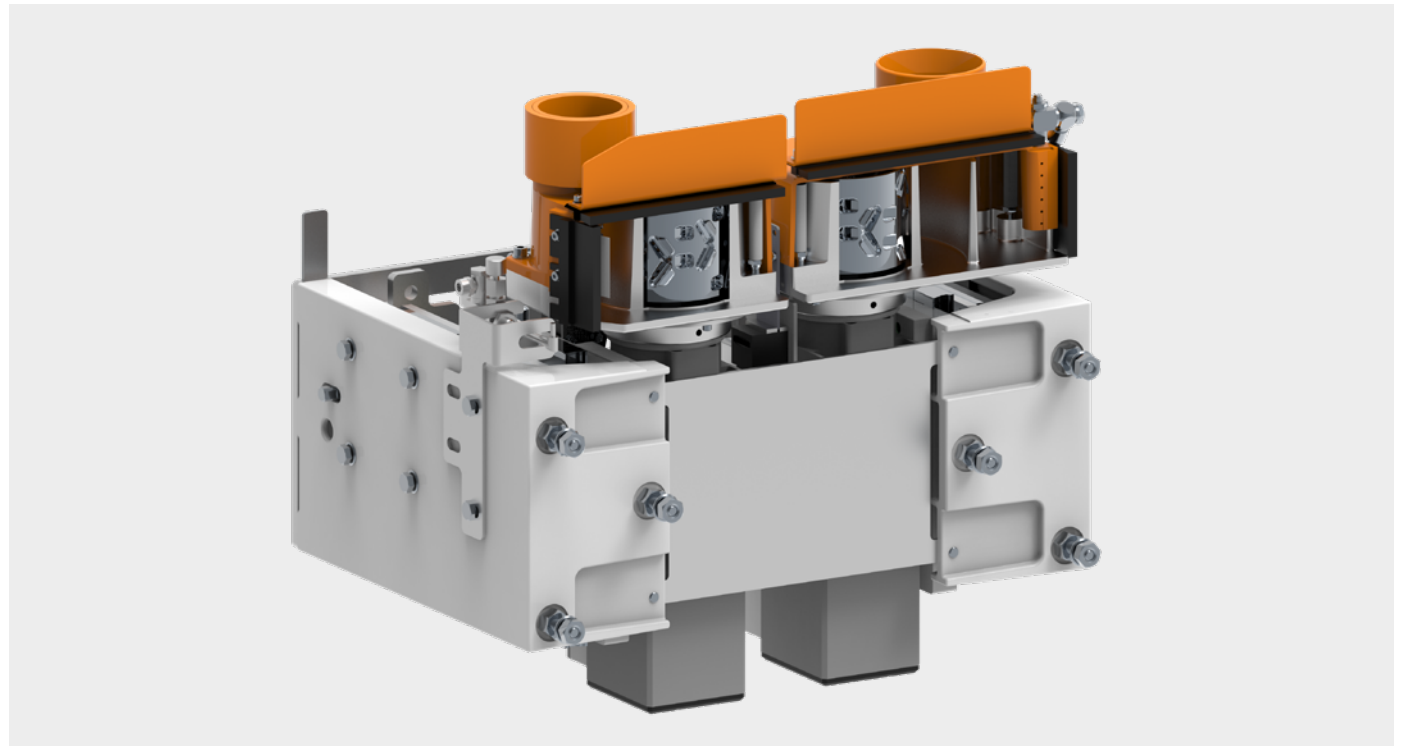


## PRE-MILLING UNIT FG701 MOT2 HSK32R

The motor-driven height-adjustable milling units have a HSK32R tool holder, which ensures high concentricity in a particularly force-locking and form-fitting manner. In combination with the patented Air-Stream technology, the two 100 mm milling heads with their diamond cutting tips mounted at 35° produce the best pre-milling results even at high feed rates.

Due to the plunge control of the milling units chipping at the corners is specifically avoided.

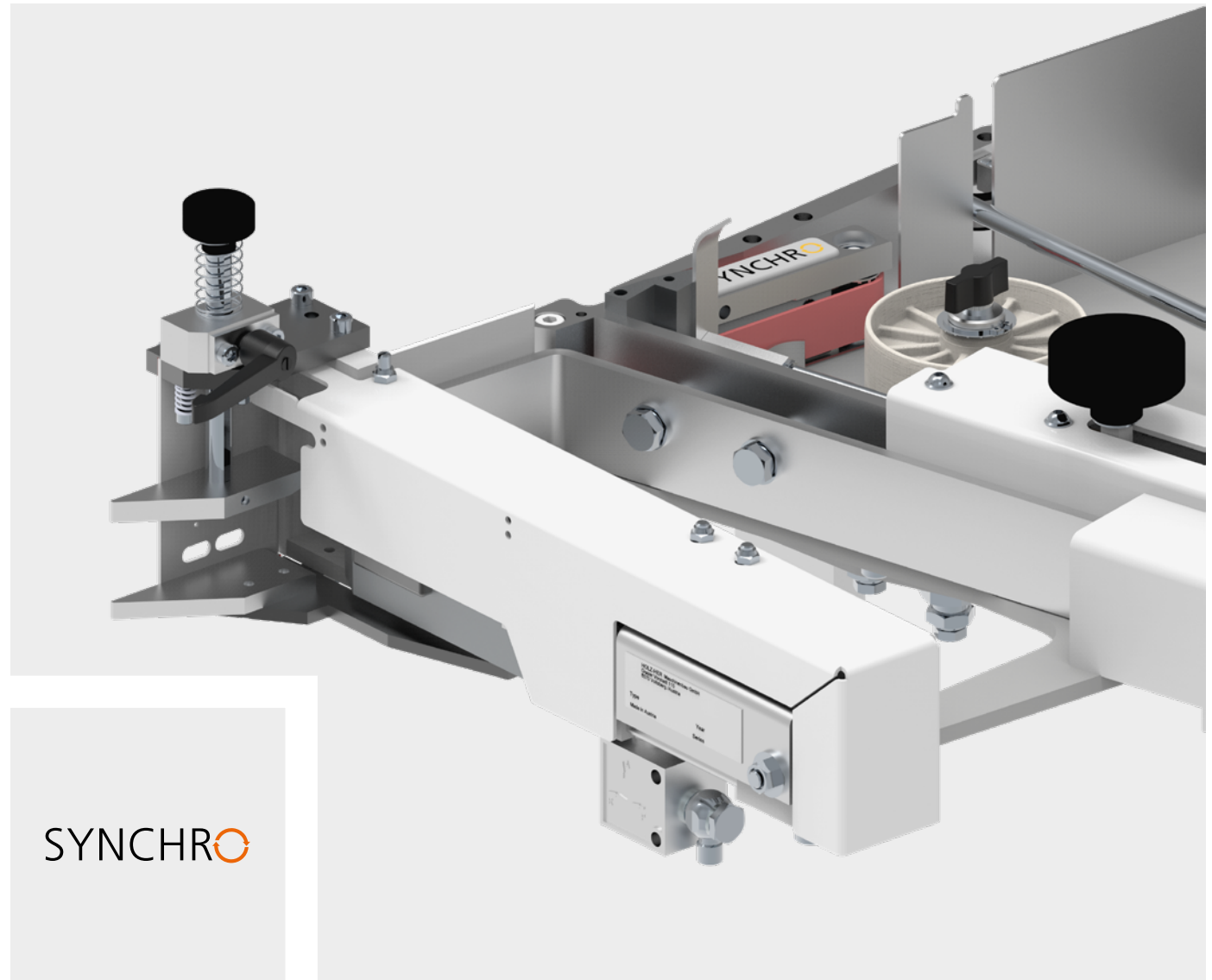
- Motorized height adjustment
- Immersion controlled aggregates
- HSK32R coupling
- Diamond cutter, Ø 100 mm
- 1 x clockwise / 1 x counter clockwise operation
- Air-Stream technology – HOLZ-HER / LEUCO patent
  - Quiet operation
  - Up to 99% chip capture
  - Significantly reduced double chipping
  - Long service life and low maintenance



## EDGE FEEDING MG705 SYNCHRO

The magazine guarantees short workpiece distances by synchronous adaptation to the feed rate and at the same time optimizes edge protrusions. Slight infeed angle due to the nozzle concept – problem-free feeding of solid wood edges up to 15 mm.

- Flush trimming in standard up to 8 mm
- Automatic transport of coils and strips
- Automatic adaptation to the feed rate
- Pre-trimming up to 65 mm edge height
- Without any slippage due to drive belt
- Adjustable edge protrusion
- Low infeed angle allows perfect processing of solid wood lipping



SYNCHRO

## EDGE FEEDER MG705 MOT3 SYNCHRO

The edge feeder has 3 NC servo axes and automatically adjusts to the appropriate edge height and thickness.

Due to the synchronous adaptation to the feed rate, short workpiece distances can be realized without slippage.

- Motorized height and width adjustment
- Automatic adaptation to the feed rate
- Automatic transport of coils and strips
- Roll material: 0.3 – 3 mm edging thickness
- Pre-trimming up to 65 mm edge height
- Shallow infeed angle allows perfect processing of solid wood lipping
- Solid lippings up to 20 mm thick
- Pre-loading magazine for 150 mm strip material
- Without any slippage due to drive belt
- Adjustable edge protrusion

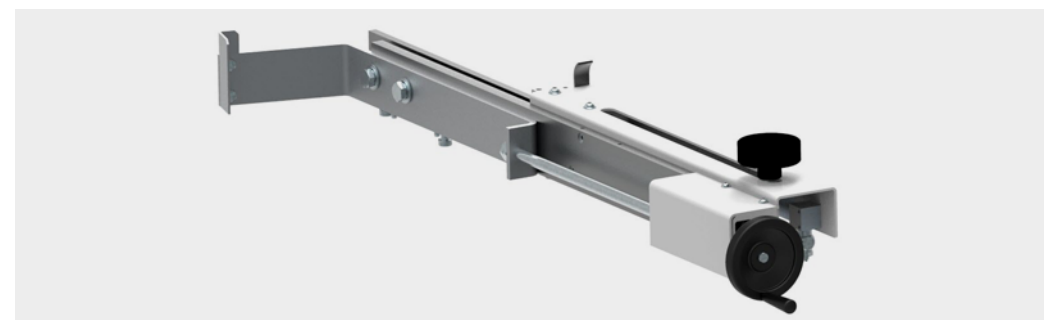
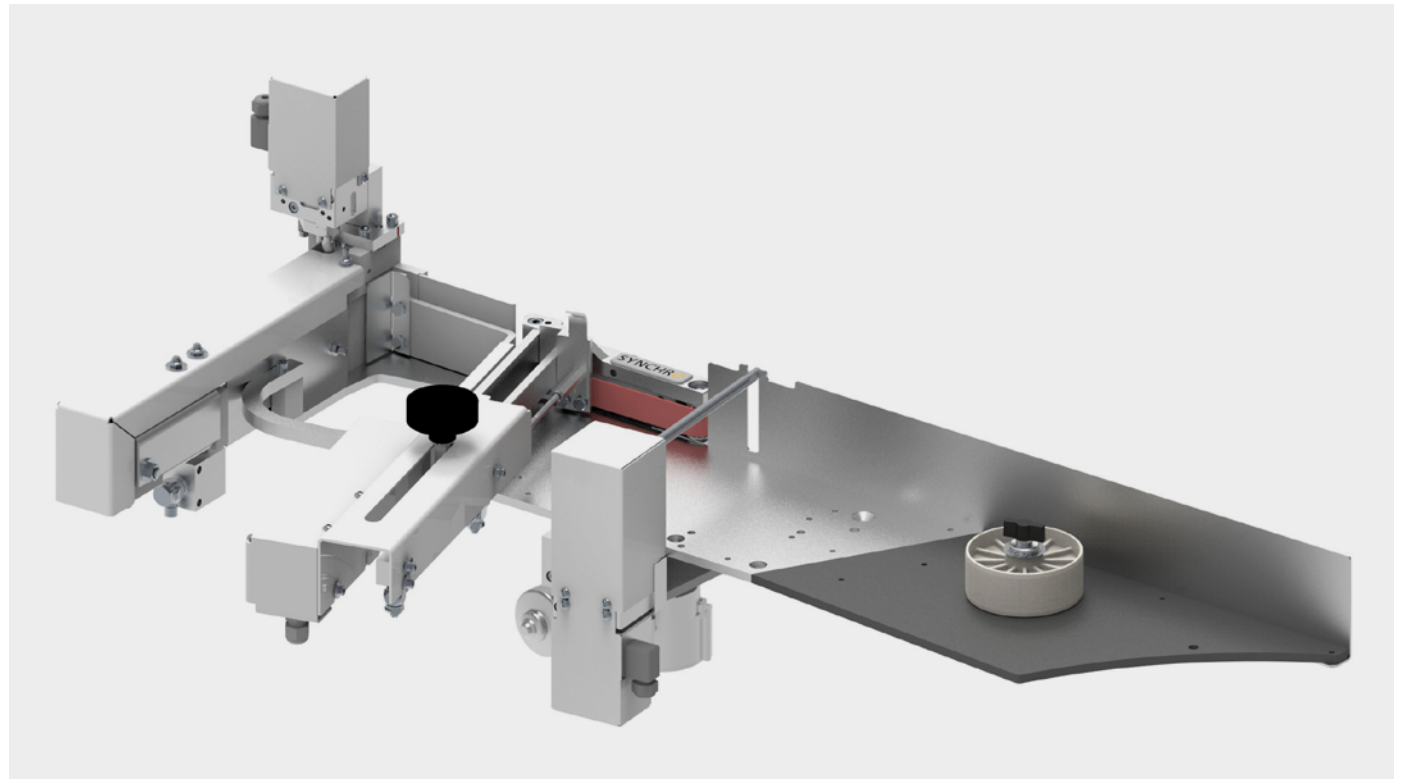
Optional

### MAGAZINE EXTENSION FOR STRIP MATERIAL

Extends the edge magazine to 300 mm.

