

Superior Technology – outstanding Design

CONTRIGA INDUSTRY



PRODUCTIVITY AND PRECISION



Modular, multifunctional, maximum Performance

The CONTRIGA series is a future-oriented milestone for edgebanders. It has been designed for absolute maximum performance. For its charismatic design and choice of new materials, it received the internationally renowned red dot design award, as well as the IF product design award. One outstanding feature is the pneumatically controlled hoods. Compared to conventional hoods, this design takes up much less space.

The CONTRIGA is highly flexible, allowing perfect adaptation to your specific requirements. Up to 60 NC servo-axes move your high performance units to the specific machining position at the touch of a button.

ECO Mode

Intelligent energy management for HOLZ-HER edgebanders.

SYNCHRO

For short intervals between workpieces and optimized edge protrusions.



Illustrations may contain optional features.

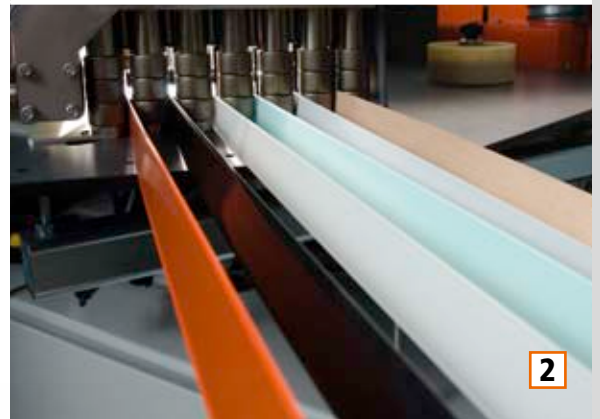
Simple Handling – high Productivity

■ Guide System

For optimum guidance of narrow parts. The guide system moves along with the workpiece at a 90 degree angle right up to secure transfer to the machine (optional) (Fig. 1).

■ 6-Position Edge Feeder

New with sensor for recognition of remaining length and automatic change-over to alternative edging channel. Including auxiliary channel for feeding in cut-length edging strips (optional) (Fig. 2).



The elegant, space-saving push-up hoods are pneumatically controlled as a standard feature.

High Standards guarantee your Investment for the Future

The HOLZ-HER Edge Control provides extremely high performance and is exemplary for its simple operation. A high-end industrial PC with generous features is included. Set-up and conversion of the machine has never been so rational.

Monitor

- 15" Touch screen PPC 231 as a standard feature.
- Graphic user interface, all information displayed in plain text and/or graphic form.
- Simple operation – rotating and swiveling control panel at eye height (Fig. 1 top right).

Program List

- Programs are simple to call with program names and numbers.
- Large program memory for all desired applications.
- Individual selection of units with the functions as basic setting possibilities for nominal values, path points and tool corrections.
- Set-up processes for units and their axis settings carried out centrally and clearly by fine adjustment with accuracy of 1/100 mm (depending on equipment).

Integrated Path Control

- Interval display for shortest interval between workpieces.
- Path points are controlled generally or in a program-specific manner.
- Clear and complete acquisition of all operating data: Total running meters, total quantity, total hours as well as running meters, quantity and time per program with reset function.
- Service reports in clear text.
- Integrated synchronous bus system for maximum unit control accuracy in controlling the units.
- Individual management for up to ten users with password protection and individual authorization.



Equipment / Service

- Network connectivity.
- Online maintenance (optional), rapid exchange of data with HOLZ-HER service department.
- Barcode interface (optional).
- Connection to HOLZ-HER process data management (HHPDE) system for direct read-out of operating data.

Electronically controlled Set-Up Processes with Accuracy of 1 / 100 mm

PPC 231 Edge Control with 15" Touch screen.

1

Highly efficient Production in combination with other HOLZ-HER Machines Programming – Sawing – Edgebanding – CNC Machining

CabinetControl (1)

- Carcass furniture at the click of the mouse.
- Automatic generation of cutting lists and CNC programs

Perfect Data Flow (4)

- Program information also via data matrix barcode.

Rational and precision Sawing (2)

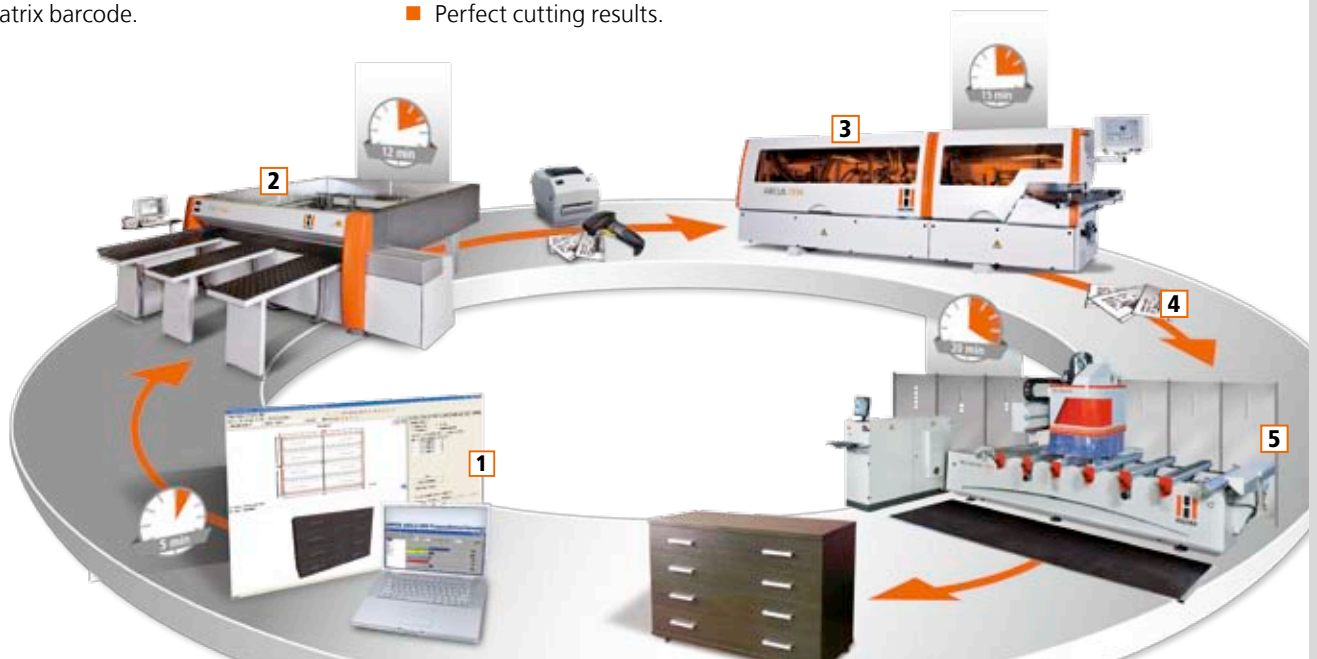
- Perfect cutting results.
- Mature optimization software.
- Optimum sawing cycle.

