

Powerful performance – high level of automation

SPRINT 1327



PRODUCTIVITY AND PRECISION

The future of edge banding

A newly designed base frame, even more functions for the modules, more power and perfected operation: the SPRINT 1327 forms the basis for a new generation of the successful SPRINT series.

- High rigidity of the base frame, welded vertical module wall for superior precision.
- Sturdy chain guide with rubber pads for a smooth and gentle transport of the workpieces.
- Smooth workpiece transport thanks to precisely milled guides for the transport chain.
- Pressure bridge with double-row, continuous pressure rollers to hold the workpiece firmly.
- Fast feed speed up to 18 m/min.
- Standard model already designed for a workpiece thickness of up to 60 mm.
- Can process reel and strip material up to 8 mm.
- Variable processing range thanks to a variety of options.
- Telescopic workpiece rest for processing long parts.
- Attractive design, soundproof protective hood in module area.
- Precise and sturdy guidance of the pressure bridge.

Simple programming – fast set-up

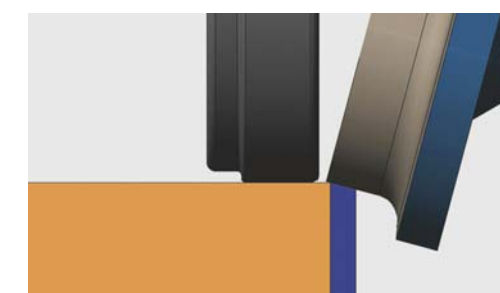


- Power-PC control PPC 221
- 8.4 inch VGA colour screen
- Easy operation, all information can be read and programmed in plain text and/or graphic
- Rotating and pivoted control panel at eye level.
- Extensive program memory allows a fast set-up of the machine
- Individual selection of modules with functions as default settings for setpoints, line points and tool corrections
- Well arranged and complete recording of all operating data
- Individual administration of up to ten users
- Online service (option)
- Barcode interface (option)
- Connection to HOLZ-HER process data acquisition (HHPDE) for a direct export of operating data

NEW: Joint milling module 1827 – multifunctional and precise



Flush trimming



Chamfer trimming up to 15 degrees, manual adjustment (option: pneumatic adjustment)



Radius trimming (standard)



Chamfer trimming for thin edges (option: 1827 MOT 4)

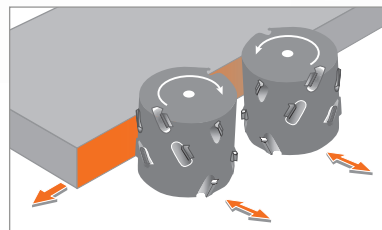
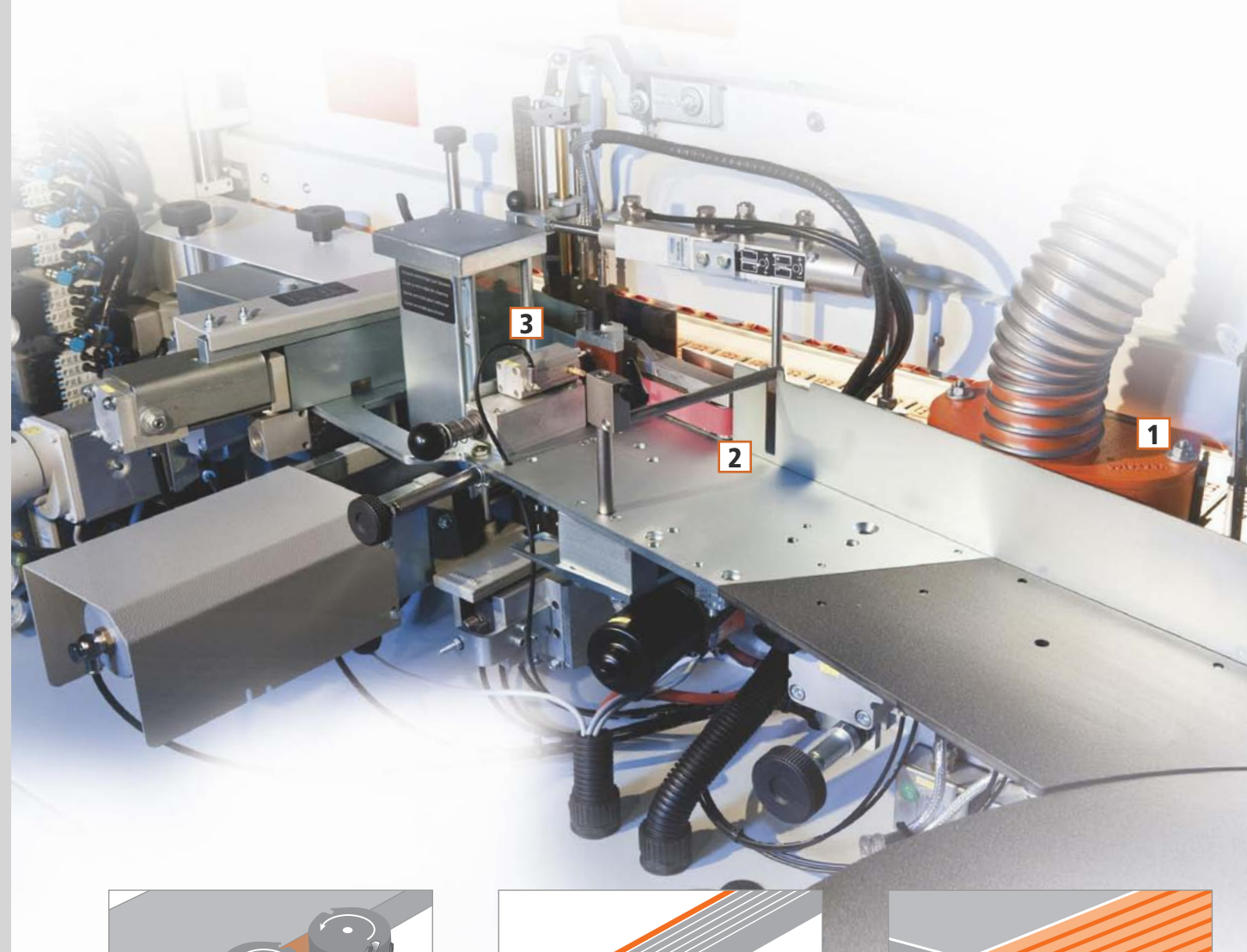


