

SPRINT
1315/1317

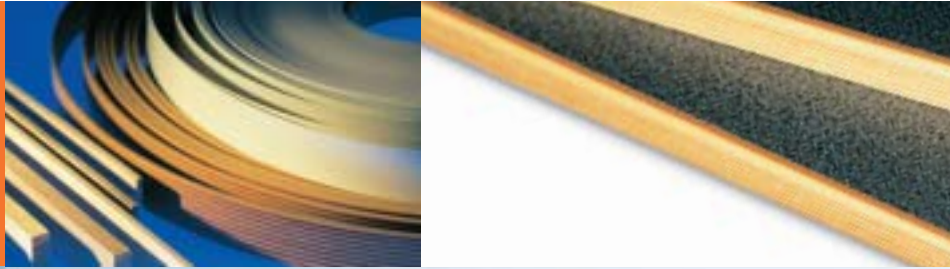


**The high-performance series
with variable solutions**

Your partner for productivity and precision

HOLZ-HER
Special Machines

SPRINT 1315/1317



Two series, four complete packages

- **SPRINT 1315**
Eight high-performance basic units – including corner rounding and postform copying* – for applying plastic edges of up to 3 mm and solid-wood edges of up to 8 mm. The workpieces can be up to 50 mm thick (2").
- **SPRINT 1317**
Pre-Milling cutter as standard: All four machines in the series are equipped with a pre-milling cutter unit.
- **SPRINT 1315-1 and 1317-1**
The superior performance of the more powerful end trimming unit 1918 with two 0.22 kW motors makes it possible to process thicker edges.
- **SPRINT 1315-2 and 1317-2**
Tight glue joints are possible by virtue of pressure unit 1913 with three individually controlled pressure rollers. If the corner-rounding unit is not used, a very high feed speed of 16 m/min is possible, and therefore a performance can be obtained which otherwise could only be achieved with higher-end machines.
- **SPRINT 1315-4 and 1317-4**
Powerful pressure unit and end trimming unit – as standard in the 1315-2 and 1317-2 – but equipped with two flush trim units, for flush cutting of cut-length and coiled edges from 0.4 to 15 mm. The corner-rounding unit 1832 is not present.

* Plastic edges only

Perfect Edgebanding

Fast, superior edgebanding of PVC, HPL veneer and solid-wood edges.



Compact, stable and powerful

Extraordinary quality and surface finish in edge processing can be achieved only with high-performance edgebanders which precisely match the production requirements. With the series SPRINT 1315/1317, HOLZ-HER offers convincing solutions when your business is defined by small to medium batch sizes. Even large production runs are dealt with in a superior manner. Compact dimensions, a comprehensive range of units, and the visible high performance of the technology make the SPRINT 1315 and 1317 particularly attractive products.



SPRINT 1317

The pre-milling cutter unit ahead of the glue application system eliminates even very small chips in the edge and surface layer.



Finish-processing using the Corner Rounding Unit 1832

Vertical front and rear edges of the workpieces, as well as their lower and upper corner points (having radii of up to 3 mm) are rounded perfectly and cleanly. There is no need for manual touch-up work. The unit is also suitable for post-formed panels up to R6.



The innovative concept of this series is accentuated by a modern shape. The defined geometric shape and modern execution provides many advantages during use. Excellent stability, a lot of interior space and good accessibility to the units are decisive factors for professional, effective operation. The patented HOLZ-HER glue application system – one of the key units in edge finishing – ensures a strong, tight joint between the workpiece and the edge, and represents the latest technology.

SPRINT 1315/1317



The SPRINT 1315/1317 series is equipped as standard with the 1906M cartridge glue application system.

The new nozzle design further optimizes the gluing operation and makes it possible to apply an extremely thin layer of glue. The patented "melt-on-demand" system ensures that overall glue consumption is extremely efficient. Costs remain low and there is no unnecessary waste. The enclosed heating system prevents any irritation from odors or smoke. Since only the precisely required amount of glue is melted in each case, discoloration or scorching is prevented. When the reserves of glue are running low, the control panel displays the message "Refill glue" in plain text. This ensures continuous operation.

Fast change of glue

One particular strong point of the cartridge system is the possibility of changing from EVA to PUR glue in a rapid and easy process. It is also possible to easily change the color of the glue. The cartridge is simply exchanged. There is no need for complex cleaning of a messy glue pot.

