

100 Percent. Repetition Accuracy. Multifunctional.

# ACCURA



PRODUCTIVITY AND PRECISION



# Accuracy in Every Detail

Designed for highest requirements in terms of quality and flexibility.

The ACCURA series stands for complete processing of modern edging and panel materials. Program selection allows the machine to be set up without even opening the hood, so that it is ready for production immediately.

The HOLZ-HER ACCURA series sets the highest, professional standards for edgebanding without compromises.

- Maximum precision and processing reliability for many years with torsionally stiff, welded machine columns.



Video  
ACCURA



Illustrations may contain  
optional features.

- Ergonomic operation with rotating and pivoting 18.5" touch screen control panel. Comprehensive program memory with complete storage of all operating data as well as service messages in clear text.
- Fully automatic control of machining units at the touch of a button using NC servo-axes without opening the hood.



Intelligent energy management for HOLZ-HER edgebanders.



For short intervals between workpieces and optimized edge protrusions.

# Glu Jet – Invisible Joints with Thin Film Technology

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

Wafer-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.

Superior appearance on all materials – starting with state-of-the-art, high gloss edging right up to solid wood edging with extremely large cross-sections, HOLZ-HER remains unequaled for variety. Set the trends and standards for tomorrow today.

## Glue Change and Cleaning Require Only 3 Minutes Each



**Heat-up time**  
3 minutes

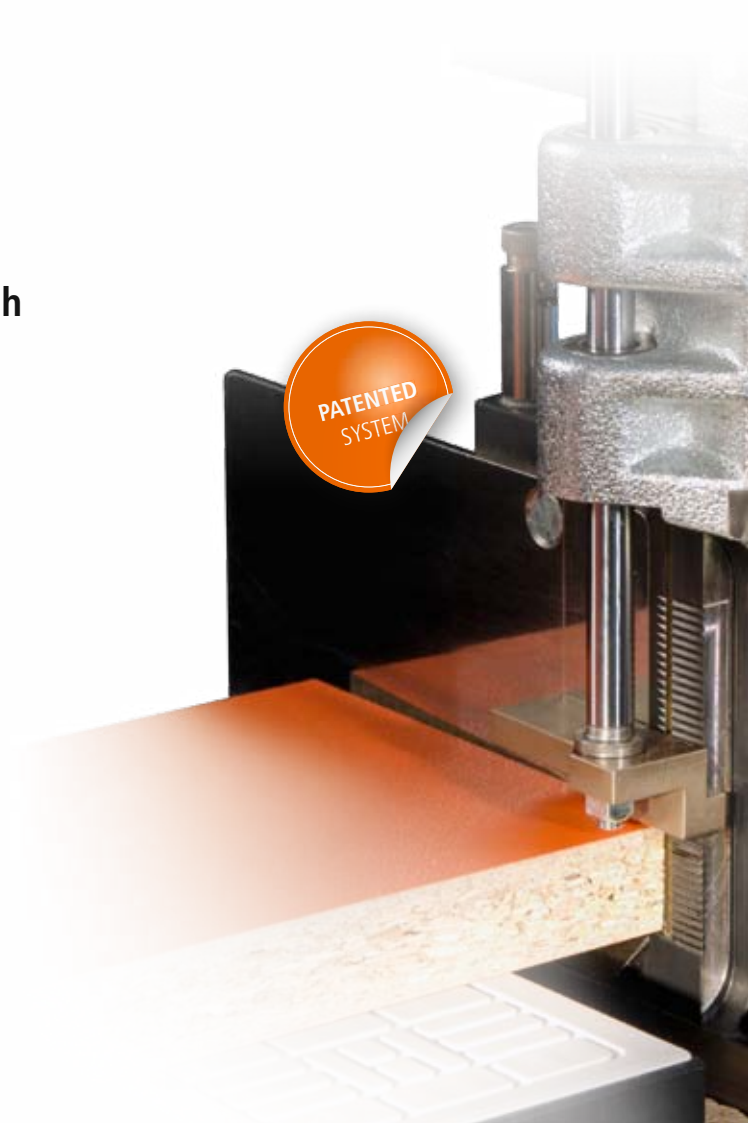


**Glue change\***  
3 minutes

\* to PUR glue, to EVA glue and color change



**Cleaning**  
3 minutes





## PUR Glue is the Standard for Professional Cabinet Makers

Industrial technology for small shops – with the HOLZ-HER Glu Jet system, you can process PUR glue on a standard basis; just as simply as EVA glue. Strong arguments for you and your customers:

- No glue pots.
- No expensive nitrogen tanks.
- High strength joint for extremely long service life.
- Resistant to heat and water, providing quality advantages in all areas of cabinetmaking.

Video  
Glu Jet



Invisible joints

Video  
Glu Jet



Functional principle

**Waterproof PUR glue – ideal for kitchen and bath furniture.**





# Glu Jet XL – Edgebanding at the Highest Level

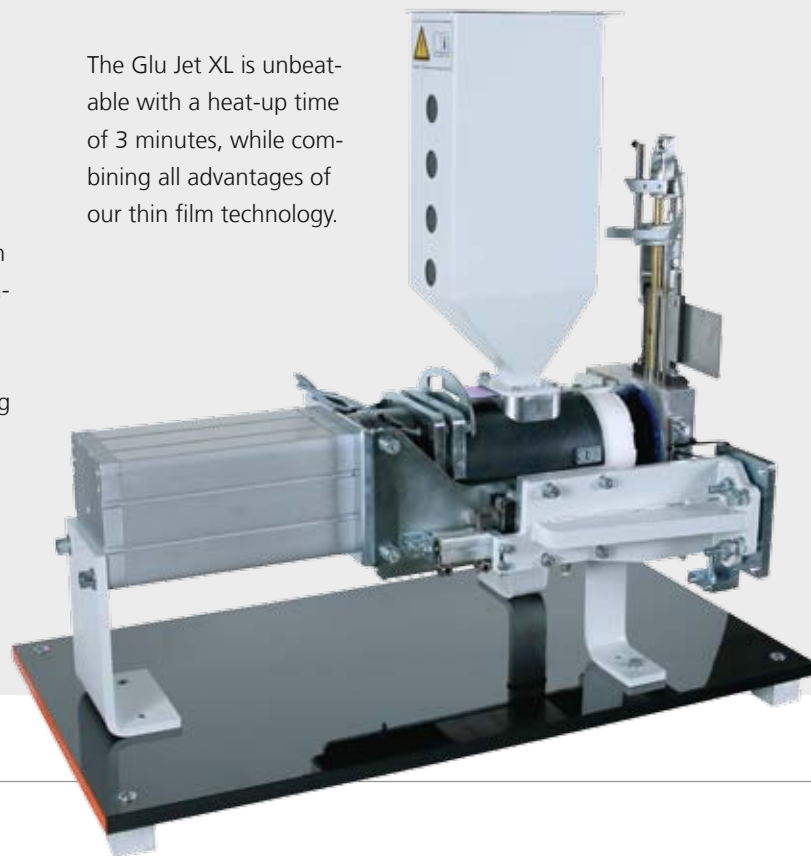
## Glue Application System for PUR

For the ACCURA series HOLZ-HER offers the Glu Jet XL with greater melting capacity for even higher feed rates.

With the Glu Jet XL, users can process 2 kg PUR glue cartridges (Fig. 3, below), which are significantly more economical than conventional PUR granules.

This investment is clearly worthwhile beginning at consumption rates of approx. 400 kg of PUR glue per year, or approx. 2 kg per day. The savings for glue costs alone already amortize the machine during the second year.

The Glu Jet XL is unbeatable with a heat-up time of 3 minutes, while combining all advantages of our thin film technology.



## Glue Granules

Naturally, the station can also be used for processing glue granules (Fig. 1) making it extremely flexible for HOLZ-HER customers and offering every user major competitive advantages.

Cleaning the system is child's play with standard PUR cleaners (Fig. 2) using an automatic cleaning program integrated into the control.





## Even More Flexibility with Double Gluing Station

The generous entrance area on the ACCURA allows a second Glu Jet for a double gluing station in addition to the classic Glu Jet station. This allows realization of applications possible only with high set-up times until today. PUR and EVA glue can be selected on the touch screen. While one gluing station is working, the other is automatically retracted and can then be put back into operation at the touch of a button.

The highly popular combination of neutral and colored glue is also possible. Finally, special nozzles for use on thick solid wood edges can be combined with thin film nozzles for a zero joint appearance. These are also ready for use after a heat-up time of only 3 minutes.

Perfect flexibility saves time:

- EVA and PUR glue continuously available for change-over.
- Neutral and/or colored glue continuously available for change-over.
- 2 kg PUR glue (Glu Jet XL) and Glu Jet.
- Glu Jet with thin film technology combined with solid wood nozzle for edge cross sections of 20 x 65 mm.



Edge Control Touch –  
high standards for future-proof design.

## Edge Control Touch

The HOLZ-HER Edge Control Touch provides extremely high performance and is exemplary for its simple operation. Ergonomic, simple and uniform tablet design.

### Display

- 18,5"-touch screen with 16:9 format.
- Brilliant graphic display of machining process
- Simple operation – rotating and swiveling control panel at eye height.

### Operation

- Electronically controlled set-up processes with 100 percent repetition accuracy.
- Clear and complete acquisition of all operating data: Total running meters, total parts, total hours with reset.
- Custom user management with password protection and single authorization.

### Equipment/Service

- Network connectivity.
- Online maintenance, rapid exchange of data with HOLZ-HER service department.
- Barcode interface for automatic program call-up.
- External USB port for data backup and system updates.
- Connection to HOLZ-HER process data acquisition system for direct read-out of operating data (optional).



