

Focusing on the essential



The 4 Series:

HPP 410 | HPP 430 | HPL 410 | HPL 430 | HKL 430

The HOLZMA 4 series – the essence of performance

Power, speed, high performance: the HOLZMA 4 series focuses on the essential and achieves really high throughput. The high saw blade projection and enormous speed featured in all the models ensure that. This makes the 4 series ideal for all companies that process panel material on a grand scale. No-frills efficiency – success all the way.

New highlights in the standard version

- designed for smooth material flow and precise logistics
- for integrated production processes
- ecoPlus technologies:
 - even higher energy savings
 - further increase in saw performance
- cleaning flaps at the front
- clamps with two fingers
- 19" touch screen monitor
- automatic cutting height control
- manually adjustable pressure for pressure beam and clamps
- a window at the height of the pressure beam allows the rear part of the machine to be in clear view
- air tables and machine tables with air jets throughout
- first air table 800 mm wide



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The HPP models

The HPP 410 and HPP 430 are two compact, powerful single saws, characterised by their exceptional versatility. The HPP 410 is the perfect solution for expanding woodworking shops or companies producing small to medium-sized batches. The larger HPP 430 boasts greater performance thanks to its higher saw blade projection.



Highlights at a glance

- 110 mm saw blade projection for the HPP 410 and 125 mm for the HPP 430
- ergonomic table height of 920 mm
- easy operation
- reliable and efficient



HPP 430. Also available: HPP 410.
Illustration may show optional equipment not included in the basic price.

The HPL models

The HPL models from HOLZMA set you up for big jobs. These panel saws offer the convincing addition of an integrated lift table for automatic feeding. This speeds up your production and significantly boosts throughput.



Highlights at a glance

- 110 mm saw blade projection for the HPL 410 and 125 mm for the HPL 430
- ergonomic table height of 920 mm
- easy operation
- reliable and efficient
- also available: HPL 430 profiLine – with an even wider choice of optional extras



HPL 430. Also available: HPL 410.
Illustration may show optional equipment
not included in the basic price.
Safety fence obligatory.

The HKL 430 angular system

Fully automated cutting with state-of-the-art technology: that is what the new HKL 430 has to offer. This saw copes effortlessly with large books of panels – at very high speed. It is impressive in its puristic appearance and its focus on cutting large quantities fast.

- Highlights at a glance**
- angular system with small footprint
 - ideal for single panels and small books
 - high quality cuts in record time
 - 125 mm saw blade projection
 - also available: HKL 430 profiLine – with an even wider choice of optional extras



Illustration may show optional equipment not included in the basic price.

Standard features

Standard Features
HPP 410 | HPP 430 |
HPL 410 | HPL 430 | HKL 430

You think ahead. So does HOLZMA. This is clearly reflected in the standard features.
 Why not benefit from state-of-the-art, high-precision technology.

Save energy

with the new models of the 4 series. Tip: before purchasing, check out government funding opportunities.

ecoLine is now ecoPlus – for even greater energy efficiency



ecoPlus: state-of-the-art technology for energy savings of at least 20%

- the standby button, standard across all models, puts the saw in an energy-saving standby mode at the touch of a button
- all models equipped with new motors with EFF1 energy efficiency rating
- speed control by means of a modern bypass circuit for all models with frequency-controlled main saw motor

- patented rocker raises just the main saw blade, while the motor remains stationary – this saves electricity
- the light sensor on the saw carriage has its own blow-cleaner, which utilises the air discharged from the main saw motor
- the pneumatic system in the saw carriage has partly been replaced by hydro-pneumatic components, thus cutting compressed air costs and enhancing precision
- the new geometry of the saw carriage boosts extraction efficiency

- intelligent optional extra: load-dependent control of air cushion
- all models with the HOLZMA energy monitor for consumption monitoring
- lower energy requirement thanks to optimised extraction system
- HOLZMA thin-kerf saw blades available on request
- a raft of innovations for improved ergonomics and smooth production processes

More information in the ecoPlus brochure.

Program fence for precision and dimensional accuracy

- resistant to torsion and bending
- electronically controlled
- perfect guidance on H-girder
- electromagnetic measuring system guarantees positioning accuracy of +/- 0.1 mm
- measuring system involves no wear and no maintenance

Rugged pressure beam for first-class cut quality

- large-area pressure zone directly at the cutting line reduces material vibrations to a minimum
 - linear guide on both sides
 - rack and pinion ensure the necessary parallel adjustment
- This results in accurate, clean cuts, for books too.

Air jets throughout as standard: the machine table

Anyone working with sensitive material or very heavy boards and books will benefit from the machine table being equipped with air jets throughout.



