Automatically efficient. Manually versatile. Incredibly flexible.

HOMAG

Our panel dividing saws
SAWTEQ B-300 flexTec
SAWTEQ B-400 flexTec

YOUR SOLUTION

Robot performance and operating freedom in one

Robotics is the key to highly efficient batch size 1 production in the cutting process. The crux of the matter is that cutting cells equipped with this up to now have been designed from A to Z for the requirements and processes in single-panel cutting. This makes them extremely efficient and highly productive, but limits the range of use of the saws.

Such concepts are often not appropriate for companies with a wide variety of work and a limited production area. That is why the panel dividing experts at HOMAG have now developed an innovative hybrid concept combining the two: the robot performance for automated batch size 1 cutting and the wide range of processing options of classic HOMAG saws.

The names of these innovations are SAWTEQ B-300 flexTec and SAWTEQ B-400 flexTec. Both saws are equipped with an integrated robot and are technically capable of fully automated batch size 1 production over longer distances. Alternatively, these two saws can be operated manually as usual – totally flexibly and as needed: for cutting books, for example.

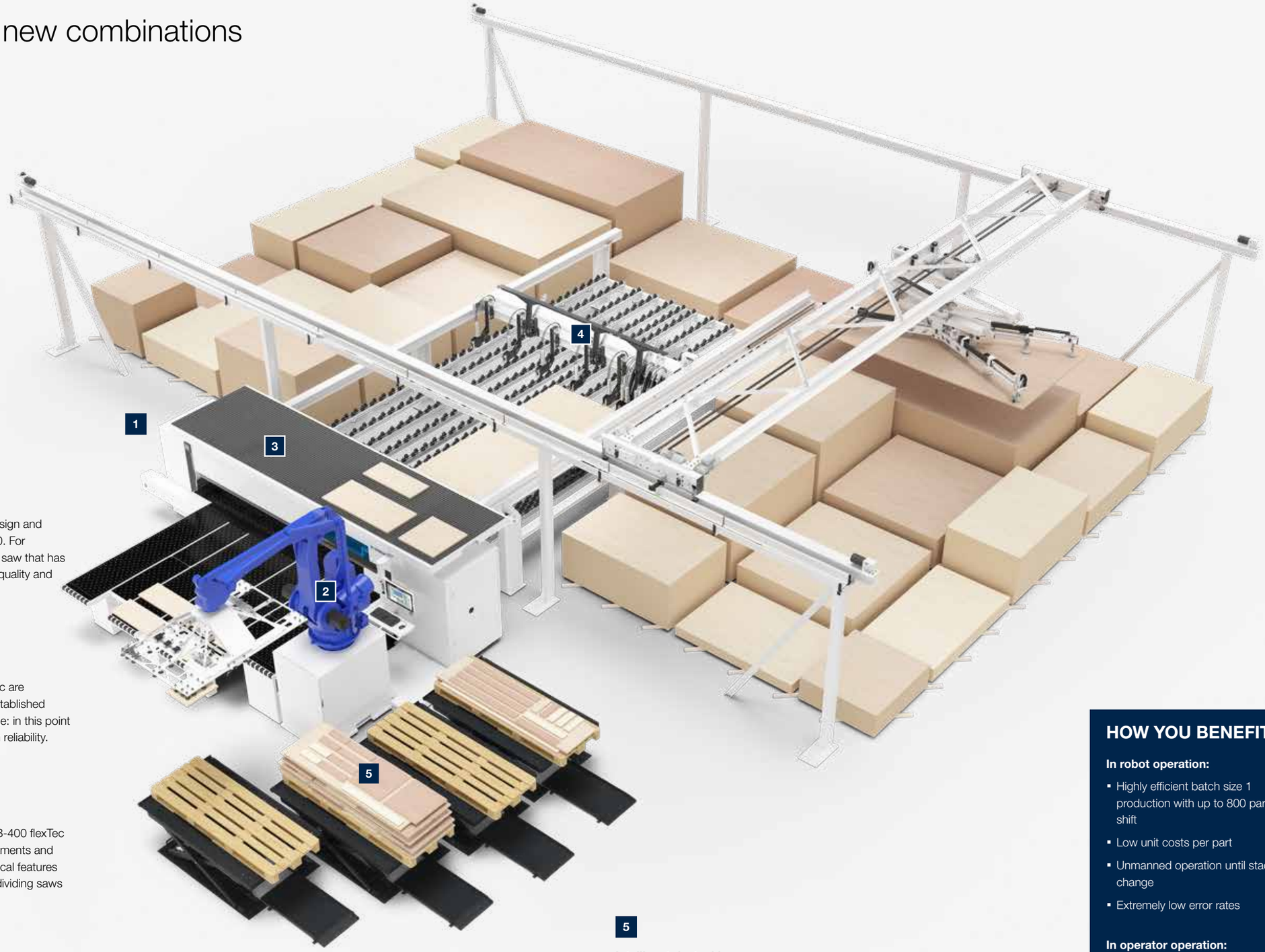
YOUR SOLUTION

CONTENTS

Proven technology in new combinations

THE BASIC MODELS AT A GLANCE

- SAWTEQ B-300 flexTec as single saw
- SAWTEQ B-300 flexTec as single saw with lifting table
- SAWTEQ B-400 flexTec as single saw
- SAWTEQ B-400 flexTec as single saw with lifting table



1

Saw design

Essentially, the two basic models correspond in both design and features to the SAWTEQ B-300 and the SAWTEQ B-400. For customers, this means that they will get a panel dividing saw that has proven itself in practice many times over and embodies quality and reliability.

2

Robot technology

The SAWTEQ B-300 flexTec and SAWTEQ B-400 flexTec are equipped with the same robot technology as the well-established batch size 1 cell SAWTEQ B-320 flexTec. Your advantage: in this point too, you are opting for proven technology and maximum reliability.

3

Wide variety of features

The robot saws SAWTEQ B-300 flexTec and SAWTEQ B-400 flexTec can be extensively customized to match different requirements and manufacturing environments. A wealth of optional technical features make sure of this in the same way as they do for panel dividing saws without robot.

4

Feeding options

Whether by hand, via a storage control connection, an integrated lifting table, the separate HOMAG HBX 150 gantry or a feeding station located at the side of the saw, there are many technologies for feeding panels to choose from. Find out more from page 24 onwards.

5

Intelligent destacking

Highly intelligent stack formation when destacking onto pallets and lifting tables is the key to unmanned production. This is achieved by means of software that has already proven successful in the SAWTEQ B-320 flexTec. When it comes to destacking hardware, the SAWTEQ B-300 flexTec and the SAWTEQ B-400 flexTec can be individually customized to meet your requirements. Find out more from page 26 onwards.

