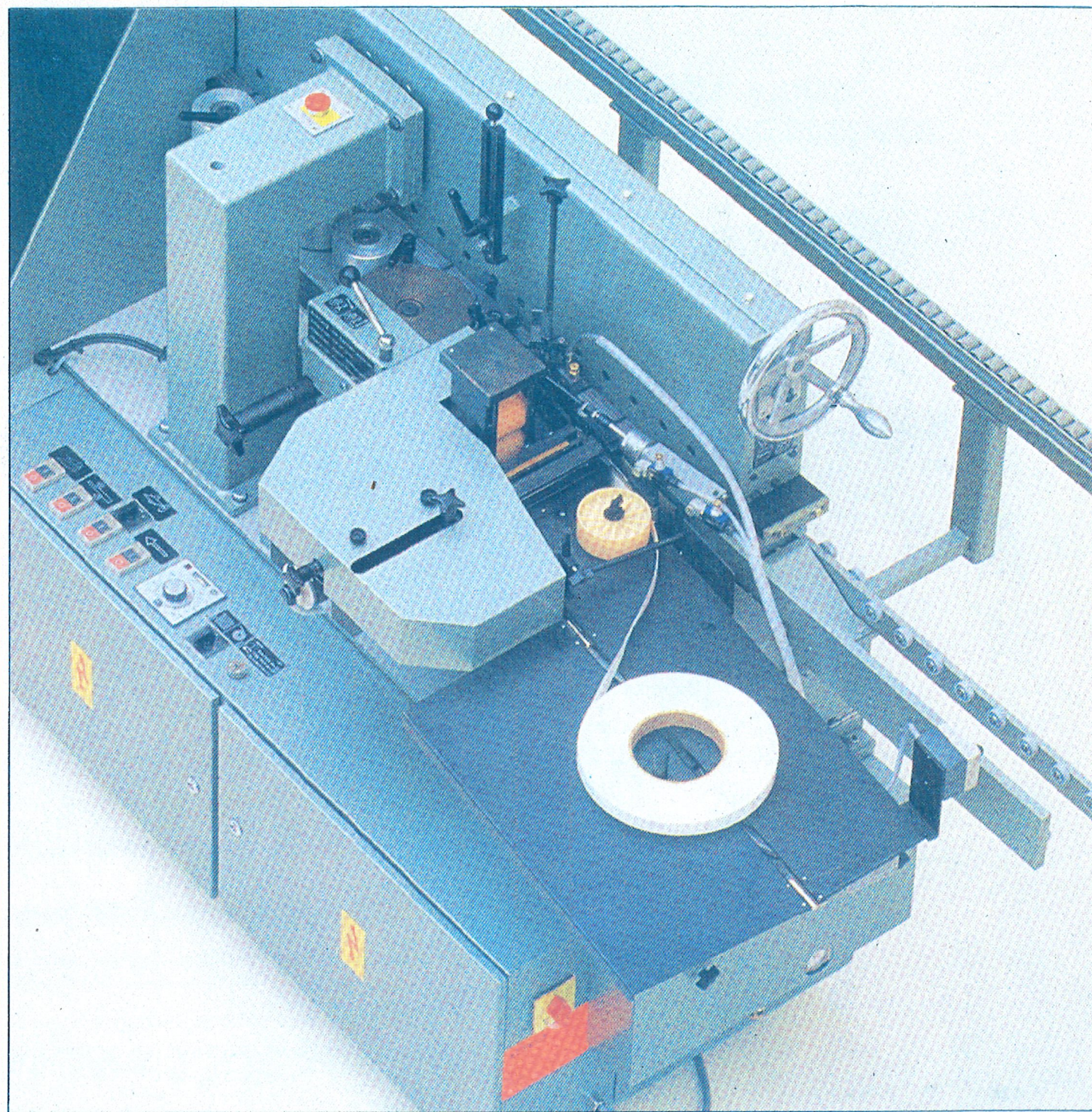
