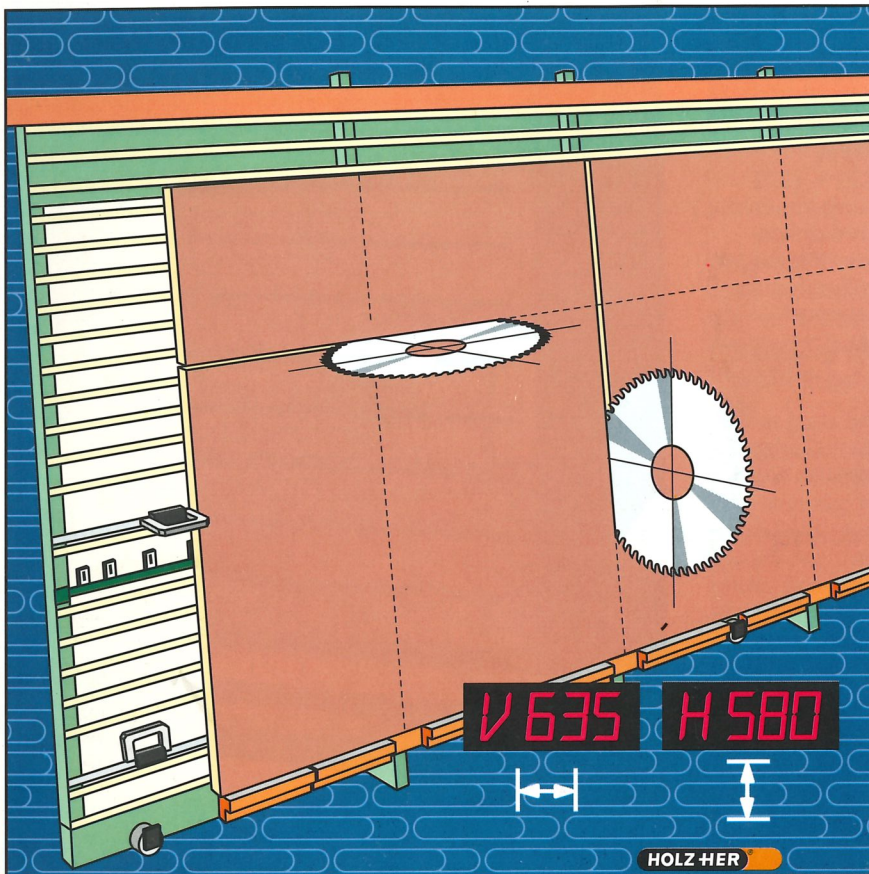


HOLZ HER[®]
special machines



Panel saws
Models: 1216 / 1221 / 1222

**Super
cut**

NEW

Cutting to size



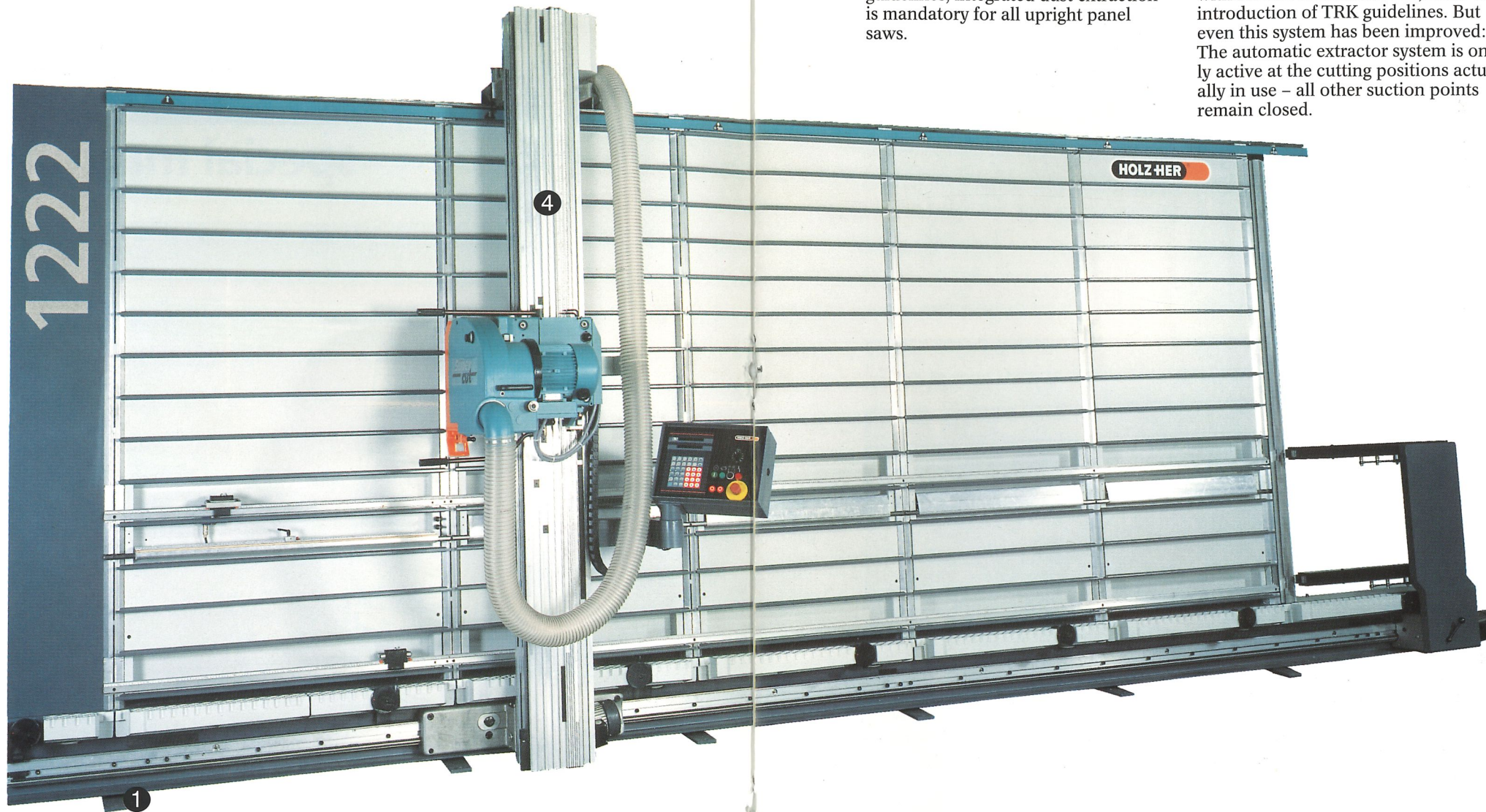
Position-controlled saw unit
 – for horizontal cuts (1221 + 1222 only). After release, the unit automatically moves to the required dimension, regardless of whether the workpiece rests on the hinged rail or the aluminium honeycomb support.

– saw units move with the greatest of ease on ground and hardened round steel bar guides.

– Silence – our machines just whisper – the saw unit has an integrated noise damping system

– powerful with 5.5 kW drive for 80 mm cutting depth.

Swiveling
 of the units is easy in one single movement. There is no further need to pull the units back before swiveling.



Horizontal extraction
 Since the introduction of the TRK guidelines, integrated dust extraction is mandatory for all upright panel saws.

Dust extraction
 at all cutting points, as is standard with HOLZ-HER machines, since the introduction of TRK guidelines. But even this system has been improved: The automatic extractor system is only active at the cutting positions actually in use – all other suction points remain closed.