Ready to start in 3.5 minutes

Since only the amount of glue which is actually required is melted, the heating time is reduced to 3.5 minutes – that is twice as fast as in conventional glue pot systems – and saves up to 95% of the electricity required.

One of a kind – the 1905 MULTI-SYSTEM

The first system for processing glue cartridges and glue pellets. This also applies to the use of PUR glues. Up to four cartridges or up to 1.5 kilograms of pellets can be loaded. The system is highly flexible in daily use and saves time and power. All that is required is to exchange the hopper – then add the new glue and continue the edgebanding operation.



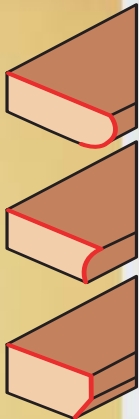
Advanced Glue Application System – for a secure joint

The performance of a glue application system is determined by three factors: the unsurpassed properties in terms of glue quality, the short processing time and the resulting operating costs. HOLZ-HER's patented cartridge system 1906/1906M is a market leader in all three factors. It combines the high performance of a closed heating system with the excellent advantages of nozzle technology. The already melted glue is applied to the panel at high pressure via the nozzle and the pores in the workpiece are filled. The result is an extremely durable and tight joint.



Profile trimming at the press of a button

Individual units and their functions can be stored in such a way that the corresponding profile shape is set simply by pressing the soft key.



HOLZ-HER Control System – high standards safeguard it for the future

- Powerful PLC control for rational set-up and operation.
- User friendly interface – all information in plain text and/or graphics
- Simple program selection (numbers and plain text)
- Clear and complete acquisition of all operating data
- Individual selection of the units
- Central adjustment and fine adjustment of the units
- Interval indicator for very short workpiece spacings
- Monochrome screen (Color available in late 2005)
- Rotatable and tiltable operating panel at eye level
- Anti-dust touch keyboard with soft keys
- Individual management for up to ten users

Perfect system solution – convenient to operate

The new HOLZ-HER control system is extremely high-performance. It utilizes an advanced industrial processor and a modern CAN bus system for data exchange on a standard platform. The integrated synchronous bus system further increases the precision for control of the working units. The well-designed ergonomics of the control panel with a VGA screen ensures operator comfort during operation. It is effective and makes it simple to work with the intelligent HOLZ-HER control concept.



SPRINT 1315/1317



Finish Scraper –

Final finishing of plastic edges.
No need for manual touch-up.



Buffer unit –

For perfect post-finishing of
edges and surfaces for
absolutely clean results.



