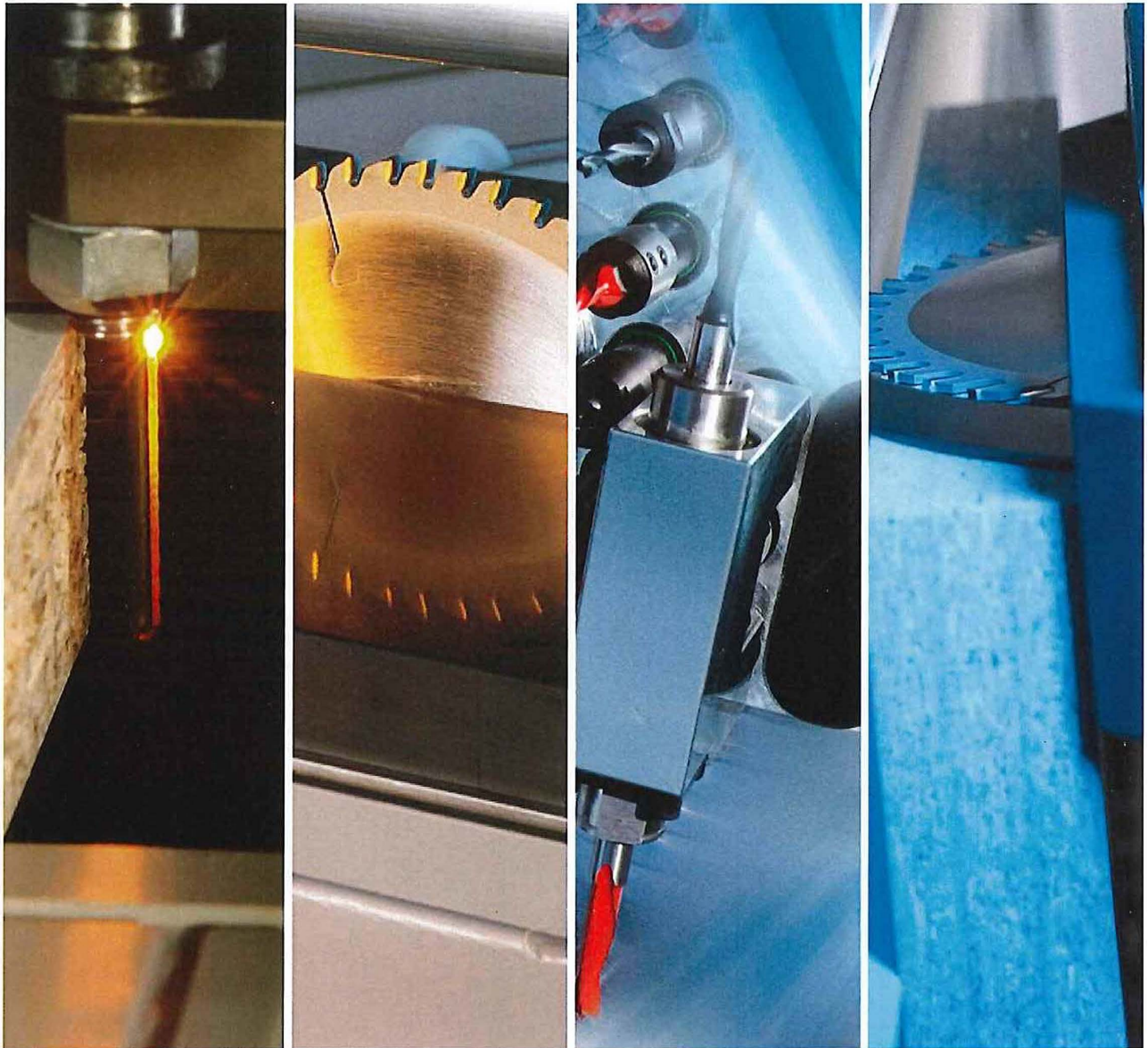


**Precision and productivity for the panel processing**  
**Everything from a single source. Everything 100%!**



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## Your benefit at a glance

**LUMINA series:** Torsionally rigid, welded machine stands, transport chain with round and flat guides, incl. intelligent transport rail lubrication, **pneumatic locking rollers for minimum workpiece intervals at machine entry**, motor-drive pressure bridge adjustment, **infinite feed rate 10 - 20 m/min (25 m/min)**, ensure maximum ease of operation, long-term productivity, precision and operating reliability.