Clamps

- rugged clamps, all with two fingers
- gentle positioning of material
- the bottom fingers of the clamps can be removed to allow the clamp base to be cut in perfect alignment – a fast means of adjustment
- the contact pressure can be adjusted (manually) to suit each particular type of material
- the short, rugged design allows material to be held more accurately and handled more gently
- irrespective of the book height, the top fingers of the clamps do not exert any leverage; instead, they are lowered horizontally and their entire contact surface rests on the material. This increases the working depth and ensures material is held firmly
- designed for continuous, multi-shift operation



HOLZMA patent: central side aligner

- integrated directly in the saw carriage; this shortens cycle times by up to 25% in comparison with conventional systems
- infinitely variable adjustment of contact pressure – to match the panel thickness. This allows even thin boards, laminates or sensitive materials to be processed perfectly. A new feature here is book-height-dependent control of the contact pressure: the higher the book, the greater the pressure

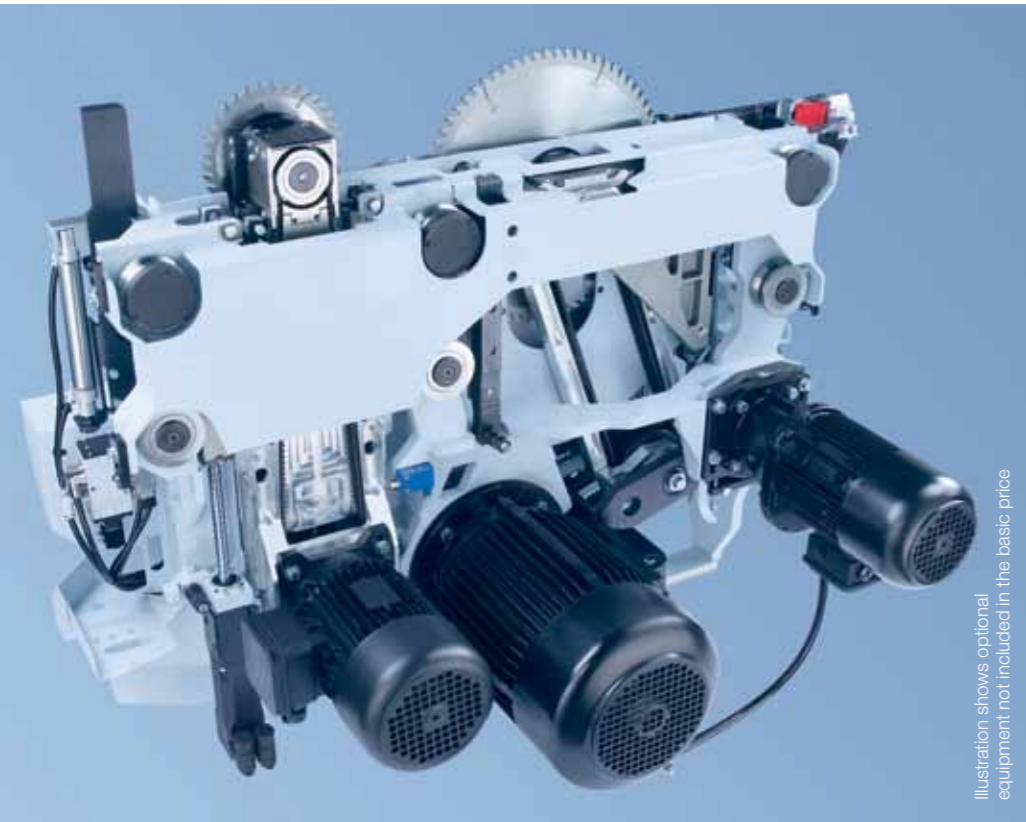


Illustration shows optional equipment not included in the basic price



Newly designed saw carriage

Exceptionally smooth running, high precision and low energy consumption are the hallmarks of the new saw carriage of the 4 series.

- developed especially for the 4 series
- torsion-resistant, rugged and resilient construction of the steel plate body for maximum dynamics and precision
- infinitely variable saw carriage speed – for precision cutting of demanding materials
- long-term accuracy of the saw blade projection
- fast, precise, low-wear and infinitely variable positioning of the main saw blade by means of linear guide system with rocker (patent)
- main saw motor is not raised
- low-noise, maintenance-free drive for the main saw blade
- Power-Loc system: fast and easy saw blade change
- spring-loaded wheels always in perfect contact with the guides
- light sensor with blow-cleaner
- reduced air requirement
- excellent extraction results thanks to the innovative design of the saw carriage
- postforming package, optional extra (page 19)

Control made to measure – CADmatic 4 PROFESSIONAL

Developed with the needs of different user groups in mind and individually configurable, the CADmatic control software delivers optimised machine cycles.

- intuitive, easy-to-understand operating software
- 3D, real-time moving graphics
- 19" TFT flat panel touch screen monitor
- online diagnostics
- improved navigation due to permanent access to all functions
- improved design for even easier operation

Handy cleaning flap

Quick and convenient: the area under the saw carriage is easily accessible via flaps. For easy removal or vacuuming of scraps and dust.



Powerful feeding system

Feeding is performed by the electro-hydraulic four-column lift table.

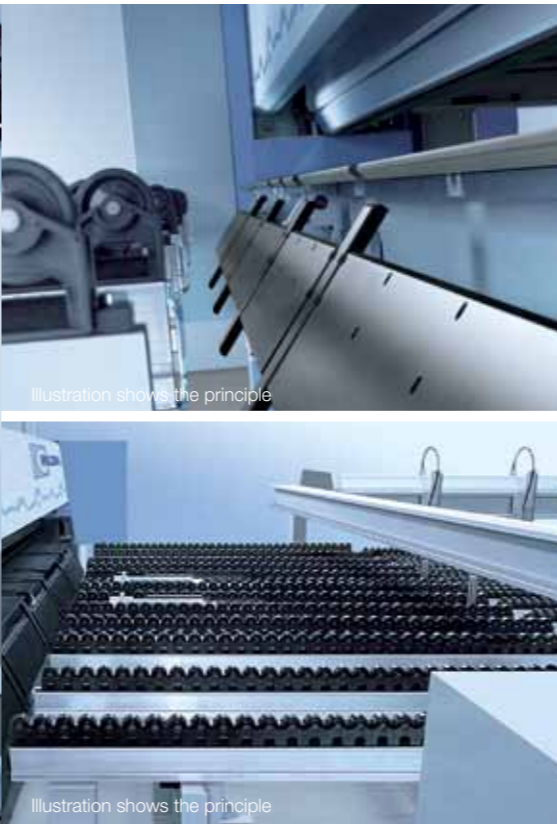
- automatic measurement of book height
- equipped as standard with longitudinal profiles and sensing device