### NOTICE!

- Front protective hood not possible



## GLUE APPLICATION SYSTEM

### The heart of the edgbanding machine

With the Glu Jet-Hybrid-Technology from HOLZ-HER, you can process EVA and PUR glue in one system as standard. Via the 3-fold heating system, consisting of ring heater, main heater and nozzle heater, the Glu Jet is ready for use within 3 minutes. Valuable production time is gained and energy costs are reduced as a result.

- **Zero joint with thin-film technology**

With the HOLZ-HER Glu Jet system, you can process PUR glue on a standard basis; just as simply as EVA glue

- **Fast and uncomplicated changeover**

From EVA to PUR and from cartridge to granule form

- **A clean machine**

The sealed system prevents the glue from burning, ensuring that it maintains its original colour and does not emit any adhesive vapor

- **Remaining glue quantity indicator**

The operator knows how many running meters can still be produced at all times

- **Sensor controlled automatic reloading**

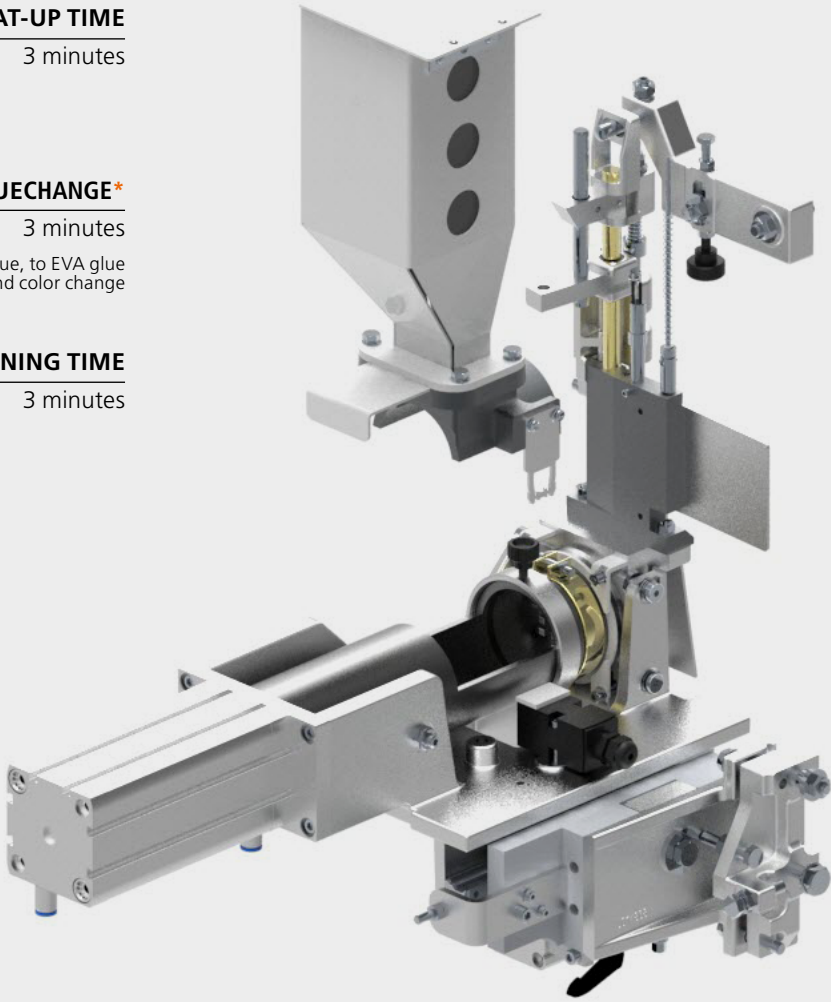
- **Just-in-time heat-up**

The complete gluing unit is fully ready for use in 3 minutes

- **100% adhesive strength**

By melting the adhesive as required


- **Low maintenance system**



**HEAT-UP TIME**  
3 minutes

**GLUECHANGE\***  
3 minutes  
\* to PUR glue, to EVA glue and color change

**CLEANING TIME**  
3 minutes

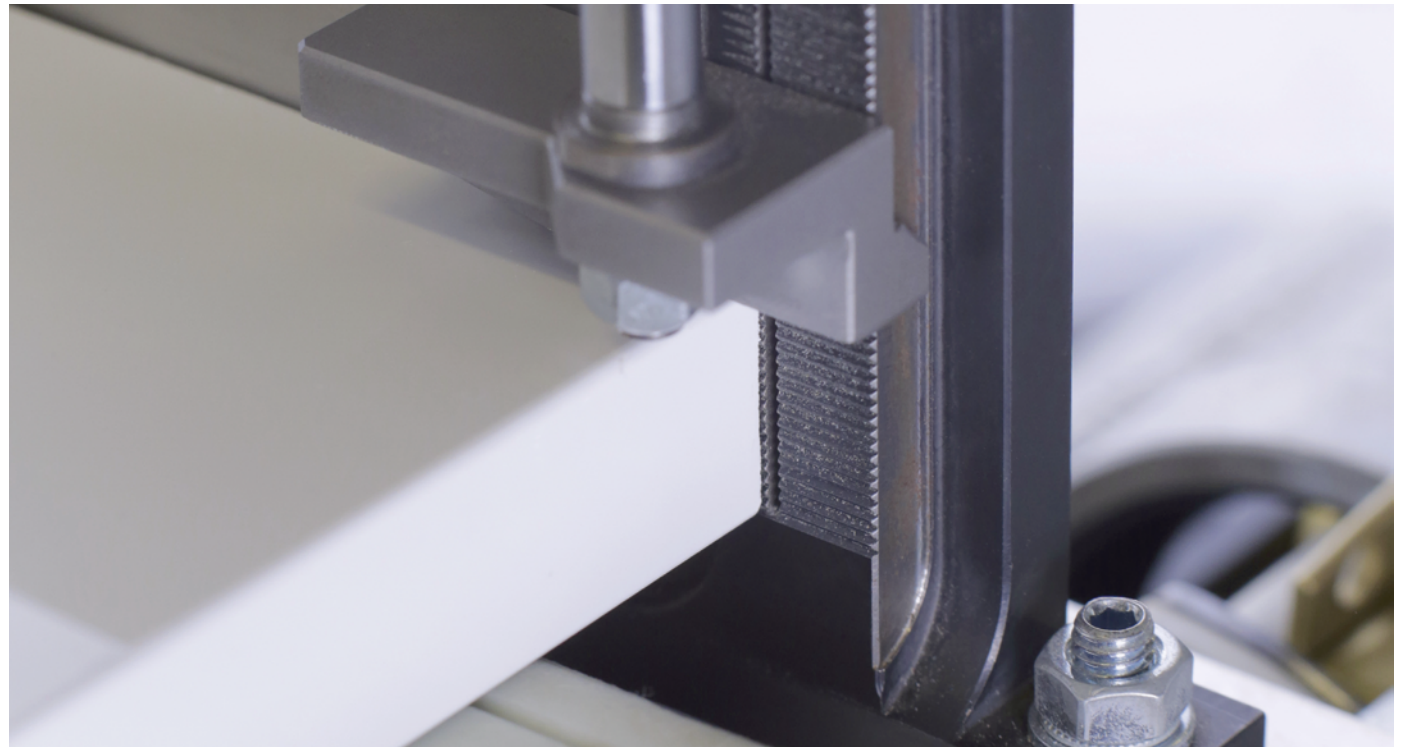


## GLUE APPLICATION SYSTEM

### Precision at the highest level

GluJet automatically adapts to all common panel thicknesses worldwide via the optimized nozzle segmentation. Tolerances in the panel thickness are compensated by the tracing nozzle. The sensing shoe is spring-loaded and opens the nozzle exactly to the sensed panel thickness. The GluJet thin film technology means the glue penetrates deep into the panel structure. You get a high strength joint and an invisible joint at the same time. Due to the 90° separation in 1 mm increments, the glue can spread evenly during edge pressing. For example, 19 glue lines are applied to a 19 mm panel, each forming a valley towards the outer edge of the panel. With this ingenious combination, the glue does not form above the joint.

- Zero joint with thin film technology
- Clean and clear nozzle application system in 1 mm increments, for uniform homogeneous glue application
- The amount of glue is exactly as required. This saves costs and increases quality
- Tracing nozzle for precise glue application

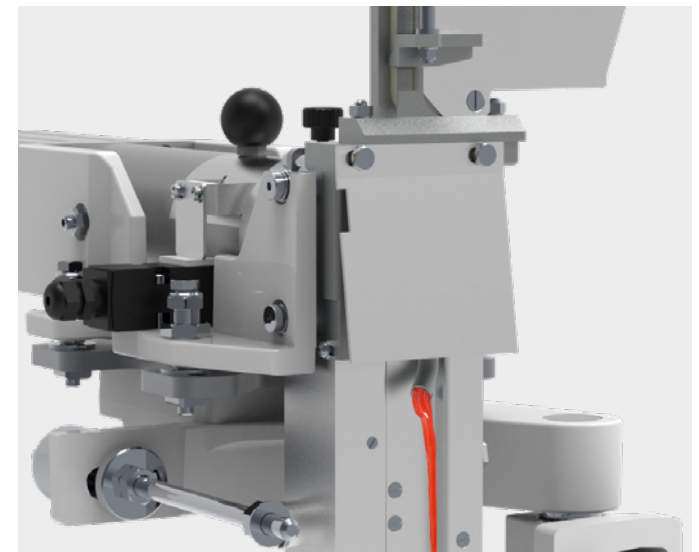


## CLEANING

### Simple, clean and uncomplicated

With the help of special cleaning cartridges or granules, the chemical process of the PUR is stopped by means of a neutralizer. For better identification, the cleaner is colored and can be easily distinguished from the glue. The rinsing process is performed by pressing a button on the touch display. Optionally, the entire cleaning process can be controlled with the use of iTronic, ensuring a high level of operating safety. The complete system is thoroughly and completely cleaned with the correct temperature as well as the appropriate pressure and optimized cycle. An integrated purge hole in the metering rod directs residual glue or cleaner into the collection container in a clearly visible manner and can then be conveniently disposed of. When using PUR glue, cleaning of the system is required after 48 hours. It is easy to conserve the system over periods of non use.

- In a few minutes the complete system is completely cleaned
- PUR adhesive always under control
- Guided process (with iTronic option)
- Fast and uncomplicated changeover from EVA to PUR and from cartridge to granule form

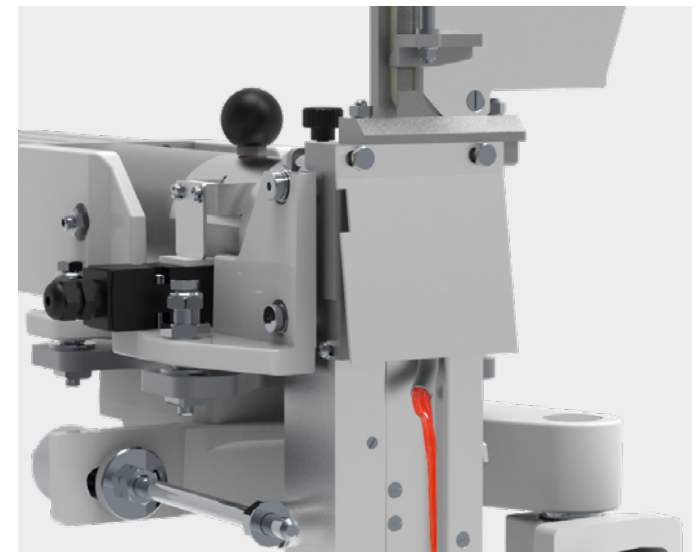


## CLEANING

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- In a few minutes the complete system is completely cleaned
- PUR adhesive always under control
- Guided process (with iTronic option)
- Fast and uncomplicated changeover from EVA to PUR and from cartridge to granule form



## GLU JET COLLECTION CONTAINER

Catches PUR and EVA

When rinsing, larger glue residues are produced, which are collected within the container. A soft glue-repellent insert made of silicone ensures a permanently clean tub. This saves annoying and expensive cleaning work and ensures a clean machine appearance.

