

Technical Specification

HOLZ-HER Edgebander LUMINA 1584 automatic



BASIC MACHINE

BASIC MACHINE LUMINA 1584 automatic with roller bridge

Base frame design for **high rigidity, welded version**
Stabile pressure bridge with two rows of rubber coated pressure
Surface hardened round steel guides for pressure bridge
adjustment with direct drive.

With **motorized pressure** beam adjustment
With extraction duct for pre-milling unit, dia. 125 mm
Central dust evacuation connection for post-machining units,
Ø 190 mm
Integrated switch cabinet, easily accessible
Integrated chip catch box on the end of the machine

Pivoting and tilting **control panel for ergonomic adjustment** at
eye height
Workpiece support on rollers (690 mm extension / 1068 mm in
total), can be clamped in any position for optimum workpiece
support, with 3 adjustable feed

Integrated stowage area for supply bottles for spraying unit and cleaning system
 Chain guide rail lubricated manually with grease nipple
 Pneumatic locking roller for minimum workpiece interval at machine entry
 Pressure bridge of high strength, rigid U-channels for smooth workpiece transport
 Light barrier for sensing workpieces

Large, space-saving and acoustically insulated guard hood with **noise-absorbing safety cover over** the post-processing area
 Heavy duty drive motor for jerk-free transport of workpieces with workpiece chain
 Transport chain runs on precision half-round flat guides, chain pads on transport chain with high handle for perfect grip on workpieces



Pull-out workpiece support

For perfect workpiece support, self-supported mounted on machine

TECHNICAL SPECIFICATIONS

LUMINA 1584 AUTOMATIC

Edgebander for edging and post-processing of panel-type materials

Edging thickness, rolled edging: 0.4 - 3 mm (depending on material)

Edging thickness, strip edging: 8 mm (Glu Jet)
 max. 15 mm with tool change on cutter unit

Edging height: max. 65 mm

Workpiece thickness: 8 - 60 mm

Workpiece width: min. 60 mm

Workpiece length: min. 140 mm

Feed rate: infinite 10 - 20 m/min.

ELECTRICAL

Electrical for variable feed 400 V / 50 Hz, 2.2 kW

OPERATION



Edge Control 19

with 18,5" color touchscreen 16:9

Powerful controls and simplest machine operation for **efficient machine setup and re-setting.**

Rotatable and tiltable operating control at eye level with Windows-like user interface, all information is displayed in plain text and/or graphics, with extensive program store.

External USB-interface



ECO MODE+

This power-saving mode is an automatic **stand-by mode**, which puts all drives out of operation as soon as no workpiece is entered into the machine. The motors correspond to the new energy efficiency class IE2. If a workpiece is not entered into the machine over a longer time period (6 minutes) the heater of the glue application system automatically shuts down. No more energy is consumed by the machine.

MULTIFUNCTION



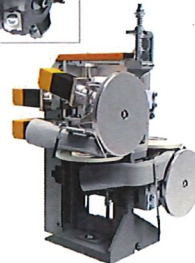
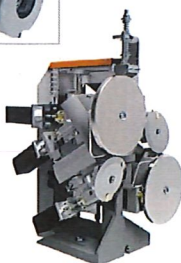
FR701 Multi



FF701 Multi



ZK701 Multi



Multipurpose package

Fully automatic and complete multi tool equipment with multipurpose tools and tooling revolvers for:

- FR701 Multi
- FF701 Multi
- ZK701 Multi

INFEEED AREA

Infeed fence long (1492 mm)

incl. support with integrated rollers

Infeed fence long for precise feeding of very long work pieces, easy adjustment to adjust the cutting depth during joining

Motorical adjustment of infeed fence
automatically adjustable through the control panel
 to adjust depth of cut

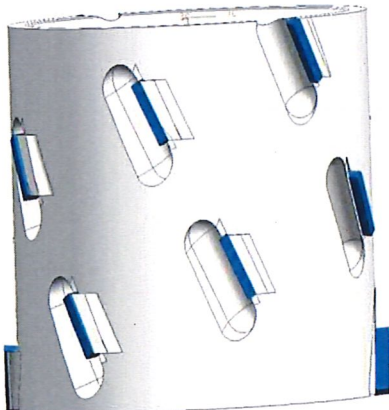
PRE-MILLING UNIT

Pre-milling unit 1802 400 V (2 x 2.0 kW, 200 Hz, 12,000 min-1)

