

HOLZHER[®]

special machines

Edge Banders

AGGORD

Edge Banders

The ACCORD Generation

For edging from 0.3 to 30 mm thickness up to 60 mm workpiece thickness

The new ACCORD line complements all the advantages that have distinguished HOLZ-HER edge banders in the past. It offers even better performance, more flexibility and improved economy.

The HOLZ-HER ACCORD series accommodates up to 12 work stations. You have the choice of 18 stations with more than 40 tooling possibilities, to set up the machine exactly in accordance with your needs.

Unbeatable arguments:

10 different machine lengths – one of them will meet your requirements

3 glue application systems – choose among these world-wide patented HOLZ-HER glue application systems:

- Cartridge system
- ultra-granupress-system*
- * May also be supplied as
- DUO model

Simple change of colour and grade of glue, no overheating and glue burn, no need for tank cleaning, immediate readiness for operation, lower energy consumption.

3 edge strip magazine models – including fully automated feed of both coil and strip material: Simply set the selector switch.

2 end-trimmer motors – with draw cut. Simple setting for 90° or for bevelled end trimming up to 10° max.

10 cutter settings – for flush trimming, radius and chamfer cutting, vertical and horizontal edge rounding, dado and profile cutting

2 Sanding units – for 90° edge surfaces or for top or bottom edge chamfer.

Scrapper unit

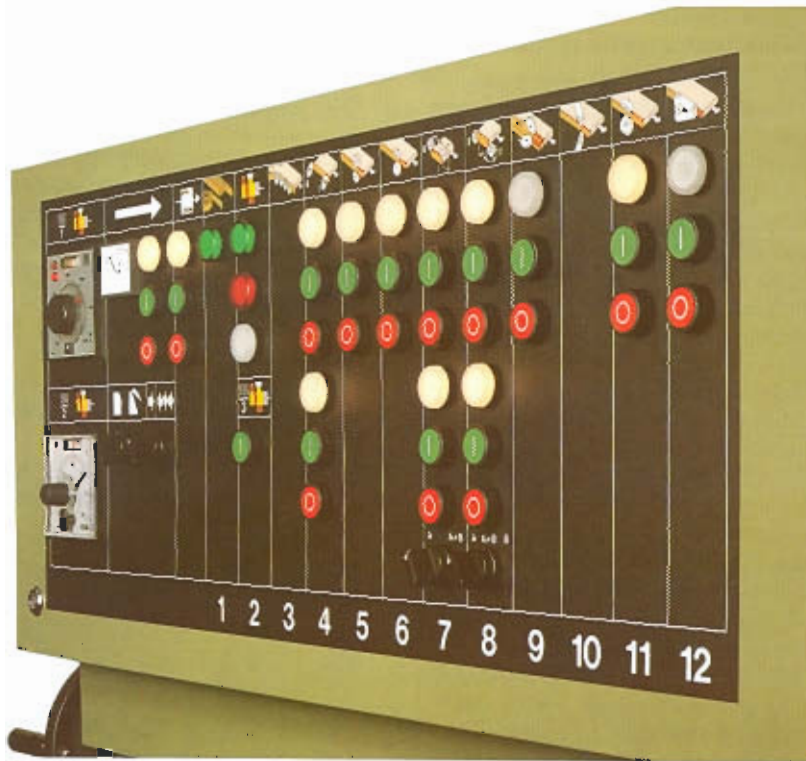
for machining PVC edges, with chip collector box (optional).

2 buffing units

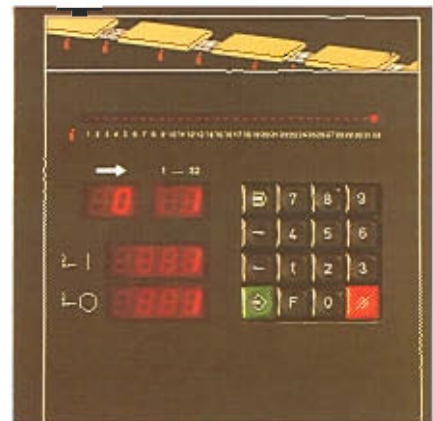
suitable for textile, lamellar or segmented discs.



Innovation for real progress

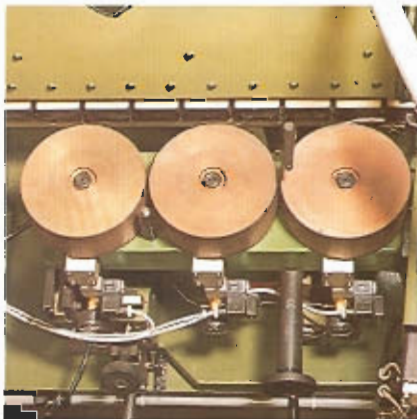


Well-arranged operator's panel
A clear functional display shows all unit functions and conditions, which may be changed whenever needed. Meaningful symbols and figures improve positive operation.



New:
Electronic micro processor

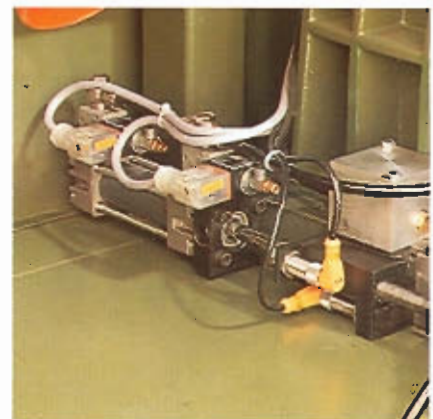
- With 32 freely programmable limit switch functions.
- Individual selection of start and stop positions.
- Indication of feed speed.
- 32 LEDs for status indication.
- Caters for difficult shapes, which would be unsuitable for mechanical limit switches.
- Standard feature with ACCORD models 1445 to 1449.



New:
Pneumatic pressure unit 1926
A manometer ensures correct pressure regulation of each individual pressure roller.

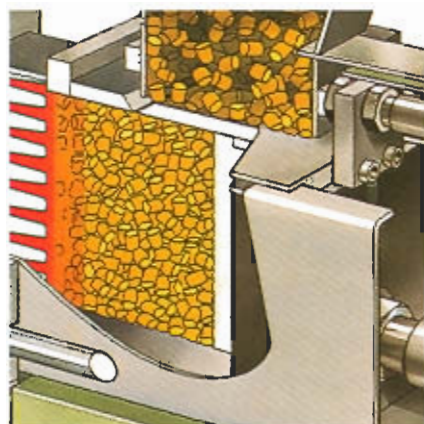


New:
Digital counters (SIKO)
Fast positive re-setting of units with digital indication.



New:
Pneumatic unit shift device
For quick retraction of units not used at the time. At present available for profile cutters 1931/1932; flush-trimming units 1933, 1934, 1962 and 1966; edge sander 1935; scraper unit 1927; buffing units 1941 and 1944.

