

Precision at your fingertips

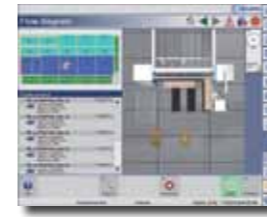


power
Touch

Software:
CADmatic 4.1 BASIC
CADmatic 4.1 PRACTIVE
CADmatic 4.1 PROFESSIONAL
CADmatic 4.5 PROFESSIONAL

HOLZMA CADmatic

Having a HOLZMA horizontal panel saw is very similar to having a modern high-end car: to be able to master all their functions, you need a perfectly designed cockpit – one that is clearly structured, with easy-to-understand displays and intelligent menu navigation. And that is exactly what CADmatic control software has to offer. Developed by HOLZMA – and successfully in operation for nearly 30 years.



CADmatic 4.1 BASIC

The control software for the models of the 1 series: HPP 120, HPP 130 and HPP 180. May vary slightly, depending on the saw model.



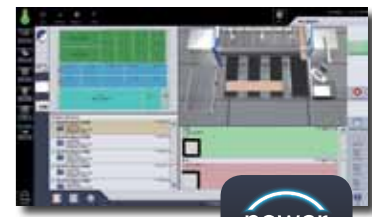
CADmatic 4.1 PRACTICE

The proven control software for all models of the HOLZMA 2 series.



CADmatic 4.1 PROFESSIONAL

Covers all the functions of CADmatic PRACTICE – and much more besides! Available as an optional feature on the HPP 200 and supplied as standard for angular saw units from the 3 series upwards.



CADmatic 4.5 PROFESSIONAL

The latest version of the HOLZMA machine control unit – equipped with many powerful features and innovative touch operation. From the 3 series upwards, CADmatic 4.5 PROFESSIONAL comes standard for all HPP and HPL models and is available as an option for the angular saw units (HKL).



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Overview

CADmatic BASIC / PRACTIVE

CADmatic BASIC is the control software for the 1 series. CADmatic PRACTIVE gives you full control over all models of the 2 series.

Virtual bird's-eye view | 1

The main screen displays your HOLZMA as if you were looking down onto it from a tower – in all its detail and with useful information on production status. You are even able to customize the layout of the functions you have at your disposal. Ask your HOLZMA consultant for more details.

Keep an eye on the cutting pattern at all times | 2

The graphic shows you clearly and precisely which parts have already been produced and which are still to be cut, enabling you to keep an eye on everything at all times.

The most important functions at the click of a button | 3

Especially convenient: the central CADmatic functions can be accessed via the function buttons – using either the mouse or the keyboard.

Fast access to all machine units | 4

Whether pressure beam or side pressure device: the self-explanatory function buttons on this vertical bar give you direct access to all machine units. You are even able to customize the layout of the functions you have at your disposal. Ask your HOLZMA consultant for more details.

CADmatic BASIC



CADmatic PRACTIVE



Overview

CADmatic PROFESSIONAL

Intuitive machine control – simple, fast and clear: CADmatic 4.5 PROFESSIONAL. The new operating software is available in combination with the new widescreen monitor – this package goes under the name of “powerTouch”. It makes machine control a breeze.

New: powerTouch operating panel | 1

The new powerTouch operating panel comprises an extra-large widescreen monitor with touch functionality. Zoom, wipe, scroll – simple, smart-phone-style movements are sufficient to utilize the control software’s entire range of functions. CADmatic 4.5 PROFESSIONAL also offers many further benefits.

- Intelligent production readiness display
- Softkeys
- Standardized navigation: all content selectable via a single window (for more information please see the HOMAG Group powerTouch brochure)
- Uninterrupted operation thanks to software messages that briefly appear and automatically disappear using speech-bubble technology (not shown)
- MMR basic for need-based maintenance and for logging key machine data

Keep an eye on the cutting pattern at all times | 2

The graphic shows you clearly and precisely which parts have already been produced and which are still to be cut, enabling you to keep an eye on everything at all times.



3D flow diagram with preview / review features | 3

The 3D flow diagram shows you the entire workflow at the saw in real time and from freely selectable perspectives. You also have the option of using the preview and review features, which allows you to see which parts in the current cycle have already been produced and which will be cut next.

Parts overview | 4

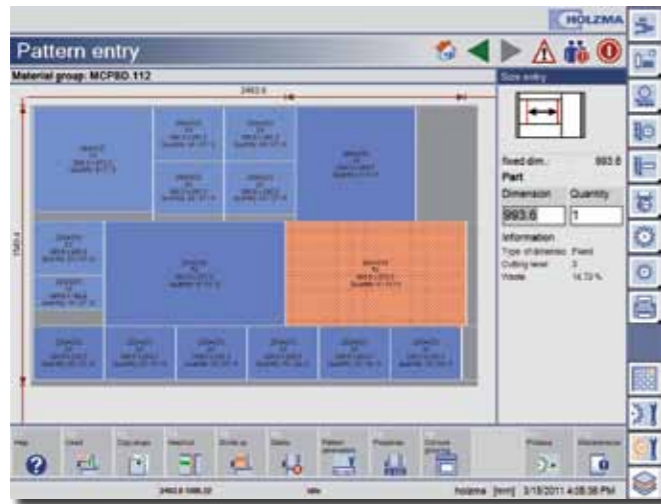
The cut parts are clearly arranged in a list. This gives you an overview of the parts that have been produced, as well as the option to reprint any labels you may need.



CADmatic 4.1 PROFESSIONAL

CADmatic 4.1 PROFESSIONAL is supplied as standard for angular saw units (HKL) from the 3 series upwards. CADmatic 4.1 PROFESSIONAL is also optionally available for your HPP 200 – for even more control potential for the 2 series, featuring a convenient touch screen.

Standard feature Cutting pattern entry



CADmatic 4.1 BASIC
CADmatic 4.1 PRACTICE
Cutting pattern entry

Standard feature Fixed position



CADmatic 4.1 BASIC
CADmatic 4.1 PRACTICE
Fixed position

For a fast single cut. Just enter the required dimension – nothing else is needed to complete the cut.

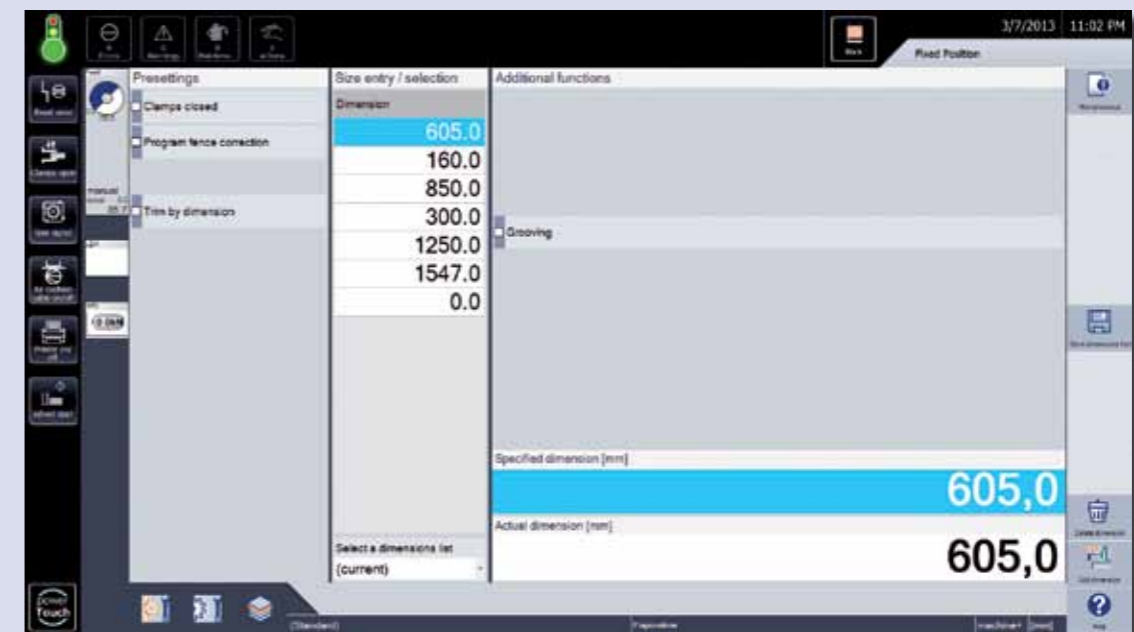
BASIC / PRACTICE

PROFESSIONAL



CADmatic 4.5 PROFESSIONAL
Cutting pattern entry

The full range: this is where you enter all the data that your HOLZMA needs to cut complex rip and crosscut patterns.



CADmatic 4.5 PROFESSIONAL
Fixed position

The program fence functions as a fixed position stop, with its clamps either open or closed.