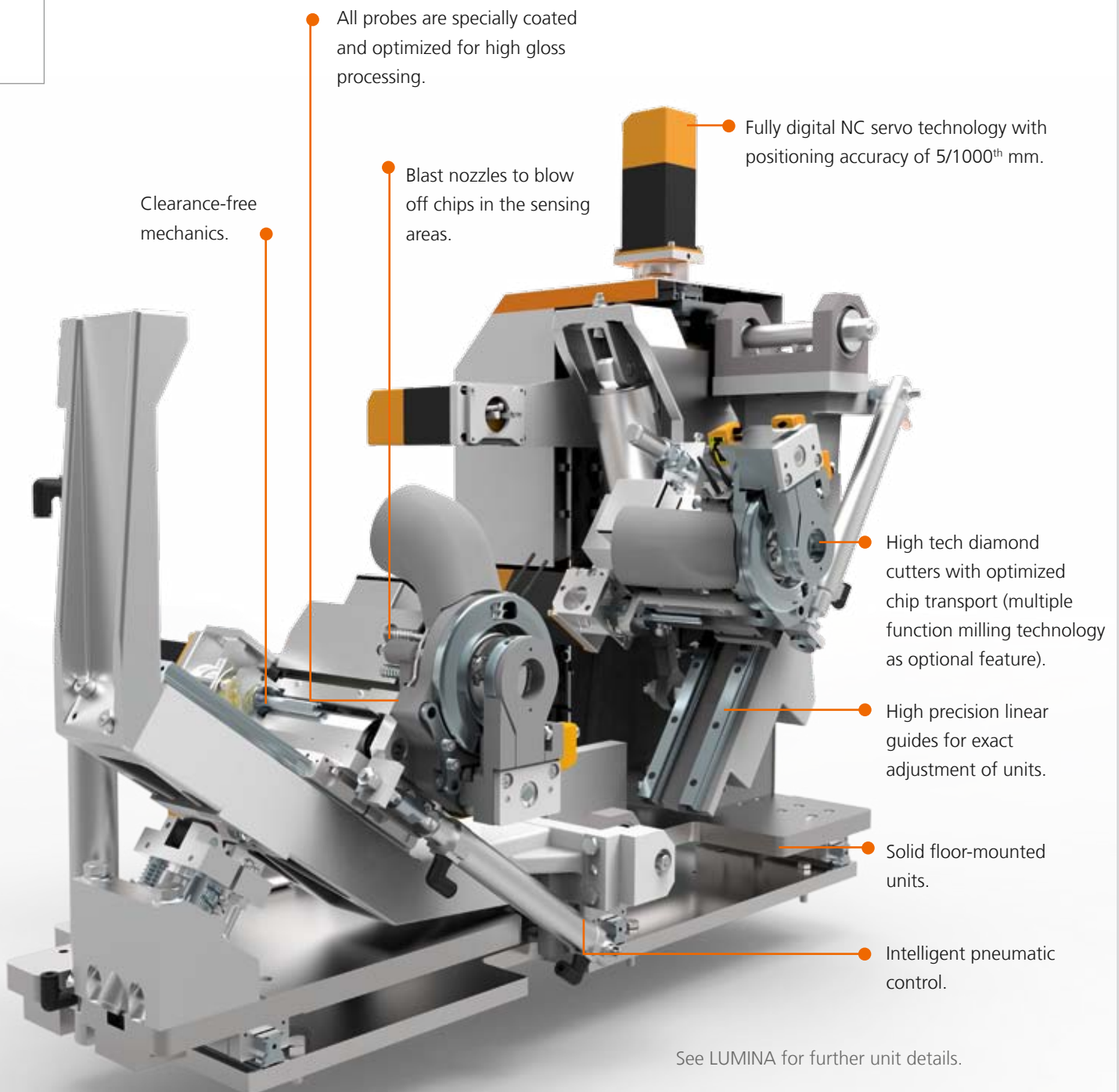
Rotating and pivoting control panel.



# Units for 100 Percent Repetition Accuracy!

All units must satisfy maximum requirements right down to the last detail to obtain the same, precision results repeatedly at high processing rates. The shaping cutter unit is an example of what is important.

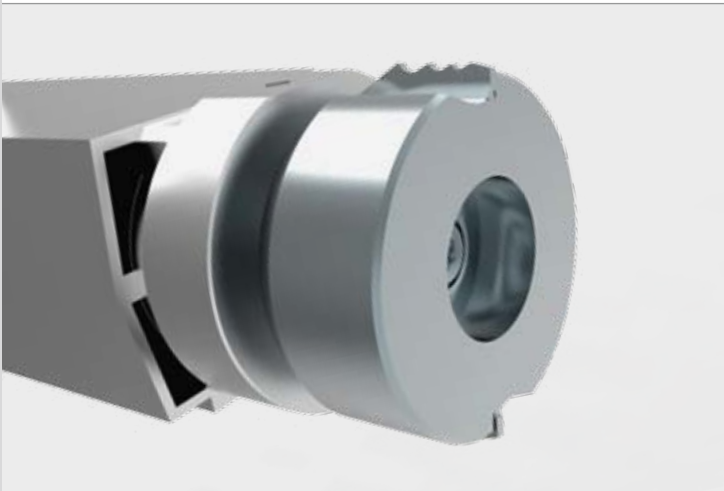
Because 100 percent repetition accuracy is highly significant for professional edgeworking.



See LUMINA for further unit details.

# Multifunctional Package (Option)

The multifunctional package for cutting, corner copying and radius scraping provides a perfect appearance for all your normal edgebanding processes, such as flush cutting, varying radiuses and chamfers. Tool-changing is a completely automatic process via the NC servo-axes, multistage tooling technology and zero-clearance mechanisms for maximum precision.

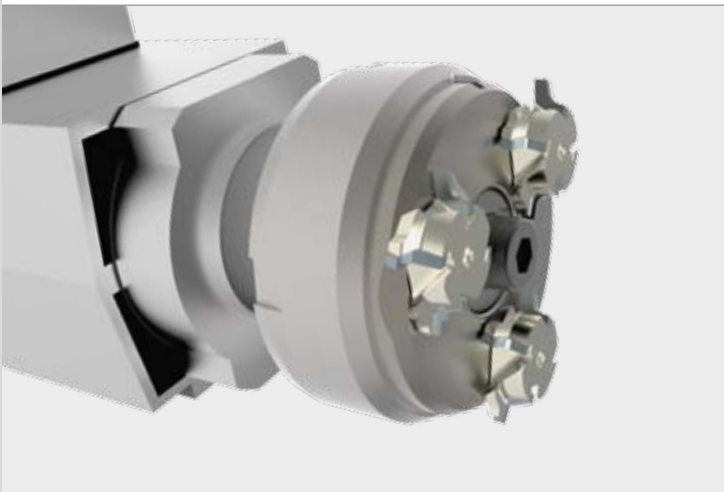


## Multistage Cutter Unit

With 6 NC servo-axes and diamond combination tool.

- Radius 1.3
- Radius 2 (double)
- Flush up to 8 mm
- Bevel 45°

Other tool configurations available on request!

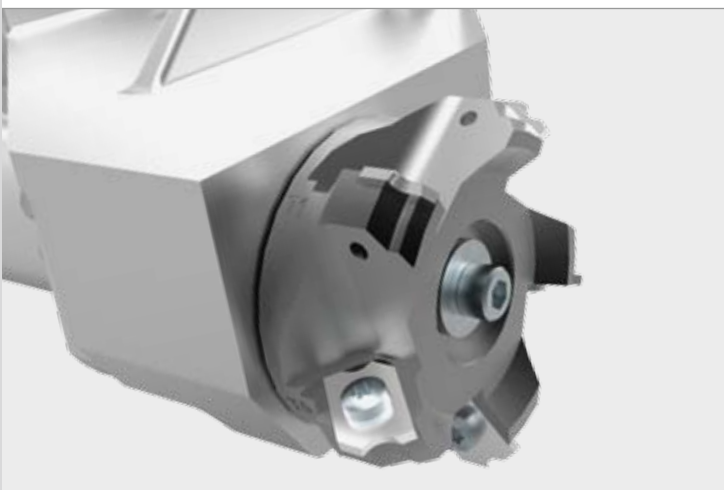


## Revolving Cutter Unit – quattro <sup>Form</sup>

With 6 NC servo-axes and diamond revolving tool.

- Radius 1.3
- Radius 2 (double)
- Chamfer 45°

Other tool configurations available on request!



## Revolving Scraper Unit

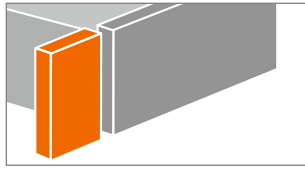
With 8 NC servo-axes and HW standard scrapers on a fully automated 5-position revolving tool.

- Radius 1
- Radius 1.3
- Radius 2 (double)
- Chamfer 45°

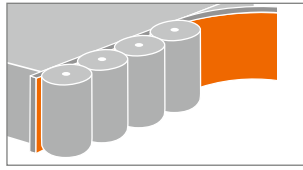
Other tool configurations available on request!

# Adaptive Package

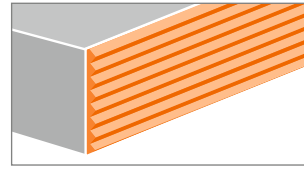
Adaptive pressure and glue quantity control for intelligent automation (optional).



Adaptive trimming blade



Adaptive pressure unit



Automatic glue quantity control

## Simple Handling – High Productivity

### ■ Workpiece Support

Extremely stable, extending workpiece support, completely self-supporting and thus independent of irregularities in floor (optional) (Fig. 1).

### ■ 6-fold Edging Feed

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

### ■ Air Cushion Table

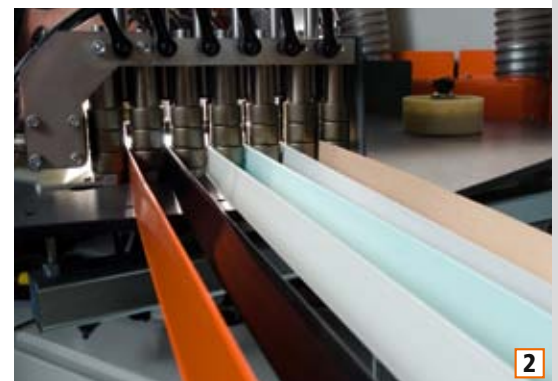
For easy and careful handling – even with bulky work pieces (optional) (Fig 3).

