

Material in motion



Handling

Version 2015/1

Perfectly matched: HOLZMA handling systems

One of your most important, and at the same time most expensive, resources is your personnel. Therefore, you will want to deploy each employee as efficiently as possible. HOLZMA handling systems help you in doing so. We offer intelligent processes that allow you to feed the saw on time, to transport sensitive material gently and later destack everything in an orderly manner – or to send it straight on to the next processing station. Our aim is to eliminate idle time throughout your entire production process. This allows you to save time, reduce unit costs and, on top of that, you can deploy your saw operator elsewhere.



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Feeding with HOLZMA

HOLZMA offers a variety of solutions for feeding the machine from the rear. These include, for example, push-feed systems, combinations of push-feed and vacuum-feed systems and purely vacuum-feed systems. In addition, the Econolift assists you in feeding the saw from the front. Furthermore, HOLZMA also designs larger, custom handling systems, complete with intelligent storage concepts, if desired. Here, HOLZMA works closely with sister company HOMAG Automation.



Feeding from the rear:
Easy2Feed



Custom industrial feeding system



Feeding from the rear: storage system



Feeding from the rear:
two-tier roller conveyor



Feeding from the front:
Econolift



Feeding from the rear:
protects sensitive material



Feeding from the rear:
profiLine VAC feed carriage

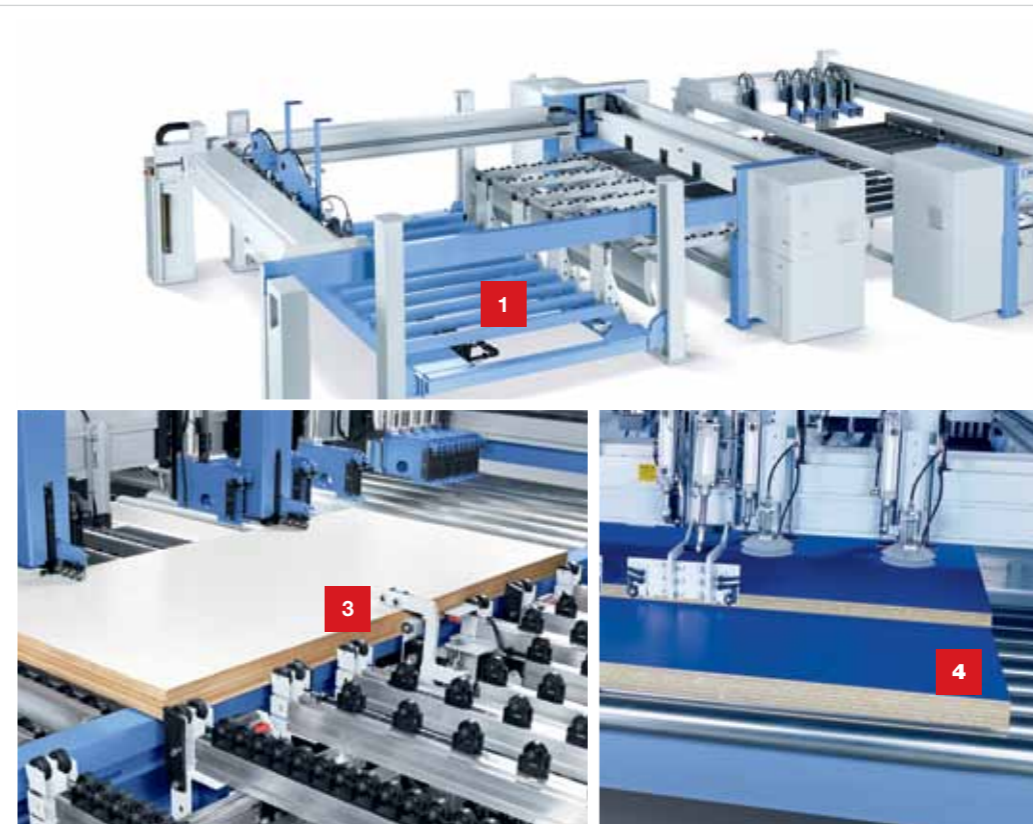
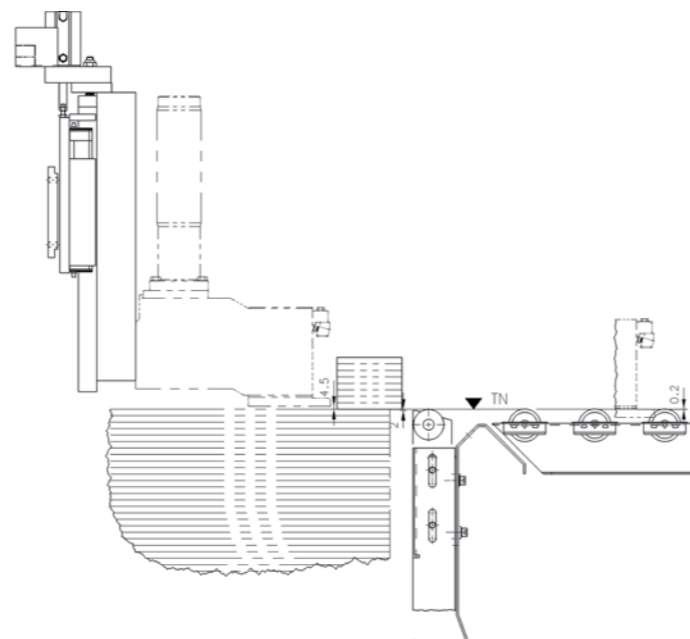
Feeding: solutions around the lifting table

Feeding via the lifting table is possible for HOLZMA single saws (HPL) and angular systems (HKL). For non-sensitive panel material, we recommend a classic push-feed system, which allows you to transport big books of panels quickly, efficiently and fully automatically to the rear machine table. HOLZMA has special solutions to offer for thin, corrugated or sensitive panels.

The many HOLZMA feeding components allow you to design a saw that will fully meet your specific requirements.

Your benefits

- You save time
- You save space
- You work ergonomically
- You increase saw output



Powerful feeding system

Feeding is performed by the 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 from 9.5 mm upwards. If equipped with the options micro-feed and hold-back device, suitable for materials from just 3 mm upwards
- Maintenance-free and no lubrication required

Workflow description (standard)

1. Stack of panels is deposited on the lifting table (forklift truck)
2. Sensing device swings down
3. Lifting table platform moves upwards
4. Measuring process begins, using the sensing device
5. The lifting table stops when it reaches the height defined for the material to be pushed off
6. The two middle clamps then push the panels onto the machine table. The outer clamps assist in the feeding process
7. The clamps are lowered to their starting position. The open clamps then position the book against the aligning devices
8. The clamps close and position the book for the first cut

Lifting table options

HOLZMA offers a wide range of lifting table options, including:

- Standard version: sturdy rungs | 1
- Heavy-duty roller conveyor (4 t, 7 t or 10 t) with gaps for forklift trucks on the lifting table – available on request with automatically driven rollers for especially fast stack changes | 2
- Roller rails in crosswise direction enable narrow books of strips to be manually pushed up against the backing wall at the front. Furthermore,

das schonende Abschieben der untersten Platte | 3

- Powered, crosswise roller conveyor with gaps for forklift truck | 4
- Two-tier roller conveyor (7 t or 10 t) allows feeding and at the same time removal or interim storage of a stack, or remainder of a stack, that is currently not needed. The rollers of both conveyors are driven and transport the panels lengthwise to and from the lifting table | 5

On top of these, a host of other options allow you to put together your own, individual package, for example, additional rollers, special gaps for forklift trucks, pit installations, connecting pieces between roller conveyors and much more.

Separate feed carriage (not illustrated)

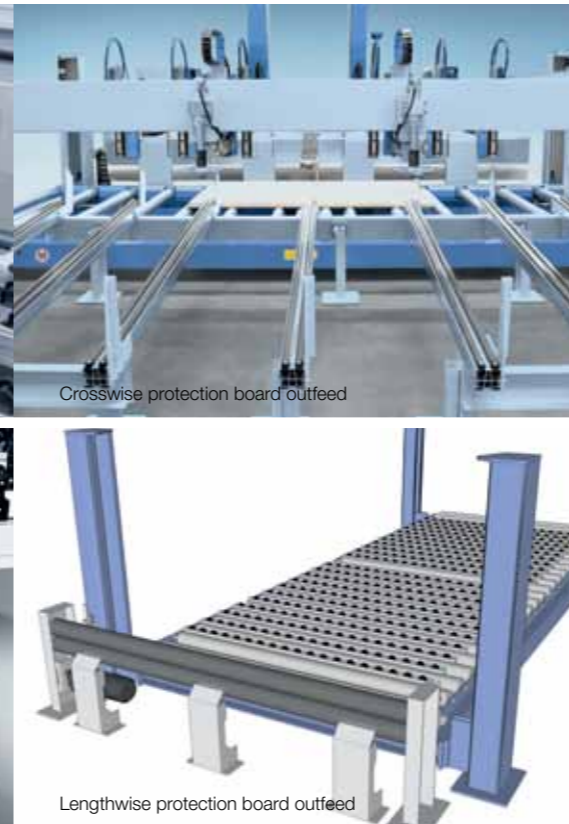
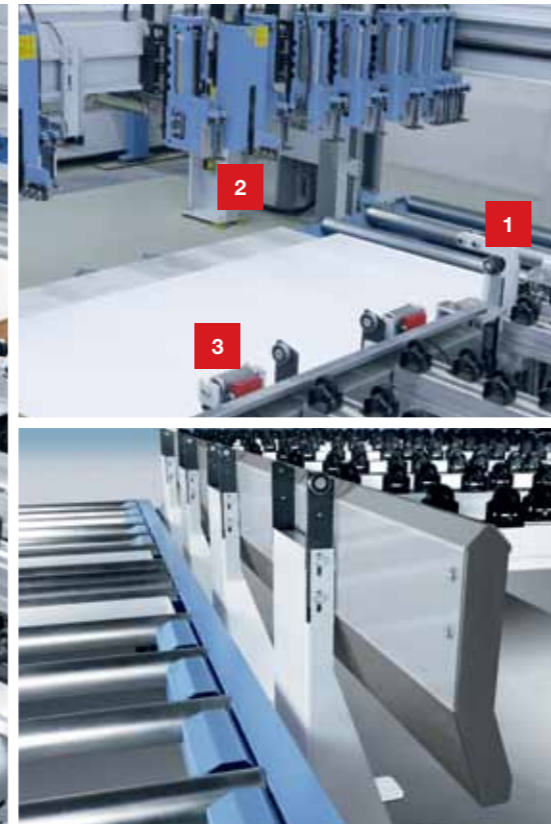
The separate feed carriage feeds the saw while the program fence is still up front at the saw, dealing with the current job. That saves a great deal of time.



