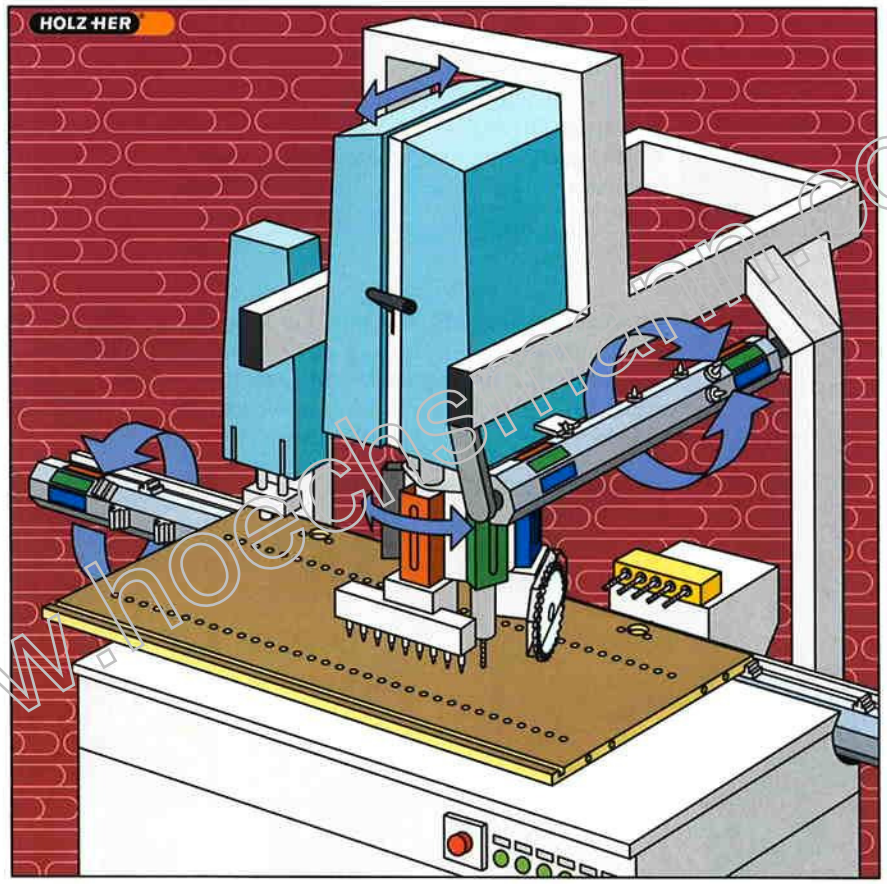
HOLZ-HER®

special machines



Manual Machining Center

OCTO-CONTROL

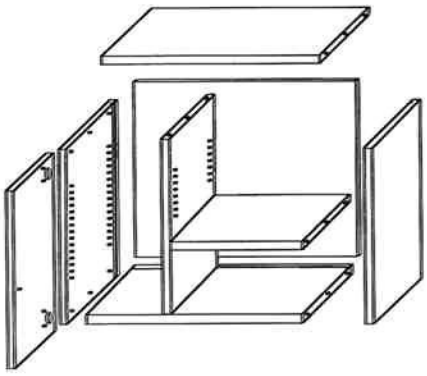
The cost effective machining center for

The machine is suitable for boring:
- **Line holes**
- **Holes for door hinges**
- **Holes for joint fittings**
- **Vertical dowel holes**
- **Horizontal dowel holes**

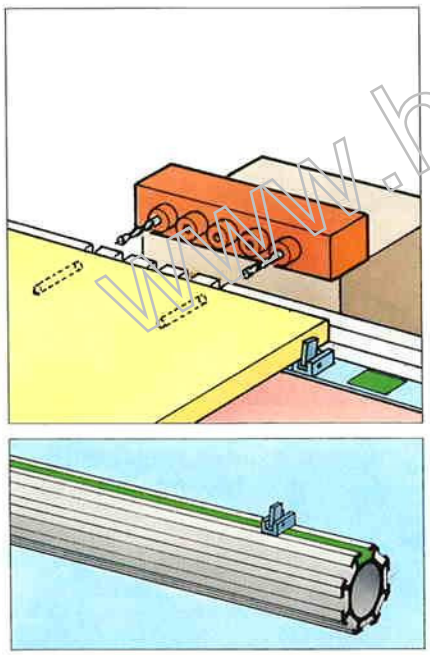
Insertion of:
- **Door hinges**
- **Joint fittings**