### ■ Nesting Package

For concealed hinge holes or trapezoidal work (optional) (Fig. 4).

### ■ Transport Chain Lubrication

Intelligent automatic transport chain lubrication. Sensor-controlled unit, for metering lubrication to match load (optional).



# Tool Versions for ACCURA 15 Series

Maschine	ACCURA 1554 automatic	ACCURA 1556 premium	ACCURA 1556 grooving	ACCURA 1556 flex	ACCURA 1558 performance	Options
Control	18,5" Touch screen	18,5" Touch screen	18,5" Touch screen	18,5" Touch screen	18,5" Touch screen	
Bridge	Roller bridge*	Roller bridge*	Roller bridge*	Roller bridge*	Belt bridge	*Belt bridge
Edge feeder	SYNCHRO*	SYNCHRO*	SYNCHRO*	SYNCHRO*	SYNCHRO*	*6-fold magazine
Joining	60 mm*, Ø 70 mm	60 mm*, Ø 70 mm	60 mm*, Ø 70 mm	60 mm*, Ø 70 mm	60 mm MOT 2, Ø 100 mm	*60 mm MOT 2, Ø 100 mm
Glue application	<b>Glu Jet*</b> automatic	<b>Glu Jet*</b> automatic	<b>Glu Jet*</b> automatic	<b>Glu Jet*</b> automatic	<b>Glu Jet*</b> automatic	* <b>Glu Jet</b> XL PUR unit (2-kg cartridge)
Glue application	*	*	*	*	*	* <b>Glu Jet</b> double gluing station
Pressure unit	4 motor-driven rollers	4 motor-driven rollers	4 motor-driven rollers	4 motor-driven rollers	4 motor-driven rollers	
End trimming	15 mm*	15 mm*	15 mm*	15 mm*	15 mm*	*20 mm with solid wood package
Cutter 1	x	Flush 15 mm*	x	x	Flush 15 mm*	*+ MOT versions (20 mm)
Cutter 2	Radius 2 mm*	Radius 2 mm*	Radius 2 mm*	Radius 2 mm*	Radius 2 mm*	
Corner copying	60 mm, MOT 4*	60 mm, MOT 4*	60 mm, MOT 4*	60 mm, MOT 4*	60 mm, MOT 4*	*Multifunctional package for cutting, corner copying and radius scraping
Radius scraper	MOT*	MOT*	MOT*	MOT*	MOT*	
Flat scraper	Application controlled*	Application controlled*	Application controlled*	Application controlled*	Application controlled*	*With pre- and post-sensing
Buffing	Application controlled*	Application controlled*	Application controlled*	Application controlled*	Application controlled*	*Oscillating
Corner buffing	x	x	x	Application controlled	Application controlled	
Grooving	x	x	MOT 2	x	*	*MOT 2
Spraying device						

Standard

Optional

x

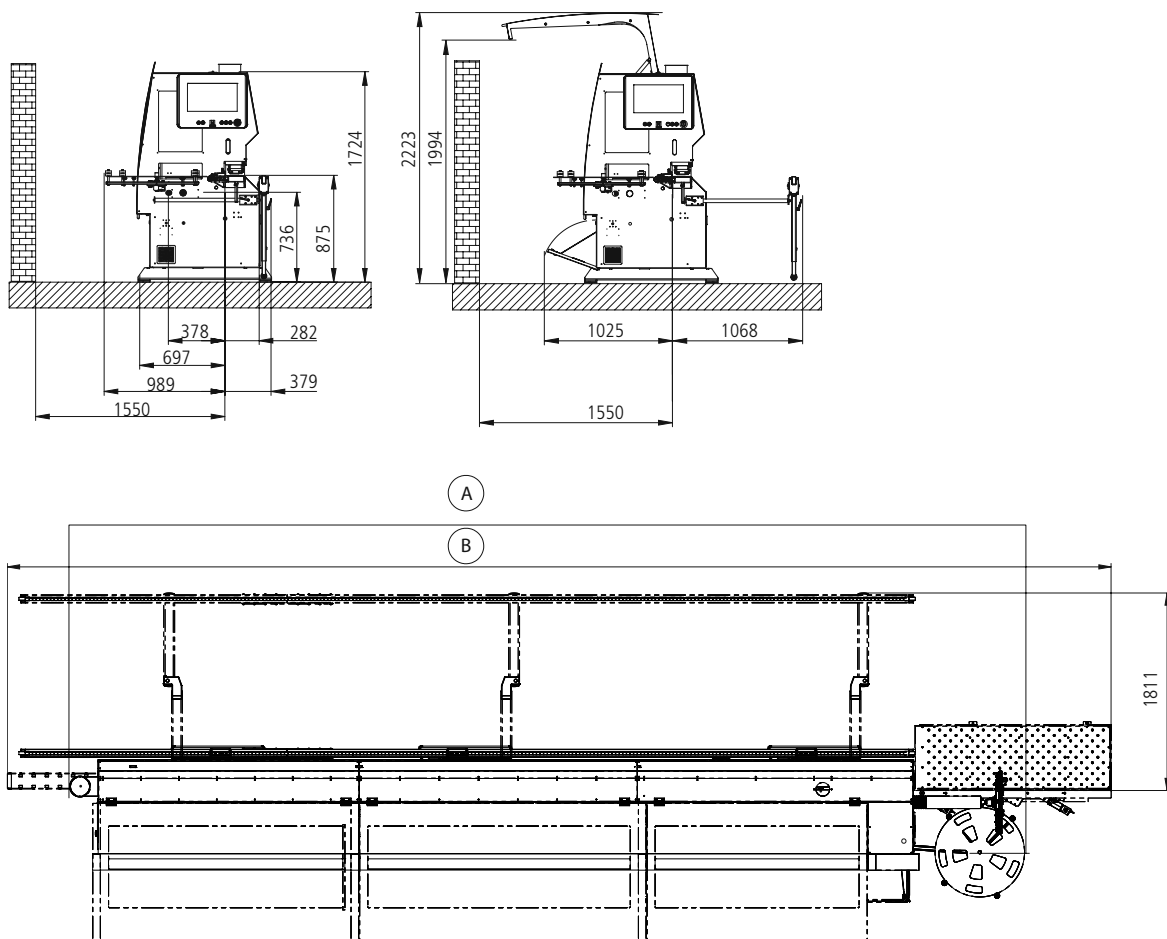
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Free space

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.

	ACCURA 1554 automatic	ACCURA 1556 premium	ACCURA 1556 grooving	ACCURA 1556 flex	ACCURA 1558 performance
<b>Technical Data</b>					
Overall length A (mm)	7540	8085	8085	8085	8755
Total length with air cushion table and extended discharge B (mm)	8990	9450	9450	9450	10120
Width x height (mm)	1368 x 2223	1368 x 2223	1368 x 2223	1368 x 2223	1368 x 2223
Weight (kg)	2750	3000	3000	3000	4200
<b>Feed Rate</b>					
Feed speed (m/min)	10–20 (25)	10–20 (25)	10–20 (25)	10–20 (25)	10–25
<b>Working Dimensions</b>					
Minimum workpiece length (mm)	140	140	140	140	140
Minimum workpiece width (mm)	60	60	60	60	60
Workpiece thickness (mm)	8–60	8–60	8–60	8–60	8–60
Edge width (mm)	0.4–8 (12)*	0.4–15	0.4–8 (12)*	0.4–8 (12)*	0.4–15 (20)

\* with tool change





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have the right solution. No matter



how you twist and turn – we always



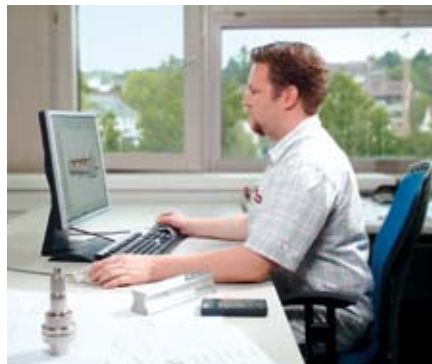
Invisible Joints. Perfect Appearance. Flexibility.

LUMINA



PRODUCTIVITY AND PRECISION





## Perfect Edgebanding is our Passion

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. Customers appreciate our capability to develop and produce excellent products quickly at equitable prices and high quality. Integrative, networked solutions are decisive for machining wood and panels worldwide.

This is why HOLZ-HER offers a line of products matched to one another and always develops a complete product series, from an entry-level machine right up through all performance ranges to the comprehensive top model.

All service activities and product training courses are planned in parallel to new products. This ensures that, in addition to being offered a new machine, customers can also take advantage of a complete range of services. This focuses on practical solutions and greater customer benefit.

Absolute precision in production  
guarantees perfect results  
for customers.



# What You Can Expect from Us

- We want to understand our customers and partners optimally and optimize and increase their success with innovative products and services.
- Close contact to our dealers as well as to final customers, cabinet makers, interior architects and industrial shops is one of HOLZ-HER's particular strengths.
- Providing excellent performance in all areas, thinking into the future, continuity and consistency in development and design, perfection in production and intensive consulting in sales and service are HOLZ-HER's focal points.
- HOLZ-HER sets trends and provides the impetus for technological development. This is the only way to meet market demands for continuously shorter development cycles and get these developments to our customers faster. This applies for mechanical systems as well as software.
- Recognizing and anticipating trends are key qualifications for strong companies like HOLZ-HER. This requires up-to-date qualifications from each and every employee. For this reason, HOLZ-HER places great emphasis on qualified training for young employees. A choice selection of courses of advanced occupational and personal training keep the learning process going.
- As a WEINIG Group company we profit from synergistic effects in development, production and sales – to the advantage of our customers.



For over 100 years HOLZ-HER employees have developed innovations, setting trends for the future.



QUALITY

# Professional Solutions for Professionals

Wherever professionals work precisely and efficiently with panel materials around the globe, machines from HOLZ-HER are in reliable use day after day. To succeed in this hard competition, we have to continue to be better than others. For HOLZ-HER employees it is simply a matter of course to take responsibility for major, complex work and pay attention to 100% quality right down to the final detail. Our staff always think and act as a partner for our customers.