The HOLZ-HER »ultra-granupress« System



The HOLZ-HER »ultra-granupress« system*

is the product of on-going development of the cartridge system, and quite definitely the most modern glue application system on the market. Any type of commercially available hotmelt pellets may be used, and the glue hopper has a capacity of up to 4 kg. This is sufficient to glue edging 600 mm long and 19 mm wide. A cylinder/piston combination shapes the pellets into rectangular cartridges (even here the glue pellets are compacted into cartridges before use).

Only the amount of glue needed at the time is heated and melted. This means fresh glue at any time, not one that has been re-heated over and over again. The quality of your edging will prove it. The enclosed pressure system also makes it possible to use the recently developed glue types which are highly cold and heat resistant, but which cannot be used with conventional open glue melt pots.

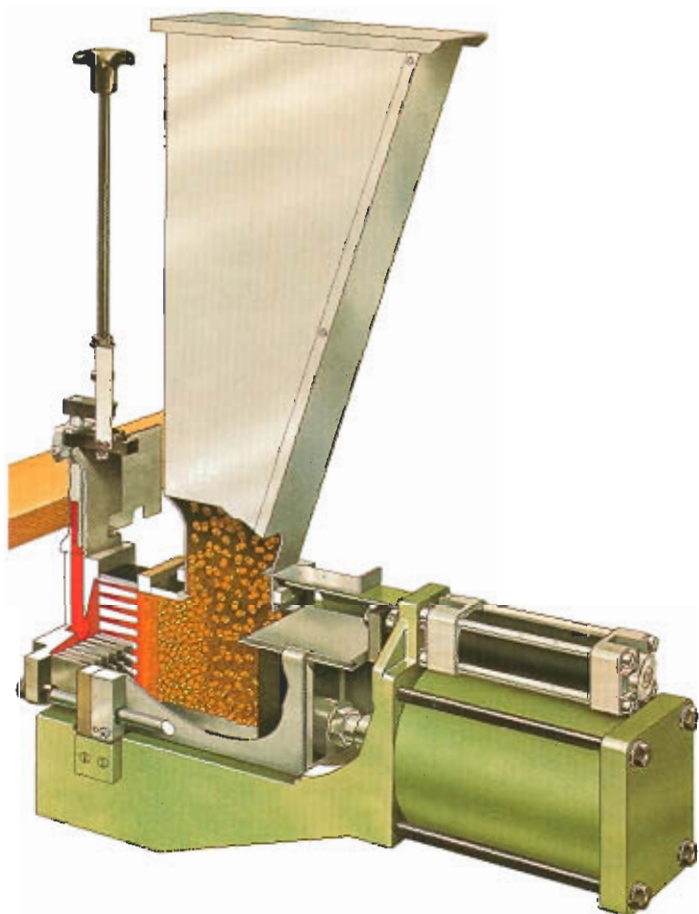
Quite unique is the automatic »flushing« of the entire glue application system: the new glue, (when changing the glue type) dumps the old remaining glue directly into a waste container. Any impurities, however small, which may have entered the system together with the pellets, are automatically flushed out before each glue application. »ultra-granupress« is a closed glue application system. The glue in the application station is protected from the air, and can neither oxidise, burn off or become contaminated.

These are the main advantages:

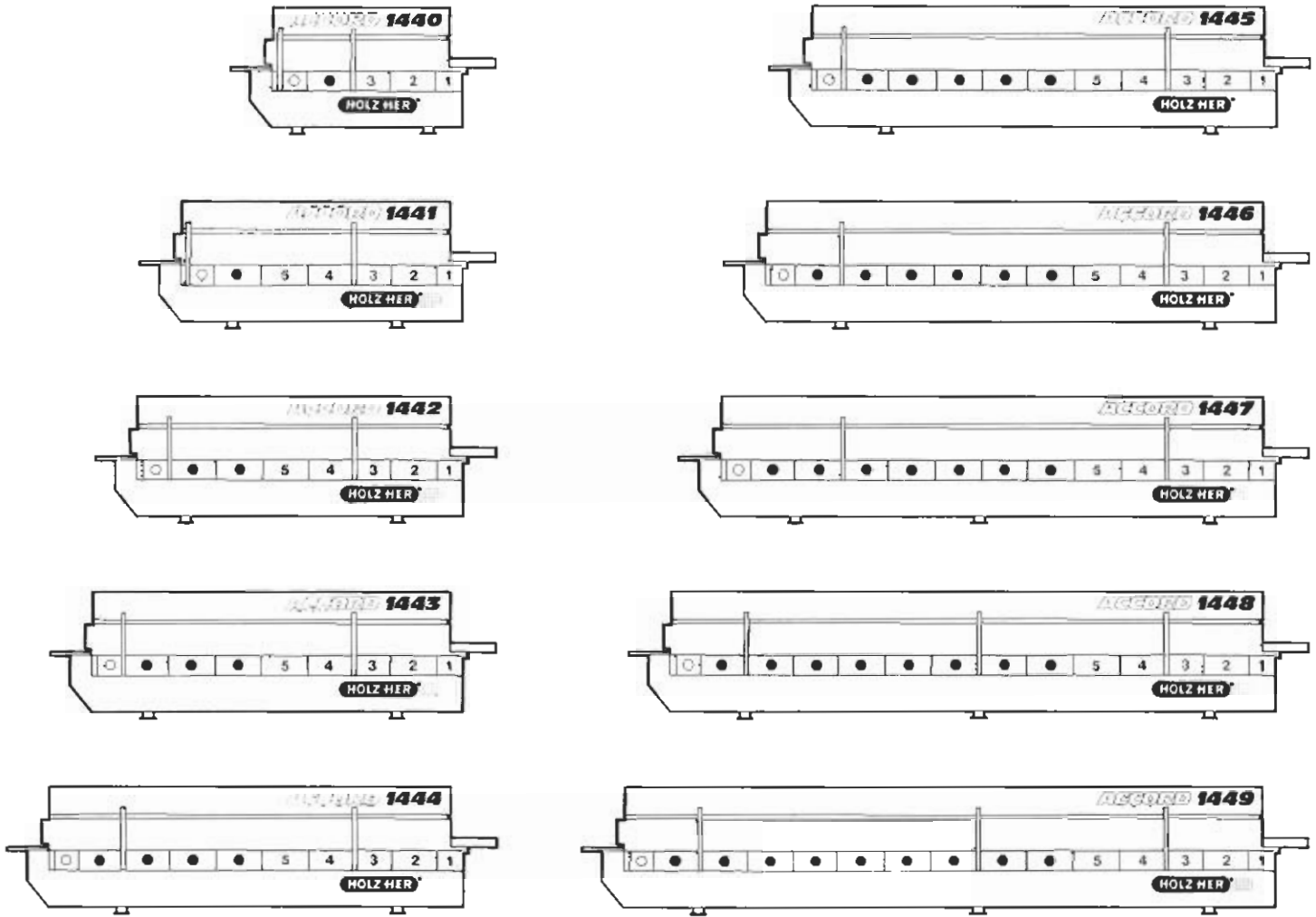
- Heating-up time only 3 to 5 minutes – and the system is ready for use.
- Colour change: Fast and easy change of different glue types.
- Economy: Only as much glue is melted off as is required for the job.
- Friendly to the environment: Fewer moving parts mean less noise. Fumes and heat losses are considerably lower than with conventional melt pots.
- Efficiency: The glue does not burn off: this means that the container requires no cleaning and less heat is evolved. The result is reduced energy consumption, fewer parts needing replacement, lower service costs – etc.

