

Invisible Joints. Perfect Appearance. Flexibility.

LUMINA INDUSTRY



PRODUCTIVITY AND PRECISION



High-tech Edgebanding with the **LUMINA** Series

In addition to optimized adaptation of panel and edging decor, the quality of the edging plays an immensely important role for furniture construction and interior fittings. On the one hand, the edging has to hold permanently, on the other, the joint should not be visible – the renowned “invisible joint”. In addition to our LTRONIC and Glu Jet systems, our LUMINA series offers everything that a professional edgebander could need. Up to 30 NC servo-axes for maximum automation of all machining units with exact repetition at the touch of a button. Even the pressure and glue quantity settings can be made fully automatically and adapted to the specific requirement. The HOLZ-HER LUMINA with LTRONIC laser edging unit sets the highest professional standards for edgebanding, without compromise.



Video
LUMINA



Illustrations may contain optional features.

- 
- Fully automatic control of machining units at the touch of a button using NC servo-axes without opening the hood.
 - LED mode display – automatic visual LED display for various operating states of the edgebander.
 - Maximum precision and processing reliability for many years with torsionally stiff, welding machine columns.



Intelligent energy management
for HOLZ-HER edgebanders.



For short intervals between
workpieces and optimized
edge protrusions.

HOLZ-HER Ensures Perfectly Invisible Joints

The new LUMINA series offers a unique combination for panel processing:
Two systems for perfect invisible joints.

- Our Glu Jet application system for standard use of PUR glue.
- LTRONIC, the laser edging unit from HOLZ-HER is unbeatable in terms of speed and cost efficiency.

Glu Jet – Waterproof Invisible Joints with Thin Film Technology

Industrial technology for small workshops – with the HOLZ-HER Glu Jet system, you can process PUR glue as standard, just as simply as EVA glue.
Persuasive arguments for you and your customers:

- No additional glue basin.
- No expensive nitrogen tanks.
- High strength joints for extremely long service life.
- Resistant to heat and water, providing quality advantages in all areas of cabinetmaking.



Heat-up time
3 minutes



Glue change*
3 minutes

* to PUR glue, to EVA glue and color change



Cleaning
3 minutes



> LTRONIC and Glu Jet –
for superior edge appearance.
Unbeatable as twin pack! <



LTRONIC LASER EDGING UNIT

LTRONIC – Perfectly Invisible Joints with Laser Edging

With LTRONIC you can process co-extruded and subsequently coated “Laser Edges”. The NIR module in our LTRONIC unit can transfer heat energy quickly and precisely to the exact point where it is required, making it ideal for the activation of function layers on laser edging.

- Visually perfect results – tone in tone with invisible joints.
- No heat-up time.
- Noiseless processing.
- No cleaning work.
- Pioneer in terms of energy efficiency.
- Completely clean postprocessing.



Heat-up time
None



Glue change
None



Cleaning
None



Glu Jet PUR-2K

Glue Application System for PUR

For the LUMINA series, HOLZ-HER offers the Glu Jet PUR-2K with greater melting capacity for even higher feed rates. With the Glu Jet PUR-2K, users can process 2 kg PUR glue cartridges (Fig. 2), which are significantly more economical than conventional PUR granules. This investment is clearly worthwhile beginning at consumption rates of approx. 400kg of PUR glue per year, or approx. 2 kg per day. The savings for glue costs alone already amortize the machine during the second year.

The Glu Jet PUR-2K is unbeatable with a heat-up time of 3 minutes, while combining all advantages of our Thin Film Technology.



PUR (Polyurethane) Neutralizer

Cleaning the system is child's play with standard PUR cleaners (Fig. 1) using an automatic cleaning program integrated into the control.



Self-Cleaning at the Touch of a Button

There is no way to design a simpler cleaning process for PUR glue. For one thing, the PUR glue can be left in the Glu Jet station from one day to the next. In the Glu Jet, PUR glue can be remelted within 48 hours (= reaction time of PUR glue) so that, as a rule, cleaning is required only on weekends.

The Monday Button

At the beginning of the work week, simply fill the system with PUR glue through the guide tube. The neutralizer is flushed out of the system fully automatically at the touch of a button. Then you can start production immediately.

The Friday Button

Simply fill the station with conventional PUR neutralizer. The integrated, fully automatic cleaning routine on the control can be started by simply pressing a button. Then the entire station is flushed completely with the proper quantity, at the right temperature and correct pressure, neutralizing the PUR glue. Then the station can be left standing even over the entire summer vacation without problems.