Production is the heart of any industrial enterprise. Our state-of-the-art production techniques at the HOLZ-HER production facilities in Voitsberg in the Austrian State of Steiermark are decisive for high quality, flexibility and economic production costs. Keeping core competencies for production in the company is one of HOLZ-HER's top priorities. This includes, for example, our own steel construction facilities with all technical equipment – which helps us to maintain short delivery times – or our own prototype construction shop. Intensive testing right from the start ensures that the high HOLZ-HER quality requirements are always state-of-the-art. And finally a well thought through service concept for after-sales guarantees: Our customers can depend on HOLZ-HER machines right from the start as well as over their long service life.

Video  
Image





## Single-company Quality – from Steel Plate to Finished Machine

- Up to 2200 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 edgebander in all design parts relevant for rigidity.
- With a nominal pressing force of 400 tons, a number of hydraulic trimming presses ensure perfect part shape using automatic material thickness measurement and pressure control.
- The individual parts are welded together very carefully. Optimally designed welding equipment ensures high quality consistency for your machine.
- 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 equipment.
- After cleaning and painting, the frames are moved to final assembly, where all units and components are installed.
- Before packing and shipping, comprehensive final inspection is performed to guarantee highest quality standards for your machine.

## LUMINA Series

In addition to our LTRONIC and Glu Jet systems, our LUMINA series offers everything required for a professional edgebander. Up to 25 NC servo-axes for maximum automation of all machining units with exact repetition at the touch of a button. Even the pressure and glue quantity settings can be made fully automatically and adapted to the specific requirement. The HOLZ-HER LUMINA with LTRONIC laser edging unit sets the highest, professional standards for edgebanding without compromises.

- Fully automatic control of machining units at the touch of a button using NC servo-axes without opening the hood.



Video  
LUMINA



Illustrations may contain  
optional features.

- Ergonomic operation with 18.5" latest generation touch screen control in 16:9 format. Includes an intelligent edging library for rapid selection of laser edges.
- Maximum precision and processing reliability for many years with torsionally stiff, welding machine columns.



Intelligent energy management for HOLZ-HER edgebanders.



For short intervals between workpieces and optimized edge protrusions.



# HOLZ-HER Ensures Perfectly Invisible Joints

The LUMINA series offers a unique combination for panel processing:  
Two systems for perfect invisible joints.

- Our Glu Jet application system for standard use of PUR glue.
- LTRONIC, the laser edging unit from HOLZ-HER is unbeatable in terms of speed and cost efficiency.

## Glu Jet – Waterproof Invisible Joints with Thin Film Technology

Industrial technology for small shops – with the HOLZ-HER Glu Jet system, you can process PUR glue on a standard basis; just as simply as EVA glue. Strong arguments for you and your customers:

- No glue pots.
- No expensive nitrogen tanks.
- High strength joint for extremely long service life.
- Resistant to heat and water, providing quality advantages in all areas of cabinetmaking.



**Heat-up time**  
3 minutes



**Glue change\***  
3 minutes

\* to PUR glue, to EVA glue and color change



**Cleaning**  
3 minutes





> LTRONIC and GLU JET –  
for superior edge appearance.  
Unbeatable as twin pack! <



LTRONIC LASER EDGE BANDER

## LTRONIC – Perfect Invisible Joints with Laser Edging

Co-extruded and subsequently coated “Laser Edging” can be processed with LTRONIC. The NIR module in our LTRONIC unit can transfer heat energy quickly and precisely to the specific point required making it ideal for activation of function layers on laser edging.

- Visually perfect results – tone in tone with invisible joints.
- No heat-up time.
- Noiseless processing.
- No cleaning work.
- Pioneer in terms of energy efficiency.
- Completely clean postprocessing



Heat-up time  
None



Glue change  
None



Cleaning  
None





Perfect results at  
the touch of a button  
with LTRONIC.

## NIR MODULE

# Your Advantages with the NIR Module in the **L**TRONIC

### ■ Immediate Availability

No non-productive heat-up times whatsoever. Immediate availability at the touch of a button.

### ■ Noiseless Processing

LTRONIC operates without any noise emissions whatsoever and without compressed air.

### ■ High Tech Cooling from CNC Technology

The NIR module (Near Infrared Radiation) is kept at a uniform temperature by its liquid cooling system allowing continuous production without pauses for cooling.

### ■ High Energy Efficiency

The wave length of our NIR module (Near Infrared Radiation) is very close to the intensity of the diode laser allowing it to optimize its energy with the utmost precision over the entire length of the workpiece. No energy is lost during set-up times.

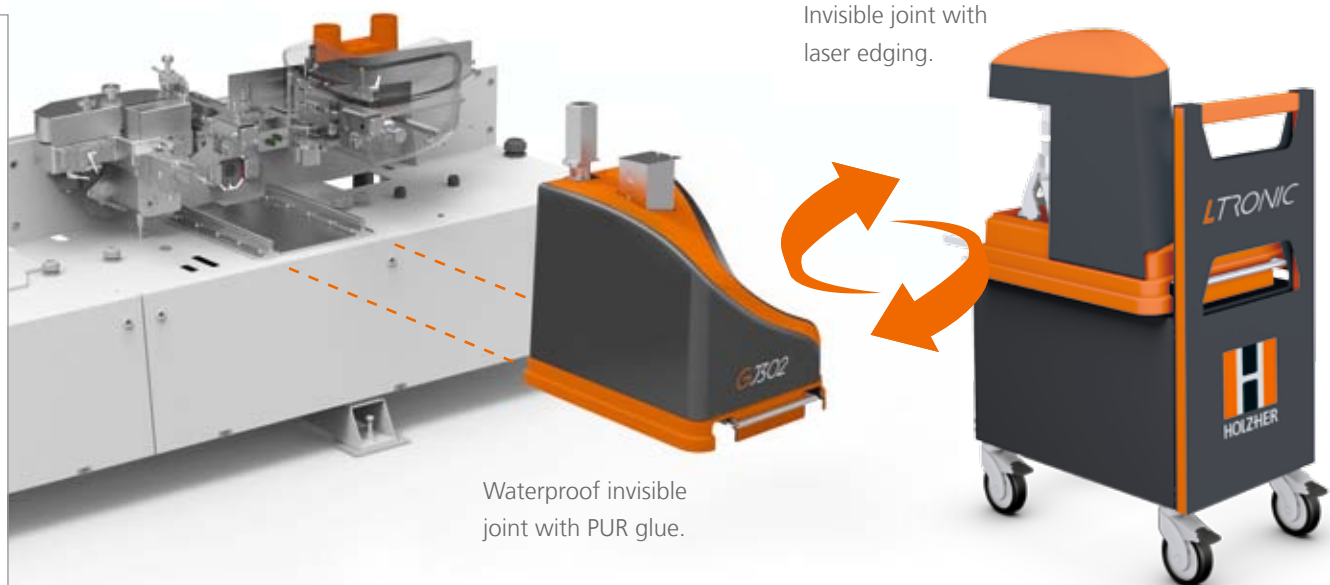


# Glu Jet and LTRONIC Changing Station

On the LUMINA users can change over from the LTRONIC to the Glu Jet unit as required within minutes using the high precision HSK interface from our CNC technology.

The LUMINA has an automatic unit recognition feature and is ready for use immediately after changing over to the LTRONIC. The change over time from edge to edge is only 5 minutes.

On the LUMINA the Glu Jet as well as the LTRONIC both have edging magazines with optimized feed angles, allowing uncompromising edging variety, stating from modern high gloss edging to thick edging cross sections in the solid wood range.



## AWARDS

2012



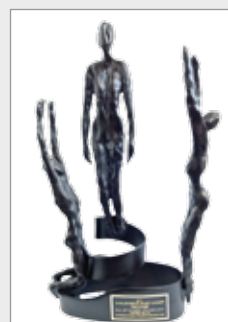
GOLD STAR AWARD  
AWISA, Sydney (Australia)

2014



GOLD STAR AWARD  
AWISA, Brisbane (Australia)

2014



CHALLENGER AWARD  
IWF, Atlanta (USA)

2014



TROPHÉE EXPOBOIS  
EXPOBOIS, Paris (France)

# Edge Control Touch

The HOLZ-HER Edge Control Touch provides extremely high performance and is exemplary for its simple operation. Ergonomic, simple and uniform tablet design.

## Display

- 18,5"-Touch screen with 16:9 format.
- Brilliant graphic display of machining process.
- Simple operation – rotating and swiveling control panel at eye height.

## Operation

- Electronically controlled set-up processes with 100% repetition accuracy.
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- Custom user management with password protection and single authorization.

## Equipment/Service

- Network connectivity.
- Online maintenance, high speed data interchange with HOLZ-HER service department.
- Barcode interface for automatic program call-up.
- External USB port for data backup and system updates.
- Connection to HOLZ-HER process data acquisition system for direct read-out of operating data (optional).

Edge Control Touch –  
high standards guarantee your  
investment for the future





Laser edging at the touch of a button.

## Edging Database

A highlight is the edging library completely integrated into the control. All of the very latest co-extruded and subsequently coated edging are already stored here as a factory-provided item and can be simply selected by the user via the standard touch screen.

Each laser edging needs a specific energy entry, which, by way of an example, depends on the edge thickness or the color. After the selection is made, LTRONIC automatically adjusts the respective energy requirement.



Rotating and pivoting control panel.



## LUMINA 1380

- Including change-over gluing unit (LTRONIC and Glu Jet).
- Variable feed 10–18 m/min.
- Your start with HOLZ-HER laser edging technology.

The LUMINA 1380 has a glue-changing unit. The LTRONIC as well as the Glu Jet application station can be attached to this machine. Perfect invisible joints with maximum flexibility and absolutely affordable technology.



## LUMINA 1584 | 1586 | 1588

- Including a glue-changing unit (LTRONIC and Glu Jet).
- Variable feed up to 25 m/min.
- Five different equipment versions for your custom processing requirements.
- Maximum degree of automation right up to continuous multifunction milling technology with multiple stage tools and revolving tool magazine; up to 5 different profiles fully automatically.