Sawing and cutting of:
- **Grooves – continuous**
  – intermittent
- **Rebates – continuous**
  – intermittent

OCTO-CONTROL is a complete machining system for boring, insertion, grooving and rebating. Complete machining processes, such as the production of a piece of furniture, can be set up once and for all at the machine. Once set up, the workpiece can be fully processed without any need for further tool changes.
The boring system works on a 32 mm center to center, allowing both door hinge and jointing bores to be made in one machining process, using the appropriate manufacturer's bore heads.
Since all the bore heads remain installed on the indexing turret, there is no need to change the tooling.
The turret will accept head configurations for dowel holes, Line holes, door hinge holes and for grooving simultaneously. The turret can accommodate a total of six stations, and there is an additional station for the insertion of door hinges.
It is possible, therefore, to produce a complete workpiece in a very short time, without any need for time-consuming resetting or retooling.
The program cylinders for both the X and Y axes, used for setting the boring, grooving and rebating positions, are completely interchangeable.
Each of the two program cylinders has a slot for each of the six turret stations, used for setting the tooling positions. This means that complete tooling arrangements may be pre-set on the cylinders, to be recalled if and when required.

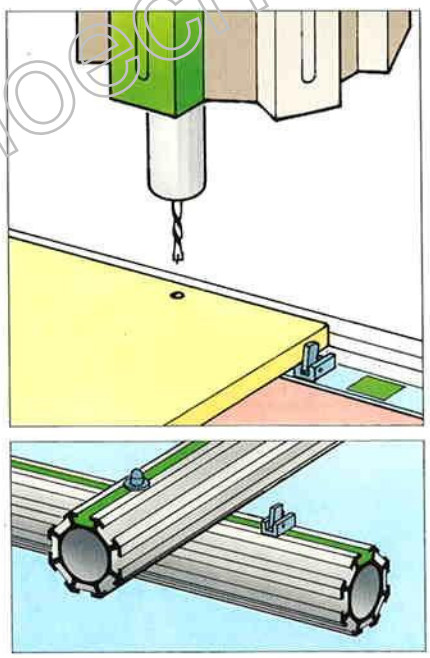


The following example illustrates the machining process for one workpiece, including the boring of dowel holes, line holes, hinge holes, grooving of a back panel, and insertion of the door hinges. The workpiece in question is a complete wardrobe, for which the stops of the machine have been set just once.



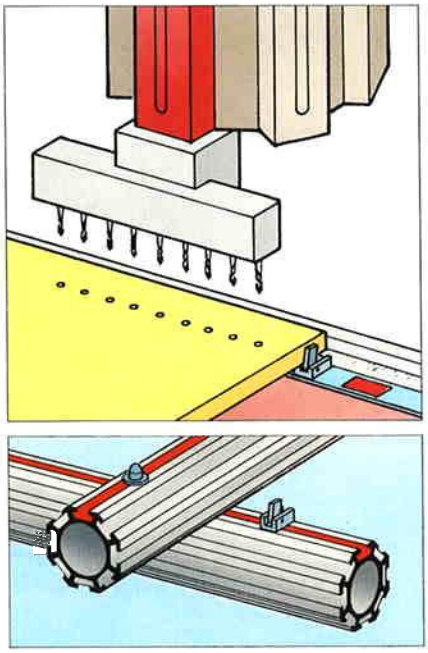
The first operation consists of boring the horizontal dowel holes in the top, middle and base boards, as well as in the dividing panel.