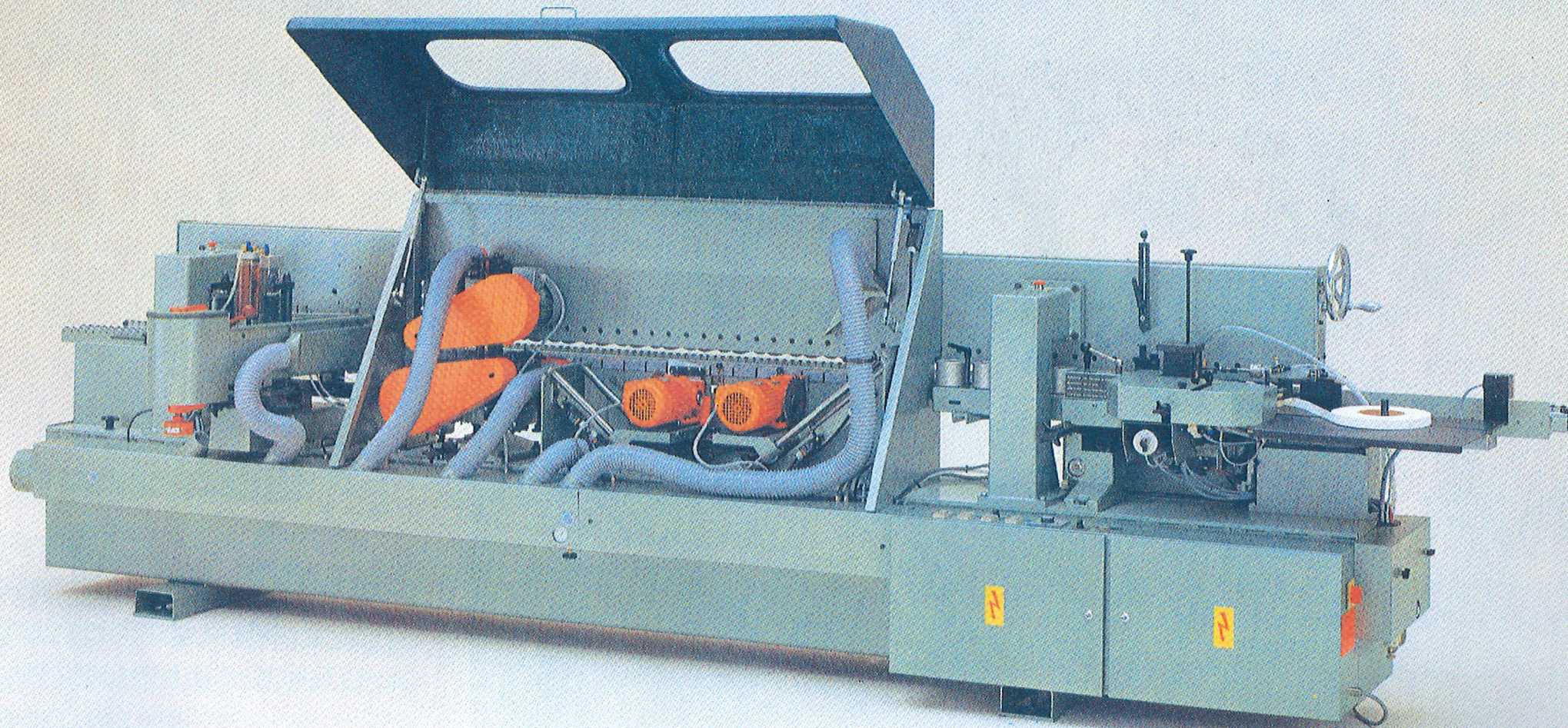