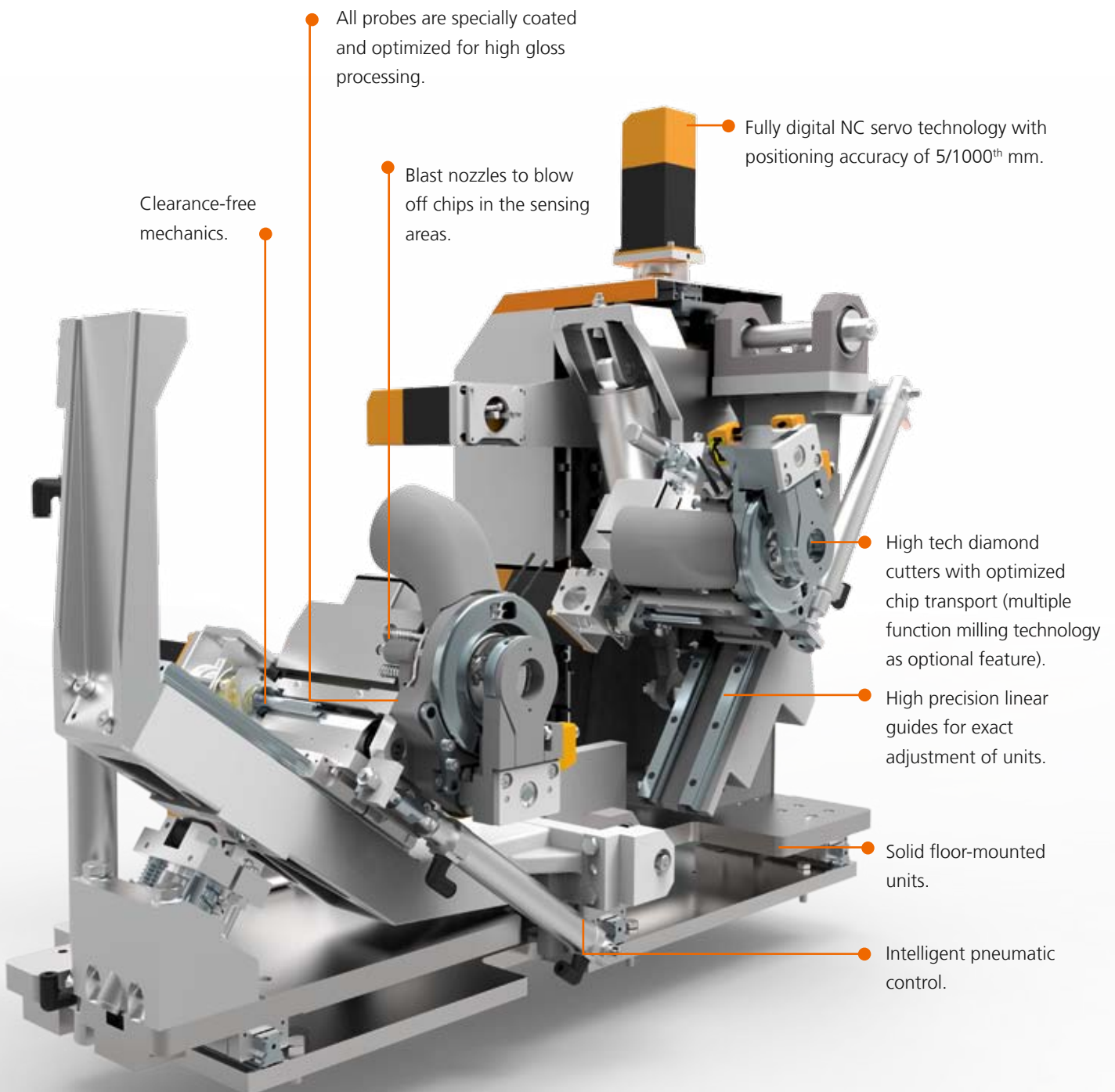


The 15 series LUMINA also has a glue-change unit. Here you can also choose between the Glu Jet and Glu Jet XL application systems. Here as well, high performance postprocessing units provide perfect results at feed rates up to 25 m/min.

# Units for 100 Percent Repetition Accuracy!

All units must satisfy maximum requirements right down to the last detail to obtain the same precision results repeatedly at high processing rates. The shaping cutter unit is an example of what is important.

Because 100 percent repetition accuracy is highly significant for professional edgebanding.



Clearance-free mechanics.

All probes are specially coated and optimized for high gloss processing.

Blast nozzles to blow off chips in the sensing areas.

Fully digital NC servo technology with positioning accuracy of 5/1000<sup>th</sup> mm.

High tech diamond cutters with optimized chip transport (multiple function milling technology as optional feature).

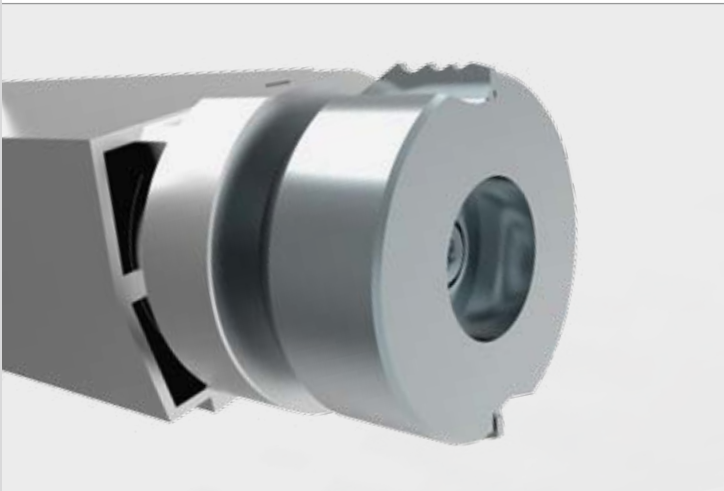
High precision linear guides for exact adjustment of units.

Solid floor-mounted units.

Intelligent pneumatic control.

# Multifunctional package (Option)

The multifunctional package for cutting, corner copying and radius scraping provides a perfect appearance for all your normal edgebanding processes, such as flush cutting, varying radiuses and chamfers. Tool-changing is a completely automatic process via the NC servo-axes, multistage tooling technology and zero-clearance mechanisms for maximum precision.

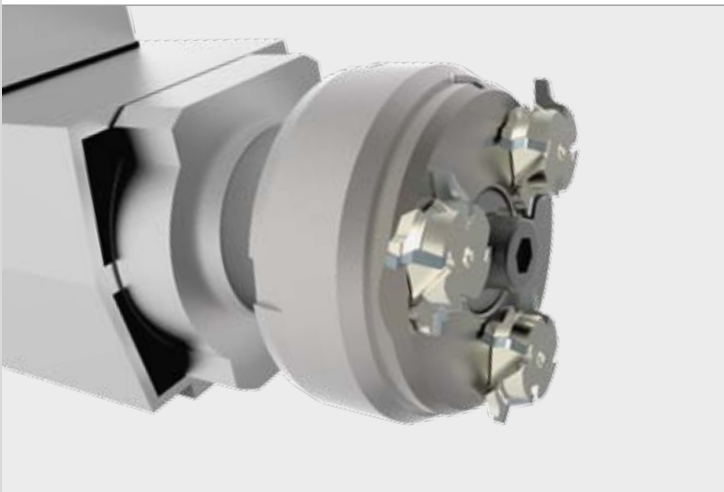


## Multistage Cutter Unit

With 6 NC servo-axes and diamond combination tool.

- Radius 1.3
- Radius 2 (double)
- Flush up to 8 mm
- Bevel 45°

Other tool configurations available on request!

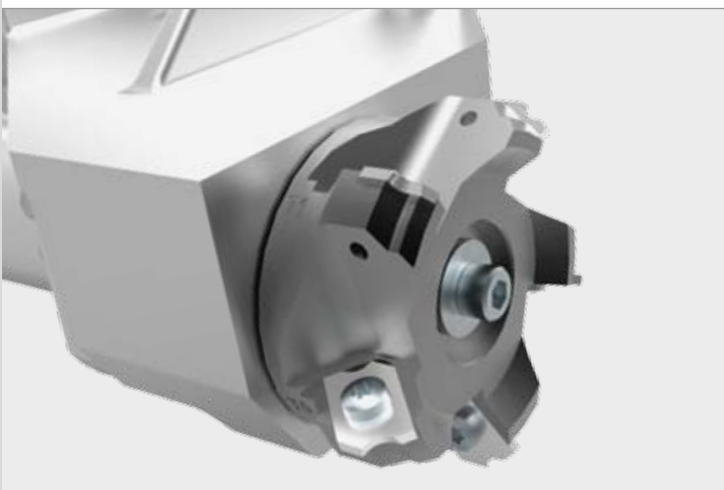


## Revolving Cutter Unit – quattro <sup>Form</sup>

With 6 NC servo-axes and diamond revolving tool.

- Radius 1.3
- Radius 2 (double)
- Chamfer 45°

Other tool configurations available on request!

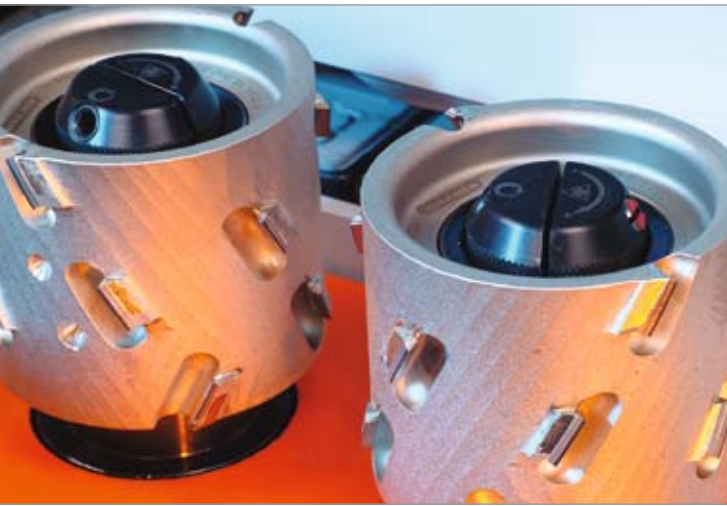


## Revolving Scraper Unit

With 8 NC servo-axes and HW standard scrapers on a fully automated 5-position revolving tool.