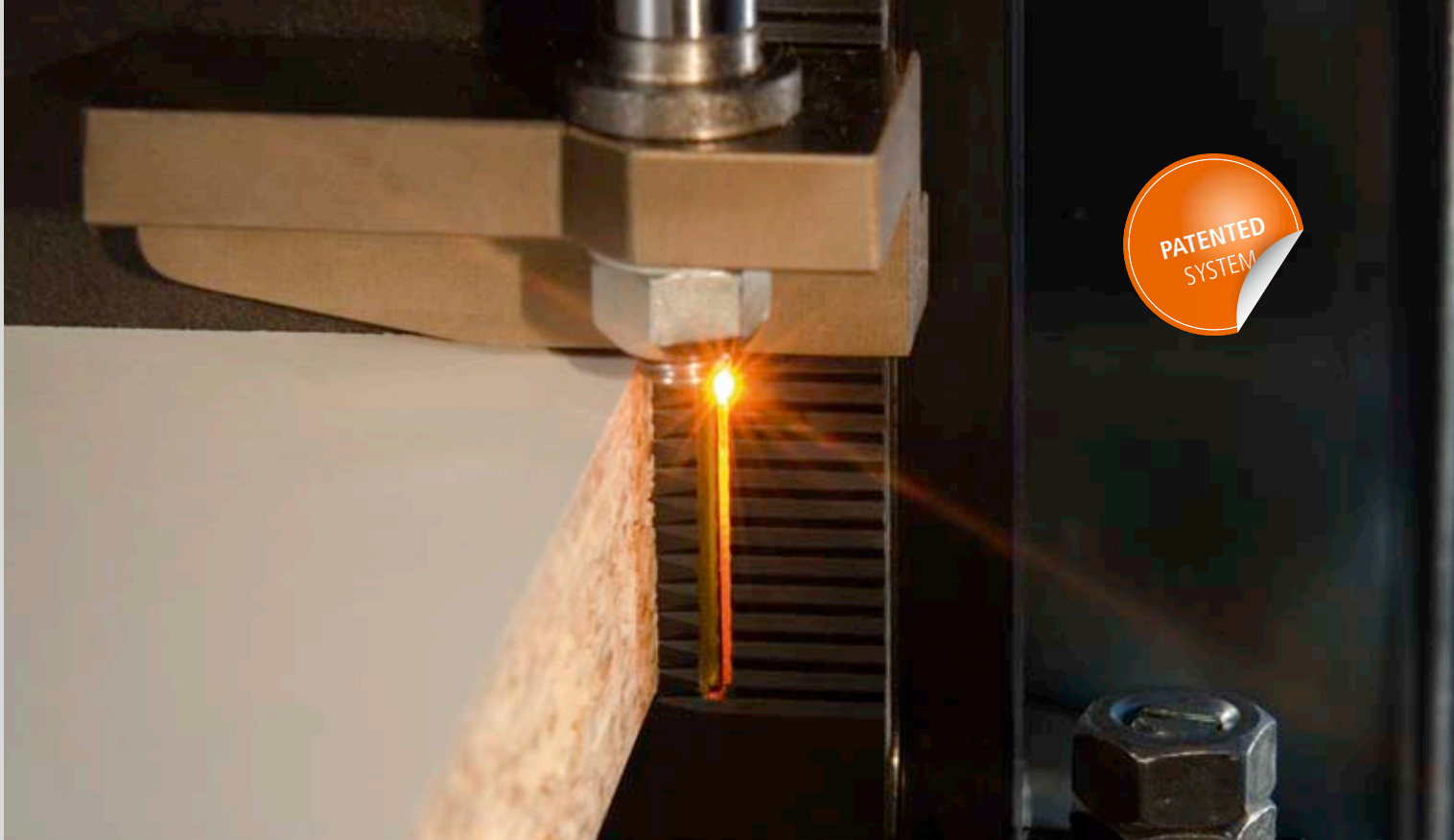
Effective CNC Performance (5)

- Automatic program call with barcode.
- Variable programming with CAMPUS Software.
- Perfect cutting results.

Intelligent Edgebanding (3)

- Program selection at the press of a button.
- Alternative: fully automatic with barcode.





GLUE APPLICATION SYSTEM

Hybrid Technology – two perfectly combined Systems

The edgebander is decisive for furniture with a high quality appearance. You can also profit from 45 years of HOLZ-HER technological leadership in edgebanding.

- Change over from colored to neutral glue at the flick of the wrist.
- Cartridge or granular form (Figs. 1 and 2) – the glue can be changed over in a few minutes.
- Changeover from EVA to PUR glue is also possible within the shortest time.
- And the entire system can also be completely cleaned in just a few minutes.



Heat-up Time only 3 Minutes

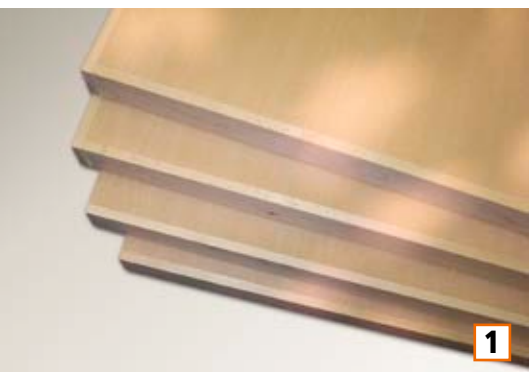
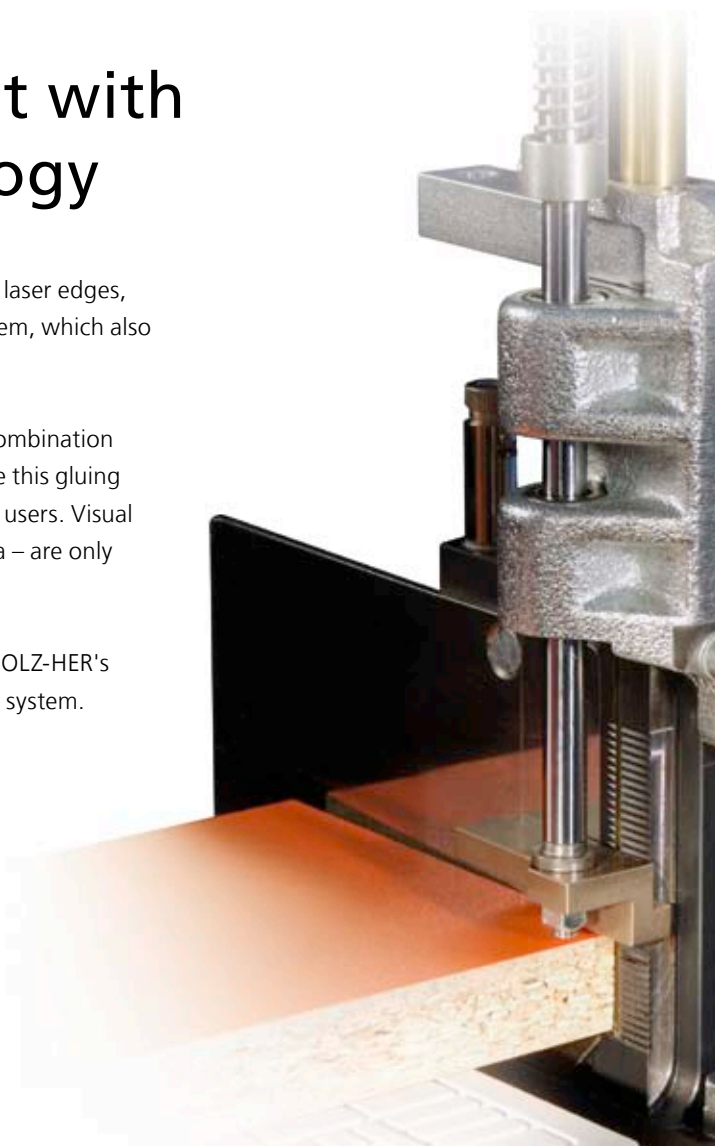


