

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



HOLZ-HER ACCURA 1554 DOOR Edgebander



Your benefit at a glance

ACCURA 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**.

Glu Jet hybrid technology

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

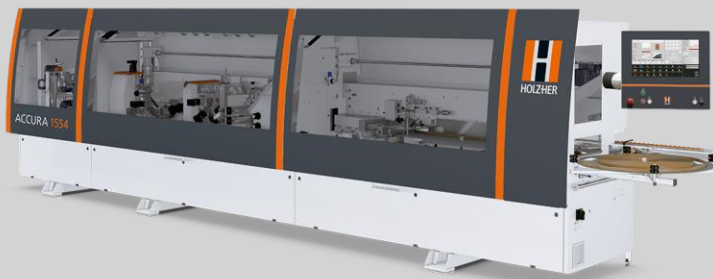
Diamond tipped, state-of-the-art cutting tools with integrated chip removal, all matched perfectly to your range of application.
Optional with completely integrated multifunction tools.

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 ACCURA 1554 DOOR Edgebänder (Illustration with optional front machine hood)



BASIC MACHINE

KPT 1732185

BASIC MACHINE ACCURA 1554 DOOR with synchronized driven belt bridge

Base frame design for **high rigidity, welded version**
Surface hardened round steel guides for pressure bridge
adjustment with direct drive.

With **motorized pressure** beam adjustment
With extraction duct for pre-milling unit
direct dust avacuation connection for post-machining units

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

Integrated stowage area for supply bottles for spraying unit and cleaning system
Chain guide rail central lubricated
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
workpiece support on rollers.



LED operating mode indicator
automatic, optical LED indicator for various operating modes

Top light:

white = standby
orange = feed on
yellow = refill glue or edging
green = workpieces in production
red = error message

Bottom light:

green = infeed stop up - workpiece infeed possible
off = infeed stop down - no infeed possible

Pull-out workpiece support

For perfect workpiece support, completely self-supported, extends up to 1800 mm.

TECHNICAL SPECIFICATIONS

ACCURA 1554 AUTOMATIC (belt bridge)

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
max. 20mm with BF701 Flush trimming unit

Edging height: max. 65 mm
Workpiece thickness: 8 - 60 mm
Workpiece width: min. 60 mm
Workpiece width: min. 140 mm
Feed rate: infinite 10 - 25 m/min.

ELECTRICAL

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

OPERATION

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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

Network ready



Intelligent tool correction

The intelligent tool correction allows intuitive adjustment of all milling and scraper operations. The operator can see graphically at any time which corrections are being made in which direction. The values entered at the control for horizontal and vertical tool infeed are automatically converted to the actual axis values in the background. Test workpieces are thus a thing of the past.



fa.s.t.

fa.s.t = fast setting technology

makes it possible for edgebanders to perform various operations simultaneously.

Units can be switched on intelligently without having to empty the machine before running a set-up process, making it possible to fully utilize the entire capacity.

The locking roller at the machine infeed controls the setup gap dynamically.

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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 IE 3. 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.

EQUIPMENT VARIANTS AND ACCESSORIES

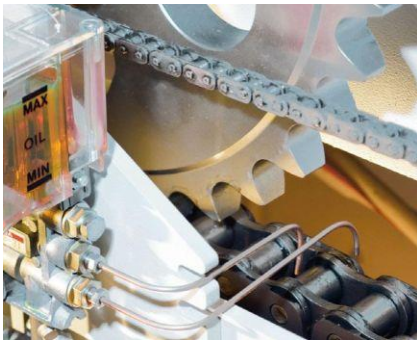


LED-Lamps (3 pc) for the infeed area / post-processing area
 Moderne LED technique with tempered, break-proof glass



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 ZH701

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

iTronic - 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
- incl. monitoring of remaining glue quantity
incl. automatic PUR purge system

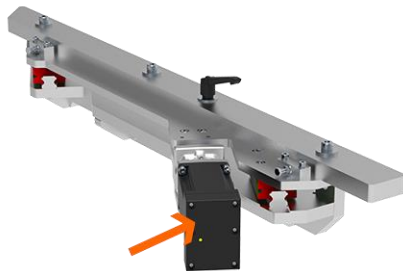
INFEED AREA

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

PRE-MILLING UNIT

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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

Advantage AirStream Technology:

Low-noise operation in use and idling -3 dB(A)

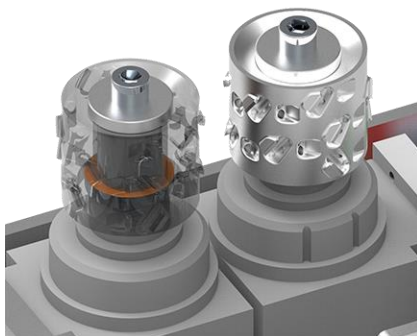
Chip capture rate up to 99% through AirStream technology.

This means significantly less double cutting, longer tool life and less cleaning effort.

35° axis angle ensures excellent cutting quality.