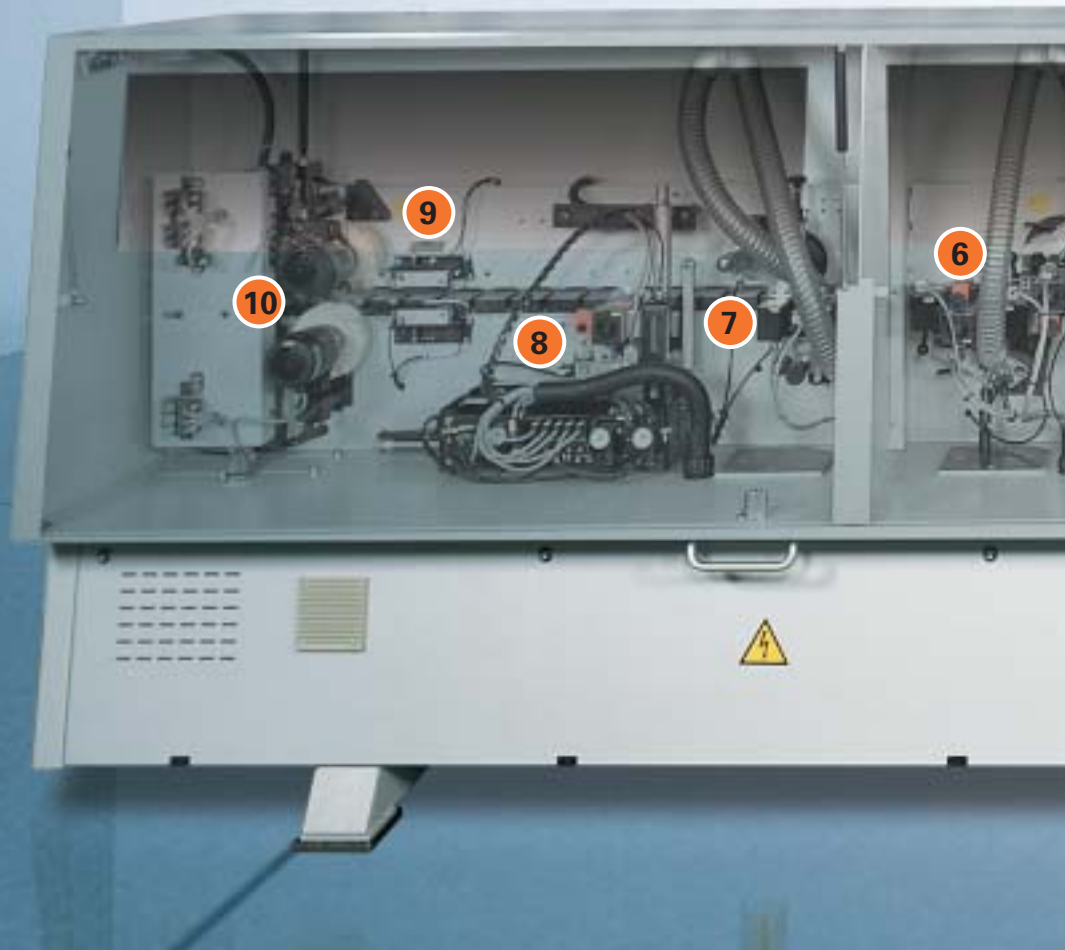
Corner Rounding unit –

For copying the vertical front
and rear edge. Also suitable for
post-formed profiles up
to R=6 mm.



Profile Scaper unit –

For perfect smoothing of radii
and trimmed plastic edges.
Available with motorized
adjustment (servos) if desired.



Up to ten high-performance units as a solid solution for individual requirements.

From the fully automatic, user-friendly universal magazine and the pre-milling station (SPRINT 1317), to the buffer unit for clean finishing, the series is excellently equipped. Manual touch-up is a thing of the past. One benefit of the new design concept is the high stability and rigidity. At the same time, there is a lot of space for the units which are positioned clearly and in an easily accessible manner. With its particular equipment packages – higher feed speeds, pressure unit with three individually controlled pressure rollers, high performance end trimming unit, and the units for flush trimming of solid and coiled edging – the machine series offers a large number of combination possibilities.



Multifunction Flush Trim unit –

For flush, radius and chamfer cuts. Available with servos for motorized adjustment of the tracer shoe for automatic changing from radius to flush cuts. PCS System also ensures fast changeovers.