HOW YOU BENEFIT

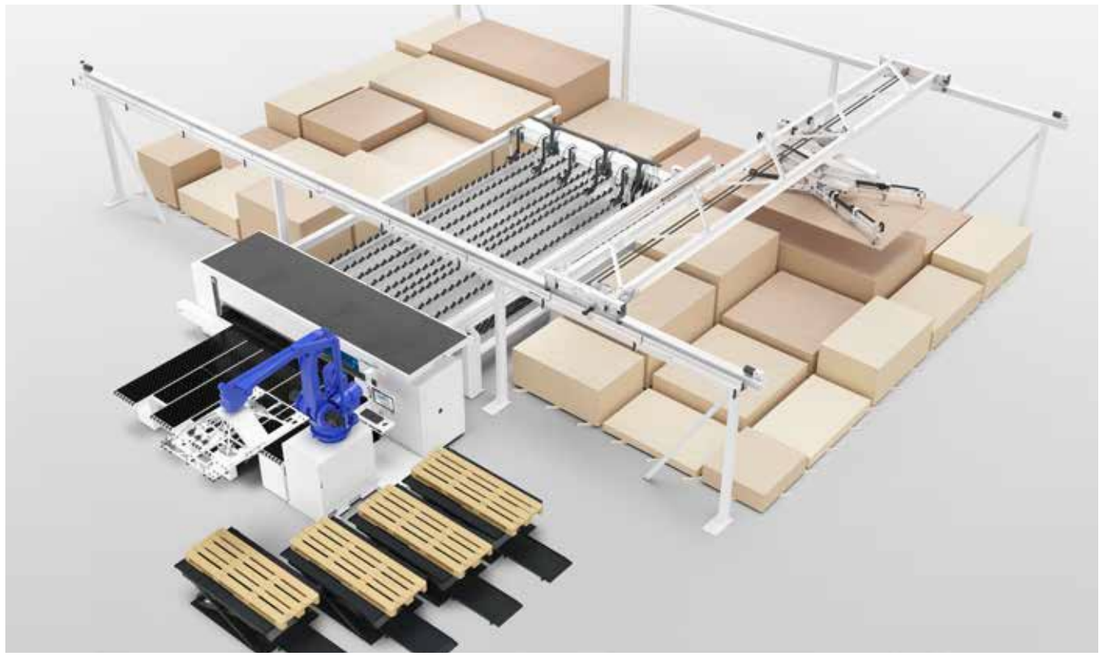
In robot operation:

- Highly efficient batch size 1 production with up to 800 parts per shift
- Low unit costs per part
- Unmanned operation until stack change
- Extremely low error rates

In operator operation:

- Complete operating freedom in the cutting process
- Maximum flexibility
- Package cutting is also possible

Your flexTec benefits at a glance



Fully automated batch size 1 cutting process

- Both saws are optimized for the single-panel cutting process in trade establishments, but are also suitable for use in industry
- The modular design provides the basis for numerous variants – individually aligned to your requirements
- The result: seamless workflows with high throughput in a compact space
- Minimal operating effort, low tool and maintenance costs
- High output with up to 800 parts per shift in robot operation

An investment that pays off

- Precisely predictable benefits can be calculated as early as the planning stage thanks to HOMAG simulation software
- Attractive price/performance ratio
- Significantly reduced unit costs in batch size 1 production
- Low personnel costs due to fully automated, partially unmanned production
- High availability of the robot
- Low life-cycle costs

Perfect handling

- Fully automatic rip and cross cutting with just one saw
- No more manual panel handling, instead the option for unmanned operation – freely selectable depending on the operating mode
- The robot even takes care of handling the offcuts, provided that offcuts are automatically destacked to a place reserved for this purpose or returned to the store
- Automatic labeling of the finished parts is possible – with part- and order-specific information for further manufacturing operations
- In manual operating mode, it is furthermore possible to cut books of panels or to cut thin or larger/smaller-than-average panels in the usual way. The robot itself can process panels up to 3,200 mm long

No special robotics or programming knowledge is required!

Unmanned operation

- In robot mode, unmanned operation is possible over longer periods
- The robot moves the panels using gentle vacuum technology, works accurately, requires little maintenance and is highly available
- Production interruptions are almost completely ruled out with the proven industrial robot (almost 100% availability)
- No special robotics or programming knowledge is required
- Extremely low error rate in robot operation

Recuts almost at will

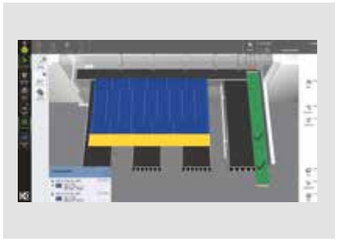
- Full flexibility in cutting pattern design thanks to recut technology
- Allows unlimited recuts provided that the panel materials comply with certain minimum and maximum dimensions
- Head sections, and therefore main parts of any length, are possible

Systematic safety

- For robot operation, the operator terminal at the saw is moved to a safe position. The position is continuously checked by sensors whilst the robot is working
- During robot operation, the saw can be operated from a separate machine terminal. This is outside the fenced-in safety area
- During manual operation, the external operator terminal is automatically switched off
- A (three-color) indicator light on the fence informs operating personnel of the current operating status of the saw
- The fold-down air cushion tables are raised during automatic operation

Software

Always up to date, intelligent and developed by HOMAG experts: tailored software solutions ranging from optimization to machine control and destacking allow you to get the most out of your saw. Highly efficient and reliable.



MACHINE CONTROL SYSTEM

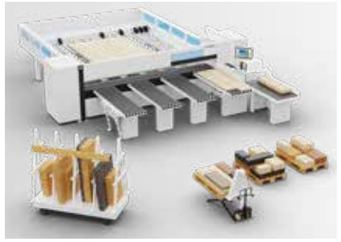
CADmatic 5 – the change in perspective

The latest generation of the HOMAG saw control system has a new assistance graphic that clearly shows the machine operator all the steps in order. Compared to the previous process graphic that showed all the work steps of the saw 1:1 (and can still be called up if required), this new graphic represents a 180-degree change in perspective!

Highlights:

- The 3D assistance graphic supports the operator directly at the saw and is intuitive to operate, which shortens the training period and reduces errors to a minimum
- This results in efficient processes and a steady output
- 24" full-HD multi-touch display in widescreen format is easy to use by swiping, scrolling and zooming
- Uniform operating concept thanks to the powerTouch user interface
- All HOMAG saws with CADmatic 5 are automatically tapio-ready

Find out more in the “CADmatic” brochure.



DESTACKING

The HOMAG destacking algorithm

The control center for intelligent destacking via robot is an algorithm that has been developed in-house and now further improved (for more information, see page 26).

The new functional highlights:

- Single-type or individually defined stack layouts
  - For even more flexibility and significantly easier handling
- Graphically formatted stack preview
  - The software determines the number of stacks that will be created in advance
  - A preview graphic shows what the planned stacks will look like
  - This ensures transparency and also makes production planning easier
- Accurate prediction of production times
  - The algorithm continuously calculates the remaining production time until completion of a stack
  - If desired, data is transmitted to the tapio MachineBoard app
  - The app notifies the operator in good time when a stack is finished and operator intervention is required
  - This makes planning easier and ensures a smooth workflow
  - Operators do not have to monitor the saw and can use their work capacity to create value somewhere else

OPTIMIZATION

intelliDivide (optional feature)

Simply upload the parts list. Done! The result? A choice of several alternatives for cutting patterns and entire runs. That’s how easy intelliDivide makes it.

In detail: the cloud-based optimization software intelliDivide utilizes significantly higher computing capacities than are available for locally installed optimization software and can therefore swiftly provide the user with several alternative optimization results.

When using intelliDivide, in addition to a purely waste-based result, the operator can also select other alternatives, such as results based on the shortest machine time or the simplest handling – to ideally suit the specific requirements.

Applications are varied and are geared toward both the trade and industry.

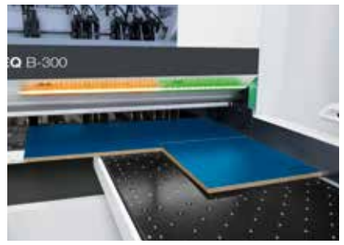
OPTIMIZATION

Cut Rite (optional feature)

Efficiency through planning: this short phrase sums up the key benefits of the Cut Rite software. With this world-leading software solution, you can optimize waste and systematically lower the overall costs for cutting.

