



Order confirmation

Date : 17.11.2011 / WAG
Execution : 3

For queries please specify

Order number : 083972
Customer :
Machine number : 0-617-08-3972

Customer number : 49499
Your order number : 1287469
responsible for you : W. Hackl

PROJECT

M.01 Machine number
PROFESSIONAL HQP11/16/56/L/X
Crosscut saw
PLATTENAUFTEILSÄGE, Type HQP 11 profiLine

M.0101 Machine number
DESCENDING CONVEYOR

M.02 Machine number
Modification PROFILE TLF210/10/05
BARGSTEDT AREA WAREHOUSE

B.23 DELIVERY CIP
Freight prepaid customer factory, packed and
insured, unloaded.

PUBLIC EDITION

1. Production program

- Kitchen furniture

2. Plate and part information

2.1 Carrier material

- Chipboard
- MDF

2.2 Surface material

- Melamine
- Laminate

2.3 Plate formats

- Panel size max.: 4200 x 1200 mm
- Panel size min.: 1000 x 300 mm
- Plate thickness max: 60 mm
- Panel thickness min.: 16 mm
- Package height max: 60 mm
- Package height at finished cut max.: 0 mm
- Part length after crosscut saw min.: 300 mm
- Finished part size min.: 300 x 300 mm
- Material density (kg/m3): approx. 750

3. Program slider

- The collet positions correspond to the standard.
- Additional collets are integrated at the following positions: mm

4. Other information

- Left machine
- Acceptance takes place at Holzma
- Sample material from customer (to be ordered)
- The saw is used in a single layer.
- A warranty of 1 year is guaranteed for the defined shift operation.
- Defined benefit obligation yes x

G.00

HQP 11/16/56 PROFILINE

Crosscut saw

PLATTENAUFTEILSÄGE, Type HQP 11 profiLine

Automatic panel sizing saw for rip-free and dimensionally accurate cross-cutting of coated and uncoated panels made of wood-based materials and those to be processed like wood-based materials.

Control panel and angle stop on the right.

1. Rear machine table

The input material is positioned on the rear machine table, which is equipped with high-quality Combi profile rails.

Advantage:

+ Material transport that is gentle on the surface.

2. Program slider

The materials to be cut are positioned program-controlled on the cutting line by means of the program slider and the robust collets.

Advantage:

- + Program slide guide in double T-beam design
-> positioning accuracy for life!
- + Drive via rack and pinion -> no lubrication required!
- + Drive via AC servo motor -> high program slider speed!
- + Non-contact electromagnetic measuring system:
 - Positioning accuracy +/- 0.1 mm/m!
 - No wear and tear!
 - Maintenance free!
 - Measurement is independent of the drive system!
- + Short, robust collets:
 - No negative leverage effects!
 - Material is pressed into the base of the collet -> no slipping!

3. Machine table (saw body)

The machine table of the saw body is equipped with large-surface, abrasion-resistant phenolic resin plates, with corresponding recesses for the collets.

Advantage:

- + No milling out of the machine table-> full stability of the steel table is maintained!
- + Easy, cost-effective replacement of the phenolic resin plates when worn!

4. Pressure bar

Optimal fixation of the panels on the machine table of the saw body.

Advantage:

- + Torsion-resistant aluminum pressure beam:
 - Low dead weight, therefore minimal wear of the cylinders!
 - The contact pressure set by the pressure gauge is maintained exactly!
- + Pressure beam guide on both sides via toothed rack:
 - Contact pressure on entire surface identical!
 - No tilting movement (parallel compensation)
 - > no material damage!
- + Pressure beam with collet recesses:
 - Minimum bleed = scratch cut
 - > Waste optimization!
- + Automatic pressure bar height control
 - > significant cycle time savings!
- + Optimum suction performance due to minimum pressure bar opening:
 - BG emission values are clearly undercut!

5. Saw carriage + angular pressing device

The saw carriage, which is made of a robust steel construction, is equipped with a main saw and a scoring saw as well as with the patented 'Central Angle Pressing Device'.