- Input lists can be saved
- Easy trimming of edges

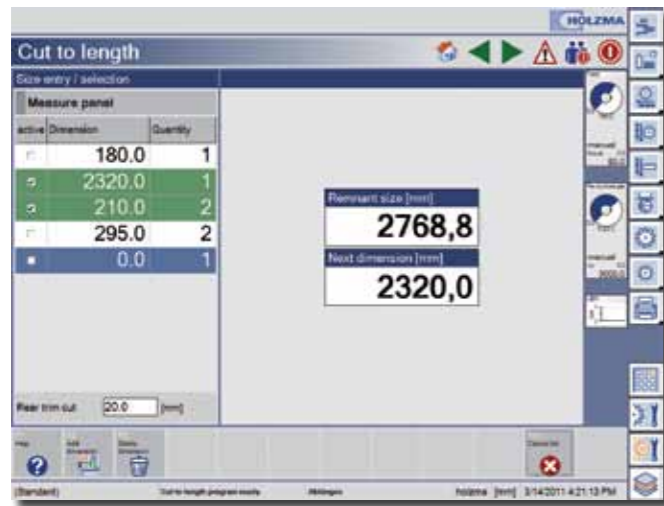


CADmatic 4.1 PROFESSIONAL
Cutting pattern entry



CADmatic 4.1 PROFESSIONAL
Fixed position

Standard feature Cut to length



CADmatic 4.1 BASIC
CADmatic 4.1 PRACTICE
Cut to length

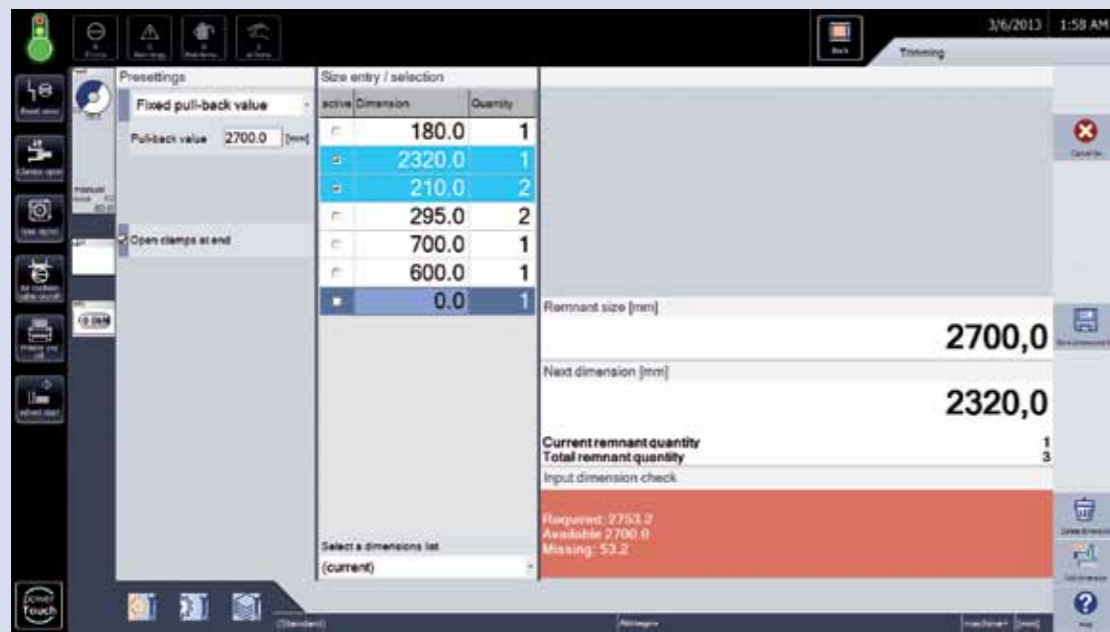
Cut after cut in one direction: here you can enter all the data needed to cut a strip into differently sized parts.

Standard feature Single parts



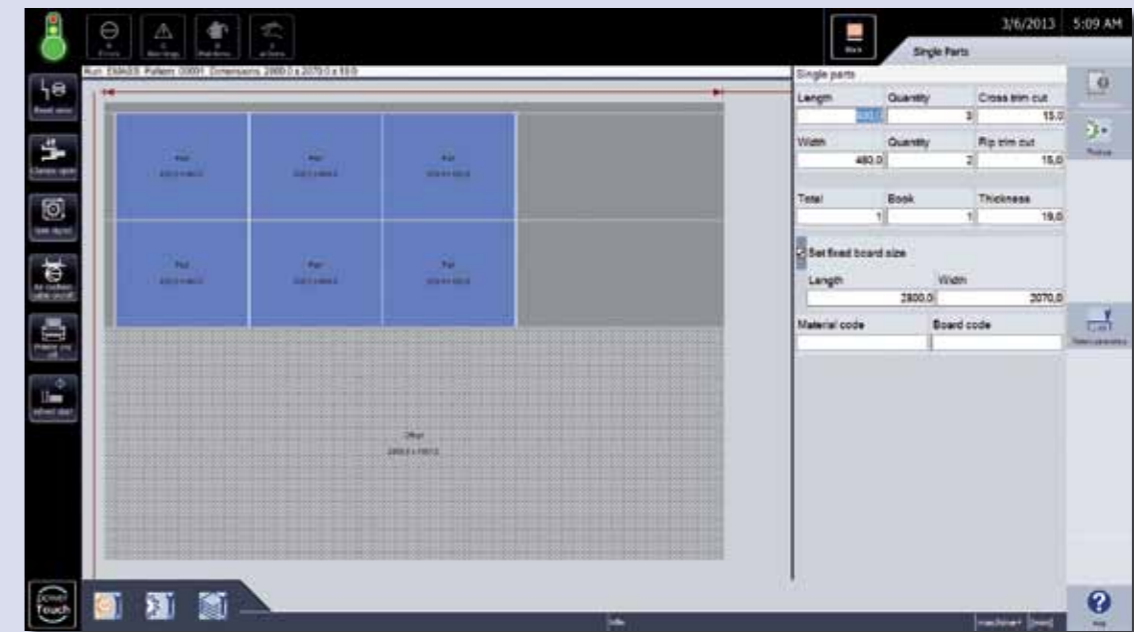
CADmatic 4.1 BASIC
CADmatic 4.1 PRACTICE
Single parts

For single cuts with a trim you only need to enter the dimensions. Everything else is already set up.



CADmatic 4.5 PROFESSIONAL
Cut to length

Cutting to length is controlled by a number of pre-
settings, allowing you, for example, to enter the book
height and to specify whether the clamps should open at
the end. In addition, it is possible to save dimension lists
that have already been entered. Finally, your input data is
checked for plausibility.

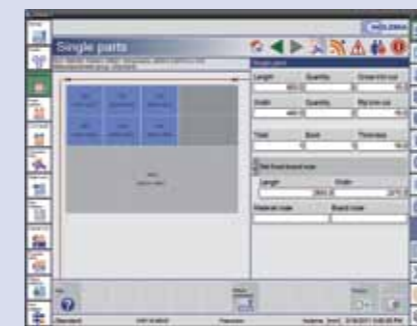


CADmatic 4.5 PROFESSIONAL
Single parts

Lengthwise and crosswise trims can be entered
separately for single cuts. You can also select codes
for materials and panels, as well as other parameters.



CADmatic 4.1 PROFESSIONAL
Cut to length



CADmatic 4.1 PROFESSIONAL
Single parts

Standard feature Graphically supported diagnostics



CADmatic 4.1 BASIC
CADmatic 4.1 PRACTICE
Graphically supported diagnostics

Standard feature Cutting pattern management



CADmatic 4.1 BASIC
CADmatic 4.1 PRACTICE
Cutting pattern management

Many cutting jobs need completing more than once. The good news: any cutting patterns created at the saw are saved and can be retrieved whenever needed, saving time and cutting costs.



CADmatic 4.5 PROFESSIONAL
Graphically supported diagnostics

The graphically supported diagnostics feature shows you immediately if, for example, an emergency stop has been activated or a service action is required. Furthermore, if your saw is equipped with a modem or an internet connection (TeleServiceNet), HOLZMA will be able to remedy most errors online - free of charge during the warranty period. This feature saves time and increases your productivity.



CADmatic 4.5 PROFESSIONAL
Cutting pattern management

Individual production sequences can be defined using the program sequence feature (including part summary).



CADmatic 4.1 PROFESSIONAL
Graphically supported diagnostics



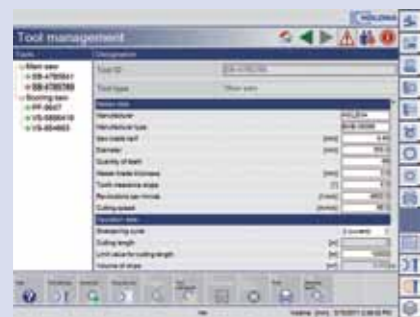
CADmatic 4.1 PROFESSIONAL
Cutting pattern management

Standard feature Tool management

Standard feature Parameter management



CADmatic 4.1 BASIC
CADmatic 4.1 PRACTICE
Parameter management



CADmatic 4.1 PROFESSIONAL
Tool management

CADmatic 4.5 PROFESSIONAL Tool management

How much board material have you already cut with this saw blade? Does its condition still meet your quality requirements? The tool management feature knows the exact answers to such questions and indicates when it is time to change the blade. To make use of this feature, simply enter estimated values for the specific material mix.

Do you use a number of different tools? If so, you can save the respective parameters under an appropriate name. The software then assigns the data for usage and volume to each tool separately. If a tool has to be replaced due to wear, you simply reset the corresponding counter to zero.



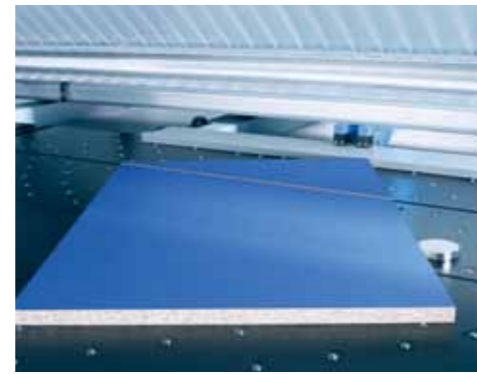
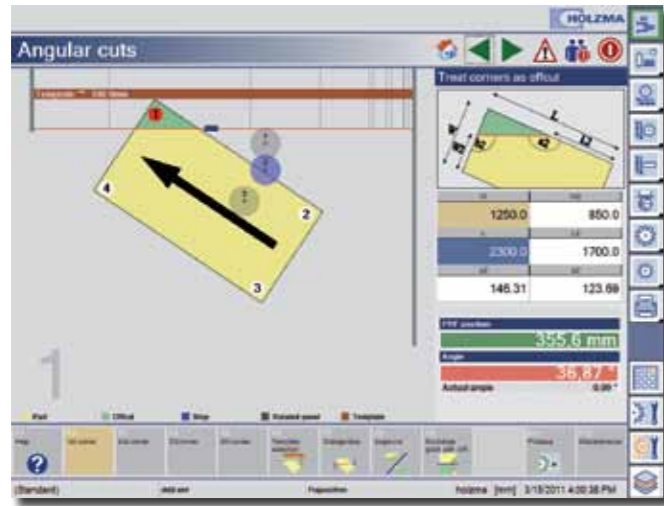
CADmatic 4.5 PROFESSIONAL Parameter management

Trim dimensions, speed or acceleration: CADmatic allows you to define basic machine settings, known as material parameters. These are then automatically accessed for each cutting process. You create a user-defined parameter list and have the option of changing the stored values whenever necessary.