Micro-feed
Video available

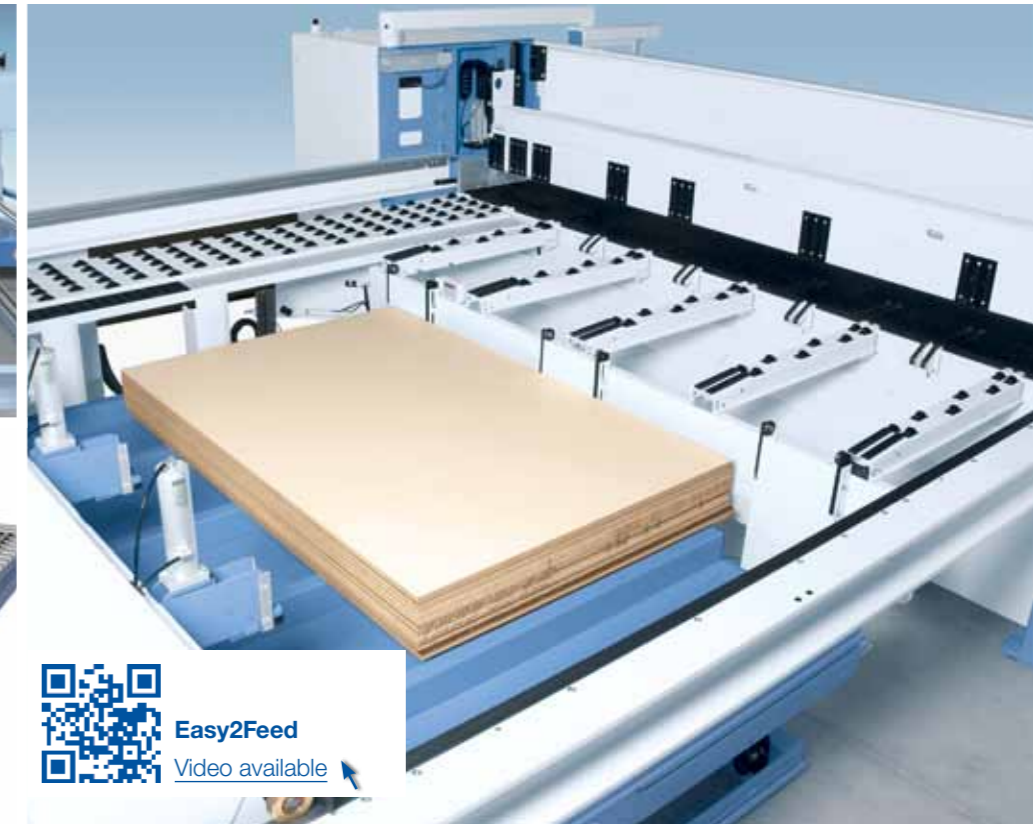


Illustration shows the principle



Crosswise protection board outfeed

Lengthwise protection board outfeed



Easy2Feed
Video available

Micro-feed and hold-back device for thin panels

The micro-feed option allows thin panels upwards of 6 mm thickness to be pushed onto the rear machine table (provided that the material properties meet HOLZMA specifications). Another HOLZMA option, the hold-back device, allows even thinner panels, upwards of just 3 mm, to be processed. This is how it works:

1. The hold-back device | 1 is raised above the book of panels and positioned at the book height that is

- to be fed. Book height is measured by a non-contact, maintenance-free, electromagnetic measuring system on the micro-feed units
2. After the measuring process, the micro-feed units | 2 push the panels under the hold-back device
3. The hold-back device moves back and the panels are pushed onto the machine table. Raisable rollers assist in this process so as to prevent the panels from sagging | 3

Separate backing wall

The heavy-duty backing wall is not attached to the machine base. Consequently, aligning books of panels up against the backing wall is no problem. Forklift truck collisions, for instance during the feeding process, have no detrimental effects on the cut quality because the lifting table and the backing wall are not directly connected with the machine. Vibrations are therefore not transferred via the roller rails to the machine body. This ensures even smoother running and precise cuts.

Protection board outfeed

The automatic protection board outfeed option allows you to transport protection boards to a storage system located at the side.

- Crosswise protection board outfeed comprises two ejector cylinders on the program fence and a protection board storage station
- Lengthwise protection board outfeed comprises a free-standing mangle roller, a top roller and a driven bottom roller

Easy2Feed

(only for right-hand versions of the HPP 200 and HPP 300)

Easy2Feed promises automatic feeding at a budget price. This optional feature saves time and space, is very ergonomic and can be retrofitted.

The core element is a compact scissor lifting table, which can be comfortably loaded by forklift truck.

- For 3800 mm and 4300 mm cutting lengths
- Panels upwards of 9.5 mm thickness can be fed
- Maximum panel size: 3100 x 2200 mm (for 4300 mm cutting length: 3660 x 2220 mm)
- Stack height 460 mm (standard version)
- Lifting table in pit on request
- For material that can be push-fed
- Feed roller conveyor on the side available as option

Feeding with vacuum technology

Vacuum feeding is the number one choice for sensitive panels. In contrast to push-feed systems, it deposits the panels singly, and so extremely gently, on the rear machine table. This ensures that you are ideally set up for a growing diversity of materials.