- also suitable for thin materials from 9.5 mm upwards. If equipped with the optional extras micro-infeed and hold-back device, it is also suitable for materials from 3 mm upwards
- maintenance-free, no lubrication required



Separate backing wall

- not attached to the machine bed; this ensures precise cuts
- vibrations caused by the movement of stacks on the lift table are not passed on to the machine bed



Transfer to crosscut saw

(only for HKL)

- special powered pushers ensure perfect transfer
- roller rails can be raised and lowered
- lengthwise and crosswise alignment after transfer
- AB-BA system for mirror-image cutting on request (optional extra)
- integrated headcut device



Outfeed device for the rip saw

The outfeed device pushes the panel material onto the intermediate table and the trim onto the waste flap.

Waste flap

(only for HKL)

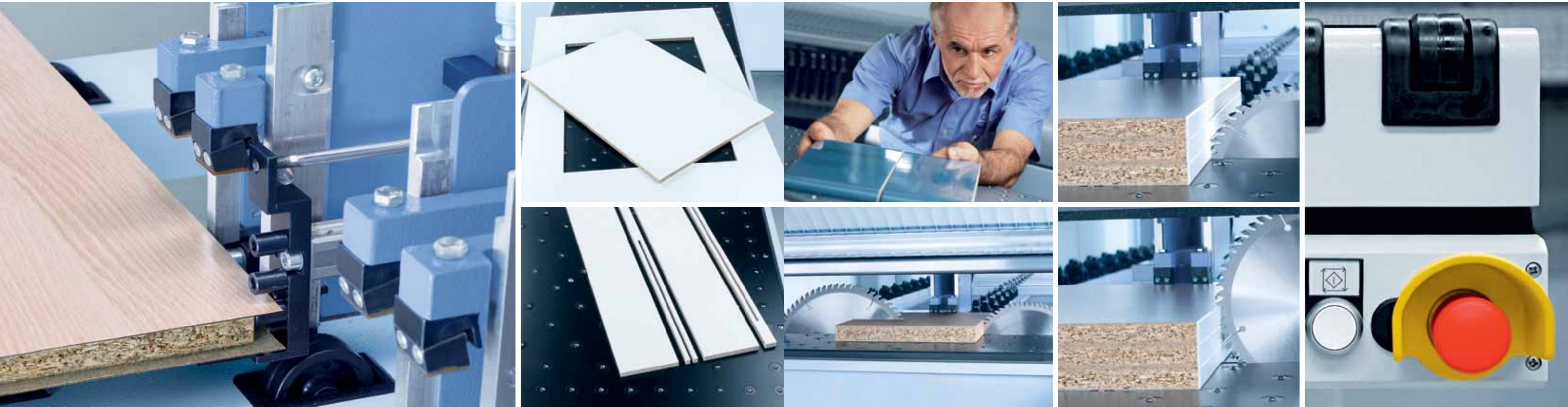
The waste flap opens automatically when required and removes waste cuttings from the rip saw.

- opens and closes in perfect coordination with the operating cycle of the system

Optional extras

Optional Extras
HPP 410 | HPP 430 |
HPL 410 | HPL 430 | HKL 430

Specially tailored options allow you to customise your HOLZMA saw to match your production process.



Pneumatic trim stops

The trim stops are attached to the clamps and are activated when needed by the CADmatic machine control.

- robust
- adjustable to popular panel thicknesses
- gentle processing of sensitive materials with overhanging laminate or veneer
- precise positioning

Cut-out and stress-release cut

At the moment material is cut, tension in the material is released and can affect the quality of dimensions and cuts. The HOLZMA stress-release cut option remedies this. Systematic preliminary cuts can be defined during optimisation and release the tension in the material. The cut-out feature additionally allows you to produce both cut-outs and intermittent grooves – as are required, for example, for kitchen sinks or doors.

The perfect postforming cut

Version 1: ascending postforming saw

- ensures perfect cuts on softformed and postformed parts
- maximum saw blade projection: 55 mm

Version 2: vertical postforming saw

- maximum saw blade projection: 90 mm
- scores the edge of the entire book (scoring depth up to a maximum of 15 mm)
- ideal for veneered edges, paper-covered edges, ABS edges etc.