- Integrated in the machine
- For collecting glue residues during the rinsing process
- Capacity for four 300 gram cartridges
- A heat-resistant non-stick silicone insert ensures easy emptying of the container
- This reduces the cleaning effort enormously



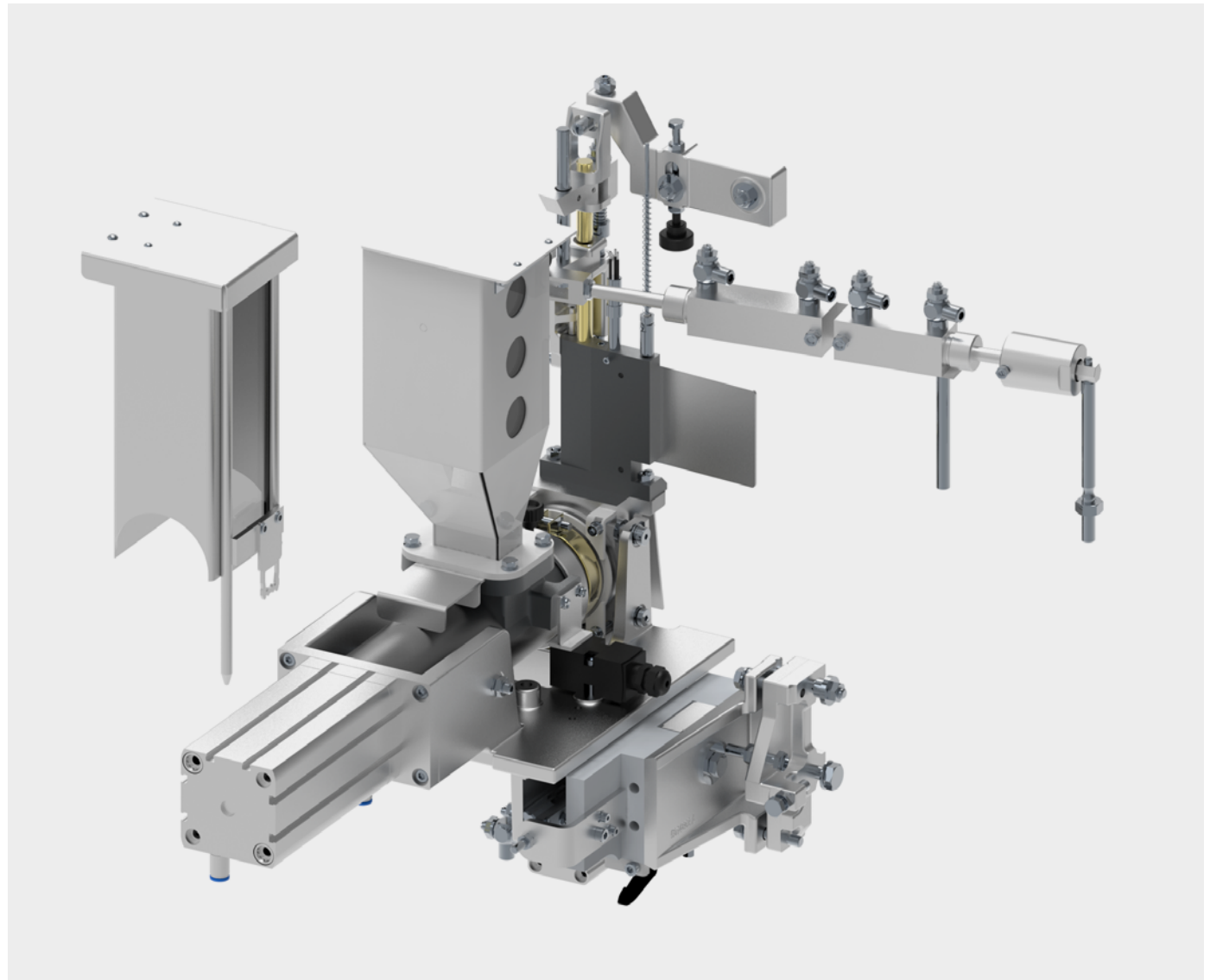
## GLUE APPLICATION

### Glue application system Glu Jet GJ301 automatic

For industrial processing of EVA- and PUR-Glue cartridges of approx. 0.3 kg or use granules. The practical hoppers can be used to preload sufficient glue, which is automatically reloaded by sensors. The Glu Jet automatic moves independently to the glue or rinse position. An extremely practical function, especially when no glue is to be applied during machining.

#### ■ Glu Jet-Hybrid-Technology

- All advantages of the HOLZ-HER Glu Jet system
- Automatic glue height adjustment via tracing nozzle
- Automatic positioning to glue or rinse position
- Incl. cartridge hopper for 4 cartridges (approx. 1.4 kg)
- Incl. granule hopper for approx. 1.5 kg of granules
- Incl. pressure regulator for automatic control of the cartridge contact pressure
- Low maintenance

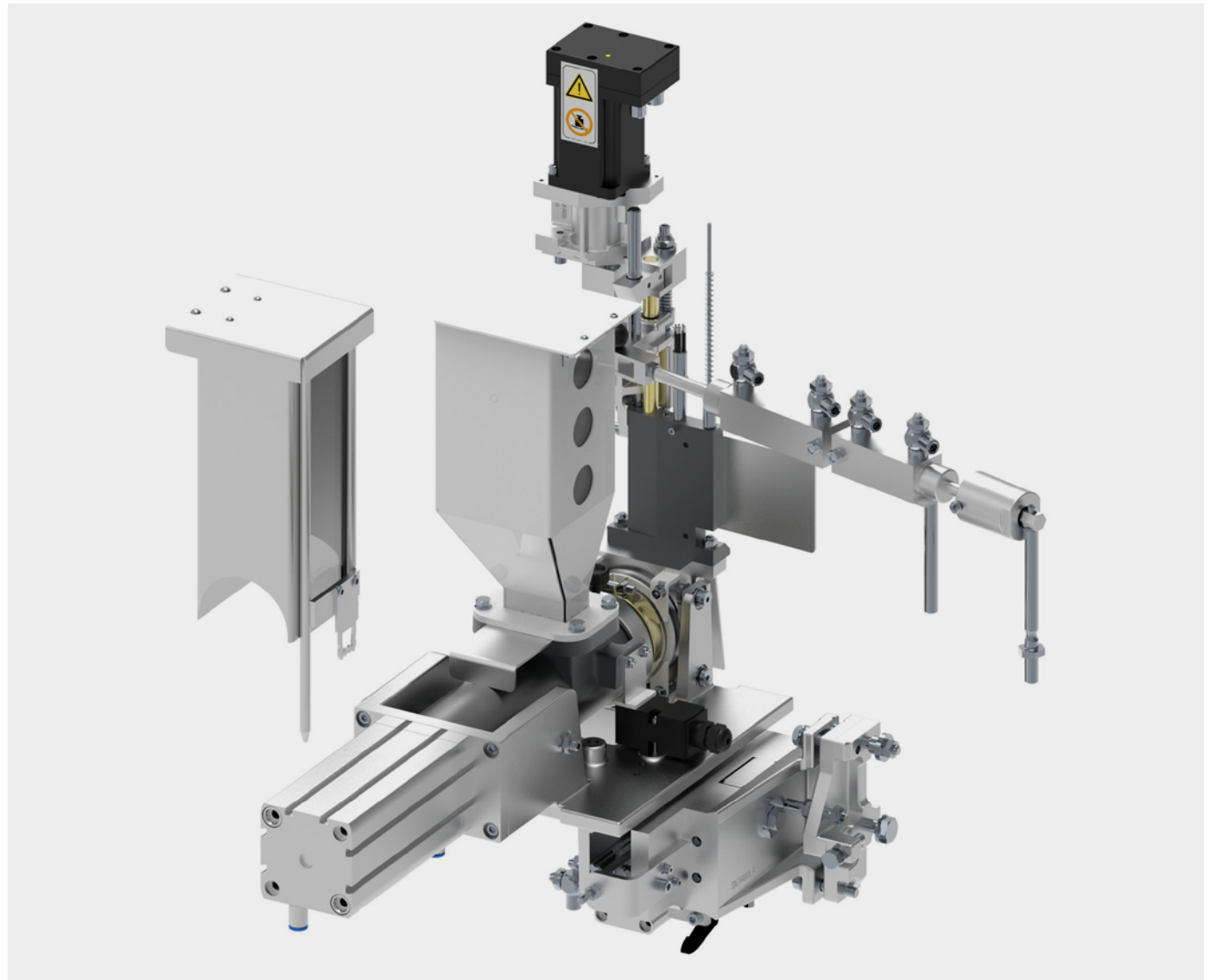


## GLUE APPLICATION

### Glue application system Glu Jet GJ301 automatic NC

With the NC servo axis, the glue height adjustment can be carried out independently of the machine bridge. An added value for highly sensitive panel surfaces. The Glu Jet automatic moves independently to the glue or rinse position. An extremely practical function, especially when no glue is to be applied during machining.

- **Motorized, automatic glue height adjustment**
- **Glu Jet-Hybrid-Technology**  
All advantages of the HOLZ-HER Glu Jet system
- Automatic positioning to glue or rinse position
- Incl. cartridge hopper for 4 cartridges  
(approx. 1.4 kg)
- Incl. granule hopper for approx. 1.5 kg of granules
- Incl. pressure regulator for automatic control of the cartridge contact pressure
- Low maintenance



## PRESSING UNIT

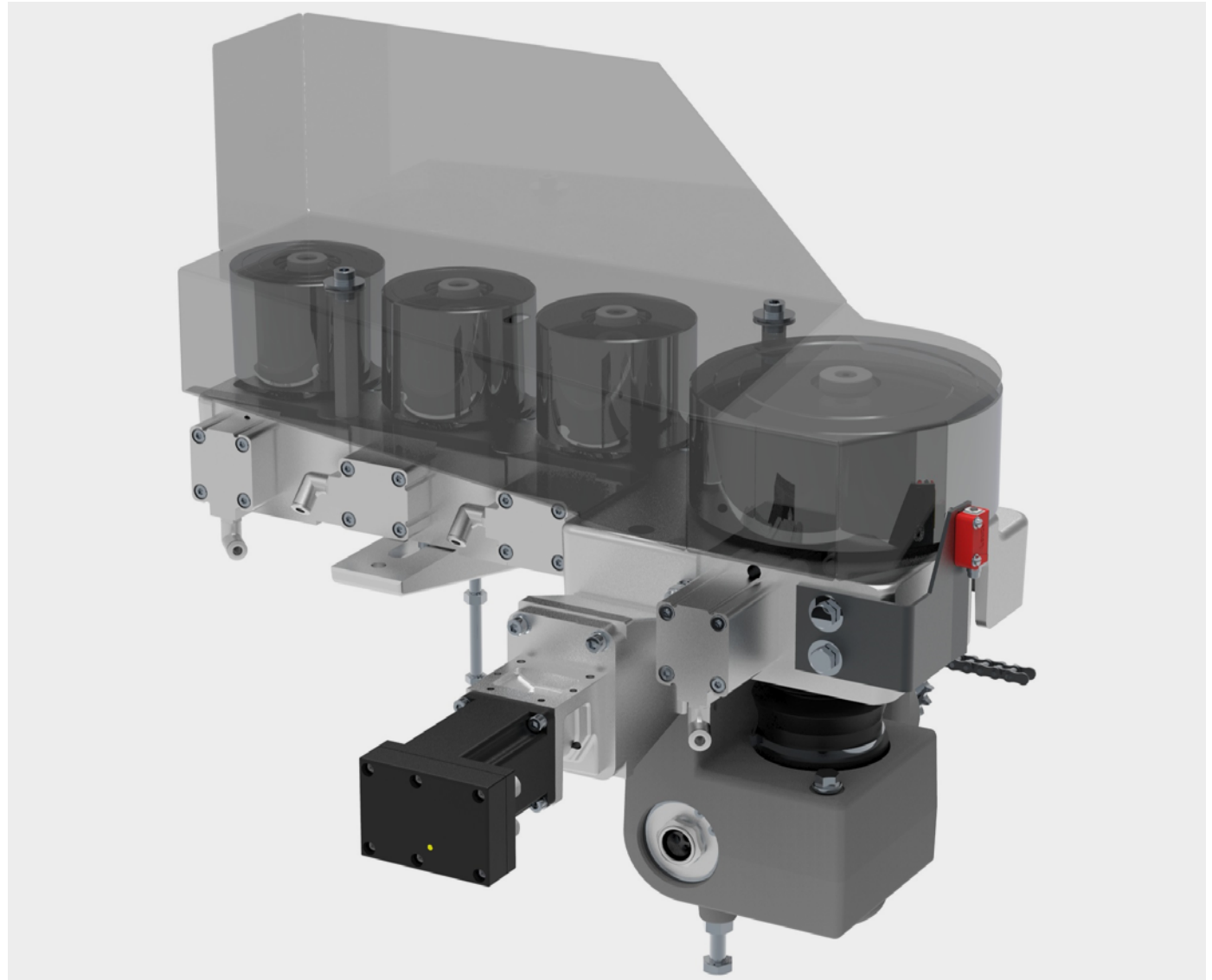
### DW701 MOT

The pressing unit is designed for high feed rates of up to 25 m/min. The first large pressure roller is motor-driven synchronously with the drive chain. 3 additional holding pressure rollers run straight and conical to the workpiece edge, thus ensuring a perfectly closed glue joint.

The pressure rollers are pressed electropneumatically, with each of the 4 rollers being guided separately to the workpiece.

The switch-on and switch-off points of the pressure rollers can be changed via the programmable logic controller. The adjustment to the respective edge thickness is carried out by means of NC servo motor, completely automatically.