- Seamless, precise and highly efficient processes ensure optimized project control
- Efficient cutting processes which can be individually adapted to your production processes by means of parameter settings
- Full cost control within the cutting process: material costs and processing time are calculated automatically when the quotation is prepared
- Faster calculations by using all the processors in the PC
- Simple handling: clearly structured, easy to operate and graphics display the information

Find out more in the “Cut Rite” brochure.

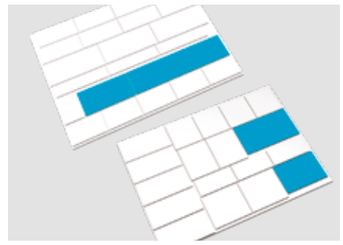


OPERATOR ASSISTANCE

intelliGuide Classic (optional feature)

intelliGuide always shows the operator the next step directly at the saw. The system accomplishes this by means of an LED strip at the cutting line. The LED strip produces light signals that appear directly in operator’s field of vision.

- Colored LED signals at the cutting line allow intuitive operation and a quicker, safer way of working
- Using the colored LED elements, machine operators can immediately see if a part has been fully processed, needs to be cut again or can be disposed of as waste
- Based on the LEDs that are lit up, the operator can determine whether the workpiece being processed meets the required specifications



OPTIMIZATION

intelliOptimizer Stacking (optional feature)

This software-based additional function allows you to get maximum performance from your robot saw.

- Significantly more saw output per day
  - Intelligent resorting of the cutting patterns previously created by an optimization software and specially tailored to the saw concept enables even better stacks and therefore fewer stacks overall (more parts per stack)
  - The process thus reduces the number of stack changes required by 20%
  - The improved and higher stack enables the ghost shift to be extended and therefore greater output
- Transparency and flexibility
  - intelliOptimizer stacking suggests alternative handling options for your production. You select the option that suits you. This also allows you to decide on the ideal utilization of the machine concept: maximum output through processing series jobs in package cutting or maximum time for fully automatic operation

Illustrations may show the technical principle but not the precise machine variant described.
Optional features, for example, may be shown.

Standard features

The SAWTEQ B-300 flexTec and the SAWTEQ B-400 flexTec are equipped with everything you need for highly efficient and even partially unmanned manufacturing.

Robot with suction traverse

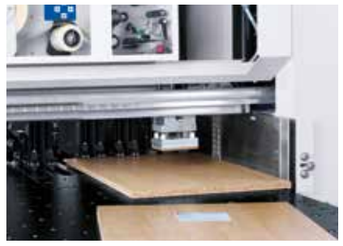
At the heart of these saws is a tried-and-tested industrial robot with a specially developed suction traverse. The robot is responsible for all the handling of the panels, strips and parts. Fully automatic, highly flexible, error-free and efficient.

The basic principle: using the suction traverse, the robot gently lifts the material, moves it under the pressure beam and aligns the part to be processed against the right-angled fence. Then, it is automatically pushed backwards into the clamps. After sensors have checked the position and orientation, the cutting process starts. Afterwards, the robot collects the processed part and either aligns it again for the next cut, stores it temporarily or destacks it.

Parts buffer

The system has a parts buffer directly above the pressure beam. This is where the robot temporarily deposits parts that are to be either destacked or fed to the saw again later.

In order to ensure maximum process reliability, the parts buffer is equipped with a cleaning station for the aligning suction cups on the traverse. Dust deposits on the suction cups are regularly blown off.

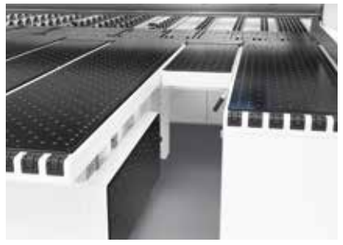


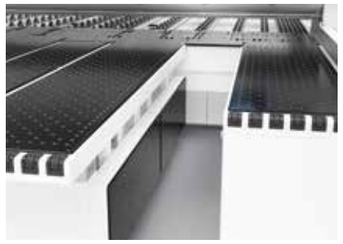
Fully automatic labeling

A must in robot operation and an advantage in operator operation: the labeler is an integral part of the standard configuration. It labels the finished parts or books of parts automatically – even when several strips are processed simultaneously side by side (Power Concept).

Good to know: the labeler is located near the pressure beam, i.e. in your field of vision. Furthermore, whether panels are fed from the side, front or rear is irrelevant for the labeling process. The position of the label can be individually controlled if desired – even right up next to the right-angled fence.

- Label size: 76 x 76 mm
- Suitable for panels, offcuts and finished parts
- Gives precise details of the destacking location
- Gives precise instructions for further processing
- Saves time
- Minimizes errors
- Guides the operator





Fold-down air cushion tables

- The gaps between the air cushion tables are each equipped with two fold-down tables
- The additional tables in the first gap are equipped with air jets as standard
- In operator operation, the tables can be folded up or down to enable easy access to the cutting line or to prevent thin materials from sagging and to increase the work area
- For robot operation, the additional tables are raised and all gaps closed

Automatic outfeed fence

- Pushes panel remnants from the rear machine table to the front
- Included as a standard feature as it is essential for robot operation

Patented: central side pressure device

- Integrated directly into the saw carriage – shortens cycle times by up to 25% in comparison with conventional systems
- Infinitely variable adjustment of contact pressure – depending on panel thickness. This allows even thin panels, laminates or sensitive materials to be processed perfectly. Another key feature here is the control of the contact pressure, which is dependent on the package height: the higher the package, the greater the pressure

Illustrations may show the technical principle but not the precise machine variant described.
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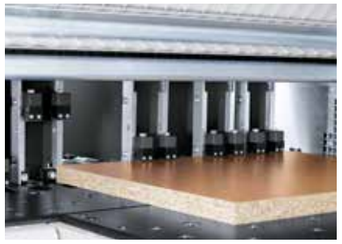
Standard features

Clamps

- Robust clamps, all with two fingers
- Gentle positioning of material
- The bottom fingers of the clamps can be removed at any time to allow the back of the clamp to be cut in perfect alignment – a fast means of adjustment
- The clamping pressure can be adjusted (manually) to suit each particular material
- The short, rugged design allows material to be precisely held and guided 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



Clamp activation

This option prevents damage to edges. Now also available: clamp activation in “measuring” mode.

Handy cleaning flap

Quick and convenient: the area under the saw carriage is easily accessible via flaps, allowing easy removal or vacuuming of cutting waste.

Patented dustEx technology

dustEx guides dust and chips on a direct route toward the dust extraction system. How does it work? Using combination air jets and an optimized extraction geometry at the right-angled fence. Furthermore, the machine table is fully equipped with air jets. This is particularly advantageous when cutting sensitive material or handling especially heavy panels and books.
To round off the dustEx package, we recommend using a dust-trap curtain.

One saw carriage, numerous benefits

- Torsion-resistant, rugged and resilient basic design of the steel plate body for maximum dynamics and precision
- Infinitely variable feed speed – for precision cutting of demanding materials
- Long-term accuracy of saw blade projection
- Fast, precise, low-wear and infinitely variable positioning of the main saw blade by means of linear guide system with rocker arm (patent)
- Energy-saving feature: main saw motor is not raised

Power-Loc system

Making it quick and easy to change the saw blade.

Program fence for precision and dimensional accuracy

- Resistant to torsion and bending
- Electronically controlled
- Precision guidance on H-girder
- Electromagnetic measuring system guarantees a positioning accuracy of +/- 0.1 mm per meter
- Measuring system involves no wear and no maintenance

Rugged pressure beam for first-class cut quality

- Increased pressure beam elevation. The suction traverse can move under the pressure beam
- 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
- The result is accurate cuts, for books too
- With height control on request (available as an option)

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Optional features

The HOMAG SAWTEQ B-300 flexTec and SAWTEQ B-400 flexTec saws are designed for maximum flexibility. This is achieved by the innovative machine concept, but also by the many optional features. The choice is yours!