Start-stop button

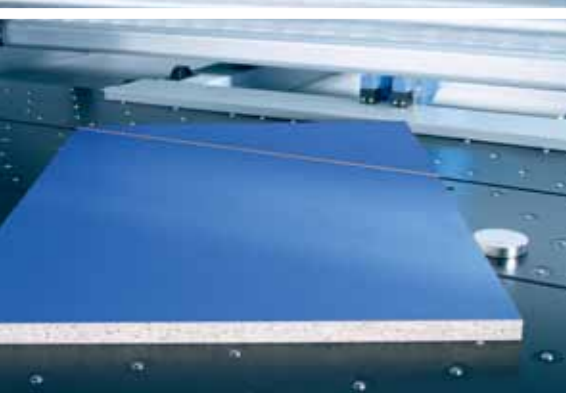
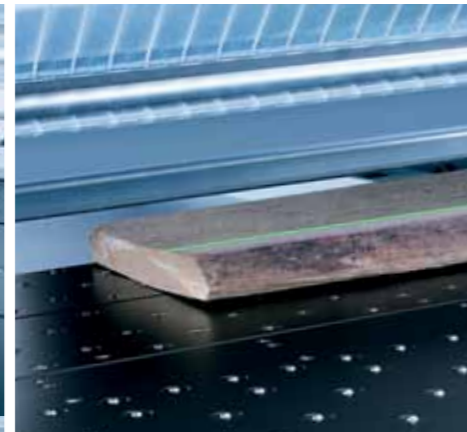
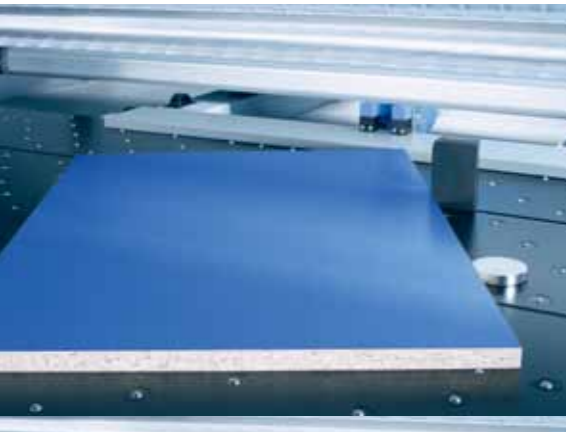
- allows the programmed cycle to be started independently of the control panel
- equipped with an emergency stop button

Optional extras

Optional Extras
HPP 410 | HPP 430 |
HPL 410 | HPL 430 | HKL 430

High-precision laser guide beam

- especially for solid wood, veneered panels and other materials with grain structure
- precision positioning right down the line



Manual angle cuts

The angle cut option allows you to control angle cuts using the CADmatic control software.

Kerfing

The “turbo-grooving” option saves you an entire production step in subsequent machining. Because your HOLZMA saw will also groove the panel material in both directions – all at top speed and much faster than a processing centre could.

Sliding label printer

The HOLZMA label printer facilitates an efficient workflow. It dispenses the right label for the right part at the right time. With barcodes, text or even graphics, depending on your needs. If, in addition, you use our Cut Rite optimisation software, instructions for downstream CNC machining can also be included on the labels. Cut Rite also permits link-up to ERP/PPC systems. In this way, you can integrate the saw perfectly in your production flow.

Cut optimisation in the office

HOLZMA increases output and efficiency in panel cutting with its proven optimisation software Cut Rite.

- optimised project control
- efficient cutting processes
- full control of costs
- faster calculations

As an alternative to the comprehensive Cut Rite optimisation software, the CADmatic add-on module CADplan can be used to perform small optimisation jobs directly at the saw.

Options packages

HOLZMA now offers the most important optional extras in attractively priced equipment packages:

- performance package
- feeding package (HPL models)
- package for sensitive surfaces (HPP models)
- angle cut package
- handling package
- grooving and cut-out package
- labelling package
- postforming package
- Cut Rite package PRACTICE
- Cut Rite package PROFESSIONAL

Additional clamps

- for an even better grip on thin, narrow or smooth materials
- for higher material throughput

Higher performance due to automated feeding from the front

The automated feeding system Econolift achieves a significantly higher material throughput in a shorter time. The result: more efficiency with less manpower.

- automated feeding from the front
- retrofittable at any time

Optional extras

Optional Extras
HPP 410 | HPP 430 |
HPL 410 | HPL 430 | HKL 430



Movable air table

The movable air table is easily moved along linear guides and offers you a mobile work surface and storage area. It will help you move small panels, big panels and books more ergonomically and with less risk of damage.

Longer air tables (not illustrated)

- length increased from 2160 mm to 2810 mm
- greater freedom of movement
- better connection to destacking systems
- very useful when cutting large-format panels



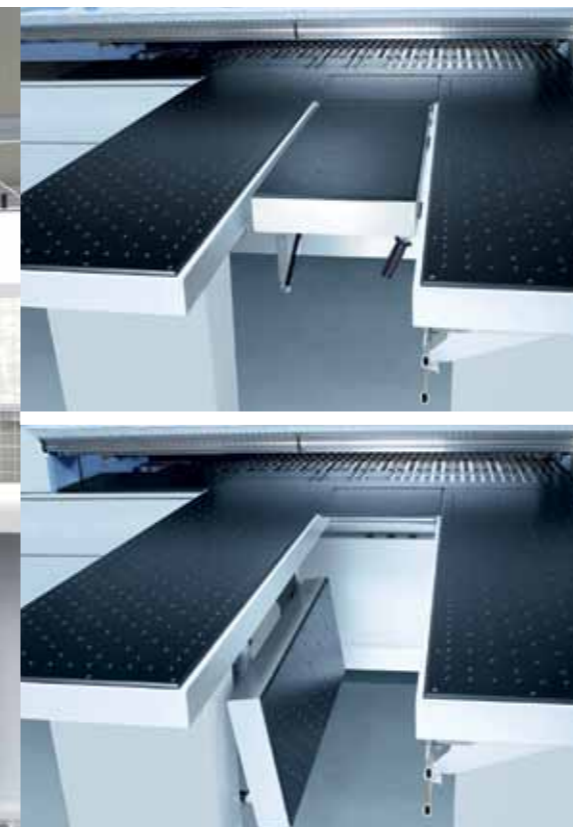
Low-cost storage link-up

HOLZMA offers economical feeding solutions with storage system integration for the single saws of the 4 new series.