Advantage:

- + Solid steel saw carriage body (approx. 350 kg):
 - Torsionally stiff for life!

- Cutting direction against the angle stop -> no slipping of the panels!
- + Balanced saw carriage:
 - Minimal wear of the prism rollers!
 - No counterholder rollers required!
- + Drive via rack and pinion:
 - No lubrication required!
 - No vibration buildup/exact positioning = Top cutting quality!
- + 10 years warranty on the guides of the saw carriage!
- + Motorized adjustment of the scoring saw on the operating panel -> minimum setup times!
- + Optimized saw blade change due to the quick clamping system 'Power-Loc'!
- + Automatic, stepless cutting height adjustment -> Reduction of cycle time!
- + HOLZMA patent: Central angular pressing device:
 - Reduces cycle time by up to 25% compared to conventional systems!
 - Pressure of strips possible over the entire cutting length!
 - Press-on strength electrically adjustable -> thin and sensitive plates can be pressed on automatically!

6. Power Control: CADmatic 4 - Professional - State-of-the-art control system designed specifically for the requirements of a production facility.

a) Hardware

- + PLC control according to international standard IEC61131.
- + Operating system: Windows XP (US) embedded.
- + Industrial PC.
- + TFT flat screen:
 - 19 inch with touch function.
- + USB connection / modem (analog).

b) Software

- + Sectional plan display in moving sequence graphics (2-D/3-D).
- + Network capable.
- + Integrated tool management with ver-

wear data acquisition.
+ Graphic and video sequence supported fault diagnosis.

Technical data

Saw blade
tion125 mm Saw carriage feed: projec
forward1-
150 m/min reverse constant150
m/min
Program slider speed: forward90 m/min
backward1
30 m/min (in EU countries forward = 25 m/min)

Automatic pressure bar height control YES
Automatic cutting height control YES
Adjustable pressure beam pressure YES
Adjustable collet pressure YES
Collet release

Angle pressing device min.
pressing width 0 mm
max. contact pressure width 1600 mm
Main saw motor 13,5 kW
Scoring saw motor 2,2 kW
Operating voltage400 V (+10%/-5%) / 50 Hz
Collet opening max. 130 mm
Working height 1020 mm

Main saw blade450 x 4.8 x 60 mm
Scoring saw blade180 x 4.8 - 5.8 x 45 mm

Required air pressure 6bar
Compressed air requiremen t210 NL/min
V at the suction nozzle approx.26N

egative pressure min 1200 Pa
Exhaust air volume5800 m³/h
Suction connection chip channel1 piece 200 mm
Suction connection pressure bar1 piece 150 mm

Operating temperature min. + 5 degrees
Operating temperature max. 35
degrees If the temperature falls below or
exceeds this value, a cooling unit (Sales No.
6750) must be used.

- CE-tested, GS-tested, FPH wood dust tested
- Positioning accuracy: +/- 0.1 mm/m

Customer-specific machine data

HQP 11/16/56 profiLine

Cutting length 1600 mm

Cutting width (program slide travel) 5600mm

Collets (two-ring) 3 pieces

Collet pitch

Item 75/275/775

Measured from the angle ruler to the center of the collet chuck

5 additional two-finger collets possible Pos.

175/375/475/1075/1375 mm

Air cushion table with roller element

2810 x 650 mm1 piece

Blower1 piece

Air cushion tables nozzle pitch 70 x 70 mm

N.02 Number : 05621 times
REAR LOADING (TYPE HQP11) 5600 MM
 consisting of:
 1) Friction roller conveyor
 Conveying speed: V = 27 m/min (50 Hz)
 2) Raisable collets
 Max. Lifting height Type 11: 145 mm
 3) Continuous angle ruler
 4) 4 pneumatic pressure cylinders

N.04 Number : 11751 times
ADDITIONAL PRESS-ON CYLINDER (PNEUMATIC)
 For aligning strips against the standard angle ruler (optional).
 Press-on width: max. 1350 mm
 min. 50 mm

N.10 Number 1700 time_
POSTFORMINGAGGREGATTYP 410/430/530
 For tear-free scoring of soft and postformed parts as well as edge-glued workpieces.
 Program-controlled vertically from below in the through-

running ascending. Including special program
'Material dependent parameters'.