Radius trimming with overhang (option)



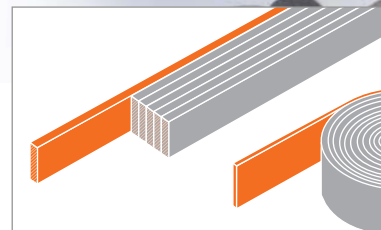
Powerful performance, high level of automation

Each unit of the new SPRINT 1327 convinces through its precise workmanship. The possible equipment options are perfectly matched and designed for a high constant load.



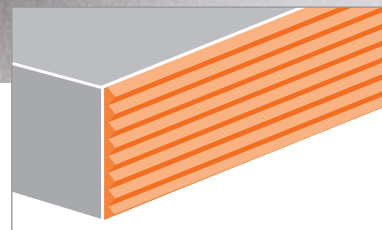
1 1802 Premilling

The powerful joint milling module ensures smooth bonding surfaces and a thin bonded joint. Fitted with the ProLock quick change flange. Diamond-tipped and height-adjustable tools for a long too life.



2 Edge feeding unit 1903

Fully automated, user-friendly feed of coil and strip material. Tool-less changeover. Exact guidance of the edging material with two adjustable holding-down devices. Maximum load capacity 40 mm for strip material. The small feeding angle (approx. 6 degrees) is particularly gentle on solid timber edges during infeed.



3 Glue application 1906 MG

The patented HOLZ-HER system with nozzle technology guarantees a firm hold of the edges and clean joints. The standard system is designed to process glues in a cartridge or granulate form, irrespective of whether they are EVA or PUR glues.

Innovative glue application 1906 MG – optional cartridge system or granulate hopper

The standard SPRINT 1327 is equipped with the patented HOLZ-HER nozzle system 1906 MG.

- The glue is applied exactly as required. This saves costs and optimises the quality.
- No discoloration or scorching of the glue since only the glue needed is actually melted in the closed system.
- The quick cartridge change is a particular boon. This allows a fast and rational changeover from EVA to PUR glue or different glue colours.
- Scanning nozzles for precise glue application. The nozzle is coupled to the pressure bridge (option). This does away with any manual adjustment to the board thickness.

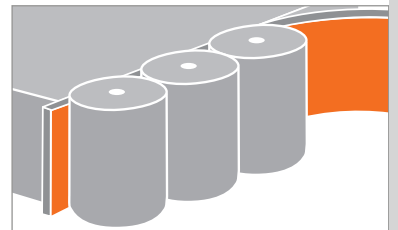
Only 3.5 minutes to warm up –
means 100 hours more productive
time every year*!

*With 8 h per day and 200 working days a year
compared to conventional roller gluing systems



Pressure unit 1913 pneu

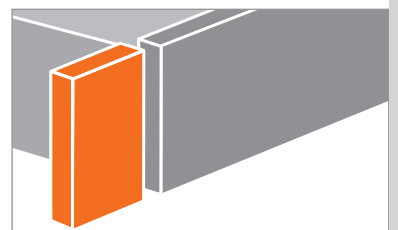
High contact pressure for clean edge gluing. All pressure rollers with pneumatic plunge control. Motorised adjustment to edge thickness on request.