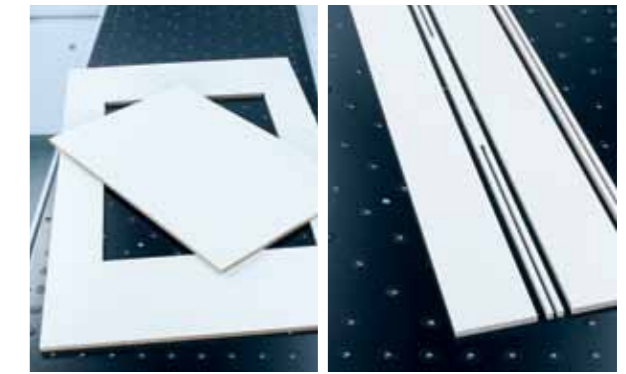
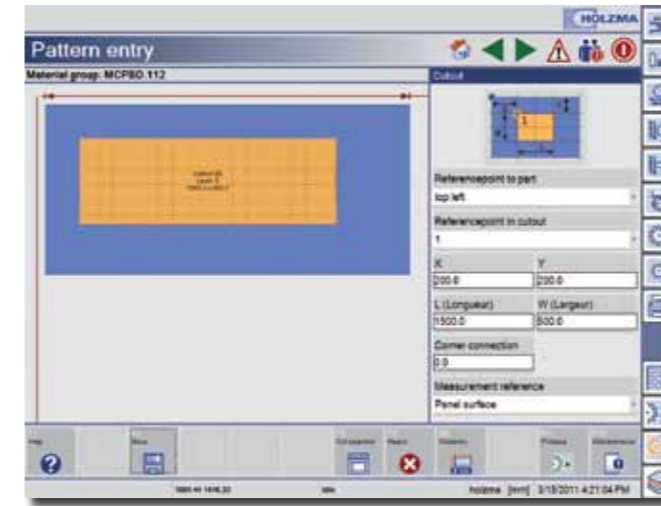
CADmatic 4.1 PROFESSIONAL
Parameter management

Optional feature
Manual angle cuts



CADmatic 4.1 PRACTICE
Manual angle cuts
 (not for CADmatic 4.1 BASIC)

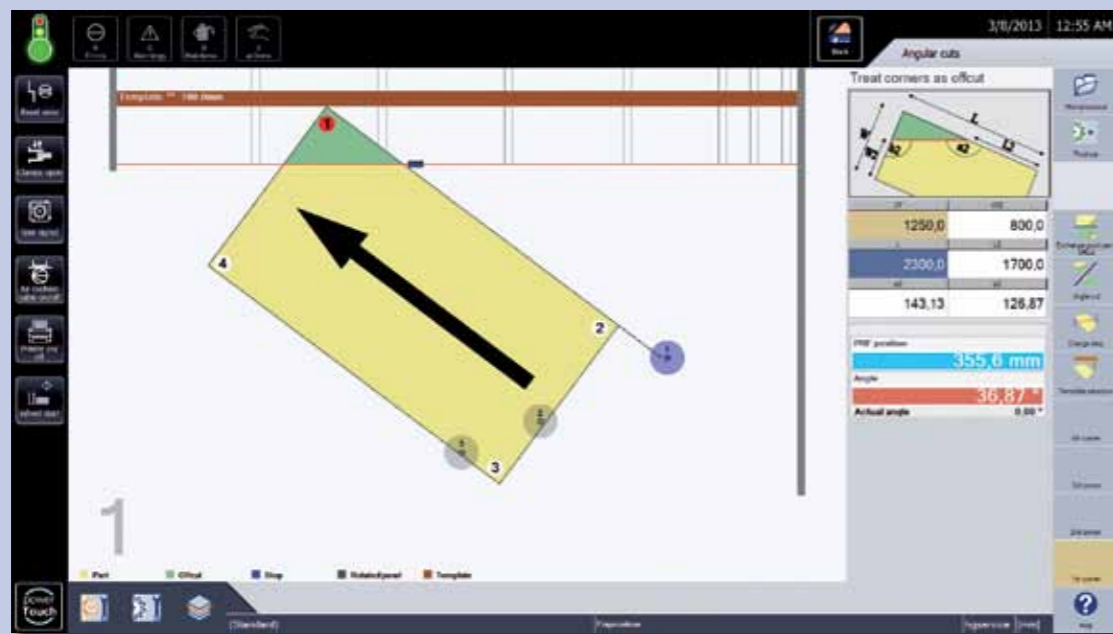
Optional feature
Cut-outs and stress-elimination cut



CADmatic 4.1 PRACTICE
Cut-outs and stress-elimination cut
 (not for CADmatic 4.1 BASIC)

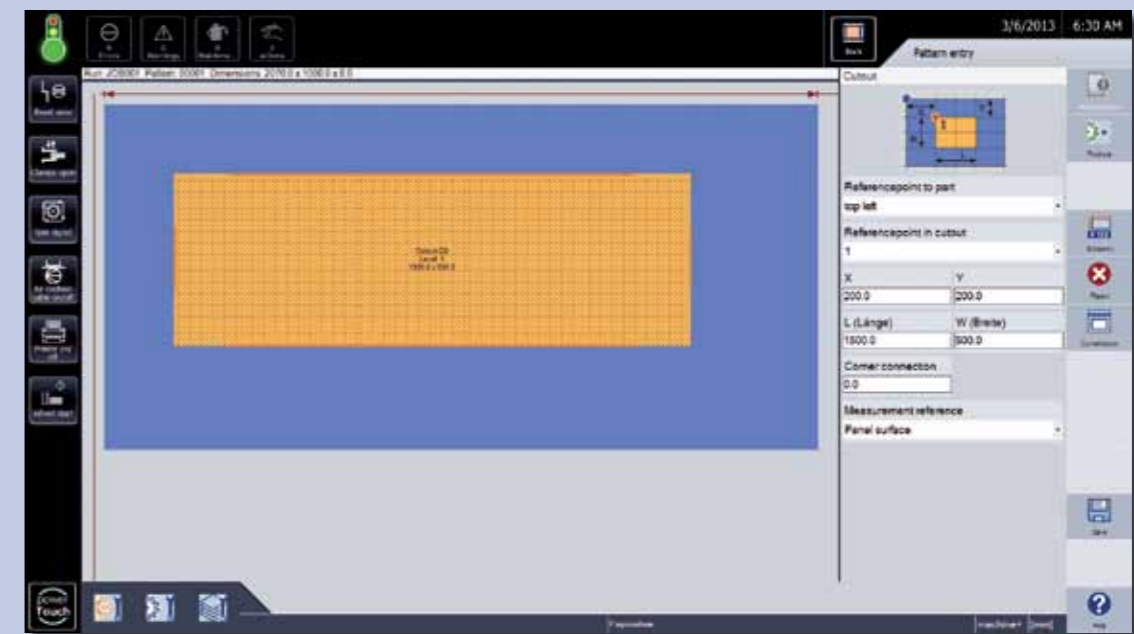
PRACTICE

PROFESSIONAL



CADmatic 4.5 PROFESSIONAL
Manual angle cuts

This feature allows you to control angle cuts quickly, conveniently and precisely.

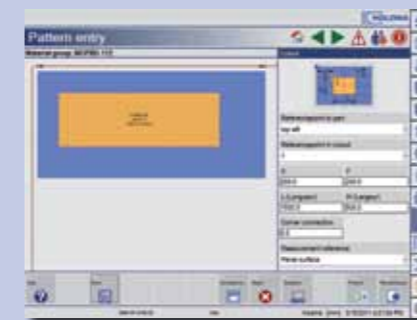


CADmatic 4.5 PROFESSIONAL
Cut-outs and stress-elimination cut

Laminated materials warp during cutting due to tension being released – the HOLZMA stress-elimination cut feature has the solution. The tension is released by specifically pre-cutting the material. In addition, the cut-out feature allows sections to be cut out of panels – for example for kitchen sinks.