- ideal for the craft sector
- low space requirement
- attractive price
- movable in x and y directions
- saw and storage system are perfectly matched
- automatic feeding for small panel saws

- perfect handling – even with just one machine operator
- easy, ergonomic operation
- storage system controls the saw

More information, for example about combination with BARGSTEDT TLF storage systems, can be found in the HOLZMA Handling brochure.



Tiltable air table

(Illustrations show principle on a different model)

- prevents thin materials from sagging
- increases the work surface
- primarily for large panels
- folds down for easy access to the cutting line



Automatic waste removal

(only for HKL)

- Vibrating conveyor: cuttings that fall through the waste flap are collected here. |A
- Waste chopper: this cuts waste into small pieces, facilitating automatic removal of the cutting scraps. |B
- Elevating conveyor belt for waste: this transports the cuttings to a container, for example. |C

profiLine optional extras (HPL/HKL 430)

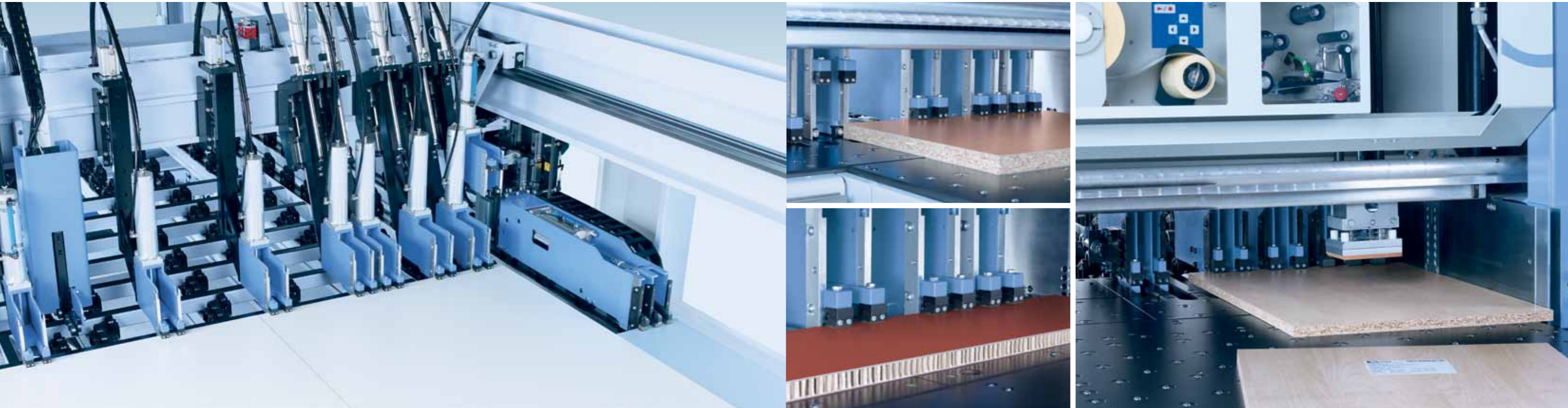
The HOLZMA profiLine options are technological highlights. They promise maximum performance and custom solutions. These advanced options require an enhanced standard specification of the saw. HOLZMA completes the extra construction work involved for a comparatively low, one-off additional charge. Your saw is then ready and prepared for all the following profiLine options.

Program-activated clamps

This option ensures panel edges are not damaged.

XXL cutting length

The HKL 430 profiLine is also available with a 5600 mm cutting length as a further option.



Power Concept – for up to 40% higher output

The Power Concept allows you to cut strips with different crosscuts together. Power Concept achieves this by means of:

- an additional clamp which works independently
- clamps on the program fence that can be raised out of the work area if necessary

- sorting the strips again, directly at the saw, so that they are ideally matched to the Power Concept. This is based on existing optimisation data for shortest machining times

The advantages:

- up to 40% higher output
- significantly shorter cutting cycles
- significantly improved material flow
- high material throughput
- lower costs per cut

- attractively priced high-tech solution with minimum space requirement
- precision cutting of even very narrow strips
- simultaneous feeding and cutting without a separate infeed carriage: the Power Concept clamp positions the last strip at the cutting line while the program fence fetches the next panel or book of panels from the lift table (HPL)

Soft Touch package for pressure-sensitive material

As the diversity of materials increases, so do the requirements: pressure-sensitive lightweight boards, composite boards and plastic sheets are steadily gaining in importance. HOLZMA has bundled the technologies to deal with these materials in the Soft Touch package. HOLZMA also offers equally innovative package solutions for scratch-sensitive material. Ask your HOLZMA advisor for more details.

