

# HOLZ-HER Edge-Banding Machines 1404/1405

*For edge-banding, trimming, flush-cutting up to an edgeband thickness of 8 mm.*

*The edge-banding machines 1404/1405 are compact, multi-stage woodworking machines. Mid-frequency units are used for trimming and cutting. The main advantages of frequency conversion are: higher speeds, improved pulling power and greater power reserves.*

*The edgebander 1404, equipped with end trim and flush trim units, is well suited for many different applications and boasts a very fast start-up.*

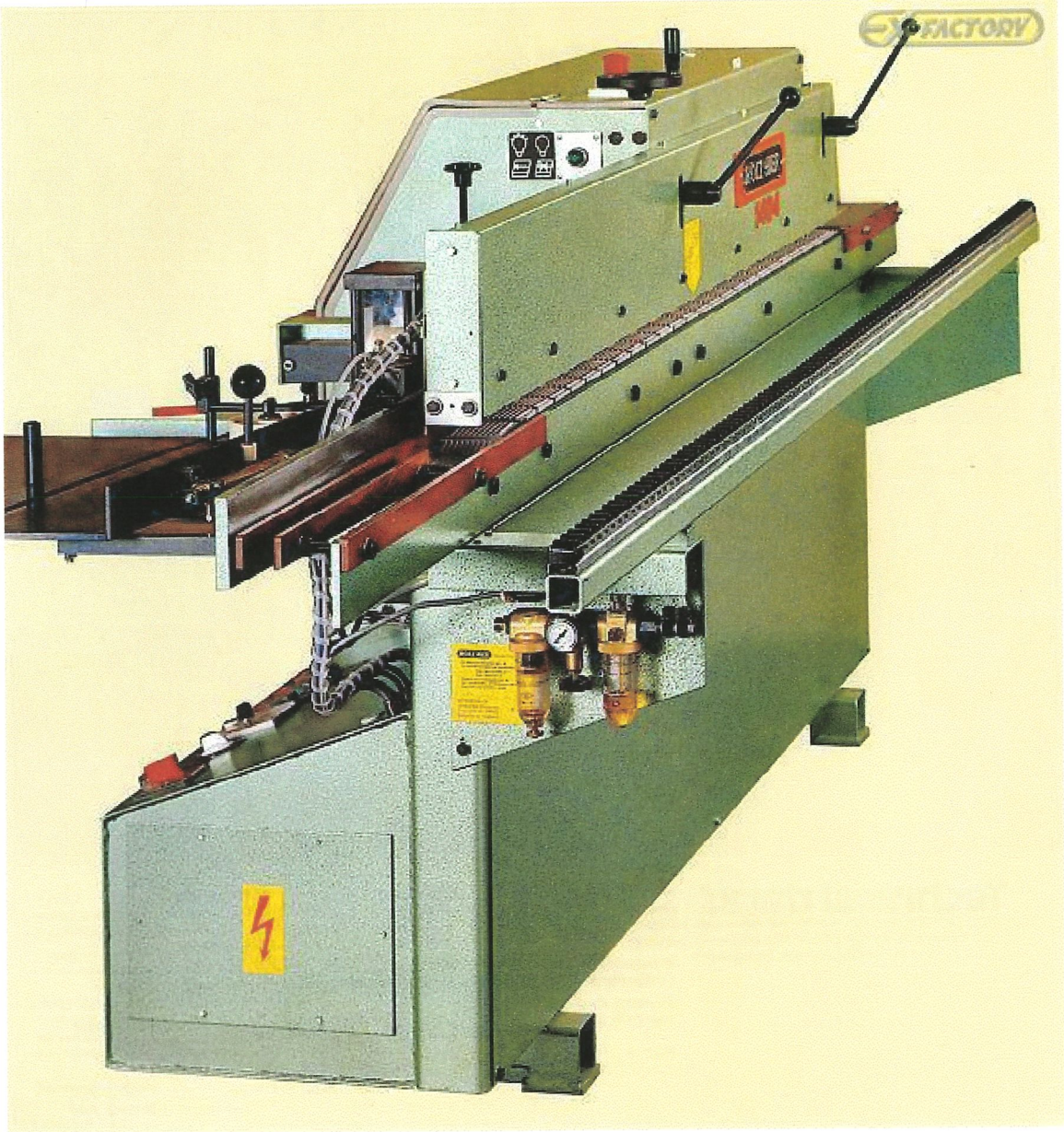
*Type 1405 has additionally two free stations which may be equipped with super finish and buffing units.*