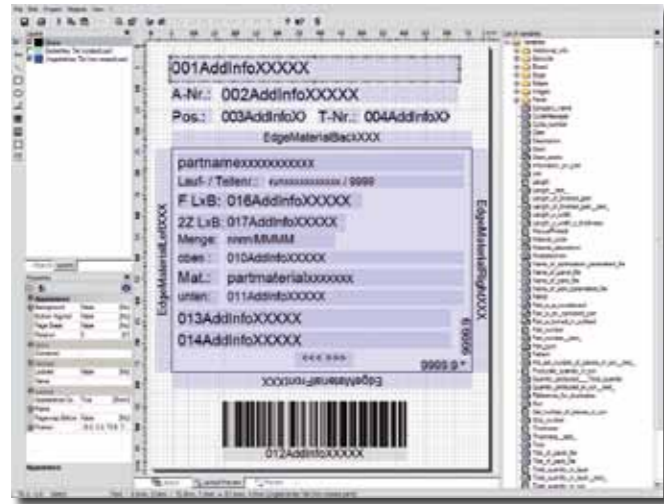


CADmatic 4.1 PROFESSIONAL
Manual angle cuts



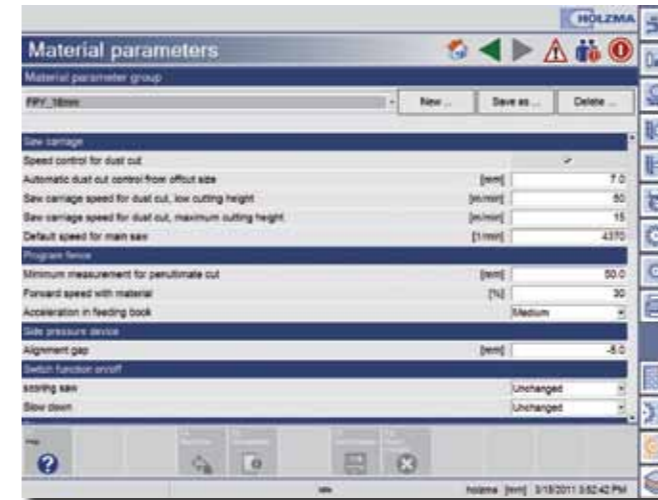
CADmatic 4.1 PROFESSIONAL
Cut-outs and stress-elimination cut

Optional feature Labeling

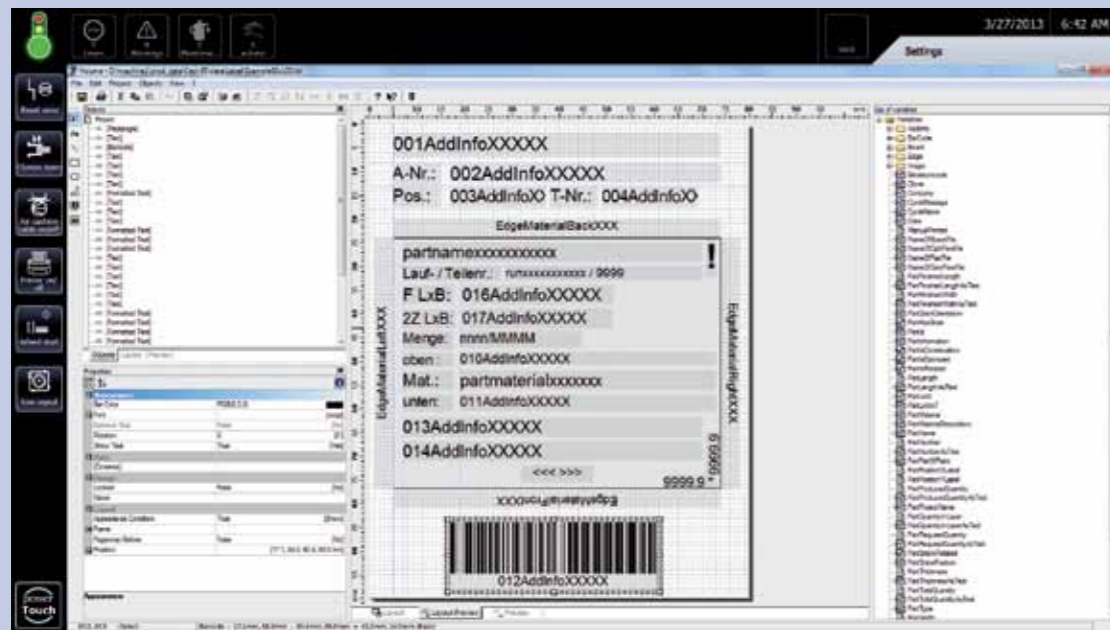


CADmatic 4.1 BASIC
CADmatic 4.1 PRACTICE
Labeling

Optional feature Material-dependent parameters



CADmatic 4.1 BASIC
CADmatic 4.1 PRACTICE
Material-dependent parameters



CADmatic 4.5 PROFESSIONAL Labeling

With the optional "Labeling" feature, you can label the results of your work – whether individual components, cut books or entire stacks – with all the relevant information, in time with the cuts, and pass data on to downstream machines.

How does it work? The layout editor allows you to define the label design and enter the required data in CADmatic. You are able to include text information as

well as graphics and freely selectable bar codes. The system will then generate the labels in perfect time with the processing cycles. Depending on the system, the labels are then attached automatically or by hand.

An optional feature that sets industry benchmarks where scope for design and hardware quality is concerned, leaving nothing to be desired.



CADmatic 4.5 PROFESSIONAL Material-dependent parameters

When processing many different materials, the saw needs re-adjusting each time the material is changed. This re-adjustment increases set-up time at the expense of production time. Adjustment can be automated and significantly speeded up using the add-on module "material-dependent parameters".

You only need to enter the parameter settings for each material once. These settings may include, for example, settings for the travel of the side pressure device, for the saw blade projection or for the

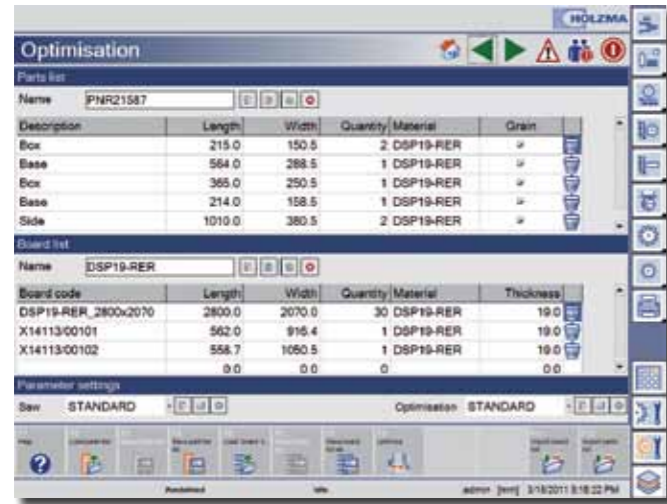
point of immersion for postforming material. Other parameters such as the pressure of the clamps and pressure beam, or the speed can also be specified, if your HOLZMA is equipped with one of these options (some options only available from the 3 series upwards).

When you change materials, you then only have to retrieve the corresponding set of parameters – and your HOLZMA is adjusted. This process is performed fully automatically and in the blink of an eye.

CADmatic 4.1 PROFESSIONAL
Labeling

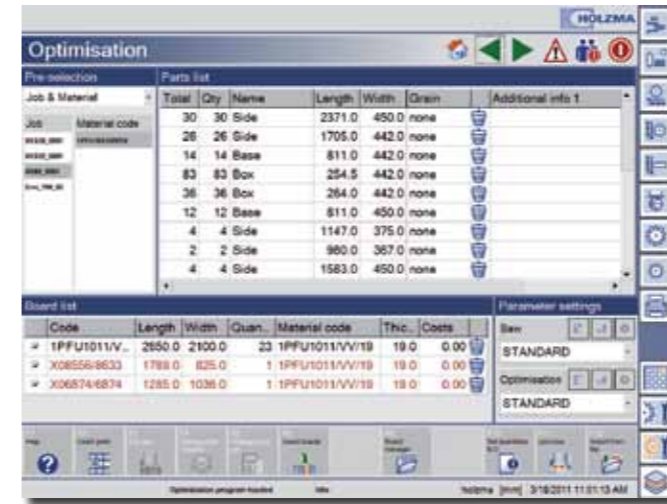
CADmatic 4.1 PROFESSIONAL
Material-dependent parameters

Optional feature CADplan – manual cutting pattern optimization

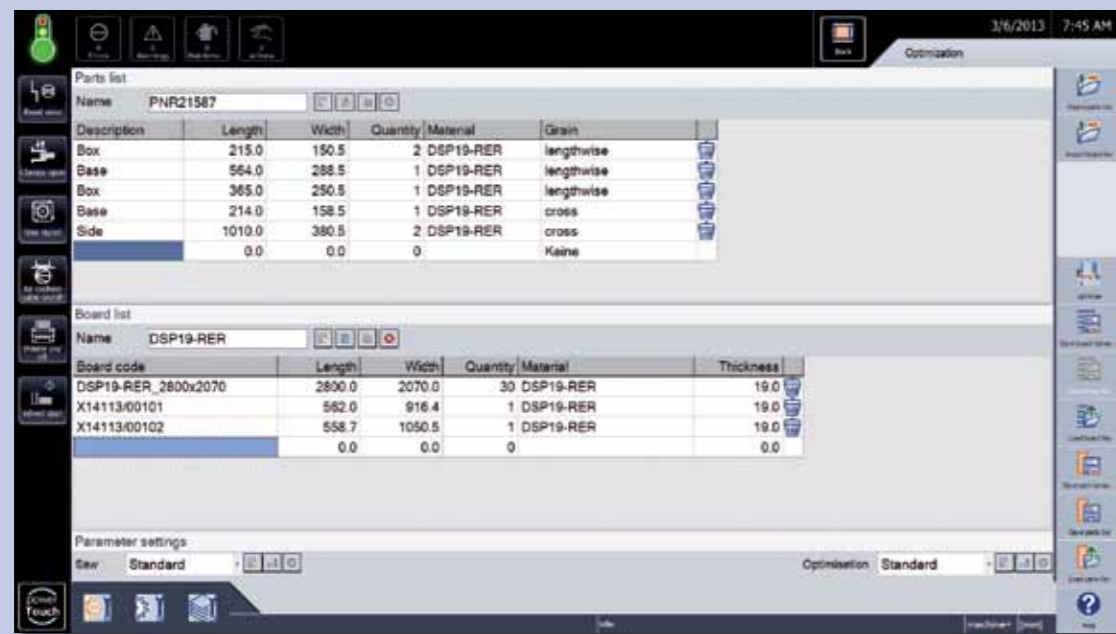


CADmatic 4.1 BASIC
CADmatic 4.1 PRACTICE
CADplan – manual cutting pattern optimization