Fully automatic labelling

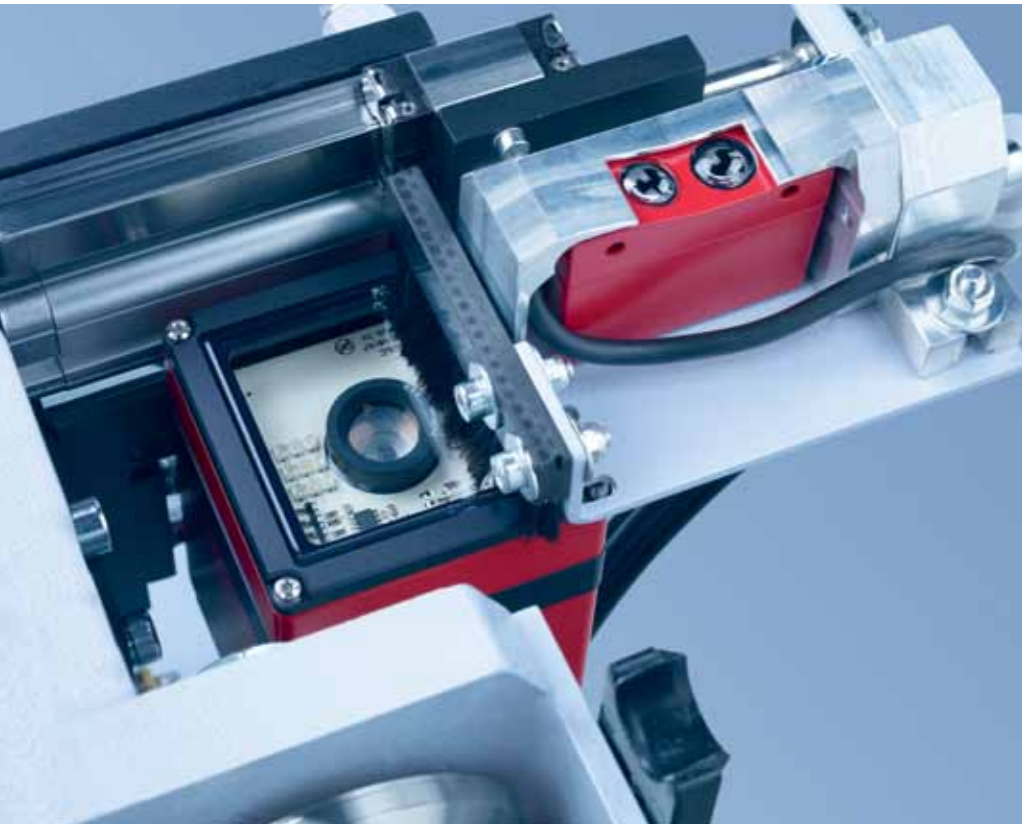
The printer is located near the pressure beam, so in your field of vision, and labels the finished parts and books – also when several strips are cut simultaneously, side by side (Power Concept). It makes no difference at all whether you feed the panels from the front or the rear.

- suitable for panels, offcuts and finished parts
- gives precise details of the destacking location
- gives precise instructions for further processing
- saves time
- prevents errors
- guides the operator

profiLine optional extras (HPL/HKL 430)

Anodised aluminium machine bed plates

The special coating ensures exceptionally gentle material handling. Ideal for materials with highly sensitive surfaces. This option is also included in the "highly sensitive surfaces" package.



Patented: camera-controlled scoring saw adjustment

This adjusts the scoring saw fully automatically (manual adjustment is still possible if desired).

- optimal measuring results: the camera selects the colour of lighting and the exposure time itself
- the simple adjustment takes no longer than a minute
- adjustment is accurate to one hundredth of a millimetre



Automatic angle cut device

This technology completes angle cuts fully automatically, after you have entered the respective data in the CADmatic control.

Dust-trap curtain on both sides

- attached to front and rear of the pressure beam
- protects operators from dust
- improves extraction
- ideal for dust cuts



Ready for large-scale storage system integration

This optional extra ensures that your HOLZMA saw is open for connection to almost all storage systems. The perfectly matched machines and systems of the HOMAG Group ensure top performance. Take a look at the HOLZMA Handling brochure for more information.

Illustration shows the principle. Storage integration as illustrated is not possible.

profiLine optional extras (HPL/HKL 430)



Everything in view – with video monitoring

- recommended for large panel saws
- displayed via the CADmatic control software
- you always have the rear machine table and infeed system in view
- camera pictures can be recorded for error diagnostics and workflow optimisation purposes and sent to the HOLZMA Service department