Technical data

Saw blade projection (530):	70 mm
Saw blade projection (410/430):	80mm
Saw blade:	HM 340 x 5.0 x 45 mm

N.11 Number 8998time

ANGULAR RULER WITH SPRING RULING TAPE

in hard chrome plated version

N.12 Number 8998 time

EXECUTION FOR DEEP SEAM CONTROLLERS

The machine is designed so that it is possible to integrate one or two deep cutting aggregates. Included is the complete mechanics (without Agreggate) and the complete control integration.

If this system is used, the maximum width of the useful width in the crosscut saw is 1300 mm.

N.1210 Number 8998 time

DEPTH CUTTING SAWS FOR WORKING SHEETS

This deep cut saw with a saw agreggat is used for strips (countertops), which still get a deep cut.

Separate suction hood over the entire width. Including 1 saw blade HM 380 x 4.8 x 60.

If this option is used on the machine, the maximum cutting width of the line is reduced to 1300 mm.

Technical data

Main saw motor	7	.5 kW
Saw blade projection		85 mm
Positioning accuracy	0	.3 mm
Resaw width		
at the angle ruler		min. 5 mm
Working width	max	.1400 mm

Diameter suction supply line320 mm
V at the suction nozzle approx. 22 m/s
Exhaust air volume 8000 m3/h

N.14 Number : 17701 times
 °LINKSAUSFÜHRUNGTYPE 380/410/430/530/550/570
Angle stop left instead of standard right.
Sawing direction from right to left in the
direction of the angle stop.

Note: only cutting length 4300 mm possible!

N.16 Number : 89981 times
 WASTE FLAP1600 MM
The waste flap opens automatically in the
sawing cycle to dispose of the initial and
residual cuts

N.17 Number : 12701 times
 COLLET FOR CROSSCUT SAW 2FINGRIG TYPE 11
includes: 1 collet
Pos.: 475 mm

N.20 Number 2085 20times 1
 LFDM PROTECTION FENCE
Height: 1800 mm

N.21 Number : 20901 times
 1 DOOR ELEMENT FOR SAFETY FENCE
with safety interlock 1000 mm
wide, 1800 mm high

N.22 Number 1430 time
 automatic ejector ruler
Program-controlled ejection of parts packages
into the area of the air cushion tables.



N.24 Number 3330 time

FRICTION OIL TYPE HER 56/22 F

for the onward transport or the optimal convergence of the different cut parts. The design of the friction roller conveyor ensures that all panel materials can be transported without damage.

Technical data

Roller spacing : 140 mm
Part length min. : 290 mm Conveying
speed: V = 37 m/min (50 Hz)

N.2410 Number 8998 time

ROLLER RAILWAY EXTENDED TO 1300 M

N.2411 Number : 89981 times

2 TER DRIVE IN THE ROLLER CONVEYOR
at position 3000 mm

N.2412 Number 8998 time

ADVANCED SAFETY RANGE

N.30011 Number : 18962 times
1 M SHAKING TROUGH 550 MM (DRIVEN)
Waste volume (peaks) up to 0.2 m³/min.
Basics:
- Bulk factor approx. 0.6
- Conveying speed vibratory conveyor
approx. 6 m/min

N.4001 Number 8998 time
SPARE RECHNERFOR THE MACHINE

N.8001 Number 8998 time
ADAPTATION WASTE DISPOSAL

E.02Service : 6200 1 time
DATA TRANSMISSION ONLINE + USB PORT

F_u_n_k_t_i_o_n_s_u_m_f_a_n_g :
> Transfer of optimization data
(SAW files) to the saw
> Viewing from office (AV workstation) the
current program sequence of CADmatic control
to answer the following questions:
+ Which job is being cut?
+ How long will this order last?
+ Which order will be split next?
+ Which orders have already been split
today (history)?
> Chat function between saw/operator and
AV workstation (information exchange)
> HOLZMA USB stick

E.06Service : 6222 1 time
DATA CONNECTION TO STORAGE SYSTEMS (SIMPLE)
to Bargstedt area warehouse.