Supervision of Remaining Quantity

Moreover the PUR glue to be flushed out can be optimized professionally. The remaining quantity of glue as well as the running meters that can still be processed are automatically monitored by a special sensor in the system and displayed to the operator on the control. This means the operator knows at all times how many running meters are still in the cartridges in the system, before flushing, for example.



Perfect results at the touch of a button with LTRONIC.

NIR MODULE

Your Advantages with the NIR Module in the *LTRONIC*

■ Immediate availability

No unproductive heat-up times whatsoever Immediate availability at the press of a button.

■ No noise emission

LTRONIC operates without any noise emissions whatsoever and without the use of compressed air.

■ High tech cooling using CNC technology

The NIR module (Near Infrared Radiation) is kept at a uniform temperature by its liquid cooling system allowing continuous production without pauses for cooling.

■ High energy efficiency

The wave length of our NIR module is very close to the intensity of the diode laser allowing it to optimize its energy with the utmost precision over the entire length of the workpiece. No energy is lost during set-up times.



Free Selection of Invisible Joint Technology **Glu Jet**, **Glu Jet PUR-2K** and **LTRONIC**

On the LUMINA, users can change over from the LTRONIC to the Glu Jet unit as required within minutes using the high precision HSK interface from our CNC technology.

The LUMINA has an automatic unit recognition feature and is ready for use immediately after changing

over to the LTRONIC. The maximum change-over time from one type of edging to another is 5 minutes.

This allows you to always offer your customers absolutely precise edgebanding. If desired also with waterproof and heat-resistant PUR glue. Choose between processing laser edging and use of EVA or PUR glues. With HOLZ-HER, you always have convincing technology at your fingertips.



LTRONIC –
perfectly invisible joints with laser edging
Co-extruded and subsequently coated laser edging can be processed with LTRONIC.

- Visually perfect results – tone in tone with invisible joints.
- No heat-up time.
- Noiseless processing.
- No cleaning work.



Glu Jet –
waterproof invisible joints with thin film technology
With the Glu Jet system you can always process waterproof PUR glue on a standard basis.

- No additional glue basin.
- No expensive nitrogen tanks.
- High strength joints for extremely long service life.
- Resistant to heat and water, providing quality advantages in all areas of cabinetmaking.

AWARDS

2012/14



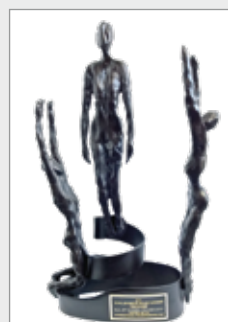
GOLD STAR AWARD
AWISA, Brisbane (Australia)

2014



TROPHÉE EXPOBOIS
EXPOBOIS, Paris (France)

2014/16



CHALLENGER AWARD
IWF, Atlanta (USA)

2016



GOLD STAR AWARD
AWISA, Brisbane (Australia)

Edge Control Touch

The HOLZ-HER control Edge Control Touch provides extremely high performance and is exemplary for its simple operation. Ergonomic, simple and uniform tablet design.

Display

- 18.5" touchscreen with 16:9 format.
- Brilliant graphic display of machining process.
- Simple operation – rotating and swiveling control panel at eye height.

Equipment/Service

- Network connectivity.
- Online maintenance, rapid exchange of data with HOLZ-HER service department.
- Barcode interface for automatic program call-up.
- External USB port for data backup and system updates.
- Connection to HOLZ-HER process data acquisition system for direct read-out of operating data (optional).

Operation

- Electronically controlled set-up processes with 100 % repetition accuracy.
- Clear and complete acquisition of all operating data. Total running meters, total parts, total hours with reset.
- Custom user management with password protection and single authorization.

Pictograms

- The Edge Control offers self-explanatory, graphic pictograms for simple user guidance.



Edge Control Touch –
high standards for future-proof design.



Laser edging at the touch of a button.

Edging Database

A highlight is the edging library completely integrated into the control. All of the very latest co-extruded and subsequently coated edging are already stored here as a factory-provided item and can be simply selected by the user via the standard touchscreen.

Each laser edging needs a specific energy entry, which, by way of an example, depends on the edge thickness or the color. After selection, the LTRONIC automatically sets the specific energy requirement, and, if your edging is not listed in the database, the edging calculator calculates the required energy for you.



Rotating and pivoting control panel.

LUMINA 1594

On a floor space of just 7.5 meters, the LUMINA 1594 offers complete professional machining with all required machining units.



LUMINA 1596

The LUMINA 1596 is designed for maximum requirements with regard to quality and flexibility.

The **"premium"** model with two cutter units allows processing of solid wood edging with thickness up to 15 mm (optional up to 20 mm).