Glu Jet – Zero Joint with thin Film Technology

Ultra-thin glue joints, easily equivalent to industrial laser edges, are easy to achieve with the HOLZ-HER **Glu Jet** system, which also offers unrivaled flexibility.

The clear advantages of the hybrid technology in combination with the new HOLZ-HER thin film technology, make this gluing system the all-rounder for craftsmen and industrial users. Visual zero joints with PUR glue – allowing use in wet area – are only natural for HOLZ-HER customers.

Reliability, quality and experience – backed up by HOLZ-HER's three year guarantee on its patented **Glu Jet** nozzle system.

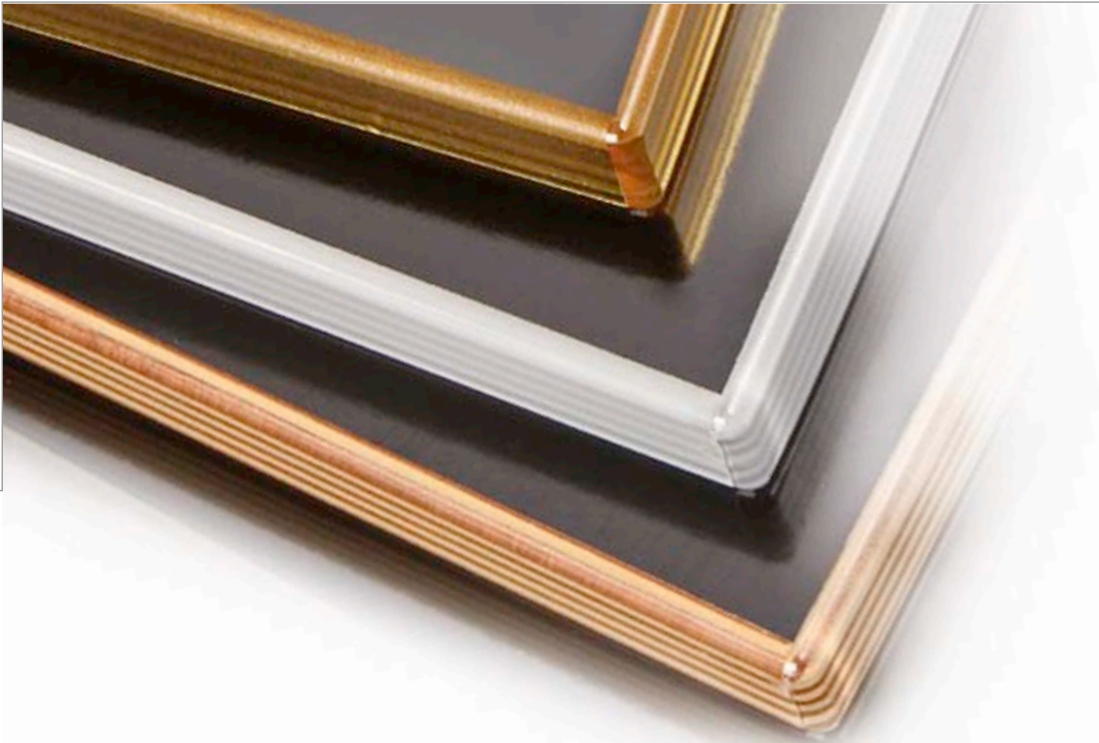


Superior Appearance on all Materials

Starting with the state-of-the-art high gloss edging right up to solid wood edging with cross section of 30 x 65 mm, HOLZ-HER remains unequalled for variety.

HOLZ-HER sets the trends for tomorrow today.

- Solid wood edging (Fig. 1)
- Veneer edging
- Plastic edging (Fig. 2)
- Aluminum edging
- Formica edging
- Melamine edging
- and many others



Perfect attachment of various edging materials.

High Tech for Perfect Edges

Over 50 high performance units are available to adapt your CONTRIGA exactly to your work profile. Every one of these units is laid out for high continuous stress. Pneumatic and motor-controlled versions are available for a series of units. Thus there are almost no limits to the performance spectrum for edgebanding



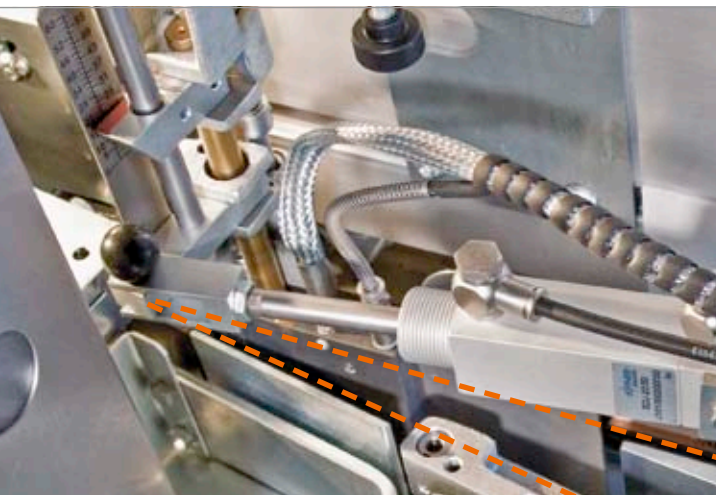
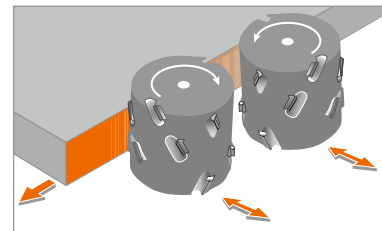
Clean Joints and Finishing on High Gloss Edging





Premilling

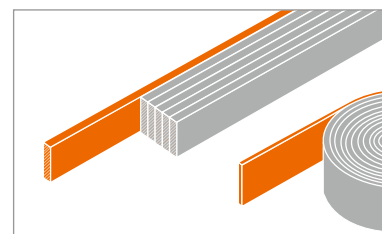
With new symmetrical diamond cutters (Ø 100 mm) for maximum joint quality and long service life. Automatic height adjustment with two NC servo-axes (optional).