Optional feature “Just-in-time” optimization



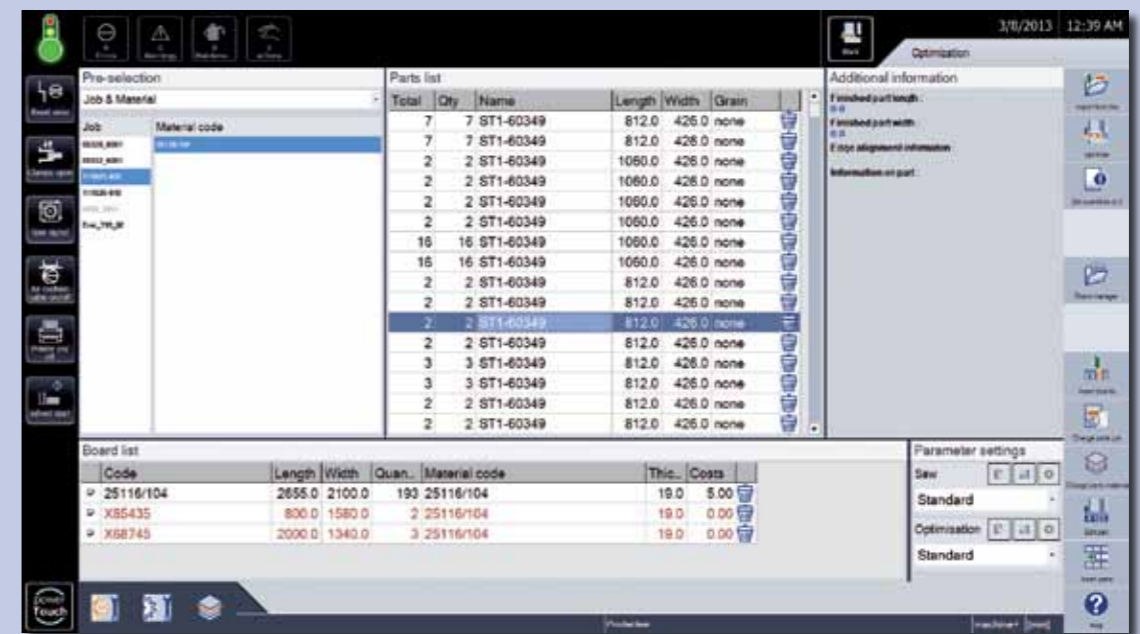
CADmatic 4.1 BASIC
CADmatic 4.1 PRACTICE
“Just-in-time” optimization



CADmatic 4.5 PROFESSIONAL
CADplan – manual cutting pattern optimization

Our motto is “get more out of it”. That is why HOLZMA has taken its CADplan cutting pattern optimization feature directly to the saw. The benefit to you: you simply enter all the parts lists and panel lists for the current order into CADmatic, or

import the Excel lists required in CSV file format. CADplan then promptly generates optimized cutting patterns, minimizing material wastage and making your company more productive. The ideal solution for small to medium-sized orders.



CADmatic 4.5 PROFESSIONAL
“Just-in-time” optimization

The “just-in-time” optimization feature from HOLZMA goes one step further than CADplan, allowing you to import the parts lists currently required directly from the office and to process them on the saw – without time-consuming manual input, and precisely when you need them. If the same materials are required by different jobs, they can be grouped and optimized together. Thanks to this feature, the “just-in-time” add-on module allows very dynamic, production-related cutting pattern optimization.

ing production and can then be included in the optimization process. The intelligent parts management feature allows a company’s entire panel stock to be managed via CADmatic – an interesting alternative for all panel saws without storage system integration.

In addition, you also have the option of importing cutting patterns that have already been optimized from the office. Data will then simply be imported from an industry-standard optimization software program such as Cut Rite.

If required, any offcuts available at the saw can be entered by hand before start-

CADmatic 4.1 PROFESSIONAL
CADplan – manual cutting pattern optimization

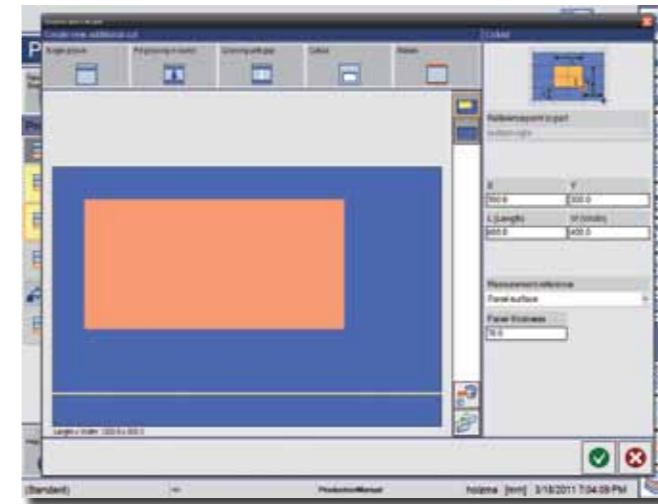
CADmatic 4.1 PROFESSIONAL
“Just-in-time” optimization

Optional feature
Manual production list:
1. Facts at a glance



CADmatic 4.1 PRACTICE
Facts at a glance
 (not for CADmatic 4.1 BASIC)

Optional feature
Manual production list:
2. One input screen for all work steps

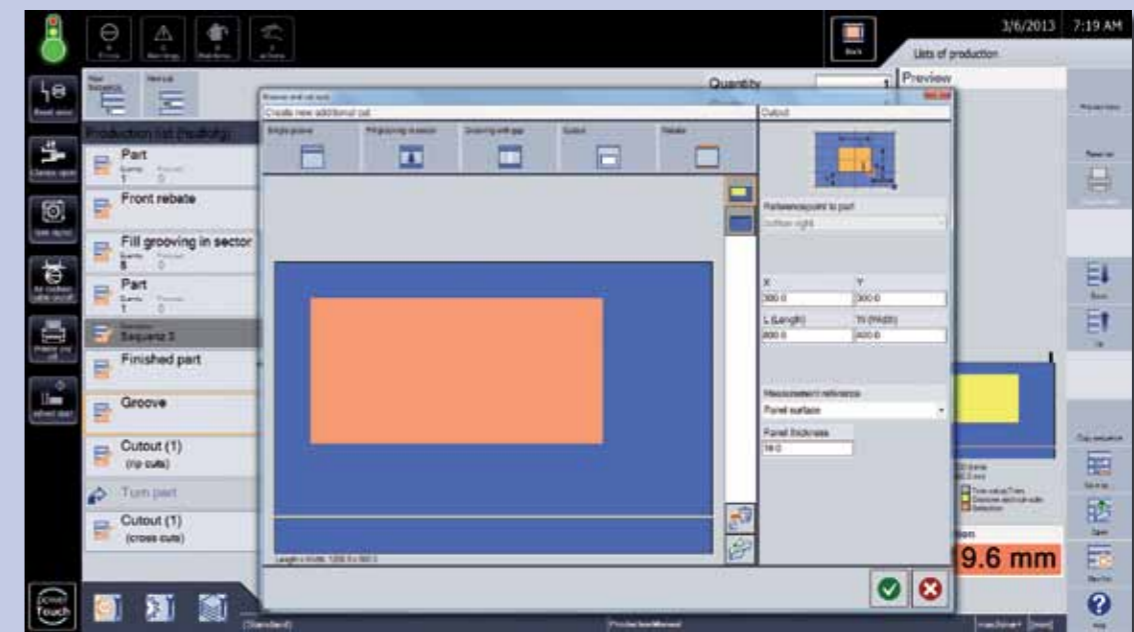


CADmatic 4.1 PRACTICE
One input screen for all work steps
 (not for CADmatic 4.1 BASIC)



CADmatic 4.5 PROFESSIONAL
Facts at a glance

With the "manual production list" module, you are able to control all the functions of your saw using just one input screen, and keep an eye on everything at all times – thanks to 2D, real-time process graphic. This module allows you to save all your input and retrieve it whenever required.

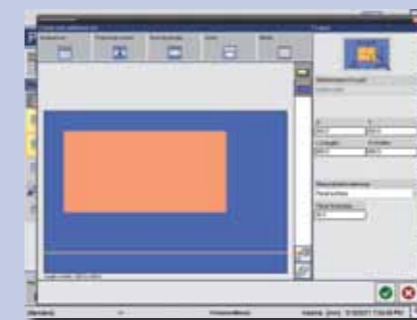


CADmatic 4.5 PROFESSIONAL
One input screen for all work steps

- Single cuts
- Processing of finished parts
- Grooving / turbo-grooving and rabbeting
- Cut-outs
- Cut to length
- Checkerboard cutting



CADmatic 4.1 PROFESSIONAL
Facts at a glance



CADmatic 4.1 PROFESSIONAL
One input screen for all work steps

Optional feature Data transfer via network

Data transfer via network

If you work in a network environment, you can exchange useful CADmatic data quickly and interactively – from saw to saw as well as between the saw and your company's central data management system.