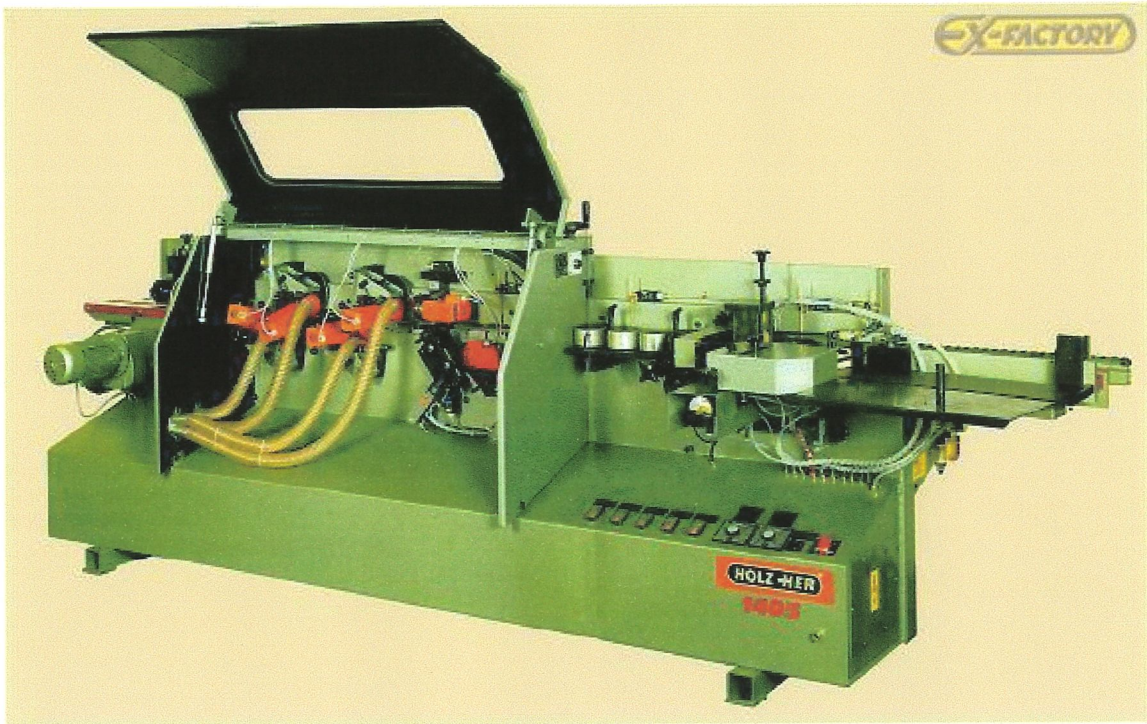
*The unique glue cartridge system, which is patented throughout the world, requires a heating up time of only about three minutes. Colour and glue can be changed in no time. Heating elements require no time-consuming cleaning. The extreme ease of use is further underlined by the small amount of fume generated and the low noise level.*

*The trimming and cutting units are pivoted and are fitted with a cover, a safety cutout and a central dust extraction connection. You may choose between the manual magazine for individual edge strip and coiled material feeding or the fully automatic magazine that works both for solid strips and coiled materials. HOLZ-HER edgebanders have market recognition for universal applications of coiled and strip materials as well as power-efficient operation.*