Swivel-mounted operating panel
 for unrivalled ergonomic operation. All operating elements are centrally accessible.

Now only one digital display for horizontal and vertical cuts, which automatically shows the required dimensions when the unit is swiveled or when the hinged rail is folded out.

Pneumatic unit locking
 in the horizontal position – even the manual version (1216) allows no deviation from the value set on the digital display.

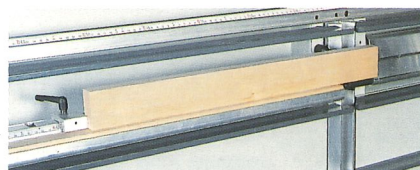
4 In spite of the digital display no corners have been cut. There are three scale tapes at the saw bridge. One with the hinged rail as the reference level, and two using the aluminium honeycomb support as reference. Readings can be taken from below or above the unit.

Pneumatic plunge
 by moving the lever or by pushing a button at the operating panel.

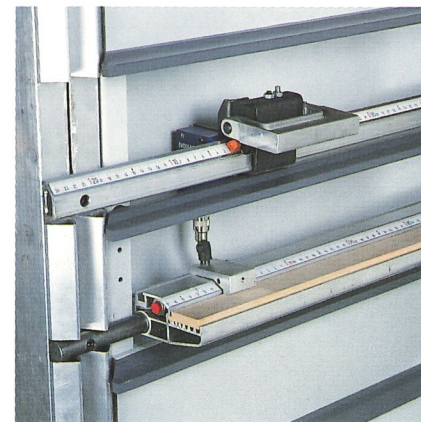


Super-Cut perfection
 Strictly in line with our guiding principle »HOLZ-HER – always one step ahead«, the Super-Cut scoring unit has been perfected to the point that there is no longer any need for setting the panel thickness.