- Program-controlled adjustment of the edge thickness
- NC servo axes for motorised adjustment
- 4 insert-controlled pressure rollers

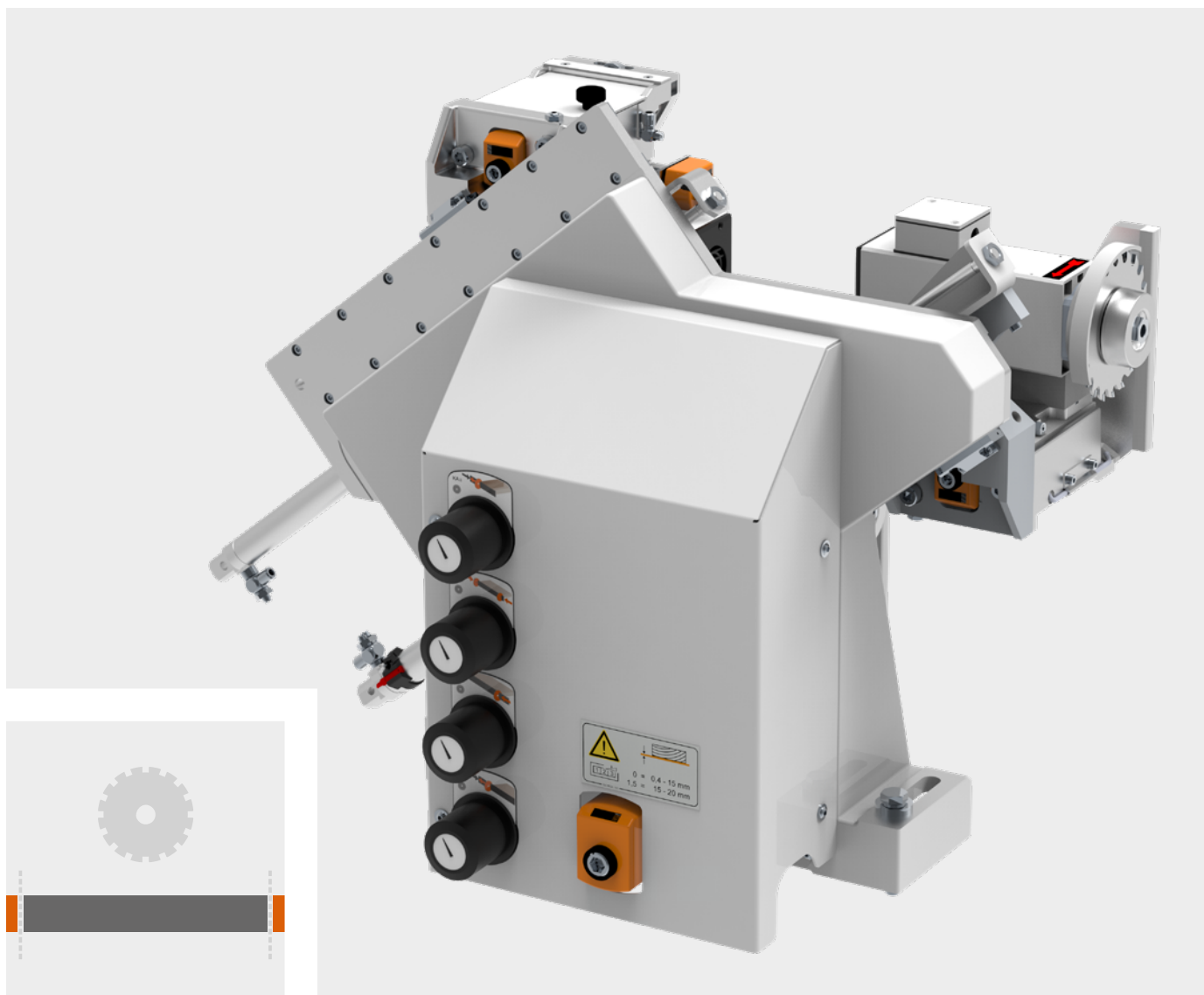


## END TRIMMING UNIT KA702 PNEU

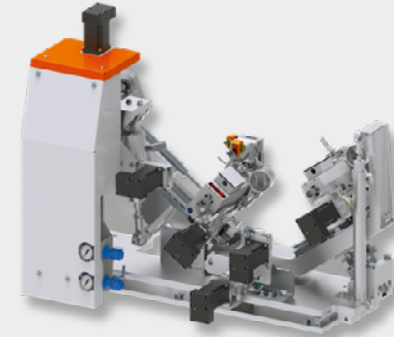
Most powerful end trimming unit in its class

The end trimming unit consists of two separate sawing units that are precisely guided on surface-hardened linear guides. Solid wood edge with a thickness of 15 mm are perfectly sawn flush with this robust unit.

- Surface hardened linear guides
- Max. edge thickness 15 mm
- Two carbide WZ saw blades  
Z 22, Ø 120 mm
- Pneumatic pivot to 10° –  
for thin edges
- Two extraction hoods included
- Optimum workpiece gap due  
to short trim-cut cycles



FF701 MOT6 MULTI



## MULTIFUNCTION PACKAGE

With the package you get continuous and fully automatic multifunctional equipment. Heavy-duty stationary units with multi-stage tools as well as turret tool changers.

- Highest flexibility
- Quick tool profile change
- High-tech aggregates

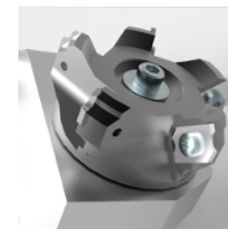
The package consists of:

- **FR701 MOT6 MULTI**  
Milling unit with 5-stage profile tools
- **FF701 MOT6 MULTI**  
Shape milling unit with tool turret for 4 profiles
- **ZK701 MOT8 MULTI**  
Profile scraper unit with 5-fold turret changer

FR701 MOT6 MULTI



ZK701 MOT8 MULTI



## CUTTER UNIT FR701 MOT6

### Perfect results at high feed rates

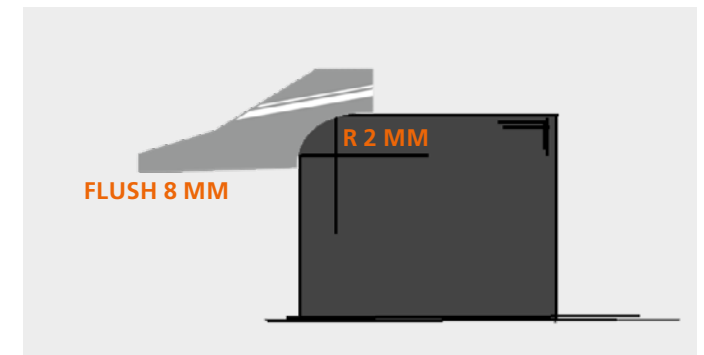
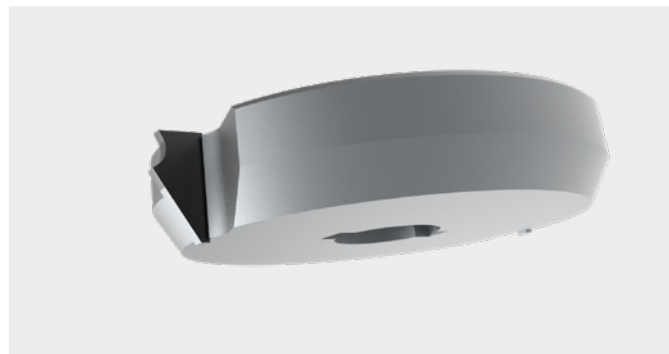
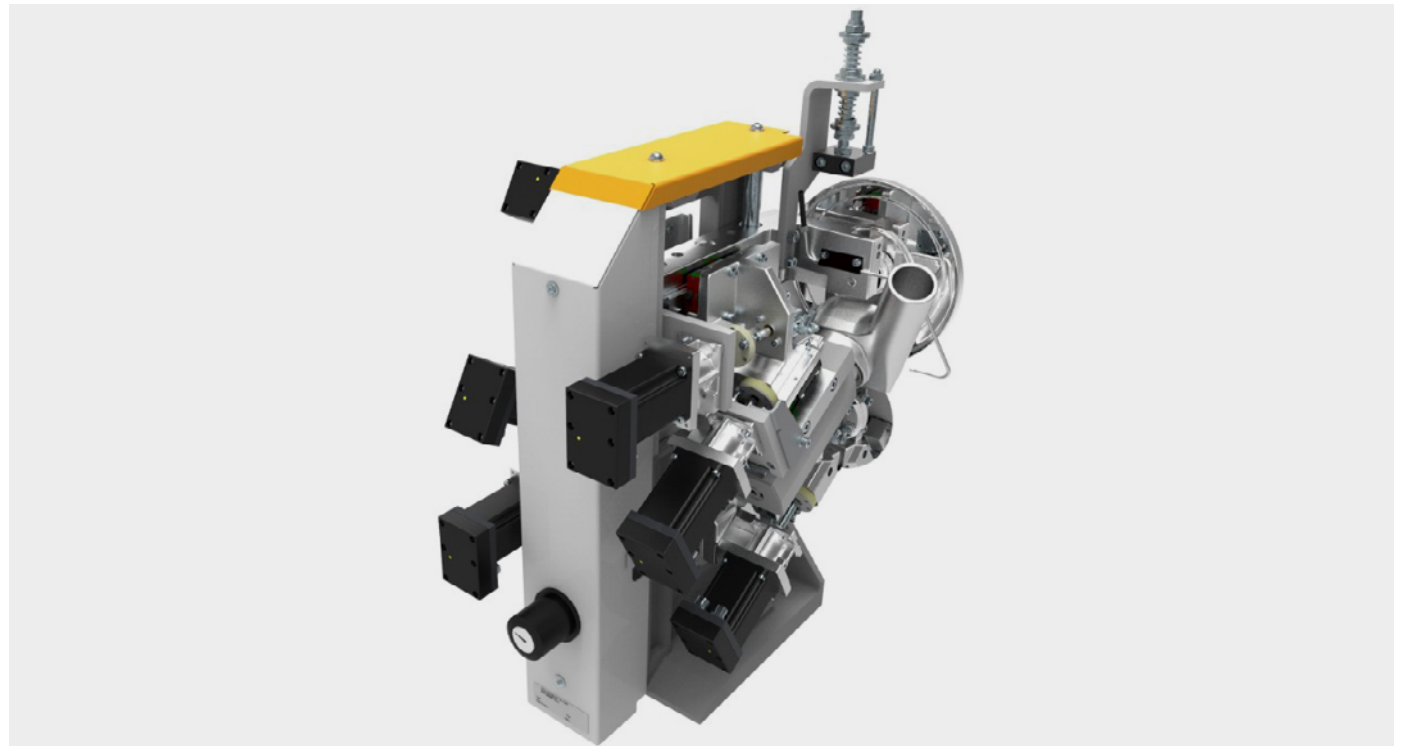
The heavy-duty stationary unit with shock-absorbing bearings and large feeler rollers has 6 NC servomotors. Two-stage diamond tools ensure flexible processing of your workpieces. The appropriate tool is automatically moved into the correct position via the program selection. Thanks to the intelligent software and robust design, you can achieve repeatable and precise machining results even at high feed rates.

With IntelliSet, you can easily set your milling profile to an accuracy of a hundredth of a millimeter. This greatly minimizes set-up times.

The unit also has vertical chamfering rollers, which have been specially developed for processing high-gloss edges.

Translated with DeepL.com (free version)

- 2 stage diamond tools  
(8mm flush + one profile, standard 2mm)
- Extremely precise tolerance mechanics,  
6 fully digital NC servo axes
- Solid construction with low-maintenance,  
precise linear guides
- Standard blowing nozzles in front of the sensing rollers
- Large tracing rollers for smoother workpiece tracing
- Other profiles selectable on request