- Radius 1
- Radius 1.3
- Radius 2 (double)
- Chamfer 45°

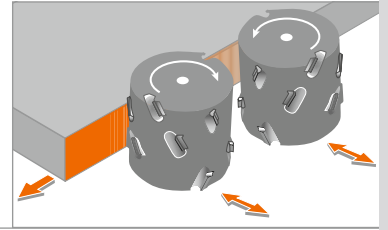
Other tool configurations available on request!



## Jointing Cutting Ø 70 mm

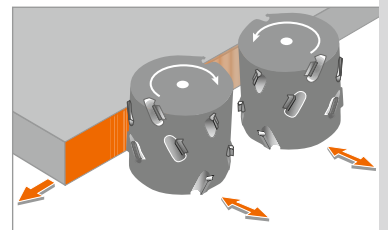
Cut edgings often have small tears in the top layer. The jointing cutter unit provides for perfect adhesive surfaces and prepares the panels for gluing. Equipped with quick-change flange ProLock and diamond tool (Ø 70 mm).

Including height adjustment for optimum utilization of cutters.



## Jointing Cutting Ø 100 mm

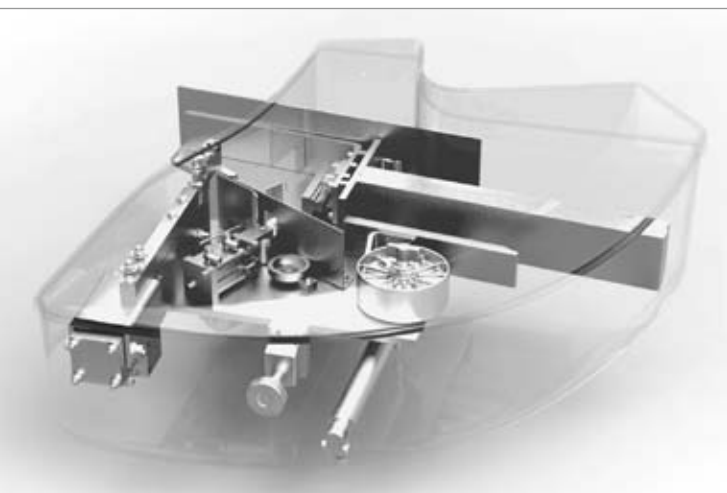
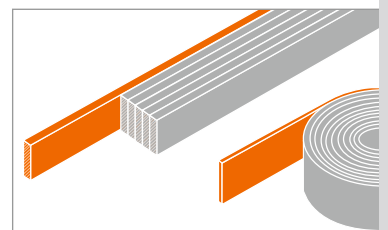
With symmetrical diamond tipped cutters (Ø 100 mm) for maximum joint quality and long service life. Automatic height adjustment with 2 NC servo-axes.



## SYNCHRO Edging Feed

The edging magazine with SYNCHRO drive. With its synchronous adaptation to the feed rate, this edge feeder guarantees short intervals between workpieces and simultaneously optimizes edging protrusions.

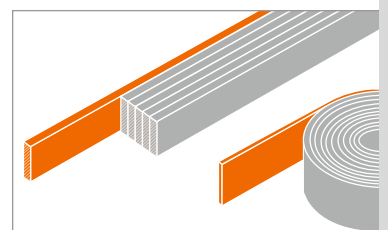
Small feed angle thanks to nozzle design – easy feeding of solid wood edging up to 15 mm (20 mm as optional feature).



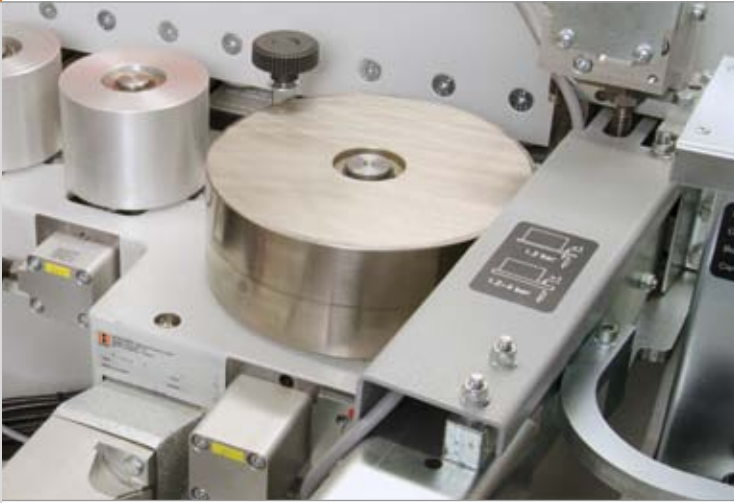
## LTRONIC/Glu Jet Edging Magazine

The special LUMINA edging magazine combines the unique, acute feed angle of only 7 degrees for extreme edging cross sections in the solid wood range with optimum feed angle for activating laser edging.

SYNCHRO drive, automatic edging separation as well as automatic edge monitoring are all standard features.



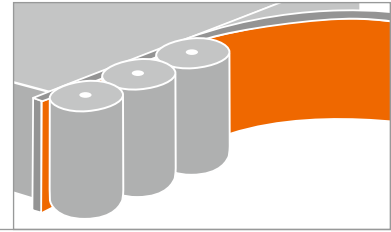




### Motor-driven Pressure Unit (3 Rollers)

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

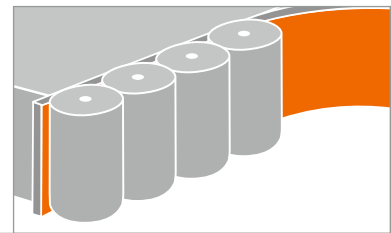
Straight and tapered pressure rollers for perfectly glued joints.



### Motor-driven Pressure Unit (4 Rollers)

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

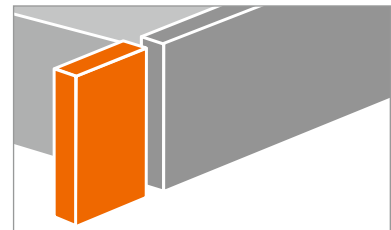
Straight and tapered pressure rollers for perfectly glued joints.



### Trimming Unit (up to 12 mm)

For straight or chamfered trimming on thin edging; a standard feature allows this unit to be pivoted to 10 degrees pneumatically. High quality version with stable cast iron pillars.

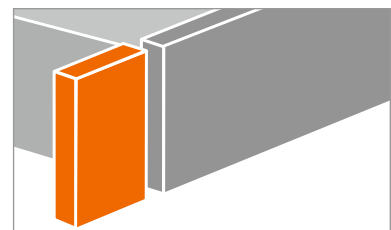
Sawing motors each with 2 guides for precisely trimming off protruding edging.



### Trimming Unit (up to 15 mm)

With hardened linear guides for high precision trimming results up to edging thicknesses of 15 mm; pneumatic pivoting to 10° as standard feature.

(20 mm with solid wood equipment).



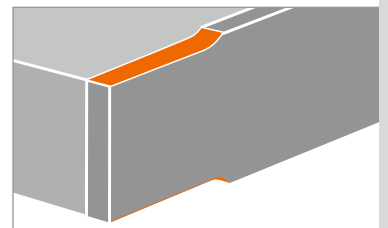


# Convincing Cutting Results on Edging with Thickness up to 20 mm



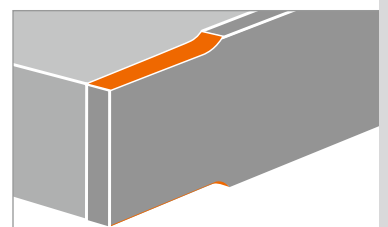
## Flush Cutting Unit (up to 15 mm)

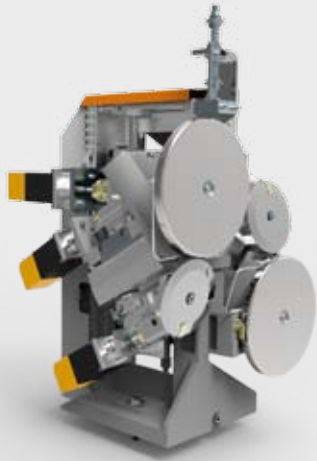
High performance cutter unit for edge thickness up to 15 mm.  
Optional: 2 NC servo-axes for cutting work with and without edge protrusion.



## Flush Cutting Unit (up to 20 mm)

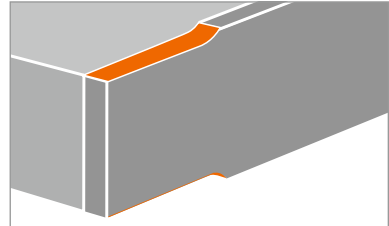
High performance cutter unit for edge thickness up to 20 mm.  
3 NC servo-axes for cutting work with and without protruding edging, as well as motor-driven horizontal adjustment for optimal cutter utilization (optional).





## Cutter Unit

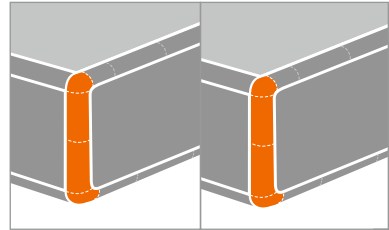
Heavy-duty floor-mounted unit with shock-absorbing bearing and large sensing rollers for perfect results even at high feed rates. 100 percent repetition accuracy at the touch of a button based on zero-clearance mechanisms and 6 high precision NC servo-axes. Horizontal sensing with angular sensing rollers developed especially for processing modern, high gloss edging. Multiple function milling technology as optional feature.