* Home and foreign patents.

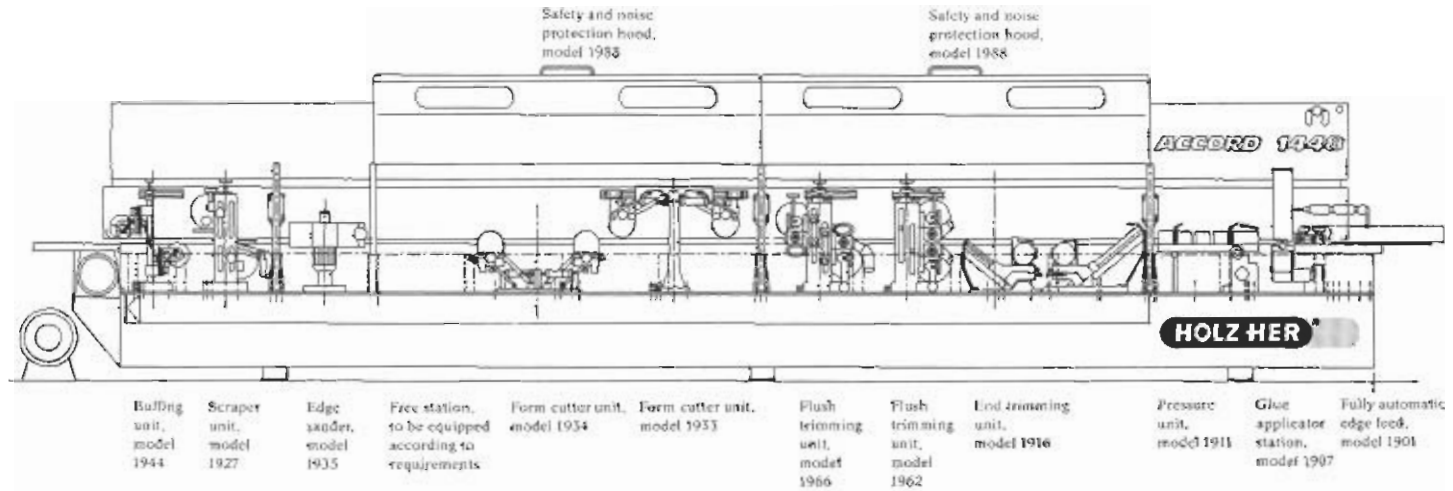
Our experts will be very pleased to supply you with any further information required – with no obligation to you.



Plan your machine according to your needs



1 – Magazine, 2 – Gluing station, 3 – Pressure unit, 4 + 5 – End trimming station,
 ● – Station(s) to be equipped at will, ◻ – Bulling unit



We will be pleased to let you have a computer aided design plan for your particular machine set-up.

Edge bander 1440



The 1440 edge bander is also available as a compact model with fixed processing units. This version is particularly cost effective for edging of 0.3 to 20 mm thickness.

The fully automated edge feed takes coiled and solid wood edging of 0.3 to 20 mm thickness. Simply set your choice at the selector switch, and the machine is ready for use.

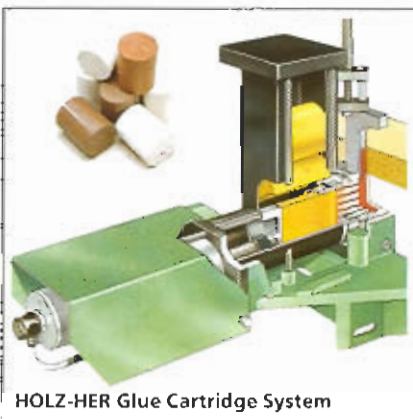
The »Cartridge« glue application system is best suited to the requirements of the smaller workshop: Shortest possible heating-up times, fast changeover from one glue type and colour to another, no cleaning or maintenance.

The pressure unit boasts a quick reset feature, to make the re-setting for thin veneer strips as fast and easy as for thicker solid wood edgings. The rest is left to the first pressure roller which runs synchronous with the workpiece feed and keeps the edging parallel.

Setting of the flush-trimming unit is extremely simple, both for flat trimming and for chamfering. A few simple adjustments, and everything is ready, top and bottom at the same time.

The acoustic hood is equipped with a safety interlock, to prevent it from being opened during operation. There is only one central connector for dust extraction.

The 1440 model may also be equipped with other units, and there are a number of possibilities: From edge magazines to glue applicators and trimmers.



Edge bander 1442



The 1442 edge bander is also representative of other ACCORD range models:

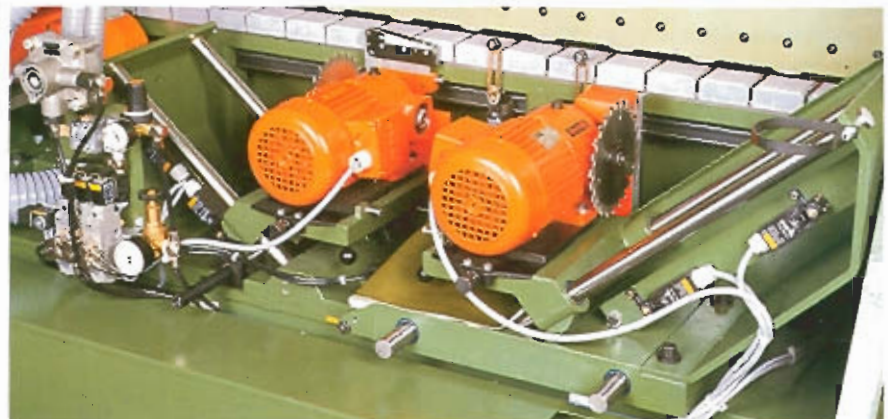
The overall length of the machine is designed to accommodate the most important machining units following the application of the edge strip, that is end trimming, flush trimming, sanding and profiling.