End trim unit 1918 pneu

For straight or chamfer trimming; pneumatic system as standard for swivelling to 10-degree chamfer trims.

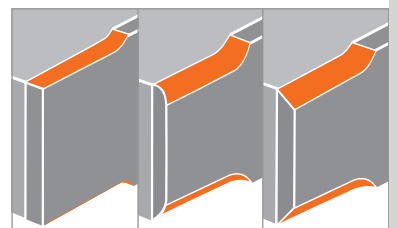
Each saw motor on two guides for a precise trimming of the edge overhang.



Trim unit 1827 pneu

Powerful joint milling module for flush trimming of the top and bottom longitudinal edge, radius up to 3 mm, chamfer trimming 0 – 15 degrees pivoted.

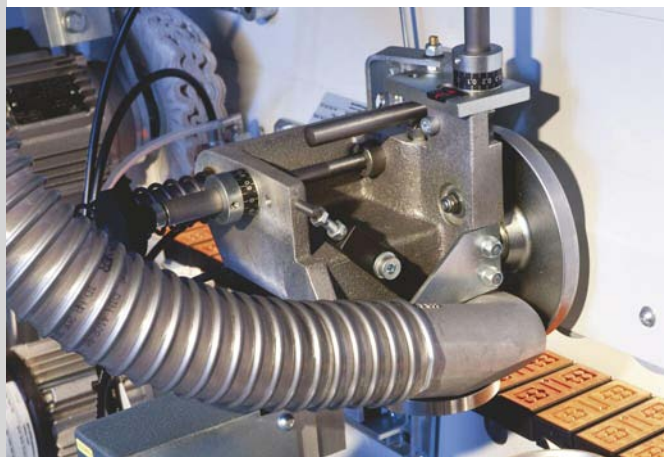
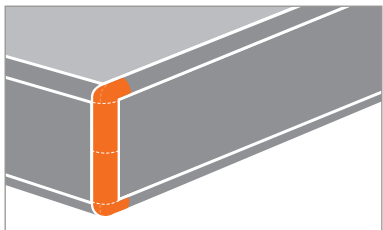
- Further equipment:
- Diamond-tipped tools
 - Integrated chip guide in tool
 - ProLock system
 - Two vertical jockey rollers
 - Two horizontal contact shoes with two rollers each





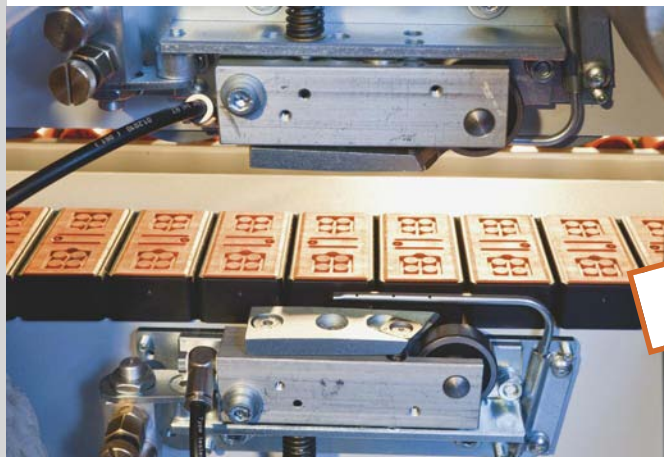
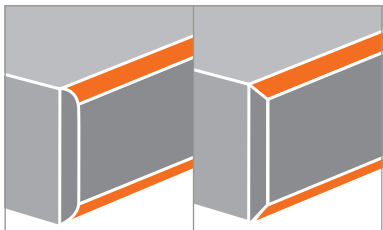
Copy cutter unit 1832

Copy cutter unit to process the front and rear vertical edge with a milling motor. Max. infeed 10 m/min. Maximum workpiece thickness 12 – 45 mm.



Scraper module 1929

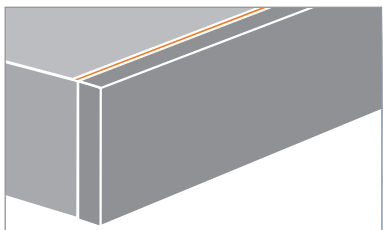
For the perfect smoothing of radiuses and chamfers on plastic edges. Option: pneumatic exchange or with motorised fine adjustment. With vertical and horizontal jockey rollers for perfect scanning.



Flat scraper 1964

Clean post-processing of the surface – no more manual finishing. This greatly reduces the cost per workpiece.