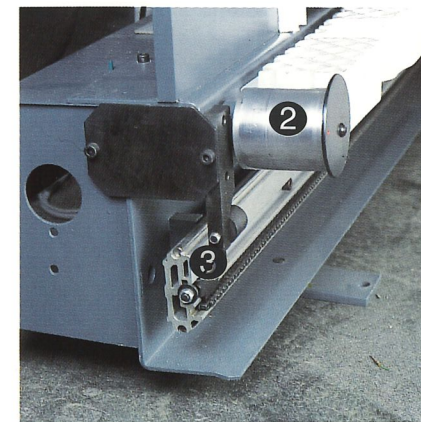
1 Adjustable frame legs to adapt the saw to floor level conditions – a standard feature for years.



Stop cams
 for cutting narrow workpiece at the hinged rail. The stop may still be brought up to the cutting position.



Individual hinged rails
 between cutting points. Panel sections may remain on the rear part of the machine, since there is no need to fold out the entire rail.



2 Pneumatic lift rollers may be controlled from the operating panel when required for material transport.

3 Precision
 Thanks to two low-positioned, hardened and ground round steel bar guide system for both carriage and material pusher (1222 only).

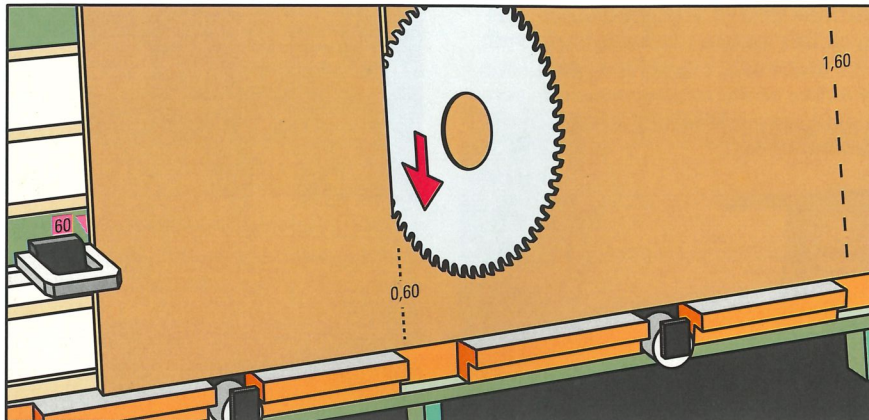


The dust falls through
 the sturdy aluminium honeycomb supports, which may of course be re-trimmed in the old HOLZ-HER tradition, and which provide positive support even for small panel sections.



Programmable material pusher
 (1222 only) to position the panel with a precision of 0.1 mm. The process: The dimension is set – and then the system takes over. After release, the rollers move upwards, the material pusher is positioned, the rollers move downwards, and the cut may be initiated. All that is left is to take the strip away.