The **"grooving"** model serves for fully automatic grooving in the vertical and horizontal direction.

The standard equipment on the **"flex"** model includes a corner buffing unit for perfect edge finishing without any subsequent work.



LUMINA 1598

The LUMINA 1598 **"performance"** is a future-oriented milestone for edgebanders. It has been designed for absolute maximum performance. The LUMINA 1598 **"performance"** is highly flexible, allowing perfect adaptation to your specific requirements.

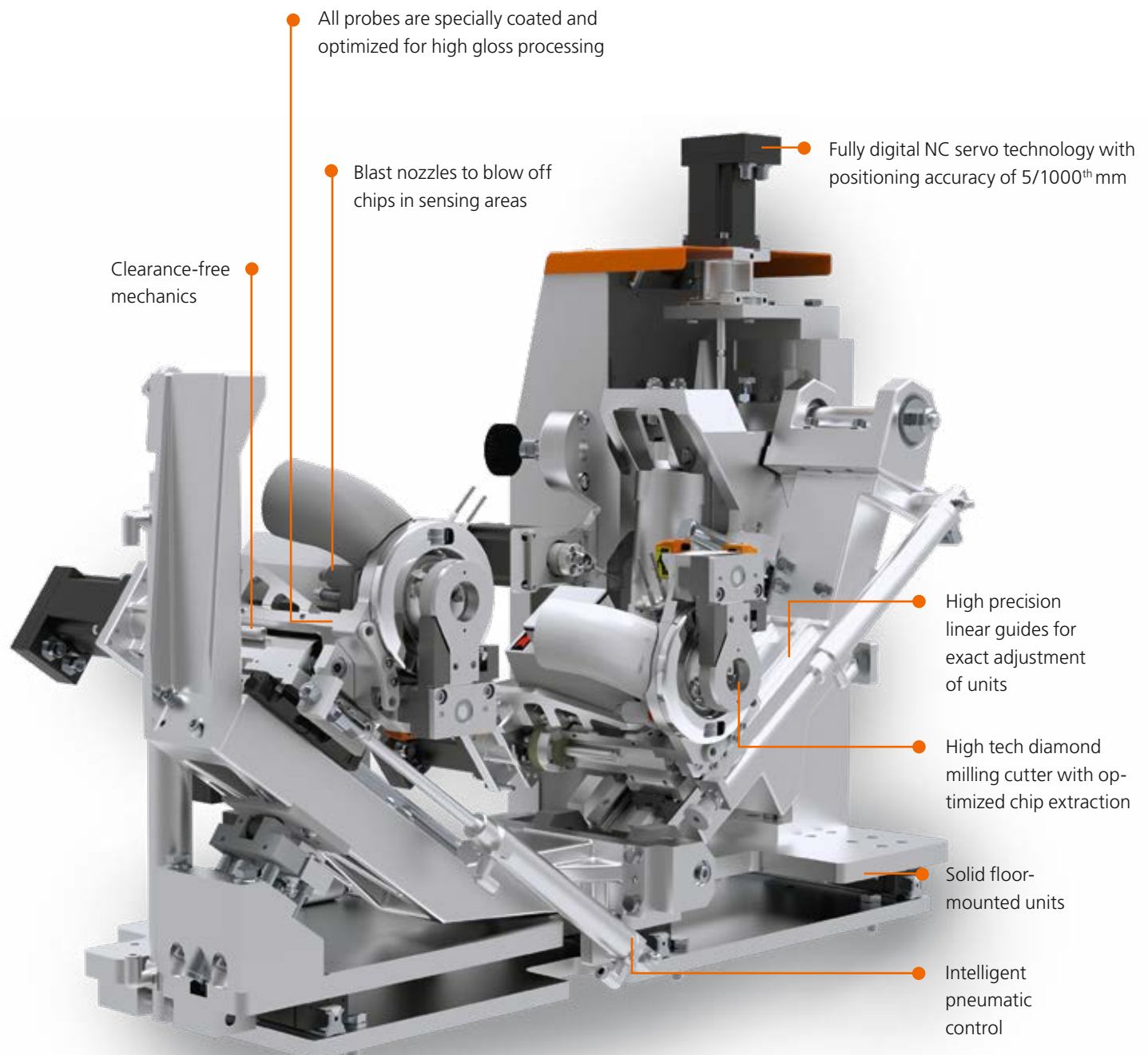
Also available as special **"sanding"** model with sanding unit as a standard feature.



Units for 100 % Repetition Accuracy!

All units must satisfy maximum requirements right down to the last detail to obtain the same, precision results repeatedly at high processing rates. The shaping cutter unit is an example of what is important.