With 2 trimming units for joining panel edges

1x operating in forward direction, 1x in rearward direction

max. milling thickness: 3 mm, patented ProLock screw-in clamping system for rapid tool change



Diamond cutter Ø 70 x 64 x 30 mm, **2 teeth, left hand**
 For pre-milling unit **1801 / 1802**

Diamond cutter Ø 70 x 64 x 30 mm, **2 teeth, right hand**
 For pre-milling unit **1801 / 1802**

EDGE FEEDER

SYNCHRO

Edge feeder 1901 SYNCHRO

automatic transport of roll and strip products

max. load capacity: 150 mm

Synchronous drive with adjustable edge protrusion for cut length edging, for coils: max. edge thickness 3 mm (material dependent)

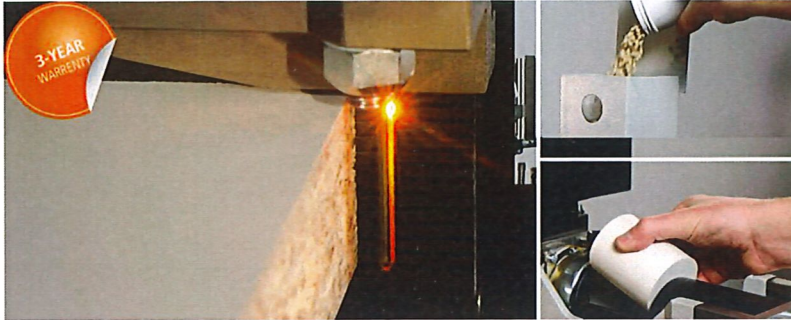
forward cut up to max. 65 mm (material dependent)

max cross section 135 mm² (material dependent)

support table for coils Ø 820 mm

GLUE APPLICATION (EXCHANGE UNIT)

2



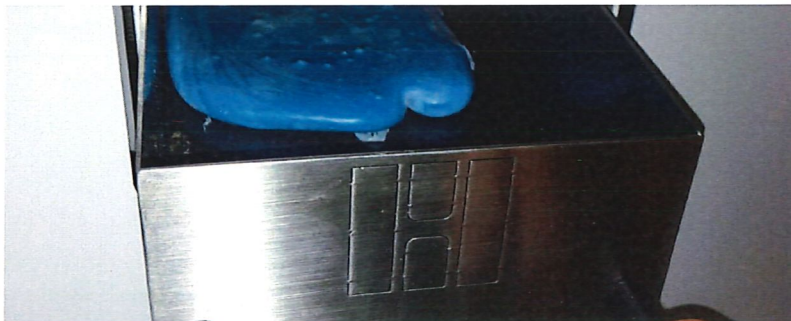
Glue application system Glu Jet GJ302 automatic
(2,3 kW, 50 Hz)
Automatic adjustment of gluing height (tracing nozzle)

Glu Jet hybrid technology

Processing of EVA and PUR adhesives
Adhesive in cartridge or granules form
Processing of neutral and coloured adhesives

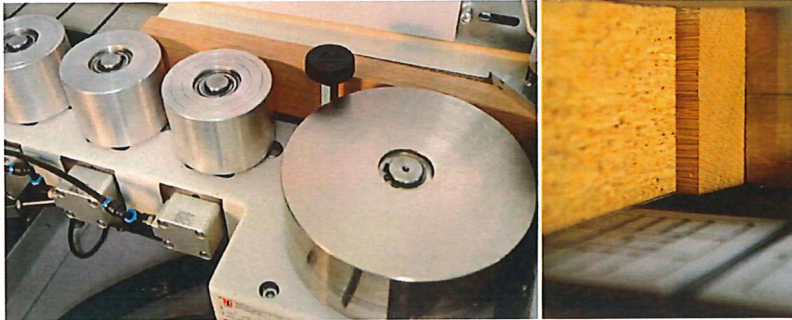
Glue applied by means of nozzle technology