Panel labeling system

The innovation for saws with automatic storage integration: the HOMAG panel labeling system labels the unprocessed panel before it is cut – independently of the saw, in non-productive time that previously went unused. It can also be combined with the feed-stacking table with integrated feed.

- Smallest part size 170 x 170 mm
- Up to 10 labels/min, optionally up to 15 labels/min
- Labeling independent of cutting process
- Saves time, because non-productive time is used productively
- Optimizes handling during destacking because all the parts are already labeled
- Simplifies and speeds up production processes
- Automated parts tracking
- Can be retrofitted
- For smooth processes

Control scanner

Mounted directly on the pressure beam printer, the control scanner checks just in time whether the parts cut are correctly labeled.

- Ideal for quality assurance in automatic production
- Minimizes sources of error: the system checks independently whether parts are labeled and barcodes are legible
- If labels are missing or illegible, they are reproduced automatically

Rotation device for headcuts

- Process integrated perfectly into the machine cycle
- Labor-saving device for operators
- With automatic aligning function
- Less time required for preparation
- Easy operation
- Significant increase in output

Feed-stacking table with integrated feed

When linked to a simple storage system, the saw has to stop working briefly when a new panel is fed. The feed-stacking table ensures smooth, faster cycles: while one panel is still being cut, the storage system already positions the next panel(s) on the feed-stacking table with integrated feed.

- Ideal in combination with the HOMAG panel labeling system
- Can be retrofitted
- Plug & Play: easy add-on
- Without alignment
- Perfectly matched to the saw (height, width, roller rails)
- Virtually no more idle time

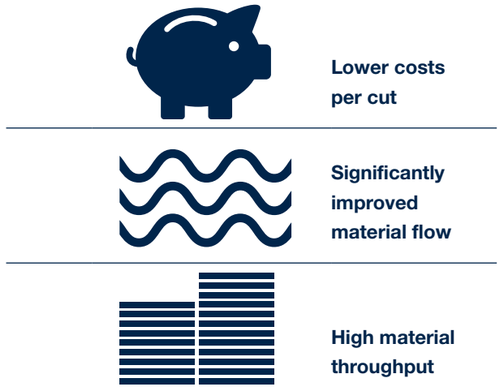
Power Concept Premium

At the heart of this technology is a clamp that can be moved separately. Using this clamp, several strips with different cross cuts can be cut to length together. Even very narrow strips are precisely cut. Like this, Power Concept professional accelerates overall production and significantly increases material throughput.

Power Concept works with:

- An additional clamp that operates independently
- Clamps on the program fence that can be raised out of the overlapping work area as needed
- Re-sorting the strips directly at the saw so that they are ideally matched to Power Concept professional. This is based on existing optimization data for the shortest machining times

Can only be used in operator operation.



Power Concept Advanced (for saws without lifting table)

This is the low-cost version of the successful Power Concept professional. Power Concept practive can be used on saws without lifting table with the following feeding variants:

- Feeding via a feeding station in front of the saw
- Feeding via a simple storage connection
- Feeding via the HBX 150 feed gantry

The advantage: Power Concept practive can do everything that constitutes Power Concept, but can be integrated far more easily and therefore more economically.

Can only be used in operator operation.

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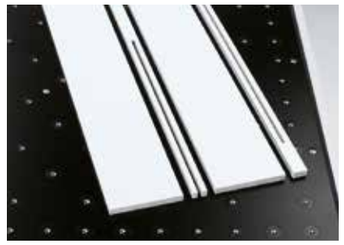
Optional features



Cut-out and stress elimination cut

Stress in the material is released when it is cut and can affect the quality of dimensions and cuts. The stress elimination cut provides a solution here. Systematic preliminary cuts can be defined during optimization and release the tension in the material. In operator operation, the cut-out feature allows you to produce even cut-outs and insertion grooves immediately – for example for doors or kitchen sinks.

Cut-out function can be used in operator operation only.
Stress elimination cut can be used in operator and robot operation.

Automatic angle cut device

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

Can only be used in operator operation.

Soft Touch 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. HOMAG has a range of solutions in its portfolio designed to meet these requirements. Simply ask your customer advisor.

Grooving and turbo grooving

These options save you an entire work step in post-processing. This is because your saw will also groove the panel material. The turbo-grooving option completes the grooves even much faster than a processing center.

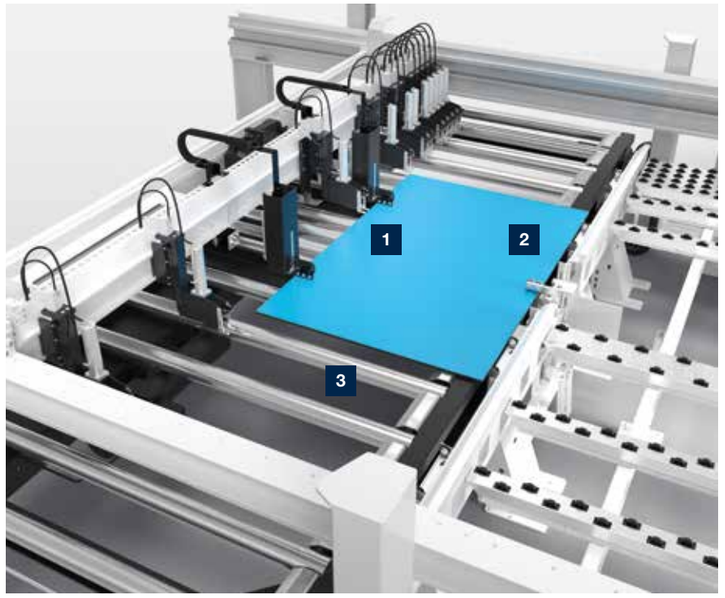
Can only be used in operator operation.

Processing panel materials more than 3200 mm long

Thanks to a newly developed processing program, in robot mode the saw can even process large panel sizes of > 3200 mm to 4200 mm fully automatically.

How it works:

- After infeed via the rear machine table, a compulsory headcut is executed to reach the maximum panel length of 3200 mm
- The remaining panel is then pulled to the rear and parked in the storage shaft for later processing
- This also increases efficiency and flexibility in robot mode



1 Micro-feed for thin panels (for lifting-table saws only)

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

2 Hold-back device for thin panels (for lifting-table saws only)

For thin panels from a thickness of 3 mm.

3 Extra impetus for feeding (for lifting-table saws only)

The automatically driven roller conveyor integrated into the lifting table and additional roller conveyors on the side ensure fast stack changeover.

Pneumatically operated trim stops

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

- Robust
- Adjustable to common panel thicknesses
- Gentle handling of sensitive materials with overhanging covering layers
- Precise positioning

Cutting gap closer

Open and close automatically during the machine cycle, preventing narrow strips or trimmings from getting caught in the cutting line.