Because 100 % repetition accuracy is highly significant for professional edgebanding.



Multifunction Package

The multifunctional package for cutting, corner copying and radius scraping provides a perfect appearance for all your normal edgebanding processes, such as flush cutting, varying radiuses and chamfers. Tool-changing is a completely automatic process with the NC servo-axes, multistage tooling technology and zero-clearance mechanisms for maximum precision.

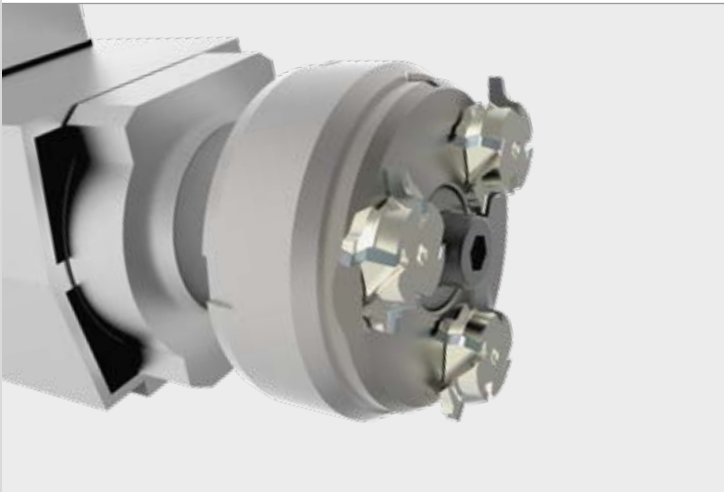


Multiple Stage Cutter Unit

With 6 NC servo-axes and diamond combination tool.

- Radius 1.3
- Radius 2 (double)
- Flush up to 8 mm
- Bevel 45°

Other tool configurations available on request!

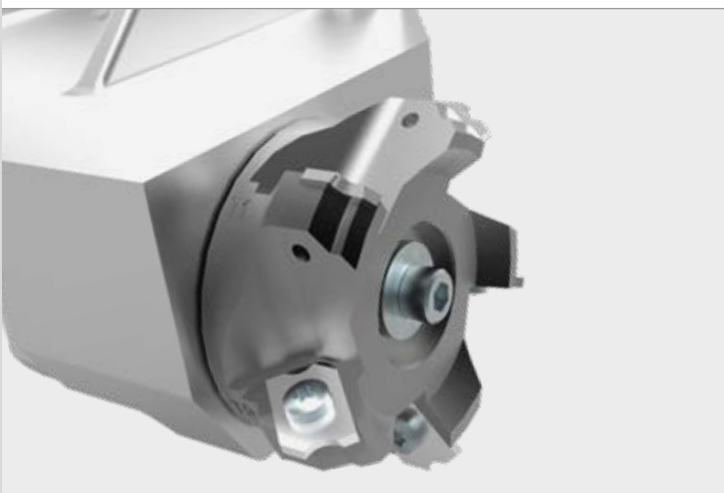


Revolving Cutter Unit – quattro ^{Form}

With 6 NC servo-axes and diamond revolving tool.

- Radius 1.3
- Radius 2 (double)
- Bevel 45°

Other profile combinations available on request!



Revolving Scraper Unit

With 8 NC servo-axes and HW standard scrapers on fully automatic revolving tool magazine for 5 tools.

- Radius 1
- Radius 1.3
- Radius 2 (double)
- Bevel 45°

Other profile combinations available on request!

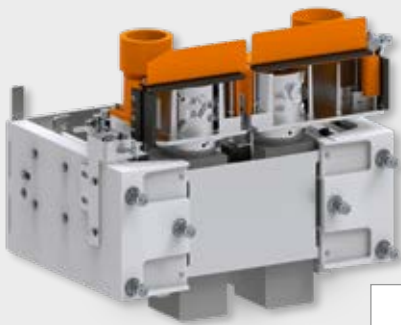
> Our experience in construction of edgebanders ensures greater reliability for your production. <



Jointing Cutter dia. 70 mm

Cut edgings often have small tears in the top layer. The jointing cutter unit ensures perfect glued surfaces and prepares the panels for the gluing process. Equipped with patented AirStream technology and diamond-tipped tools.

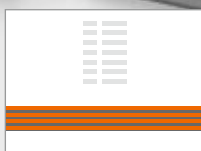
Including height adjustment for optimum utilization of cutters.



Jointing Cutter dia. 100 mm

With symmetrical diamond tipped cutters for maximum joint quality and long service life. Automatic height adjustment with 2 NC servo-axes.

Including patented AirStream technology for longer service life and low noise operation.