Heat-up time: 3 minutes
Incl. hopper for cartridges: 4 cartridges (approx. 1,4 kg)
Incl. hopper for glue granules: (approx. 1,5 kg)
Incl. automatic reloading of glue
Incl. automatic rinse function directly at the control panel through separate rinse channel
Automatic glue temperature reduction according to time



GLU JET rinse hopper
to collect glue residues during rinse procedure

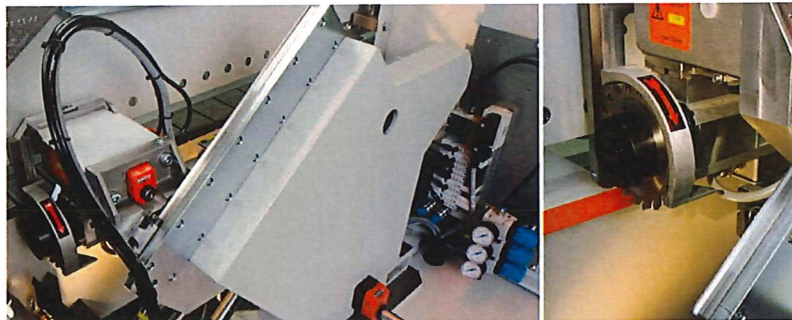
PRESSURE UNIT



Pressure section 1914-1 MOT

Motorical adjustment to the edge thickness directly from the control panel, with 4 sep. contact-controlled pressure rollers for clean edge pressing on carrier panel, first roller automatic driven synchronous to the feed speed, 3 support pressure roller

END TRIMMING UNIT



End-trimming KA 701 pneumatic

(2 x 0.65 kW, 200 Hz, 12,000 min⁻¹)

Pneumatic pivoting feature 0/10° for coils and strips:

max. edge thickness: 20mm

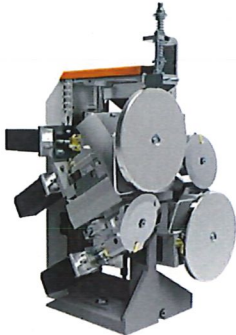
(depending on material and feed speed),

hardened and precision-ground linear guides each, incl. 2 noise

reduced TC-sawblades altern. teeth, Ø 110 mm, Z 20, incl. 2

extraction hoods

MULTIFUNCTIONAL TRIMMING UNIT



FR701 Cutter unit Multi with fully automatic multipurpose tool

100% repetition accuracy at the touch of a button based on zero-clearance mechanisms and 6 fully digital NC servo-axes.

Heavy duty floor-mounted machine with shock-absorbing mounts and large sensing rollers for perfect results even at high feed rates.

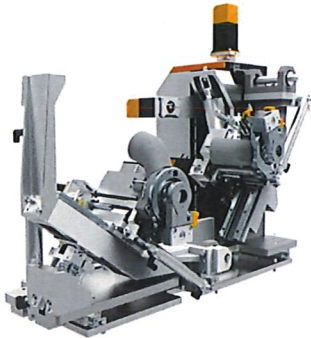
Machine adjustments on linear guides with central lubrication.
With standard blast nozzles in front of sensing rollers to blow away chips in front of sensing areas.

Horizontal sensing with angular sensing rollers with chemically applied nickel plating developed especially for processing modern, high gloss edging.

Incl. diamond-multipurpose cutterhead with the following profiles:

flush trimming 8 mm
Radius 1,3 mm
Radius 2 mm (2-fold)
Chamfer 45°

CORNER COPY UNIT



Form trimming unit FF701 Multi with automatic tool revolver quattroForm

100% repetition accuracy at the touch of a button based on zero-clearance mechanisms and 6 fully digital NC servo-axes.

Includes two diamond tipped cutters with optimized chip removal. With automatic pendulum sensor for perfect copying results. Fully automatic pendulum sensor copies ends without material protrusion and leaves the optimum edge protrusion for the longitudinal edge for subsequent machining.