Edge Feeder SYNCHRO

The new edge feeder with SYNCHRO drive. The new Synchro magazine with its synchronous adaptation to the feed speed guarantees short intervals between workpieces and simultaneously optimizes edging protrusions.

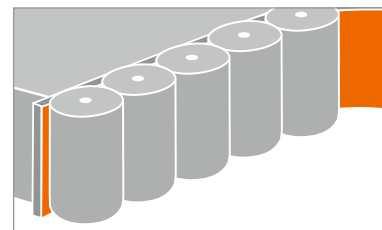
Small feed angle thanks to nozzle design – easy feeding of solid wood edging



Motor-Driven Pressure Unit

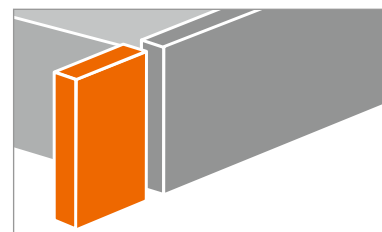
Synchronously driven pressure unit with automatic adaptation to feed speed and NC servo-axes for motor-driven adjustment to correct edge thickness.

Straight and conical pressure rollers for perfectly glued joints.

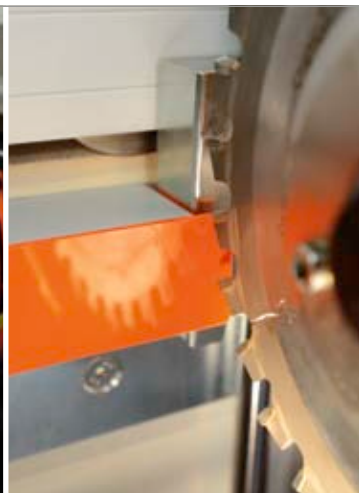
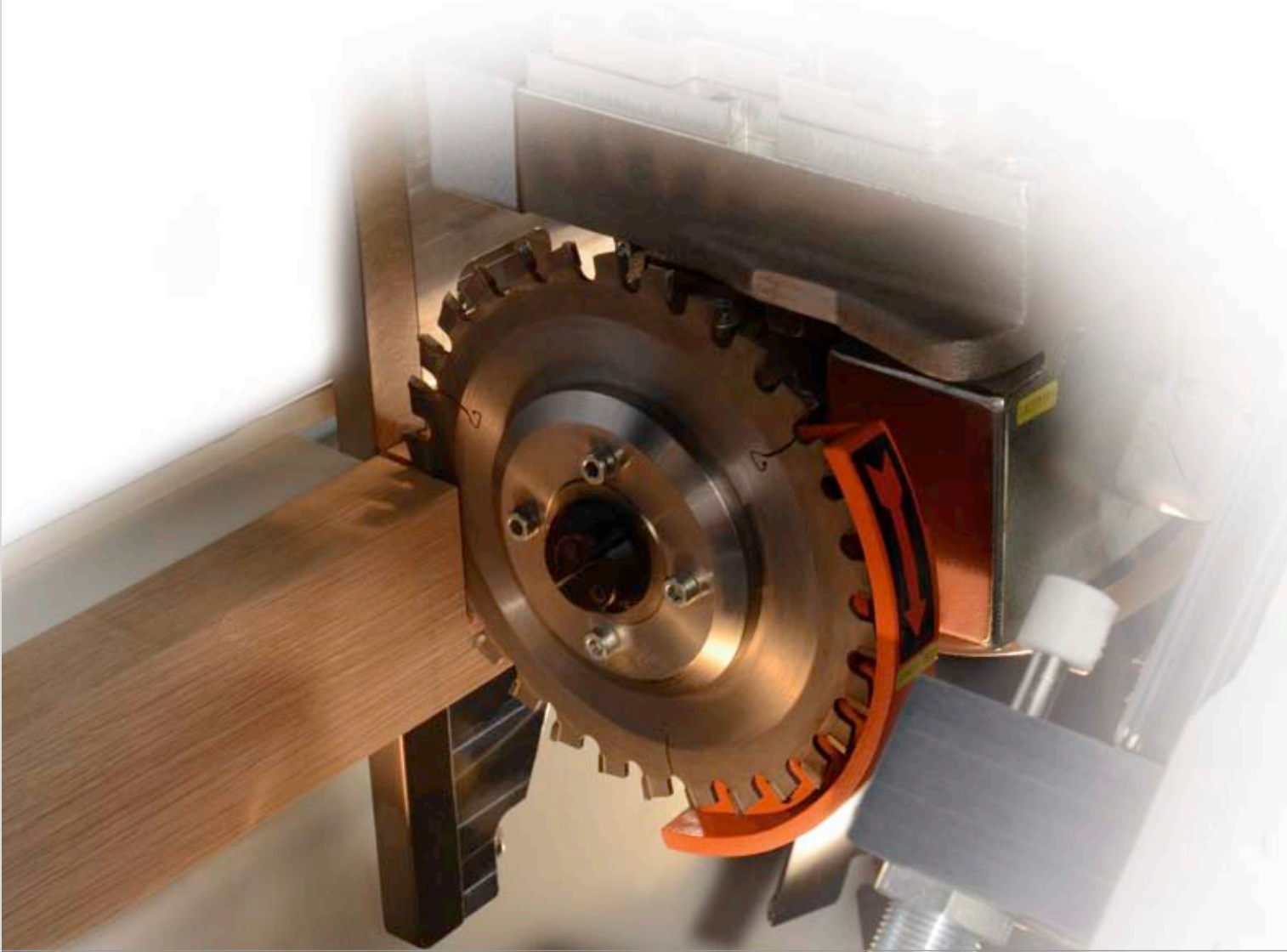


End Trimming Unit

For workpieces with thicknesses up to 80 mm (optional). Now with hardened linear guides for high precision end trimming results for edge thicknesses up to 20 mm.