## Shaping Cutter Unit

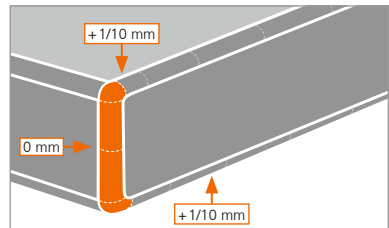
Unit adjustment on linear guides. With standard blast nozzles in front of sensing rollers to blow away chips in front of sensing areas. Including shelf program for optimum processing of shelves with rounded edges.

With optional, automatic revolving tool magazine.



### ■ Pendulum Sensor

Automatic pendulum sensor copies rear without material protrusion and leaves the optimum edge protrusion for the longitudinal edge for subsequent machining with the radius scraper.




 LUMINA satisfies all  
 machining desires. 

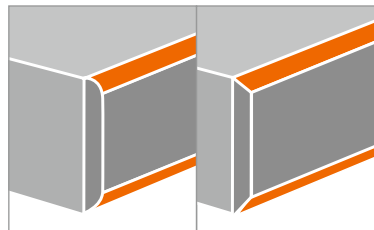




### Scraper Unit (MOT 4)

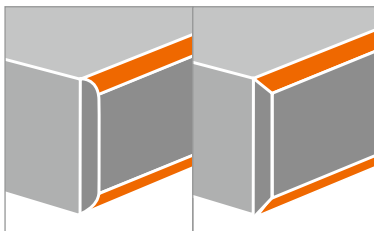
For perfect smoothing of radiuses and chamfers on plastic edging.

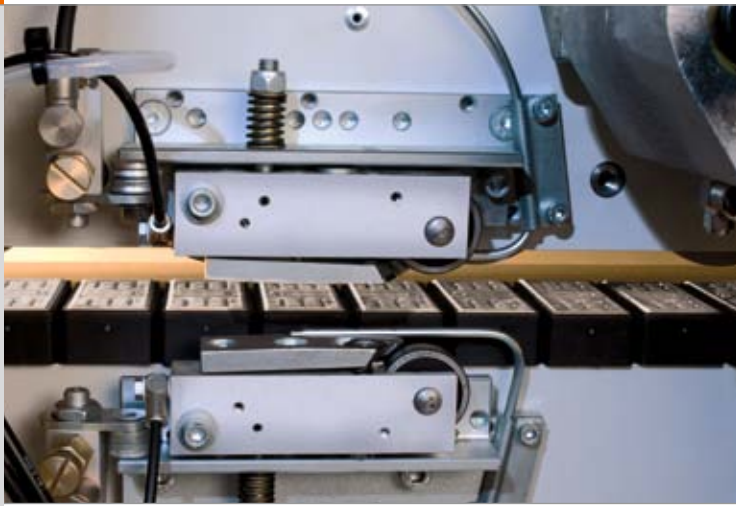
With 4 NC servo-axes for exact adjustment of tool depth when using high gloss panels with protective foil.



### Scraper Unit (MOT 6)

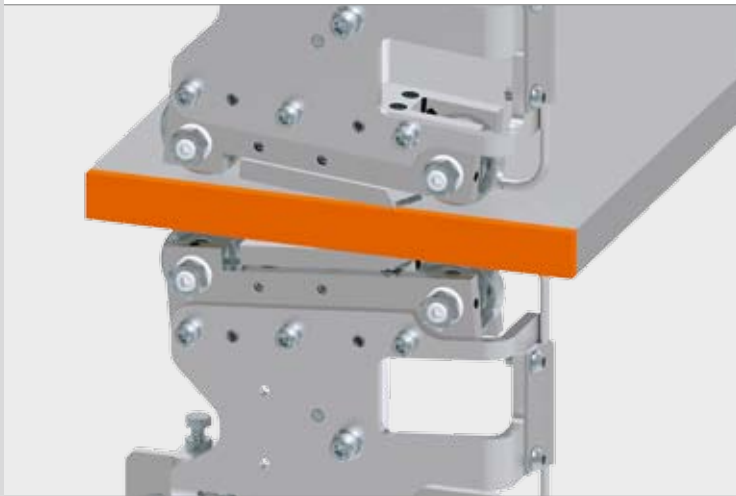
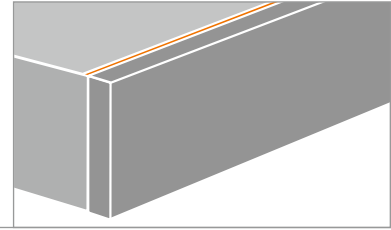
100 percent repetition accuracy at the touch of a button based on zero-clearance mechanisms and 6 high precision NC servo-axes. Including high gloss package for exact adjustment of tool depth when using high gloss panels with protective foil as well as sensing rollers with chemical nickel plating. With optional, automatic revolving tool magazine.





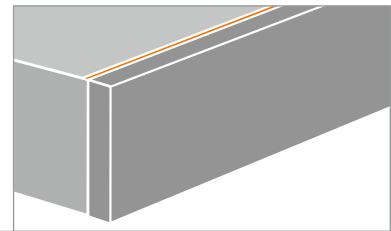
### Flat Scrapers (application controlled)

Clean post-processing of surfaces. Application controlled with 2 HW cutting edges, for use on 4 sides. Completely eliminates all manual finishing.



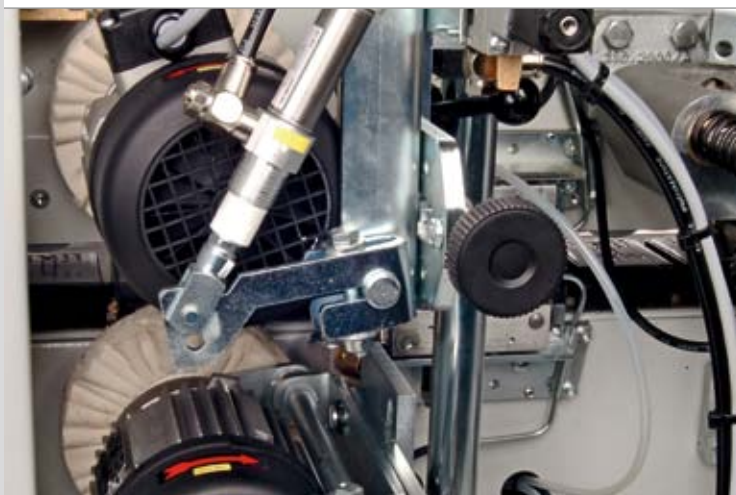
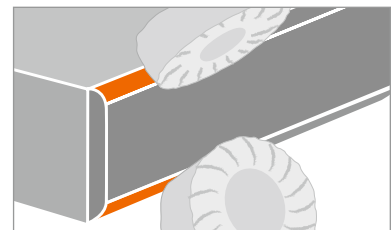
### Flat Scrapers (pre- and post-sensing)

Clean surface finishing with pre- and post-sensing for high feed rates. 2 HW cutting edges, for use on 4 sides. Completely eliminates all manual finishing. Both units can be lifted automatically for special applications.



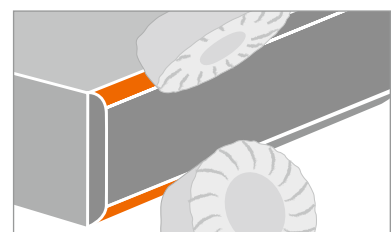
### Buffing Unit

Polishing for maximum gloss; for complete finishing.



### Buffing Unit (application controlled)

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

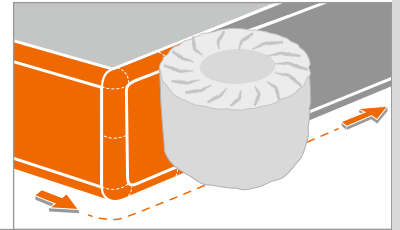






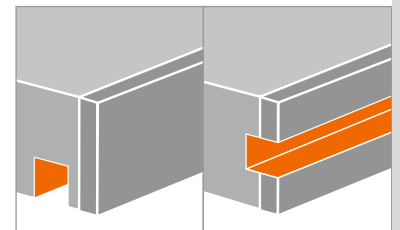
## Corner Buffing Unit

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



## Grooving Unit (forward direction)

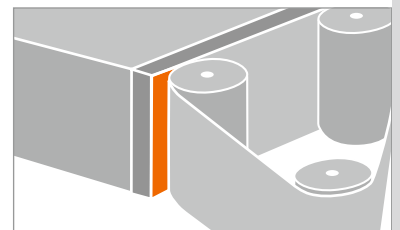
With 2 NC servo-axis for groove depth adjustment as well as groove position above control panel as a standard feature. Pivots 0–90 degrees including grid holes at increments of 11.25 degrees. Including plunge control. Optimum chip collection with blast nozzle and optional post-evacuation hood.



## Oscillating Sanding

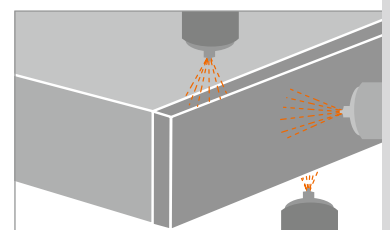
Oscillating sanding unit with NC servo-axis for overall horizontal control as well as for motor-driven downfeed to increase sanding pressure. The perfect finishing for your solid wood or veneer edging.

On request only.



## Spraying Devices

Spraying units for parting agents and cleaning agents for feed and discharge 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.







# Perfectly Equipped Down to the Last Detail

## ■ Air Cushion Table

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

## ■ Workpiece Support

Extremely stable, extending workpiece support, completely self-supporting and thus independent of irregularities in floor (optional) (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 (optional) (Fig. 3).