Machine adjustments on linear guides with central lubrication. With standard blast nozzles in front of sensing rollers to blow away chips in front of sensing areas.

Including shelf program for optimum processing of shelves with rounded edges.

Incl. diamond tools with the profiles:

Radius 1,3 mm

Radius 2 mm (2 fold)

Chamfer 45°

FINISHING

SCRAPER UNIT



Scraper unit ZK701 Multi Fully automatic multifunction revolver version

Heavy duty floor-mounted machine with shock-absorbing mounts and large sensing rollers for perfect results even at high feed rates.

Machine adjustments on linear guides with central lubrication. With standard blast nozzles in front of sensing rollers to blow away chips in front of sensing areas.

100% repetition accuracy at the touch of a button based on zero-clearance mechanisms and 8 fully digital NC servo-axes.

Including high gloss package for exact adjustment of tool depth when using high gloss panels with protective foil as well as sensing rollers with chemical nickel plating.

incl. TCT turnover knives with the profiles:

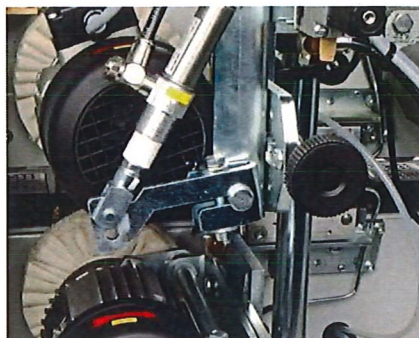
Radius 1,3 mm - bottom 5041596
 Radius 1,3 mm - top 5041597
 Radius 2 mm (2-fold) - bottom 5039911
 Radius 2 mm (2-fold) - top 5039913
 Chamfer 45° - bottom 5041565
 Chamfer 45° - top 5041566
 1 x free space

SURFACE GLUE SCRAPER

Surface glue scraper 1964

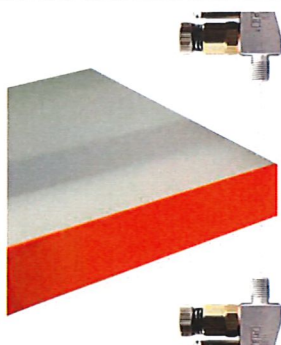
scrapping out superfluous glue for a clean glue line
 Plunge-in controlled top and bottom separately, incl. 2 blow nozzles, incl. 2 turnover knives, incl. dust extraction hoods

BUFFING



Buffing unit 1944K (2 x 0.2 kW, 400 V, 1,400 min⁻¹)
For edge cleaning and polishing, incl. plunge-in control,
incl. 2 textile buffing wheels

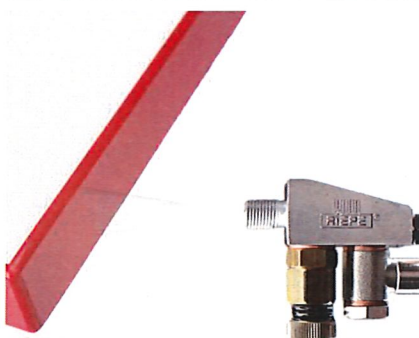
SPRAYER UNIT



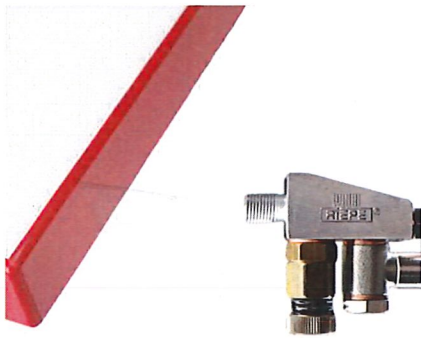
Sprayer unit 1856 for the in- and outfeed area

for the infeed area: electronically controlled release agent sprayer
with release agent

for the outfeed area: electronically controlled cleaning agent
sprayer with cleaning agent



Spraying unit (Antistatic coolant) after pressure unit
with use of antistatic coolant