**Super  
edge**









# The HOLZ-HER Glue Cartridge System

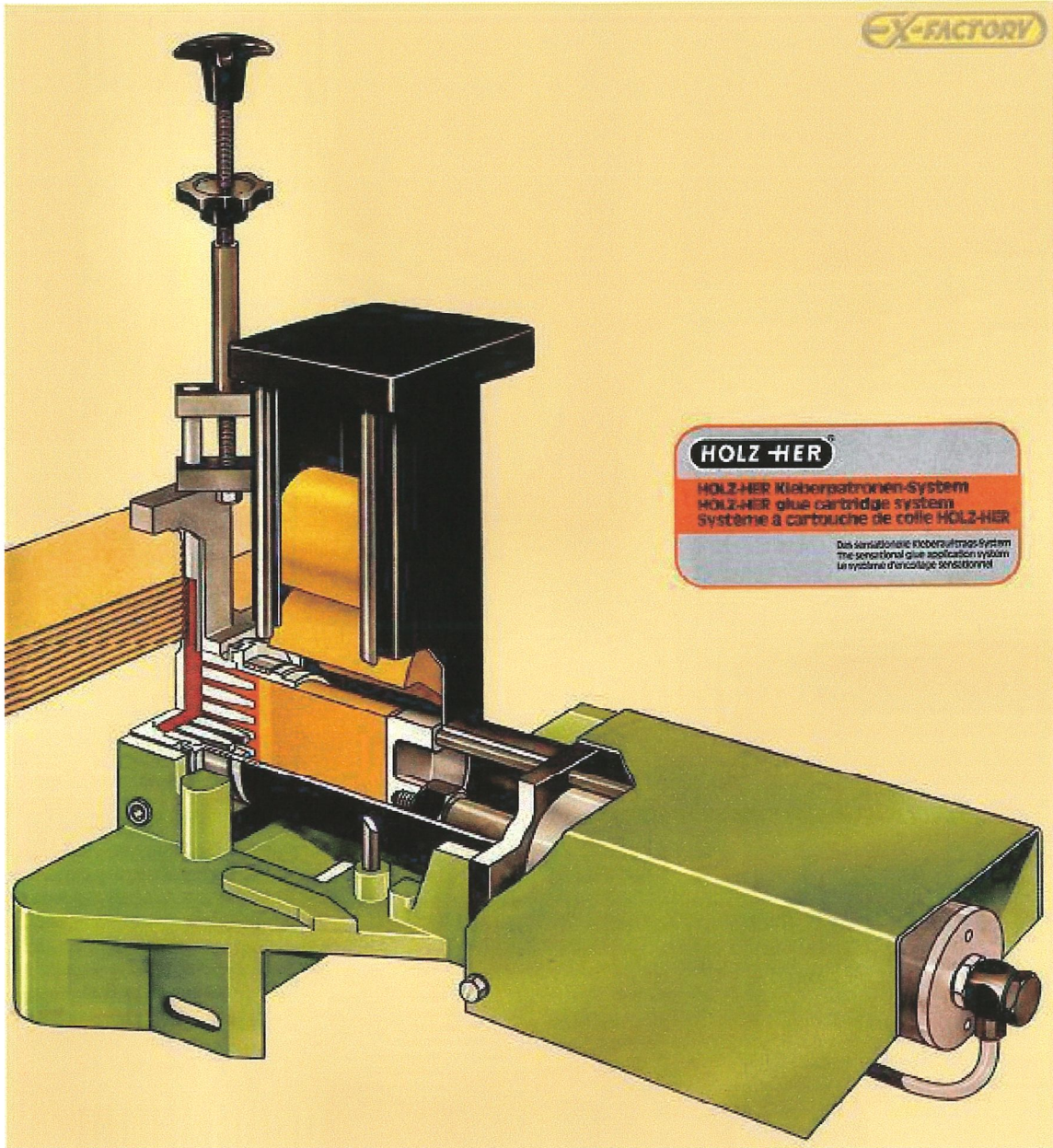


*Since its launch the HOLZ-HER glue cartridge system has revolutionized the operating of edge banders and is being acclaimed throughout the world because of its economic operation. The glue cartridge system uses a ready-made cartridge of hot-melt glue. The cartridge is pressed against a melting wall and, using the same pressure, the melted off glue is conveyed to the nozzle. Only the amount required at the time is melted, without the glue coming into contact with air. This enclosed application system guarantees optimum adhesion. Because the glue is sealed off from the air it cannot change colour, oxidize, burn, become contaminated or encrusted. Changing colour or grade of glue is very simple. The partially melted cartridge is removed and the residue is pushed out at the nozzle, using the new cartridge.*

*The decisive advantages of the HOLZ-HER glue cartridge system:*

- **Heat up time:**  
*only about 3 minutes  
(economic therefore even for single workpieces and short runs)*
- **Changing colour:** *no problem  
(similarly various grades of glue can be changed in a very short time)*
- **Power consumption:**  
*extremely low  
(only 1.9 kW is required)*
- **Economical**  
*(only as much glue is melted as is required for the job in hand)*
- **Non-polluting**  