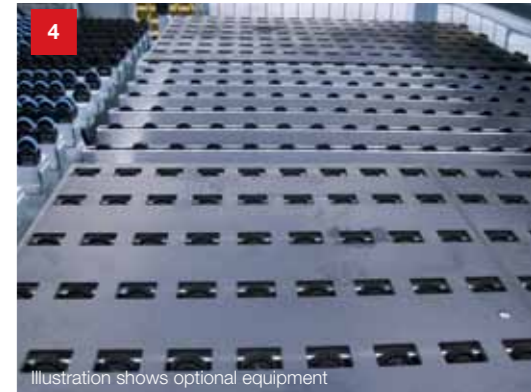
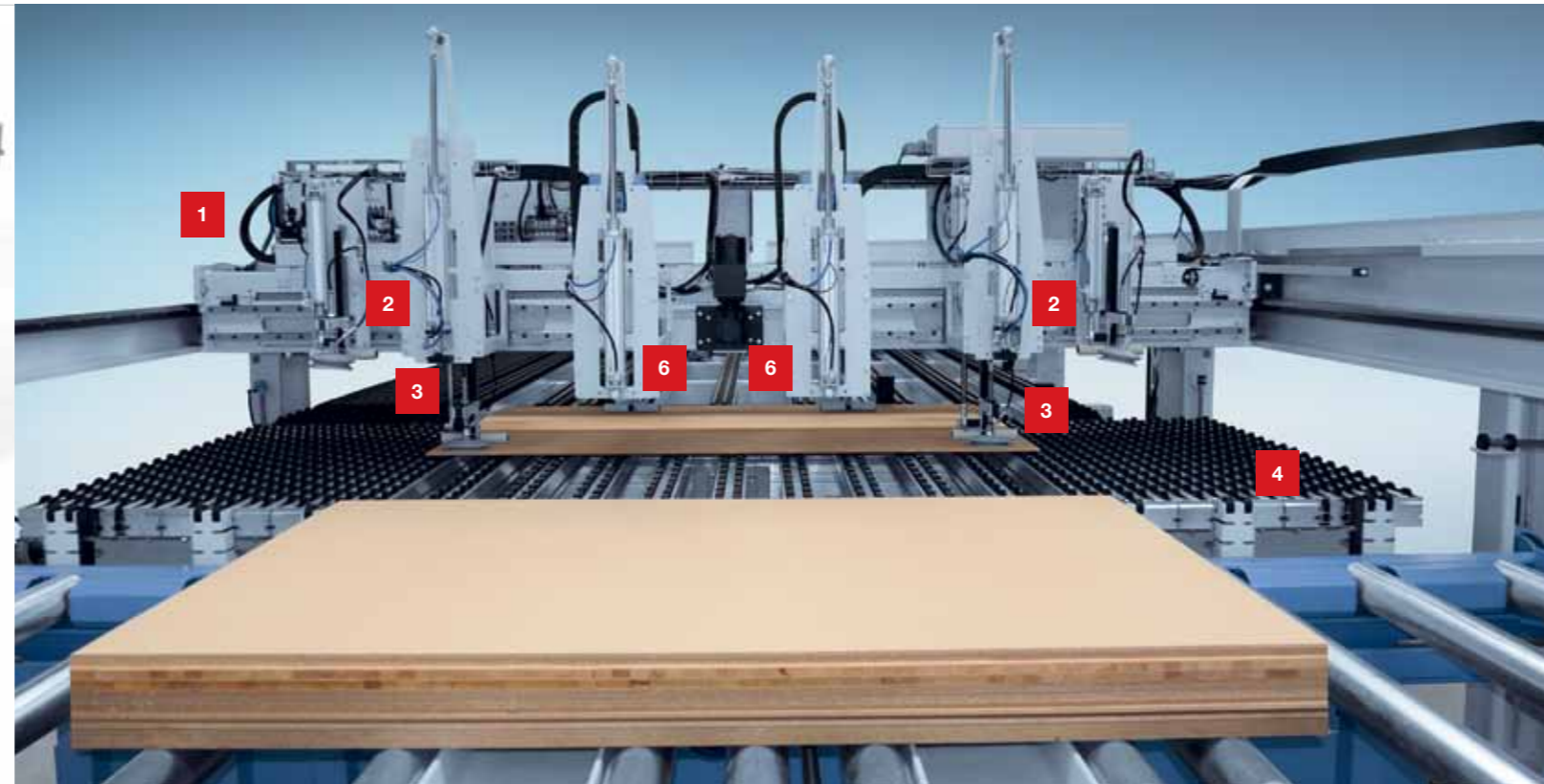
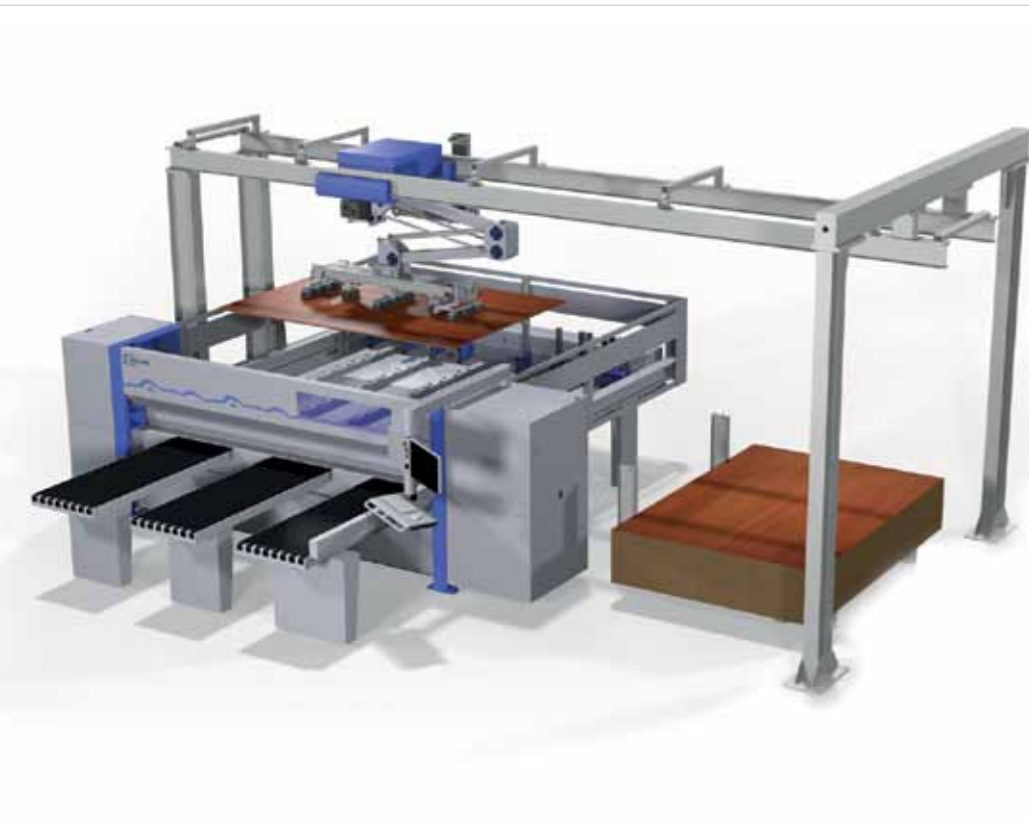


Illustration shows optional equipment



Feed gantry TBP 211

The TBP 211 feed gantry from HOMAG Automation is designed to increase efficiency and flexibility in the cutting process. It feeds panel saws automatically and quickly, with maximum care of material. Layouts can be individually configured to suit specific requirements and available space.

- Increased capacity
- Higher productivity
- Increased material throughput
- Gentle on surfaces
- Lower quality costs
- Short transport times
- Ergonomic handling

The profiLine VAC feed carriage

Parallel to the program fence and above the lifting table, there are two linked feed carriages with integrated vacuum suction units and feed units. This option allows sensitive panels to be laid on the machine table – and material that can be push-fed to be simply pushed over.

- With this fast, space-saving and cost-effective solution you are prepared for all present and future requirements
- For all panel materials that allow easy separation and vacuum pick-up up to a width of 2500 mm

Elements:

- Feed carriage and trailer | 1
- Movable tilting suction cups | 2
- Feed unit | 3
- To form books using the vacuum feeding system, you need the profiLine feed-stacking table | 4

- Corner-lifting device (four separation suction cups) for plastic or thin panels < 3 mm | 5
- 2 micro-feed units for thin panels up to 6 mm and panel lengths from 1800 mm | 6

Feeding: saw-storage combinations

Small, medium or large – we have the right saw-storage combination for everyone. The systems installed by HOLZMA are as varied as the companies in which the storage systems are used. Let HOLZMA's specialists advise you as to which solution is best for your company.

Saw and storage system: an unbeatable team

- Standardized interfaces link the HOMAG Automation storage system with the HOLZMA saw, creating an effective processing center
- High degree of flexibility due to ideal usage of the available space
- Up to 40% increase in productivity with the same manning levels
- The software allows you to set up instructions for handling each type of panel for every storage position and panel identification number (vacuum settings)
- The storage software indicates the different storage positions and storage position groups using color-coding – this gives you a clear overview
- Storage system and saw are cross-linked. So you don't have to run back and forth between the two computers, but can operate everything comfortably from the saw – or from the store, whatever suits you best at the time



Feeding a storage system (example)



Feeding a storage system (example)



Small storage systems: a perfect start

HOLZMA offers low cost feeding solutions, including storage link-up, for nearly all single saws.

- Optimum use of space
- Attractive price
- Movable in x and y directions
- Saw and storage system perfectly coordinated
- Perfect handling – even with just one machine operator
- Easy, ergonomic operation
- Storage system controls the saw

HOMAG Automation storage system TLF 211: viable even in restricted spaces

- The TLF 211 optimizes the storage area, saving you valuable production space
- Rapid amortization – combination with a saw pays off when 20 or more unprocessed panels are cut a day
- Intelligent standby feature – the machine consumes energy only when it moves
- Optimum material usage right down to the offcuts thanks to sophisticated material management

- Panel length: 2000 mm to 4200 mm (max. 5600 mm as an option)
- Workpiece width 800 mm to 2200 mm (min. 400 mm as an option)
- Unprocessed panel thicknesses from 12 mm upwards (from 3 mm as an option)
- Portable weight: 250 kg
- Stack height: 2 100 mm

Large storage systems: unlimited possibilities

Naturally, there is virtually no upward limit to the size of saw-storage combinations. The design of a custom solution is governed by your requirements. These include your capacity requirements (storage/retrieval cycles per time interval), the space available and also your strategic aims.

Our software solutions help with the planning: using both the HOLZMA simulation software and the HOLZMA Cut Rite optimization software allows us to make very precise calculations during the preliminary planning stages and thus to determine the ideal processes.

Offcuts management, your production planning and much more will also be taken into consideration, if requested.