The following stations are fixed:

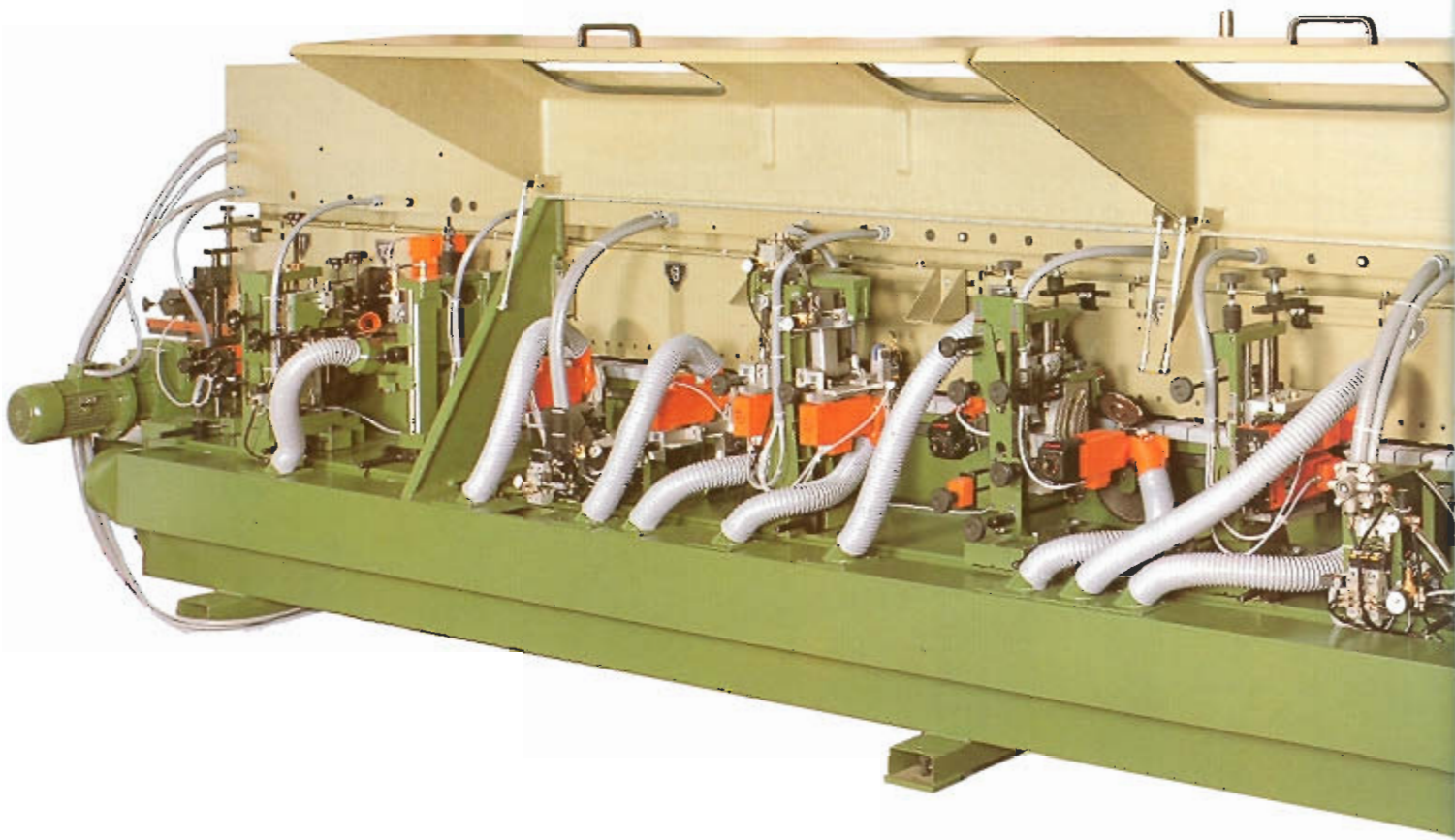
Edge strip magazine, glue applicator, pressure unit and end trimmer.

The following two stations may be equipped at will and may accommodate either a rough or fine trimming unit, a sanding unit, a grooving unit or a profiler. And the final station still leaves room for a buffing unit for polishing and cleaning.

Processing requirements determine the number of work stations and, therefore, the length of the basic machine. Up to 12 machining stations with more than 40 tooling options are available to meet your needs.