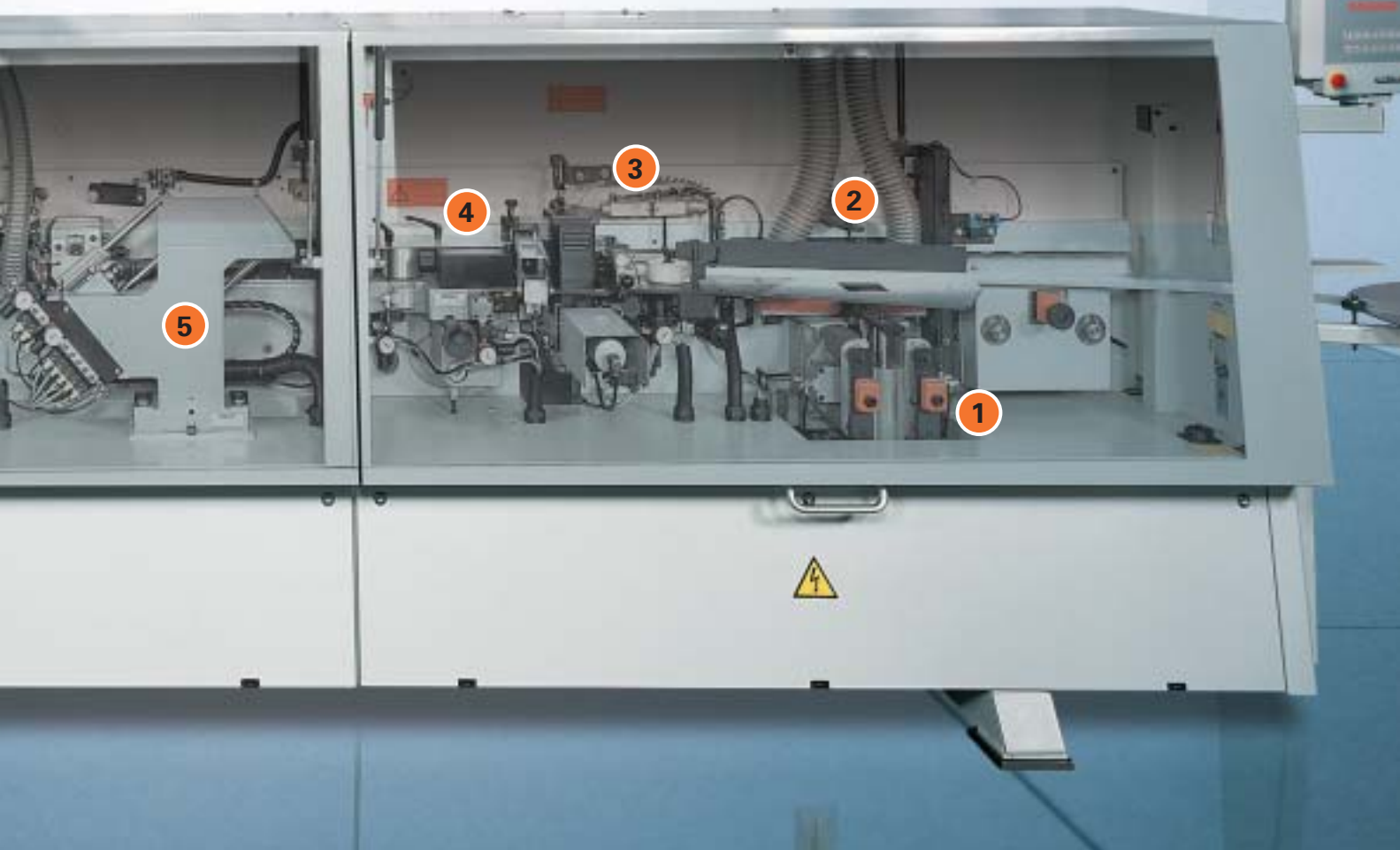
End trimming unit –

Precise round linear guides for a clean end trimming result for all edgebanding materials. Tilttable for flush and chamfer. Three motor variants: 1 x 0.22 kW, 2 x 0.22 kW, 2 x 0.35 kW.



Pressure unit –

Strong, heavy pressure section for a tight joint. Pressure unit has pneumatic control with activation via the PLC Screen. Conical pressure rollers ensure a tight glue line.



Versions with pneumatic or motorized control (servos) are available as an option for many units. The pressure section and overhead bridge are available with motorized instead of manual adjustment – once again as an option – for all the models of SPRINT 1315 and 1317. The strong, heavy transport chain runs on precision guides and transports the workpieces smoothly and accurately through the machine using the smooth surface pads. The transport chain is driven by a powerful motor which ensures a uniform feed speed. Depending on the units, an above-average feed speed of 16 m/min is possible.



Glue Application System –

Reliable tight and clean joints. The patented HOLZ-HER cartridge system for processing EVA and PUR glues comes as standard.



Universal Edge Magazine –

Fully automatic, user-friendly feeding of cut-length and coiled edging. The heavy-duty guillotine cuts thick PVC banding. The edging material can be changed very quickly without the need for tools.



Pre-Milling station –

For cutting the edge surfaces of materials in panel form. This results in chip-free edges without visible tears in the surface layer of the panel material.