Dust-trap curtain

- Attached to the rear of the pressure beam
- Protects operators from dust
- Improves dust extraction

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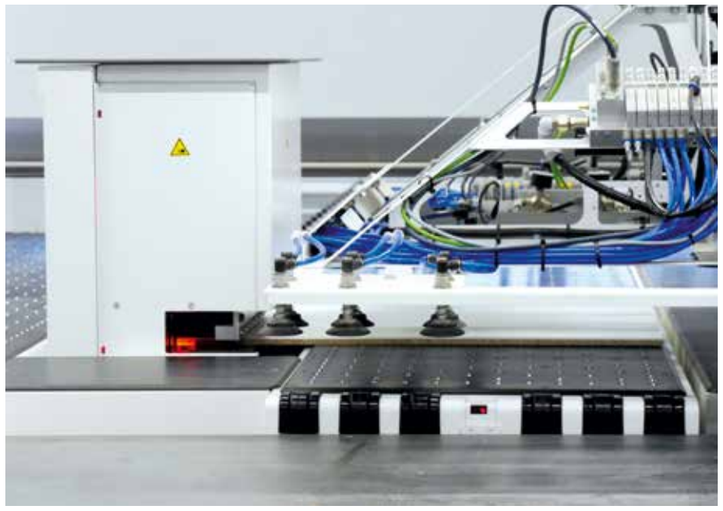
Optional features



NEW: measuring system cutting quality (MSQ)

- Cut quality is monitored automatically through regular checks on edge breaks
- Specified material-specific warning and limit values are observed

Lots of potential for your production:

- Objective and regular evaluation: frequent quality management and unique result interpretation with reduced operator interventions
- Demand-based saw blade change: use of maximum saw blade service life and increased availability
- Avoid reject parts: less post-production effort since specified, material-specific limit values are observed
- Increased process reliability and potential for further process and cost optimizations

Scissor lift pallet truck “HuGo”

The scissor lift pallet truck “HuGo” is equipped with automatic height control and facilitates ergonomic and intelligent destacking processes. A light barrier controls the automatic raising and lowering of the pallet truck, allowing you to reach all the parts on the pallet at an ideal working height – at an edge banding machine, for example.

Automatic waste removal

Compact, practical and quiet: a robust disk chipper connected to a waste container is at the heart of the automatic waste removal system. The system is completely encapsulated and housed in a soundproof cabinet.

- Waste cuttings fall through a waste flap onto a conveyor belt and are transported to the chipper
- The chipper pulls the waste in and shreds it
- The shredded waste is automatically catapulted upward by the mechanical action and lands in the waste container

NEW: Now with integrated direct suction in the waste disposal area (optional)

Benefits: the fully automatic waste handling also saves time for the machine operator and frees up their capacity for value creation activities. In robot operation, intervention by the operator is no longer required. The waste disposal runs fully autonomously, provided the waste material can be burned directly. This means less machine idle time and more output!

Additional start-stop key

- Allows the program sequence to be started independently of the control panel
- Equipped with an emergency stop key

Label printer for superb results

The label printer is simply integrated in the robot pedestal. With it, you can create custom labels for manual part labeling directly at the saw and design them as required with a barcode, text or even graphics. If you also use our Cut Rite optimization software, the material goes directly to the next process step with printed instructions. In this way, you can integrate the saw perfectly into your production flow.

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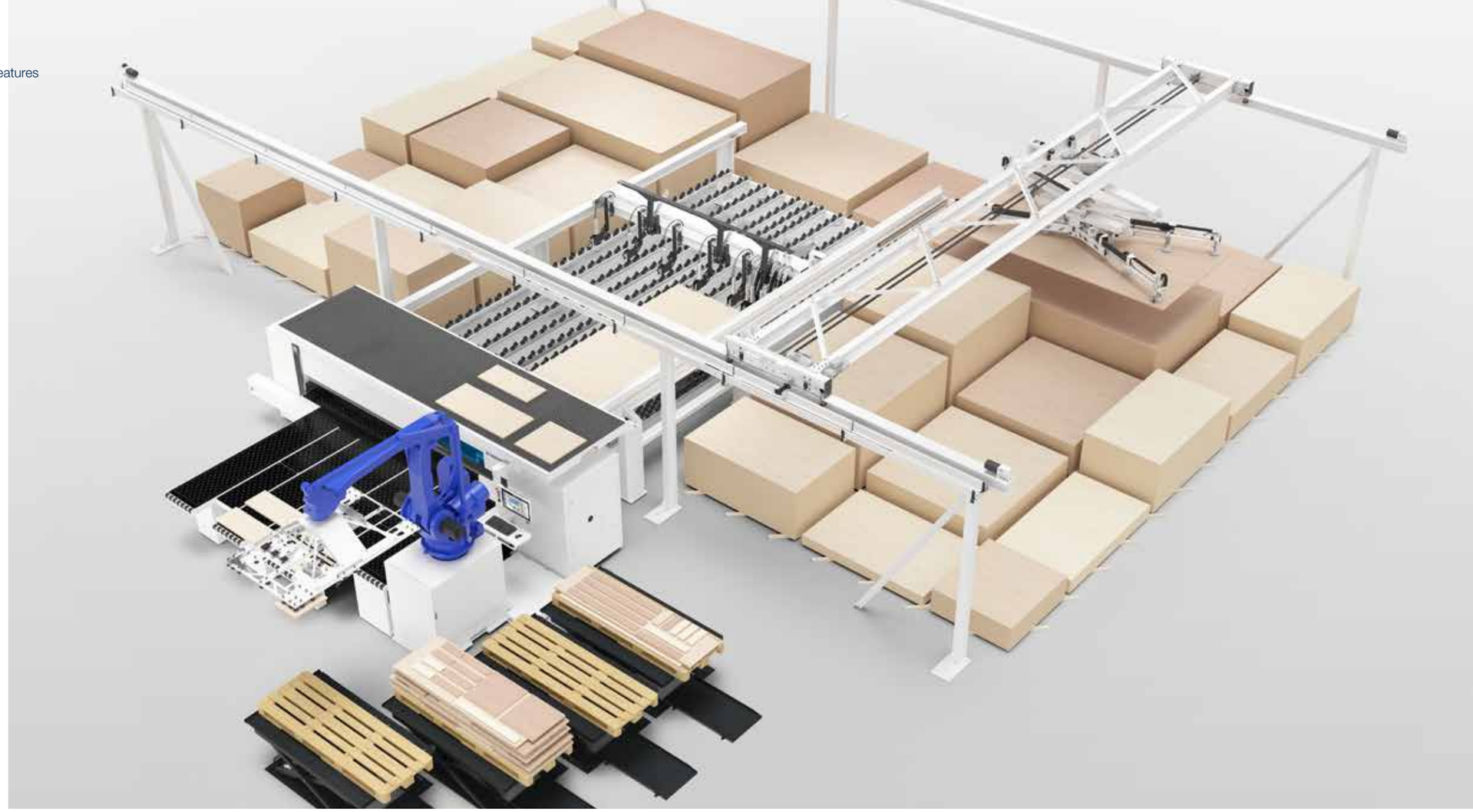
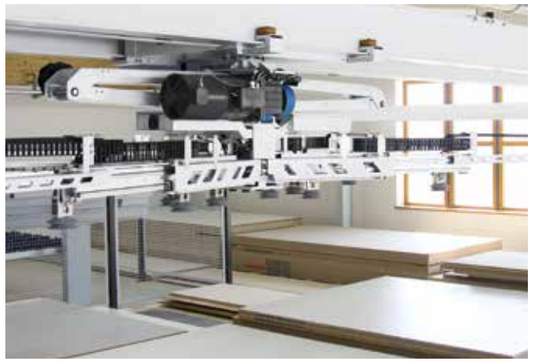
STORETEQ S-200 or S-500 – the right horizontal storage system to meet your needs

Even with the widest possible range of products, high speeds, and full equipment. The STORETEQ S-200 allows you to optimize transport routes and quantifiably save material and time. The STORETEQ S-200 provides intelligent logistics with palpable efficiencies. The STORETEQ S-500, the all-rounder among the storage systems, is used to deliver even more flexibility for a variety of materials.





