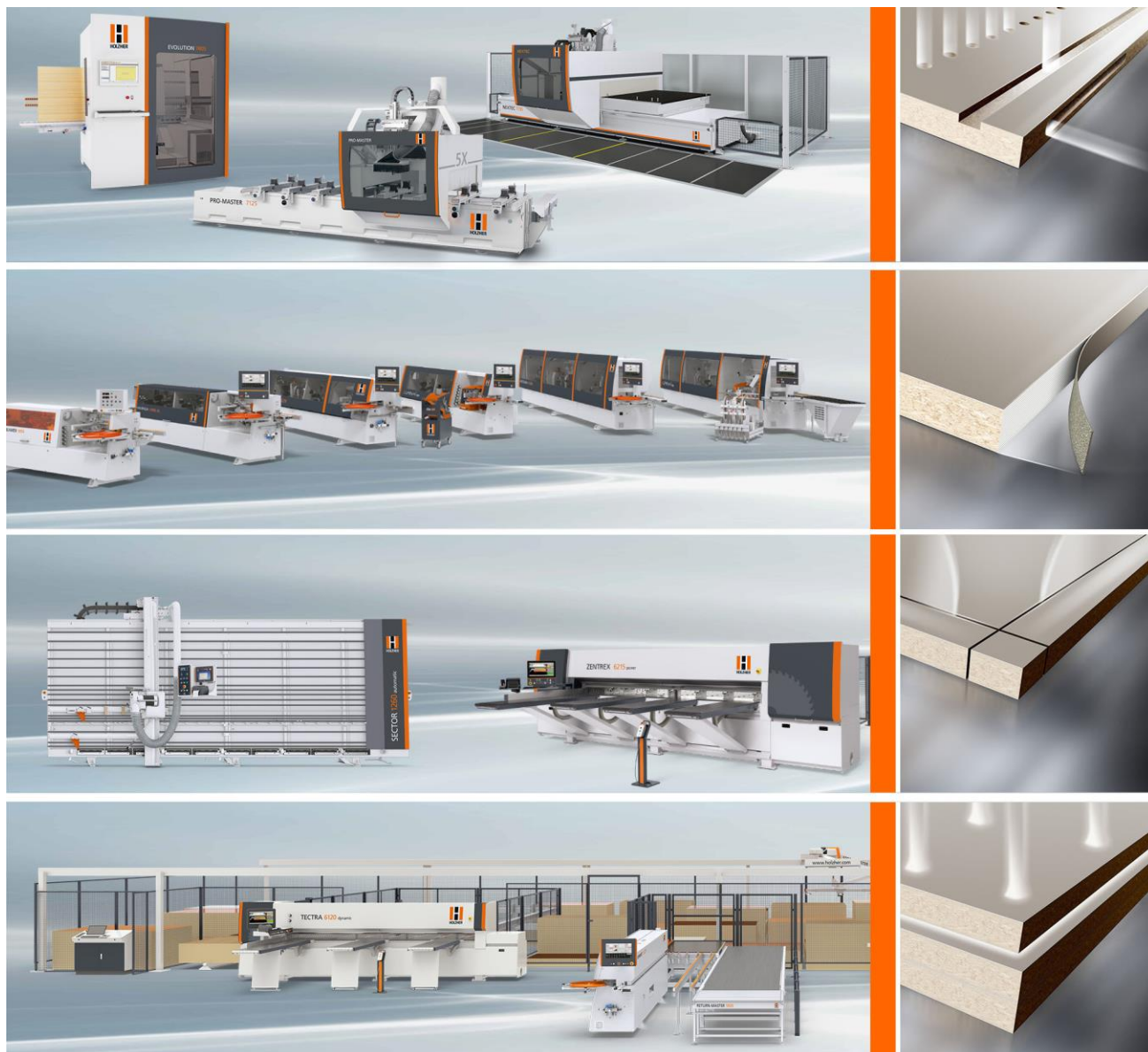


Precision and productivity for the panel processing  
Everything from a single source. Everything 100%!



**HOLZ-HER Edgebander LUMINA 1594 DOOR**



## 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 - 25 m/min**, ensure maximum ease of operation, long-term productivity, precision and operating reliability.

**Incl. synchronized driven belt bridge**

### 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) with GJ702 PUR 2K (change unit)

Highly flexible glue application with **patented nozzle for invisible zero joints**. Standard equipment allows use of PUR glue without expensive and time-consuming auxiliary equipment. Automatic cleaning feature for glue system at the touch of a button.