B_e_i_n_h_a_l_t_e_t :
- Complete communication interface
between saw and bearing control:
'bearing controls saw'.
- Technical clarification by HOLZMA software
technician.

- Residue communication for the storage of usable residues in the storage system is carried out according to HOLZMA data format definition.

A_b_l_a_u_f :

- 1) The plates are generally supported with the program slider in the rear position.
- 2) Positioning of the plates under the pressure beams.
- 3) Manual alignment of the plate/package by the machine operator.
- 4) Start of the cutting cycle.

Plate dimensions for feeding:

- max. panel thickness: 40 mm
- min. Panel thickness: 12 mm
- Cutting length saw 3800 mm:
 - > Support longitudinal up to max. 3660 mm
 - > Support crosswise up to max. 3100 mm
- Cutting length saw 4300 mm:
 - > Support longitudinal up to max. 4100 mm
 - > Support crosswise up to max. 3660 mm

Consider dependencies on installation situation !

E.09 Number : 62981 times
MOBILE CADMATIC CONTROL PANEL INSTEAD OF STANDARD

E.10 Number 6750 time
COOLING AGGREGATE FOR SINGLE SAWS

E.22Service : 7075 1 time SOFTWARE
UPDATE
Optimization update to V8.2

E.24 Number : 89981 times
SOFTWARE CHAOTIC BATCH PRECOMMISSIONING
for optimization orders

In the customer's manual plate storage system, the operator forms a chaotic loadable

Batch in which a so-called 'job list' is created and stored on a server when the batch is completed and a batch accompanying paper including barcode is printed.

Based on the information of the stack accompanying paper, the operator at the BARGSTEDT feeder can select and activate the corresponding 'job list' manually or with barcode reader. This enables the BARGSTEDT-HOLZMA plant to automatically process the stack with the associated cutting plans.

The software can be installed on a customer PC with WinXP SP3.

E.30 Number 8998time

CONNECTION CUSTOMER PRINTER

The customer's printer is integrated into the system. When a part is cut, the data is sent from the CADmatic control to the printer.

Prerequisite from DAN Kitchens:

- Printer driver for Windows XP
- Ethernet print server port integrated on the printer.
- Printer should be sent to Holzma for testing before delivery.

D.02Service : 8602 1 time

TRAINING MACHINE (HOLZMA): 2 DAYS/1 PARTICIPANT
Training machine / control system in HOLZMA training center for 1 participant.

Target group : machine operators, workshop ladder
Prerequisite : PC knowledge (keyboard, Mouse, Windows Explorer)
Language : German or English
Price includes: Lunch, beverages during breaks and training materials

D.04 Service: 8604 1 time
TRAINING MACHINE (LUMBER MA): 1 ADDITIONAL. PART.
Training machine / control system at the HOLZMA
training center for each additional
participant.

D.06Service : 8703 1 time
TELESERVICENET VIA DSL / LAN
Remote diagnostics via router instead of modem
for fast, cost-effective and reliable remote
service.

- the services and fees of remote diagnostics
are regulated in a separate teleservice
contract
- TeleServiceNet on the machine offers
additional e-service options
- The customer must provide a separate
Internet connection and a standard
telephone.
- a bandwidth of min. 256 kbit/s upstream and
256 kbit/s downstream is required
- in case of deviation from standard
connections (DSL, ISDN), there are
additional costs for project planning; the
price is determined according to the effort
involved

D.08Service : 8600 1 time
PROJECT MANAGEMENT
The HOLZMA project management team is deployed
to ensure professional handling of the entire
project.