Cutting to size with Models 1216 and 1221



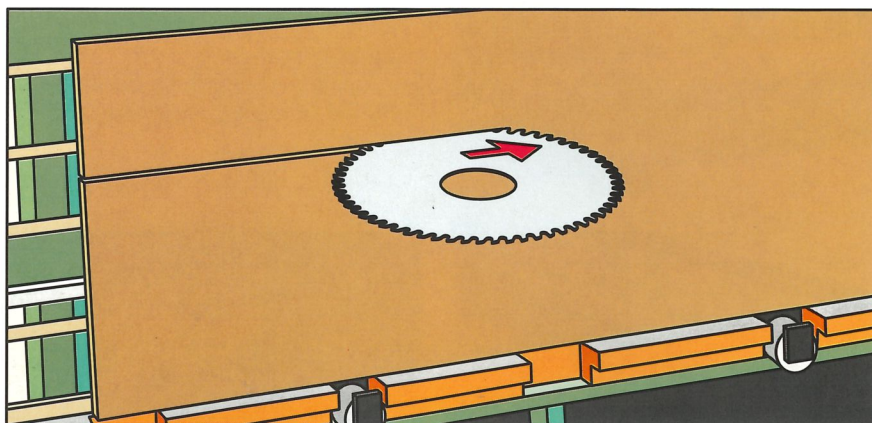
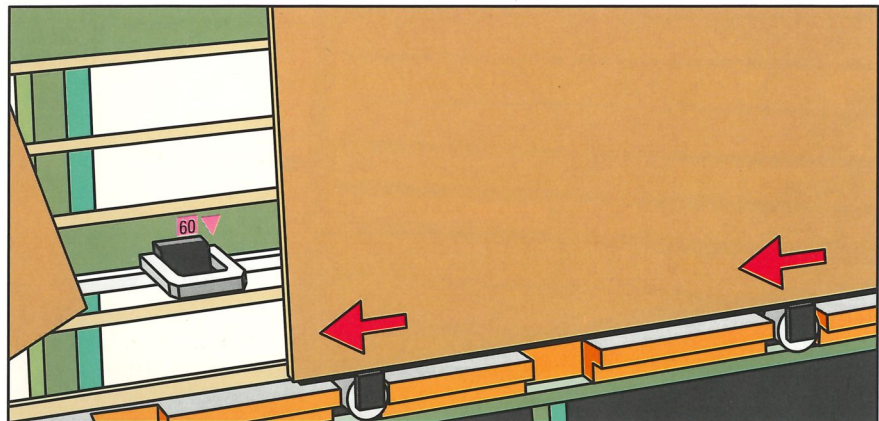
Vertical cuts

The required dimension to be cut vertically is set at the length stop, say 60 cm. Depending on the present position of the saw unit, a length of 0.6 m, 1.6 m, 2.6 m, etc. will result.

While the saw cycle – plunge (pneumatic), cut and retract (pneumatic) – is manually controlled with Model 1216, Model 1221 does all this automatically.

Intermediate transport

After taking off the workpiece just cut, the transport rollers are moved upwards (pneumatically) by pushing a button at the operating panel. The panel is pulled over the rollers against the set lateral stop, and the rollers move down once more. The next sawing cycle may be manual (1216) or automatic (1221).



Horizontal cuts

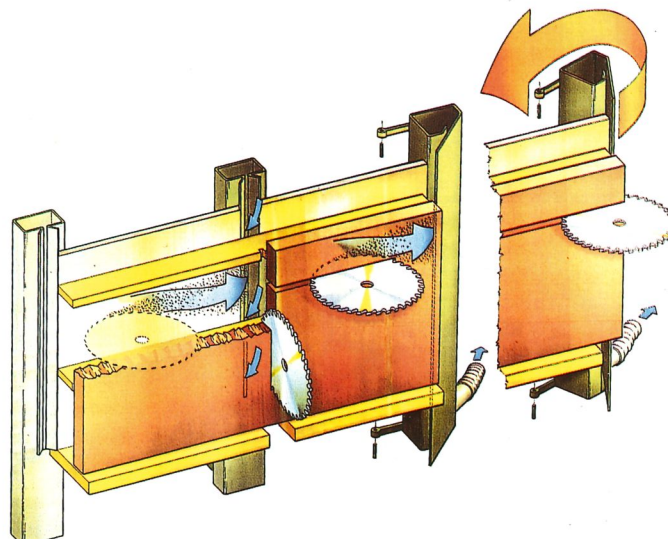
For horizontal cuts, the saw unit is swiveled and the panel trimmed on top. The unit is locked in the horizontal position by pushing a button at the control panel.

When the required dimension is set for horizontal and vertical cutting at the central digital indicator, the saw blade thickness is automatically taken into account.

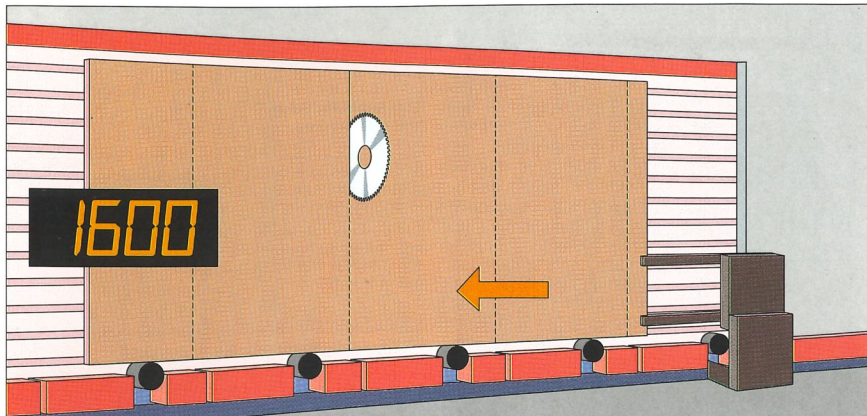
The sawing cycle – plunge (pneumatic), cut, retract (pneumatic) and return – is manually controlled with Model 1216, while Model 1221 does all this automatically.