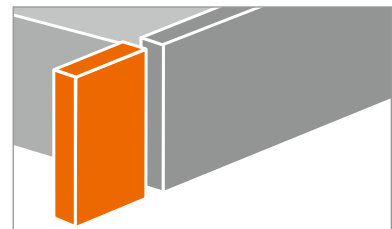


Most powerful End Trimming Unit in its class – edging cross section 30 x 65 mm



High Gloss Touch

The articulated mount on the sensing shoe effectively prevents scratching the sensitive surface of the edging. Particularly recommendable for state-of-the-art high gloss edging (optional).

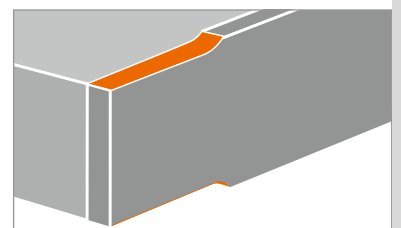


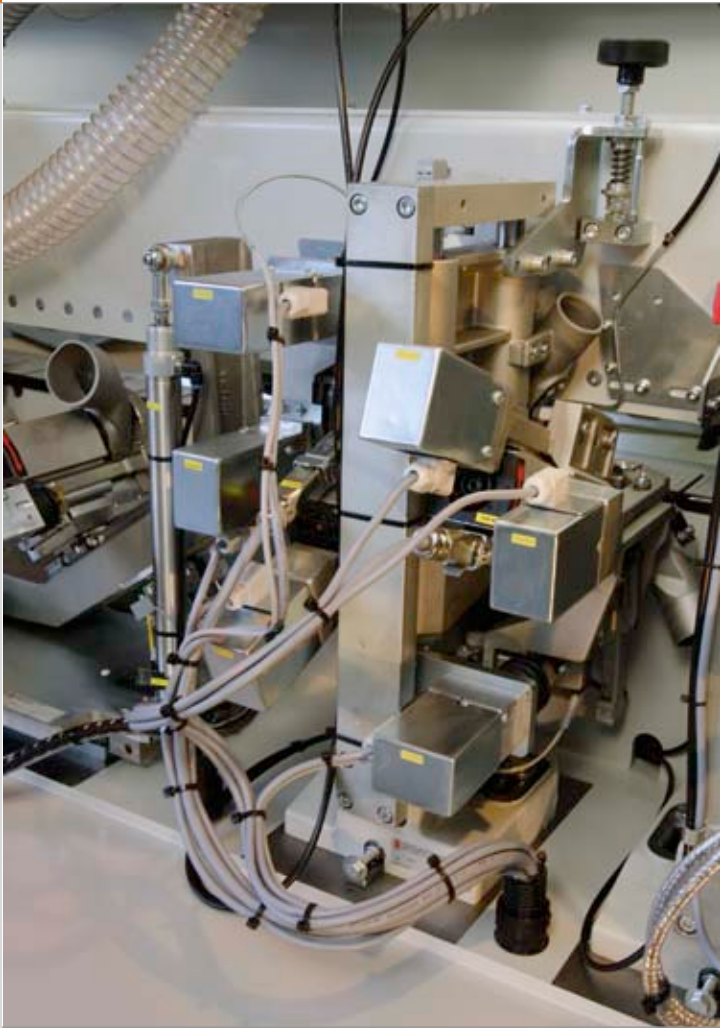
Convincing Cutting Results up to Edge Thickness of 30 mm



Flush Cutting Unit

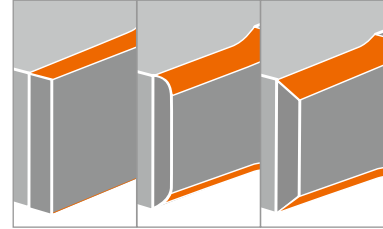
High performance cutting unit for edge thicknesses up to 30 mm. Three NC servo-axes for cutting workpieces with and without protruding edging, as well as motor-driven horizontal adjustment for optimal cutter utilization (optional).





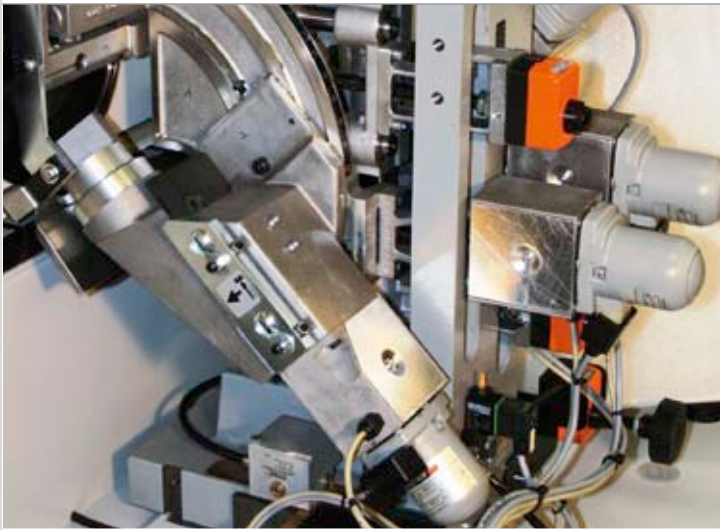
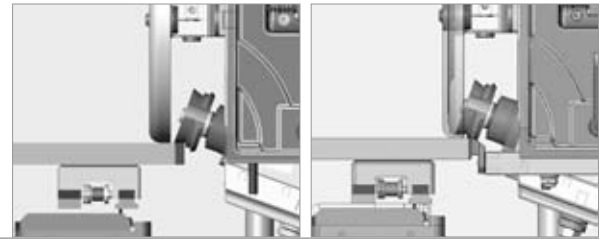
Multi-function Cutter Unit with 6 NC Servo-Axes

For flush, radius and bezel cuts including permanently installed diamond tool with chip-optimized CM technology. Fully automatic control with 6 NC servo-axes.



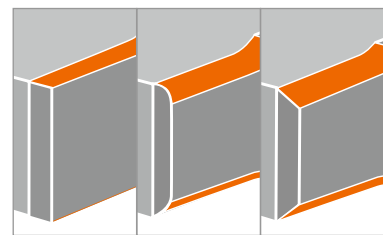
Multi-function Cutting Technique at highest Level

Copying near the joint and moving fully automatically with multi-function tools - perfectly combined with HOLZ-HER cutting technology.



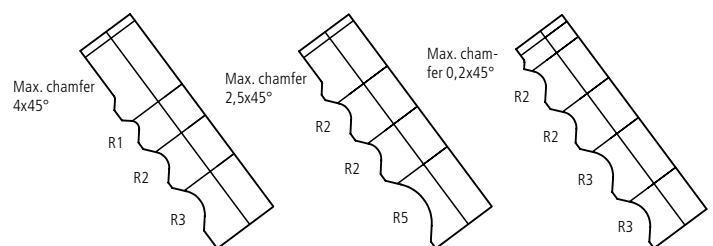
Multi-function Cutter Unit with 7 NC Servo-Axes

For processing various radiuses, chamfers and flush cutting. Fully automatic control with 7 NC servo-axes.



