

## Focusing on the essential



**The 4 series:**  
**HPP 400 | HPL 400 | HKL 400**

# The HOLZMA 4 series – the essence of performance

The 4 series stands for first-rate technology on fair terms. No matter whether it's the HPP, the HPL or the HKL, all three standard versions offer you everything you expect of saws in this performance category – and a great deal more, if you need it. Simply select the appropriate optional features. This allows you to invest selectively in the right technology, thus matching your HOLZMA saw to your individual requirements.

## New highlights in the standard version

- Designed for smooth material flow and precise logistics
- For integrated production processes
- ecoPlus technologies:
  - even higher energy savings
  - further increase in saw performance
- Cleaning flaps at the front
- Clamps with two fingers
- 19" touch screen monitor
- Automatic cutting height control
- Manually adjustable pressure for pressure beam and clamps
- An eye-level window provides a clear view of the rear part of the machine
- Air cushion tables and machine tables with air jets throughout
- First air cushion table 650 mm wide

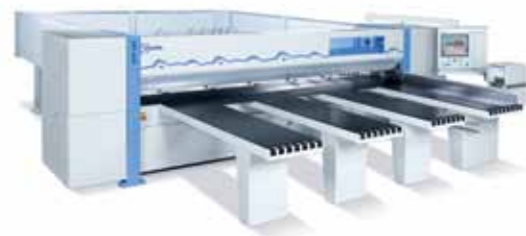


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# HPP 400 and HPP 400 profiLine

Powerful and ready for more: The HPP 400 is the ideal solution for expanding businesses and enterprises producing small to medium-sized batches.



- Highlights at a glance**
- 110 mm saw blade projection, 125 mm available as option
  - Ergonomic table height of 920 mm
  - Easy operation
  - Reliable and efficient



HPP 400. Illustration may show optional equipment.

# HPL 400 and HPL 400 profiLine

This model sets you up for really big jobs. The integrated lift table for automatic feeding allows you to speed up your production and significantly increase throughput.



- Highlights at a glance**
- 110 mm saw blade projection, 125 mm available as option
  - Ergonomic table height of 920 mm
  - Easy operation
  - Reliable and efficient
  - HPL 400 profiLine with an even wider choice of optional extras



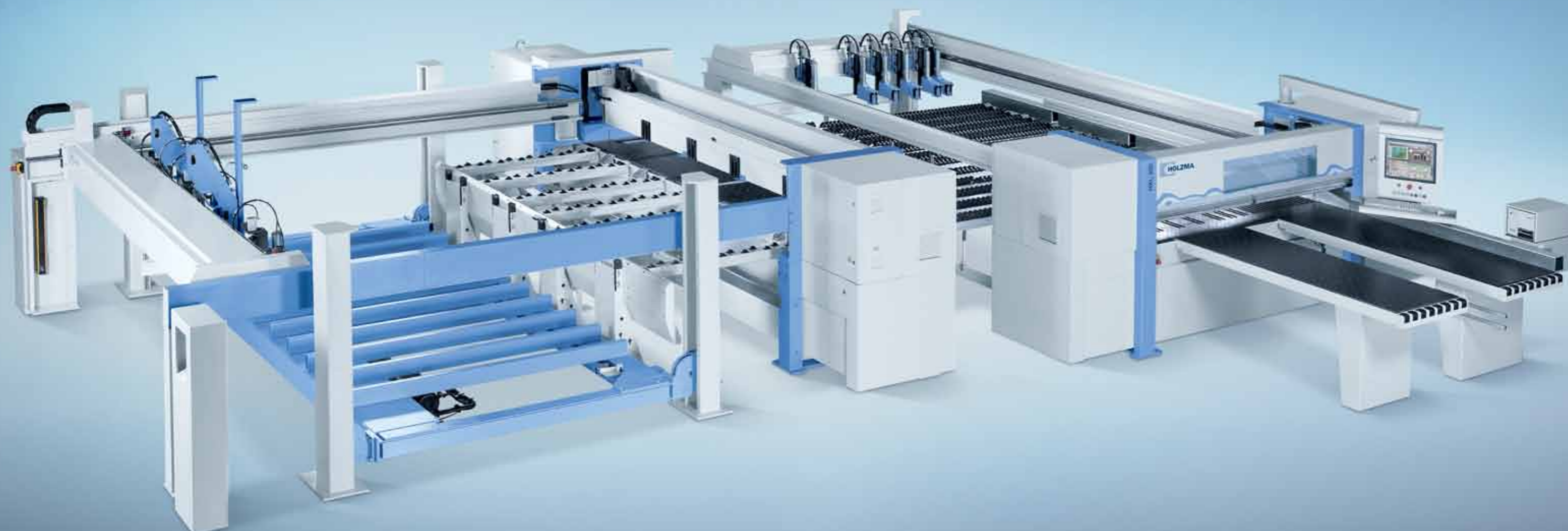
HPL 400. Illustration may show optional equipment.  
Safety fence obligatory.

# The HKL 400 and HKL 400 profiLine angular system

The HKL 400 angular system is the top model in the 4 series – designed for high precision in continuous operation. It addresses the needs of trade and industry alike. The system cuts entire books of panels as accurately as it does single panels. Fully automatically and with lasting dependability.

## Highlights at a glance

- Angular system with small footprint
- Ideal for single panels and small books
- High quality cuts in record time
- 80 mm saw blade projection, 95 mm available as option
- 110 mm saw blade projection, 125 mm available as option



HKL 400. Illustration may show optional equipment.  
Safety fence obligatory.

# Standard features

Standard features  
HPP 400 | HPL 400 | HKL 400

Even in its basic configuration, the 4 series offers you an ideal basis for successful production. HOLZMA ensures this by providing advanced technologies of uncompromisingly high quality.