*Odour, steam generation and heat loss are significantly less than in the case of traditional glue tank designs.*
- **Low running costs**  
*The glue cannot overheat, so the glue tank does not need cleaning. Fewer wearing parts are required, so servicing costs are low.*

*Why not opt for the unique and tested HOLZ-HER glue cartridge system – like people in our business all over the world have done.*

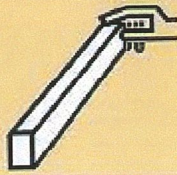
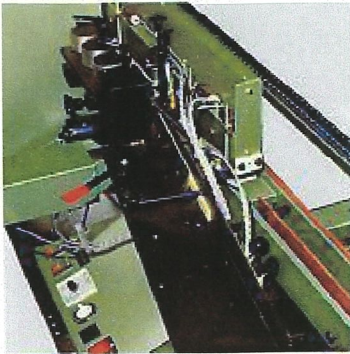


**HOLZ-HER**  
HOLZ-HER Kleberpatronen-System  
HOLZ-HER glue cartridge system  
Système à cartouche de colle HOLZ-HER

Das sensationelle Kleberauftrags-System  
The sensational glue application system  
Le système d'encollage sensationnel

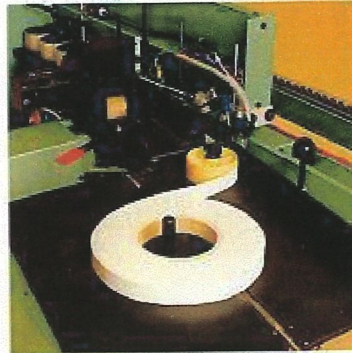


# The units



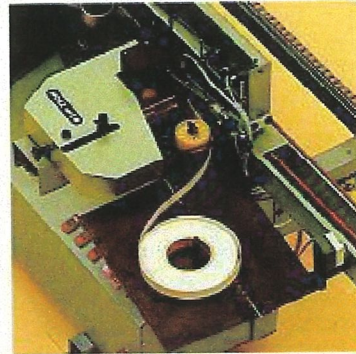
### Individual edgestrip feed

Edgestrip length min. 200 mm (7<sup>7</sup>/<sub>8</sub>"")  
 Edgestrip height max. 66 mm (2<sup>5</sup>/<sub>8</sub>"")  
 Edgestrip thickness, single 0.3 – 25 mm  
 (0.012" – 1")



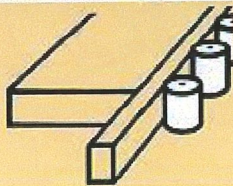
### Semi-automatic edge-strip feed

Edgestrip length min. 200 mm (7<sup>7</sup>/<sub>8</sub>"")  
 Edgestrip height max. 51 mm (2")  
 Edgestrip thickness, single 0.3 – 25 mm  
 (0.012" – 1")  
 for coiled material 0.3 – 0.8 mm  
 (0.012" – 0.031")  
 Coil diameter max. 500 mm (19<sup>11</sup>/<sub>16</sub>"")