Varying Profiles

The perfect tool for every application. Select from 41 possible profiles.

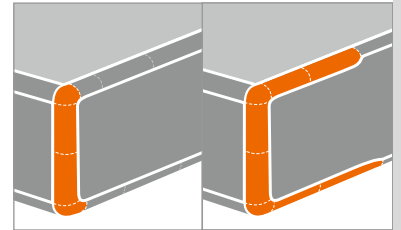


Tool axis 45°



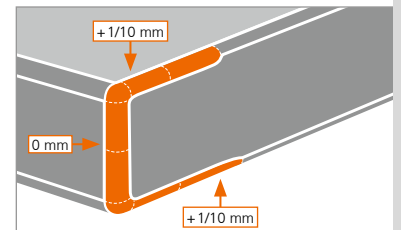
Profile Cutter Unit with 2 Motors

Profile cutter unit for corner copying. Machining with two cutter motors for a wide variety of postforming profiles. Standard equipment includes four NC servo-axes as well as two diamond cutters with CM technology and ProLock quick change chuck. Maximum workpiece thickness 60 mm.



■ Pendulum Sensor

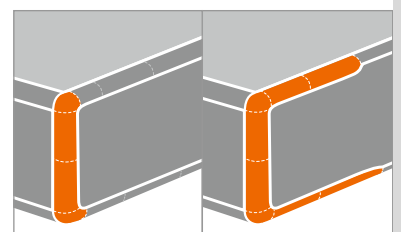
Automatic pendulum sensor copies ends without material protrusion, leaving the optimum edge protrusion for the longitudinal edges for the next machining step with radius scraper.

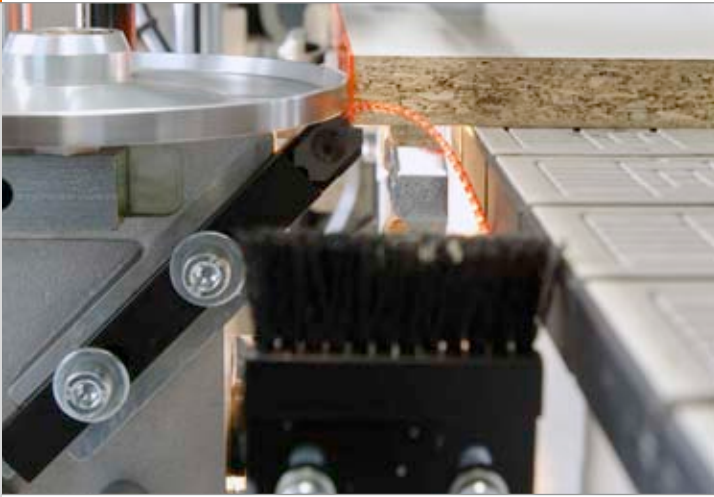


Profile Cutter Unit with 4 Motors

Profile cutter unit for corner copying with four cutting motors for tear-free machining of solid wood edging as well as a wide variety of postforming profiles. Standard equipment includes four diamond cutters with CM technology and ProLock quick clamping function. Maximum workpiece thickness 50 mm – optional up to 60 mm.

Maximum automation with 6 NC servo-axes.

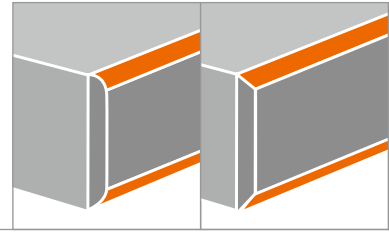




Scraper Unit

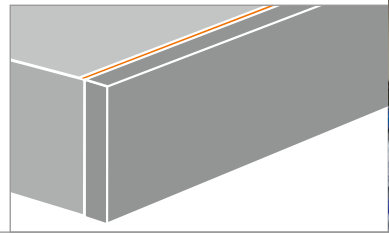
Heavy duty vertical unit – motor-driven horizontal adjustment with NC servo-axes – accuracy in 1/100 mm range. Also available as fully automatic version with five motor-driven adjustment axes (optional).

Motor-adjustable scraper for optimum adaptation to existing edging tolerances.



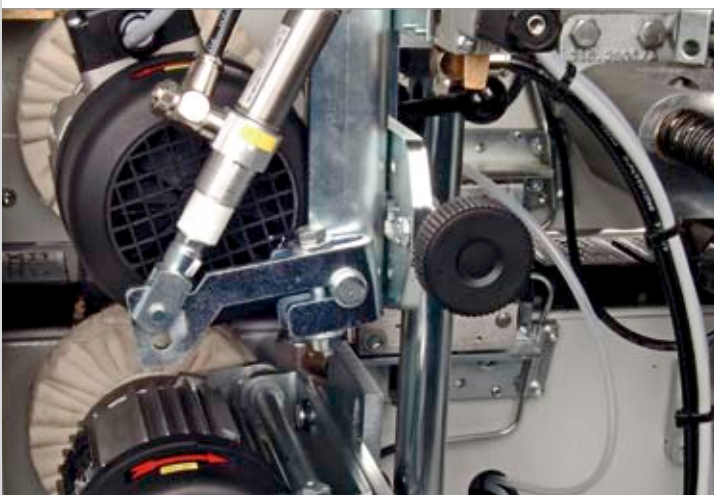
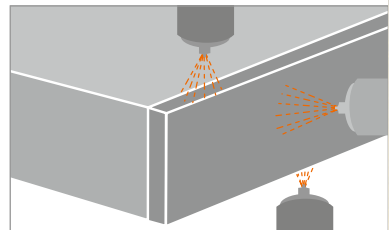
Glue Scraper

Clean surface finishing – application controlled with two HW reversible blades usable on four sides – eliminates manual finishing.



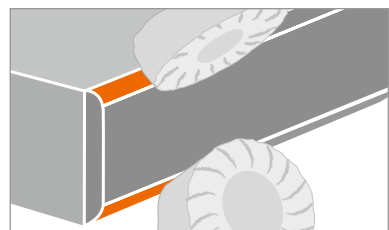
Spraying Devices

Spraying units for parting agents and cleaning agents for entry and finishing area. Anti-static, coolant and lubricant – electronically controlled by special nozzles – for a perfect edge finishing. The various fluid reservoirs are all integrated cleanly into the machine frame.