## ecoPlus: state-of-the-art technology for energy savings of at least 20%

- The standby button, a standard feature, puts the saw in an energy-saving standby mode at the touch of a button
- All models with IE2 motors
- Variable speed control by means of a modern bypass circuit for all models with frequency-controlled main saw motor
- Patented rocker raises just the main saw blade, while the motor remains in position – this saves energy

- The light sensor on the saw carriage has its own blower unit, which utilizes the air discharged from the main saw motor (optional)
- The pneumatic system in the saw carriage has partly been replaced by hydro-pneumatic components, thus cutting compressed air costs and enhancing precision
- The new geometry of the saw carriage boosts extraction efficiency
- Intelligent optional extra: the load-dependent control of the air cushion

- All models with the HOLZMA energy monitor for consumption monitoring
- Lower energy requirement thanks to optimized extraction
- HOLZMA thin-kerf saw blades available on request
- A raft of innovations for improved ergonomics and smooth production processes

More information in the ecoPlus brochure.

## Program fence: precision and dimensional accuracy

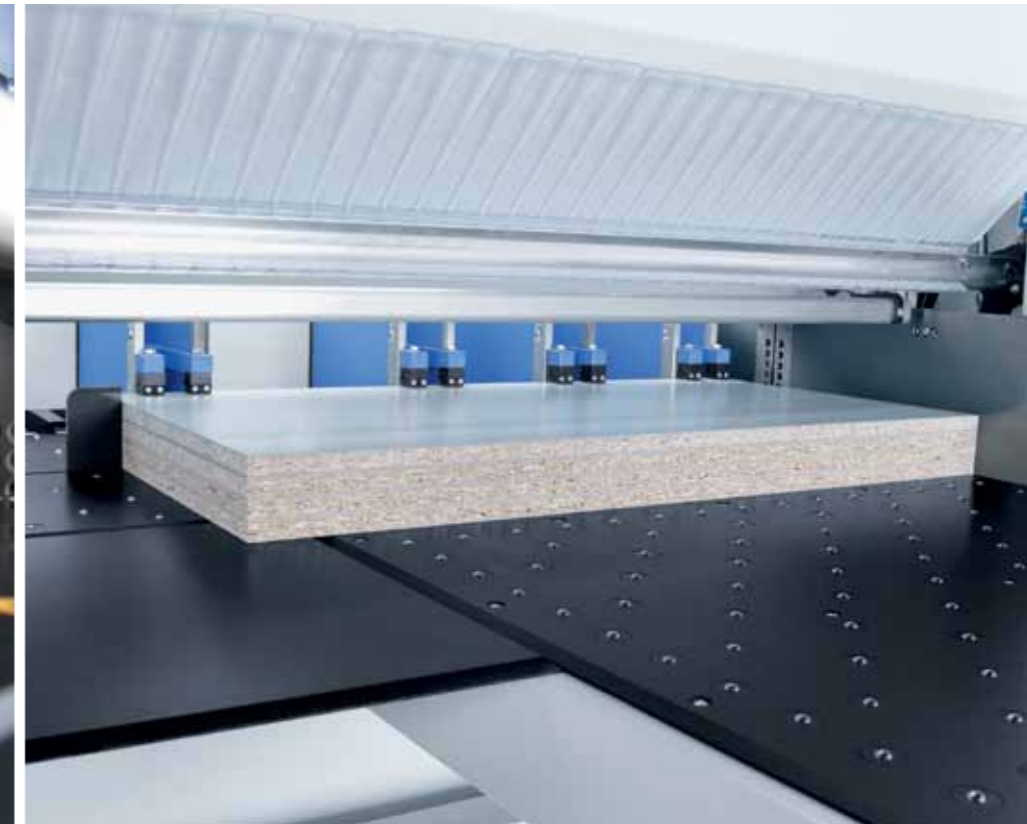
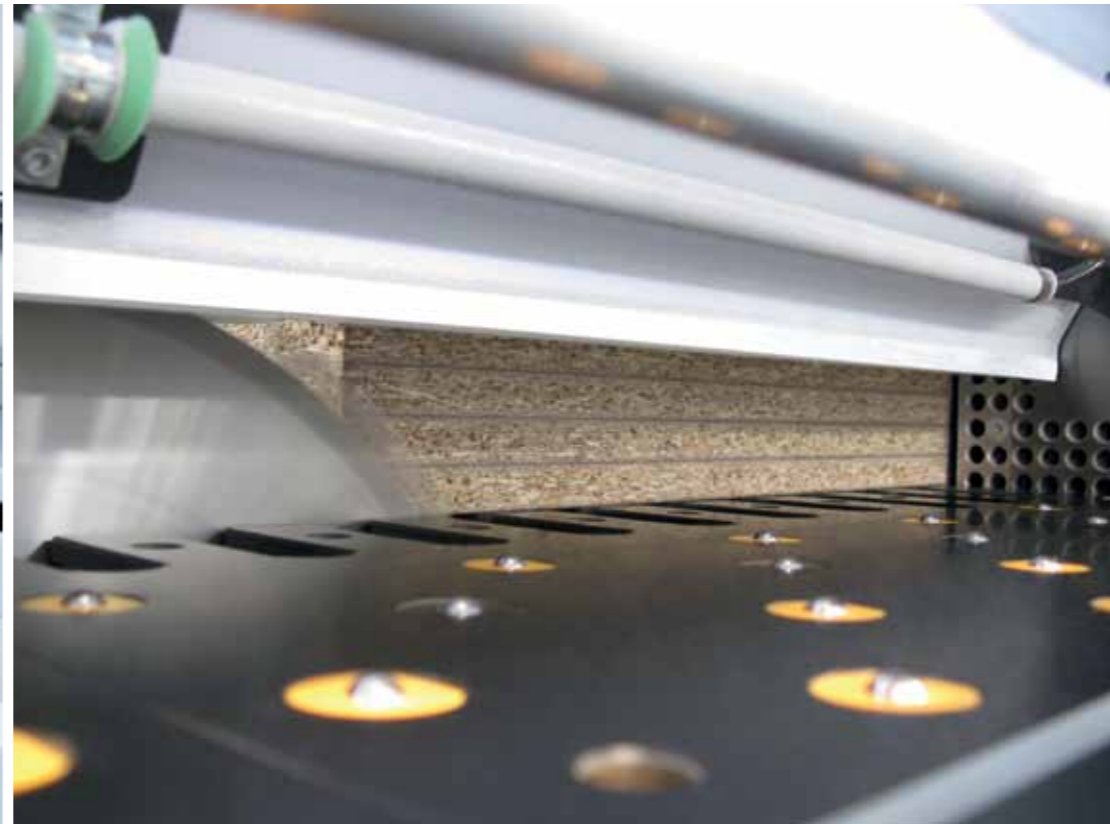
- Resistant to torsion and bending
- Electronically controlled
- Precision guidance on H-girder
- Electromagnetic measuring system guarantees positioning accuracy of +/- 0.1 mm
- Measuring system involves no wear and no maintenance