Unit equipment

	1315	1315-1	1315-2	1315-4	1317	1317-1	1317-2	1317-4
Pre-Milling cutter unit 1961								
2 x 2.0 kW, 200 Hz, 12000 rpm								
Two plunge-controlled cutter units (up and down cutting modes), plunge travel 5 mm	–	–	–	–	✓	✓	✓	✓
Edge Magazine 1903								
Support plate Ø 820 mm, max. loading capacity 40 mm	✓	✓	✓	✓	✓	✓	✓	✓
Glue application system 1906 M								
Patented cartridge system for EVA and PUR glue 1.9 kW, manual recharge, magazine capacity: one cartridge (approx. 330 grams)	✓	✓	✓	✓	✓	✓	✓	✓
Glue application system 1906								
As 1906M, but with a floating nozzle (option) and automatic recharge, magazine capacity: 4 cartridges	○	○	○	○	○	○	○	○
Glue application system 1905								
Multi-system for EVA and PUR glues in cartridge and pellet form. Cartridge hopper for four cartridges (approx. 1.4 kilograms), pellet hopper for approx. 1.5 kilograms	○	○	○	○	○	○	○	○
Glue application system 1910								
Glue roller for EVA pellets, application in clockwise & counter-clockwise rotation.	○	○	○	○	○	○	○	○
Pressure unit 1816								
Three rollers, 1st roller motor-driven	✓	✓	–	–	✓	✓	–	–
Pressure unit 1913								
Three rollers, one roller motor-driven. Optional: pneumatic individual control of all pressure rollers (1913-P)	–	–	✓	✓	–	–	✓	✓
End trimming unit 1822								
0.22 kW, 300 Hz, 9000 rpm Tilting from 0 to 10 degrees	✓	–	–	–	✓	–	–	–
End trimming unit 1918								
2 x 0.22 kW, 300 Hz, 9000 rpm Pneumatic Tilting from 0 to 10 degrees	–	✓	✓	✓	–	✓	✓	✓
Multifunction Flush Trim unit 1942 M								
2 x 0.6 kW, 300 Hz, 18000 rpm Tilting range from 0 to 15 degrees	✓	✓	✓	✓	✓	✓	✓	✓
Multifunction Flush Trim unit 1942 MOT 2								
As 1942 M, but with motorized adjustment via servos	○	○	○	○	○	○	○	○
Flush Trim unit 1823								
2 x 0.6 kW, 300 Hz, 9000 rpm For flush cutting only	–	–	–	✓	–	–	–	✓
Profile Scraper unit 1929								
Two scraper carriers, up to max. R = 3 mm	✓	✓	✓	✓	✓	✓	✓	✓
Profile Scraper unit 1929 MOT 2								
As 1929, but with motorized adjustment (via servos)	○	○	○	○	○	○	○	○
Profile Copying cutter unit 1832								
1 x 0.22 kW, 300 Hz, 9000 rpm Including cutting tool	✓	✓	✓	–	✓	✓	✓	–
Finish Scraper 1964								
Top and bottom separately controlled via PLC	○	○	○	○	○	○	○	○
Buffer unit 1940								
2 x 0.12 kW. Two textile wheels Ø 150 mm, tilting from 0 to 5 degrees	○	○	○	○	○	○	○	○

- ✓ = Standard
- = Optional
- = not available

The technical data given are for reference only. We reserve the right to make modifications, since HOLZ-HER woodworking machines are subject to constant development. The illustrations are therefore not binding. The machines illustrated may contain special features that are not series-standard, but optional. Please ask your HOLZ-HER dealer for details of the features included. All rights reserved in respect of changes in design and features.