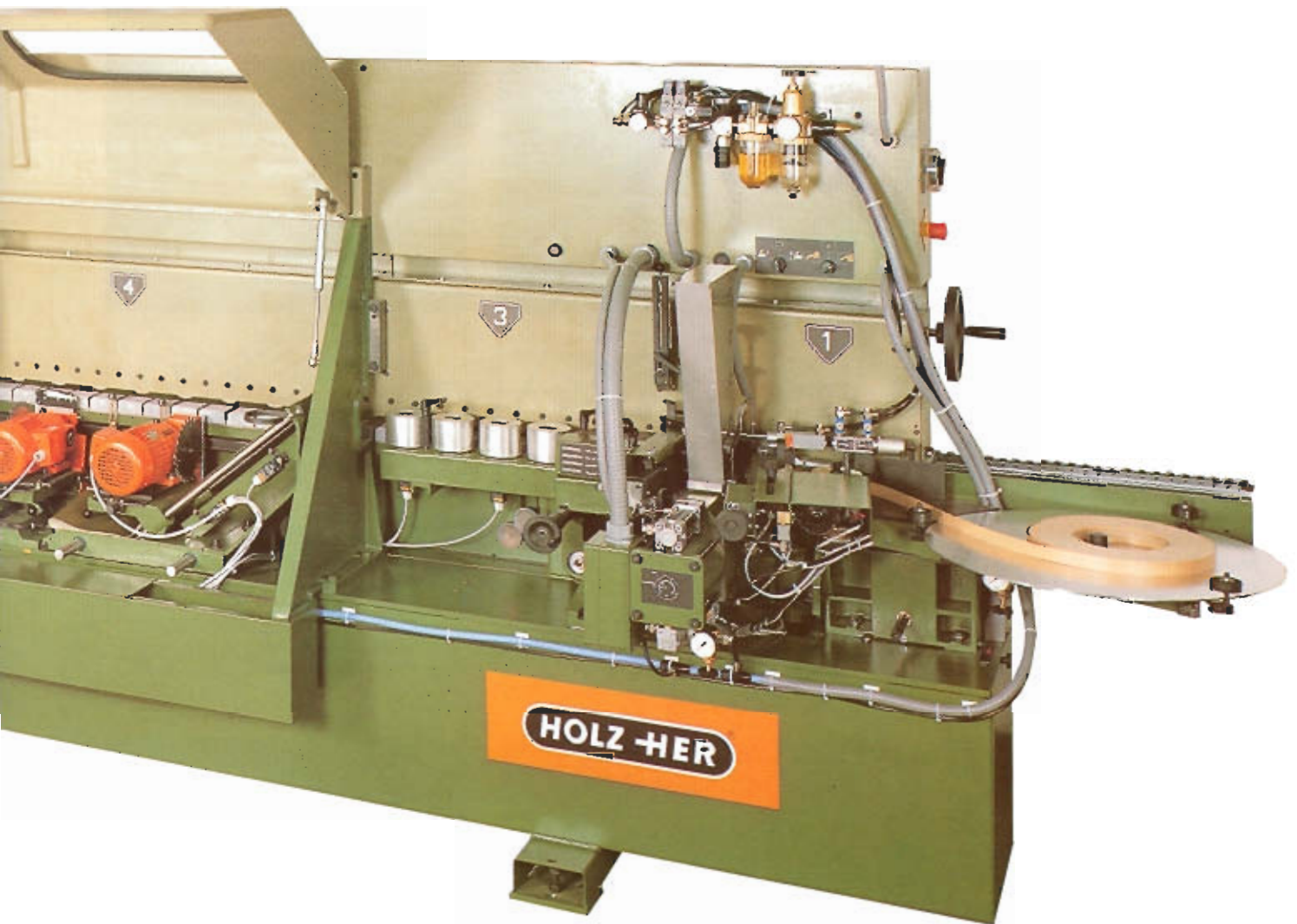


At a glance



Technical Data	1440	1441	1442	1443	1444	1445	1446	1447	1448	1449
Machine dimensions in mm:										
Length	3320	4520	5120	5720	6320	6920	7520	8120	8720	9320
Depth	880	920	920	920	970	970	970	970	970	970
Depth with support rail extended	1380	1420	1420	1420	1470	1470	1470	1470	1470	1470
Min. clearance from wall	340	500	500	500	500	500	500	500	500	500
Height	1725	1725	1725	1725	1725	1725	1725	1725	1725	1725
Workpiece infeed height	850	850	850	850	850	850	850	850	850	850
Operating system	Hot/cold, left hand									
Working dimensions, depending on equipment used:										
Edge strip thickness, mm	0.3 - 30	0.3 - 30	0.3 - 30	0.3 - 30	0.3 - 30	0.3 - 30	0.3 - 30	0.3 - 30	0.3 - 30	0.3 - 30
Edge strip height, mm, max.	66	66	66	66	66	66	66	66	66	66
Edge strip length, mm, min.	200	200	200	200	200	200	200	200	200	200
Edge strip length with automatic feed, mm, min.	350	350	350	350	350	350	350	350	350	350
Edge strip projection, vertical, per side, mm, max.	3	3	3	3	3	3	3	3	3	3
Workpiece width, mm, min.	60	60	60	60	60	60	60	60	60	60
Workpiece length, mm, min. at 60 mm thickness, max., approx. m	140	140	140	140	140	140	140	140	140	140
(Increased length for thinner workpieces)	6	6	6	6	6	6	6	6	6	6
Workpiece thickness, mm, min.	6	6	6	6	6	6	6	6	6	6
mm, max.	60	60	60	60	60	60	60	60	60	60

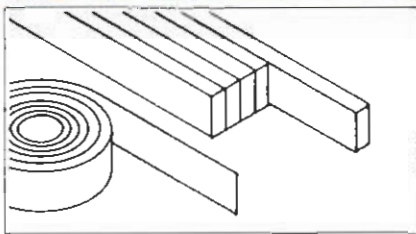
ACCORD



	1440	1441	1442	1443	1444	1445	1446	1447	1448	1449
Feed:										
Motor power, kW	0.75	1.8	1.8	1.8	2.5	2.5	2.5	2.5	2.5	2.5
Speed, m/min	8/16	8/16 or 12/24	8/16 or 12/24	8/16 or 12/24	8/16 or 12/24	8/16 or 12/24	8/16 or 12/24	8/16 or 12/24	8/16 or 12/24	8/16 or 12/24
Energy consumption:										
Connected load –	Depending on stations									
Compressed air connecting, bar	6	6	6	6	6	6	6	6	6	6
Connector	R 3/8"	R 3/8"	R 3/8"	R 3/8"	R 3/8"	R 3/8"	R 3/8"	R 3/8"	R 3/8"	R 3/8"
Extraction air requirement (6 mbar, dyn. pressure), m ³ /h.	1000	1000	2000	2000	2000	3500	3500	3500	3500	3500
Connector dia., mm	125	125	160	160	160	200	200	200	200	200
Standard accessories:	Set of spanners, operating manual with spare parts list, hot-melt glue.									
Optional extras:	Counterpressure rail.									

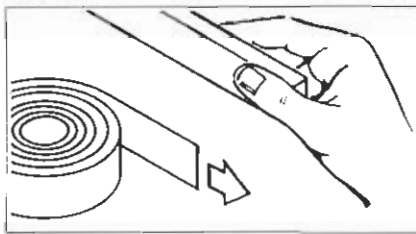
This specification is based on approximate values. We reserve the right to modify any of the data and illustrations, as HOLZ-HER products are subject to continuous improvement and updating.

Range of units available for individual choice



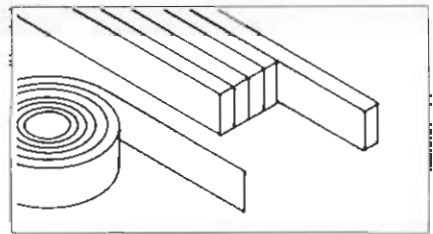
Fully automated edge feeder, Model 1901

For coiled edging and for cut lengths
 Coiled edging: 0.3 – 3.0 mm;
 Max. coil dia. 575 mm
 Straight edging: 0.3 – 30 mm thickness
 For 1440 up to 20 mm as standard
 Edge length 350 mm min.
 Edge height up to 66 mm



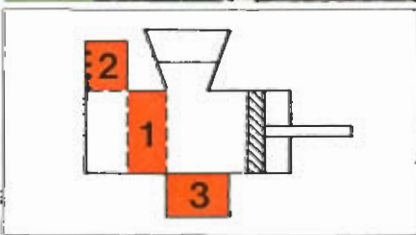
Automatic edge feeder, Model 1902

For coiled material 0.3 – 1.2 mm thick
 Max. coil dia. 575 mm
 Straight edging 0.3 – 30 mm thickness
 (manual feed)
 Edge length 200 mm min.
 Edge height up to 66 mm



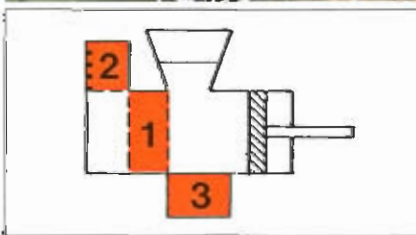
Fully automated DUO edge feeder, Model 1904

