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PRESS RELEASE

**New CNC Machines from HOLZ-HER   
at LIGNA 2019**

It would be really difficult to imagine rational production without CNC machining centers, even in smaller carpentry workshops. HOLZ-HER offers a variety of CNC machine lines to provide the ideal solution for all users.

**Supplement to EVOLUTION 7405 doors**

The new, must-have feature for the 7405 4mat and Connect is the optional "Doors" package. It allows complete machining of door leaves with a maximum thickness of up to 70 mm. The optional EVOLUTION door package, consisting of a specially developed angle gear for lock boxes and a lock box cutter, expands the capabilities of this vertical CNC machine from HOLZ-HER. The door package allows complete machining of door leaves with a maximum thickness of up to 70 mm. This process machines the hinge side and lock side in two clamping operations. The 16 mm diameter end mill cutter supplied with the machine provides for milling depths of up to 115 mm, allowing installation of lock boxes with different backsets. Handle and lock holes can also be drilled precisely using HOPS macros. After turning and reclamping the door leaf, it is possible to recess hinges for rabbeted doors as well as install concealed hinges or fittings for object doors.

**The new EVOLUTION xcut package –   
for simple production of furniture components**

Vertical CNC machining with our "best performers", the EVOLUTION 7402 and 7405 Connect: The EVOLUTION models offer complete, versatile and universal machining on all 4 edges in spite of their extremely low space requirement in your workshop.

**The latest** feature on all EVOLUTION models is the Laser Plausibility Check. Here the exact height of the workpieces is read out of the machining program. This value is checked by a quick test run in the machine and any deviation in the tolerance is output as an error message. This accessory feature prevents operating errors and helps minimize material waste in your workshop.

**At the LIGNA**, HOLZ-HER will be introducing its xcut package as a **new feature** for the EVOLUTION models. With this package the vertical CNC machines automatically produce the required workpieces from panel strips previously cut in the longitudinal direction. This xcut mode completely eliminates cross-cuts otherwise required. The machine operator simply activates the xcut mode with a single click and positions the requested panel strips. The suction cups are automatically positioned on the machine, the material-friendly vacuum is activated and the machine started. During this machining process the parts are measured and subjected to a plausibility check fully automatically.

The software for the xcut mode lists all jobs pending on the machine. This provides the machine operator with a perfect overview of all jobs and the required strip material. After positioning the strip, the EVOLUTION starts its optimized cutting and four-sided formating operations. The strips are cut to the precise length, machined, and drilled as required. This process ensures that the entire surface of the panel strips is utilized optimally.

The HOLZ-HER edgebanders offer the perfect supplement to the EVOLUTION CNC machines and the SECTOR line of vertical panel saws. Together they form an efficient production cell, for optimal combination of all production sequences.

**With the HOLZ-HER 5-axis CNC machines, your creativity has no limits.**

The 5-axis, HOLZ-HER PRO-MASTER Series 7125 and 7225 machining centers offer maximum variability for universal utility. Their top equipment, fully interpolating 5-axis technology and generous machining dimensions make these power packages ideal for highly varying types of machining operations. The powerful 10 kW or 12 kW milling spindles, 4 machining areas, a completely equipped drilling head and traveling tool changer for 18 tools are only a few of the comprehensive features offered as standard equipment. The 17 kW Power Spindle with PRO-Torque technology offers a practical solution for extreme machining operations Machining lengths of 3620 mm to 7220 mm and machining depths up to 1600 mm as well as a 565 mm Z-stroke are ideal for extremely versatile machining on highly varying types of materials and shapes.

The CAMPUS/NC HOP software package supplied with the machine includes the aCADemy CAD program - also for professional data import from DWG/DXF formats – and 3D material removal simulation with collision monitoring. The open interface to NC-HOPS allows processing of real 5-axis CAD/CAM programs using a post-processor. The maximum Z-height on the PRO-MASTER 7225 is 300 mm from the top of the suction cups, giving you the capability of fulfilling virtually all customer wishes.

**NEXTEC 4.0 – The complete solution for nesting machining**

The NEXTEC nesting machining centers from HOLZ-HER include 3 lines in various sizes and degrees of automation, giving HOLZ-HER the right solution for every requirement and every size shop.