## Rugged pressure beam for first-class cut quality

- Large-area pressure zone directly at the cutting line reduces material vibrations to a minimum
- Linear guide on both sides
- Rack and pinion ensure the necessary parallel adjustment

This results in accurate, clean cuts, for books too.

Illustration shows the replaceable optional equipment



## Clamps

- Rugged clamps, all with two fingers
- Gentle positioning of material
- The bottom fingers of the clamps can be removed to allow the clamp base to be cut in perfect alignment – a fast means of adjustment
- The clamping pressure can be adjusted (manually) to suit each particular material
- The short, rugged design allows material to be held more accurately and handled more gently
- Irrespective of the book height, the top fingers of the clamps do not exert any leverage; instead, they are lowered horizontally and their entire contact surface rests on the material. This increases the working depth and ensures material is held firmly
- Designed for continuous, multi-shift operation

## Air jets throughout: the machine table

Anyone working with sensitive material or especially heavy boards and books will benefit from the machine table being equipped with air jets throughout.

## Now with new dustEx technology

HOLZMA was one of the first manufacturers to introduce a machine table with air jets throughout. dustEx now offers the next leap forward.

New combination air jets, patent pending, located along the cutting line transport dust and chips specifically toward the right-angled fence. Here, they are now picked up even more effectively thanks to the improved suction geometry.

Recommended: A front and rear dust trap curtain rounds off the dustEx package (see p. 28).

## HOLZMA patent: central side pressure device

- Integrated directly in the saw carriage; this shortens cycle times by up to 25% in comparison with conventional systems
- Infinitely variable adjustment of contact pressure – depending on panel thickness. This allows even thin boards, laminates or sensitive materials to be processed perfectly. A new feature here is the book-height-dependent control of the contact pressure: the higher the book, the greater the pressure



Illustration shows optional equipment not included in the basic price



## Newly designed saw carriage

Exceptionally smooth running, high precision and low energy consumption are the hallmarks of the new saw carriage of the 4 series.

- Developed especially for the 4 series
- Torsion-resistant, rugged and resilient basic design of the steel plate body for maximum dynamics and precision
- Infinitely variable saw carriage speed – for precision cutting of demanding materials
- Long-term accuracy of saw blade projection
- Fast, precise, low-wear and infinitely variable positioning of the main saw blade by means of linear guide system with rocker (patent)
- Main saw motor is not raised
- Low-noise, maintenance-free main saw blade drive
- Power-Loc system: fast and easy saw blade change
- Spring-loaded wheels always in perfect contact with the guides
- Light sensor with blower unit
- Excellent dust extraction thanks to innovative design of the saw carriage
- Postforming package, optional extra (page 19)

## Control made to measure – CADmatic 4.1 PROFESSIONAL

Developed with the needs of different user groups in mind and individually configurable, the CADmatic control software delivers optimized machine cycles.

- Intuitive, easy-to-understand operating software
- 3D, real-time process graphic
- 19" TFT flat screen monitor with touch screen
- Graphically supported diagnostics feature
- Improved navigation due to permanent access to all functions
- Improved design for enhanced user-friendliness

## Handy cleaning flap

Quick and convenient: flaps provide easy access to the area under the saw carriage, allowing easy removal or vacuuming of cutting waste if required.





### Powerful feeding system

Feeding is performed by the electro-hydraulic four-column lift table.

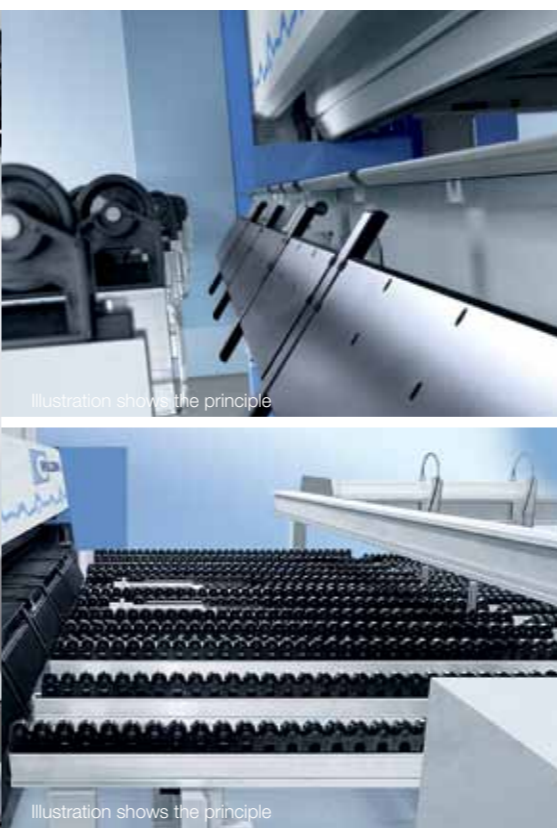
- Automatic measurement of book height
- Equipped as standard with longitudinal profiles and detector device

- Also suitable for thin materials from 9.5 mm upwards. If equipped with the options micro-infeed and hold-back device, it is also suitable for materials from 3 mm upwards
- Maintenance-free and no lubrication required



### Separate backing wall

- Not attached to the machine bed; this ensures precise cuts
- Vibrations caused by the movement of stacks on the lift table are not passed on to the machine bed



### Transfer to cross cut saw

(Only for HKL)

- Special powered pushers ensure perfect transfer
- Roller rails can be raised and lowered
- Lengthwise and crosswise alignment after transfer
- AB-BA system for mirror-image cutting
- Integrated headcut device



### Outfeed device for the rip saw

(Only for HKL)

The outfeed device pushes the panel material onto the intermediate table and the trim onto the waste flap.