For coiled material 0.3 to 3.0 mm thick
 Max. coil dia. 575 mm
 Straight edging 0.3 – 30 mm thickness
 Edge length 370 mm min.
 Edge height up to 70 mm



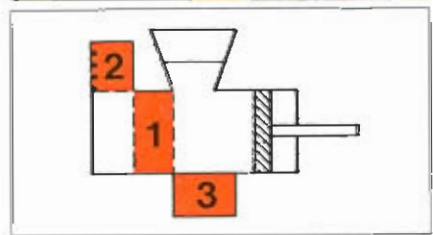
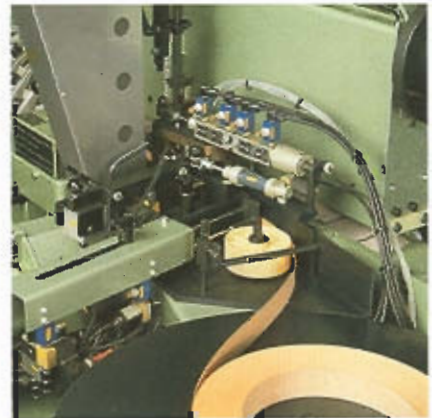
Glue applicator station, Model 1906

· Cartridge system with applicator nozzle for workpiece 6 to 45 mm thick
 Glue cartridge dia. 63 x 80 mm long
 Magazine capacity: 4 cartridges – 1.4 kg
 Power consumption: 1.9 kW



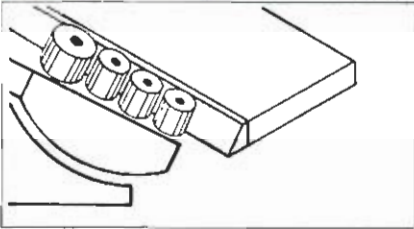
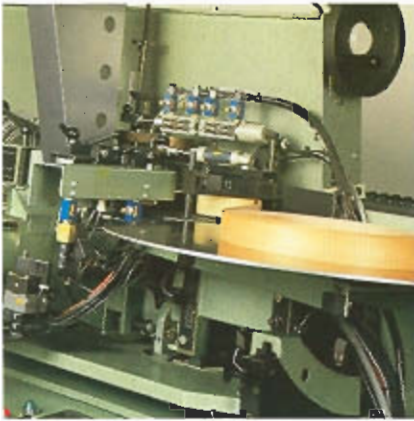
Glue applicator station, Model 1907

· ultra-granupress® system with applicator nozzle (takes all commercial glue pellets)
 For workpieces 6 to 60 mm thick
 Glue in pellet form
 Pellet fill capacity: 4 kg approx.
 Power consumption: 4 kW



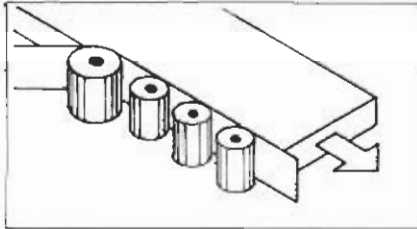
DUO glue applicator station, Model 1908

· ultra-granupress® system with applicator nozzle (takes all commercial glue pellets)
 For workpieces 6 to 60 mm thick
 Glue application either to workpiece or edging
 Pellet fill capacity: 4 kg approx.
 Glue application for edging max. 60 mm
 Power consumption: 4 kW



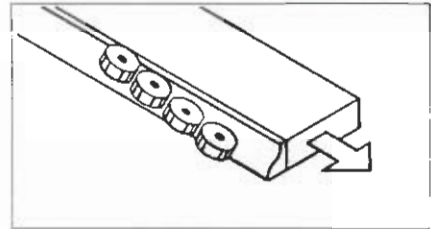
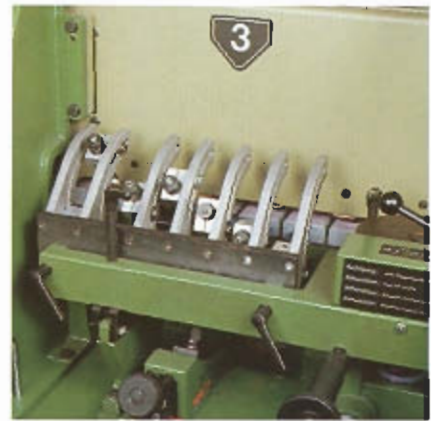
Tilt unit, Model 1928

Takes the following stations:
Edge feeder, glue applicator and pressure unit
Tilt range: 0 – 10°
For bevelled workpieces



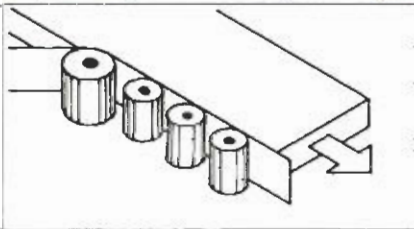
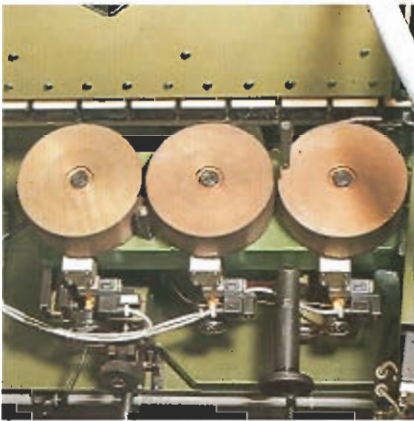
Pressure unit, Model 1911

First pressure roller driven,
plus four spring-loaded pressure rollers
with quick re-setting facility
For edging up to 66 mm wide and
max. 30 mm thick



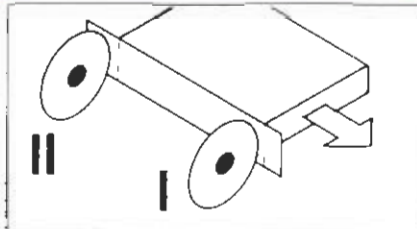
DUO pressure unit, Model 1945

For edging up to 30 mm thick
Pressure applied over 600 mm for
straight and profiled edging
(for use only in conjunction with tilt
unit 1928)



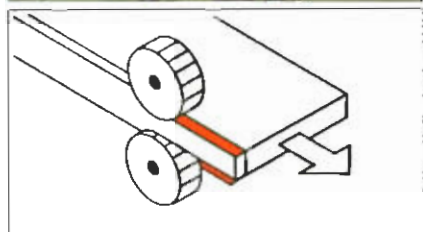
**Pneumatic pressure unit,
Model 1926**

For edging up to 30 mm thick
Synchronised with workpiece feed,
with 3 individually controlled pressure
rollers (for use with tilt unit 1928)



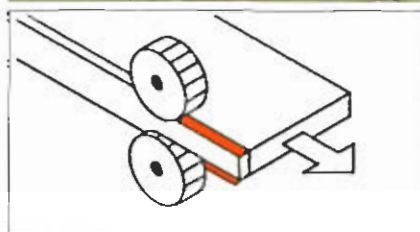
End trimming unit, Model 1916

Tilt up to 10°
Draw cut with 2 std. fr. motors
with swing-out control
for short workpiece intervals
Edge thickness: 30 mm max.
Edge height: 66 mm max.
Workpiece length: 140 mm min.
Power consumption: 1.1 kW
Electro-pneumatic version available
on request, at additional cost.