Nesting machining with the NEXTEC offers the advantage of precision formatting and CNC machining with one single clamping operation. And this with minimum handling by the machine operator. Our nesting technology is perfect for use of state-of-the-art connection technologies such has the Clamex P-System or Cabineo connectors.

The **new** **NEXTEC 4.0 solution** goes far beyond pure machining operations. It offers a complete solution for entry and control of production and material flow in the workshop. The NEXTEC 4.0 Master Computer is the heart of this technology. This additional computer takes over part design as well as control of the data and material flow during work preparation. This master computer then automatically transfers the data to the machine. The advantages are obvious: Work preparation and the machine are interlinked using cutting edge technology, while the data remains in local storage in your workshop.

With our CabinetSelect software HOLZ-HER is capable of generating CNC and cutting data for your panel furniture in the simplest manner. Over 400 furniture designs are included in the standard library on all NEXTEC machining centers.

Other professional CAD/CAM software systems can be used for even greater flexibility. Naturally, standardized interfaces are provided for transferring data to the HOLZ-HER Warehouse program.

The Warehouse program serves for managing orders using the integrated Warehouse database. Among other features, this software allows consolidation of multiple orders for production as one collective job. The integrated workpiece management list allows workpieces and their quantity to be entered and changed manually. The software also includes a material database. Data is reconciled automatically.

The job database on the machine computer serves for monitoring the orders pending for the machining center as well as the degree to which they have been processed. This provides the machine operator with a clear overview of the nesting plans to be produced. Moreover it shows the anticipated processing time, degree of processing and production time achieved.

Of course, the NEXTEC 4.0 solution is also available for the 5-axis nesting machining centers. The 5-axis head with universal mounts offers greater flexibility in designing and producing your work.

**Part marking with labeling systems from HOLZ-HER**

HOLZ-HER offers 4 different manual and automated labeling systems for marking workpieces. These labels can be adapted to customer requirements using a label configurator.

With **Easy Label** for pressure beam saws a matching label is printed for each completely formated workpiece containing edging information and barcode for CNC machining. With the popular **Touch Label System** the operator sees all the workpieces in a nesting plan on the monitor and can simply tap the desired component on the touch screen to print out the label. The fully automatic **Direct Label System** integrated into the machine offers even more convenience. With this system the labels are attached to the correct position on the panel before nesting machining.

The **Power Label System** is presented as a **new feature** in this range. It is particularly suitable for integration into the STORE MASTER automatic pallet handling system for installation above the elevating table on automated nesting systems.

**Automation PRO**

Automation PRO is the master system for control of production flow and material management in modern shops. Automation PRO ensures efficient, transparent and documented production. This solution is based on a master computer with pre-installed software and database for product control on various HOLZ-HER machines and a STORE MASTER panel storage system. Only a few clicks are required to transfer the production data from the production drawing, produced with the aid of leading CAD/CAM systems, to the production department.

Automation PRO also provides for real time communication between the panel storage system and database. It takes the current material inventory as well as reserved panel material into consideration. Naturally, it is possible to minimize the quantity of remnant panels with appropriate priorization. A preview of the job database allows an overview of activated orders and machining details, before they are released for production.

As soon as the master computer releases the order, automatically optimized cutting plans are sent to the HOLZ-HER pressure beam saw and the required panels are requested from the storage system. The workpieces can be labeled manually or automatically for part recognition. Jobs approved for HOLZ-HER Nesting CNC operations are displayed to the machine operator in a job list and the necessary material is automatically requested from the STORE MASTER system. The Job Manager provides for fully automated daily production.

Clear marking of the workpieces and further processing operations are essential particularly for collective jobs. The new HOLZ-HER Power Label System is recommended particularly for processing large quantities of panels in minimum time. The workpiece labels can contain information on the edging either in clear text or barcode. The HOLZ-HER edgebander scans the individual QR code and switches over to the required processing mode fully automatically.

To complete the Automation PRO system, the "WEINIG Machine Monitoring" app offers the possibility of checking the machine status online, calling up machine efficiency evaluations and reviewing the degree of processing for pending or completed orders. **Digitization in craft shops –  
combined with perfectly invisible joints**

Continuously higher demands for quality as well as high expectations regarding customization and versatility have made digital solutions essential in the branch today. Protracted setup operations on edgebanders can be optimized for maximum profit and productivity using intelligent technology. Properly utilized, digital processes facilitate work in craft shops and industrial applications to the maximum.