The process:
Set the workpiece hold-down - set the exact hole depth (SIKO digital counter) – turn the X program cylinder to green – position workpiece – bore...



This is now followed by boring the dowel holes in the side walls and in the dividing panel.

The process:
(The hold-down is no longer required). Turn the Y program cylinder to green – also turn tool turret to green – position workpiece – bore...



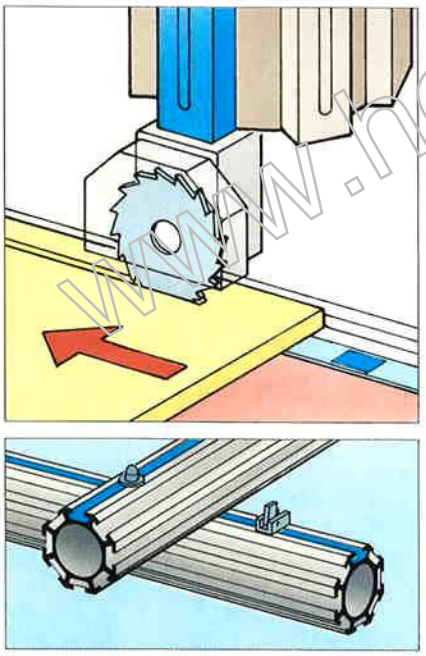
Next comes the boring of the line holes for the shelves.

The process:
Turn both X and Y program cylinders to red – also turn tool turret to red – position workpiece - bore...

large and small production runs

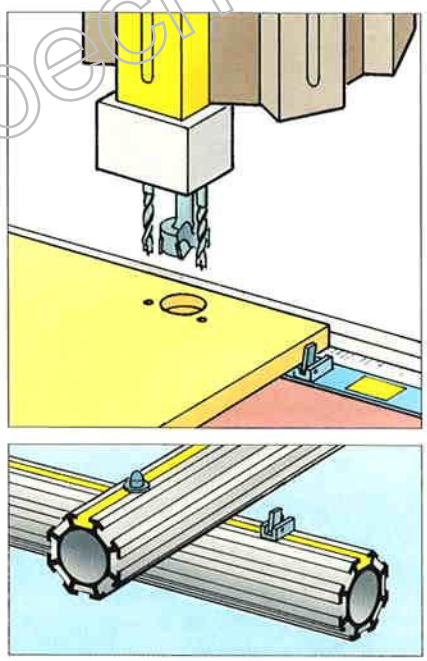
The advantages of the machining center:

- Boring, grooving, rebating and insertion of fittings with just one machine.
- Multiple processing and location against the wall means very little floor space required.
- Cost savings by investing in only one machine.
- Complete processing without any need for tooling change and set-up, since the appropriate machining head is in place for each processing step.
- The reference edge remains the same, as the workpieces do not have to be turned round.
- Patented program cylinder system in combination with a tooling turret. In the shop, the machine is set up only once after purchase.
- Interchangeable program cylinders for industrial large-batch production.
- Patented system including air-flotation table and vacuum down hold.
- Dust extraction at all boring heads (improving on the value of 2 mg/m^3 in the GS testing procedure).
- Optimum boring speed at 6000 rev/min and optimum cutting speed of 70 m/s.
- The processing side is always visible. This allows process monitoring and machining to plan.



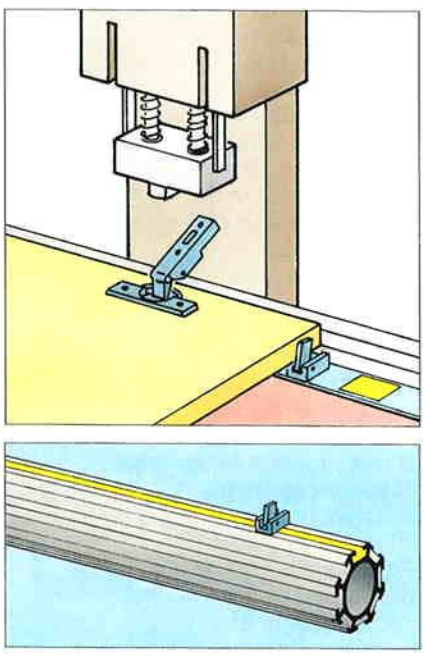
The last machining process for the carcase is grooving the back panel.