The project management team will perform the
following tasks:

- Creating schedules.
- Internal deadline monitoring.
- Detailed discussions with the customer.
- Creation of a detailed project
description.
- Organize and perform customer pre-
inspections.

- Create an assembly schedule with resources.
- Supervision of assembly and commissioning activities.
- Joint definition and implementation of the acceptance.

D.11Service : 8996 1 time
CE FOR CELLS / PLANT.

- Only the machines and only the partly completed machines listed in the relevant 0-617 number are used for the EC conformity assessment procedure.

V_o_r_a_u_s_s_e_t_z_u_n_g :

- All assembly instructions incl. all installation declarations of possibly existing incomplete machines (or plants, etc.) and all operating instructions incl. all EC declarations of conformity of all existing machines (especially in the required foreign languages) must be available completely!

EC conformity check:

- Hazard interface recording in the cell (on site). Effort approx. 2-3 days (incl. arrival/departure) with 1-2 safety officers (for electrics/electronics and mechanics).
- Carry out a risk assessment of all (machine) interfaces, including description (documentation) of any necessary measures (electrics/electronics and mechanics).
- Preparation of any necessary intersection and risk descriptions, including preparation/supplementation of a cell description, taking into account the measures from the individual risk assessments.

D.95Service : 8321 2 times

DOCU. AND CONTROL TEXTS: GERMAN

Scope of delivery:

1. operating instructions in German consisting of operating and maintenance instructions on DIN A4 paper and CD-ROM

N.30012 Number 8998 x left
DROP RIBBON 1300 MM
Forms the connection between the automatic
cross-cut or vertical shredder and a waste
container provided by the customer.

Belt length : 1200/2800 mm
Belt width : 1300 mm
Belt speed, approx. : 27m/min
Max. Angle of incline : 38
degree
Part size min. : 400 x 150 mm

INSTALLATION PLAN
NUMBER 5012653154

MATERIAL FLOW DESCRIPTION AREA STORAGE

E I N L A G E R P L A T Z

- no protection plates
- When setting up the system manually, a piece count accurate input is required
- Material: Worktops
- min. Part width: 300mm
- min. Part length: 1200mm
- max. part width: 1200mm
- max. part length: 4100mm
- Stop stanchions for transport frame to be provided by customer
- Transport rack max. width 1400 mm
- Transport rack max. length 4800 mm
- Surface of the transport frame with open structure to avoid sticking on the transport frame.

Positioning on customer's transport frame:

- Wide workpiece, always centered
- Length of workpiece always at fixed edge in front
The exact arrangement of the panels on the structural transport frame is the responsibility of the customer.
- pos. on deposit roller conveyor always centered

R E S T E

- no leftovers!

B E A R B E I T U N G S M A S C H I N E

- Saw manufacturer: Holzma
- Saw type:

Connection

- Connection to Holzma see pos. G0019

G.00

PROFI TLF210/10/05

BARGSTEDT AREA WAREHOUSE

For gentle and fully automatic transport and effective storage of panel-shaped wood materials.

- Safe transport of heavy material

- Optimal utilization of space and area
- Optimal material flow

OVERVIEW OF THE AGGREGATE ASSEMBLY

- BREAK
- VEHICLE
- LIFTING DEVICE
- TRAVERSE

1. BASIC MACHINE

- Base frame, mounted on the hall floor.
- Mobile unit for transporting workpieces.
- Painting in gray RDS 240 80 05
Accent color in Reflex Blue 50

Dimensions:

- Tower length (x) : 10000 - 50000 mm
- Span (y) : 5000 - 12000 mm
(in 100 mm increments)
- Stacking height in the warehouse : max. 2100 mm

General:

- Positioning accuracy : +/- 35 mm
- Pneumatic connection : min. 6 bar
(constant, dry, oil-free, filtered, according to DIN standard ISO- 8573-1 grade 3)
- TRK value (wood dust) : < 2
mg/m³ (if the extraction capacity to be provided by the customer is complied with in accordance with the extraction plan)
- Floor thickness : min. 220 mm
(industrial floor, steel-reinforced, quality C25/30 XC 1, tensile and compression loadable, surface even)
- technical availability : >= 95
% (according to VDMA)
- Structural tolerance : according to DIN 18202

2. WORKPIECE AND STACKING PARAMETERS

- Workpiece lengths : 2000 - 4200 mm
- Workpiece widths : 800 - 2200 mm
- Workpiece thicknesses : 12 - 40 (*)mm
MDF raw : from 16 (*)mm
- Single weight : max. 250 kg
- Density
Raw particleboard : > 650 kg/m³
Raw MDF boards : > 750 kg/m³

(*)Notice:

The separation process can be ensured via the weight control (optional). There are no deviations in the as-built data. The system detects tolerances of the materials. Countermeasures are suggested automatically and can be initiated manually.

- Shape:
rectangular, closed, without cutouts
- Carrier material:
Particleboard, MDF, HDF, plywood, glued wood, solid wood, multiplex
- Dish:
max. 0.2 % of the diagonal, but max. 10 mm
- Cover layer protrusion:
For parts with cover layer overhang, the workpiece measurement (optional) must be switched off manually for each plate
- Workpiece surface:
raw, ABS, PVC, lacquer, veneer, laminate, melamine, aluminum, foil;
smooth, clean, separable and absorbent
- Detection of critical surfaces:
The handling of plates with critical surfaces (e.g. black, dark brown, matt red) is possible without any problems.
For a smooth process, it is recommended to simply deactivate the workpiece measurement (optional).
- Edge material:
raw, veneer, PVC, ABS, melamine, paper

- Stacking data:
Data sheet no. 9-506-00- Stack in store
Data sheet no. 9-506-00- Stack height Shaft
Data sheet no. 9 - 5 0 6 - dimension
0 0 -

3. A G G R E G A T B E C O M P A N Y

3.1 BREAK

- Bridge moving on the base frame
- Omega drive (low-noise, good power transmission, low-wear)
- Feed rate (x-direction) : max. 60 m/min.

3.2 VEHICLE

- Trolley moving on the bridge
- Omega drive
- Feed rate (y-direction) : max. 80 m/min.

3.3 LIFTING DEVICE

- Lifting device with scissor-type vertical guide
- Belt direct drive (good power transmission, low wear)
- Feed rate (z-direction) : max. 30 m/min.

3.4 TRAVERSE

- Suction traverse with suction cups manually adjustable to part length, incl. vacuum generator and sensors

4. POWER CONTROL WOODSTORE PROFILINE BEARING CONTROL

Modern control system based on Windows PC.

Hardware:

- PLC control according to international standard IEC61131
- Industrial PC
- Operating system Windows XP (US) embedded
- 1 hard disk fixed
- 1:1 Backup (Clone)
- 1 CD-ROM drive
- TFT flat screen with PC keyboard and mouse
- Fieldbus for inputs/outputs and decentralized aggregates
- Network connection Ethernet via additional card and network software
- Virus protection

Software:

- Menu-driven operation with Windows standard
- Software package woodStore warehouse control PROFILINE with:
 - Online connection Ethernet to Holzma saw for data transmission.
 - Time recording during stacking. The stacking date is stored in a database for each stored plate.
- Date-optimized restacking is possible.

- Supplier management.
The supplier identifier of the respective plate is assigned. The definition takes place when the plate is placed in storage.
- Software connection to AV system Ethernet.
- Incl. 2 user licenses.
- Max. 2 additional delivery places.
- Ethernet network protocol.
The international standardized protocol TCP/IP is used as the network protocol.
- Statistical data can be generated for each station connected to the network.
- Residual plate extension automatically.
The extension includes the inclusion of residual plates.
The data of the residual piece and the ID number are specified by the on-site optimization.
- Cover plates and protection plates are managed automatically.
- Software IntelliStore
IntelliStore is an optimization module that ensures that the plates are always located in the storage bins that match the proportion of the total production of the plates.
The integrated permanent analysis of the retrieval processes evaluates the plates according to adjustable criteria and changes the priority of the plate if necessary.
The plate priority results in a variable flexible allocation of plates to the storage bins, which is then taken into account for each further stock removal.
- Diagnostic system woodScout
- Schuler MDE Basic for machine data collection