Extraction

All machines fitted with TRK extractor systems (in accordance with BG) have an extractor channel behind every vertical cutting position. When the unit is positioned, the extractor points required are automatically opened up and activated. For horizontal cuts, the panel is re-positioned to rest against a hinged extractor channel on the right-hand side. The space between the stop fences then acts as an extractor channel. Like all standard models, the TRK version also benefits from an additional extractor point at the unit.



Cutting to size with Model 1222



Cutting to size

The 2-axes program-controlled high performance Model 1222 makes use of a material pusher.

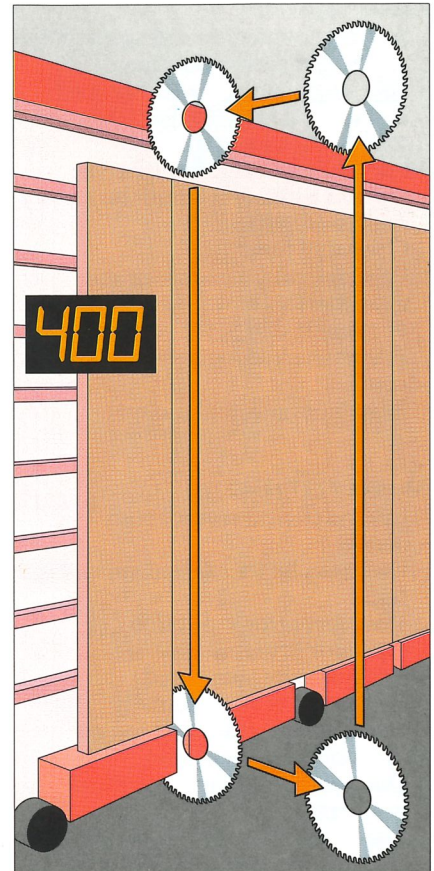
Vertical sizing cuts

The panel set down on the saw may be moved to the vertical cutting position for trimming, by means of the material pusher.

After trimming and when again released, the transport rollers move upwards and the material pusher places the panel in position with a precision

of 0.1 mm with respect to the programmed dimension, say 60 cm. Depending on the present position of the saw bridge, 0.6 m, 1.6 m, 2.6 m, etc. are cut off.

The rollers are retracted and the sawing cycle can be initiated: Plunge (pneumatic), cut, retract (pneumatic) and return to the starting position. All this is, of course, fully automated. The positioning and sawing cycles may now be repeated as often as required, in accordance with the program.

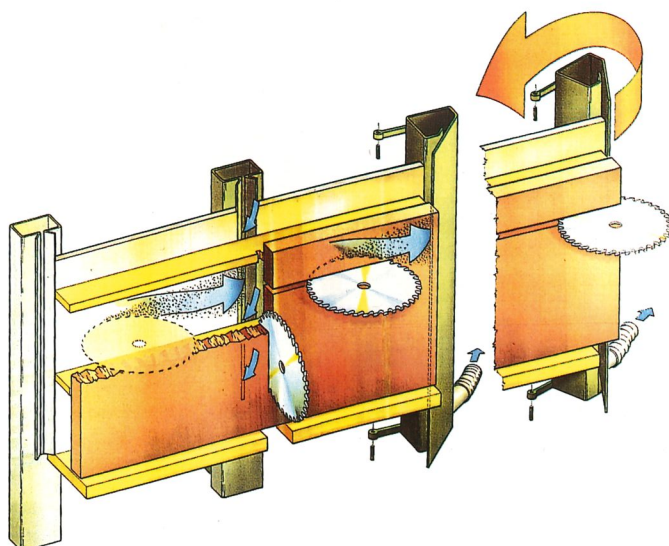
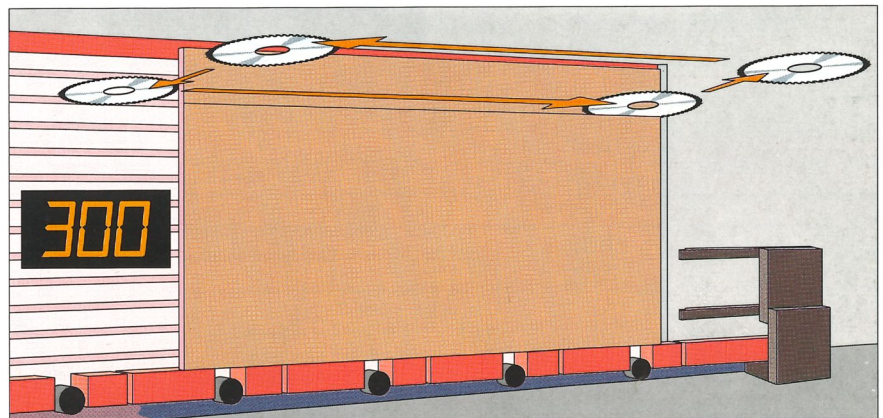