### Waste flap

(Only for HKL)

The waste flap opens automatically when required and removes cutting waste at the rip saw.

- Opens and closes in perfect coordination with the operating cycle of the system

## Equipment package premium

- Scoring saw with motor-driven lift, including automatic adjustment
- Pressure beam dynamics package
- First air table 800 mm wide instead of 650 mm



### Pneumatically operated trim stops

The trim stops are attached to the clamps and are activated as needed by the CADmatic machine control.

- Rugged
- Adjustable to common panel thicknesses
- Gentle handling of sensitive materials with overhanging laminates or veneers
- Precise positioning

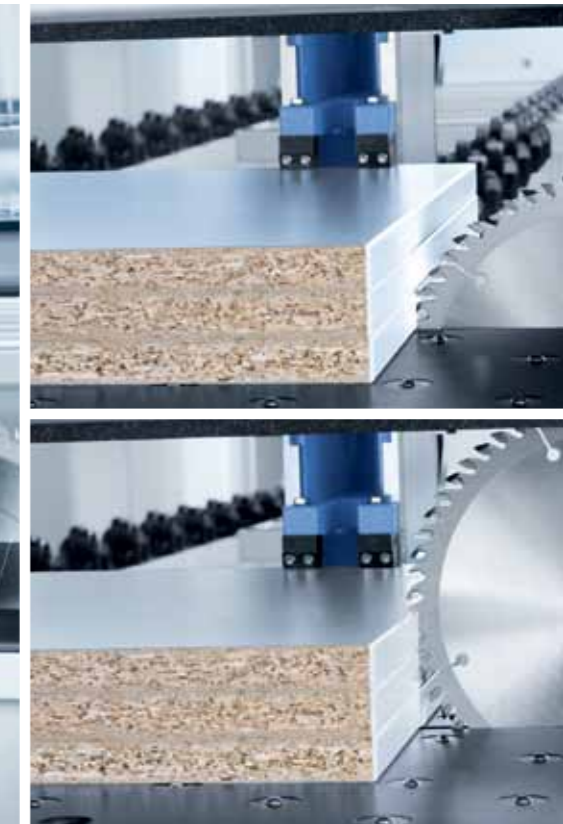


### The perfect postforming cut

This option is available in two versions. Both include the scoring saw being raised by a motor and automatic adjustment.

#### Version 1: ascending postforming saw (VVSH)

- Ensures perfect cuts on sofformed and postformed parts
- Maximum saw blade projection: 55 mm



#### Version 2: VVSH plus vertical postforming saw (VVS)

- VVSH as described in Version 1
- VVS with a maximum saw blade projection of 90 mm
- Scores the edge of the entire book (scoring depth up to a maximum of 15 mm)
- Ideal for edges covered with veneer, paper, ABS etc.

**XXL cutting length**  
HPP 400, HPL 400 and HKL 400 are also available with a 5 600 mm cutting length (also for profilLine) on request.

**Patented: camera-controlled scoring saw adjustment**

This allows the scoring saw to be adjusted fully automatically (manual adjustment still possible too).

- Optimal measuring results: the camera selects the color of lighting and the exposure time itself
- The simple adjustment takes no longer than a minute
- Adjustment accurate to one hundredth of a millimeter



**powerTouch**

Intuitive machine control – simple, fast and clearly structured: this is what CADmatic 4.5 PROFESSIONAL stands for. The new operating system comes with the new widescreen monitor. This package goes under the name of powerTouch and is available as an option. It makes controlling the machine a real pleasure.



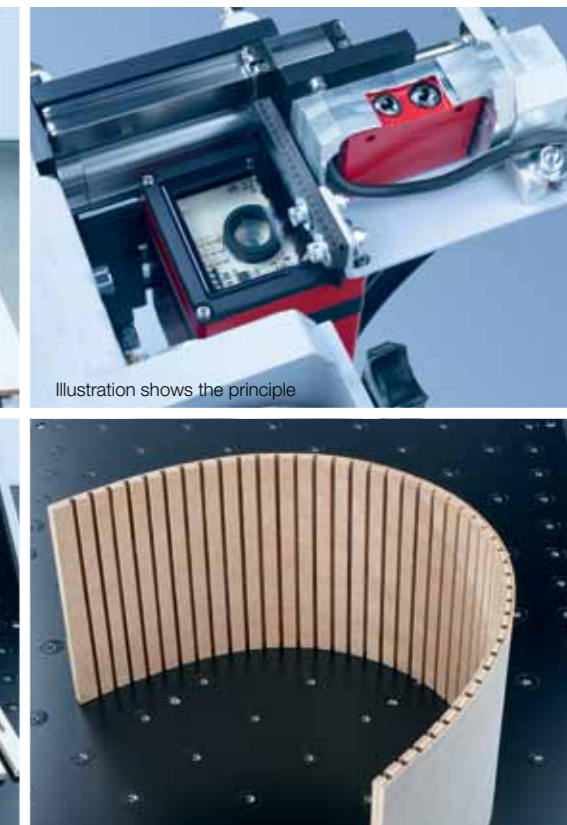
**Manual angle cuts**

The angle cut device allows you to control angle cuts using the CADmatic control software.