Kantenanleimmaschine
Edge Bander
Plaqueuse de chants
Encoladora de cantos
Bordatrice
Kantenaanlijmmachine
Kantbelistningsmaskin
Kantlistepåsetnings-
maskine

1408
1410

HOLZ-HER®





HOLZ-HER®

Here are the most important reasons for purchasing one of HOLZ-HER's edge banders 1408 or 1410:

1. Glue system: optionally HOLZ-HER Cartridge or HOLZ-HER Granulate System.

This choice is offered by HOLZ-HER only! Both procedures consist in a closed system, i.e. the hot-melt is separated from the ambient air within the applicator system and it cannot oxidize or become dirty. The adhesive strength is maintained.

2. Heat-up time: only 2 to 5 minutes

(it is economic even for single workpieces and short runs).

3. Changing colour: no problem

(grades of glue can be changed in a very short time).

4. Power consumption: extremely low

(e. g., the gluing station consumes only 1.9 kW; conventional glue-tanks require 4 – 5 kW).

5. Economical:

only as much glue is melted as is required for the job at hand.

6. Non-polluting:

fewer moving parts mean a lower noise level; fumes and the heat losses are considerably lower than with conventional glue-tank models.

7. Low operating cost:

the glue cannot overheat, no glue-tank to clean, less waste of heat, thus low power consumption, fewer parts to wear out, lower maintenance cost, etc.

8. Modular system:

machine can be equipped with various combinations of stations for nearly every application.

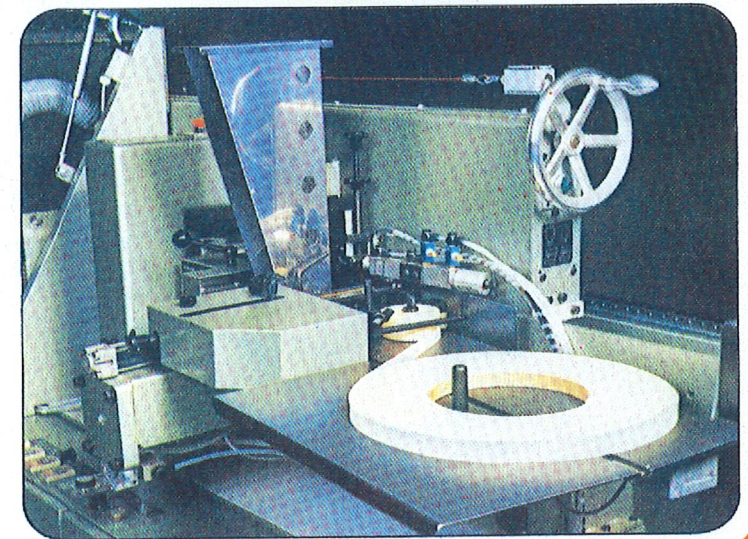
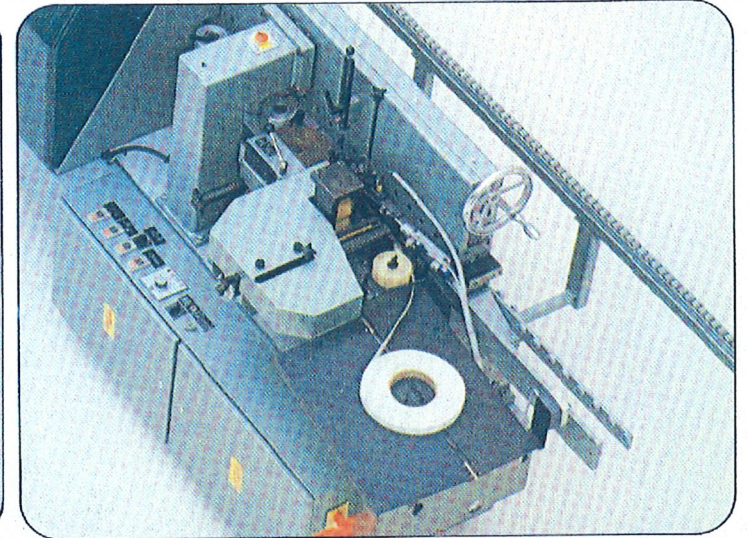
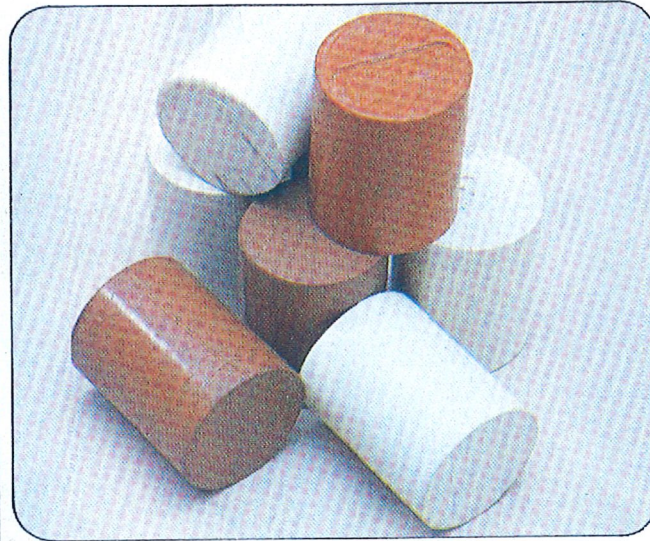
1. The HOLZ-HER Cartridge System