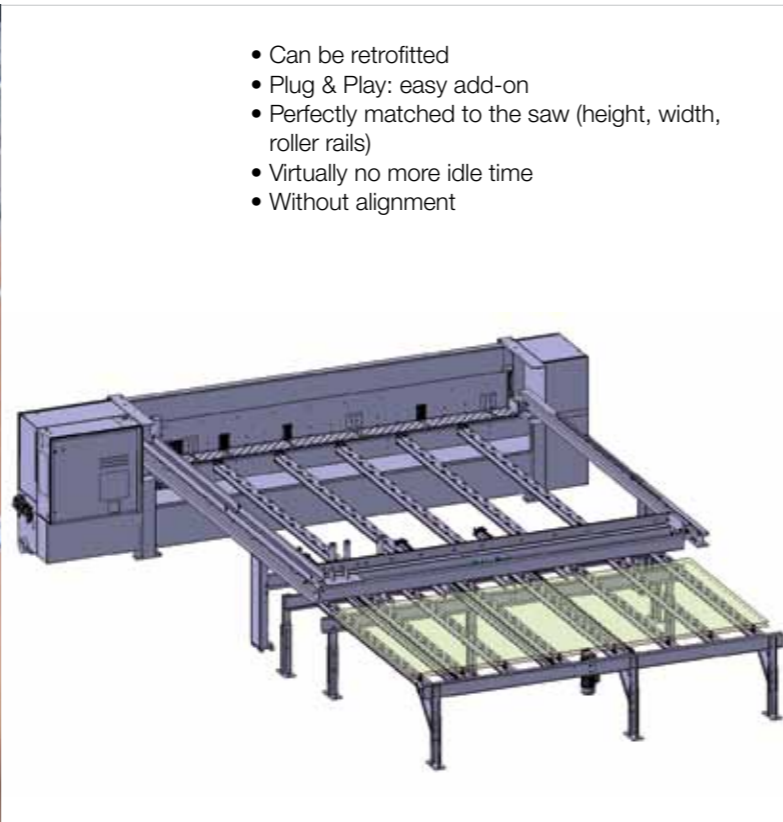
HOMAG Automation storage system TLF 411: easily handles material diversity

- Panel weights up to 350 kg and panel lengths up to 5 600 mm
- Trouble-free transport even of structured surfaces
- Controlled, low-vibration movements even in the largest version
- Extremely stable double scissors for precise panel handling
- Handling of plastic panels

Feeding from the storage system – with intelligent assistance

Efficiency boost with panel labeling system and feed-stacking table (optionally with integrated feed)

- Ensures smooth production without interruptions
- Turns dead time into value-adding time
- Optimizes handling during destacking, because all the parts are already labeled
- Saves time, space and money by improving efficiency



- Can be retrofitted
- Plug & Play: easy add-on
- Perfectly matched to the saw (height, width, roller rails)
- Virtually no more idle time
- Without alignment



Panel labeling system

The innovation for saws with storage link-up: the HOLZMA panel labeling system labels the panel before it is cut – independently of the saw, in non-productive time that hitherto 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

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 new feed-stacking table now 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).

CADmatic control software: from feeding ...

CADmatic PROFESSIONAL features a data connection to your storage system, providing the basis for completely automated feeding. Current stock information from your horizontal, block-stack or high-bay storage system is provided parallel to production and is taken into account in all CADmatic calculations, allowing material usage to be optimized. Even offcuts are registered and recorded in the storage system.

... to real time production planning

CADmatic PROFESSIONAL is prepared for connection to your internal ERP or PPC system. All production data is passed to the planning system in real time. This allows you to react promptly even to last minute changes in orders and take them into account for your production planning.

Simulation software: precise planning

With the aid of simulation technology, machines and systems, or even entire production areas, can be visualized in the form of dynamic models. This allows a very accurate prognosis of how they will behave with a given production program.

Feeding from the front: Econolift

The Econolift assists in feeding the saw from the front. It allows books of panels to be transported effortlessly onto the air cushion tables. This is efficient and at the same time ergonomic.



Automatic panel feeding – directly onto the air cushion tables

The Econolift allows single panels or books to be automatically pushed directly onto the air cushion tables of the saw.

The Econolift comprises:

- a four-column lifting table with longitudinal roller conveyor (not driven) | **1**
- automatic panel feed by micro-feed | **2**
- an additional air cushion table measuring 2 160 x 650 mm | **3**

The benefits:

- Minimizes handling times
- Maximizes ease of use
- Increases efficiency
- Feeds panels with a minimum thickness of 6 mm to the saw

Available options include:

- An extension of the air cushion table length to 2810 mm
- The online link-up for automatic activation by the CADmatic control software

Available sizes:

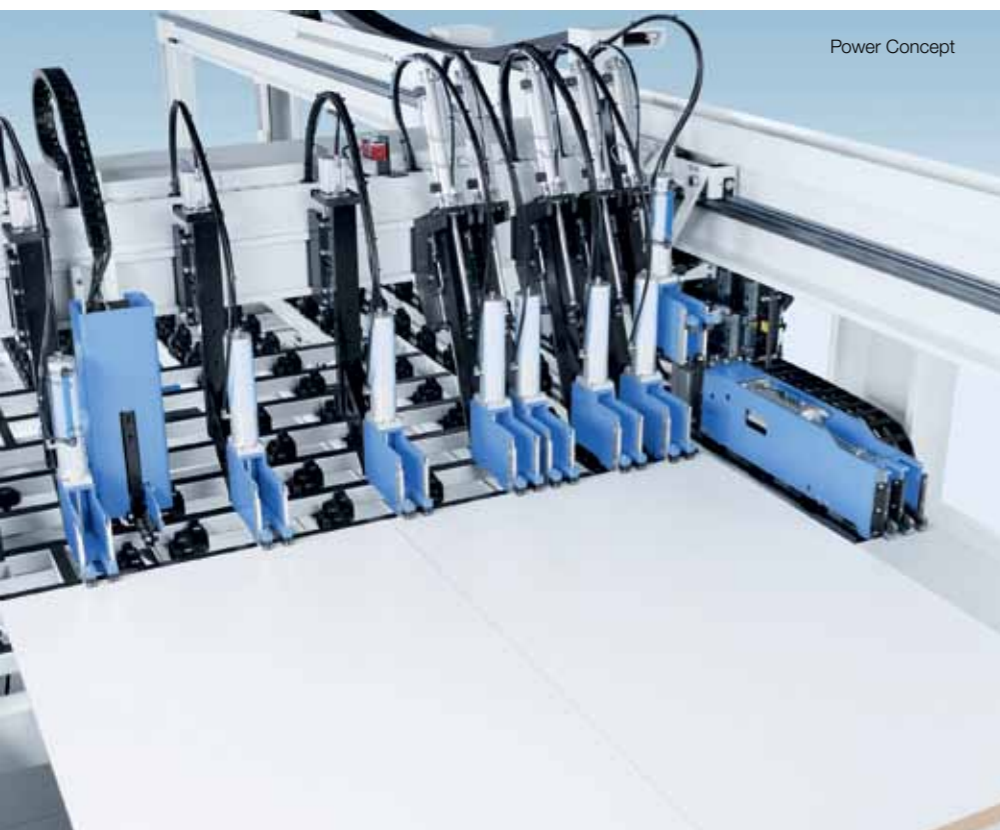
- 3300 mm x 2200 mm
- 3800 mm x 1600 mm
- 4300 mm x 2200 mm

Workflow description:

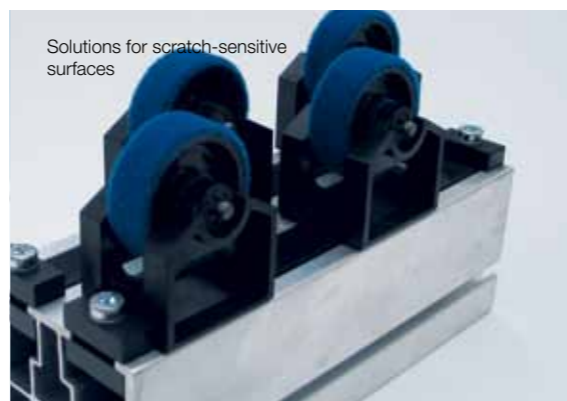
See marking A to D

Between feeding and destacking: convincing handling solutions within the saw

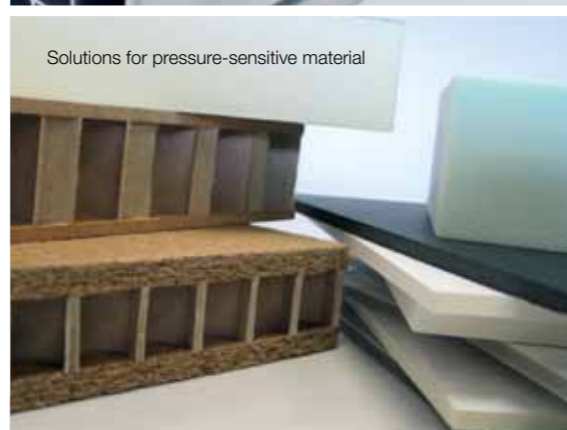
An intelligent overall process is essential for good work results. That is why HOLZMA not only attaches great importance to good feeding and destacking solutions but also continually develops innovations for transport within the saw. We are going to present some of these concepts here.