## CUTTER UNIT FR701 MOT6 MULTI

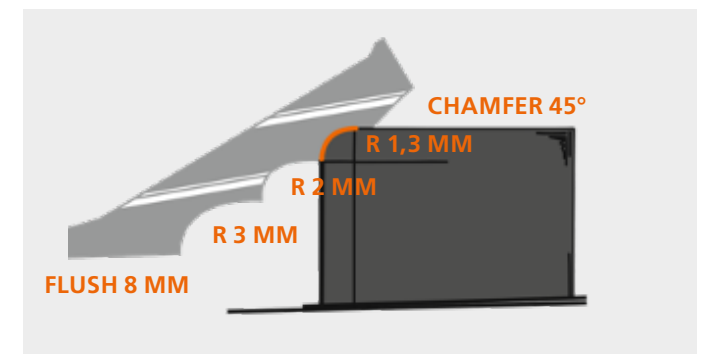
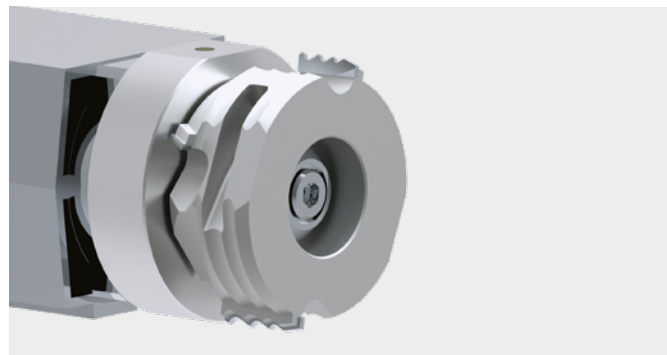
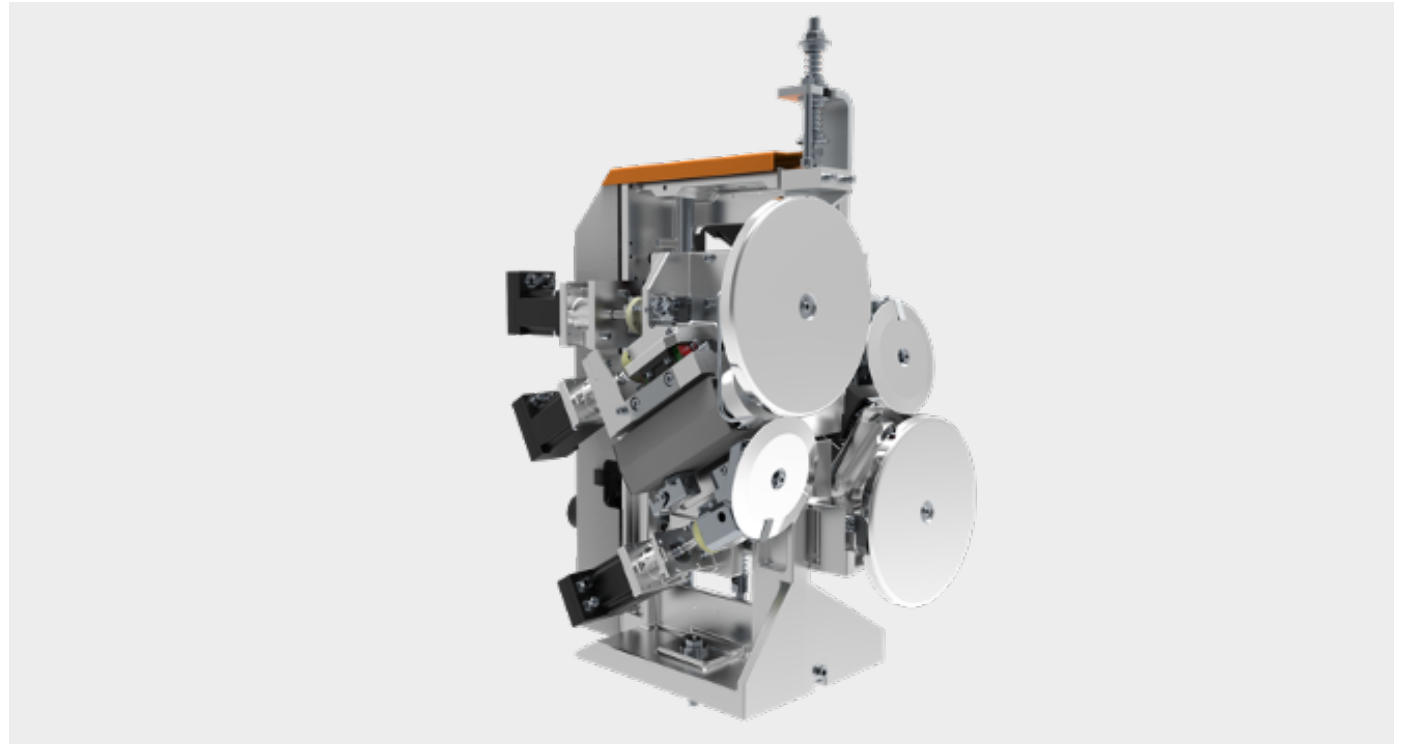
Perfect results at high feed rates

The heavy-duty floor-mounted unit with shock-absorbing mounting and large tracing rollers has 6 NC servo axes that are repeatable and precise even at high feed rates. Multi-stage diamond tools ensure highly flexible machining. The appropriate tool is selected automatically. The selection is made automatically at the push of a button on the display via the program selection. Setup times are thus greatly minimized. The unit is equipped with inclined rollers, which are especially developed for the processing of high gloss edges.

- 5 stage diamond tools
- Extremely precise tolerance mechanics, 6 fully digital NC servo axes
- Solid construction with low-maintenance, precise linear guides
- Standard blowing nozzles in front of the sensing rollers
- Large tracing rollers for smoother workpiece tracing

### MULTI-PROFILE TOOL

- Flush 8 mm
- Radius 2 mm (2-fold)
- Radius 1.3 mm (2-fold)
- Other profiles selectable on request

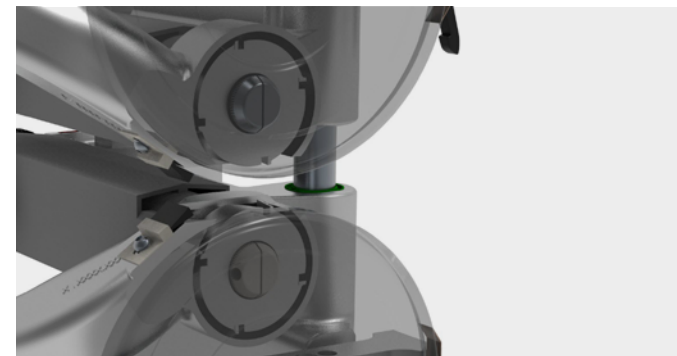


## FLUSH TRIMMING UNIT BF501 MAN

Solid wood

High performance cutting unit for edge thicknesses up to 15 mm. Cutting possible with and without edge protrusion.

- Flush trimming up to 15 mm
- Maximum panel thickness of 60 mm
- Carbide knives
- Ø-70 mm cutter heads
- Cutting width 16 mm, Z4
- Air Stream System
- Patented ProLock screw-in clamp for quick tool change

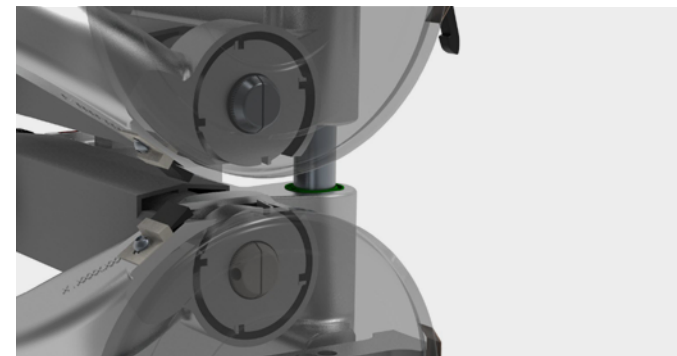
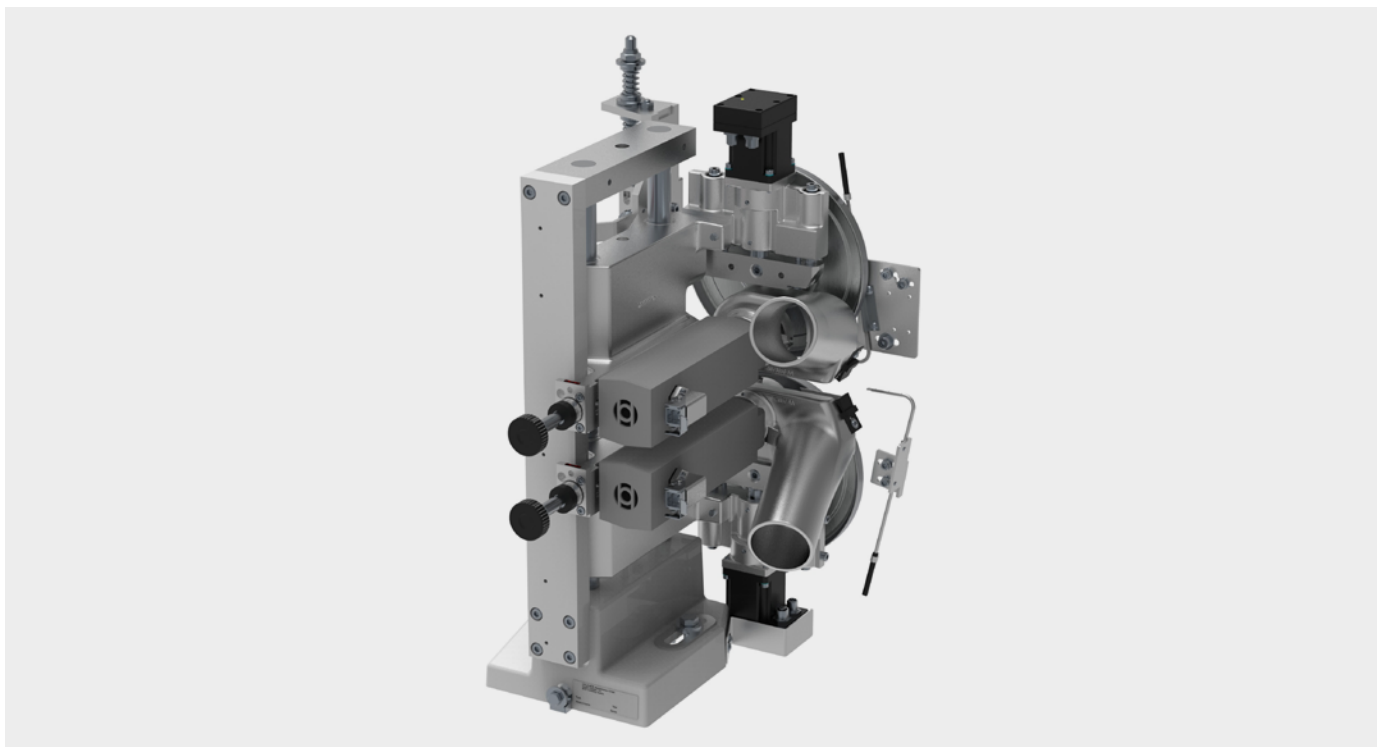


## FLUSH TRIMMING UNIT BF501 MOT2

Solid wood

High performance cutting unit for edge thicknesses up to 15 mm. Two NC servo-axes for cutting with and without edge protrusion. Cutting possible with and without edge protrusion.

- Flush trimming up to 15 mm
- Maximum panel thickness of 60 mm
- Carbide knives
- Ø-70 mm cutter heads
- Cutting width 16 mm, Z4
- Air Stream System
- Patented ProLock screw-in clamp for quick tool change

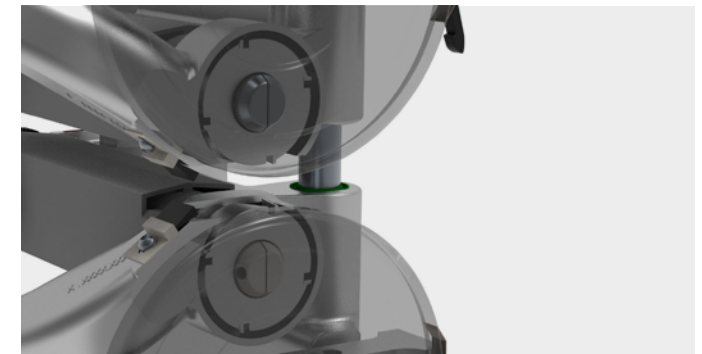
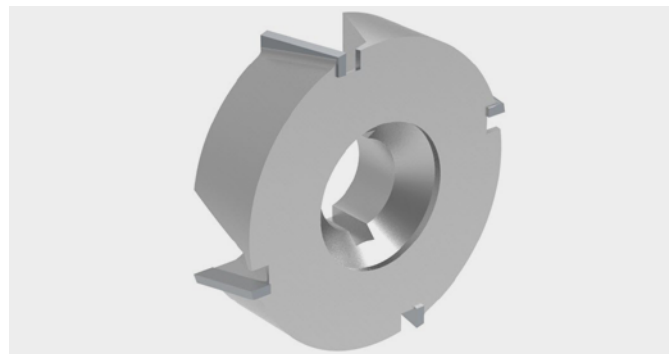
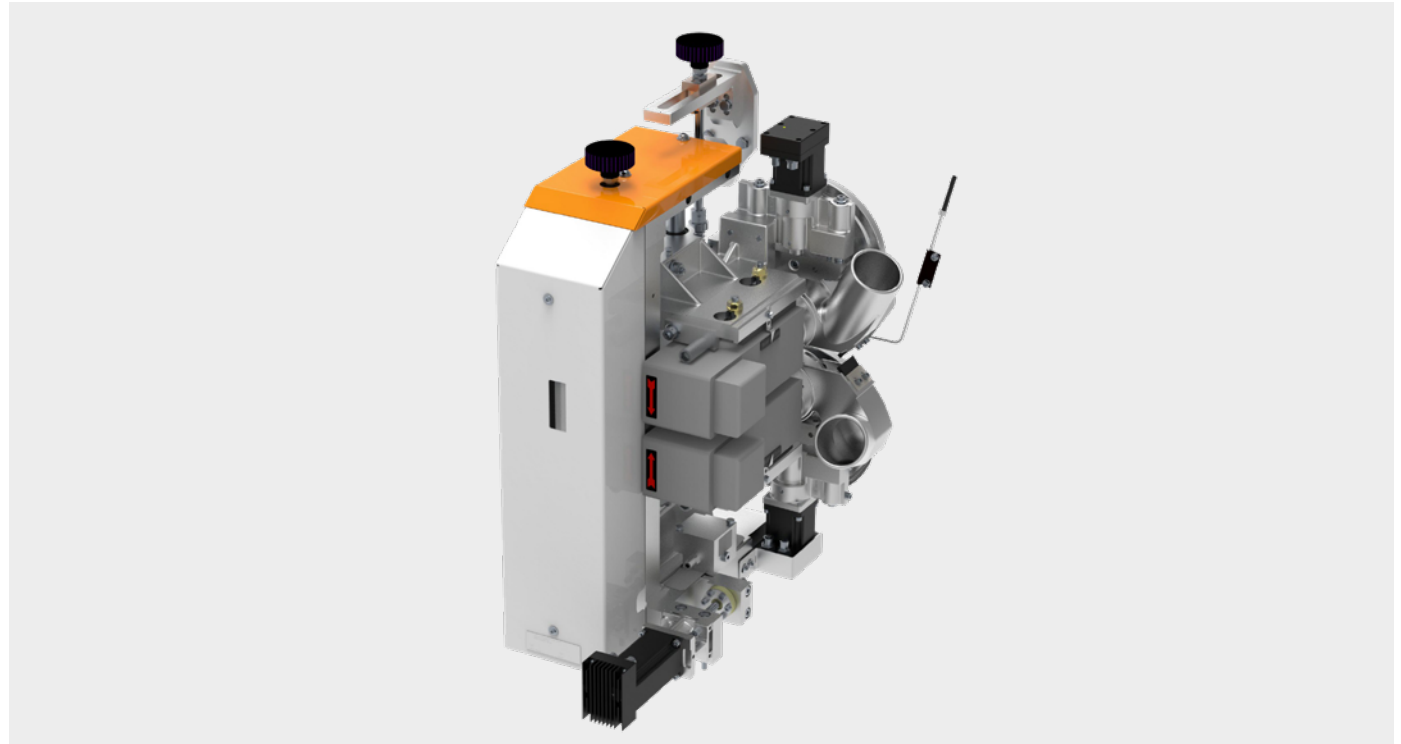


## FLUSH MILLING UNIT BF701 MOT3

The heavy milling unit can effortlessly mill flush solid wood strips up to 20 mm thick with an overhang of up to 2.5 mm. Equipped with 3 NC servo motors, the entire unit as well as the vertical sensing rollers can be adjusted automatically via programme control.