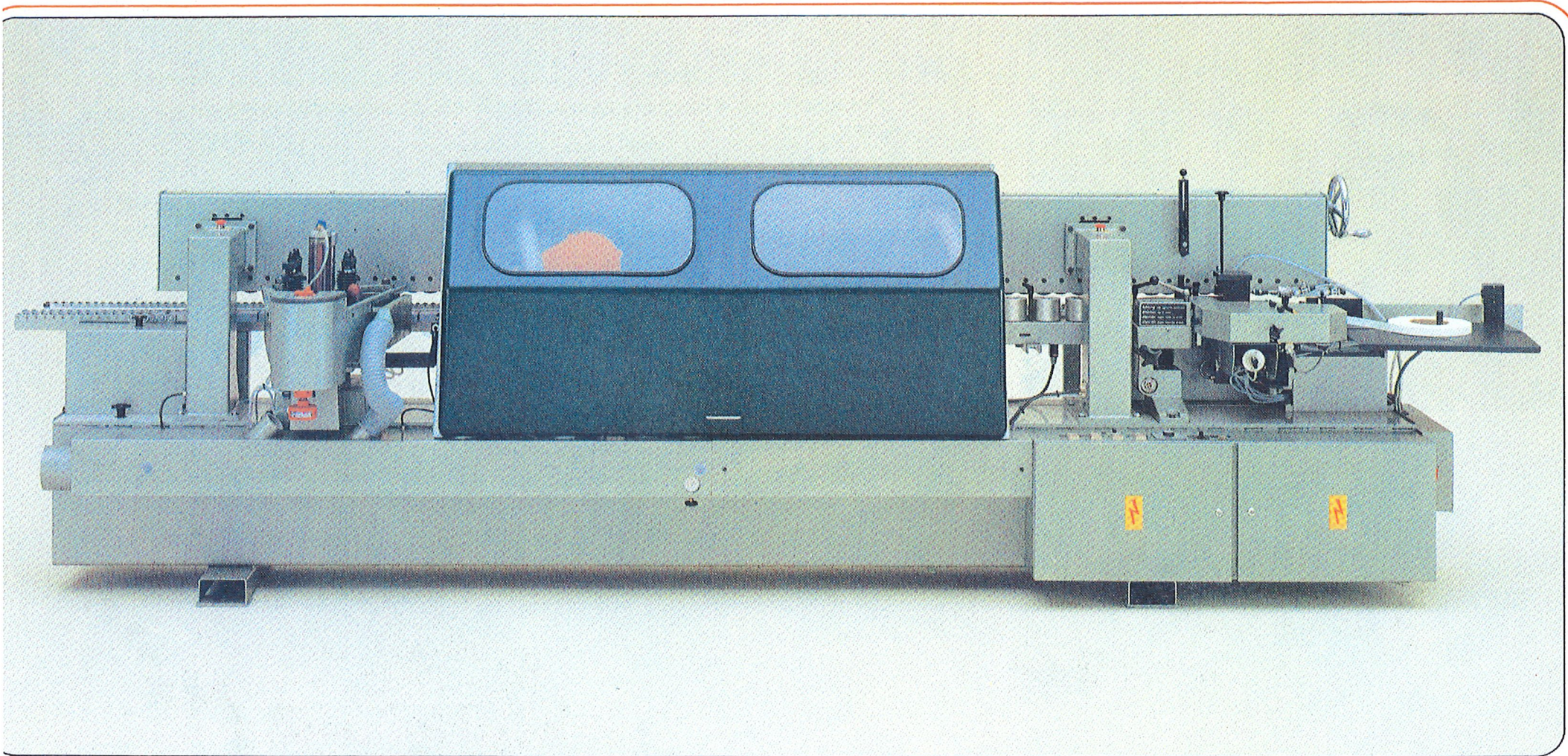
Since its introduction onto the market in 1979 the HOLZ-HER Cartridge System has had an enthusiastic reception. Investigate the 'most important reasons' why so many of your colleagues chose HOLZ-HER edge banders.