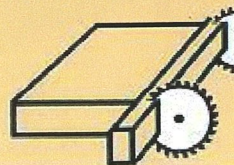
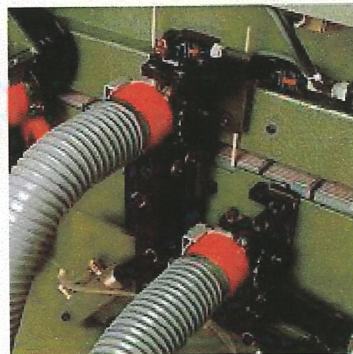
### Automatic edgestrip feed

Edgestrip length min. 350 mm (13<sup>3</sup>/<sub>4</sub>"")  
 Edgestrip height max. 51 mm (2")  
 Edgestrip thickness, single 0.3 – 25 mm  
 (0.012" – 1")  
 for coiled material 0.3 – 0.8 mm  
 (0.012" – 0.031")  
 Coil diameter max. 500 mm (19<sup>11</sup>/<sub>16</sub>"")



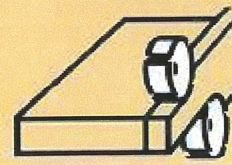
### Pressure unit

adjustable to edgestrip material using  
 scale,  
 first roller driven,  
 ensures strong contact pressure and  
 precise and rapid gluing



### Trimming unit

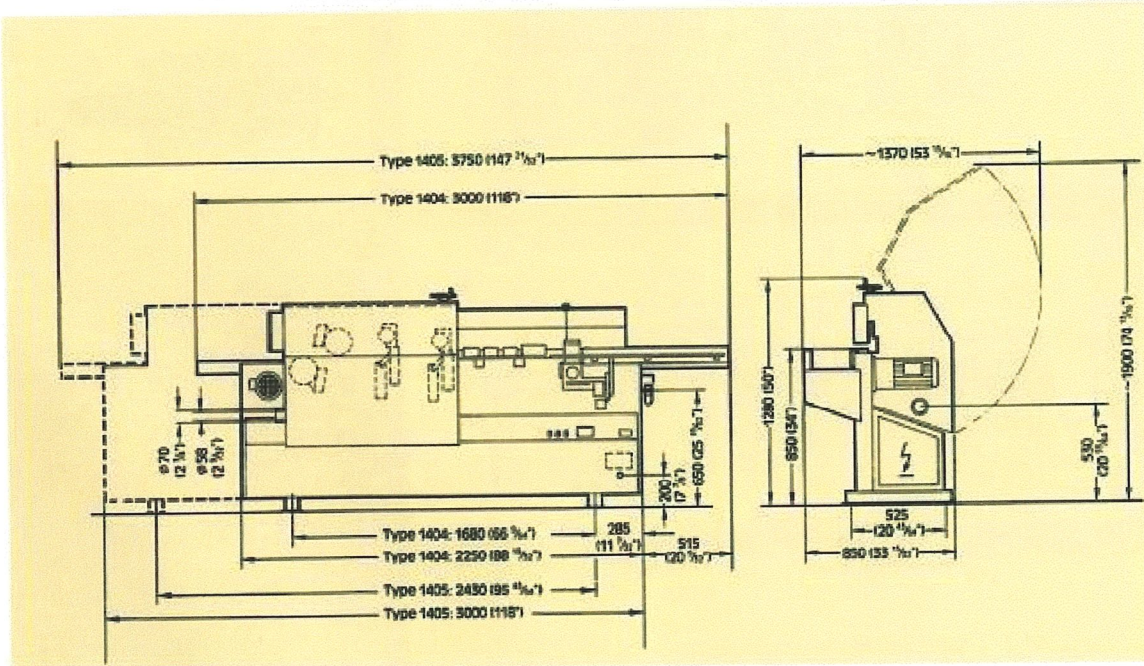
Edgestrip thickness up to 5 mm (3/16")  
 Connected load 2 x 0.6 kW  
 Speed 10 500 rev/min