**Cut-outs and stress-release cut**

Tension in the material is released when it is cut and can affect the quality of dimensions and cuts. The HOLZMA stress-release cut option remedies this. Systematic preliminary cuts can be defined during optimization and release the tension in the material. The cut-out feature additionally allows you to produce both cut-outs and intermittent grooves – as are required, for example, for kitchen sinks or doors.



**Turbo-grooving**

This option saves you an entire production step in subsequent machining. This is because your HOLZMA saw will also groove the panel material in both directions – at top speed and much faster than a processing center could.

### Program-activated clamps

This option ensures panel edges are not damaged. Now also possible: clamp activation in “measuring” mode.



### High-precision laser guide beam

- Especially for solid wood, veneered panels and other materials with grain structure
- Pinpoint positioning right down the line



### Label printer

The HOLZMA label printer has everything to facilitate an efficient workflow. You can print customized labels directly at the saw and design them to include barcodes, text and graphics, if so desired. If you also use our Cut Rite optimization software, instructions for downstream CNC machining can also be included on the labels. In this way, you can integrate the saw perfectly in your production flow.



### Swiveling label printer and parts buffer

The new HOLZMA parts buffer with swiveling label printer increases the efficiency of processes around the saw and optimizes handling. Parts can be ergonomically buffered here after cutting. Located in a comfortable working position for the operator, the integrated printer dispenses the right label for the right part at the right time (see page 25).



### Cut optimization in the office

HOLZMA increases output and efficiency in panel cutting with its proven optimization software Cut Rite.

- Optimized project control
- Efficient cutting processes
- Full control of costs
- Faster calculations

As an alternative to the comprehensive Cut Rite optimization software, CADplan, an add-on module for the CADmatic, can be used to perform small optimization jobs directly at the saw.

### Options packages

HOLZMA now offers the most important optional extras in attractively priced equipment packages:

- Performance package
- Feeding package (HPL models)
- Handling package
- Grooving and cut-out package
- Labeling package
- Postforming package
- Cut Rite package PRACTICE
- Cut Rite package PROFESSIONAL

### Additional clamps

- For an even better grip on thin, narrow or smooth materials
- For increased material throughput

### Higher performance due to automated feeding from the front

The automated feeding system Econolift achieves a significantly higher material throughput in a shorter time. The result: more efficiency with less manpower.

- Automated feeding from the front
- Can be retrofitted at any time

### Extra impetus for feeding

An automatically driven roller conveyor integrated in the lift table and additional roller conveyors to the side ensure fast stack change.

### New! More options for intelligent destacking:

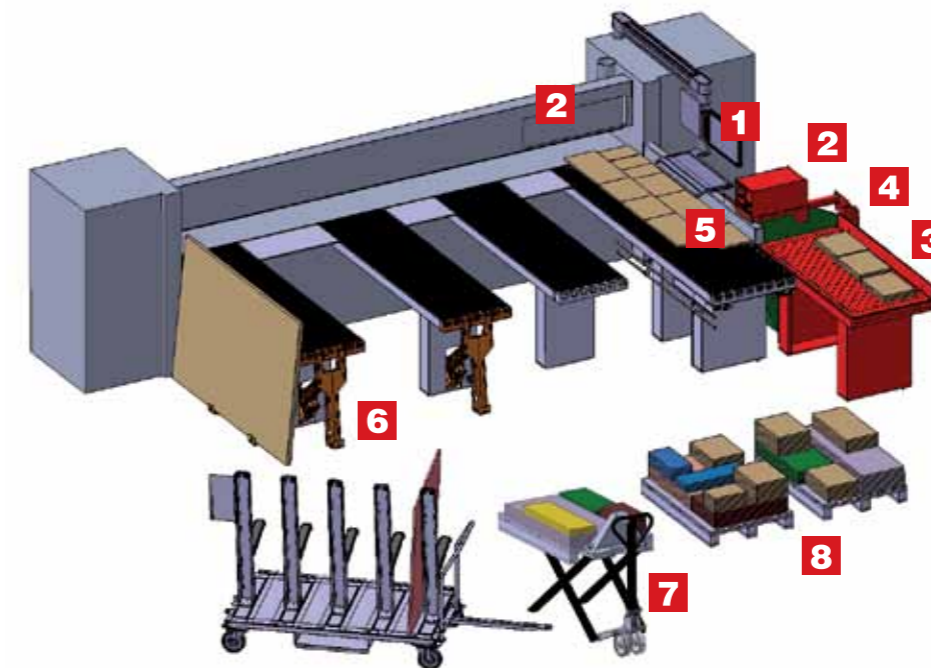
- **Visual operator guidance:** An additional LED display indicates, at the same time as the monitor, when a cut part is to be pushed onto the parts buffer or removed from there.
- **Flexible parts buffering:** Up to now, only the parts of a panel that were cut last went onto the parts buffer, so as not to slow down the saw. New: Now the parts buffer can be used whenever this allows improved stack formation.
- **Additional stability:** In order to make stacks more stable, waste parts are now actively used in stack formation.



Illustration shows CADmatic 4.5 PROFESSIONAL

### Everything in view – with video monitoring

- Recommended for large panel saws
- Displayed in the CADmatic control software
- You always have the rear machine table and the infeed in view
- Camera images can be recorded for troubleshooting and workflow optimization purposes and forwarded to the HOLZMA Service department



- 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

### Low-cost storage system integration

HOLZMA offers economically priced feeding solutions for the single saws of the new 4 series, including storage system integration.

- Ideal for the trade and craft sector
- Small footprint
- Attractive price
- Movable in x and y directions
- Saw and storage system are perfectly matched

- Automatic feeding for small panel saws
- Perfect handling – even with just one machine operator
- Easy, ergonomic operation
- Storage system controls the saw

More information, for example about combination with BARGSTEDT TLF storage systems, can be found in the HOLZMA Handling brochure.