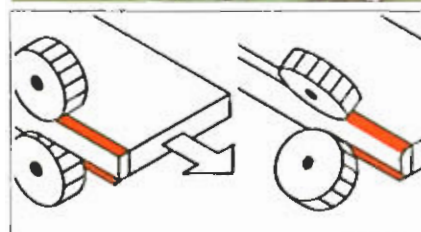
Flush trimmer unit, Model 1920

For coiled and strip material: 0.3 – 20 mm
 For flush or chamfer trimming up to 15° or
 for radius cutting $R = 2 - 5$ mm
 With horizontal and vertical feelers,
 2 motors and 2 cutter heads
 80 mm dia. x 30 x 20 with TC turnover blades
 For 5 mm chamfer at 15°, 4 knives
 2 x 1.1 kW, 50 Hz



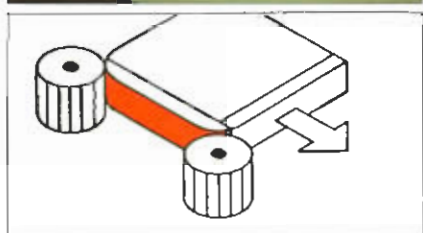
Flush trimmer unit, Model 1962

For coiled and strip material: 0.3 – 30 mm
 For flush trimming
 With vertical feelers,
 2 motors and 2 cutter heads
 80 mm dia. x 40 x 30 with TC turnover blades
 4 knives
 Power supply via frequency converter:
 2 x 2.0 kW, 200 Hz



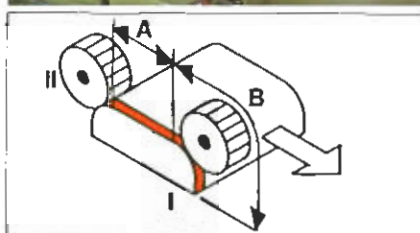
Flush trimmer unit, Model 1966

For coiled and strip material: 0.3 – 15 mm
 For flush or chamfer trimming
 Tilt range: 0 – 45°
 With horizontal and vertical feelers
 2 motors and 2 cutter heads
 70 mm dia. x 20 x 20 with TC turnover blades
 4 knives
 Power supply via frequency converter:
 2 x 0.8 kW, 200 Hz



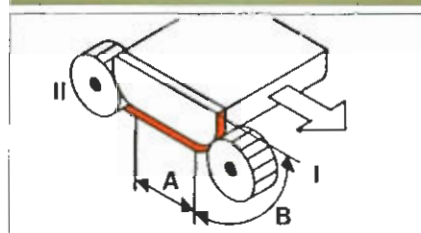
Form trimming unit, Model 1924

For rounding vertical corners
 Radius up to 25 mm
 Workpiece thickness 45 mm max.
 Power supply via frequency converter:
 2 x 1.0 kW, 200 Hz



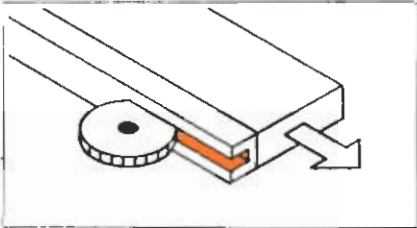
Form trimming unit, Model 1933

Up-cutting action – with horizontal and
 vertical feelers, machines top to bottom,
 end grain and upper corners
 Workpiece thickness: 50 mm max.
 Workpiece projection: 30 mm min.
 Radius up to 5 mm
 Power supply via frequency converter:
 2 x 0.44 kW, 200 Hz



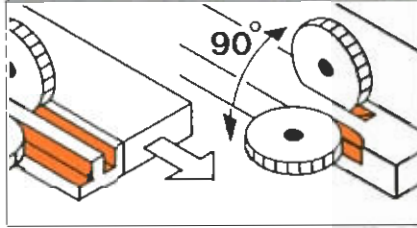
Form trimming unit, Model 1934

Up-cutting action – with horizontal and
 vertical feelers, machines bottom to top,
 end grain and lower corners
 Workpiece thickness: 30 mm max.
 Workpiece projection: 30 mm min.
 Radius up to 5 mm
 Power supply via frequency converter:
 2 x 0.44 kW, 200 Hz



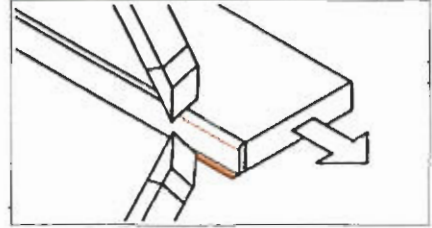
Profile cutter, Model 1930

For grooving and shaping, up-cutting action, no feelers, non-plunging
Tool spindle only for vertical cutting
Stock removal: 200 mm² max.
7000 rev/min – 2.2 kW, 50 Hz



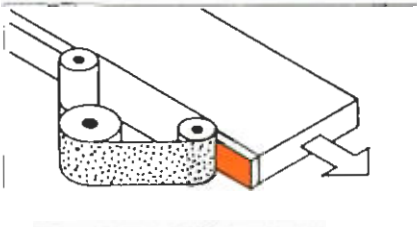
Profile cutter, Models 1931 / 1932

For grooving and shaping, up-cutting action
With horizontal and vertical feelers
Tool spindle tiltable for horizontal and vertical work, horizontal cutting from above
Stock removal: 250 mm² max.
Power supply via frequency converter:
2.2 kW, 200 Hz
Model 1932 as Model 1931, but with additional plunge control



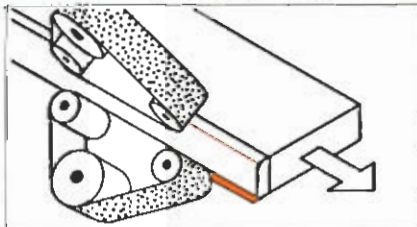
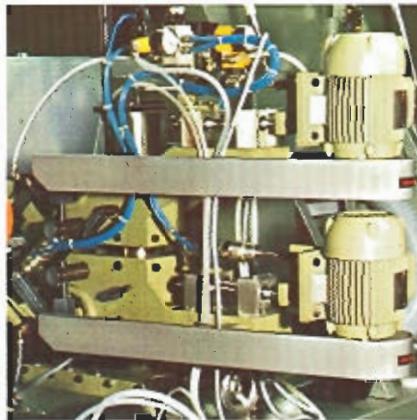
Scraper unit, Model 1927