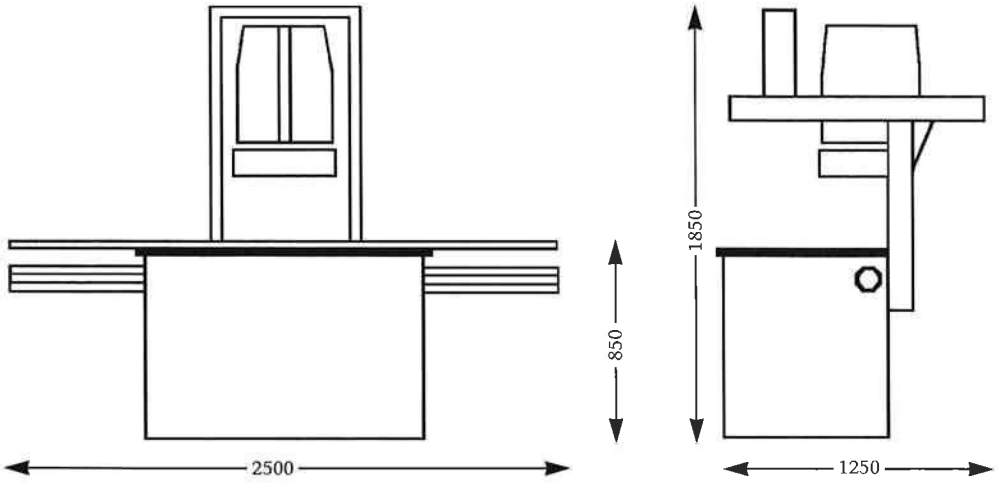
The process:
Turn both the X and Y program cylinders to blue – also turn the tooling turret to blue – push the workpiece into the grooving saw...



Finally, the holes for the door hinges have to be bored and inserted.

The process:
Turn both the X and Y program cylinders to yellow – also turn the tooling turret to yellow – position the workpiece – bore – position workpiece – insert...





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

Specification

	1650
Table height	850 mm
Table dimensions	635 x 1150 mm
Air flotation and vacuum hold-down	●
Workpiece dimensions for all processes without turning over	
– Workpiece thickness, max.	70 mm
– Workpiece width, max.	650 mm
– Workpiece length, max.	2500 mm
Motor power, vertical	1.5 kW
Boring speed	6000/min
Motor power, horizontal	0.55 kW
Boring speed	6000/min
Units on turret	6
Boring functions	
– Vertical dowel holes, dia.	3 - 40 mm
– Hole depth, max.	45 mm
– Horizontal dowel holes with 5 spindles, dia.	3 - 10 mm
– Hole depth, max.	45 mm
Through-hole depth, max.	40 mm
Line-holes (32/30/25 mm pitch) with 9 spindles, dia.	5 mm
Door hinge holes – Drives:	●
Blum, Grass, Hettich, Mepla, Salice and eccentric bores	●
Insertion of fittings (optional)	+
Grooving, dia.	150 mm
Speed at drive output	9000/min
Grooving depth, max.	10 mm
Grooving width	3 - 6 mm
Fixture for frames dia.	10 mm
Program cylinders	
– Length in X axis	2500 - 5000 mm
– Length in Y axis	650 mm
Dust extraction for all tools	●
Supplies required:	
– Power	400 V, 50 - 60 Hz 1.24 kW
– Compressed air	6 bar
Extraction:	
– Connection, dia.	80 mm + 2 x 50 mm
Space requirement: length, width, height (for 2500 mm X program cylinder)	2500 x 1250 x 1850 mm
Weight, approx.	260 kg
Weight with horizontal boring, approx.	310 kg

+ = optional ● = standard

HOLZ-HER®

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