LTRONIC/Glu Jet Edging Magazine

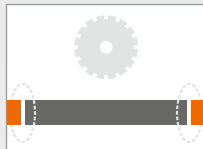
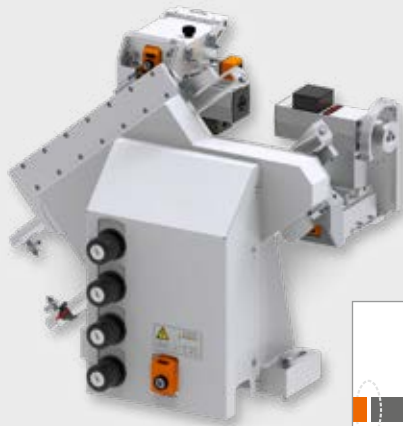
The special LUMINA edging magazine combines the unique, acute feed angle of only 7 degrees for extreme edging cross sections in the solid wood range with optimum feed angle for activating laser edging. SYNCHRO drive, automatic edging separation as well as automatic edge monitoring are all standard features.



Motor-driven Pressure Unit (4 Rollers)

Synchronously driven pressure unit with automatic adaptation to feed rate and NC servo-axes for motor-driven adjustment to correct edge thickness.

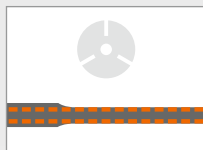
Straight and tapered pressure rollers for perfectly glued joints.



Trimming Unit

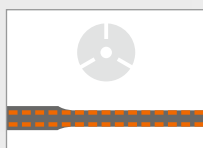
With hardened linear guides for high precision trimming results up to edging thicknesses of 15 mm; pneumatic pivoting to 10° as standard feature.

20 mm with solid wood equipment.



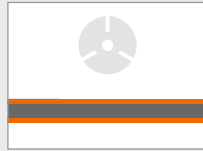
Flush Cutting Unit (up to 15 mm)

High performance cutter unit for edge thickness up to 15 mm. Optional: 2 NC servo-axes for cutting with and without edge protrusion.



Flush Cutting Unit (up to 20 mm)

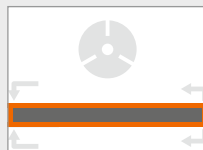
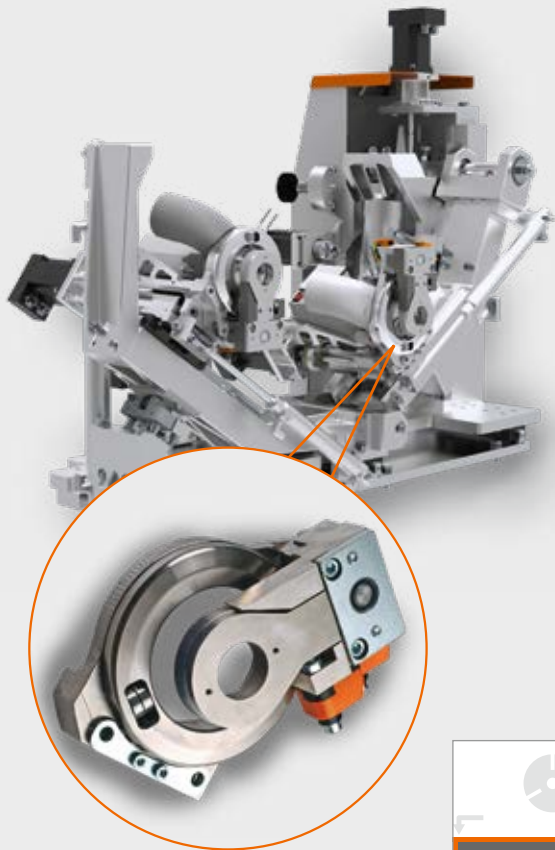
High performance cutter unit for edge thickness up to 20 mm. 3 NC servo-axes for cutting with and without edge protrusion as well as motor-driven horizontal adjustment for optimum cutter utilization (optional).



Cutter Unit

Heavy-duty floor-mounted unit with shock-absorbing mounting and large tracing rollers for perfect results even at high feed rates. 100 % repetition accuracy at the touch of a button based on zero-clearance mechanisms and 6 high precision NC servo-axes. Horizontal sensing with angular sensing rollers developed especially for processing modern, high gloss edging.

Multiple function milling technology as optional feature.



Shaping Cutter Unit

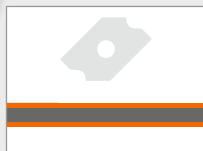
Unit adjustment on linear guides. With standard blast nozzles in front of sensing rollers to blow away chips in front of sensing areas. Including shelf program for optimum processing of shelves with rounded edges. Including intelligent pneumatic system to automatically adapt machining pressure settings to match feed rate and panel thickness.