### New: the HOLZMA destacking concept

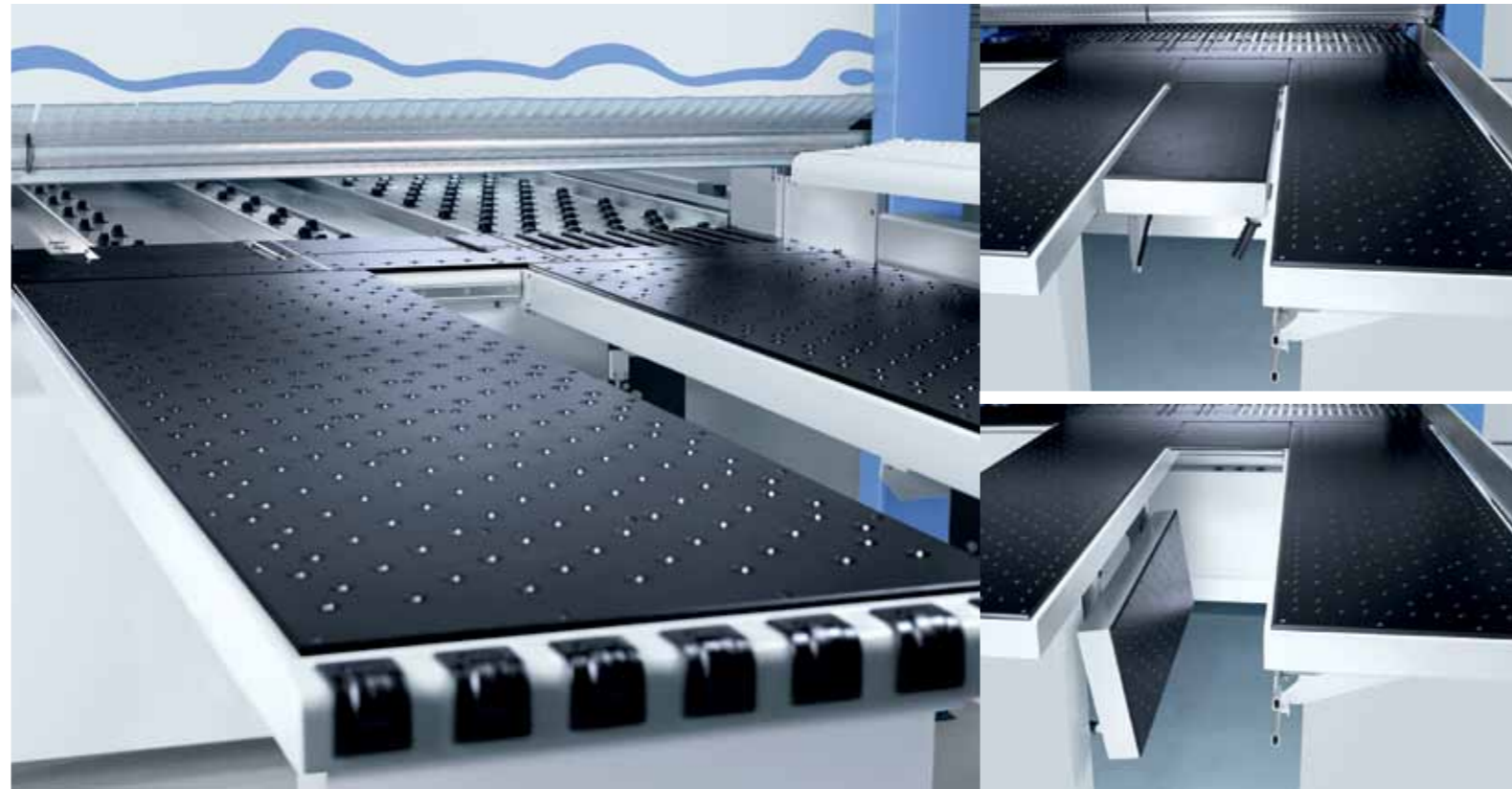
This global software and hardware concept guides the operator intuitively, from depositing the first part to forming the perfectly stacked pallet. Times and routes that do not add value are systematically reduced; the operator is shown exactly which part he has to place on which destacking station and when he should do it. The key components of the new HOLZMA destacking concept:

- New destacking software as add-on module for the CADmatic 4.1 PROFESSIONAL and CADmatic 4.5 PROFESSIONAL
- Label printing with destacking details – using the manual label printer (p. 22) or, as an option for profilLine machines, the automatic label printer near the pressure beam (p. 31)
- Ergonomic parts buffer (p. 22)
- Pneumatically operated feeding and destacking aid mounted lengthwise or crosswise on air cushion table
- And much more

# Optional extras

## Turning device for headcuts

- Labor-saving device for operators
- With automatic aligning function
- Significant increase in output
- Process integrated perfectly in the machine cycle
- Less time required for preparation
- Easy operation



## Start-stop button

- Allows the program sequence to be started independently of the control panel
- Equipped with an emergency stop button

## Movable air cushion table

The movable air cushion table is easily moved along linear guides and offers you a mobile work surface and storage area. It allows you to move small and large panels or books more ergonomically and with less risk of damage.