### Cutting unit

Edgestrip thickness up to 5 mm (3/16")  
 Connected load 2 x 0.6 kW  
 Speed 28 000 rev/min







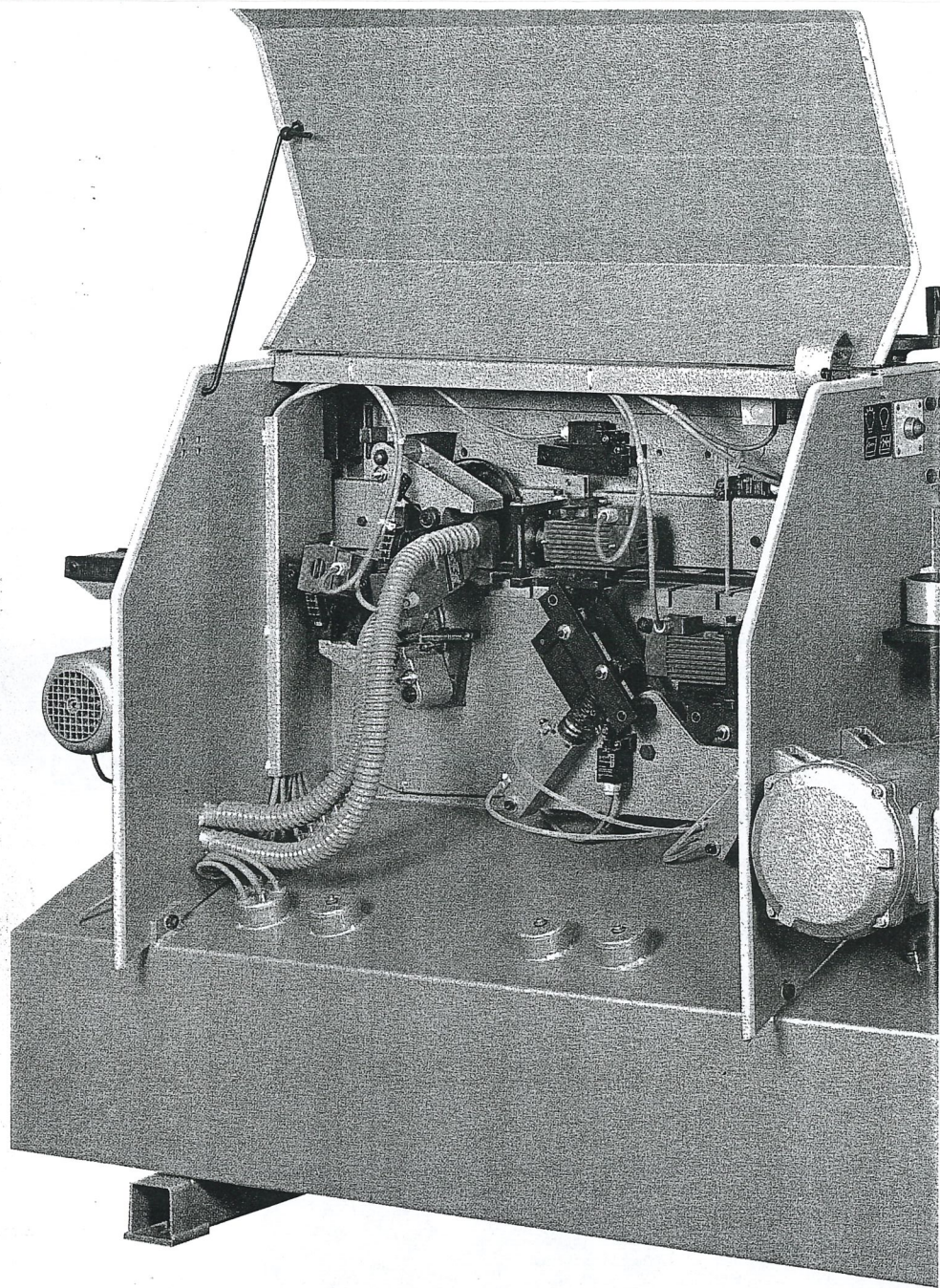
# Technical data:



	<b>Type 1404</b>	<b>Type 1405</b>
<b>Machine dimensions:</b>		
Length	3000 mm	3750 mm
Depth	850 mm with roll support	850 mm with roll support
Height	1280 mm	1280 mm
Workpiece infeed height	850 mm	850 mm
Operating system	Hot-cold, one side l.b.	Hot-cold, one side l.b.
<b>Working dimensions:</b>		
Edgestrip thickness	0.4 – 8 mm with cutting and trimming unit	0.4 – 8 mm with cutting and trimming unit
Edgestrip height	max. 51 mm	max. 51 mm
Edgestrip length	min. 220 mm, min. 350 mm with fully automatic edgestrip feed	min. 220 mm, min. 350 mm with fully automatic edgestrip feed
Projecting height of edgestrip	max. 3 mm per side	max. 3 mm per side
Edgestrip projection at front	max. 40 mm	max. 40 mm
Edgestrip projection at rear	max. 60 mm	max. 60 mm
Workpiece width	min. 85 mm	min. 85 mm
Workpiece thickness	min. 6 mm, max. 45 mm	min. 6 mm, max. 45 mm
Workpiece length	min. 180 mm	min. 180 mm
<b>Feed:</b>		
Motor output	0.37 kW	0.75 kW
Speed	11 m/min	11 m/min
<b>Energy requirement:</b>		
Connected load	4.2 kW (including gluing station)	7.4 kW (including gluing station)
<b>Compressed air connection</b>	6 bar	6 bar
Connecting sleeve	R <sup>3/8</sup> "	R <sup>3/8</sup> "
Air consumption	50 l/min	50 l/min
Air consumption, extraction	200 m <sup>3</sup> /h at 8 mbar dyn. pressure	400 m <sup>3</sup> /h at 8 mbar dyn. pressure
Connecting sleeve	dia. 58 mm internal, dia. 70 mm external	dia. 58 mm internal, dia. 70 mm external
Packing	pallet 3070x1000x1400 mm	pallet 3850x1000x1400 mm
Gross weight	622 kg	756 kg
<b>Standard accessories:</b>	Set of spanners, operating manual with spare parts list, 10 glue cartridges, EVA-base, beige; 2 TCT sawblades, 2 TC revers.-knife cutterheads (cyl.)	
<b>Special accessories:</b>	Automatic edge magazine, fully automatic magazine, manual edge feeder.	
	Type 1405 only: May be equipped with additional flush trimming unit, buffing unit.	

Technical data are given as approximate values. As our HOLZ-HER woodworking machines undergo continuous development, we reserve the right to introduce changes to data and illustrations.





## Technische Daten:

1405

### Maschinenabmessungen:

Länge  
Tiefe  
Höhe

Werkstückeinlaufhöhe  
Arbeitsweise

Arbeitsmaße:  
Kantendicke  
Kantenhöhe  
Kantenlänge

Kantenüberstand in der Höhe  
Kantenüberstand vorn  
Kantenüberstand hinten  
Werkstückbreite  
Werkstückdicke  
Werkstücklänge

3000 mm 3750  
850 mm mit Rollenauflage  
1280 mm

850 mm  
Heiß-Kaltverfahren, einseitig links

0,4 – 5 mm mit Fräs- und Kappaggregat  
max. 51 mm  
min. 220 mm min. 350 mm mit automatischer  
Kantenzuführung  
max. 3 mm pro Seite  
max. 40 mm  
max. 60 mm  
min. 85 mm  
min. 6 mm; max. 45 mm  
min. 180 mm