With optional, automatic revolving tool magazine.

■ Pendulum Sensor

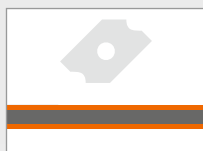
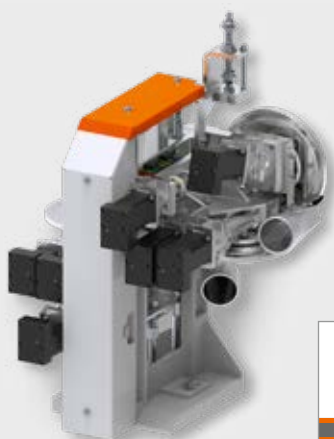
Automatic pendulum sensor copies rear without material protrusion and leaves the optimum edge protrusion for the longitudinal edge for subsequent machining with the radius scraper.

➤ The LUMINA industry is sure to satisfy your every wish. ⚡



Scraper Unit (MOT 5)

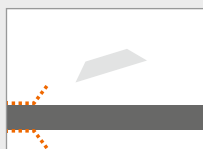
For perfect smoothing of radiuses and chamfers on plastic edging. With 4 NC servo-axes for exact adjustment of tool depth when using high gloss panels with protective foil.



Scraper Unit (MOT 8)

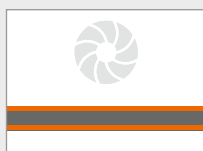
100 % repetition accuracy at the touch of a button based on zero-clearance mechanisms and 8 high precision NC servo-axes. Including high gloss package for exact adjustment of tool depth when using high gloss panels with protective foil.

With automatic revolving tool magazine (for 5 profiles).



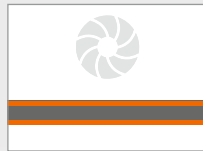
Flat Scrapers (pre- and post-sensing)

Clean surface finishing with pre- and post-sensing for high feed rates. 2 HW cutting edges, for use on 4 sides. Completely eliminates all manual finishing. Both units can be lifted automatically for special applications.



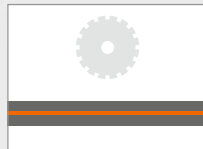
Buffing Unit (application controlled)

Polishing for maximum gloss; for complete finishing on edges and surfaces. Application controlled and optionally oscillating.



Corner Buffing Unit

For a perfect finishing on edging ends. Completely eliminates all manual finishing. Including plunge control and motor-driven horizontal adjustment via NC servo axes.



Grooving Unit

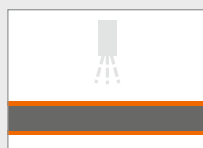
With 2 NC servo-axis for groove depth adjustment as well as groove positioning via control panel as a standard feature. Pivots 0–90 degrees including grid holes at increments of 11.25 degrees. Including plunge control. Optimum chip collection with blast nozzle and post-evacuation hood.

Including 4.2 mm groove cutter.



Oscillating Sanding

Oscillating sanding unit with NC servo-axis for overall horizontal control as well as for motor-driven downfeed to increase sanding pressure. The perfect finishing for your solid wood or veneer edging.



Spraying Devices

Spraying units for parting agents and cleaning agents for feed and discharge area. Anti-static, coolant and lubricant – electronically controlled by special nozzles – for a perfect edge finish. The various fluid reservoirs are all integrated cleanly into the machine frame.

Perfectly Equipped Down to the Last Detail



1



2



3



4

■ Air Cushion Table

For easy and careful handling – even with bulky work (optional) (Fig. 1).

■ Workpiece Support

Extremely stable, pull-out workpiece support completely self-supporting so that floor irregularities have no effect (optional) (Fig. 2).

■ Guide System

For optimum guidance of narrow workpieces. The guide system moves along with the workpiece at a 90 degree angle right up to secure transfer to the machine (optional) (Fig. 3).