Power Concept



Solutions for scratch-sensitive surfaces



Solutions for pressure-sensitive material



dustEx



Turning device for headcuts



Manual pressure control



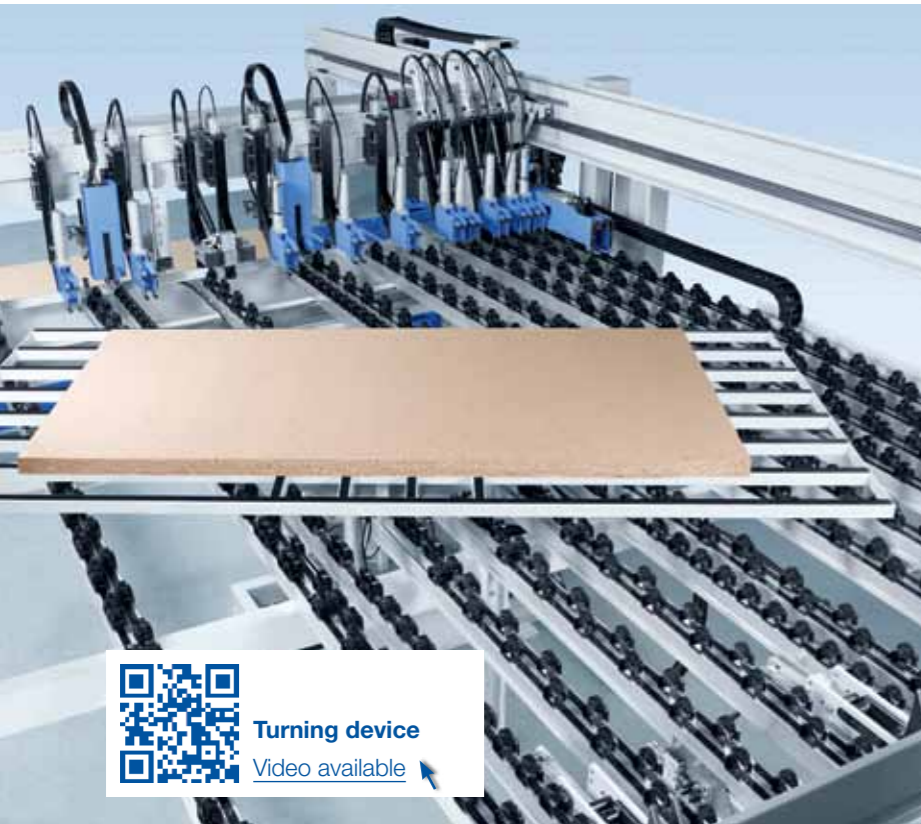
Central side pressure device

Between feeding and destacking: tailored handling solutions

HOLZMA has numerous other handling solutions. We are going to present a selection here.
 Ask your HOLZMA sales consultant – he will find the right concept to meet your challenges.

NEW! Power Concept PRACTICE

The low-cost version of the successful Power Concept PROFESSIONAL – developed for the HPP 300 profiLine with feeding from the front and for saws with simple storage link-up without an integrated feed-stacking table. Power Concept PRACTICE can do everything that constitutes Power Concept, but can be integrated far more easily and consequently more economically.



Turning device for headcuts

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

Power Concept PROFESSIONAL – for up to 40% higher output

The Power Concept allows you to cut strips with different cross cuts together. Power Concept PROFESSIONAL achieves this by means of:

- An additional clamp which works independently
- Clamps on the program fence that can be raised out of the work area if necessary

- 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 shortest machining times

The benefits:

- Up to 40% higher output
- Significantly shortened cutting cycles
- Significantly improved material flow
- High material throughput
- Lower costs per cut

- Attractively priced high-tech solution with minimum space requirement
- Precision cutting of even very narrow strips
- Simultaneous feeding and cutting without a separate feed carriage: the Power Concept PROFESSIONAL clamp positions the last strip at the cutting line while the program fence fetches the next panel or book of panels from the lifting table (HPL)

Everything under control – for pressure-sensitive material

Pressure-sensitive material is playing an increasingly important role in panel processing.
 With your HOLZMA saw you are well prepared for this trend – thanks to innovative optional features. Technology that pays off.

Lightweight/honeycomb boards

These materials are used mainly in the furniture industry. The most common types are paper or aluminum honeycomb sandwiched between sheets of chipboard, cardboard, aluminum or melamine.

Rigid plastic foam boards

These foamed boards are used for the most part as insulation and are made, for example, of polyurethane or polystyrene.

Program-activated clamps

This option ensures panel edges are not damaged. Now also possible: automatic clamp activation in “measuring” mode.

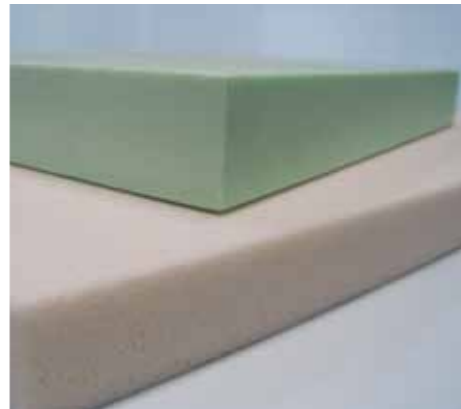
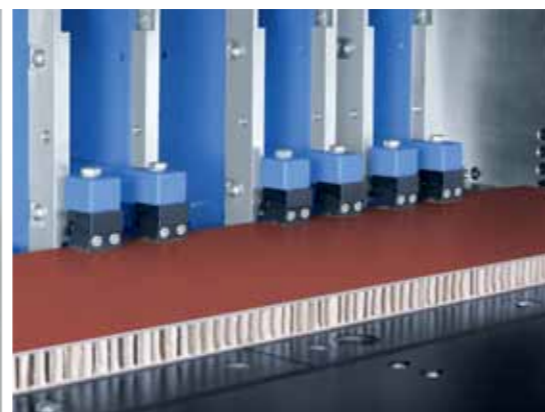


Illustration shows optional equipment



Wood fiberboards

Wood fiberboards used for thermal insulation are characterized by their very low density, which makes them correspondingly pressure-sensitive.

Composite boards

This group includes all those boards that are made up of layers of different materials. For example, rigid-foam composite boards with a core of rigid foam and facings made of paper, aluminum or plastic material.

Soft Touch package 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. HOLZMA has bundled the technologies to deal with these materials in the Soft Touch package. HOLZMA also offers equally innovative package solutions for scratch-sensitive material. Ask your HOLZMA consultant for more details.

HOLZMA patent: central side pressure device

- Integrated directly in the saw carriage, thus shortening 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 boards, laminates or sensitive materials to be processed perfectly. A new feature here is the book-height-dependent control of the contact pressure: the higher the book, the greater the pressure

Manual pressure control

This allows you to adjust the pressure for the clamps and the pressure beam by means of two manual regulators to suit your specific panel material. The simple solution for handling pressure-sensitive material. Many HOLZMA saws already come equipped with a similar solution as standard.

On some models it is also optionally possible to adjust the pressure of the clamps and the pressure beam via the CADmatic control system.

Solutions for scratch-sensitive surfaces

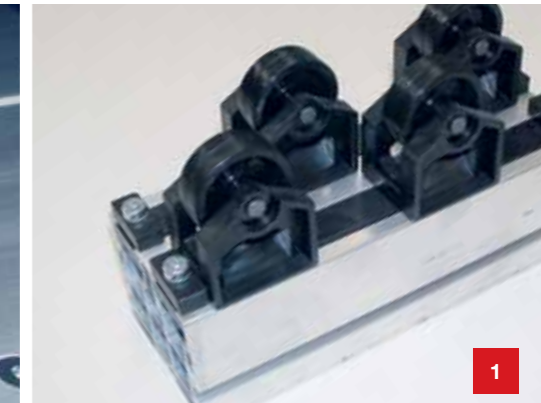
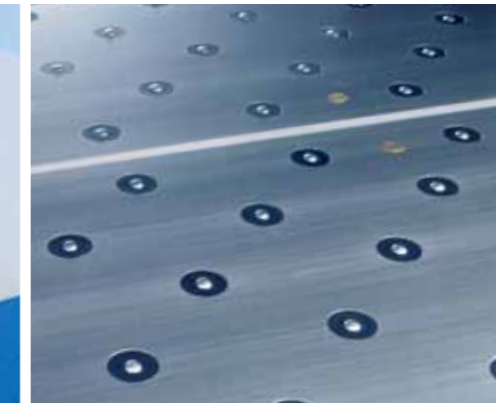
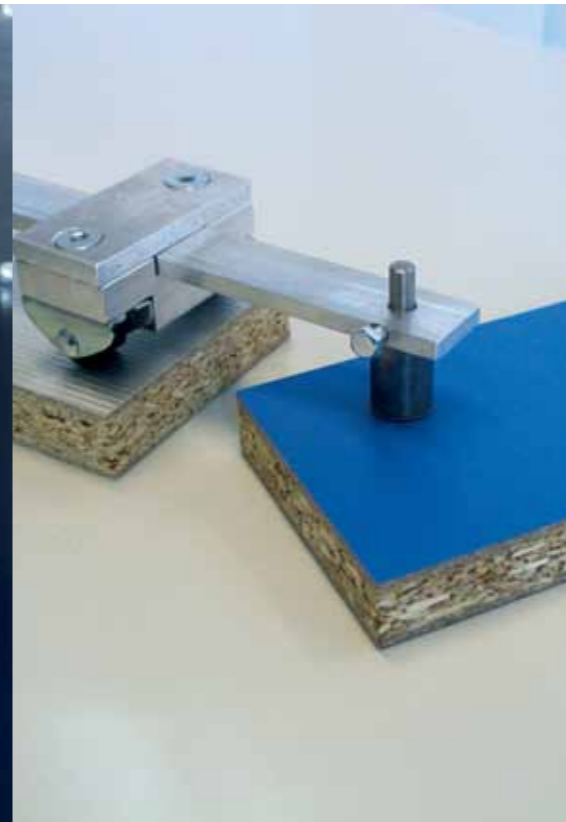
Sensitive surfaces are playing an increasingly significant role in panel processing. Whether it's designer furniture or kitchen manufacture, the trend is towards an ever-increasing diversity of high-quality and, as a result, scratch-prone materials.

Solutions for scratch-sensitive surfaces

Anyone trying to avoid damaging scratch-sensitive surfaces during the production process, and thus to minimize material losses, needs an appropriately equipped panel saw. HOLZMA offers numerous solutions for this – a number of which are available in economical packages.

Anodized aluminum machine bed plates

The special coating ensures gentle material handling. Ideal for materials with highly sensitive surfaces.