Horizontal sizing cuts

After tilting the unit and edging the panel top, the panel may also be automatically divided in a horizontal plane.

After release, the saw unit is automatically positioned and locked. Starting the cycle automatically initiates the plunge (pneumatic), cut, retract (pneumatic) and return operations. Re-positioning and locking may be initiated.

The 2-line digital readout shows both nominal and real values, as well as operational and machine errors in plain text.



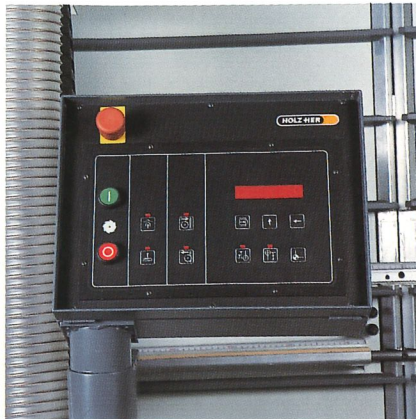
Dust extraction

As with Models 1216 and 1221, the vertical dust extraction works from behind the cut, and only suction at the point of cut in use is activated at any one time. For horizontal cuts, tilting the unit activates the suction flap at the right-hand end of the panel saw.

Control

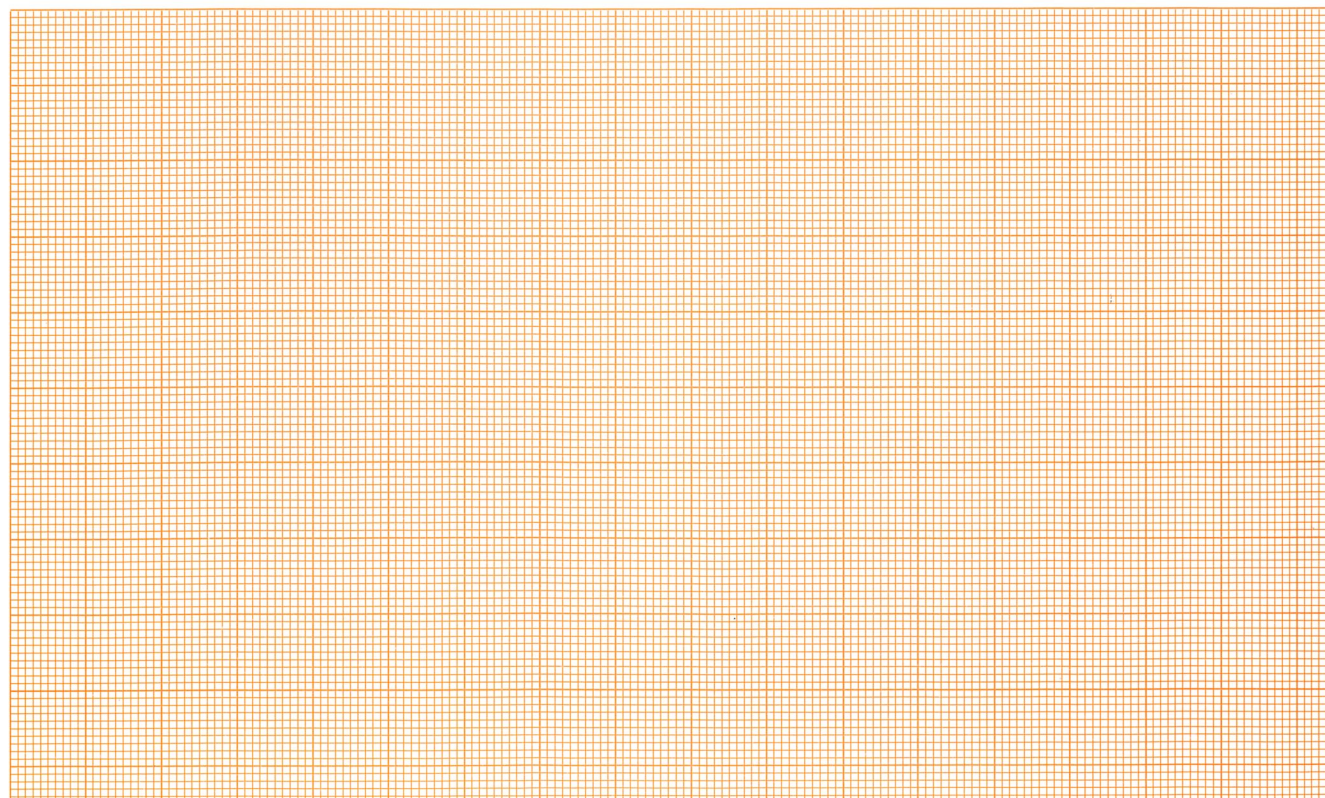
Model 1216

- Swivel-mounted operating panel for most ergonomic operation.
- One single indicator for horizontal and vertical cuts. The indicator automatically changes over to the corresponding dimension when either the unit is tilted or when the hinged rail is brought out.
- Operating functions:
 - Pneumatically assisted up and down movement of transport rollers.
 - Pneumatic detent for vertical cuts.
 - Pneumatic locking for horizontal cuts.
 - Pneumatic saw unit plunge.