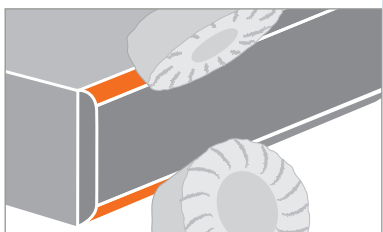
Slot 1



Buffing module 1940

One hundred percent post-processing of edges and surfaces for absolutely clean finishing. Buffing disc diameter 150 mm.

Slot 2



Equipment

	1327
Spray unit 1856	<input type="radio"/>
First spray unit with release agent, second spray unit with cleaner	
Premilling module 1802	<input type="radio"/>
Two milling motors (2 x 2.0 kW), max. joint thickness 3 mm	
Edge feeding unit 1903	<input checked="" type="checkbox"/>
For coil and strip material	
Glue application system 1906 MG	<input checked="" type="checkbox"/>
For EVA and PUR glue in cartridges or granulate form	
Glue application system 1910	<input type="radio"/>
Synchronous roller	
Pressure unit 1913 pneu	<input checked="" type="checkbox"/>
Three pressure rollers, first roller driven, pneumatic plunge control	
End trim unit 1918 pneu	<input checked="" type="checkbox"/>
2 x 0.35 kW, 200 Hz, 9000 rpm , two HW circular saw blades with pneumatic adjustment for chamfer trims (0/10 degrees)	
Trim unit 1827 pneu	<input checked="" type="checkbox"/>
2 x 0.65 kW for flush, radius and chamfer trimming	
Copy cutter unit 1832	<input checked="" type="checkbox"/>
1 x 0.22 kW, 300 Hz, 9000 rpm	
Scraper module 1929	<input checked="" type="checkbox"/>
Smoothing radiuses and chamfers on plastic edges	
Slot 1:	
for flat scraper 1964	<input type="radio"/>
Top and bottom feed controlled	
Slot 2:	
for buffing module 1940	<input type="radio"/>
Two textile discs, pivoted	
✓ = standard ○ = option	



Practical

Easy removal of the scraper chips from the collecting box at the end of the machine; even if a return device is fitted.



Efficient

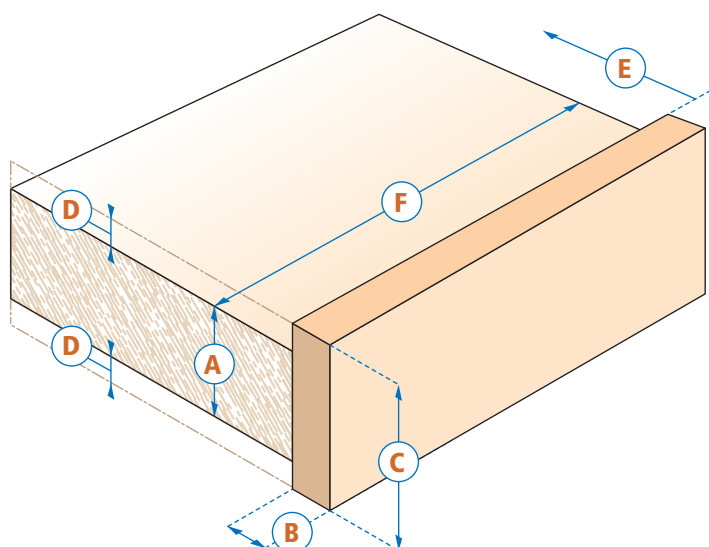
Locking roller for minimum workpiece gap and high productivity.



Workpiece protection

Roller conveyor in infeed and discharge area – no scratching of sensitive workpiece surfaces.

Product brochures and numerous
videos can be found at
www.holzher.com



Working dimensions (all sizes in mm)

A	6 – 60	
B	0,4 – 3	reel material
B	0,4 – 8	
C	65	
D	2,5	per side
E	65	minimum
F	160	

Technical data

	1327
Machine dimensions	
Overall length in mm	5215
Weight in kg	approx. 1200
Feed speed	
Feed speed in m/min	10 (option 10–18)
Suction	
Connection Ø in mm trim unit 1802	1 x 80
Connection Ø in mm trim unit	2 x 80
Connection Ø in mm trim unit 1827	1 x 100
Connection Ø in mm scraper module 1929	1 x 80
Air requirement in m³/h	930
Static vacuum in Pa	1 650
Minimum air speed in m/s	20
Compressed air	
Compressed air connection in bar	6



All illustrations may contain
optional extras.

The technical data are reference values. We reserve the right to modifications since our HOLZ-HER wood processing machines are subject to constant development and improvement. The illustrations are therefore without commitment. Some of the machines shown here also contain special equipment that is not part of the standard scope of supply. Please contact your HOLZ-HER dealer to find out about the exact scope of equipment. Subject to modifications in the design and equipment. All illustrations may contain optional extras.

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