Air jets throughout: the machine table

Anyone working with sensitive material or especially heavy panels and books will benefit from the machine table being equipped with air jets throughout.

Now with new dustEx technology

HOLZMA was one of the first manufacturers to introduce a machine table with air jets throughout. dustEx is now the next major evolutionary step.

New combination air jets, patent pending, are positioned along the cutting line and transport dust and chips specifically

toward the right-angled fence. They are now picked up here even more effectively thanks to new, innovative extraction technologies. This prevents scratches from being caused by dust on the machine.

Recommended: a front and rear dust-trap curtain rounds off the dustEx package.

Scratch-sensitive material

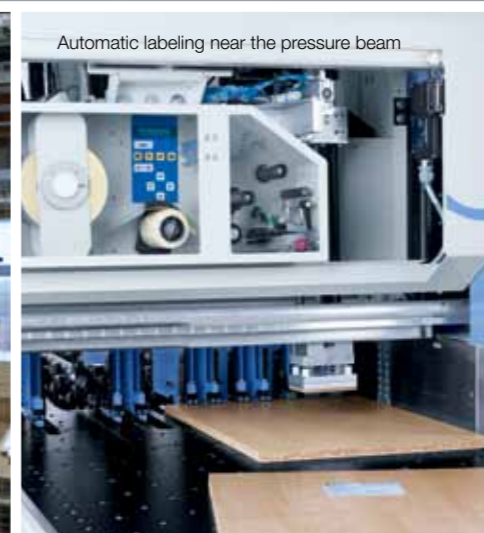
HOLZMA has developed an in-house standard for determining the scratch-sensitivity of surface materials so as to ensure that the panel saws are properly equipped, from the moment they are delivered, to process all of the materials required at the particular site with the necessary care. Together with the customer, the sales consultant tests the materials to be processed with this testing method at the advisory stage and indicates appropriate measures. This allows possible production downtimes and costly retrofitting due to wrong design or dimensioning of the system to be excluded from the outset.

Rollers

- Proven and cost-effective: our standard black rollers are suitable for unproblematic materials. They come on top hat rails or particularly stable combi-profile rails (illustrations 1 and 2).
- Flocked and gentle: these rollers prevent shiny marks and scratches on sensitive panel materials (illustration 3).

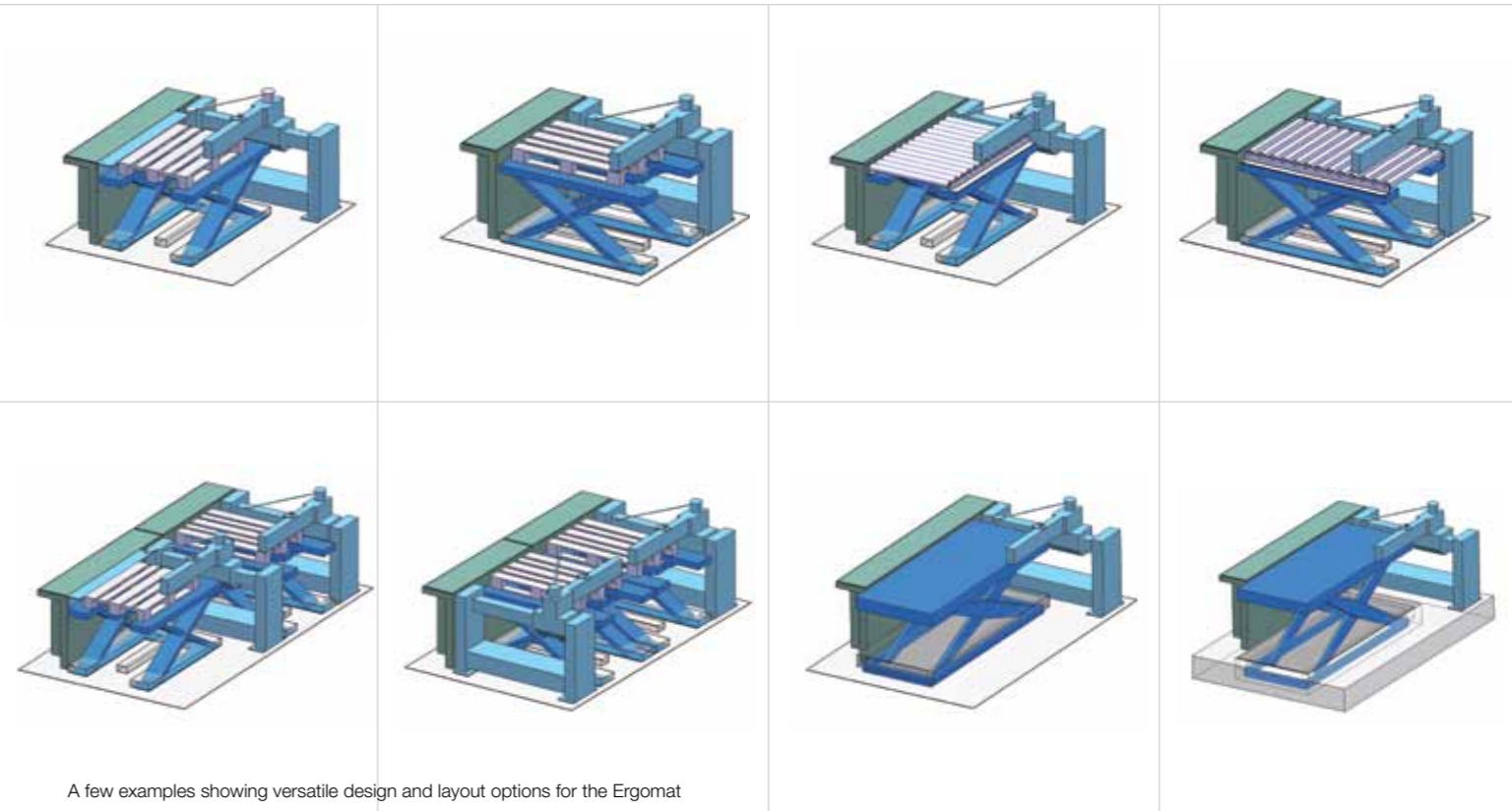
Destacking with HOLZMA

HOLZMA offers a variety of destacking systems. These include the Ergomat and its bigger brother, the Liftomat. Alongside these standard solutions, HOLZMA also offers a wide range of special solutions, for instance rake-destacking or clamp destackers for industrial systems. These components are further supplemented by an extensive modular system of lifting tables, roller conveyors and other special-purpose systems.



Destacking with the Ergomat

The Ergomat is a little helper that saves a lot of time. It helps you stack the cut parts on a pallet directly after the cutting process. There is no need for you to lift or carry the parts and books. You simply move them comfortably across the air cushion table to the destacking position – a fast solution that is gentle on operators and material alike.



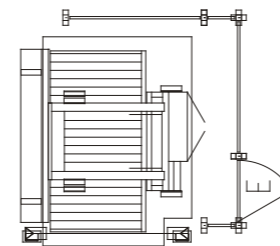
A few examples showing versatile design and layout options for the Ergomat

The Ergomat is a simple, inexpensive destacking solution that finds its home primarily in woodworking shops.

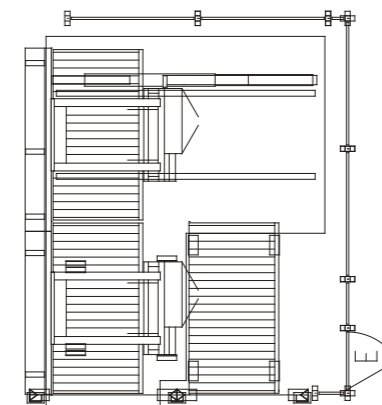
- The operator moves the book of parts over a cushion of air. He does not need to bend down or expend much energy
- The air cushion protects scratch-sensitive materials
- Adjusting the Ergomat to the part size required is a quick job, which makes it very flexible
- You increase the output of the system and speed up the cutting process as the cutting line remains free

Destacking with the Liftomat

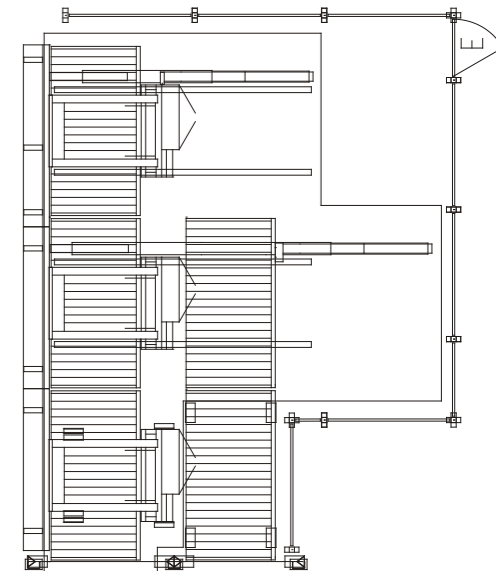
The HOLZMA Liftomat works along the same lines as the Ergomat, but offers a number of additional functions and a higher level of automation. If required, several Liftomat units can be linked to provide one large destacking station. An efficient solution that is often used in large-scale systems.