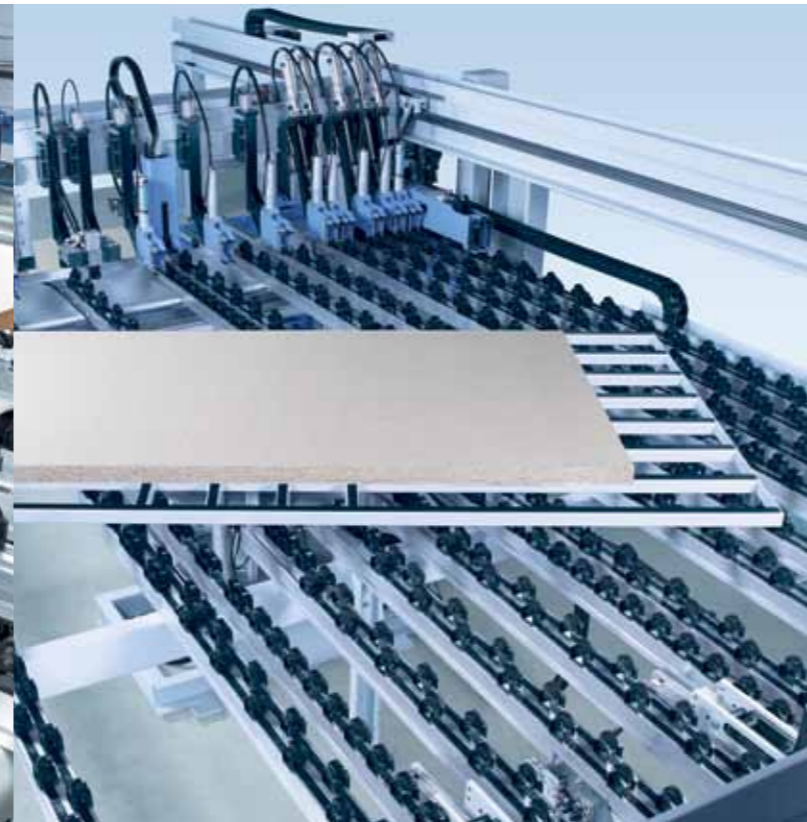
Extra impetus for feeding

The automatically driven roller conveyor, integrated in the lift table, and additional roller conveyors to the side ensure fast stack change.



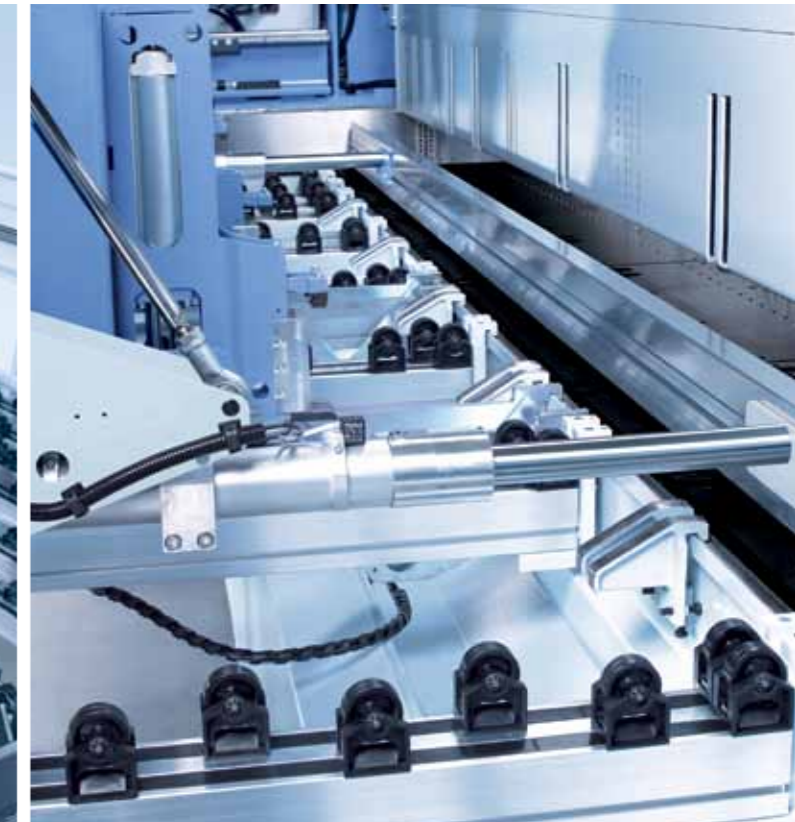
Hold-back device |B

The micro-infeed option |A can be combined with hold-back device |B for thin panels from a thickness of 3 mm upwards



Turning device for headcuts)

- labour-saving device for operators
- with automatic aligning function
- significant increase in output
- process integrated perfectly in the machine cycle
- less time required for preparation
- high degree of operating comfort



Automatic push-out fence (profiLine)

- pushes panel remnants from the rear machine table across the cutting line to the front
- you no longer need to reach into the cutting area
- ergonomic

Micro-infeed for thin panels |A

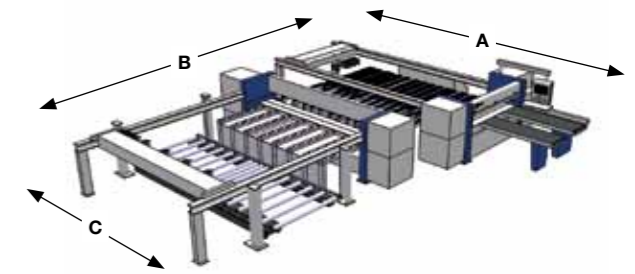
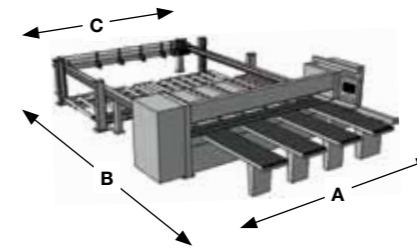
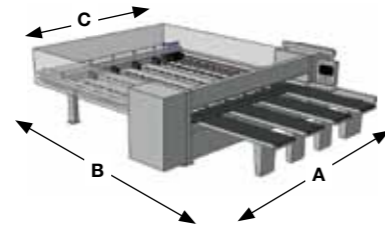
The micro-infeed option* allows thin panels from 6 mm upwards to be pushed onto the rear machine table (provided that their properties meet HOLZMA specifications). Book height is measured by a non-contact, electro-magnetic measuring system which is completely maintenance-free.

*Standard feature for 5600 mm cutting length

The HOLZMA 4 series at a glance

Technical Data
HPP 410 | HPP 430 |
HPL 410 | HPL 430 | HKL 430

Size, performance, features: Here, you will find the most important technical data for the 4 series at a glance. If you would like to know more, just contact your HOLZMA sales advisor. He will be pleased to provide you with comprehensive information.