2. The HOLZ-HER Granulate System

This system is a logical development of the cartridge system and is by far the most up-to-date gluing system on the market. It is, as its name suggests, a system which uses standard commercial hot-melt pellets. The reservoir takes up to 4 kg. Enough to glue 700 m of 19 mm wide edging. The pellets are shaped into rectangular cartridges by compression (repeat, glue is being compressed into cartridges). As is with the cartridge system, only the required amount of adhesive is melted as needed. The sealed pressure system allows the use of very sensitive adhesives, which could not be used with conventional glue reservoir machines. The unique automatic flushing action of the system carries the remaining glue directly into a container, for example when changing from one glue type to another. The automatic flushing action ensures that minor impurities which may have entered with the pellets, are removed at every gluing cycle. If you use large quantities of glue, we suggest you choose the HOLZ-HER Granulate System – there is nothing equal to it.

Why not ask our specialists for detailed information?





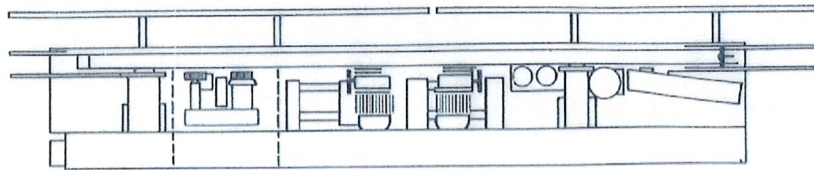
HOMAG

The HOLZ-HER 1408 and 1410 edge banders offer the most in convenience of operation, economy and safety. These machines are equipped with the advantages provided by the HOLZ-HER system, as well as many features which are not offered by our competitors. Take for example the pressure beam, it is set by only **one** handwheel fitted to the front side of the machine — simultaneously adjusting the flush trimmer. The selector switch controls the individual

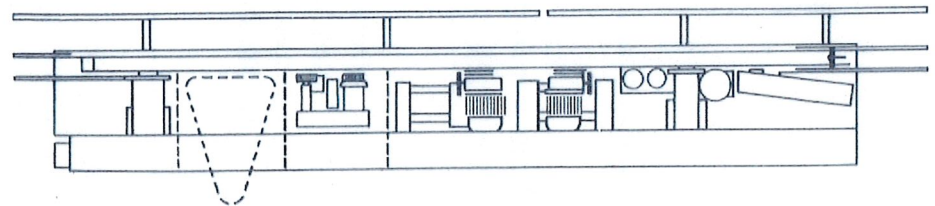
end trimmers as desired: for trimming at front and rear, or at front only, or at rear only. This selector feature is important when you are working with angled workpieces or when gluing onto mitres. The selector lever sets the pressure mechanism in just a few seconds enabling work with Melamine edgestrips, such as Resopal, Formica, etc. This is extremely advantageous as these edgestrips in particular can easily break in the pressure mechanism section. Similarly,

one can change over from thick to thin edgestrips or vice versa in only a matter of moments — compare that with other machines! Remember, that the multi-chamber glue-tanks of the conventional edge banding machines do not allow you to work interchangeably, for example with EVA and polyamide glue, without first removing the residue glue from the tank and roller. This is not the case with the 1408 and 1410, even when changing to different glue types and colour,

cleaning is a thing of the past as the new glue removes the remains of the previously used glue. Yet another reason to decide in favour of HOLZ-HER.



Type 1408 HOLZ-HER edge bander with the modular system



Type 1410 HOLZ-HER edge bander with the modular system

Here you can see the work stations in sequence (superfinish and grooving units not shown):

**Granulate system
and universal magazine**

The universal magazines for roll materials ...

**Granulate system
and universal magazine**

... as well as for straight edgestrips.

**Cartridge system
and universal magazine**

**Cartridge system
and universal magazine**

The flat nozzle produces a uniform application of the adhesive.

The pressure mechanism applies the right pressure for all types and thicknesses of edgestrips.