**Control features and operation:** With rotating and pivoting control panel, dust-proof. Large program memory for complete capture of all operating data, service messages in clear text. Fully automatic control of processing machines at the touch of a button using **NC servo-axes**.

**Ltronic laser edging activation unit (changing station):** The Ltronic unit activates the functional layer on the laser edging under electronic control and is immediately ready for use without any heat-up time.

Visually perfect results - tone in tone with invisible joints.

- Maximum energy efficiency
- Silent processing
- No heat-up time
- No cleaning work

**Glu Jet hybrid technology (changing station):** Highly flexible glue application with **patented nozzle for invisible zero joints**. Standard equipment allows use of EVA or PUR glue without expensive and time-consuming auxiliary equipment. Glue can be processed in cartridge or granulate form with automatic replenishment feature. Change-over from neutral to colored glue in a jiffy.

**Shortest heat-up time of 3 minutes** for minimum energy costs.

Automatic cleaning feature for glue system at the touch of a button.

**Machine design - 100% repetition accuracy:** Our solid, state-of-the-art processing machines are subject to continuous development based on our 50 years of experience with edgebanders, guaranteeing high quality processing of your edges and optimum product quality of your finished furniture.

**Tool design:** Diamond tipped, state-of-the-art cutting tools with integrated chip removal and patented Pro Lock quick-clamp chuck, all matched perfectly to your range of application. Optional with completely integrated multi-function tools.

**Accessories:** Comprehensive line of accessories ranging from air cushion table in entry area to electronically controlled spraying units to make subsequent retouching work completely superfluous. Modular design makes it easy to add accessories.

## Technical Specification

### HOLZ-HER Edgebander LUMINA 1584 automatic



#### BASIC MACHINE

#### **BASIC MACHINE LUMINA 1584 automatic** with roller bridge

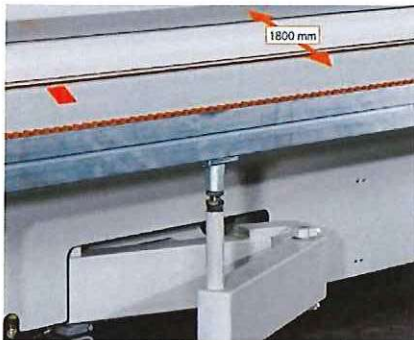
Base frame design for **high rigidity, welded version**  
Stabile pressure bridge with two rows of rubber coated pressure  
Surface hardened round steel guides for pressure bridge  
adjustment with direct drive.

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



### Multipurpose package

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

- FR701 Multi
- FF701 Multi
- ZK701 Multi

## INFEED 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  $\varnothing$  70 x 64 x 30 mm, **2 teeth, left hand**  
For pre-milling unit 1801 / 1802

Diamond cutter  $\varnothing$  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)

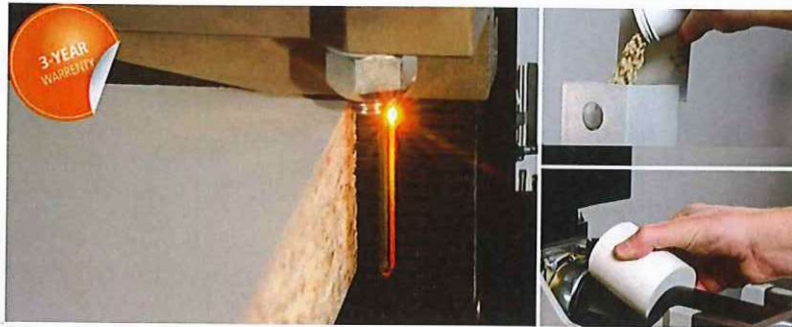
forward cut up to max. 65 mm (material dependent)

max cross section 135 mm<sup>2</sup> (material dependent)