Technical data*	HPP 410	HPP 430	HPL 410	HPL 430	HKL 430
Saw blade projection	110 mm (4.33")	125 mm (4.92")	110 mm (4.33")	125 mm (4.92")	125 mm (4.92")
Cutting length, cutting width	3800/4300 mm (150"/170")	3800/4300 mm (150"/170")	3800/4300 mm (150"/170")	3800/4300 mm (150"/170")	rip saw: 3200/4300/5600***** mm crosscut saw: 2200 mm (2100 mm*****)
Lift table width	-	-	2200 mm (86.6")	2200/1600*****/2700***** mm (86.6"/63*****/106.3*****)	2200/1600*****/2700***** mm (86.6"/63*****/106.3*****)
Program fence speed **	90 m/min (295 ft/min)	90 m/min (295 ft/min)	90 m/min (295 ft/min)	90 m/min (295 ft/min)	rip saw: 90 m/min (295 ft/min) crosscut saw: 140 m/min (459.2 ft/min)
Saw carriage speed	1-150 m/min (3-492 ft/min)	1-150 m/min (3-492 ft/min)	1-150 m/min (3-492 ft/min)	1-150 m/min (3-492 ft/min)	1-150 m/min (3-492 ft/min)
Main saw motor	18 kW (24.5 HP)	18 kW (24.5 HP)	18 kW (24.5 HP)	18 kW (24.5 HP)	18 kW (24.5 HP)
Scoring saw motor	2.2 kW (3 HP)	2.2 kW (3 HP)	2.2 kW (3 HP)	2.2 kW (3 HP)	2.2 kW (3 HP)
Average total air requirement	120 NI/min (4.24 cfm)	120 NI/min (4.24 cfm)	180 NI/min (6.35 cfm)	180 NI/min (6.35 cfm)	450 NI/min (15.9 cfm)
Compressed air requirement	6 bar (87 psi)	6 bar (87 psi)	6 bar (87 psi)	6 bar (87 psi)	6 bar (87 psi)
Extraction system	3800 m³/h, 26 m/sec (2589 cfm)	3800 m³/h, 26 m/sec (2589 cfm)	3800 m³/h, 26 m/sec (2589 cfm)	3800 m³/h, 26 m/sec (2589 cfm)	7600 m³/h (9030 m³/h****), 26 m/sec 4472.6 cfm (5314.2 cfm****)
Total connected load	24 kW (32.6 HP)	24 kW (32.6 HP)	28 kW (31.8 HP)	28 kW (31.8 HP)	53 kW (72.1)
Max. stack height without pit	-	-	560 mm (22")	560 mm (22")	560 mm (450 mm****) / 22" (17.7")
Max. stack weight	-	-	4 t (8816 lbs)	4 t (8816 lbs)	4 t (8816 lbs) / 10 t**** (22 046 lbs****)
Working height	920 mm (36.2")	920 mm (36.2")	920 mm (36.2")	920 mm (36.2")	920 mm (36.2")
Air tables	3/4 x 2160 mm (85")	3/4 x 2160 mm (85")	3/4 x 2160 mm (85")	3/4 x 2160 mm (85")	2 x 2160 mm (85")

* Values relate to the standard version
 ** In EU countries, Switzerland and Liechtenstein, forward speed is restricted to 25m/min
 *** Dim. A: incl. 64 mm for extraction connection. Dim. C: standard program fence width; there are wider dimensions for the lift table with HPL and HKL machines.
 **** For the 5600 mm cutting length
 ***** Only for profiLine
 ***** Maximum width that can be aligned

Machine dimensions***				
HPP 410	HPP 430	A	B	C
HPP 410/38/32	HPP 430/38/32	5924 mm (233.2")	6543 mm (257.6")	4269 mm (168")
HPP 410/38/38	HPP 430/38/38	5924 mm (233.2")	7143 mm (281.2")	4269 mm (168")
HPP 410/43/32	HPP 430/43/32	6514 mm (256.5")	6543 mm (257.6")	4859 mm (168")
HPP 410/43/43	HPP 430/43/43	6514 mm (256.5")	7693 mm (281.2")	4859 mm (168")

Machine dimensions***				
HPL 410	HPL 430	A	B	C
HPL 410/38/22	HPL 430/38/22	5924 mm (233.2")	9963 mm (392.2")	4196 mm (165.2")
HPL 410/43/22	HPL 430/43/22	6514 mm (256.5")	9963 mm (392.2")	4786 mm (188.4")
	HPL 430/38/22 profiLine	5924 mm (233.2")	9963 mm (392.2")	4196 mm (165.2")
	HPL 430/43/22 profiLine	6514 mm (256.5")	9963 mm (392.2")	4786 mm (188.4")
Machine dimensions***				
HKL 430	A	B	C	
HKL 430/32/22	8020 mm (315.7")	11760 mm (463")	3636 mm (143.2")	
HKL 430/43/22	9170 mm (361")	11760 mm (463")	4786 mm (188.4")	
HKL 430/32/22 profiLine	8020 mm (315.7")	11760 mm (463")	3636 mm (143.2")	
HKL 430/43/22 profiLine	9170 mm (361")	11760 mm (463")	4786 mm (188.4")	
HKL 430/56/22 profiLine	10520 mm (414.2")	11760 mm (463")	6136 mm (241.6")	

All dimensions subject to change

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A VDMA Campaign

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Illustrations may show optional equipment not included in the basic price.



A company of the HOMAG Group



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