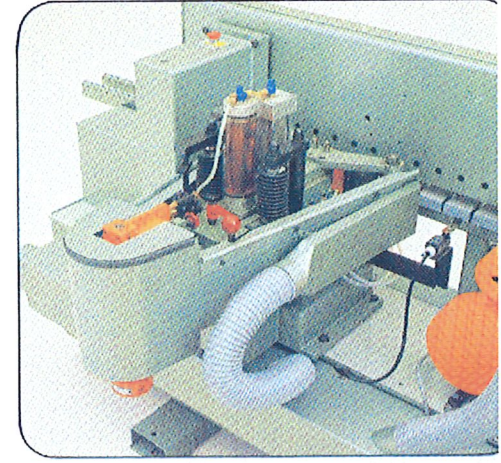
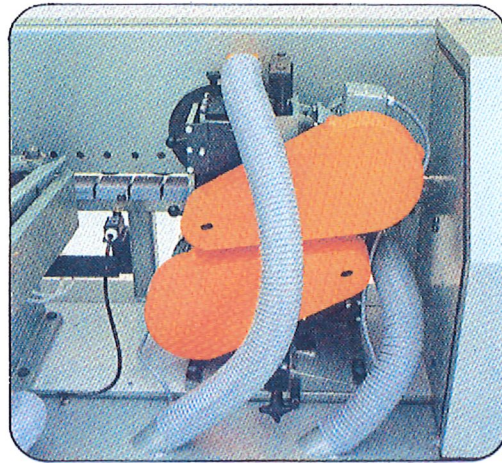
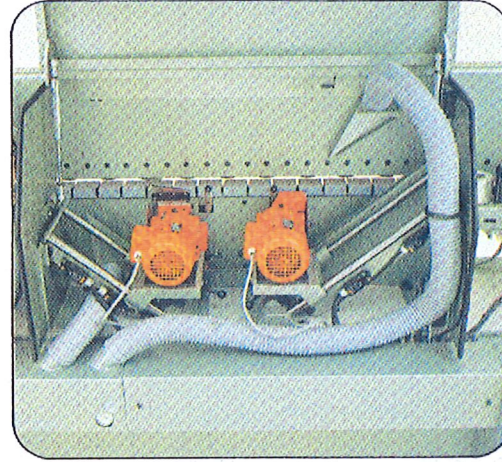
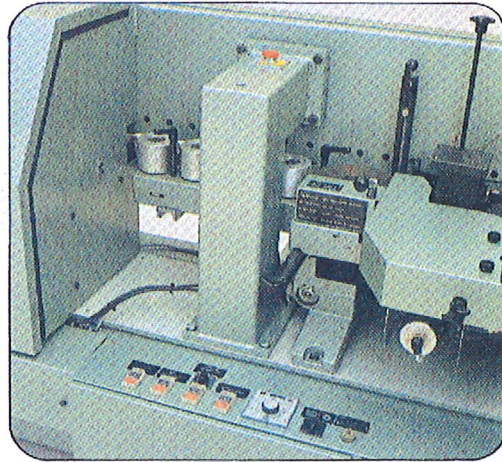
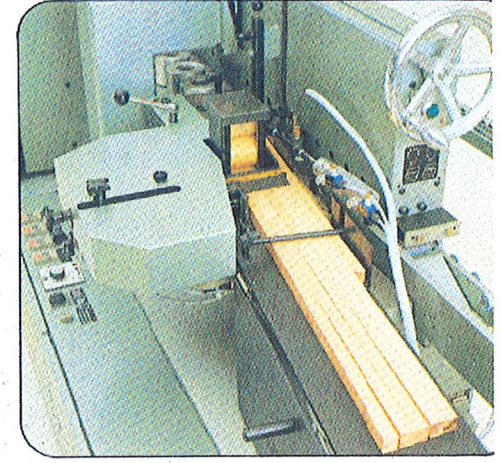
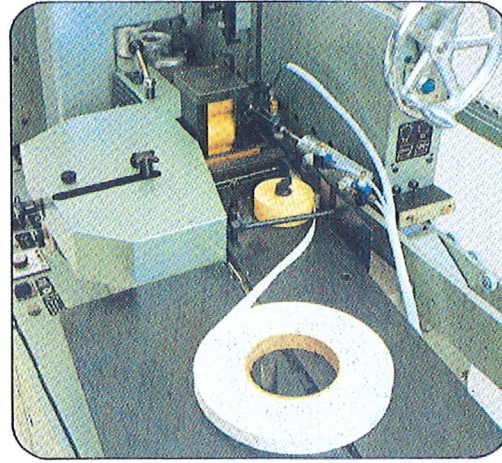
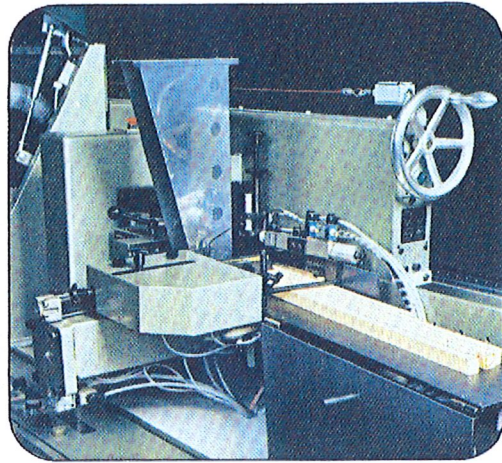
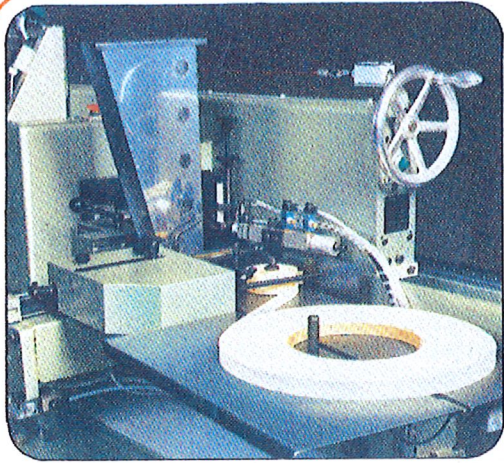
The setting of the pressure section is done instantly, just by means of a lever, with the effect that either the first pressure roller or the remaining ones are fixed radially (without springing). These features avoid the breaking of edgestrip material (even with Melamine strips).