Thanks to the patented Air-Stream technology, the diamond milling tools work highly efficiently. This ensures a long service life and quiet operation.

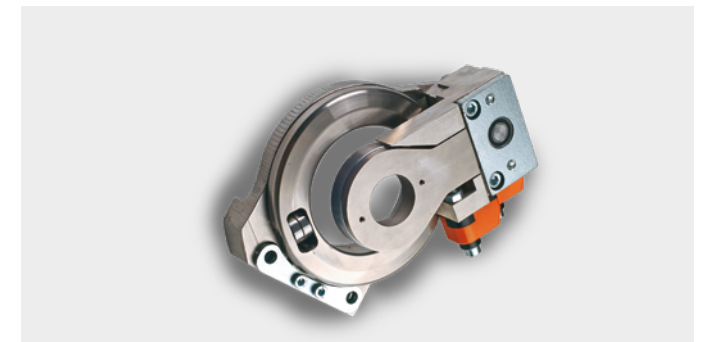
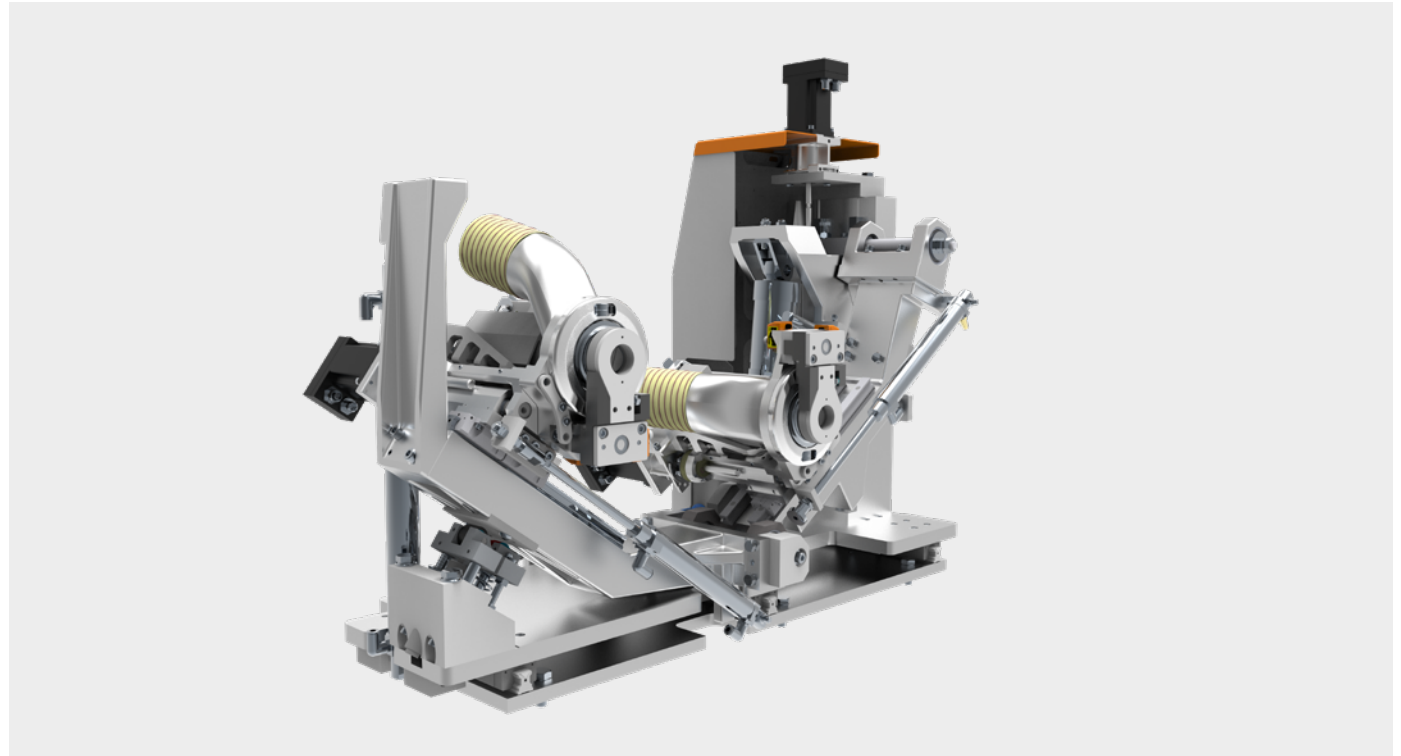
- Flush milling up to 20 mm
- Maximum panel thickness of 60 mm
- Incl. blow nozzles for the sensing rollers
- Ø-80 mm milling heads, Z4
- Carbide insert milling cutter
- Air-Stream-Technology – HOLZ-HER / LEUCO Patent
- High chip detection rate up to 99%
- Quiet operation
- Significantly reduced double chipping
- Long service life and low maintenance



## CORNER ROUNDING UNIT FF701 MOT4

Unit adjustments on linear guides for 100% repetition accuracy at the push of a button. With standard blowing nozzles in front of the tracing rollers to blow off chips in front of the tracing areas. Includes shelf program for optimal processing of shelves with rounded corners. Includes intelligent pneumatics that automatically adjust the processing pressure settings depending on the feed rate and panel thickness.

- Twin-motor corner rounding unit
- With automatic pendulum tracer – front and rear separated – for perfect copying results
- Feed rate up to 18m/min
- Four intelligent proportional valves always ensure perfect pressure settings at all feed speeds and working heights



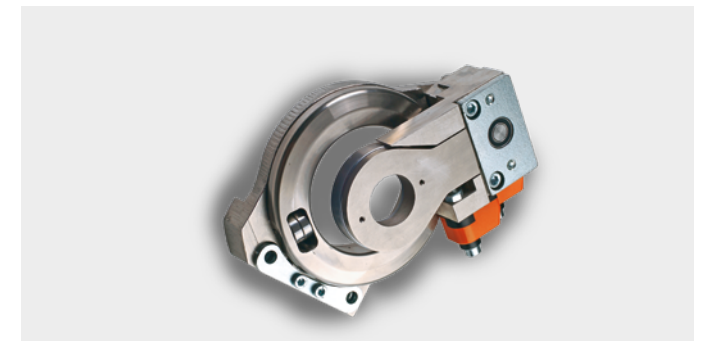
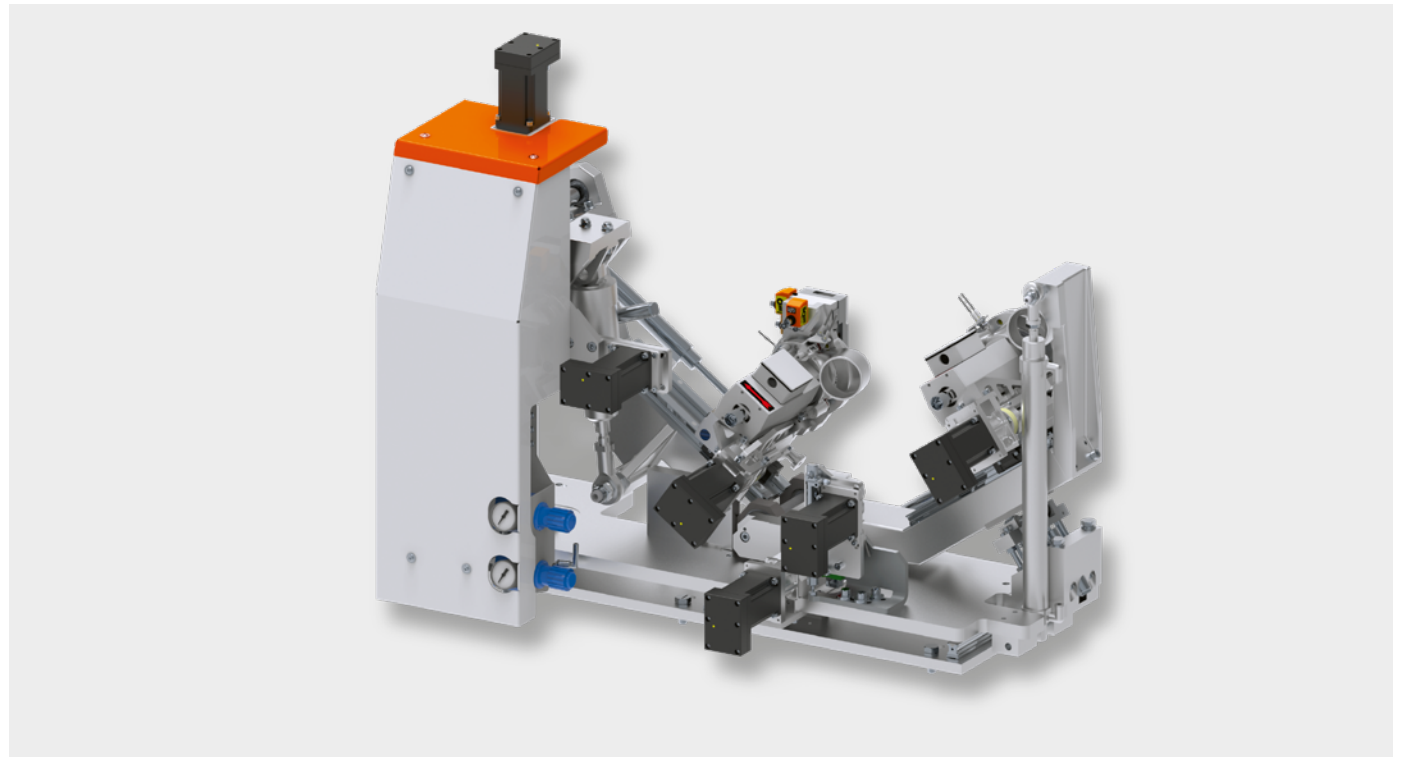
## CORNER ROUNDING UNIT FF701 MOT6 MULTI

Unit adjustments on linear guides for 100% repetition accuracy at the push of a button. With standard blowing nozzles in front of the tracing rollers to blow off chips in front of the tracing areas. Includes shelf program for optimal processing of shelves with rounded corners. Includes intelligent pneumatics that automatically adjust the processing pressure settings depending on the feed rate and panel thickness.