Resharpener zone = 1.5 mm diamond,
up to 3 - 4 re-sharpenable (depending on material)

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Diamond cutter Ø 70 x 64 x 30 mm, **2+2 teeth, left hand**
Air Stream System (HOLZ-HER / LEUCO patent)
For pre-milling unit 1802 / FG201

*
Diamond cutter, dia. 70 x 64 x 30 mm, **2+2 teeth, right hand**
Air Stream System (HOLZ-HER / LEUCO Patent)
For pre-milling unit **1802 / FG201**

EDGE FEEDER

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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



Extended edge magazine for edge feeding
Increased capacity of strip magazine 300mm

GLUE APPLICATION

MAIN GLUE STATION

Glue application system Glu Jet GJ301 automatic NC
(2,3 kW, 50 Hz)
Motorical, automatic adjustment of gluing height (tracing nozzle)

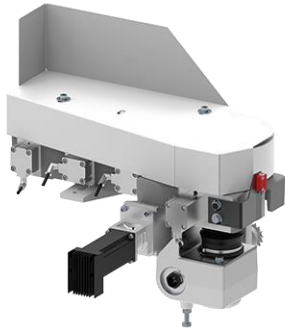
Glu Jet hybrid technology
Processing of EVA and PUR adhesives
Adhesive in cartridge or granules form
Processing of neutral and coloured adhesives

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

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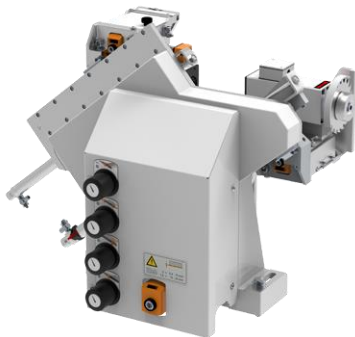


Pressure section DW701 MOT

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

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End-trimming KA702 pneumatic

(2 x 0.75 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 120 mm, Z 22, incl. 2

extraction hoods

FLUSH TRIMMING

KP



Trimming unit BF701 MOT 3 (2 x 2.0 kW, 200 Hz, 12000 min-1)
 Flush trimming unit until 20 mm edge thickness
 Motorical adjustment of the complete unit.
 Motorical adjustment of the vertical tracer rollers (top and bottom unit) for the automatic fine adjustment of the overlapping edging via NC servo drives.

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 Motorical adjustment of the vertical tracer rollers (top and bottom unit) for the automatic fine adjustment of the overlapping edging via NC servo drives.

GUARANTEE

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.

Optional Items

OPERATION



Bar code scanner

Standard bar codes: Code 39 or Code EAN 128 2D codes:
DataMatrix, PDF417



DIGITALISATION

viaCockpit Software

for a duration of 12 months

Machine data are periodically transferred to the WEINIG cloud via a secure connection. By accessing via smart devices and the web interface, these data are clearly provided to the contractor.

Functions

viaMonitor

- Overview of current and past status data
- Less downtime due to faster reaction
- Controlling and optimisation of setup and idle times allow cost reduction
- Increasing transparency facilitates production cost analysis

viaNotify

- Overview of current and past messages
- Simplified detection of frequent causes of malfunctions increases machine availability

viaOrder

- Clear presentation of order details and production progress
- Fast feedback on customer enquiries regarding production progress
- even when on the move

viaMaintain

- Simplified maintenance planning thanks to a clear maintenance monitor with reminder function prolongs machine service life
- Better planning of spare part requirements and maintenance personnel ensures smooth operation and reduces downtimes

viaCondition

- Monitoring of machine elements using sensors
- Reduced downtime and prevention of consequential damage
- Cost reduction due to maximum service life of the machine elements
- Quality assurance of the end product

Notes:

The data transfer between the machine and WEINIG Cloud takes place over the viaConnector. Activation via the WEINIG App Suite is required before use. In order to use viaCondition, machine elements equipped with sensors must be available.

For data transfer it is necessary to actively integrate the machine into a company network with an Internet-enabled computer with WINDOWS operating system and the machine must be ONLINE.

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The scope of functionality can vary depending on the product series. Machine elements equipped with sensors must be available to use viaCondition.

OPERATION

RETURN-MASTER 5920 connection package consists of:

- Emergency stop connection
- Synchronisation of feed speed
- Light barriers with control modules
- Adapted workpiece support
- Safety devices according to the latest machine regulations
- Performance Level C (2018)
- CE conformity

Preparation RETURN-connection (third-party product):

INFEEED AREA



Air cushioned table BS701 (230 V / 400 V, 50 Hz)

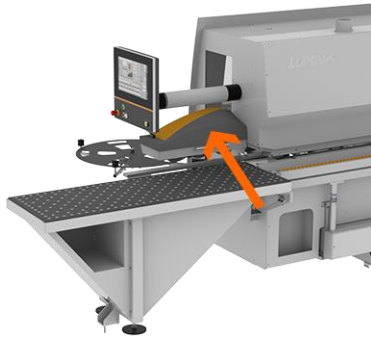
table with air cushions for an easy and gentle movement of the material at the infeed area of the machine

Fan control via control panel

length: 1800 mm, **width:** 600 mm

(inkl.long infeed fence)

with height adjustable frame base for alignment to the infeed height of the machine (880 - 900 mm)



PowerFeeder BS702
Infeed roller device

PRE-MILLING UNIT

Pre-milling unit FG701 MOT2 HSK32R 400 V

(2 x 2.0 kW, 200 Hz, 8000 - 12000 min⁻¹)

with 2 plunge-in controlled trimming units for joining panel edges, 1x operating in forward direction, 1x in rearward direction, with motorical height adjustment of the tool via 2 NC servo drives, infinitely variable speed control, 8000 - 12000 min⁻¹, max. milling thickness: 3 mm

Advantage HSK 32R tool clamping:

The increased concentricity accuracy of 20 μ ensures a smooth running of the tool and thus a higher milling quality comparable to a hydraulic clamping tool.

Low-noise operation in use and idling -3 dB(A)

Chip capture rate up to 99% through AirStream technology. This means significantly less double cutting, longer tool life and less cleaning effort.

35° axis angle ensures excellent cutting quality.

Resharpener zone = 1.5 mm diamond,
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Diamond cutter \varnothing 100 x 63 x 30 mm, **3+3 teeth, left hand**
Air Stream System (HOLZ-HER / LEUCO patent)
HSK32R
For pre-milling unit **FG701**

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