## ■ 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. 4).

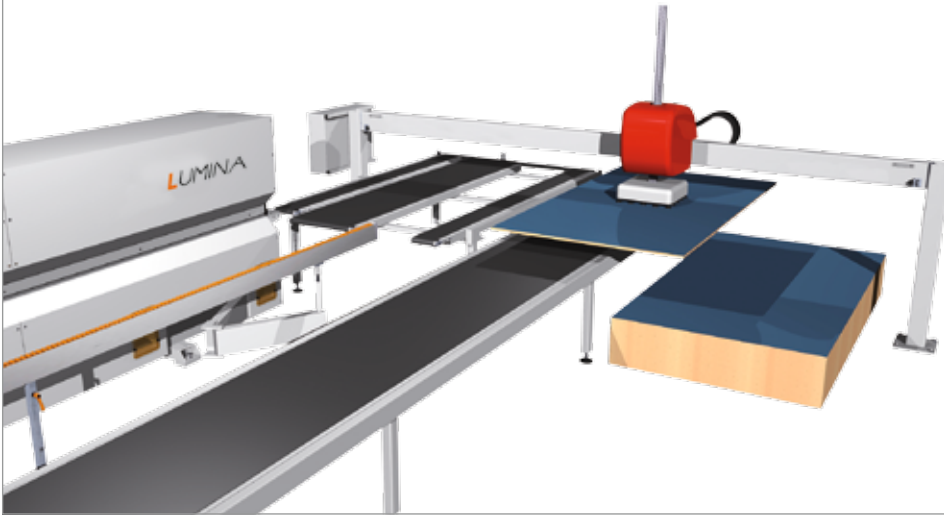
## ■ Glu Jet Catch Reservoir

For clean and convenient flushing (Fig. 5).



# Intelligent Return System

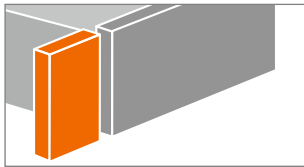
- With 90°/180° rotation unit.
- Stacking and nesting.
- For increased efficiency.



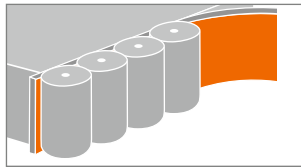
## Adaptive Package

The optimized, automatic control for the extensive pressure adjustments with plausibility checks allows HOLZ-HER to realize automatic glue quantity control matched to the specific requirements. Moreover, an adaptive trimming blade automatically adapts the pressure of the trimming blade to the edge thickness.

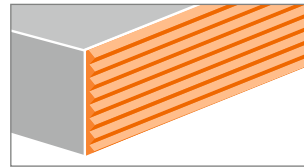
Also included is an adaptive pressure unit for optimum adjustment of the pressures of the individual pressure rollers to the specific application for perfect results every time. This reduces adjustment errors and reject quotas to a minimum (optional).



Adaptive trimming blade



Adaptive pressure unit



Automatic glue quantity control



› The adaptive package reduces adjustment errors and reject quotas to a minimum. ‹

## Equipment for **LUMINA** 1380

Machine	LUMINA 1380	Options
Control	18,5" Touch screen	
Bridge	Roller bridge	
Edge feeder	<b>LTRONIC</b> /SYNCHRO	
Jointing	60 mm	
Exchange unit 1	<b>LTRONIC</b> with NIR*	* <b>LTRONIC</b> with NIR <sup>plus</sup>
Exchange unit 2	<b>Glu Jet</b> automatic	
Pressure unit	3 motor-driven rollers	
End trimming	Two-motor 12 mm	
Cutting	Multifunction MOT 6	
Corner copying	Two-motor, 60 mm, MOT 4	
Radius scraper	MOT 4, incl. high gloss package	
Flat scraper	Flat scraper (application controlled)	
Buffing	Buffing unit	
Spraying device		

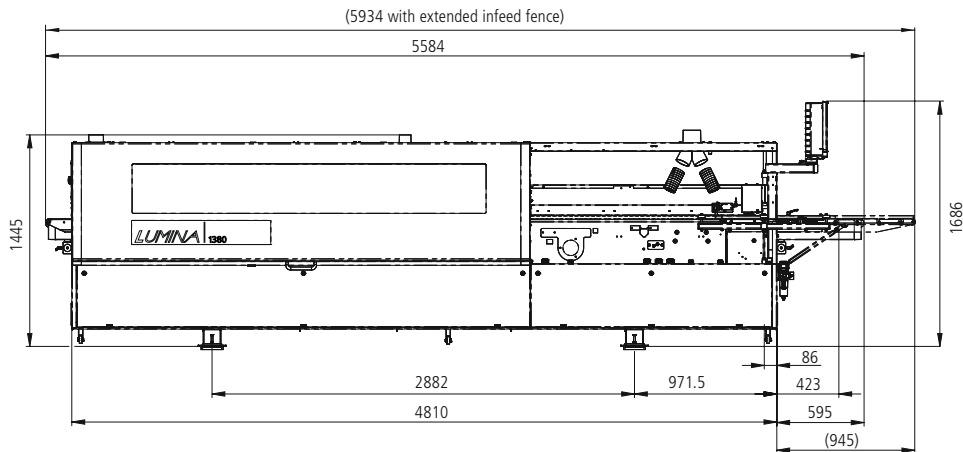
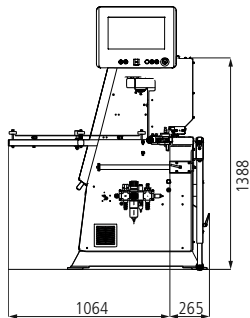
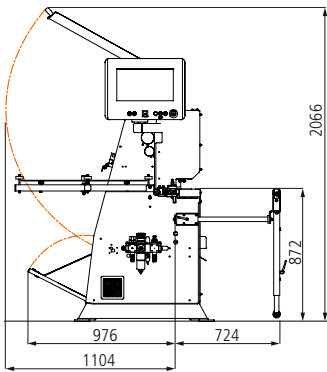
☐ Standard
 ☐ Optional
 ☐ Free space



# TECHNICAL DATA

	LUMINA 1380 with <b>Glu Jet</b>	LUMINA 1380 with <b>LTRONIC</b>
<b>Technical Data</b>		
Overall length (mm)	5,584	
Width x height	1,329 x 2,066	
Weight (kg)	2,200	
<b>Feed Rate</b>		
Feed rate (m/min)	10–18	10–18
<b>Working Dimensions</b>		
Minimum workpiece length (mm)	160	160
Minimum workpiece width (mm)	60	60
Workpiece thickness (mm)	8–60	8–23 (45)
Edge thickness (mm)	0.4–8 (12)*	0.4–3

\*with tool change



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.

# Tool Versions for LUMINA 15 Series

Maschine	LUMINA 1584 automatic	LUMINA 1586 premium	LUMINA 1586 grooving	LUMINA 1586 flex	LUMINA 1588 performance	Options
Control	18,5" Touch screen	18,5" Touch screen	18,5" Touch screen	18,5" Touch screen	18,5" Touch screen	
Bridge	Roller bridge*	Roller bridge*	Roller bridge*	Roller bridge*	Belt bridge	*Belt bridge
Edge feeder	LTRONIC / SYNCHRO	LTRONIC / SYNCHRO	LTRONIC / SYNCHRO	LTRONIC / SYNCHRO	LTRONIC / SYNCHRO	
Joining	60 mm*, Ø 70 mm	60 mm*, Ø 70 mm	60 mm*, Ø 70 mm	60 mm*, Ø 70 mm	60 mm MOT 2, Ø 100 mm	*60 mm MOT 2, Ø 100 mm
Exchange unit 1	LTRONIC with NIR*	LTRONIC with NIR*	LTRONIC with NIR*	LTRONIC with NIR*	LTRONIC with NIR*	*LTRONIC with NIR <sup>plus</sup>
Exchange unit 2	Glu Jet* automatic	Glu Jet* automatic	Glu Jet* automatic	Glu Jet* automatic	Glu Jet* automatic	*Glu Jet XL PU unit (2-kg cartridge)
Pressure unit	4 motor-driven rollers	4 motor-driven rollers	4 motor-driven rollers	4 motor-driven rollers	4 motor-driven rollers	
End trimming	Two motor 15 mm*	Two motor 15 mm*	Two motor 15 mm*	Two motor 15 mm*	Two motor 15 mm*	*20 mm with solid wood package
Cutter 1	x	Flush 15 mm*	x	x	Flush 15 mm*	*+ MOT versions (20 mm)
Cutter 2	Radius 2 mm*	Radius 2 mm*	Radius 2 mm*	Radius 2 mm*	Radius 2 mm*	
Corner copying	60 mm, MOT 4*	60 mm, MOT 4*	60 mm, MOT 4*	60 mm, MOT 4*	60 mm, MOT 4*	*Multifunctional package for cutting, corner copying and radius scraping
Radius scraper	MOT*	MOT*	MOT*	MOT*	MOT*	
Flat scraper	Application controlled*	Application controlled*	Application controlled*	Application controlled*	Application controlled*	*With pre- and post-sensing
Buffing	Application controlled*	Application controlled*	Application controlled*	Application controlled*	Application controlled*	*Oscillating
Corner buffing	x	x	x	Application controlled	Application controlled	
Grooving	x	x	MOT 2	x	*	*MOT 2
Spraying device						

Standard
Optional
x
Not available
Free space



	LUMINA 1584 with <b>Glu Jet</b> automatic	LUMINA 1586 with <b>Glu Jet</b> premium	LUMINA 1586 with <b>Glu Jet</b> grooving	LUMINA 1586 with <b>Glu Jet</b> flex	LUMINA 1588 with <b>Glu Jet</b> performance	LUMINA with <b>LTRONIC</b>
<b>Technical Data</b>						
Overall length A (mm)	7540	8085	8085	8085	8755	
Total length with air cushion table and extended discharge B (mm)	8990	9450	9450	9450	10120	
Width x height (mm)	1368 x 2223	1368 x 2223	1368 x 2223	1368 x 2223	1368 x 2223	
Weight (kg)	2750	3000	3000	3000	4200	
<b>Feed Rate</b>						
Feed speed (m/min)	10–20 (25)	10–20 (25)	10–20 (25)	10–20 (25)	10–25	10–20 (25)*
<b>Working Dimensions</b>						
Minimum workpiece length (mm)	140	140	140	140	140	140
Minimum workpiece width (mm)	60	60	60	60	60	60
Workpiece thickness (mm)	8–60	8–60	8–60	8–60	8–60	8–23 (45)
Edge width (mm)	0.4–8 (12)**	0.4–15	0.4–8 (12)**	0.4–8 (12)**	0.4–15 (20)	0.4–3

\* Edge dependent  
\*\* with tool change