The **ST71 suction traverse** in X geometry is the ideal optional feature for the STORETEQ S-200. The self-learning cross rail generates the data required for panel handling independently and thus ensures dependable process reliability. The operator does not have to enter anything.

The STORETEQ S-200 optimizes the storage area and saves you valuable production space

- Intelligent standby – the machine only uses energy when it is actually moving
- Optimal material consumption right down to offcuts thanks to well-thought out material management
- Handling without any extra costs – coated panels from a thickness of 3 mm thanks to the ST 61 suction traverse, which is already included in the standard version
- High flexibility due to ideal use of the available area even in the smallest possible space
- Increase in productivity of up to 40% with the same level of personnel

STORETEQ S-500 – flexibility and variety of materials combined in one storage system

The sturdy construction of the STORETEQ S-500 allows for great flexibility for the design in the length and width.

- Span widths of up to 16 m and travel path lengths of up to 100 m and more
- Controlled, low-vibration movements even in the largest version

Great variety of materials

Whether it's handling plastic, plexiglass or laminate, coated or uncoated panels, the STORETEQ S-500 is also a true all-rounder when it comes to handling panels.

- Panel weights up to 350 kg and panel lengths up to 5600 mm
- Smooth transport of even textured surfaces
- High double scissor stability for precise panel handling
- Handling of plastic panels

Illustrations may show the technical principle but not the precise machine variant described. Optional features, for example, may be shown.

Ten important reasons to opt for the woodStore warehouse control system

1. Open database systems enables seamless integration
2. Multi Terminal offers transparency and ergonomic operation
3. Smart Connected System: full integration of optimization, processing machine, and storage into one cutting system
4. intelliStore: flexible storage organization that automatically adjusts to production conditions
5. Complete offcuts management prevents the buildup of offcuts
6. Forklift operator management: enables material supply separate from cutting
7. Management of outside storage is integrated
8. Easy Edit production lists: easy to change orders and sequence
9. Various storage strategies enable easy adjustment to production scenarios
10. Optimization of the production sequence enables high performance

woodStore 8. Portable, networked, user-friendly.

Mobile operation
You can control various functions via mobile end devices within the machine's WiFi.

User management
Personnel-controlled warehouse operation with a functional range of up to 40 different user rights.

Smart Connected System
Complete integration of optimization, saw and storage into one cutting system with corresponding standardized interfaces.

Email notification
In the event of any malfunctions in the operation of the storage system, the system sends an email to the email account specified.

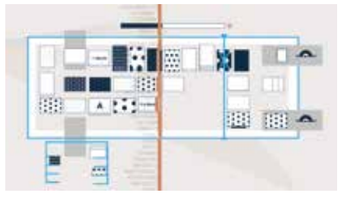
Database access analysis
Customer database is measured for performance and logged to identify digital bottlenecks.

Smart Separation Learning
Fully automatic panel separation that requires only two panel handling settings.

intelliStore
All storage movements are monitored permanently and automatically adjusted to the current production conditions.

Integrated image database
Easy selection and assignment of panel finishes for realistic representation of the panels available in the warehouse.

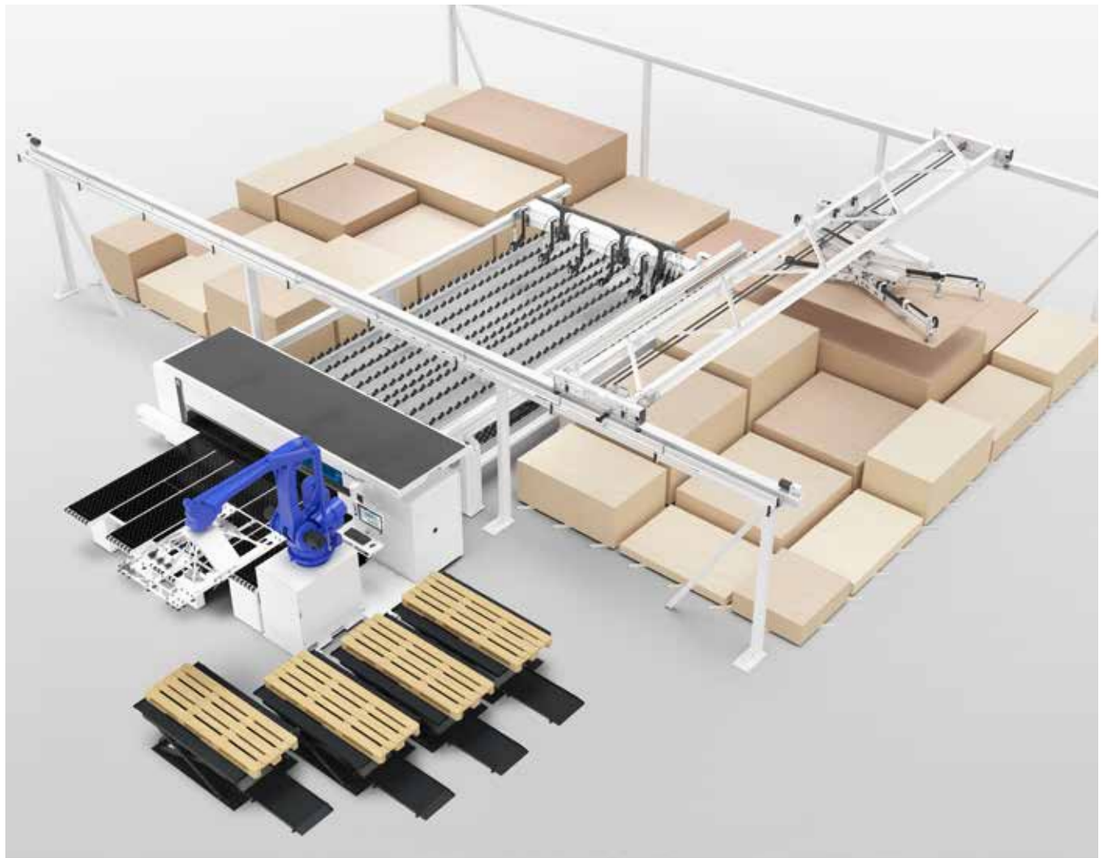
Scrap management
Automatic return of saw offcuts to storage with built-in panel measurement as part of the material intake process and management of manual offcut stocks with corresponding wizards for easy set-up.



woodStore Analyzer
In a period that can be selected individually, the main functions of the storage system are examined and analyzed according to the customer's requirements in order to determine whether the customer is using the storage system optimally.

Feeding variants

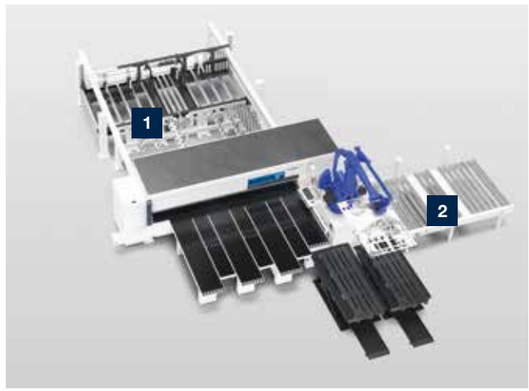
For the robot saws SAWTEQ B-300 flexTec and SAWTEQ B-400 flexTec, flexibility starts right at the feeding stage. Which variant is your favorite?



Feeding via a storage system

For customers with very demanding automation requirements, HOMAG offers tailored horizontal storage systems – ranging from small systems for the trade sector to large industrial solutions. These systems allow you to noticeably speed up your processes and reduce your costs per part.