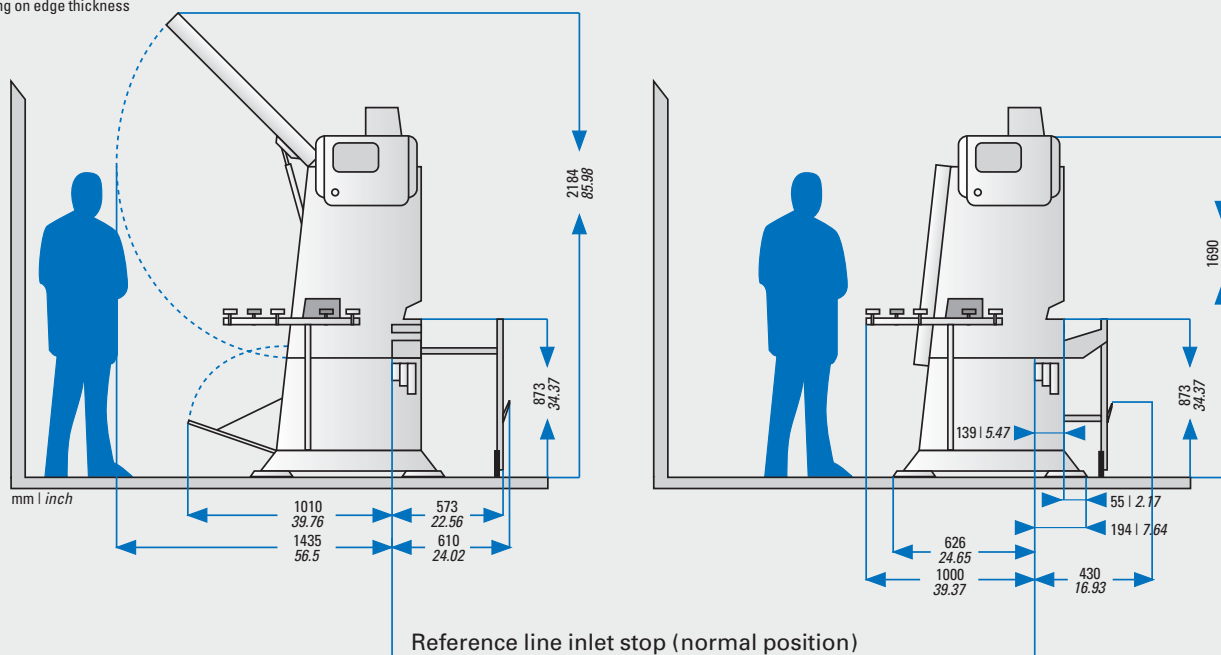
SPRINT 1315/1317

Technical data

	1315		1315-1		1315-2		1315-4		1317		1317-1		1317-2		1317-4	
Machine dimensions																
Overall length (mm feet)	4990	16.37	4990	16.37	4990	16.37	4990	16.37	5905	19.37	5905	19.37	5905	19.37	5400	17.72
Working dimension¹⁾																
Workpiece thickness min./max. ²⁾ (mm inch)	6/45	0.23/1.77	6/50	0.23/1.97	6/50	0.23/1.97	6/50	0.23/1.97	6/45	0.23/1.77	6/50	0.23/1.97	6/50	0.23/1.97	6/50	0.23/1.97
Edging thickness ¹⁾ (mm inch)	0,4-3	0.01-0.12	0,4-8	0.01-0.31	0,4-8	0.01-0.31	0,4-15	0.01-0.59	0,4-3	0.01-0.12	0,4-8	0.01-0.31	0,4-8	0.01-0.31	0,4-15	0.01-0.59
Edging height max. (mm inch)	50	1.97	55	2.17	55	2.17	55	2.17	50	1.97	55	2.17	55	2.17	55	2.17
Cut edging length min. (mm inch)	350	13.78	350	13.78	350	13.78	350	13.78	350	13.78	350	13.78	350	13.78	350	13.78
Edging projection/height per side max. (mm inch)	3	0.12	3	0.12	3	0.12	3	0.12	3	0.12	3	0.12	3	0.12	3	0.12
Workpiece width min. (mm inch)	60	2.36	60	2.36	60	2.36	60	2.36	60	2.36	60	2.36	60	2.36	60	2.36
Workpiece length min. (mm inch)	180	7.09	180	7.09	180	7.09	180	7.09	180	7.09	180	7.09	180	7.09	180	7.09
Feed speed																
Feed speed (m/min)	8	8	8	8	8/16	8/16	12,5	12,5	8	8	8	8	8/16	8/16	12,5	12,5
Extraction																
Pre-Milling cutter unit (m ³ /h)	-	-	-	-	-	-	-	-	900	900	900	900	900	900	900	900
Flush Trim unit (m ³ /h)	280	280	280	280	280	280	2 x 280	2 x 280	280	280	280	280	280	280	280	280
Scraper unit (m ³ /h)	280	280	280	280	280	280	280	280	280	280	280	280	280	280	280	280
Static underpressure																
Pre-Milling cutter unit (Pa)	-	-	-	-	-	-	-	-	1490	1490	1490	1490	1490	1490	1490	1490
Flush Trim unit (Pa)	1650	1650	1650	1650	1650	1650	1650	1650	1650	1650	1650	1650	1650	1650	1650	1650
Min. air speed. (m/sec.)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
Pre-Milling unit connection Ø (mm inch)	-	-	-	-	-	-	-	-	125	4.92	125	4.92	125	4.92	125	4.92
Flush Trim connection Ø (mm inch)	70	2.75	70	2.75	70	2.75	2 x 70	2 x 2.75	70	2.75	70	2.75	70	2.75	70	2.75
Scraper connection Ø (mm inch)	70	2.75	70	2.75	70	2.75	70	2.75	70	2.75	70	2.75	70	2.75	70	2.75
Compressed air																
Compressed air connection (bar)	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6

¹⁾ Depending on equipment

²⁾ Depending on edge thickness



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