**HOLZ-HER's high end line, the LUMINA 4.0 Edition, is a burst of innovation with clear, measurable customer benefits.**

The machine simply scans the individual QR code and switches over to the required edge processing mode fully automatically. During this process, highly differing machining operations, pressure settings and various types of edging are taken into consideration automatically. This allows production of orders with highly differing lot sizes with extremely short setup times. Setup errors and reject quotas are reduced to a minimum.

The LUMINA 4.0 Edition uses patented cutters with Air Stream technology, distinguished by extremely low noise emission. Chips are evacuated with lightening speed by the integrated blast nozzles, thus eliminating double machining and significantly increasing cutter service life. Moreover the **new HSK chucks** ensure perfectly concentric operation, eliminating long-term wear to motor, bearing and cutter.

**A new feature** at HOLZ-HER is the multiple magazine, capable of feeding in laser edging as well as conventional edging fully automatically. This ensures that the proper edging material is aways selected for the operation in progress. The magazine has six different standard edging channels capable of handling all edging thicknesses and heights independently. If desired, the magazine can also be upgraded to include six additional channels for laser edging. Moreover it even offers a "joker", i.e. an additional free channel for "occasional edging". This provides absolute flexibility for smaller jobs "in between" without interrupting the established sequence for the multiple magazine. And it also allows automatic cycling between various channels, making it possible, for example, for you to fill channels 1 and 2 with identical edging material. As soon as channel 1 is empty, it switches over to channel 2 automatically, allowing continuous production without interruptions.

The "large" Glu Jet 2K was developed especially for professional processing of large quantities of granulated PUR or EVA adhesive. The Glu Jet 2K allows use of the more economical, standard, commercially available 2 kg PUR glue cartridges. This investment amortizes itself quickly for companies using more than approx. 500 kg of PUR glue per year, i.e. customers with an average glue consumption of approx. 2 kg per day. The gluing station is conceived as a change-over station with HSK adapter and can be removed with the change-over carriage, making it even simpler to clean the glue application nozzle.

Moreover, thanks to the plug & play HSK mount, it can be equipped with additional glue application stations. The innovative control recognizes the specific equipment fully automatically. If desired, an LTronic unit is also available for laser edging. This allows virtually all types of edging and adhesives available on the market to be processed in excellent quality within a maximum of 3 minutes.

**The new, intelligent operator guidance** on the LUMINA 4.0 Edition ensures even more intuitive adjustment of all cutter and shaper machining operations than in the past. At all times, the operator can identify which corrections need to be made in which direction on a graphic display. The values for tool feed entered on the control unit are converted fully automatically to the actual axis values in the background. This makes sample workpieces a thing of the past.

**"Setup in the gap"** is one of the major themes for efficient edging operations. “Set-up in the gap” enables different machining processes to be run at the same time on the edgebander. For example, the corner rounding unit or pivoting of the trimming unit can be intelligently switched on, without having to empty the machine for the set-up procedure. All capacities are therefore utilized to the fullest.

The air cushion table ensures that even heavy workpieces can be positioned in the machine easily and ergonomically. This allows the operator to concentrate on feeding the workpieces in parallel regardless of their size and weight.

**The workpiece pull-in device** also provides additional support for the operator. The feed rollers, aligned at an angle of 3 degrees, press the workpiece into the run-in linear guide precisely, ensuring optimal workpiece alignment. The small part feed also allows small and narrow workpieces to be introduced into the machine while ensuring a perfect 90 degree angle at all times. The small part feed guides the workpiece completely until it is taken over by the machine, at which time it automatically returns to the operator.

The LUMINA 4.0 Edition offers customers from craft shops and industrial production an efficient partner for easy integration into the HOLZ-HER Automation PRO concept.

**Premiere in upper middle class: Multi-function milling technology – highly efficient and affordable**

**Customers are continuously demanding more customization and material variety. Multiple profile technology is essential for modern carpentry shops to implement such demands productively and profitably.**

Since the Ligna 2019 the entire HOLZ-HER SPRINT series has offered multi-functional milling technology with multiple stage tools and revolving tool magazines. This allows machining of various radiuses or applications with a 45° bevel at the touch of a button. The new SPRINT 1329 Multi reduces your setup times enormously and even allows production of small lots at any time.