HOLZMA offers you several ways of doing this:

- Wi-Fi online connection
- Ethernet cable online connection
- USB interface (chat function not available)

Program sequence 0-240-82-3003

Current production

Plan	Pattern	Soll Anzahl Zyklen	Ist Anzahl Zyklen	Start	End
18233	00001	4	0	3/18/2011 2:10:49 PM	3/18/2011 2:22:49 PM

Program sequence

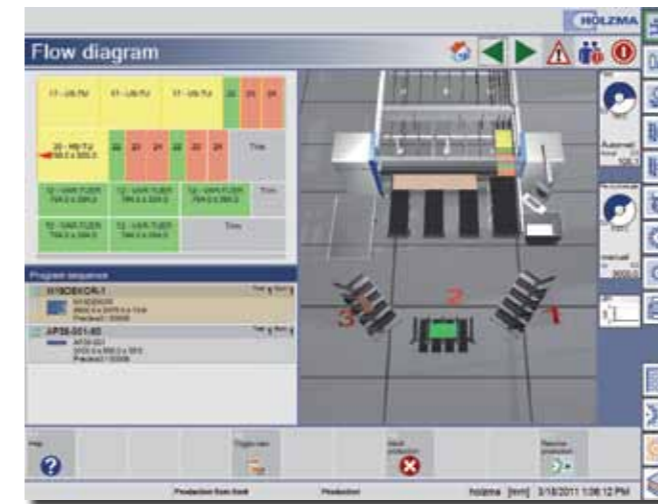
Plan	Pattern	Soll Anzahl Zyklen	Ist Anzahl Zyklen	Start	End
18233	00002	1	0	3/18/2011 2:22:49 PM	3/18/2011 2:26:19 PM
17979	00001	1	0	3/18/2011 2:26:19 PM	3/18/2011 2:27:10 PM
17979	00002	1	0	3/18/2011 2:27:19 PM	3/18/2011 2:29:59 PM
17979	00003	1	0	3/18/2011 2:29:59 PM	3/18/2011 2:32:29 PM
17979	00004	1	0	3/18/2011 2:32:29 PM	3/18/2011 2:33:59 PM
17979	00005	1	0	3/18/2011 2:33:59 PM	3/18/2011 2:36:30 PM
17979	00006	1	0	3/18/2011 2:36:38 PM	3/18/2011 2:39:29 PM
17979	00007	2	0	3/18/2011 2:39:29 PM	3/18/2011 2:41:49 PM
17979	00008	1	0	3/18/2011 2:41:49 PM	3/18/2011 2:42:49 PM
17979	00009	1	0	3/18/2011 2:42:49 PM	3/18/2011 2:43:59 PM
17979	00010	1	0	3/18/2011 2:43:59 PM	3/18/2011 2:46:29 PM
17979	00011	1	0	3/18/2011 2:46:29 PM	3/18/2011 2:47:39 PM
18233	00003	1	0	3/18/2011 2:47:39 PM	3/18/2011 2:51:00 PM

Production history

Plan	Pattern	Soll Anzahl Zyklen	Ist Anzahl Zyklen	Start	End
18123	00001	1	0	3/18/2011 2:03:42 PM	3/18/2011 2:03:42 PM
18233	00004	4	4	3/18/2011 2:07:50 PM	3/18/2011 2:08:55 PM
18233	00005	1	1	3/18/2011 2:08:55 PM	3/18/2011 2:09:34 PM
18233	00006	1	1	3/18/2011 2:09:34 PM	3/18/2011 2:10:02 PM
18233	00007	3	2	3/18/2011 2:10:03 PM	3/18/2011 2:10:15 PM

CADmatic 4.1 PROFESSIONAL allows users – via a secure network – to also view the production status and use the chat function for communication.

Optional feature Destacking module LITE



CADmatic 4.1 PRACTICE
Destacking module LITE



CADmatic 4.5 PROFESSIONAL
Destacking module LITE

Which part goes where? The answer to this question is supplied by the integrated destacking display. The individual parts are color-coded both in the cutting pattern and in the flow diagram, allowing the machine operator to clearly see which of the parts already produced have been allocated to which destacking stations.



CADmatic 4.1 PROFESSIONAL
Destacking module LITE

Optional feature – only for PROFESSIONAL Destacking module PRACTICE

An intelligent destacking concept that guides the operator

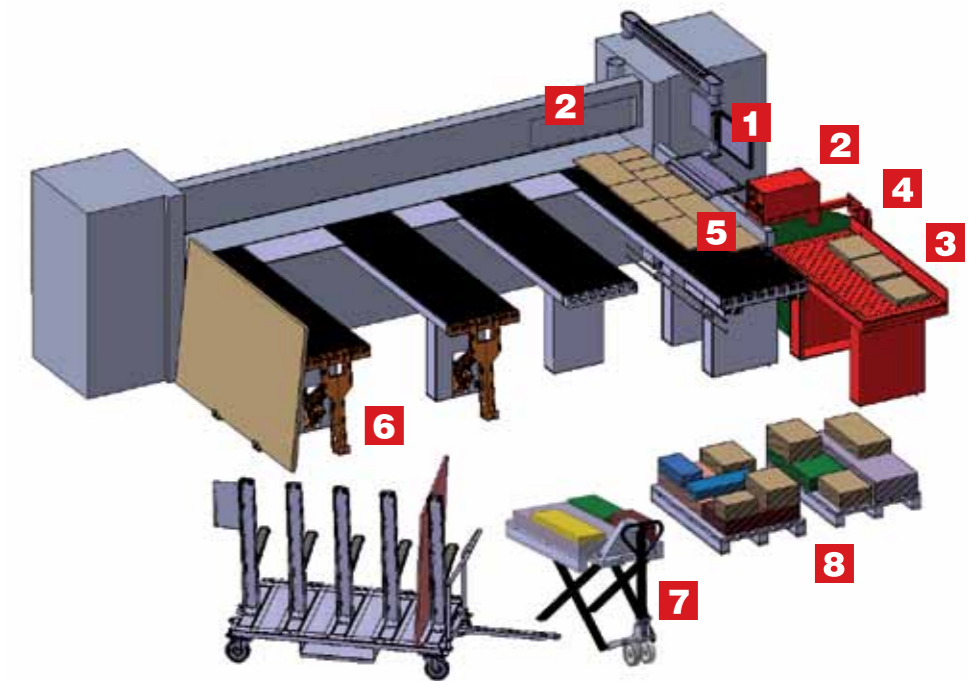
With the optional “destacking module PRACTICE”, CADmatic 4.5 PROFESSIONAL controls not only the cutting process, but also the process of destacking by the operator. The new powerTouch control panel shows the operator exactly when and where each part is to be deposited via the monitor and on each label. This process is underpinned by an intelligent destacking concept designed to boost the efficiency of post-cutting processes enormously - for example, by creating stacks optimized for subsequent processing steps.

Reduces routes, space requirements and operator dependency

Thanks to the optional “destacking module PRACTICE”, the program sequence and the destacking strategy can be managed more precisely and tailored more effectively to requirements than ever before. You can determine whether the stack formation is optimized for subsequent processing steps or according to the order or material. These priorities can be combined with one another and weighted according to the primary objective. This process ensures clear operator guidance, reduces routes between the saw and the destacking location, and ensures optimized pallet utilization with stable stack formation.

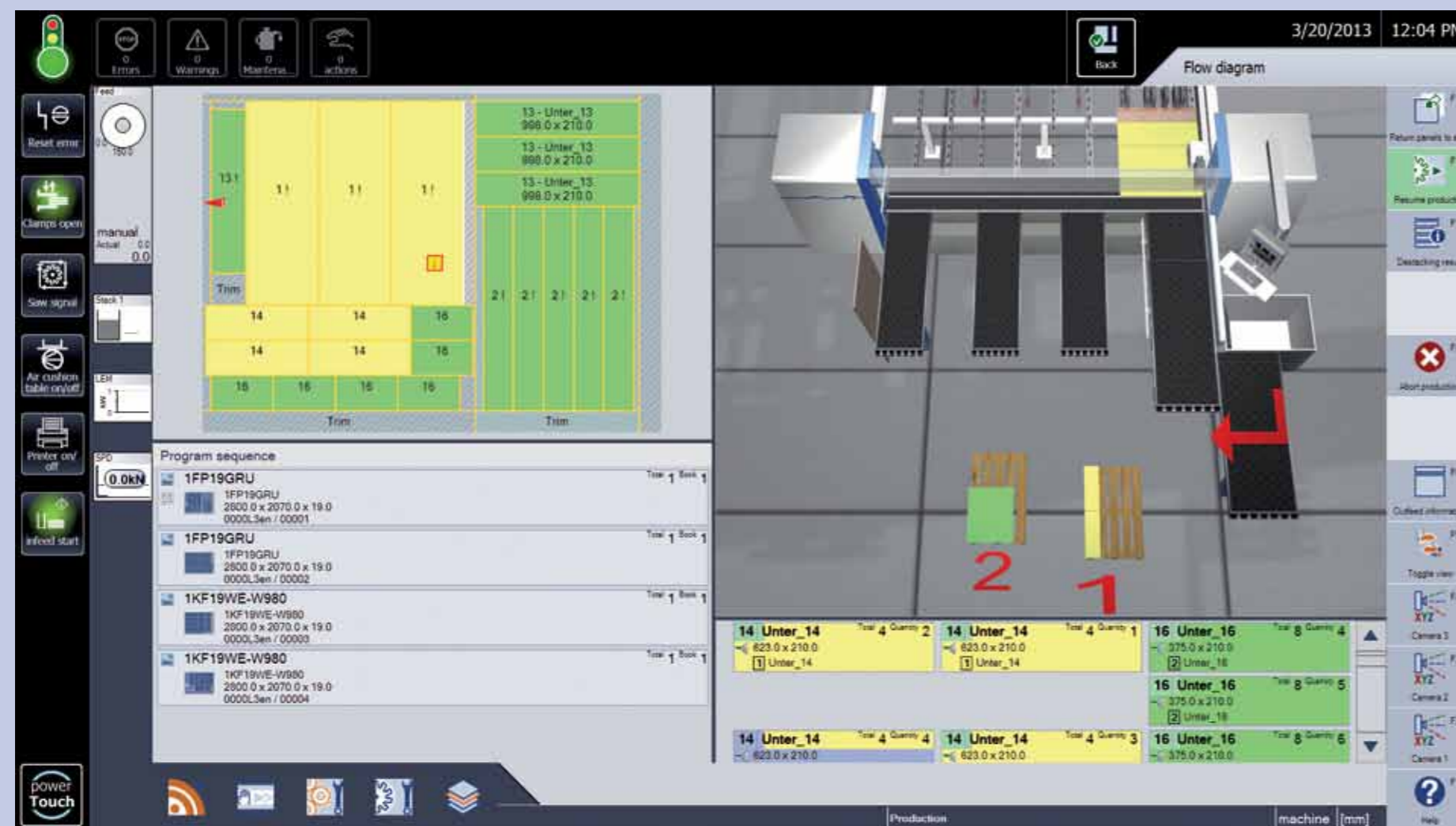
New! More features for intelligent destacking:

- **Visual operator guidance:** an additional LED display indicates, at the same time as the monitor, when the operator is to push a cut part onto the parts buffer, or remove it from there.
- **Flexible parts buffer:** up to now, only the parts of a panel that were cut last went onto the parts buffer, so as not to slow down the saw. New: now the parts buffer is always used whenever it can improve stack formation.
- **Additional stability:** in order to make stacks more stable, waste parts are now actively used in stack formation.