**Incl. automatic glue fill level control**

### 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 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 1594 DOOR



#### BASIC MACHINE

KPT 1756186\*

#### **BASIC MACHINE LUMINA 1594 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 lubricated automatically  
Pneumatic locking roller for minimum workpiece interval at machine entry  
Pressure bridge consisting of 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** above 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 lug for perfect grip on workpieces



**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, self-supported mounted on machine.  
Extendable up to 1800 mm.

## EQUIPMENT VARIANTS AND ACCESSORIES



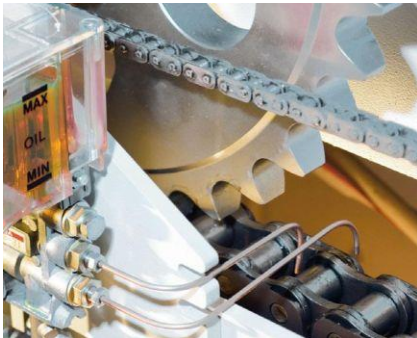
**LED-Lamps (3 pc)** for the infeed area / post-processing area  
Moderne LED technique with tempered, break-proof glass

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**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

## TECHNICAL SPECIFICATIONS

### LUMINA LT ready 1594 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 (Glu Jet)  
Max. 20mm with BF701 Flush trimming 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 - 25 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

**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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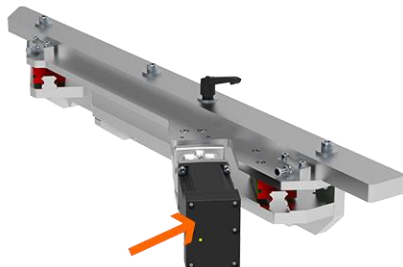
### ECO MODE+

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.

### Preparation RETURN-connection (third-party product):

#### INFEEED AREA

\*



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

#### AIR CUSHIONED TABLE



+



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

## 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 $\mu$  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,  
up to 3 - 4 re-sharpenable (depending on material)

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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Diamond cutter Ø 100 x 63 x 30 mm, **3+3 teeth, right hand**  
**Air Stream System (HOLZ-HER / LEUCO patent)**  
**HSK32R**  
For pre-milling unit **FG701**

## EDGE FEEDER

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### Edge feeder **MG701 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 Ø 820 mm

## GLUE APPLICATION

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### Glue application system **Glu Jet GJ702 PUR 2K**

Motorical, automatic adjustment of gluing height (tracing nozzle)

#### **Glu Jet hybrid technology**

Processing of PUR adhesives

Glue applied by means of nozzle technology

Incl. hopper for cartridges **for cartridge of 2 kg PUR adhesive**

Incl. hopper for cleaner granules

Incl. automatic rinse function directly at the control panel through separate rinse channel

Automatic glue temperature reduction according to time

Incl. control of glue fill level

#### **Equipment for change unit:**

Incl. change carriage

Incl. quick-change coupling device

Incl. HSK adapter for the aggregate

Incl. automatic aggregate recognition

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#### **GLU JET rinse hopper**

to collect glue residues during rinse procedure



## LTRONIC READY

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### Preparation for retrofitting - Ltronic Ready without Ltronic LT702, without changing carriage

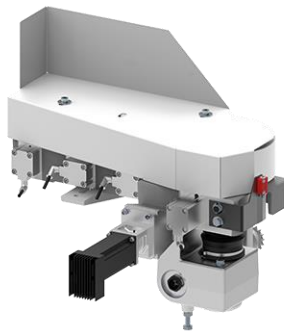
Technical preparation for retrofitting the LT702 unit for processing coextruded and subsequently coated laser edging

See separate description for costs and expenses

**24 months** after installation retrofitting will be accomplished only after technical approval.

## PRESSURE UNIT

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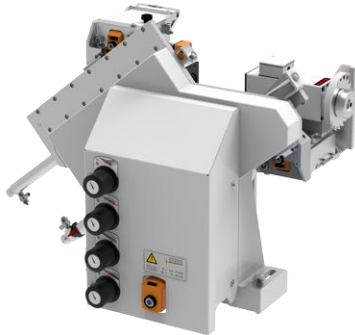


### Pressure section DW701 MOT

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<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 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<sup>-1</sup>)

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.

## 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.

## 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



### 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

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**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.

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**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.**

*Data is transferred between the machine and the WEINIG Cloud over the viaConnector. Activation using the WEINIG App Suite is required before use.*

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

## OPERATION

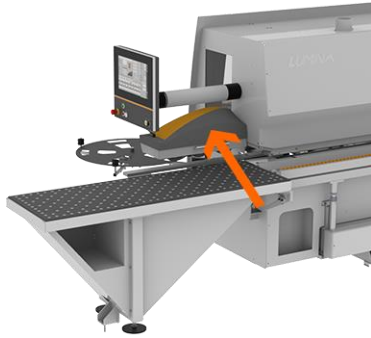
**RETURN-MASTER 5920 connection package consists of:**

- 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

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**Preparation RETURN-connection (third-party product):**

## INFEEED AREA



**PowerFeeder BS702**  
Infeed roller device