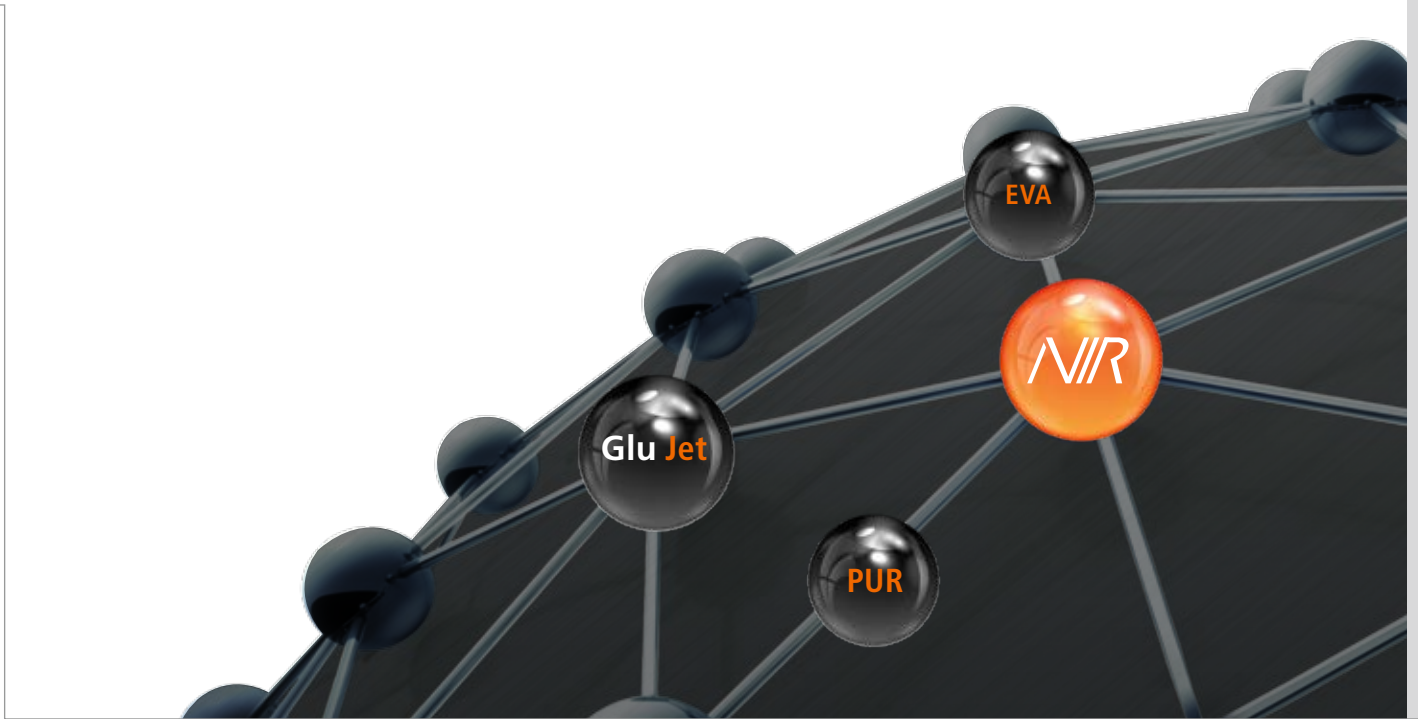
■ LED Mode Display

Automatic visual LED display for various operating states of the edgebander (Fig. 4).

■ Synchronous Belt Bridge

Belt bridge with synchronous drive, industrial version with double compound V-belt and Kevlar reinforcement layer. This guarantees precise workpiece transport for all applications.

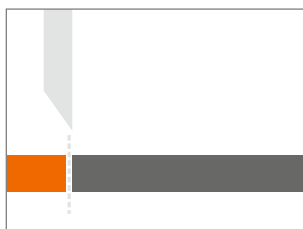
Perfect workpiece transport thanks
to belt bridge with synchronous drive.



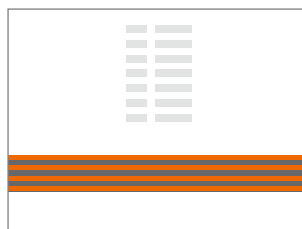
iTronic

The optimized, automatic control for the extensive pressure adjustments allows HOLZ-HER to realize automatic glue quantity control matched to the specific requirements. Moreover, an adaptive trimming blade automatically adapts the pressure to the edge thickness. And, an adaptive pressure unit optimally adjusts the pressures of the individual pressure rollers to the specific application for perfect results every time. This reduces adjustment errors and reject quotas to a minimum.

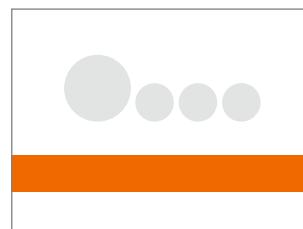
As a special feature, the iTronic package includes a fully automatic cleaning feature for PUR glue as well as a remaining glue quantity indicator on the control to show you exactly how many more running meters you can produce at any time.