With horizontal and vertical feelers
2 draw knife holders for turnover knives R = 0.8 – 5 mm



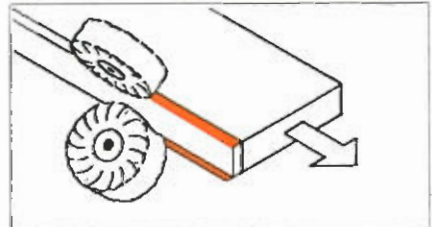
Edge sander, Model 1935

Controlled sanding pad pressure with oscillating sanding belt
For edge surfaces
1.75 kW, 50 Hz



Edge sander, Model 1937

Controlled sanding pad pressure with oscillating sanding belts for top and bottom
Edge height: 15 mm min. (at 30° workpiece chamfer)
2 x 0.35 kW, 50 Hz



Buffing unit, Model 1944

Tilt-adjustable, without feelers
With plunge control
2 motors
2 x 0.15 kW, without tooling

Buffing unit, Model 1941

Tilt-adjustable, with 2 motors
2 x 0.15 kW, 50 Hz
With 2 textile wheels 150 mm dia.

The options available:



1 Straight edges of solid wood, veneer or plastics



2 Coiled edging



3 Edges for shaped workpieces in cross-section



4 Solid edging up to 50 mm thick flush or with defined projection



5 Veneer edging, flush with chamfer



6 Formica edging, flush with chamfer



7 PVC edging with radius or chamfer



8 Solid edging with radius or chamfer



9 PVC edging with radius on top edge and rounded corners



10 PVC edging with radius on lower edge and rounded corners



11 Edging for workpieces shaped in cross-section



12 Edge machining: flush with chamfer or radius



13 Edges with radius on top and rounded corners



14 End grain grooving, also with plunge control



15 Rebate cutting



16 Profile cutting and panels and edges



17 Surface grooving



18 Also with plunge control



19 Scraper-cleaning of edges



20 Sanding of edges, veneer or solid wood



21 Sanding of chamfered solid-wood edges



22 Radius-sanding of solid wood



23 Buffing and polishing PVC edging



24 Buffing or plastics edging

Accessories

Frequency converters

Frequency converters are required for MF-units. Add together the connected loads involved to select the appropriate model:

Model 1954, 4 kVA, load capacity up to 2.7 kW
 Model 1956, 10 kVA, load capacity up to 6.7 kW
 Model 1955, 15 kVA, load capacity up to 10.0 kW
 Model 1957, 20 kVA, load capacity up to 13.5 kW
 Mounting kit, mechanical

Safety and acoustic hoods

Select the hood and safety system in accordance with local regulations: Protective hood with electric motor cut-out (incl. cabling and connections)

Models for area covered:
 900 mm – Model 1986
 1800 mm – Model 1987
 2400 mm – Model 1988
 3000 mm – Model 1989
 1200 mm – Model 1990
 2100 mm – Model 1991

Interlocks required until machine stops:
 1 per basic machine, plus
 1 per hood
 or
 Braking units for units 1924/1950/1931/
 1932/1933/1934/1962/1965/1966/1968

Lighting and accessories

For more convenient handling, the following accessories are available:

Interior hood lighting
 Wheeled base, only for Model 1440, with 4 castor wheels without lock
 Counter-pressure rail for Model 1440 or for Models 1441 to 1449

Tooling

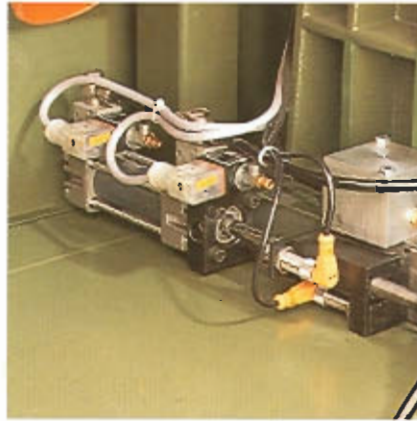
Use only high-quality tools for your units. We shall be pleased to advise you for special requirements or dimensions.

Some of our **Special accessories**



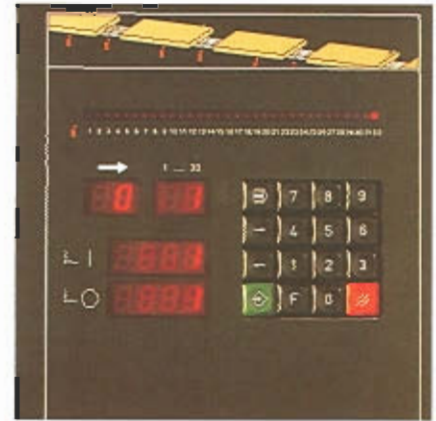
Digital (Siko) counters

For pressure units 1911, 1926, 1945
end trimmer 1916, cutter units
1933, 1934, 1962, 1966,
scraper unit 1927 and
buffer units 1941, 1944



Pneumatic unit shift device

Fast precision application and pull-
out of end trimming unit 1916,
cutter units 1933, 1934, 1962, 1966,
scraper unit 1927 and
butter units 1941, 1944



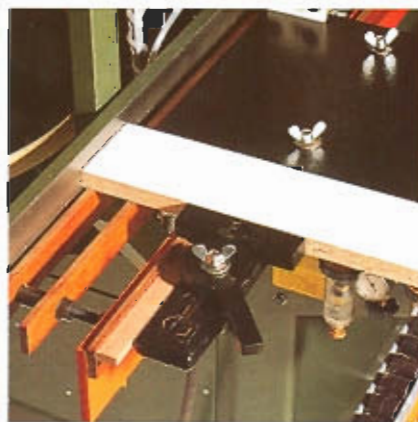
Electronic micro processor

- With 32 freely programmable limit switch functions
- Individual selection of both On and Off positions
- Standard (no surcharge) for ACCORD Models 1445 to 1449



Auxiliary support table

For coiled material up to 1,100 mm
dia.
Height adjustable from 830 to
900 mm



Short length fixture

For narrow workpieces from 90 mm
upwards



Buffing wheels

Left: Lamellar wheel
Right: Segmented wheel
(Supplied as basic wheel without
sanding cloth)



NÜRTINGEN/WEST GERMANY



DEMONSTRATION CENTER



VOITSBERG - AUSTRIA



CANADA



FRANCE



U.S.A.



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