support table for coils  $\varnothing$  820 mm

## GLUE APPLICATION (EXCHANGE UNIT)

2



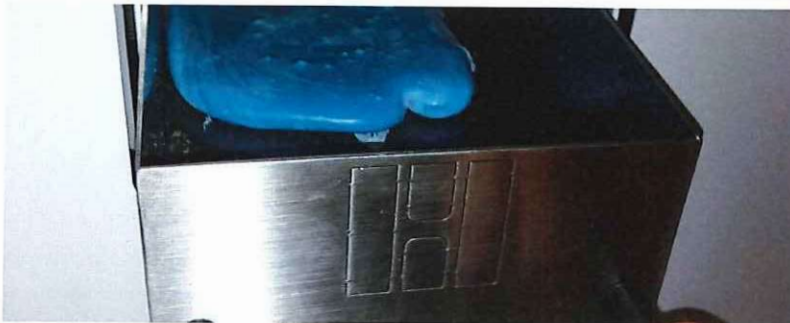
**Glue application system Glu Jet GJ302 automatic**  
(2,3 kW, 50 Hz)  
Automatic adjustment of gluing height (tracing nozzle)

### **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

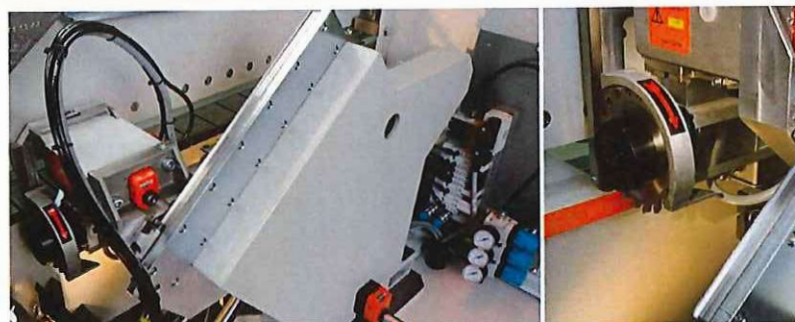
## PRESSURE UNIT



### 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<sup>-1</sup>)

**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.

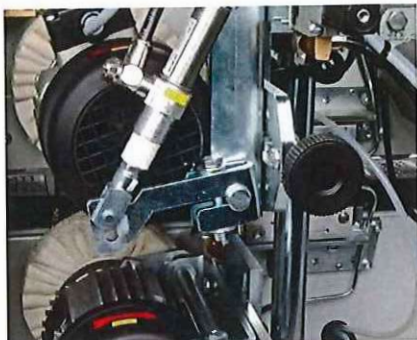
#### **incl. TCT turnover knives with the profiles:**

- 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**  
**scraping 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

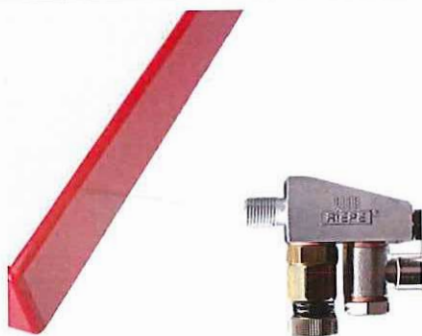
## SPRAYER UNIT



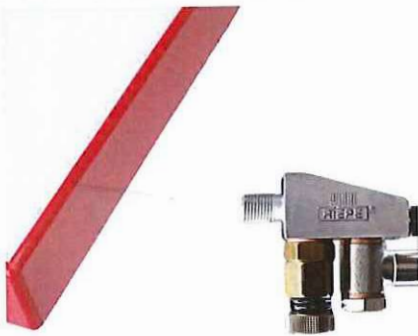
**Sprayer unit 1856 for the in- and outfeed area**

**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

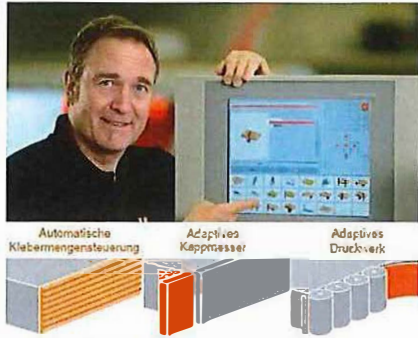


**Automatic lubrication of the transport chain**  
Intelligent automatic transport chain lubrication. Sensor-controlled unit, for metering lubricate to match load.



**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.



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