The new HOLZMA destacking concept

- 1 New destacking software
- 2 Label printing with destacking information
- 3 Parts buffer
- 4 Waste container
- 5 New chopping edge
- 6 Feeding and destacking aid
- 7 New scissor lift pallet truck
- 8 Intelligent stack formation



Optional feature Storage system integration and production planning

Optional feature 1. Storage location management for offcuts

Transparency in your offcuts store in the blink of an eye

The way to transparency in your offcuts store is quick and simple. All you need to get there is:

- Cut Rite from version PRACTIVE upwards
- CADmatic PRACTIVE or PROFESSIONAL with the “storage location management for offcuts” module
- The HOLZMA storage system software integrated at the factory
- The “stock control” module for Cut Rite

The benefits:

- You can adopt a customized storage strategy and sort offcuts according to size, material or other criteria.
- How many offcuts are in the store? How many are moved in or out of the store on average each day? The integrated statistical data generator provides the answers to these and other questions.
- Cut Rite groups cutting patterns together in a single run. In doing so, all the offcuts required can be shown at once and can be retrieved from the store before starting production.

Plenty of potential for expansion

If you subsequently invest in a HOMAG Automation storage system, the “storage location management for offcuts” module can be directly integrated in the HOMAG Automation software.

Designation	position	Height (mm)	Width (mm)	Number
1 Compartment	101-102	3500	800	2
2 Compartment	103-118	3500	400	16
3 Compartment	119-128	1750.1750	400	8
4 Compartment	129-		400	0

Setting up the offcuts store



From feeding ...

“The storage system controls the saw”: CADmatic PROFESSIONAL features a data connection to your storage system, providing the basis for completely automated feeding. Current stock information from your horizontal, block stack or high-bay storage system is provided parallel to production and is taken into account in all CADmatic calculations, allowing material usage to be optimized. Even offcuts are registered and recorded in the storage system.

... to real time production planning

CADmatic PROFESSIONAL is prepared for connection to your internal ERP or PPC system. All production data is passed to the planning system in real time, allowing you to react promptly even to last minute changes in orders and take them into account for your production planning.

Optional feature 2. Storage location management for offcuts

The procedure – step-by-step

After installing the software, you must enter the length, depth and width of each shelf compartment in the offcuts store – a quick and easy process thanks to the intuitive user interface.

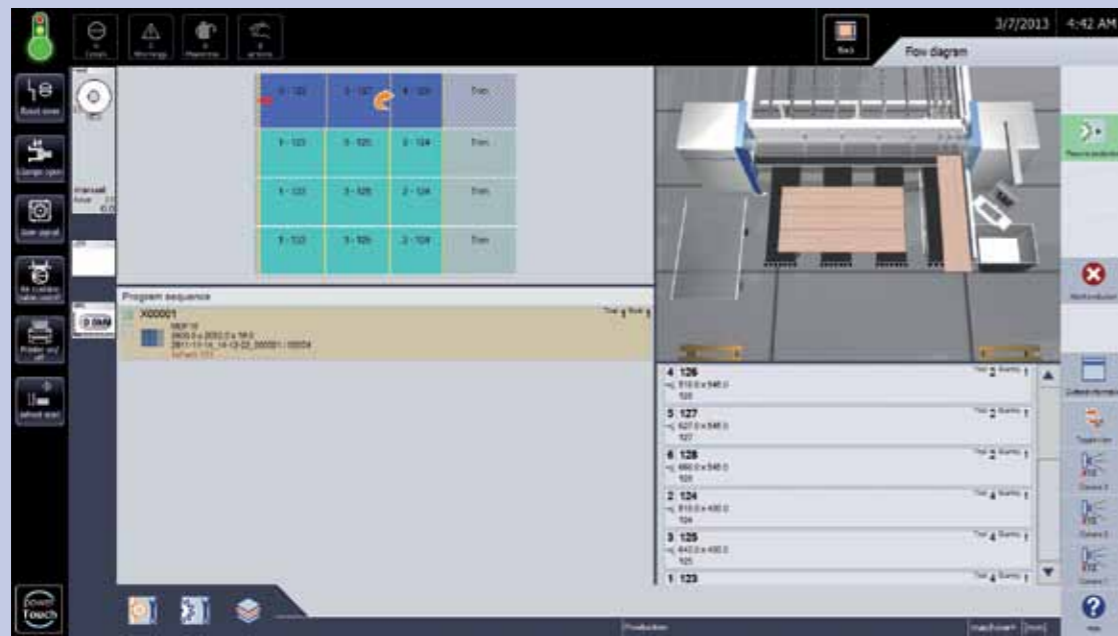
1. As soon as an offcut leaves the saw, a label is printed.
2. The label indicates the compartment where the offcut is to be stored. Alternatively, you can also manually determine the storage location via CADmatic.
3. In either case, CADmatic recognizes the storage location and automatically synchronizes this information with the data in the storage system software and Cut Rite.
4. If you then want to produce a new cutting pattern, there are two options available: either retrieve a cutting pattern that has already been optimized by Cut Rite via CADmatic, or create a pattern directly at the saw using the CADmatic “pattern entry” feature.
5. As soon as you start production, the flow diagram will show you which offcut you need to retrieve from which shelf.

Optional feature 3. Storage location management for offcuts

An extra for greater flexibility: the scanner package

If you do not only use your HOLZMA saw to process offcuts, you can now benefit from the new scanner package. The scanner will show whether an offcut in the store is still available or already reserved.

- The operator scans the label using the scanner.
- If the offcut has already been reserved for a cutting pattern, a red light comes on.
- If this is not the case, a green light comes on and the operator can take the offcut. The HOLZMA “storage location management for offcuts” then automatically adjusts the stock.
- In exceptional cases, a blue light may come on and prompt the operator to enter more details.



CADmatic 4.5 PROFESSIONAL
Offcut removal display in the flow diagram



CADmatic 4.1 PROFESSIONAL
Offcut removal display in the flow diagram



CADmatic 4.5 PROFESSIONAL
Controlled storage of offcuts



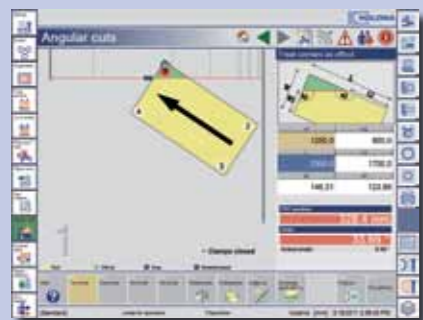
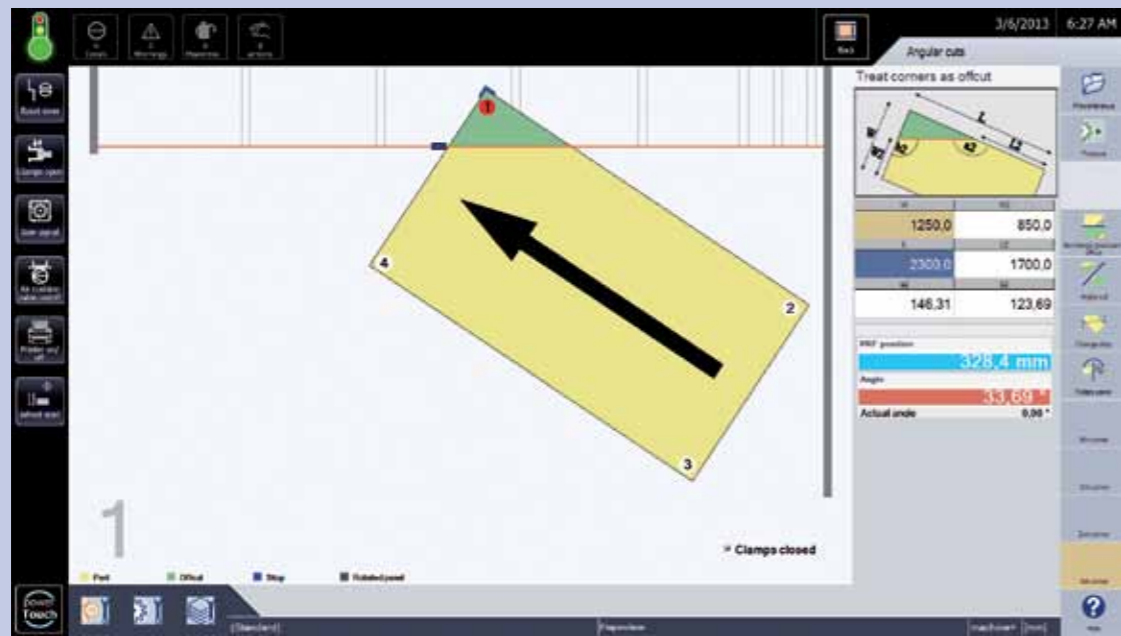
CADmatic 4.1 PROFESSIONAL
Controlled storage of offcuts

Optional feature – only for PROFESSIONAL
Automatic angle cuts



Optional feature – only for PROFESSIONAL
Integrated camera monitoring

PROFESSIONAL



CADmatic 4.5 PROFESSIONAL
Automatic angle cuts

The angle cut program allows you to control precise angle cuts either manually, or automatically using an angle cut clamp, depending on how the machine is equipped. This feature enables you to achieve precise results quickly and easily.