Buffing Units

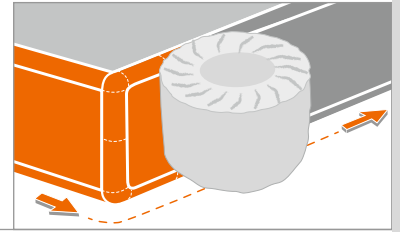
The buffing units serve for final finishing on edges and flat surfaces. Application controlled and alternatively oscillating.





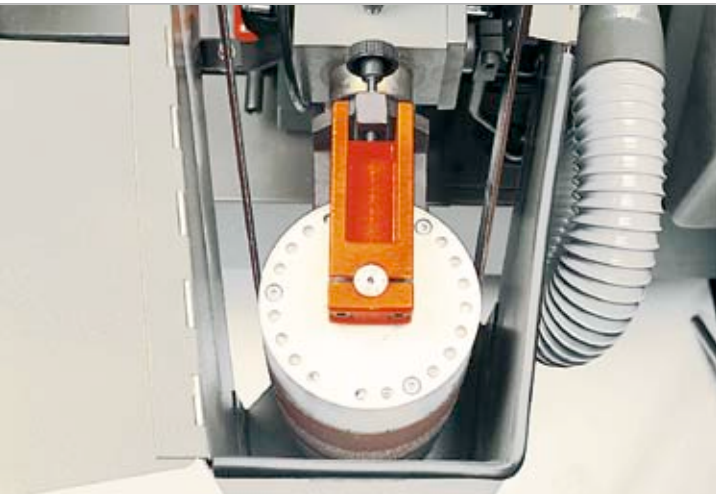
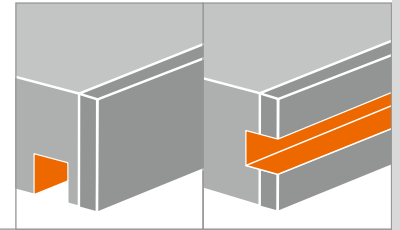
Corner Buffing Unit

For a perfect finishing on edging ends. Completely eliminates all manual finishing. Including plunge control and motor-driven horizontal adjustment via NC servo-axes.



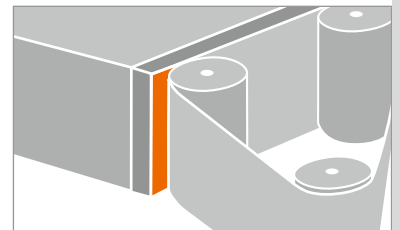
Grooving Unit

Optimum chip collection with grooves running in opposite direction. With two NC servo-axis for groove depth adjustment as well as groove position above control panel as a standard feature. Pivots 0–90 degrees including grid holes at increments of 11.25 degrees. Including plunge control.



Oscillating Sanding

Oscillating sanding unit with NC servo-axis for overall horizontal control as well as for motor-driven downfeed to increase sanding pressure. The perfect finishing for your solid wood or veneer edging.



➤ The CONTRIGA satisfies all machining Desires. ⏪

Perfectly equipped down to the last Detail

■ Air Cushion Table

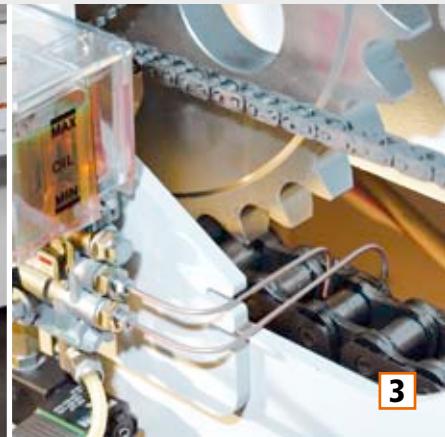
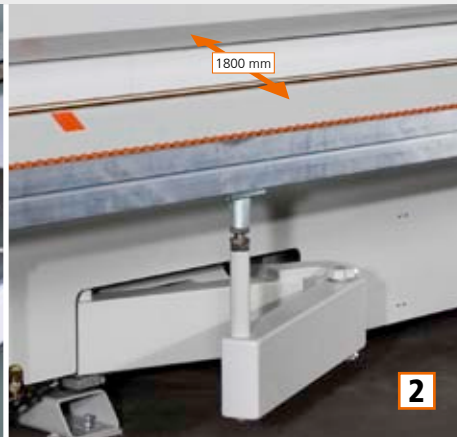
For easy and careful handling – even with bulky workpieces (optional) (Fig 1).

■ Workpiece Support

Extremely stable pull-out workpiece support completely self-supporting so that floor irregularities have no affect. With optional extension widths up to 2,600 mm (Fig. 2).

■ Transport Chain Lubrication

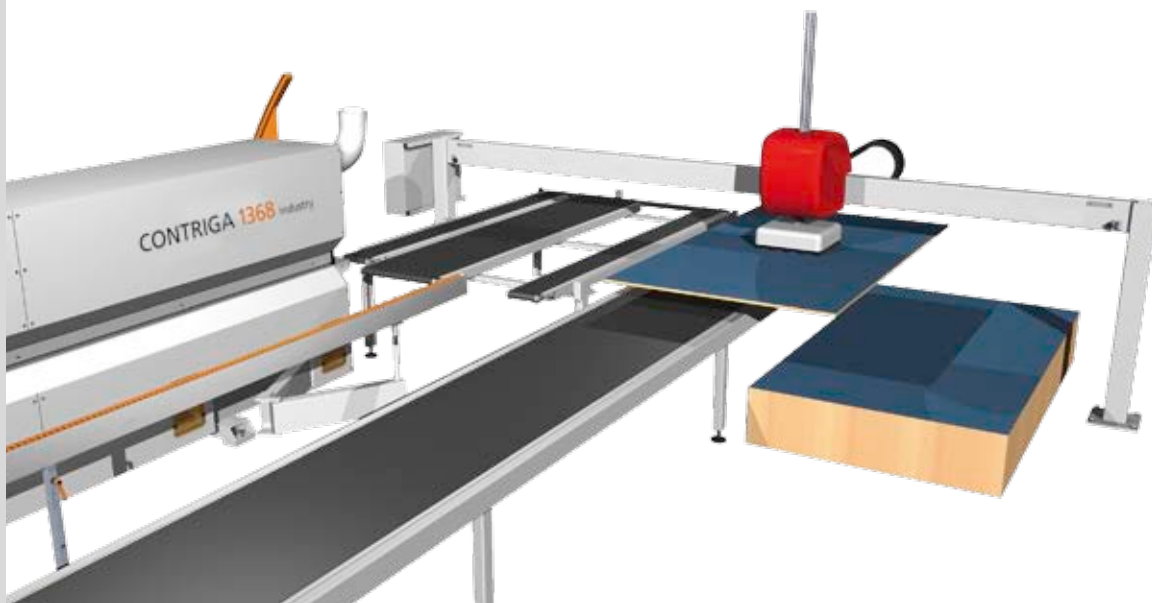
Intelligent automatic transport chain lubrication. Sensor-controlled unit, for metering lubricate to match load. Moreover an automatic injection oiler lubricates all joints and bolts (Fig. 3).