Below: the control panels.

The flush trimming unit is adjusted automatically with the pressure beam, by means of the handwheel.

The end trimming unit can cut the projecting edgestrip as desired, at front and rear, or at front only, or at rear only. By swivelling the unit you can trim the angles up to 10 degrees.

The sanding station, like the flush trimming unit, can, if required, be replaced by other work stations, such as a superfinish unit or a grooving unit.
(only 1410).



You may choose from a noise reducing hood, which encloses the end trimming and the flush trimming units (reducing the noise level of only 79 dBA), or, a safety guard hood (illustrated here) for the end trimming unit. Insurance companies recommend that either one of these hoods be used.

Consider these points:

- › Our after-sales service is always at your disposal.
- › All our machines are designed to cope with maximum workloads.
- › Purchase price is not the only factor to be considered, just as important are long service life, reliability and a high resale value...
- › Up until now, over 7000 customers have considered these points and have chosen a HOLZ-HER edge banding machine.

Model 1408 – The most important technical data

Machine dimensions:	
Length	4400 mm
Depth	900 mm
	1400 mm with support track extended
Height	1400 mm
Workpiece feed-in height	850 mm
Mode of operation	
hot-cold method, single side (left-hand)	
Working dimensions	
Edgestrip thickness	0.4 to 20 mm with flush trimmer and end trimmer; up to 25 mm when gluing only
Edgestrip height	max. 66 mm
Edgestrip length	min. 200 mm
	min. 350 mm with automatic edgestrip feed
Edgestrip projection	vertically max. 5 mm each face
Workpiece width	min. 60 mm
Workpiece thickness	at feed speed 15 m/min up to 30 mm at feed speed 11 m/min up to 44 mm at feed speed 8 m/min up to 60 mm
Workpiece length	min. 140 mm unlimited with workpieces up to 40 mm thick; 40 to 60 mm thick, approx. 4000 mm max.; determined by automatic cartridge-changing, etc.
Feed	
Motor rating	2.2 kW
Speeds	15, 11 and 8 m/min
Glue application – Cartridge System	
Heating	1.9 kW
Temperature control	via temperature selector control
Glue application	via flat nozzle with electro-pneumatic control
Glue cartridges	63 x 80 mm dia.
Cartridge magazine capacity	4 cartridges, approx. 1.4 kg
Glue application – Granulate System	
Heating	3.8 kW
Temperature control	via temperature selector control
Glue application	via flat nozzle
Granulate reservoir capacity	approx. 4 kg
Pressure mechanism	Adjustable according to scale, first roller driven. Adjustable for thick and thin edgestrips via selector lever.
End trimming unit	
Edgestrip thickness	up to 20 mm
Motor power	2 x 0.55 kW
TCT sawblade	dia. 160 x 30 x 3.2 mm
Rotary speed	5500 rev/min
Flush trimming unit	
	2 x 1.1 kW
Sanding unit	
	1.75 kW
Buffing unit	
	2 x 0.25 kW
Power consumption	
Connection load	approx. 7.4 kW with full equipment (with cartridge system)
Compressed air connexion	6 bar
Connector	R 3/8"
Air consumption of extractor	2000 m ³ /h at 6 mbar dyn. press.
Connector	160 mm dia.
Standard accessories	
Set of spanners, operating instructions with spare parts list, 6 glue cartridges (EVA base, natural), or 2 kg glue granulate.	
Special accessories	
Safety or noise reducing hood, counter-pressure rail, extra-long register fence.	

Model 1410 – The most important technical data

Machine dimensions:	
Length	5000 mm
Depth	900 mm
	1400 mm with support track extended
Height	1400 mm
Workpiece feed-in height	850 mm
Mode of operation	
hot-cold method, single side (left-hand)	
Working dimensions	
Edgestrip thickness	0.4 to 20 mm with flush trimmer and end trimmer; up to 25 mm when gluing only
Edgestrip height	max. 66 mm
Edgestrip length	min. 200 mm
	min. 350 mm with automatic edgestrip feed
Edgestrip projection	vertically max. 5 mm each face
Workpiece width	min. 60 mm
Workpiece thickness	at feed speed 15 m/min up to 30 mm at feed speed 11 m/min up to 44 mm at feed speed 8 m/min up to 60 mm
Workpiece length	min. 140 mm unlimited with workpieces up to 40 mm thick; 40 to 60 mm thick, approx. 4000 mm max.; determined by automatic cartridge-changing, etc.
Feed	
Motor rating	2.2 kW
Speeds	15, 11 and 8 m/min
Glue application – Cartridge System	
Heating	1.9 kW
Temperature control	via temperature selector control
Glue application	via flat nozzle with electro-pneumatic control
Glue cartridges	63 x 80 mm dia.
Cartridge magazine capacity	4 cartridges, approx. 1.4 kg
Glue application – Granulate System	
Heating	3.8 kW
Temperature control	via temperature selector control
Glue application	via flat nozzle
Granulate reservoir capacity	approx. 4 kg
Pressure mechanism	Adjustable according to scale, first roller driven. Adjustable for thick and thin edgestrips via selector lever.
End trimming unit	
Edgestrip thickness	up to 20 mm
Motor power	2 x 0.55 kW
TCT sawblade	dia. 160 x 30 x 3.2 mm
Rotary speed	5500 rev/min
Flush trimming unit	
	2 x 1.1 kW
Sanding unit	
	1.75 kW
Buffing unit	
	2 x 0.25 kW
Power consumption	
Connection load	approx. 10 kW with full equipment (with cartridge system)
Compressed air connexion	6 bar
Connector	R 3/8"
Air consumption of extractor	2000 m ³ /h at 6 mbar dyn. press.
Connector	160 mm dia.
Standard accessories	
Set of spanners, operating instructions with spare parts list, 6 glue cartridges (EVA base, natural), or 2 kg glue granulate.	
Special accessories	
Safety or noise reducing hood, counter-pressure rail, extra-long register fence.	

Technical Data are given as approximate values. We reserve the right to introduce changes, as our HOLZ-HER machines undergo constant development; hence illustrations are not binding, either.