- Twin-motor corner rounding unit
- With automatic pendulum tracer – front and rear separated – for perfect copying results
- Feed rate up to 18 m/min
- Four intelligent proportional valves always ensure perfect pressure settings at all feed speeds and working heights

## AUTOMATIC REVOLVING TOOL QUATTRO FORM (LEITZ PATENT) WITH 6 NC SERVO AXES AND DIAMOND REVOLVING TOOL

- Radius 1.3 mm
- Radius 2 mm (2-fold)
- Chamfer 45°
- Other profile combinations on request



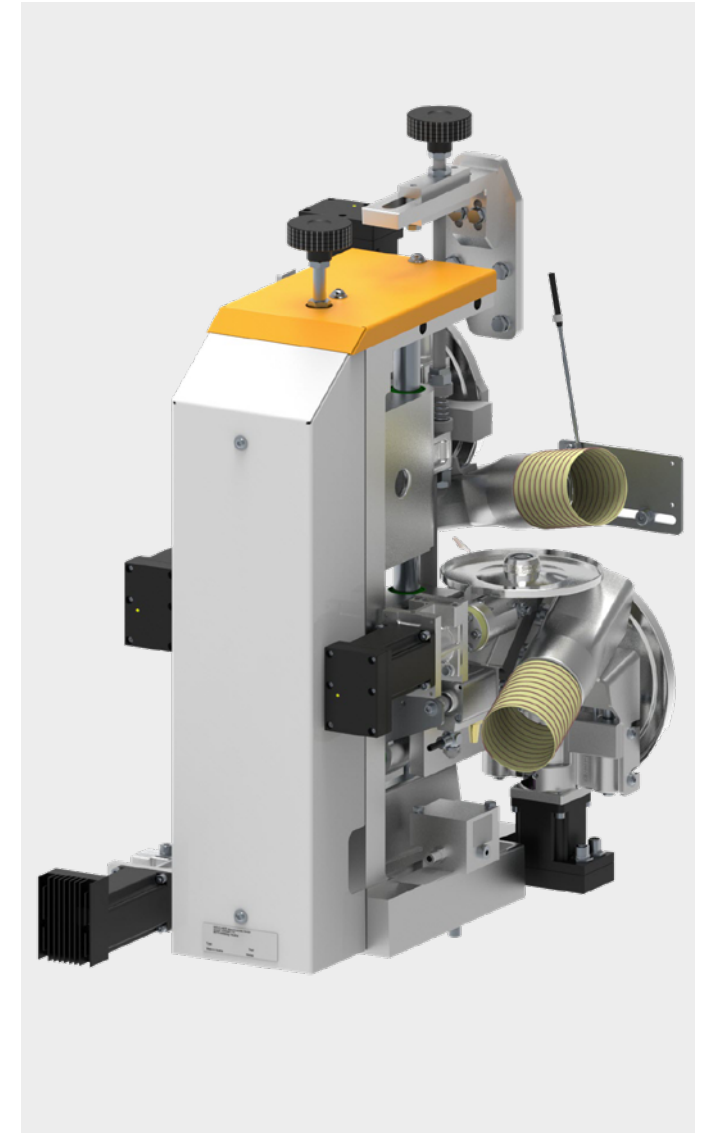
## SCRAPER UNIT ZK501 MOT5

The heavy, shock-absorbing floor-standing unit has 5 fully digital NC servo axes. Equipped with large sensing rollers and backlash-free mechanics, the unit guarantees perfect results even at high feed rates.

With the help of IntelliSet, chip removal can be set clearly and with high precision in the range of hundredths of a millimeter at the touch control panel.

Including high-gloss package for exact adjustment of the tool depth when using high-gloss panels with protective foils.

- 5 fully digital NC servo axes
- Profile scraping blade carrier with carbide inserts
- Radius 2 mm in standard
- Other profiles on request
- Incl. high gloss package
- Incl. blow nozzles and chip scrapers



## PROFILE SCRAPER ZK701 MOT8 MULTI

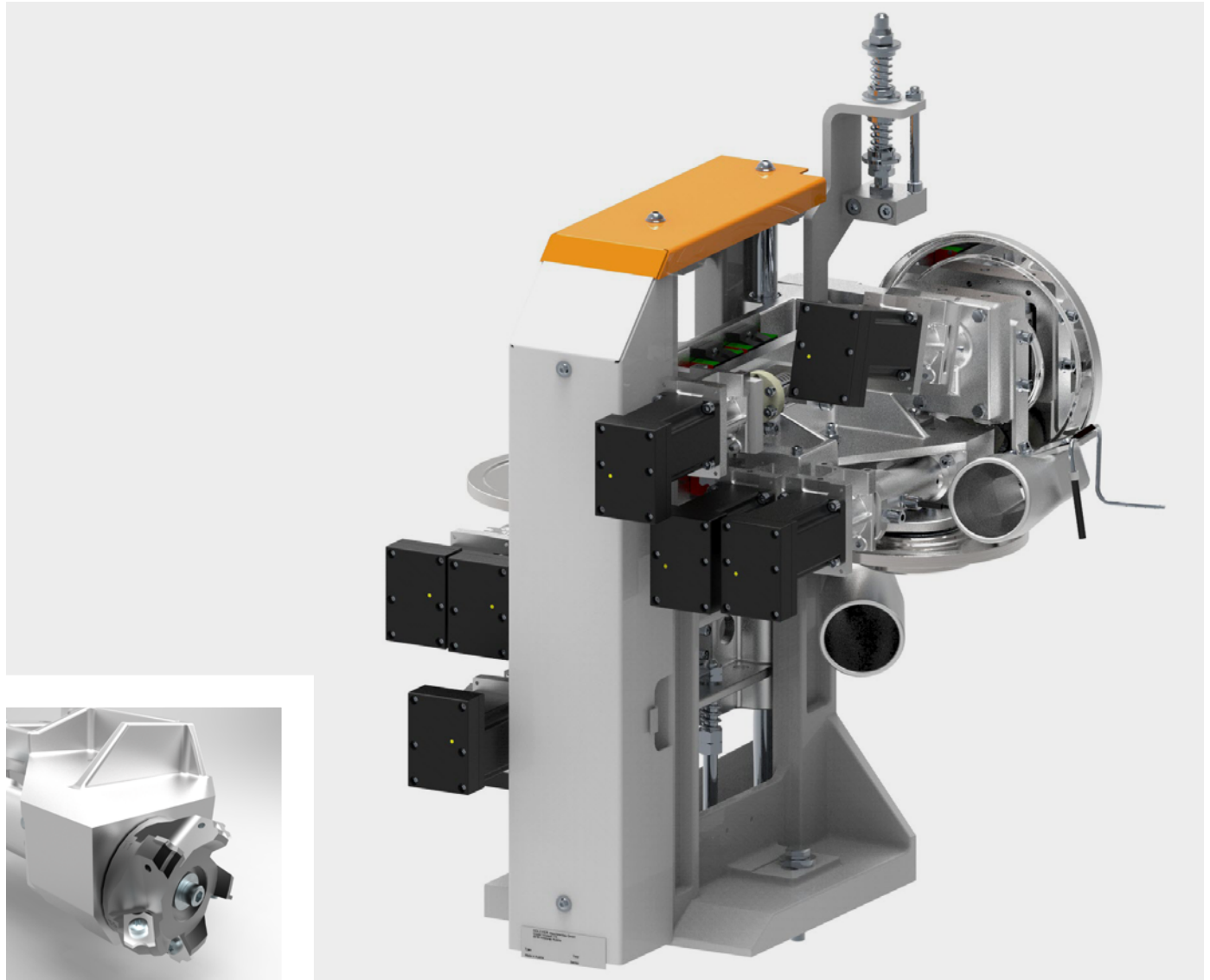
The heavy shock-absorbing stand unit stands firmly on the machine bed and operates with absolute precision even at high feed rates.

The biggest highlight is the fully automatic turret tool changer, which can accommodate up to 5 different scraper profiles.

The unit adjustment runs on high-precision and low-maintenance linear guides, with 8 fully digital NC servo axes ensuring 100% repeatability at the push of a button.

Including high-gloss package for exact adjustment of the tool depth when using high-gloss panels with protective foils.

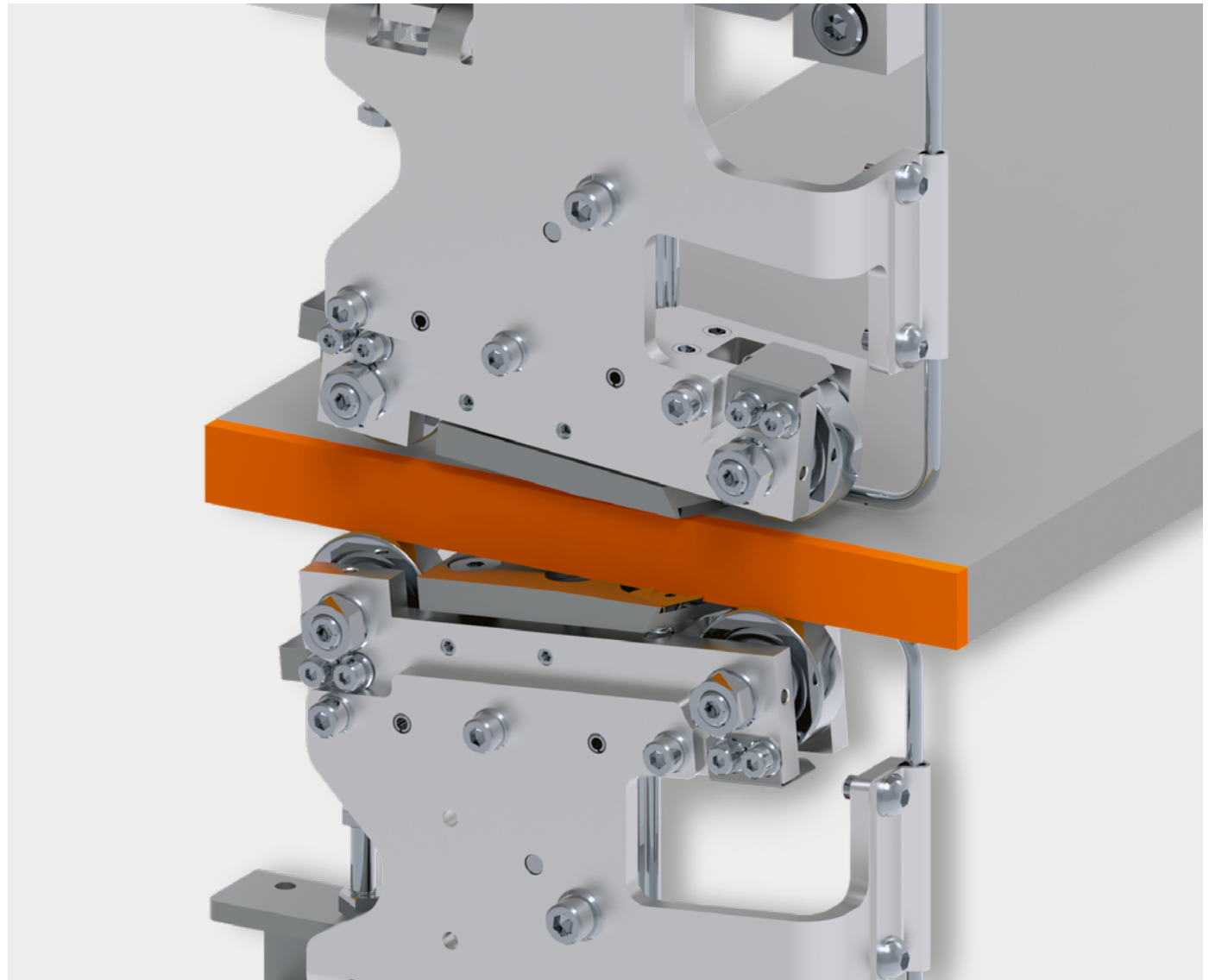
- 8 fully digital NC servo axes
- 5-fold turret tool changer
- Incl. carbide inserts
- Radius 1.3 mm
- Radius 2 mm (2-fold)
- Chamfer 45°
- Other profile combinations on request
- Incl. high gloss package
- Incl. blow nozzles and chip scrapers



## SURFACE SCRAPER FK701

Pre- and post-tracing ensure a clean finish even at high feed rates. The four reversible carbide blades ensure a permanently clean surface result. The two surface scraper blades are separately insert-controlled and can be precisely adjusted. There is no need for manual and tedious reworking at the bench. Both units can be automatically deselected for special applications such as solid wood processing.

- Pre- and post-tracing
- Application-controlled, for example in solid wood applications
- Pneumatic lifting (stroke 20 mm)
- Blowing nozzles and extraction included



## BUFFING UNIT SW701

The unit is immersion-controlled with one buffing motor each for machining the workpiece edge. The disks can be swiveled vertically and horizontally for optimum adaptation to the workpiece.

The workpiece is cleaned, polished and smoothed.

The motors run in synchronism and are adjusted so that the chips and adhesive residues are transported from the inside to the outside in the processing area of the discs.