CONTRIGA HIGHLIGHTS

Intelligent Return System for HOLZ-HER Edgebanders

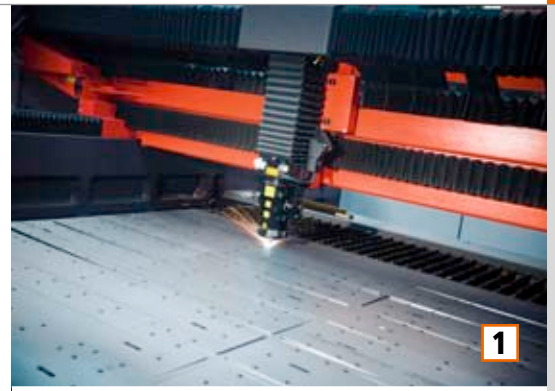
- With 90°/180° rotation
- Stacking and nesting
- For increased efficiency



Autonomous Quality – from Steel Plate to complete Machine

- Up to 1,600 tons of steel and aluminum are used in HOLZ-HER's own frame construction. A laser cutting unit with fully automatic charging optimizes cutting steel plates with thicknesses up to 25 mm. These material thicknesses are reflected on the CONTRIGA in all design parts relevant for rigidity (Fig. 1).
- With a nominal pressing force of 400 tons, multiple hydraulic trimming presses ensure perfect component shape with automatic materials thickness measurement and pressure control (Fig. 2).
- The individual parts are welded together very carefully. Optimally designed welding equipment ensures high quality consistency for your machine (Fig. 3).
- The completely welded frames are milled with high precision on a number of long-bed cutting machines. This ensures that all surfaces are optimally prepared for later attachment of guides and units (Fig. 4).
- After cleaning and painting, the frames are moved to final assembly, where all units and components are installed.

Before packing and shipment, comprehensive final inspection is performed to guarantee highest quality standards of your CONTRIGA machine under load (Fig. 5).



1



2



3



4



5



Engineering Perfection made in Germany

Our engineers number among the world's best. Their visionary imagination and exceptional skill guarantee that our machines are the highest performance, most flexible and safest in the world today.

Made in Germany stands for German quality, for brilliant engineering, for solid design and high quality production.

For nearly 100 years HOLZ-HER has endorsed this quality symbol in the service of its customers.

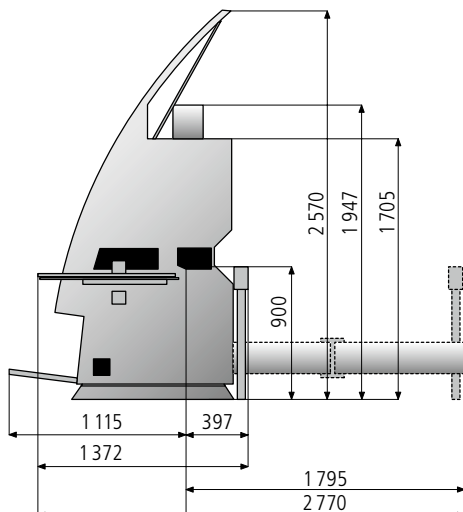
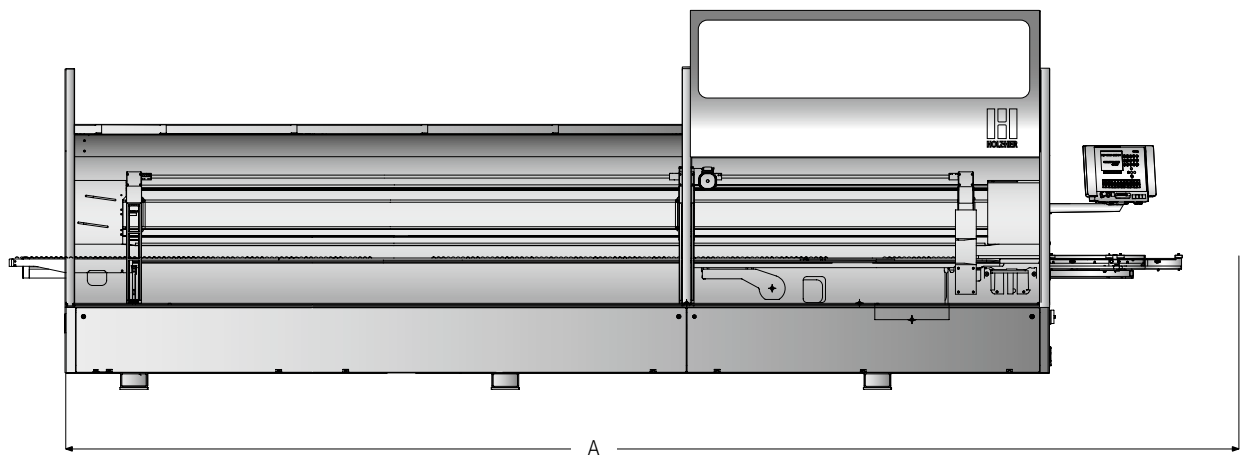
In addition to state-of-the-art technologies, we use modern CAD aids to ensure that we can also offer you affordable high tech machines made in Germany in the future as well.



TECHNICAL DATA

	CONTRIGA 1364	CONTRIGA 1366	CONTRIGA 1368	CONTRIGA 1370
Machine dimensions				
Overall length A (mm)	6698	8432	9792	10952
Weight (kg)	4350	5020	5890	6680
Feed speed				
Feed speed (m/min)	10 – 30*	10 – 30*	10 – 30*	10 – 30*
Working dimensions				
Minimum workpiece length (mm)	140	140	140	140
Minimum workpiece width (mm)	60	60	60	60
Workpiece thickness (mm)	6 – 60 (80)	6 – 60 (80)	6 – 60 (80)	6 – 60 (80)
Edging thickness (mm)	0.4 – 30	0.4 – 30	0.4 – 30	0.4 – 30

* depending on equipment



The CONTRIGA series is available in four length versions, allowing combination with module units for configuration of custom tailored, high performance edgebanders to meet every demand and for virtually all space requirements.

Product brochures and many
videos are available at
www.holzher.com



The technical data specified is intended for reference only. HOLZ-HER woodworking machines are subject to constant development and are therefore subject to modification without prior notice. The illustrations are therefore not binding. Some of the machines shown also contain special equipment not included as a standard feature. For clarity, some of the machines are shown without protective hood.

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