- Small footprint
- Attractive price
- Movable in x and y directions
- Saw and storage system compatible with each other
- Perfect handling – even with just one machine operator
- Easy, ergonomic operation
- Storage system controls the saw



1 Feeding via lifting table

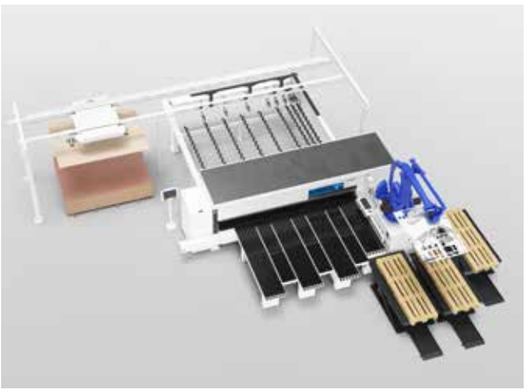
- In the case of lifting-table saws, panels are fed via an electro-hydraulic four-column lifting table
- Automatic determination of book height
- Equipped as standard with longitudinal profiles and sensing device
- Also suitable for thin materials with a thickness from 9.5 mm. Suitable for materials with a thickness from 3 mm upward if equipped with the optional micro feed and hold-back device (page 17)
- Maintenance-free and no lubrication required
- In order to ensure precise cuts, the backing wall is not attached to the machine bed

2 Robot feeding via roller conveyor at the side

HOMAG has designed a table with roller conveyor, positioned at the side, specifically for the SAWTEQ B-300 flexTec and SAWTEQ B-400 flexTec panel dividing saws.

- A pre-assembled stack of panels is placed on the roller conveyor at the side
- A panel separator positioned here raises the top panel each time so that the robot can fetch it with the aid of the suction traverse and feed it to the saw

This feeding variant can only be used in robot operation.



Vacuum feeding via HBX 150 (for single saws without lifting table only)

Automation in the smallest of spaces is the promise made by the HBX 150 gantry vacuum feeding system. It fetches the next panel from the stacking station next to or behind the saw, turns it if required and places it in the saw. Fully automatic and gentle in saw cycle.

- A choice of various layouts to suit specific requirements and available space
- With traveling lifting device and suction traverse
- Turning device for up to 90 degree rotation
- With automatic weight determination
- For especially ergonomic handling
- Manufactured by Barbaric

Find out more in the “HBX 150” flyer.

Intelligent destacking

The panel dividing professionals from HOMAG have developed destacking software with algorithm. This, together with the robot and the lifting tables in the secure area of the plant, enables the SAWTEQ B-400 flexTec and SAWTEQ B-400 flexTec to operate unmanned over long distances. A revolution in panel dividing technology!

The advantage: operators are not required over long distances

Equipped with lifting tables in the robot's field of action, the saws can work unmanned over long distances, depending on the destacking variant chosen.

The operating principle: clever and highly automated

The finished parts exit the saw in the order in which they are cut. To obtain the optimum destacking order for stable stacking and subsequent processing, the HOMAG experts have developed an algorithm.

Equipped with this intelligence, the robot systematically creates stable stacks. For this, it also makes use of the parts buffer in the destacking process as required. Like this, the lifting tables are used more intelligently than ever to form perfect stacks.

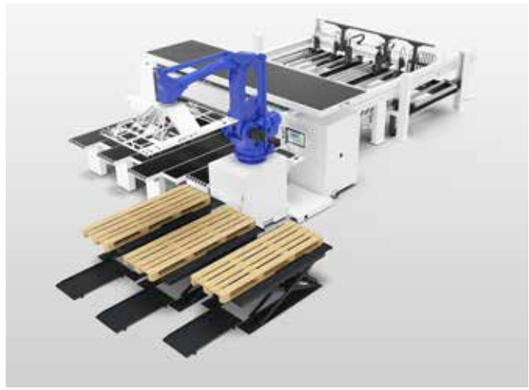
The cutting cell is equipped with a laser scanner. It measures the height of the stacks of parts on the lifting tables in real time so as to ensure that the lifting tables are positioned at the ideal height.

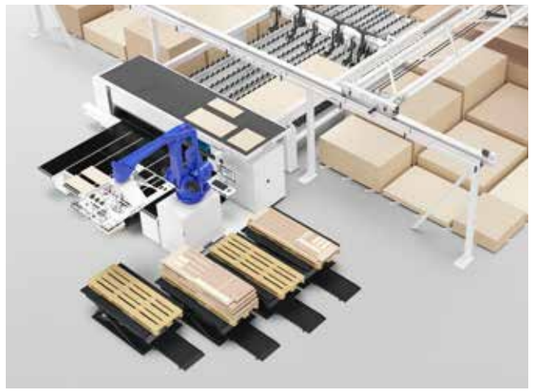
The result: all-round efficiency

- The robot can destack parts according to an optimization strategy based on either the destacking location or downstream processes
- The robot always tries to utilize the maximum stack height
- It forms absolutely stable and, at the same time, fewer stacks than is normal when manually destacking
- Actions by machine operators are rarely required, and no longer needed at all over long distances

This reduces the space required for handling tasks. All this adds up to a rapid return on investment.

- Decide for yourself: single-type or chaotic destacking





Lifting table variants for every requirement

Diversity of materials, picking destinations, number of orders processed in parallel: there are many parameters that decide the best number, size and positioning of the lifting tables in each individual case. Requirements can vary greatly. That's why the HOMAG panel dividing experts work together with you to develop the best possible lifting table layout for your production facility.

- As a minimum, a large and small lifting table are required
- The maximum number that can be combined with each other is three large and two small lifting tables
- Feeding by robot via a roller conveyor at the side limits the number of lifting tables and positioning options

Performance and level of automation tailored to your needs

PERFORMANCE

SAWTEQ B-300 / B-400
as single saw

SAWTEQ B-300 / B-400
as single saw + storage system

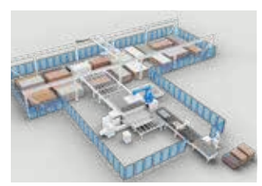
SAWTEQ B-300 / B-400 flexTec
as single saw