Basic version: stationary



Option: travel drive



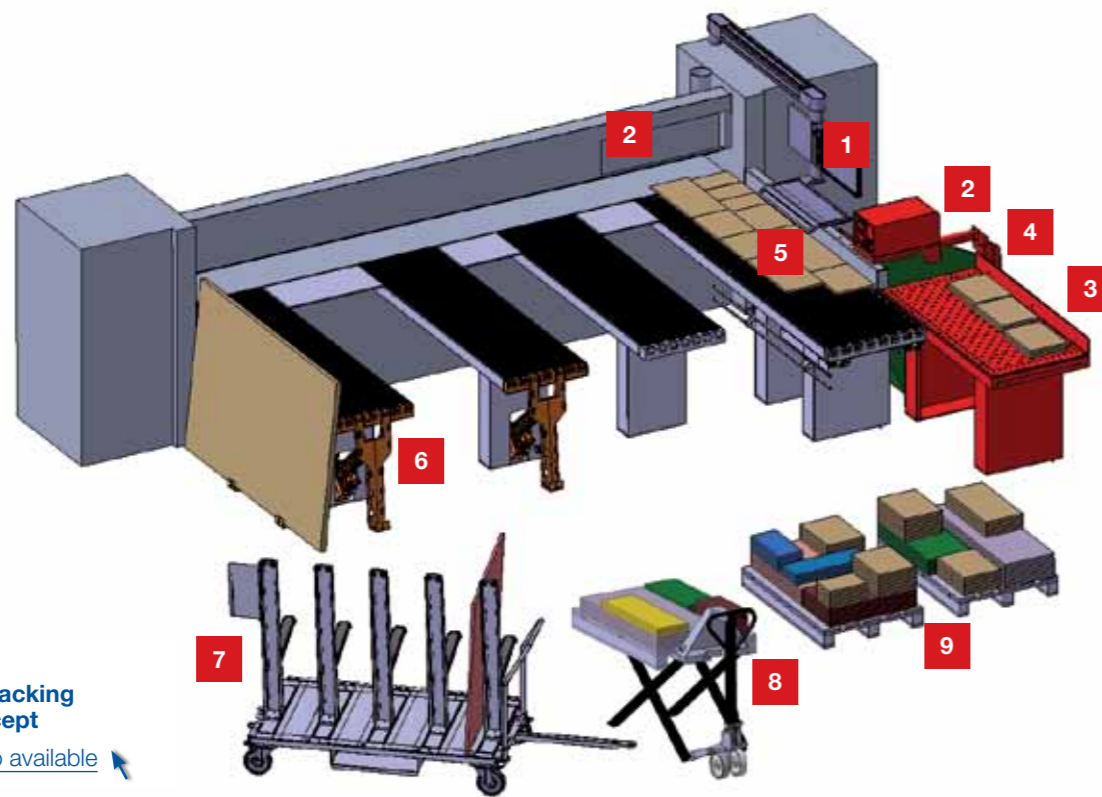
Option: travel drive with rear roller conveyor

The Liftomat is amazingly versatile. It finds its home as a stand-alone station in woodworking shops. At the same time, Liftomat units are also to be found linked together in industrial systems. In either case, it facilitates the work and ensures it is clearly and orderly structured.

- The operator moves the books of parts over a cushion of air to the destacking position. He does not need to bend down or expend much energy
- The air cushion protects scratch-sensitive materials
- The Liftomat can quickly be adjusted to the required part size
- Several stations can be linked
- You increase the output of the system and speed up the cutting process as the cutting line remains free
- Operation in a pit is possible – for higher stacks
- CADmatic PROFESSIONAL offers you the option of having the destacking positions for the individual parts displayed on the monitor (see page 33)

Zero errors – even with mixed stacks! With the HOLZMA destacking concept

The destacking concept guides the operator from depositing the first part to forming the perfect stacked pallet. This is possible due to the combination of software and hardware in an overall concept. The part to be deposited and the appropriate destacking position and time are indicated to the operator. The hardware enhances efficiency and ergonomics in all work steps.



Software for destacking module PRACTIVE (see left)

With the “destacking module PRACTIVE” option, CADmatic 4.5 PROFESSIONAL controls not only the cutting process, but also the process of destacking by the operator. The new powerTouch control panel shows the operator exactly when and where each part is to be deposited via the monitor and on each label. This process is underpinned by an intelligent destacking concept designed to boost the efficiency of post-cutting processes enormously - for example, by creating stacks optimized for subsequent processing steps.

Software for destacking module LITE

Which part goes where? The answer to this question is supplied by the integrated destacking display. The individual parts are color-coded both in the cutting pattern and in the flow diagram. The machine operator can clearly see which produced parts have been allocated to which destacking stations.



Comprehensive overall concept, multiple process optimization options

The HOLZMA destacking concept revolutionizes post-cut processes by combining a range of actions.

Your benefits:

- Systematic destacking
- Operator guidance throughout
- Cuts out unnecessary destacking routes and time
- Optimizes processes post-cut

The results:

- The destacking software guides the operator intuitively
- Times and routes that do not add value are systematically reduced
- The parts buffer is integrated into the process in an anticipatory way
- Errors are virtually eliminated
- Stack formation is bound to the destacking strategy
- This produces stable stacks in a logical order and requiring significantly less space

The key components of the HOLZMA destacking concept:

- Destacking software as option for CADmatic 4.5 PROFESSIONAL: “Destacking module PRACTIVE” (page 33) | 1
- Label printing with destacking details – using the manual label printer or the automatic label printer near the pressure beam (page 34) | 2
- Ergonomic parts buffer (page 35) | 3
- Waste container (not illustrated) | 4

- Chopping edge (standard feature) (page 35) | 5
- Pneumatically operated feeding and destacking aid (page 36) | 6
- Destacking carriage (page 37) | 7
- Scissor-lift pallet truck “HuGo” (page 36) | 8
- Thanks to intelligent stack formation (not illustrated) | 9 fewer pallets are required. This cuts out unnecessary routes and reduces destacking times. The destacking strategy is implemented systematically

More options for intelligent destacking

- **Visual operator guidance:** an additional LED display indicates, at the same time as the monitor, when the operator is to push a cut part onto the parts buffer, or remove it from there
- **Flexible parts buffer:** up to now, only the parts of a panel that were cut last went onto the parts buffer, so as not to slow down the saw.

New: now the parts buffer is always used whenever it can improve stack formation

- **Additional stability:** in order to make stacks more stable, waste parts are now actively used in stack formation

Clearly labeled parts are a must for smooth production processes. With HOLZMA labeling systems, all the labeling work can be dealt with manually or automatically, depending on the equipment.

The panel labeling system allows your saw-storage combination to complete the labeling work before the first part is produced. For further information see page 14.



 Fully automatic labeling
Video available

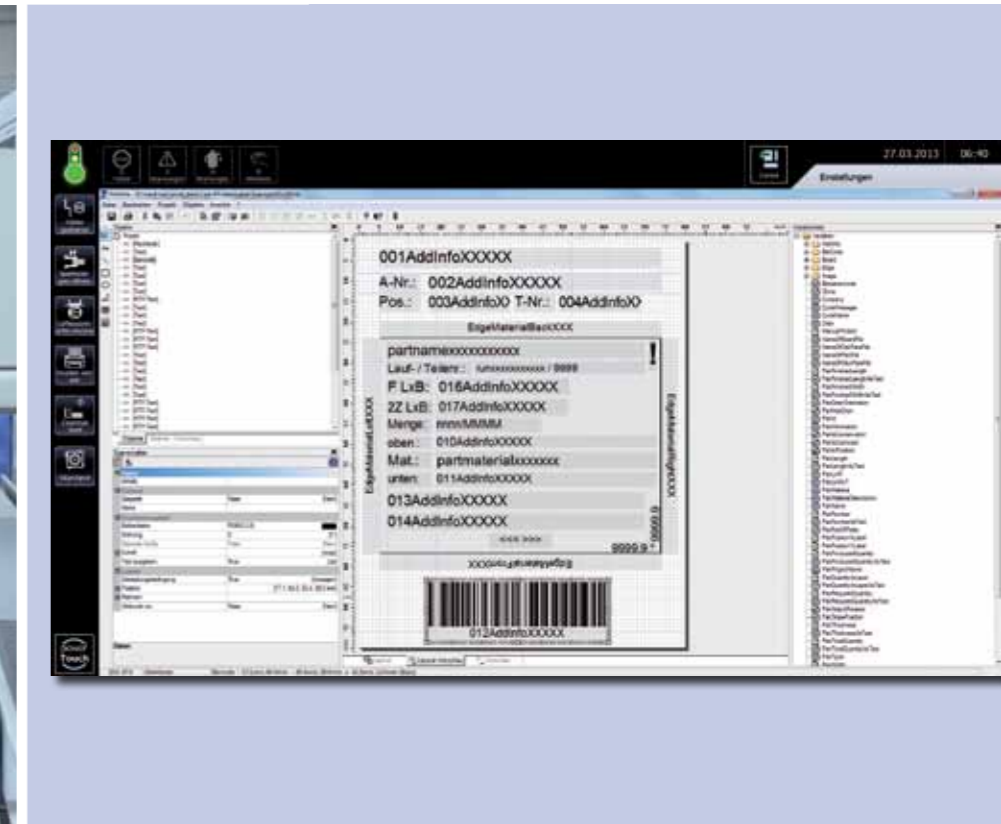


 Label printer
Video available

Chopping edge on the right-angled fence

With the help of the new chopping edge, waste strips can be disposed of quickly and easily. The robust chopping edge is within easy reach of the operator and ideally positioned on the right-angled fence, allowing waste to fall directly into the container – for improved ergonomics.