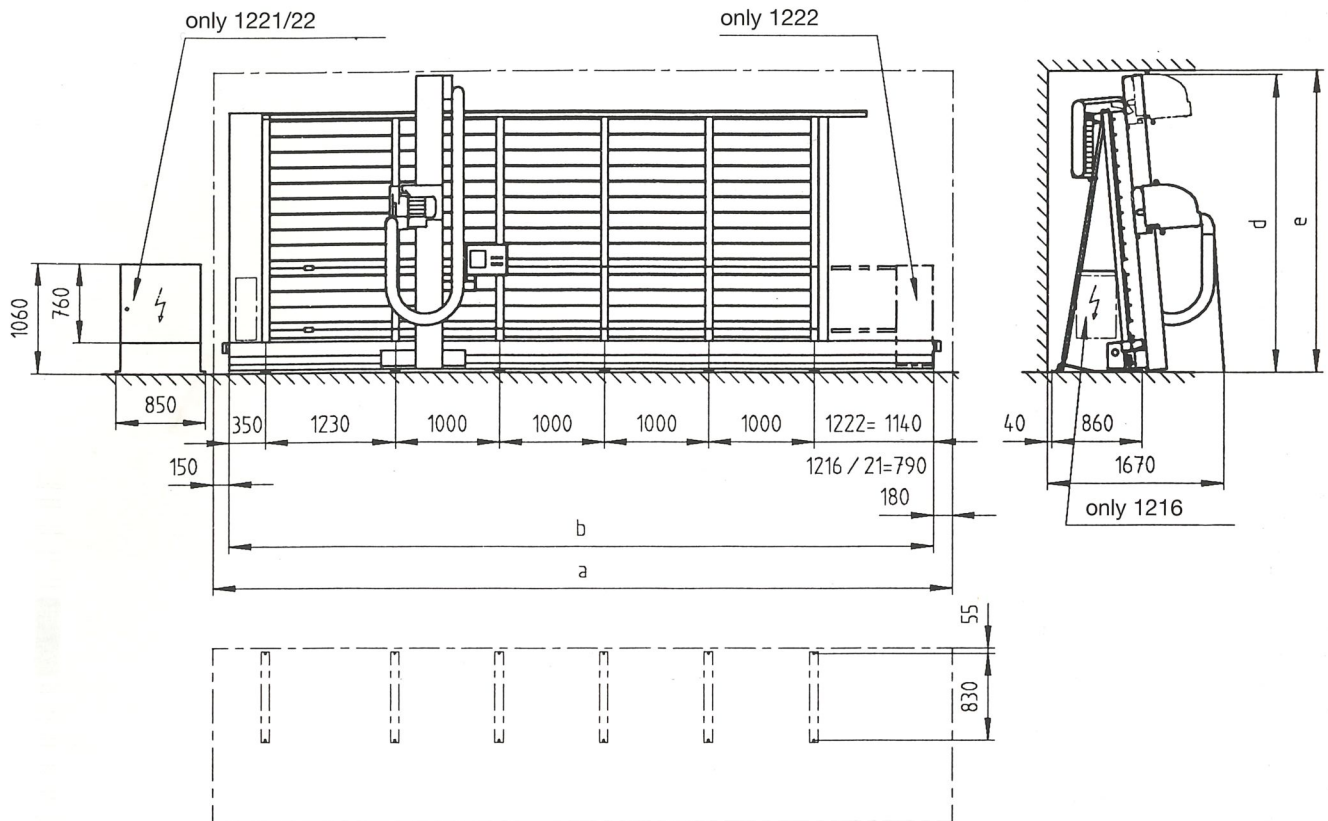


Models 1221 or 1222

- Integrated SPS control with 2-line display
- Data may be transferred via interface
- Plain text error indication
- Operator prompts
- Cycle may be automated
- Cycle may be run manually
- Nominal and real value indication
- Programs may be stored
- One central display for vertical and horizontal cuts.
The correct value is automatically selected and indicated when the unit is tilted or when the hinged rail is brought out



Machine dimensions – Models 1216 / 1221 and 1222



Dimensions in mm	Cutting length 4300 mm			Cutting length 5300 mm			Cut height 2200 mm
	1216	1221	1222	1216	1221	1222	
a	5700	6050	6050	6700	6700	7050	2520 + 40
b	5370	5370	5720	6370	6370	6720	2845 + 40
c = Frame height							2520 + 40
d = Machine height							2845 + 40
e = Headroom							2895
Edging height							2100
Pass height							2205

Specification

	1216	1221	1222
Working dimension	1216	1221	1222
Max. pass height	2205 mm	2205 mm	2205 mm
Max. edging height	2100 mm	2100 mm	2100 mm
Max. vert. scoring height	2100 mm	2100 mm	2100 mm
Max. workpiece length	4300/5300 mm	4300/5300 mm	4300/5300 mm
Extractor connection	2 x Ø 100, 1200 m ³ /h	2 x Ø 100, 1200 m ³ /h	2 x Ø 100, 1200 m ³ /h
Max. workpiece thickness	80 mm	80 mm	80 mm
Max. workpiece thickness for material pusher	-	-	40 mm
Cutting depth (depending on type of material)	80 mm + 10 mm saw blade extension, on 65 mm + 25 mm saw blade extension		