5. ELECTRICAL EQUIPMENT

- Operating voltage: 400 volts (+/-10%), 50 Hz.
- Installed according to Euronorm EN 60204
- Country-specific voltage adjustment via transformer (optional)
- RCD only permissible in connection with an all-current sensitive/selective Ground fault circuit interrupter
If the capacity of this device is not sufficient, we recommend the use of a residual current monitor on site.

- Intended ambient temperature:
+10 to +40 degrees Celsius
- Cable routing in the corridor, cable routing and cable cover from the machine to the control cabinet on site!

6. SAFETY AND PROTECTIVE DEVICES

- Separate protective devices are required to operate the system!
- EC conformity (CE) according to currently valid machinery directive for single machine operation
- For interlinked machine operation (cells/factory plants), an additional EC conformity assessment (on site) is required. Execution by user (customer) himself or optionally by supplier VKNR 8945

7. BARGSTEDT QUALITY PACKAGE

- Machine is manufactured with reproducible manufacturing processes according to TÜV certificate DIN EN ISO 9001:2008
- The machine is run in and delivered according to BARGSTEDT standard program
- Energy saving function:
 - When the machine is not producing, the control voltage is switched off by means of preset time
 - Function can be switched on and off

8. DOCUMENTATION

- Documentation as CD-ROM
- Operating and maintenance instructions additionally in printed form

Price for basic machine TLF210/10/05:

G.0001 Number 5904 21
 pieces PROTECTION GRID, HEIGHT 2,20 M,
TLF210
 - Length 1000 mm
 - Design according to UVV regulation
 - incl. posts and dowels according to installation plan

G.0004 Number 0830 piece

SAFETY LIGHT RACK(1 SET) WITHOUT MUTING

- Protection of passage areas and material supply areas.
- Manual acknowledgement.

G.00101 piece

ADDITIONAL PRICE NARROW PART WIDTHS 300 - 1200 MM TLF ATTENTION:

Observe fixed edges!

- min. Part width: 300mm
- min. Part length: 1200mm
- max. part width: 1200mm
- max. part length: 4100mm

Parts must be placed on a transport rack provided by the customer. Parts must always be centered and placed on a fixed edge at the front of the transport rack.

(Only in conjunction with length-adjustable suction crossbeam)

Ä n d e r u n g

- min. Part length: 1000mm

G.0013 Number : 59051 piece

TRAVERSE LENGTH ADJUSTABLE MOTORIZED TLF210

- the manually adjustable crosshead included in the scope of delivery is equipped with a motorized adjustment automatically via program in length

G.00191 piece

DATA INTERFACE BEARING/SAW

Holzma makes a stack picking software with which the customer knows how the stack is to be formed, whereby used remnants are booked out directly by Holzma via the SQL interface from the manual remnant warehouse.

Previously, planned remnants of wood ma over Reserves the reservation interface and b

of the debit, the reservation will be cancelled again by Holzma.

For each stack formed, Holzma generates a job list that is read in manually by the operator for the respective stacking location. When the job list is read in, a corresponding stock removal list is automatically generated. The stack is then produced according to the stock removal list on the principle of the warehouse controls the saw. The warehouse receives corresponding residual parts storage orders for any residual parts that are produced and posts them to the manual residual parts store according to standard procedures. The warehouse receives only job lists from Holzma for each batch. SAW files are for this purpose is then no longer used, since the reservation of the remains is also made by Holzma.