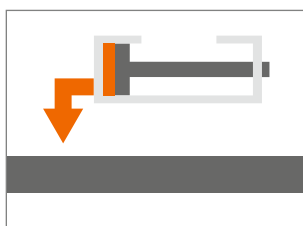
Adaptive trimming blade



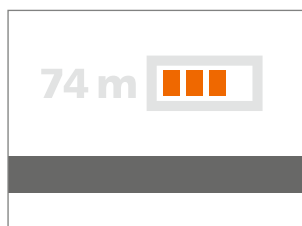
Automatic glue quantity control



Adaptive pressure unit



Automatic cleaning routine



Remaining glue quantity indicator

Equipment Versions for

LUMINA Industry Series

Machine	LUMINA 1594 automatic	LUMINA 1596 premium	LUMINA 1596 grooving	LUMINA 1596 flex	LUMINA 1598 performance	Options
Control	18,5" Touchscreen	18,5" Touchscreen	18,5" Touchscreen	18,5" Touchscreen	18,5" Touchscreen	
Bridge	Synchronized belt bridge	Synchronized belt bridge	Synchronized belt bridge	Synchronized belt bridge	Synchronized belt bridge	
Edge feeder	LTRONIC / SYNCHRO	LTRONIC / SYNCHRO	LTRONIC / SYNCHRO	LTRONIC / SYNCHRO	LTRONIC / SYNCHRO	
Joints	60 mm*, DIA. 70 mm	60 mm*, DIA. 70 mm	60 mm*, DIA. 70 mm	60 mm*, DIA. 70 mm	60 mm MOT 2, DIA. 100 mm	*60 mm MOT 2, DIA. 100 mm
Exchange unit 1	LTrready (LTRONIC ready)* **	LTrready (LTRONIC ready)* **	LTrready (LTRONIC ready)* **	LTrready (LTRONIC ready)* **	LTrready (LTRONIC ready)* **	*LTRONIC with NIR **LTRONIC with NIR ^{plus}
Exchange unit 2	Glu Jet* automatic	Glu Jet* automatic	Glu Jet* automatic	Glu Jet* automatic	Glu Jet* automatic	*Glu Jet PUR-2K PU Unit (2 kg cartridge)
Pressure unit	4 motor-driven rollers	4 motor-driven rollers	4 motor-driven rollers	4 motor-driven rollers	4 motor-driven rollers	
End trimming	Two motor 15 mm*	Two motor 15 mm*	Two motor 15 mm*	Two motor 15 mm*	Two motor 15 mm*	*20 mm with solid wood package
Cutter 1	x	Flush 15 mm*	x	x	Flush 15 mm*	*+ MOT versions (20 mm)
Cutters 2	Radius 2 mm*	Radius 2 mm*	Radius 2 mm*	Radius 2 mm*	Radius 2 mm*	
Corner copying	60 mm, MOT 4*	60 mm, MOT 4*	60 mm, MOT 4*	60 mm, MOT 4*	60 mm, MOT 4*	*Multifunctional package for cutting, corner copying and radius scraping
Radius scraper	MOT*	MOT*	MOT*	MOT*	MOT*	
Flat scraper	With pre- and post-sensing	With pre- and post-sensing	With pre- and post-sensing	With pre- and post-sensing	With pre- and post-sensing	
Buffing	Application controlled*	Application controlled*	Application controlled*	Application controlled*	Application controlled*	*Oscillating
Corner buffing	x	x	x	Application controlled	Application controlled*	
Grooving	x	x	MOT 2	x	*	*MOT 2
Spraying device						

Standard
 Optional
 x Not possible
 Free space

	LUMINA 1594 with Glu Jet automatic	LUMINA 1596 with Glu Jet premium	LUMINA 1596 with Glu Jet grooving	LUMINA 1596 with Glu Jet flex	LUMINA 1598 with Glu Jet performance	LUMINA with LTRONIC
Technical data						
Overall length A (mm)	7460	7920	7920	7920	8590	
Total length with air cushion table and extended discharge B (mm)	8960	9420	9420	9420	10090	
Width x height (mm)	1368 x 2223	1368 x 2223	1368 x 2223	1368 x 2223	1368 x 2223	
Weight (kg)	4000	4350	4350	4350	4700	
Feed rate						
Feed speed (m/min)	10–25	10–25	10–25	10–25	10–25	10–25*
Working dimensions						
Minimum workpiece length (mm)	140	140	140	140	140	140
Minimum workpiece width (mm)	60	60	60	60	60	60
Workpiece thickness (mm)	8–60	8–60	8–60	8–60	8–60	8–23 (45)
Edge width (mm)	0.4–8 (15)**	0.4–15 (20)	0.4–8 (15)**	0.4–8 (15)**	0.4–15 (20)	0.4–3

* edge dependent
** with tool change