SAWTEQ B-300 / B-400 flexTec
as single saw with lifting table
feed

SAWTEQ B-300 / B-400 flexTec
as single saw + HBX 150 feeding
unit

SAWTEQ B-300 / B-400 flexTec
as single saw + storage system

SAWTEQ B-320 flexTec +
storage system + manual
destacking



SAWTEQ B-320 flexTec +
storage system + automatic
destacking

AUTOMATION

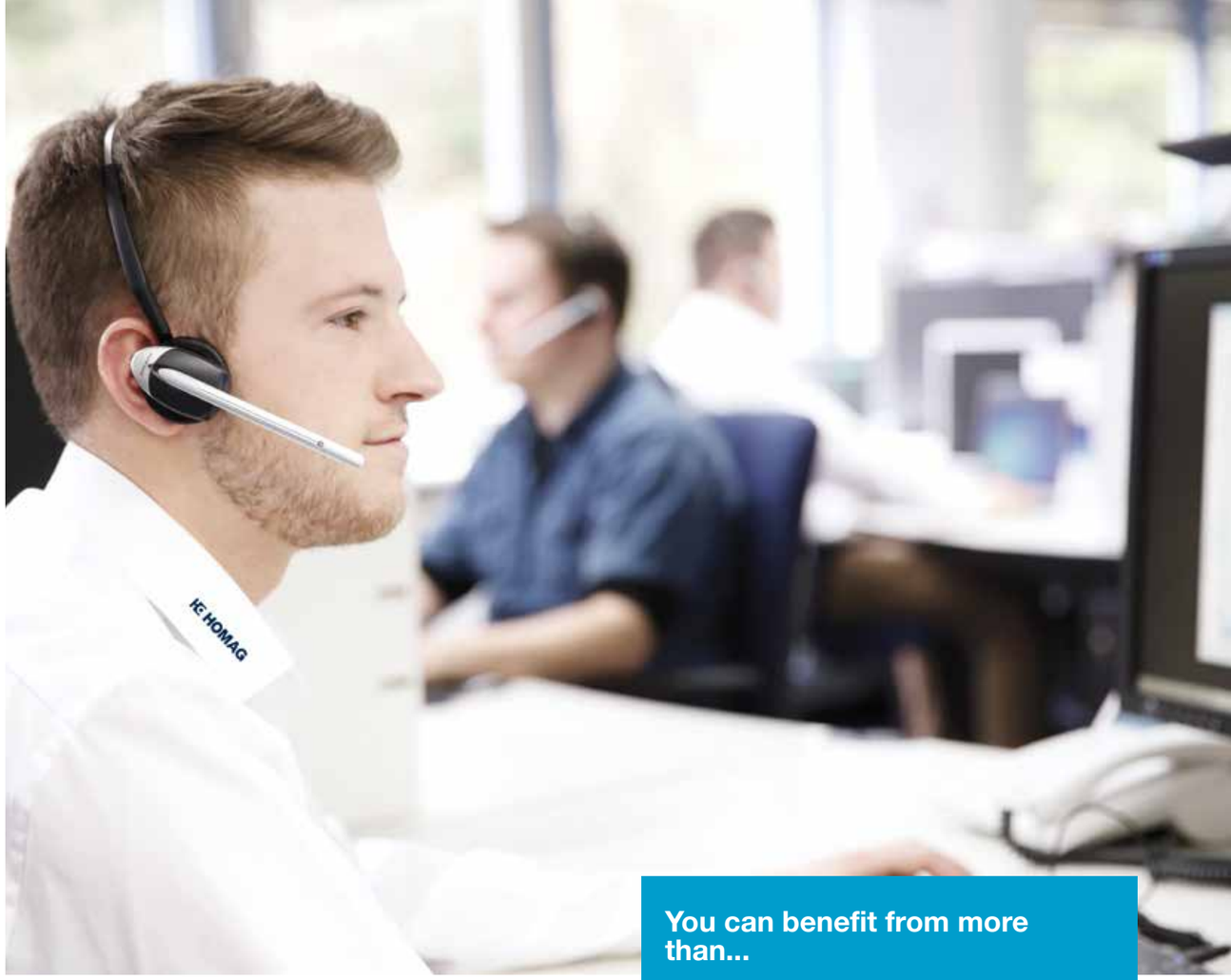
TECHNICAL DATA*	B-300 FLEXTEC	B-300 FLEXTEC WITH LIFTING TABLE
Saw blade projection (mm)	80 (optional: 95)	80 (optional: 95)
Cutting length (mm)	3800 / 4300	3800 / 4300
Lifting table width (mm)	-	2200
Program fence speed (m/min)	up to 90**	up to 90**
Saw carriage speed (m/min)	up to 130 (optional 150)	up to 130 (optional 150)
Main saw motor (kW)	50 Hz: 11 (optional 18 or 24) 60 Hz: 11 (optional 21 or 28)	50 Hz: 11 (optional 18 or 24) 60 Hz: 11 (optional 21 or 28)
Scoring saw motor (kW)	1.5 (optional 2.2)	1.5 (optional 2.2)
Average total air requirement (NL/min)	400	470
Required compressed air supply (bar)	6	6
Max. panel size (mm)	3200 x 2100 (optional 4200 x 2100)	3200 x 2100
Max. part size (mm)	2800 x 1200	2800 x 1200
Min. part size (mm)	190 x 80	190 x 80
Max. panel thickness (mm)	60	60
Min. panel thickness (mm)	8	8
Max. panel weight (kg)	125	125

TECHNICAL DATA*	B-400 FLEXTEC	B-400 FLEXTEC WITH LIFTING TABLE
Saw blade projection (mm)	110 (optional: 125)	110 (optional: 125)
Cutting length (mm)	3800 / 4300	3800 / 4300
Lifting table width (mm)	-	2200
Program fence speed (m/min)	up to 90**	up to 90**
Saw carriage speed (m/min)	up to 130 (optional 150)	up to 130 (optional 150)
Main saw motor (kW)	50 Hz: 18 (optional 24) 60 Hz: 21 (optional 28)	50 Hz: 18 (optional 24) 60 Hz: 21 (optional 28)
Scoring saw motor (kW)	2.2	2.2
Average total air requirement (NL/min)	420	490
Required compressed air supply (bar)	6	6
Max. panel size (mm)	3200 x 2100 (optional 4200 x 2100)	3200 x 2100
Max. part size (mm)	2800 x 1200	2800 x 1200
Min. part size (mm)	190 x 80	190 x 80
Max. panel thickness (mm)	60	60
Min. panel thickness (mm)	8	8
Max. panel weight (kg)	125	125

* Values relate to the standard version
** Forwards 25 m/min

LIFE CYCLE SERVICES

Optimal service and individual consultations are included in the purchase of our machines. We provide support through service innovations and products that are tailored exactly to your company's requirements. With short response times and rapid customer solutions, we can guarantee excellent availability and cost-effective production for the entire life cycle of your machine.



TELESERVICE

- Hotline support via our trained TeleService experts regarding control system, mechanics and process technology. This means over 92% fewer on-site service visits and therefore a faster solution for you!
- The ServiceBoard app helps to solve tasks in a fast, simple and concrete way. This is achieved by mobile live video diagnosis, automatic sending of service requests or the online spare parts catalog eParts.

SPARE PARTS SERVICE

- High spare parts availability and fast delivery.
- Ensuring quality by predefined spare parts and wear parts kits, comprising original spare parts.
- Identify and inquire for spare parts online at www.eParts.de 24/7 or even faster and more conveniently in the new HOMAG eShop (shop.homag.com).

MODERNIZATION

- Keep your machinery up to date and increase your productivity as well as your product quality. This is how you can meet tomorrow's requirements today!
- We support you with upgrades and modernization as well as individual consultancy and developments.

DIGITAL SERVICES

- serviceRemote – the new TeleService solution of the future! Fast restart of production because the TeleService employee has extensive access to relevant physical data.
- serviceAssist enables you to help yourself. The preventive solutions proposed in the new app are the combination of our experience and existing machine data.

SOFTWARE

- Telephone support and consultancy from Software Support.
- Digitalization of your sample parts using 3D scanning saves time and money in comparison to reprogramming.
- Subsequent networking of your machinery with intelligent software solutions ranging from design through to production.

FIELD SERVICE

- Increased machine availability and product quality thanks to certified service staff.
- Regular checks through maintenance/ inspection guarantee the highest quality of your products.
- We offer you the highest availability of technicians in order to reduce downtimes in the event of unpredictable trouble.

TRAINING

- Thanks to training perfectly suited to your requirements, your machine operators can optimally operate and maintain HOMAG machines.
- In this regard, you will receive customer-specific training material with tried-and-tested exercises.
- Online training and webinars: learn without traveling – meet your trainer in the digital classroom.

You can benefit from more than...

1350
service employees worldwide

92% **less on-site service thanks to successful TeleService**

5000
customers in training sessions/year

150,000
machines electronically documented in 28 languages in eParts

HOMAG Group AG
info@homag.com
www.homag.com

YOUR SOLUTION