## Longer air cushion tables

(Not illustrated)

- Length increased from 2 160 mm to 2 810 mm
- Greater freedom of movement
- Better connection to destacking systems
- Very useful when cutting larger panels

## Tiltable air cushion table

(Illustrations show the principle on a different model)

- Prevents thin materials from sagging
- Increases the work surface
- Primarily for large panels
- Folds down for easy access to the cutting line

## Automatic waste removal

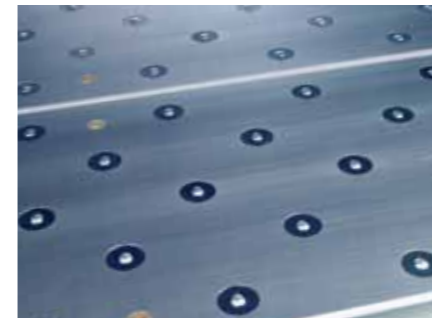
(Only for HKL)

- Vibrating conveyor: Cuttings that fall through the waste flap collect here. | **A**
- Waste chopper: This cuts waste into small pieces, facilitating automatic removal of the cuttings. | **B**
- Elevating conveyor belt for waste: This transports the cuttings to a container, for example. | **C**

# profiLine optional extras

Optional extras  
**HPP 400 profiLine** | **HPL 400 profiLine** |  
**HKL 400 profiLine**

The HOLZMA profiLine options are technological highlights. They promise maximum performance and custom solutions. These advanced options require an enhanced standard specification of the saw. HOLZMA completes the extra construction work involved for a comparatively low, one-off additional charge. Your saw is then ready and prepared for all the following profiLine options.



### Anodised aluminium machine bed plates

The special coating ensures exceptionally gentle material handling. Ideal for materials with highly sensitive surfaces. This option is also included as part of the "highly sensitive surfaces" package.

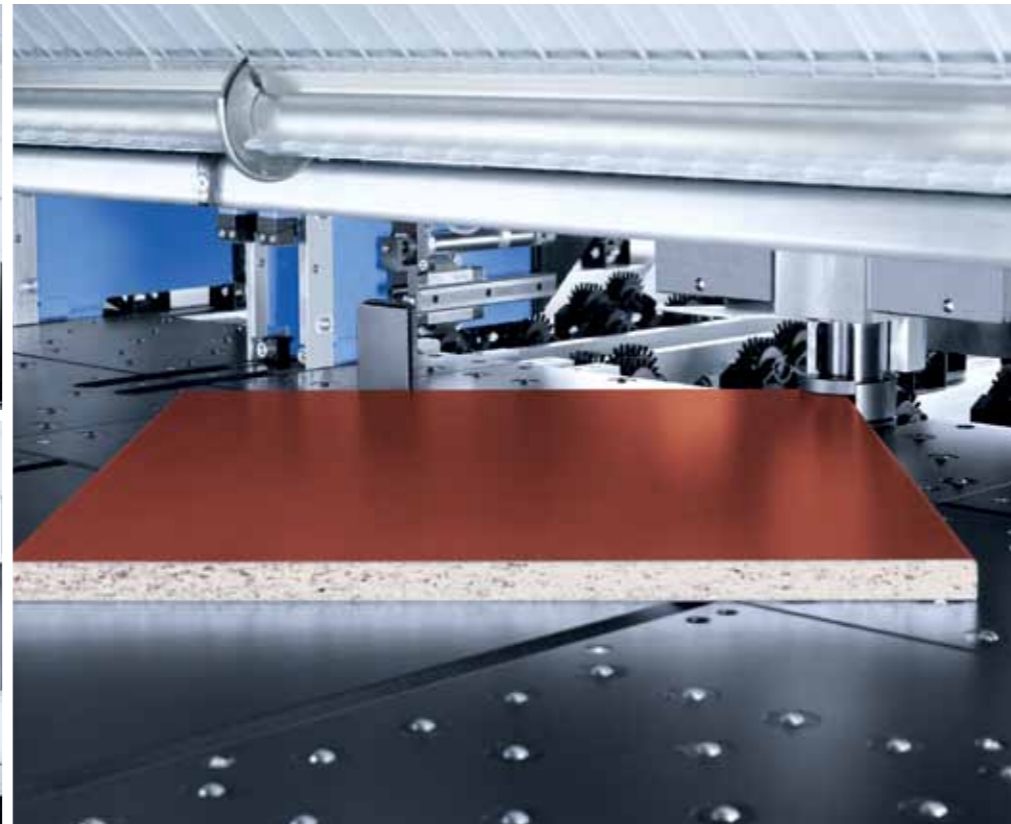


Illustration shows the principle. No storage link-up (as illustrated)

### Dust-trap curtain on both sides

- Attached to the pressure beam. Only a dust trap curtain at the rear in combination with the pressure beam printer
- Protects operators from dust
- Improves extraction
- Ideal for dust cuts

### Automatic angle cut device

This technology completes angle cuts fully automatically, after you have entered the respective data in the CADmatic control.

### Ready for large-scale storage system integration

This optional extra ensures that your HOLZMA saw is open for connection to almost all storage systems. The perfectly matched machines and systems of the HOMAG Group ensure top performance. Take a look at the HOLZMA Handling brochure for more information.

### Options packages

HOLZMA now offers the most important optional extras in attractively priced equipment packages:

- Package for sensitive surfaces (HPP models)
- Angle cut package



### Power Concept – for up to 40% higher output

The Power Concept allows you to cut strips with different cross cuts together. Power Concept achieves this by means of:

- An additional clamp which works independently
- Clamps on the program fence that can be raised out of the work area if necessary

- Sorting the strips again, directly at the saw, so that they are ideally matched to the Power Concept. This is based on existing optimization data for shortest machining times

The advantages:

- Up to 40% higher output
- Significantly shortened cutting cycles
- Significantly improved material flow
- High material throughput
- Lower costs per cut

- Attractively priced high-tech solution with minimum space requirement
- Accurate cutting of even very narrow strips
- Simultaneous feeding and cutting without a separate infeed carriage: the Power Concept clamp positions the last strip at the cutting line while the program fence fetches the next panel or book of panels from the lift table (HPL)

### Soft Touch package for pressure-sensitive material

As the diversity of materials increases, so do the requirements: pressure-sensitive lightweight boards, composite boards and plastic sheets are steadily gaining in importance. HOLZMA has bundled the technologies to deal with these materials in the Soft Touch package. HOLZMA also offers equally innovative package solutions for scratch-sensitive material. Ask your HOLZMA advisor for more details.