- Vertical swivel 0 – 5°
- Horizontal swivel 0 – 20°
- Textile buffing wheels with ideal rotation speed
- Other buffing wheels on request (for deburring, emerging, etc.)
- Immersion control
- Adjustable contact pressure
- Recommended in combination with the spraying device (separating and cleaning agent)



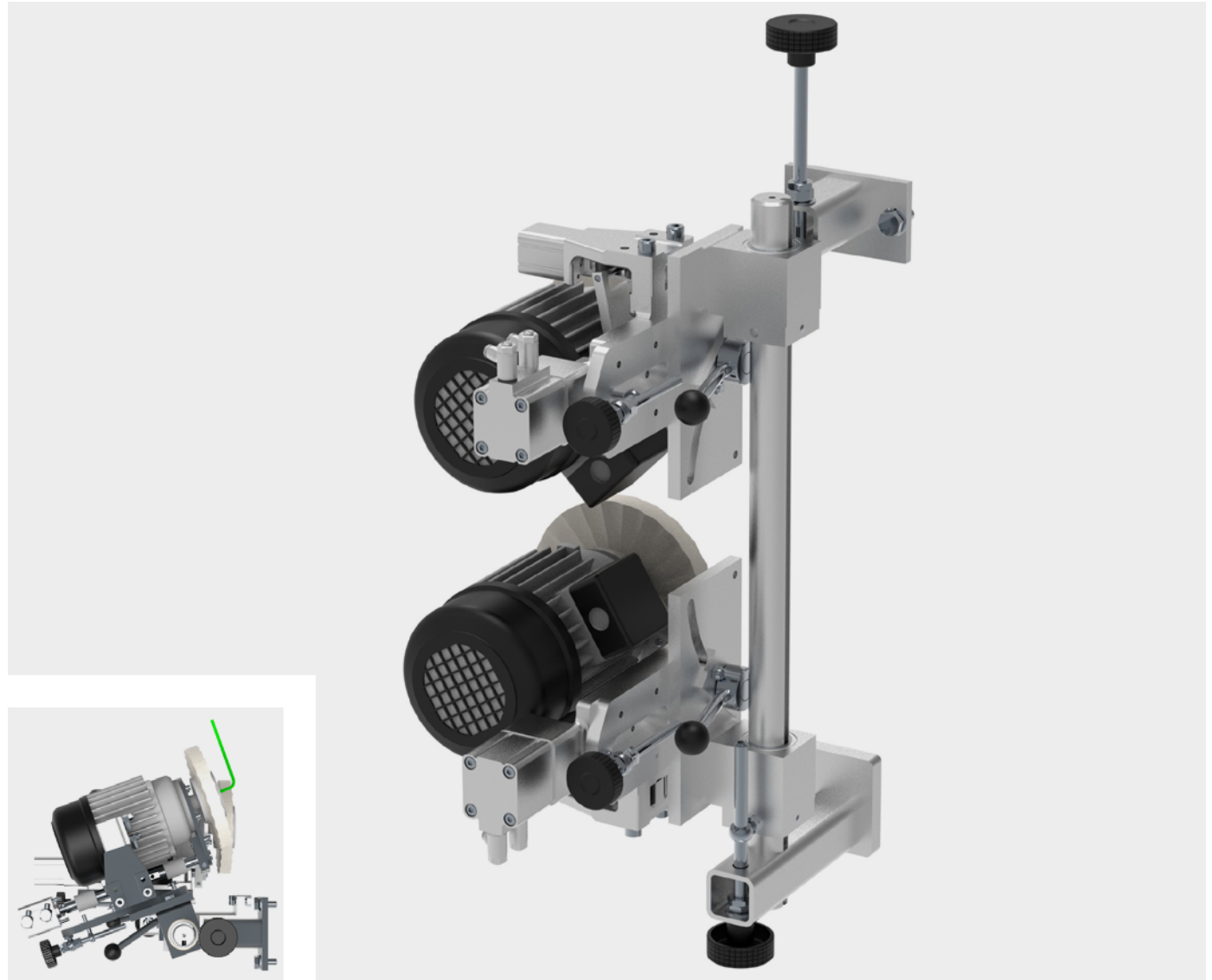
## BUFFING UNIT SW702 OSCILLATING

The unit operates with immersion control and is equipped with oscillating buffing motors. Due to the oscillation, the buffing surface is fully utilized.

The discs can be swiveled vertically and horizontally for optimum adaptation to the workpiece. The workpiece is cleaned, polished and smoothed.

The motors run in synchronism and are adjusted so that the chips and adhesive residues are transported from the inside to the outside in the processing area of the discs.

- Pneumatic oscillation
- Vertical swivel 0 – 5°
- Horizontal swivel 0 – 20°
- Textile buffing wheels with ideal rotation speed
- Other buffing wheels on request (for deburring, emersing, etc.)
- Immersion control
- Adjustable contact pressure
- Recommended in combination with the spraying device (separating and cleaning agent)

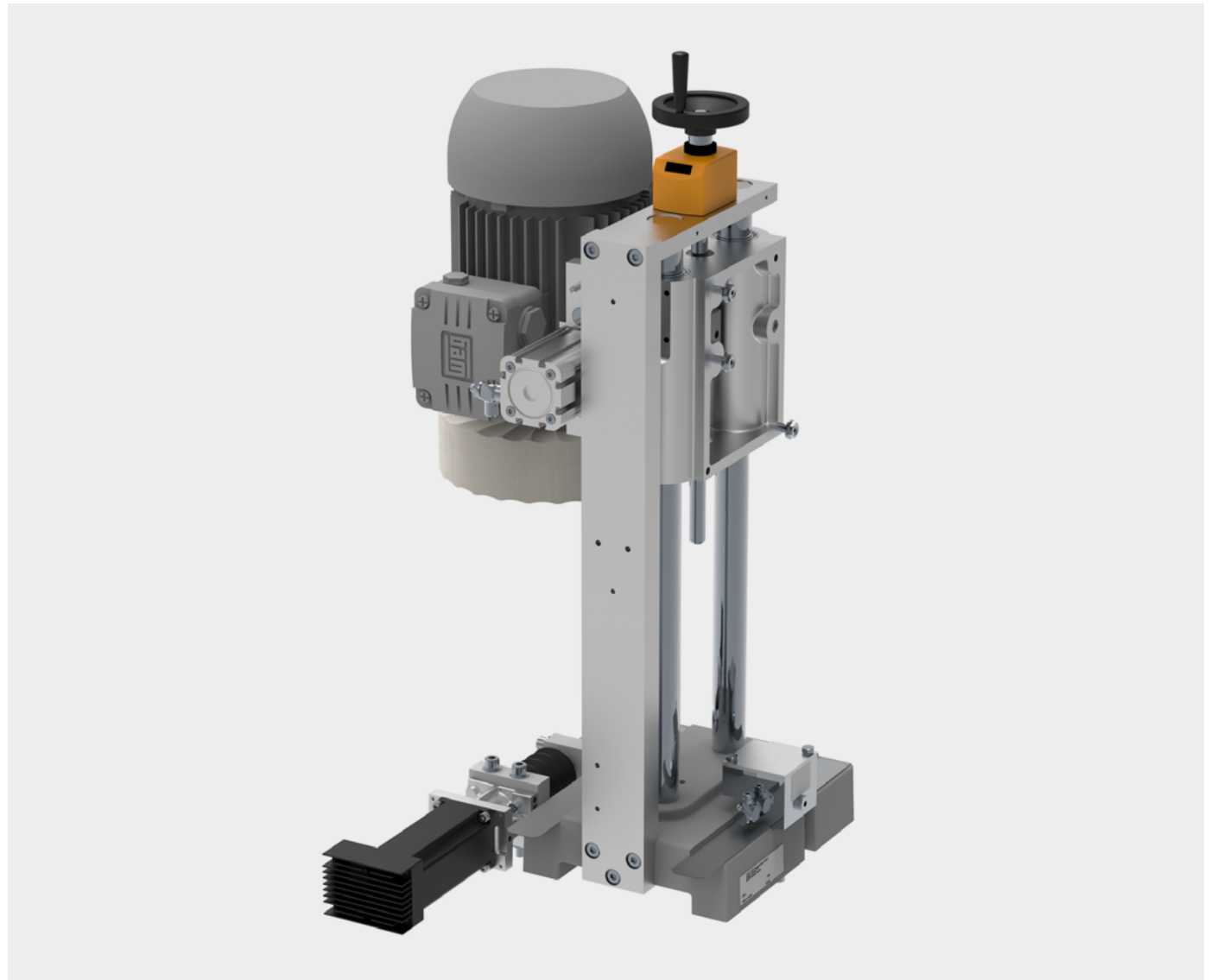


## CORNER BUFFING UNIT ES701

For finishing and polishing the  
front surface

The unit stands firmly on the machine frame and can be adjusted to the ideal working height. The unit moves to the workpiece edge via the NC servo axis. The adjustable distance points of the plunge control can be used to polish the face transitions of the edge joints in a targeted manner. Alternatively, the entire narrow surface along the workpiece can be repolished.

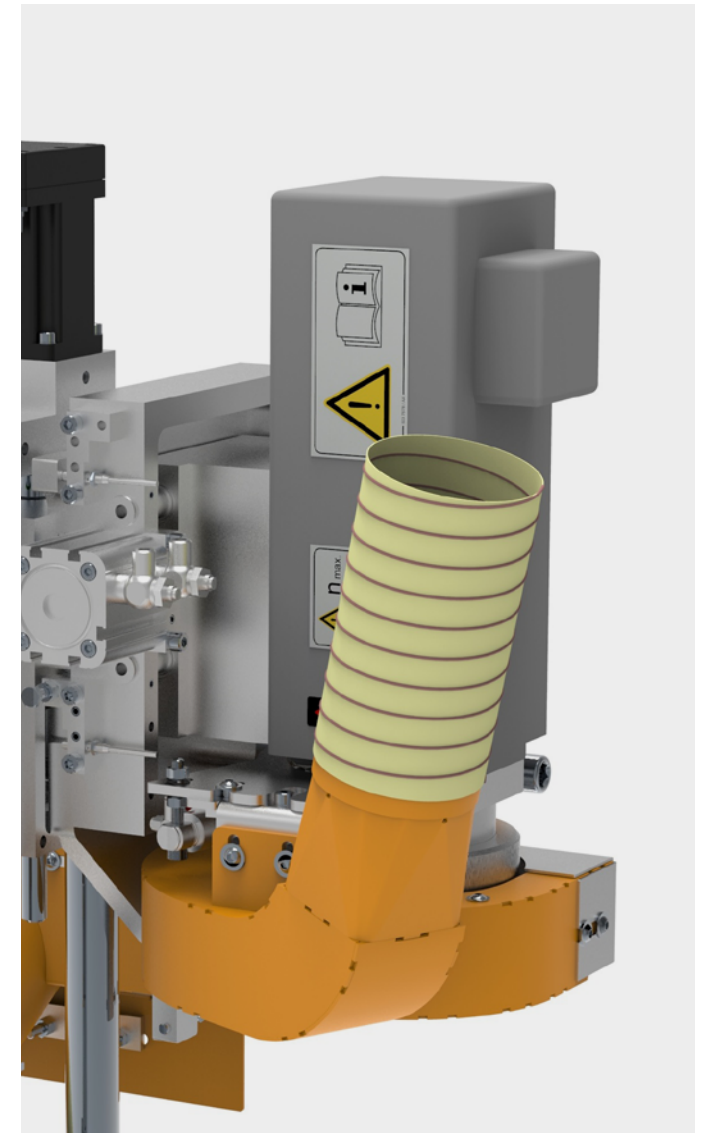
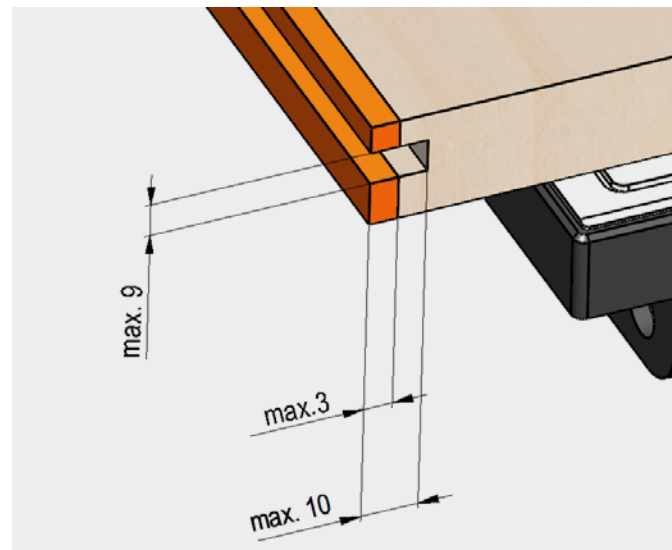
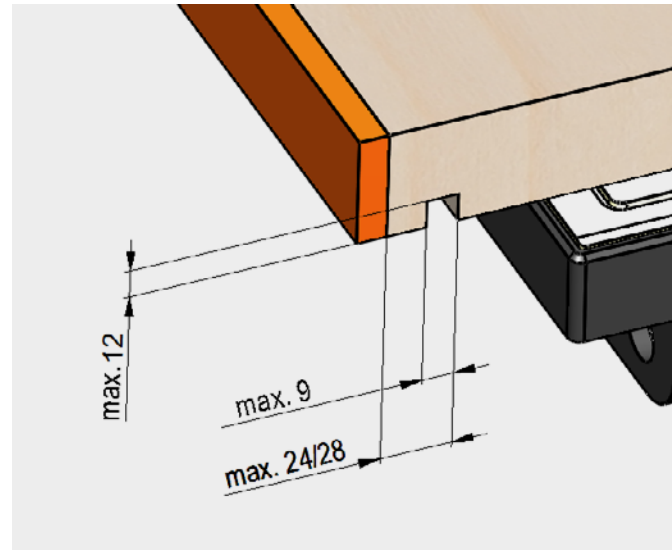
- For polishing the longitudinal edge
- Plunge-controlled for corner machining of the front and rear end edges
- Textile buffing wheels with ideal rotation speed
- Motorised horizontal adjustment to the workpiece



## GROOVING UNIT NT701 MOT2

With two NC servo-axes for groove depth adjustment as well as groove positioning via control panel as a standard feature. Pivots 0 – 90 degrees, incl. grid holes at increments of 11.25 degrees. Plunge control included. Optimum chip collection through blowing nozzle and post-extraction hood.

- Motorized adjustment of the entire unit
- Grooves – on the face and in the surface from below
- Machining in synchronism
- With plunge control for inserted back panel grooves
- Incl. 4.2 mm groove cutter (further groove widths on request)



## SPRAYING DEVICE

In the infeed area, a separating and cleaning agent is applied via special spray nozzles. Line point controlled. This specifically prevents adhesion of adhesive and dirt residues.

For workpieces with protective film, a lubricant ensures safe edge processing. The applied protective film is not damaged during processing.

A special antistatic coolant is used to prevent your workpieces from being covered with plastic chips.

### **RELEASE AND CLEANING AGENT TR701**

Prevents dirt and impurities from sticking to the panel

### **ANTISTATIC COOLANT AM701**

After the pressing unit prevents static charging of the chips

### **LUBRICANT GM701**

After the pressing unit for wetting the edge with lubricant, recommended for processing high-gloss edges