Sprayer unit (parting agent) after pressure unit
to sprinkle the edge with lubricant
recommended for the use of glossy edges

EQUIPMENT VARIANTS AND ACCESSORIES

LED-Lamps (3 pc) for the infeed area / post-processing area
Modern LED technique with tempered, break-proof glass



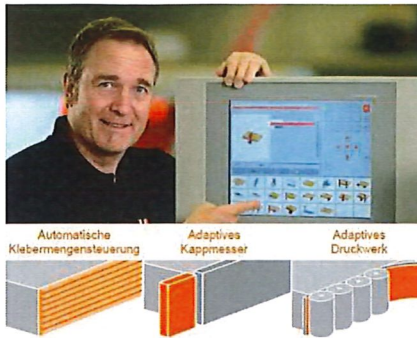
Automatic lubrication of the transport chain
Intelligent automatic transport chain lubrication. Sensor-controlled unit, for metering lubricate to match load.



Oil injection device for lubrication of articulations and pins
with an hour meter

Infrared heater model 1996

The workpiece edge is warmed up before the adhesive application
for a better adhesion.



Adaptive pressure and glue quantity control

automatic, program controlled fine adjustment for optimum adjustment to edge thickness, edge materials and glue types which guarantees best process results.

Automatic package consists of:

- automatic glue quantity control
- adaptive guillotine
- automatic pressure section

Glu Jet - 3 year warranty

On all mechanical and electrical parts.

Excluded are damages to the system due to improper operation and/or due to insufficient cleaning and maintenance. The extended warranty is limited to single shift work or a maximum workload of 200.000 meters /year.

HIAB Delivery

Weinig UK HIAB delivery and positioning service for all machines. A professional team of machine movers deliver the machine to your site on a craned vehicle. The machine is unloaded, removed from all transport packaging and positioned where required. This expert service includes insurance against damage of the machine and is able to be scheduled to meet your requirements.

Delivery and Commissioning Conditions

Included within the price of the machine is delivery to your factory including unloading and positioning in customers premises.

Commissioning, demonstration of the machine and training of your operators covering operating procedure, maintenance and safety aspects of the machine will be carried out by our engineer.

Delivery Date

To be confirmed

We Guarantee You

The warranty period for this machine begins on date of delivery and is 12 months for single shift operation, 6 months for two-shift operation and 3 months for more than 2 shifts.

The warranty terms are included in our general terms of sale and delivery.

1. The warranty exclusively covers new machines supplied by us.
2. The warranty refers to the delivery of faulty items, in particular to sub-standard material, inferior workmanship or construction. We will be liable to repair or replace the defective parts at no extra charge
3. Excluded from the warranty are the following.
Natural wear (standard wearing parts), damage caused by force or the use of unsuitable lubricants or fuels. Non-compliance with prescribed machine care and instructions for use. Incorrect assembly or putting into commission by the Purchaser or third parties. Incorrect or inadequate maintenance. Unsuitable locations, repairs or alterations carried out by the Purchaser or third parties at the Purchaser's initiative. Elemental influences, ambient conditions such as extremely high humidity, abnormal power supply fluctuations or the use of spare parts not manufactured and or approved by us.
4. We shall bear the costs for replacement parts including their shipment and any reasonable dismantling and re-assembly costs.

Important Safety Information

The safety information and the operating instructions supplied together with the machine must be read and observed by the machine operators prior to start-up.

Annex

Detailed description of machine control
Edge Control 19
18.5" touch screen with 16:9 format.
Network compatible.
LED display for equipment selection.
Program list showing program names and numbers.
External USB port.

Individual selection of units with functions as basic setting possibilities for nominal values, path points and tool corrections as well as fixed path points.
Set-up processes for units and their axis settings carried out centrally and clearly by fine adjustment (depending on equipment).
Interval display for shortest interval between workpieces.
Integrated path control - path points are controlled generally or in a program-specific manner.

Clear and complete acquisition of all operating data.
Service reports in clear text.
Diagnostic system.
Integrated synchronous bus system for maximum unit control accuracy.

Individual management for up to ten users including password protection.
Barcode interface (optional).