### Fully automatic labeling

The printer is located near the pressure beam, hence in your field of vision, and labels the finished parts/books – also when several strips are processed simultaneously side by side (Power Concept). It makes no difference whether you feed the panels from the front or the rear. On request, the position of the label can be individually controlled.

- Suitable for panels, offcuts and finished parts
- Gives precise details of the destacking location
- Gives precise instructions for further processing
- Saves time
- Minimizes errors
- Guides the operator



## profiLine optional extras (HPL 400 profiLine / HKL 400 profiLine)

Optional extras  
HPL 400 profiLine | HKL 400 profiLine

Further profiLine optional extras are available for the HPL 400 and the HKL 400. They can be individually configured to match your specific requirements, allowing you to get maximum performance from your HOLZMA saw.



### Micro-infeed for thin panels | A

The micro-infeed option\* allows thin panels from 6 mm upwards to be pushed onto the rear machine table (provided that their properties meet HOLZMA specifications). Book height is measured by a non-contact, electromagnetic measuring system which is completely maintenance-free.

\*included as standard for 5600 mm cutting length



### Hold-back device | B

The micro-infeed option | A can be combined with the hold-back device | B for thin panels from a thickness of 3 mm upwards.

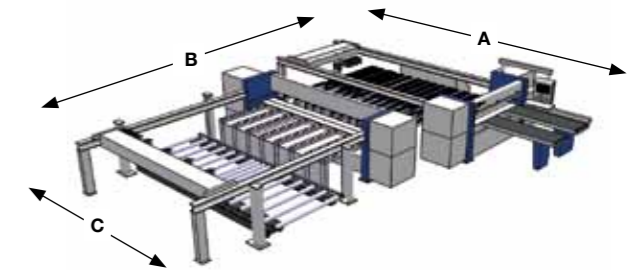
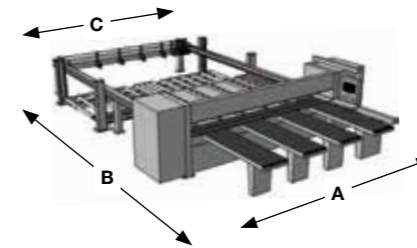
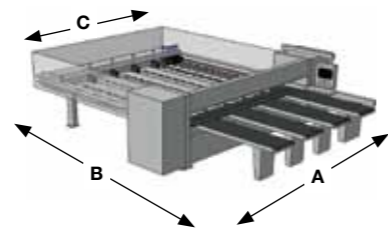


### Automatic push-out fence

- Pushes panel remnants from the rear machine table across the cutting line to the front
- You no longer need to reach into the cutting area
- Ergonomic

# The HOLZMA 4 series at a glance

Size, performance, features: the most important technical data for the 4 series can be seen here at a glance. If you would like to know more, simply ask your HOLZMA sales advisor. He will be pleased to provide you with comprehensive information.



Technical data*	HPP 400	HPL 400	HKL 400
Saw blade projection	110 mm (125 mm as option)	110 mm (125 mm as option)	110 mm (125 mm as option)
Cutting length, cutting width	3200/3800/4300/5600***** mm	3200/3800/4300/5600***** mm	Rip saw: 3200/4300 mm Cross cut saw: 2200 mm (2100 mm*****) 2200 mm
Lift table width	-	2200 mm	
Program fence speed **	90 m/min	90 m/min	Rip saw: 90 m/min, cross cut saw: 140 m/min
Saw carriage speed	up to 150 m/min	up to 150 m/min	up to 150 m/min
Main saw motor	13.5 kW (18 kW as option)	13.5 kW (18 kW as option)	13.5 kW (18 kW as option)
Scoring saw motor	2.2 kW	2.2 kW	2.2 kW
Average total air requirement	120 NI/min	210 NI/min	450 NI/min
Compressed air requirement	6 bar	6 bar	6 bar
Dust extraction	3800 m³/h (5230 m³/h****), 26 m/sec	3800 m³/h (5230 m³/h****), 26 m/sec	6600 m³/h (9030 m³/h****), 26 m/sec
Max. stack height without pit	-	560 mm	560 mm
Max. stack weight	-	4 t	4 t
Working height	920 mm	920 mm	920 mm
Air cushion tables	3/3/4/5 x 2160 mm	3/3/4/5 x 2160 mm	2 x 2160 mm

\* Values relate to the standard version  
 \*\* In EU countries, Switzerland and Liechtenstein, forward speed is restricted to 25 m/min  
 \*\*\* Dim. A: incl. 64 mm for extraction connection  
 Dim. C: standard program fence width; there are wider dimensions for the lift table with HPL and HKL machines  
 \*\*\*\* For the 5600 mm cutting length  
 \*\*\*\*\* Only for right-hand design  
 \*\*\*\*\* Maximum width that can be aligned

Machine dimensions***			
HPP 400	A	B	C
HPP 400/32/32	5364 mm	6543 mm	3709 mm
HPP 400/38/32	5924 mm	6543 mm	4269 mm
HPP 400/38/38	5924 mm	7143 mm	4269 mm
HPP 400/43/32	6514 mm	6543 mm	4859 mm
HPP 400/43/43	6514 mm	7693 mm	4859 mm
HPP 400/56/56	7864 mm	9043 mm	6209 mm

Machine dimensions***			
HPL 400	A	B	C
HPL 400/32/22	5364 mm	9963 mm	3636 mm
HPL 400/38/22	5924 mm	9963 mm	4196 mm
HPL 400/43/22	6514 mm	9963 mm	4786 mm
HPL 400/56/22	7864 mm	11413 mm	6136 mm

Machine dimensions***			
HKL 400	A	B	C
HKL 400/32/22	8020 mm	11760 mm	3636 mm
HKL 400/43/22	9170 mm	11760 mm	4786 mm
HKL 400/56/22	10520 mm	11760 mm	6136 mm

All dimensions subject to change

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Illustrations may show optional equipment not included in the basic price.



A company of the HOMAG Group



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