Special function data link Bargstedt Holzma
Mr. H-D. Maschke, Mr. Jörg Tiedemann
09.06.2011

N.011 times

STORAGE ROLLER CONVEYOR

N.01012 times 1-276-36-0226

TFR580/S/ /50/61/12

BARGSTEDT ROLLER COASTER

For conveying workpieces on fixed edge left/right, depending on the version.

G_r_u_n_d_a_u_f_b_a_u_:

Longitudinal beam made of sturdy aluminum profile with height-adjustable feet made of sectional steel.

Support rollers arranged at an angle to the conveying direction, for workpiece transport against a side ruler on a fixed edge.

Idlers each driven by individual flat belts via common shaft.

Drive via toothed belt through frequency

controlled gear motor.

Without control cabinet, but with control part Power Control according to IEC 61131 for integration in a control cabinet of a Bargstedt machine.

- EC conformity (CE) according to currently valid machine directive for single machine operation
- For interlinked machine operation (cells/factory plants), an additional EC conformity assessment (on site) is required. Execution by user (customer) himself or optionally by supplier VKNR 8945

Technical details:

Min. workpiece length: 500 mm
Roller conveyor length: 6080 mm
Useful width: 1200 mm
Working height: 840 - 1020 mm +/- 40 mm
Support roller diameter: 85 mm
Load roller pitch: 200 mm
Max. Payload per idler: 25 kg Max.
Conveying load: 100
kgConveying speed: 10 - 50 m/min.

- Drive only with flow
- Carrying rollers covered with PVC hose
- Side ruler adjustment 0 - 110 mm manual via clamping lever

Datenblatt-Nr.9-506-00-203_

E.06 Number 6019 piece

MACHINE LINK HOMAG-GROUP MACHINES

- incl. 30 m locking cable

E.07 Number : 60211 piece

EMERGENCY STOP INTERLOCK HOMAG GROUPS MACHINES

- incl. 30 m locking cable

- E.11 Service: 6068 1 time
NETWORK CABLE ETHERNET - BASIC DESIGN
25 m cable UTP/S CAT.5 twisted pair for net
work Ethernet, incl. plug RJ 45.
- Cable laying on site.
- E.14 Number 6071 pieces CABLE EXTENSION
PER METER - TOTAL MACHINE
- between control cabinet and machine
- 5 m cable is included in the standard
scope of delivery
- E.17 Number : 64251 piece
Change STORAGE LOCATION MANAGEMENT FOR REMNANTS (SCANNER)
b_e_i_n_h_a_l_t_e_t_:
- Hardware and software scanner
- Bearing indicator light
- Booking and unbooking of the remainders via scanner
- Availability queries via scanner
- (Only in conjunction with VKNR 6424)
- D.05 Service: 8741 1 times
TELESERVICENET (SHARED USE OF HOMAG ROUTER)
Remote diagnostics via TeleServiceNet instead
of modem, for fast, cost-effective and reliable
remote service
- the services and fees of remote diagnostics
are regulated in a separate teleservice
contract
 - TeleServiceNet on the machine offers
additional e-service options
 - a bandwidth of min. 256 kbit/s upstream and
256 kbit/s downstream is required
 - Deviation from standard solutions results
in additional costs for project planning,
the price is determined according to the
time and effort involved.
 - only in conjunction with powerControl

D.06 Service: 8321 1 times
DOKU. AND CONTROL TEXTS GERMAN
Scope of delivery:
1. Operating instructions
consisting of operating and maintenance
instructions on DIN A4 paper and CD-ROM
2. On-screen texts
for machine operators, for PC control
3. Spare parts designations
on CD-ROM

- Delivery time: With machine delivery

B.20 NOTE: TRANSPORT TRESTLES
Two additional transport trestles and
additional packing material are required for
the transport of a storage system.

A deposit of 1.580,- EUR will be charged
for the transport trestles.
The calculation is made separately by our
service center.

If the transport blocks are returned free of
charge to us, this amount will be credited.

Return shipment
to:
B A R G S T E D T
Handlingsysteme GmbH
Monika Przybilka
Industriestrasse 8/13
D-21745 Hemmoor