Saw unit	Tilting 90 deg.	Tilting 90 deg.	Tilting 90 deg.
Motor power	5,5 kW - S6-40%	5,5 kW - S6-40%	5,5 kW - S6-40%
Saw blade speed	4472 rev/min at 50 Hz/5410 rev/min at 60 Hz		
Saw blade dia.	300 mm	300 mm	300 mm
Feed: Motor power	-	max. 0,5 kW	
Speed	-	various from 6 to 24 m/min	
Compressed air	6 bar, 50 NL/min	6 bar, 50 NL/min	6 bar, 50 NL/min
Voltage standard	400 V, 50 Hz	400 V, 50 Hz	400 V, 50 Hz
Power requirement	5.6 kW, 3-phase	5.9 kW	5.9 kW
Machine dimensions:			
Floor space, free standing installation	1670 x 6700 mm	1670 x 6700 mm	1670 x 7050 mm

This specification is based on approximate values. We reserve the right to modify any of the data or illustrations, as our HOLZ-HER products are subject to continuous improvement and updating. The machines illustrated may also contain special equipment which is not included in the standard supply package. Please ask your HOLZ-HER distributor to specify the range of equipment included in your order.

We reserve the right to modify both the design and the equipment.



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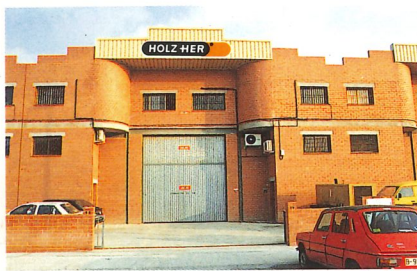
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HOLZ-HER®

– always one step ahead!

REICH
Spezialmaschinen GmbH
D-7440 (72622) Nürtingen
Plochinger Strasse 65
Tel. (0 70 22) 702-0
Telefax (0 70 22) 702-101
Tx 7 267 318 rsmn d
P. O. Box-address:
P. O. Box 1803
D-7440 (72608) Nürtingen