On the inside, the SPRINT 1329 Multi operates with assemblies from the high-end series with play-free mechanical systems and high precision, fully digital NC servo-axes, guaranteeing precise positioning with 100% repetition accuracy. The desired profile on the diamond, multi-stage tool can be selected on the 18.5" touch screen with wide band format. The unit then moves into position automatically. The new NC drives and play-free mechanical systems are also integrated into the dual-motor shaping cutter. The revolving tool magazine allows the shaping cutter unit to be set to a number of different profiles fully automatically. The fully automatic scraper unit performs the final machining operation. Two different profiles can be selected at the touch of a button.

Reduced setup times, exclusively excellent quality and enormous variety are natural features of this machine. The new, high performance SPRINT 1329 Multi is HOLZ-HER's answer to providing a universal, smart edgebander.

**RETURN MASTER 5920 Workpiece return for efficient one-person operation**

**Automation is becoming increasingly important even in smaller workshops, to ensure they remain competitive and operate profitably. The RETURN MASTER sets the stage for automated edgebanding, regardless of whether mass production or lot sizes of one. This HOLZ-HER return feature provides for efficient one-person operation for higher productivity and maximum flexibility.**

The 5920 RETURN-MASTER is perfectly matched to the SPRINT, ACCURA and LUMINA series edgebanders from HOLZ-HER.

The tilting air cushion table as well as the certified safety package are absolute quality features for safe workplaces. Moreover it is easy to process special parts. The pneumatic discharge table allows even larger workpieces to be removed easily by the machine operator. Drives and guides are distinguished by their extremely long service life and exceptionally low maintenance requirements. In addition to low energy requirements, a further advantage is automatic speed adaptation. Another exceptional feature of the HOLZ-HER RETURN MASTER is its particularly heavy and stable design. With a total weight of 2 tons, the RETURN MASTER sets its own standards for endurance and process reliability.

In many cases economical one-man operation allows the return feature to pay for itself within a very short time.

**The NEW ZENTREX 6215 – The next step in innovation**

HOLZ-HER presented the new power package beam saw ZENTREX 6215 to the international public for the first time at Ligna 2019. Powerful motors and an advanced linear guide concept ensure 100% cutting quality.

The new ZENTREX 6215 demonstrates the highly stable machine construction you expect from HOLZ-HER. Unique on the market: The high quality linear guide technology installed on all axes.

Infinite keyway and saw blade protrusion of 115 mm and fixed main motor with power up to 21 kW qualify this machine to take its place in industrial production as well as in craft shops. The large, 180 mm pre-scoring saw with drive power of 2.2 kW as well as the electrical fine adjustment including tool position memory satisfy all desires. The entire sawing unit can also be equipped with speed control for further applications.

The absolute highlight on the ZENTREX 6215 is the newly developed 2-stage extraction management system. Cutting-plan-controlled extraction flaps in the pressure beam, which open or close depending on the length of the cut, increase the extraction capacity at the saw blade, ensuring a clean machine table.

With scratch cuts, a controlled, moving extraction hood behind the saw blade catches chips and dust flying away to the rear during the cutting operation. This also ensures a clean support surface for scratch cuts**.**

For panel sizes, whose length is difficult to differentiate from its width in spite of 3D simulation, the ZENTREX 6215 now offers a laser positioning system with accuracy down to the millimeter. The great advantage: Re-measuring panels or incorrect positioning in the machine is a thing of the past. And the program-controlled, double lateral pressure system is also a standard feature on the ZENTREX 6215.

**HOLZ-HER systems - We automate your custom production processes for you**

HOLZ-HER Systems is the competency center for futuristic solutions in machining derived timber products. With our W4.0 digitization concept, we combine your machines with state-of-the-art information and communications technology. It has never been easier to make your production processes more transparent and automate them to realize their maximum value.

With customer-specific, intelligent production solutions, we increase the capacity and profitability of your production facilities to the optimum. The many process automation features already realized worldwide

using state-of-the-art machine technology, combined with matching

software solutions, make HOLZ-HER systems the perfect partner for your modern furniture production. We accompany you on your path to

production solutions with a secure future or provide consulting services for high efficiency storage facilities with the STORE-MASTER panel storage system combined with pressure beam saws and nesting machines.