 Chopping edge
Video available



Fully automatic labeling

The labeler is located near the pressure beam, i.e. in your field of vision, and labels the finished parts/books – even when several strips are processed simultaneously side by side (Power Concept). It makes no difference whether you feed the panels from the front or the rear. If desired, the position of the label can be individually controlled.

- 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

Label printer

The HOLZMA label printer has everything to facilitate an efficient workflow. You can print customized labels directly at the saw and design them to include bar codes, text and graphics, if required. If you also use our Cut Rite optimization software, instructions for downstream CNC machining can also be included on the labels. In this way, you can integrate the saw perfectly in your production flow.

Swiveling label printer and parts buffer

The new HOLZMA parts buffer with swiveling label printer increases the efficiency of processes and optimizes handling. It provides an ergonomic buffering area for parts after cutting. The integrated printer allows the operator to work in a comfortable position and dispenses the right label for the right part at the right time.

CADmatic 4 PROFESSIONAL: labeling program

With the "Labeling" option, you can label the results of your work, whether individual parts, cut books or entire stacks, with all the relevant information in time with the cuts, and also pass data on to downstream machines.

How does it work? The layout editor allows you to define the label design and enter the required data in CADmatic. You are able to include text information as well as graphics and freely selectable

bar codes. The system will then generate the labels in perfect time with the processing cycles. Depending on the system, the labels are then attached automatically or by hand.

An optional feature that sets industry benchmarks where scope for design and hardware quality is concerned, leaving nothing to be desired.

Destacking aid and destacking carriage

The small, cost-effective destacking solution is here: the destacking aid allows you to stand even big panels upright effortlessly, and to push them straight onto the practical, new destacking carriage. From there, they continue to the next processing station.
A material-friendly and ergonomic solution.

If you also use HOLZMA's destacking software, you can cut out unnecessary routes, speed up the destacking process and reduce the number of pallets required.



Feeding and destacking aid: for making light work of heavy panels

The feeding and destacking aid is permanently attached to the air cushion table. It folds up or down to position panels horizontally or stand them upright. Whatever you require.

- Attached to the side of the air cushion table
- Equipped with rollers so that vertical panels can be loaded directly onto the destacking carriage
- Particularly useful with large panels
- Gentle on material and operator

Scissor-lift pallet truck "HuGo"

The HOLZMA scissor-lift pallet truck "HuGo" is equipped with automatic height control and facilitates ergonomic and smart destacking processes. A light barrier controls the automatic raising and lowering of the pallet truck, allowing you to remove all the parts from the pallet at an ideal working height, for example, at an edge banding machine.

An extremely useful carriage

The destacking carriage is very flexible. No matter whether you are stacking the parts horizontally or vertically, you can do so quickly, without damaging the material, and then transport them to the next processing step.

- Clearly laid out
- Reduces (rotational) movement of parts and operator on the way from air cushion table to destacking location
- Free positioning and arrangement of the destacking stations, irrespective of number

- Everything is stacked in an inclined position. Contact surfaces are covered with fabric or equipped with rollers
- The positioning of parts on top of each other or side by side is not achieved by pushing them
- In the case of the preferred vertical destacking variant, parts are not moved on their lower edges
- Parts stacked horizontally do not slide out of position: the rough rear edges of the parts catch in the protective covering (fabric)

- Maximum flexibility thanks to the inclined vertical supports and the inclined brackets, which can be slotted in at four different heights
- The carriage is equipped with a number of brackets. The brackets that are not in use are stored in the drawer so that the carriage is always fully equipped
- Panels in the carriage "racks" can easily be flicked through for easy selection

Offcuts handling

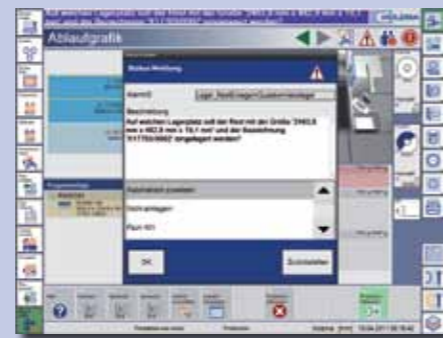
No system, long routes and lengthy searches? HOLZMA solutions for offcuts handling now put an end to that. Options, whether software, hardware or a combination of both, range from simple storage location management to fully automatic offcuts handling by a robot.

Your benefits at a glance

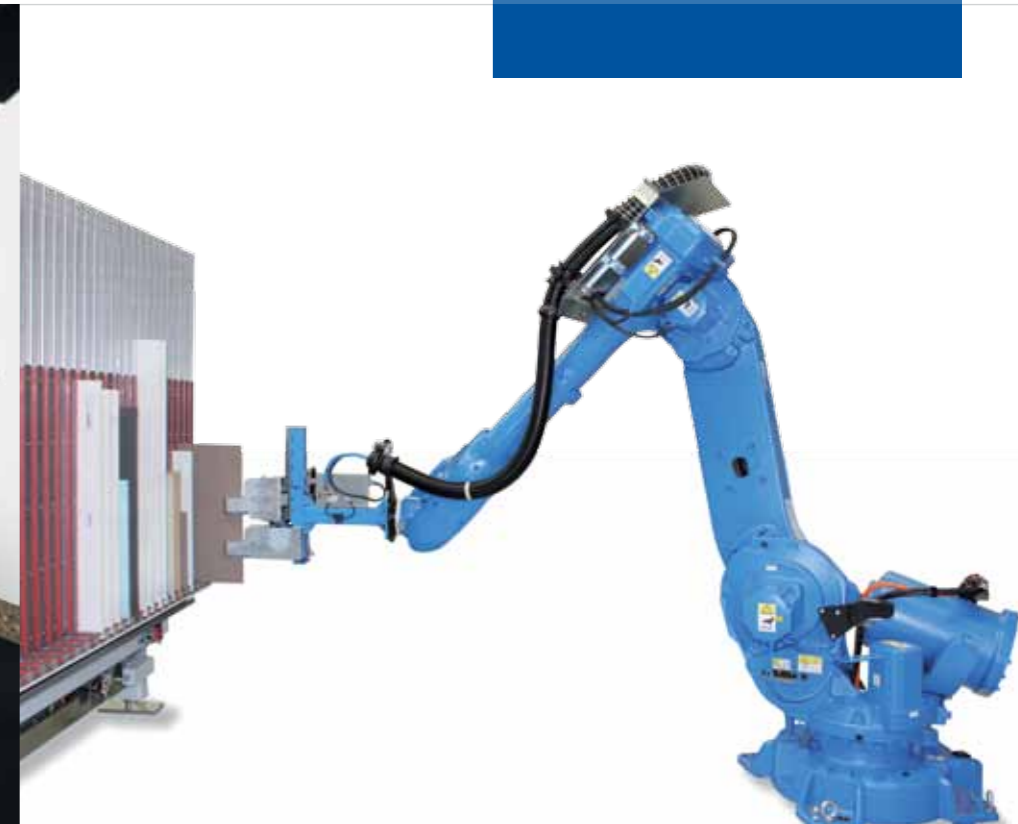
- Automatic transfer to stock, management and retrieval of offcuts
- Maximizes material yield because all offcuts are immediately available and even small offcuts are rigorously used
- Increases the efficiency of a horizontal storage system because offcuts are stored separately
- Improves transparency and structuring
- Saves space, long routes and valuable time
- Available for many HOLZMA saws of the 3, 4 and 5 series



CADmatic 4.5 PROFESSIONAL
Controlled storage of offcuts



CADmatic 4.1 PROFESSIONAL
Controlled storage of offcuts



Transparency in your offcuts store in the blink of an eye

The way to transparency in your offcuts store is quick and simple. All you need to get there is:

- Cut Rite from version PRACTIVE upwards
- CADmatic PRACTICE or CADmatic PROFESSIONAL with the “storage location management for offcuts” module
- The HOLZMA storage system software integrated at the factory
- The “stock control” module for Cut Rite

Potential for expansion included: should you subsequently invest in a HOMAG Automation storage system, the “storage location management for offcuts” option can be directly integrated in the HOMAG Automation software.

The benefits:

- You can adopt a customized storage strategy and sort offcuts according to size, material or other criteria

- How many offcuts are there in the store? How many are moved in or out of the store on average per day? The integrated statistical data generator provides the answers
- Cut Rite groups cutting patterns together in a run. This allows all the offcuts required to be shown at once and retrieved from the store before starting production

An extra for greater flexibility: the scanner package

If you do not use only your HOLZMA saw to process offcuts, you can now benefit from the new scanner package. The scanner will show whether an offcut in the store is still available or already reserved.

1. The operator scans the label using the scanner
2. If the offcut has already been reserved for a cutting pattern, a red light comes on

3. If this is not the case, a green light comes on and the operator can take the offcut. The HOLZMA “storage location management for offcuts” then automatically adjusts the stock
4. In exceptional cases, a blue light may come on and prompt the operator to enter more details

Robot handling of offcuts

The new saw-robot combinations from HOLZMA and HOMAG Automation maximize efficiency in offcuts handling. The principle: a custom-designed industrial robot with a 6-axis articulated arm is positioned directly next to the saw. It automatically fetches all the offcuts from a separate buffer table, stores them in a space-saving vertical shelving system with up to 500 slots – and retrieves them, again fully automatically, when they are needed.

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