CADmatic 4.5 PROFESSIONAL
Integrated camera monitoring

Especially for large panel saws, HOLZMA offers an integrated camera monitoring system for the rear machine table. Whenever the saw is fed, CADmatic automatically displays the current camera image, enabling you to keep an eye on everything at all times. Furthermore, it is also possible to record the camera images for troubleshooting and workflow-optimization purposes and to forward the images to the HOLZMA Service department.

CADmatic 4.1 PROFESSIONAL
Automatic angle cuts

CADmatic 4.1 PROFESSIONAL
Integrated camera monitoring

Technical data

CADmatic BASIC | CADmatic PRACTIVE | CADmatic PROFESSIONAL

Area	Function	Option number	4.1 BASIC	4.1 PRACTIVE	4.1 PROFESSIONAL as an option	4.1 PROFESSIONAL (standard HKL) 4.5 PROFESSIONAL (standard HPP & HPL)
	Machine model		1 series	HPP 200	HPP 200	3 series 4 series 5 series

General						
	Display		19"	19"	19"	19" (vers. 4.1), 21" (vers. 4.5)
	Resolution		1280 x 1024	1280 x 1024	1280 x 1024	1280 x 1024 (19"), 1920 x 1080 (21")
	Touch screen		X	X	✓	✓
	Machine keys		✓	✓	✓	✓
	Machine controller		✓	✓	✓	✓
	Optimized user interface: simplified views		✓	✓	✓	✓
	Optimized user interface: advanced views		X	X	✓	✓

Production methods						
	Fixed position		S	S	S/A	S/A
	Cut to length		S	S	S/A	S/A
	Single parts		S	S	S/A	S/A
	Cutting pattern entry		✓	✓	✓	✓
	Pattern selection (cutting pattern management)		S/A	S/A	S/A	S/A
	Pattern selection: estimation of production times		X	X	✓	✓

Production methods – optional features						
	Grooving program (automatic)	6050	X	X	X	O
	Turbo-grooving	6057	X	X	O	O
	Cut-outs and stress-elimination cuts	6065	X	O	O	O
	Angle cut program	6085	X	O	O	O
	Manual production list	6066	X	O	O	O
	PPC feedback	6240	X	X	O	O
	Integrated camera monitoring	6318	X	X	X	O
	Camera-controlled scoring saw adjustment	6040	X	X	X	O
	Production start supported by barcode scanner	6230	X	O	O	O

Stock control						
	Storage system integration	6225	X	O	O	O
	Storage system integration in CADplan and cutting pattern entry		X	X	✓	✓
	Improved offcuts return system		X	X	✓	✓
	Storage location management for offcuts	6097	X	O	O	O
	Storage location management for offcuts (scanner option)	6098	X	O	O	O

Area	Function	Option number	4.1 BASIC	4.1 PRACTIVE	4.1 PROFESSIONAL as an option	4.1 PROFESSIONAL (standard HKL) 4.5 PROFESSIONAL (standard HPP & HPL)
	Machine model		1 series	HPP 200	HPP 200	3 series 4 series 5 series

Optimization						
	CADlink	6089	O	O	O	O
	CADplan for angular saw units	6092	X	X	X	O
	CADplan: "just-in-time"	6093	O	O	O	O

Flow diagram						
	3D flow diagram		S	S	S/A	S/A
	Display of part details in the cutting pattern		✓	✓	✓	✓
	Flow diagram: preview and review feature		X	X	A	A

Settings / parameters						
	Parameter management		✓	✓	✓	✓
	User-defined show / hide parameters feature		✓	✓	✓	✓
	Material-dependent parameters	6100	X	O	O	O
	Automatic compensation of saw blade offset		✓	✓	✓	✓
	Tool settings		✓	✓	✓	✓
	Tool management		X	X	✓	✓

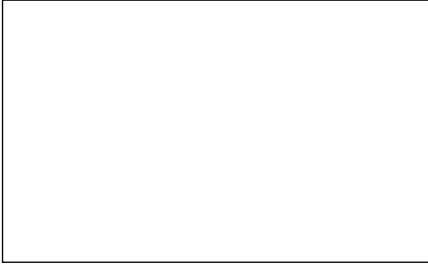
Destacking						
	Destacking module LITE	6310	X	O	O	O
	Destacking module PRACTIVE (with operator guidance)	6311	X	X	X	O
	Destacking module SYSTEMS	6315	X	X	X	O

Miscellaneous						
	Alarms overview (graphically supported diagnostics)		✓	✓	✓	✓
	woodLine & woodScout integration	6243	X	X	X	O
	Data transfer via network	6200	O	O	O	O
	Web access with option number 6200		X	X	O	O
	Data transfer via USB	6206	O	O	O	O
	HOMAG MMR basic		X	✓	✓	✓
	HOMAG MMR professional	6125	X	X	X	O
	Run data evaluation with Cut Rite	6120	O	O	O	O

Labeling						
	Labeling program	6075	O	O	O	O
	Labeling with parts graphic	6070	O	O	O	O

- ✓ Standard
- S Standard simplified
- A Standard advanced
- O Optional
- X Not possible

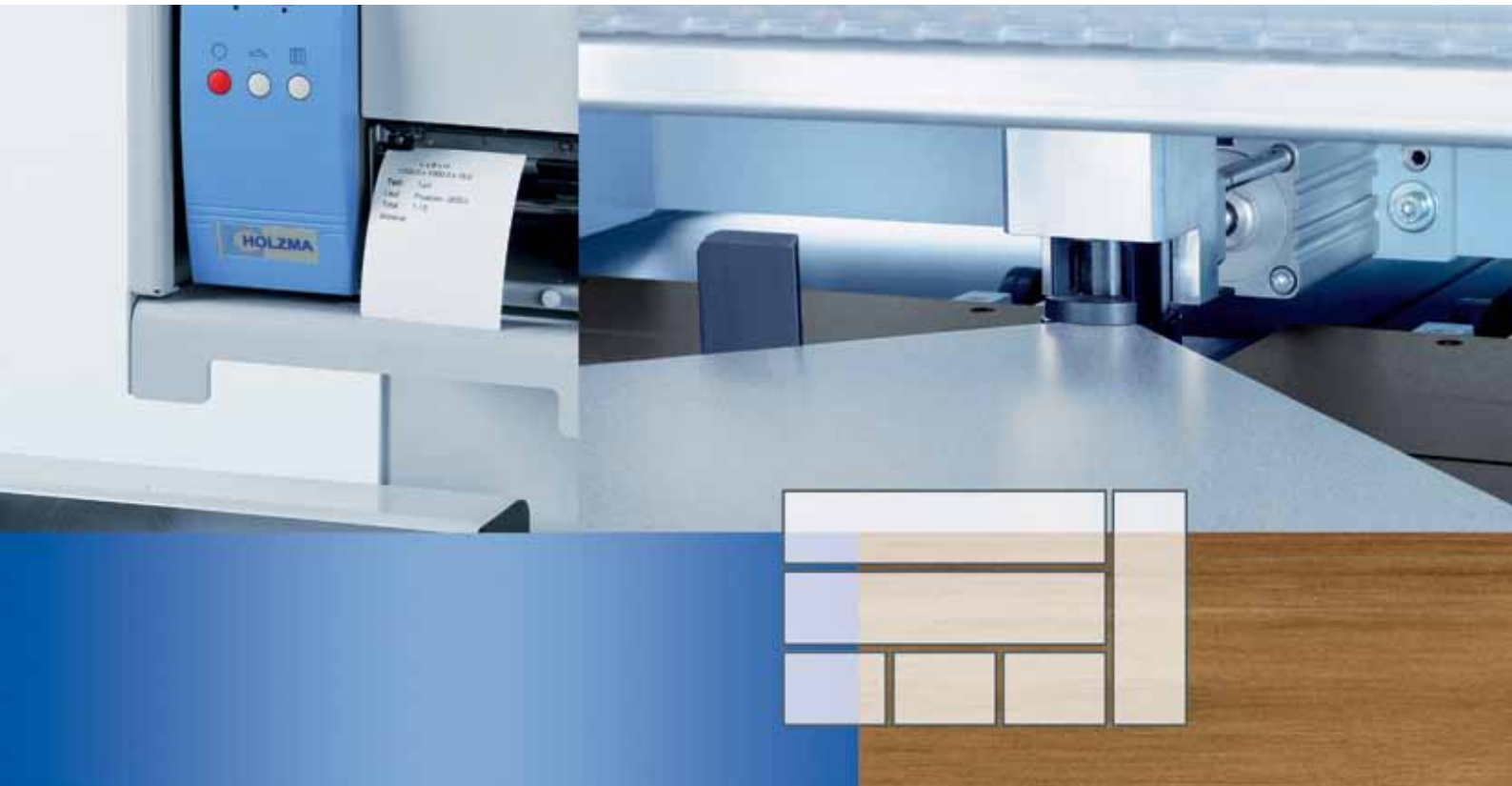
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Printed 05/15. Part number 4-099-70-0152
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