

Automatically efficient.

HE HOMAG

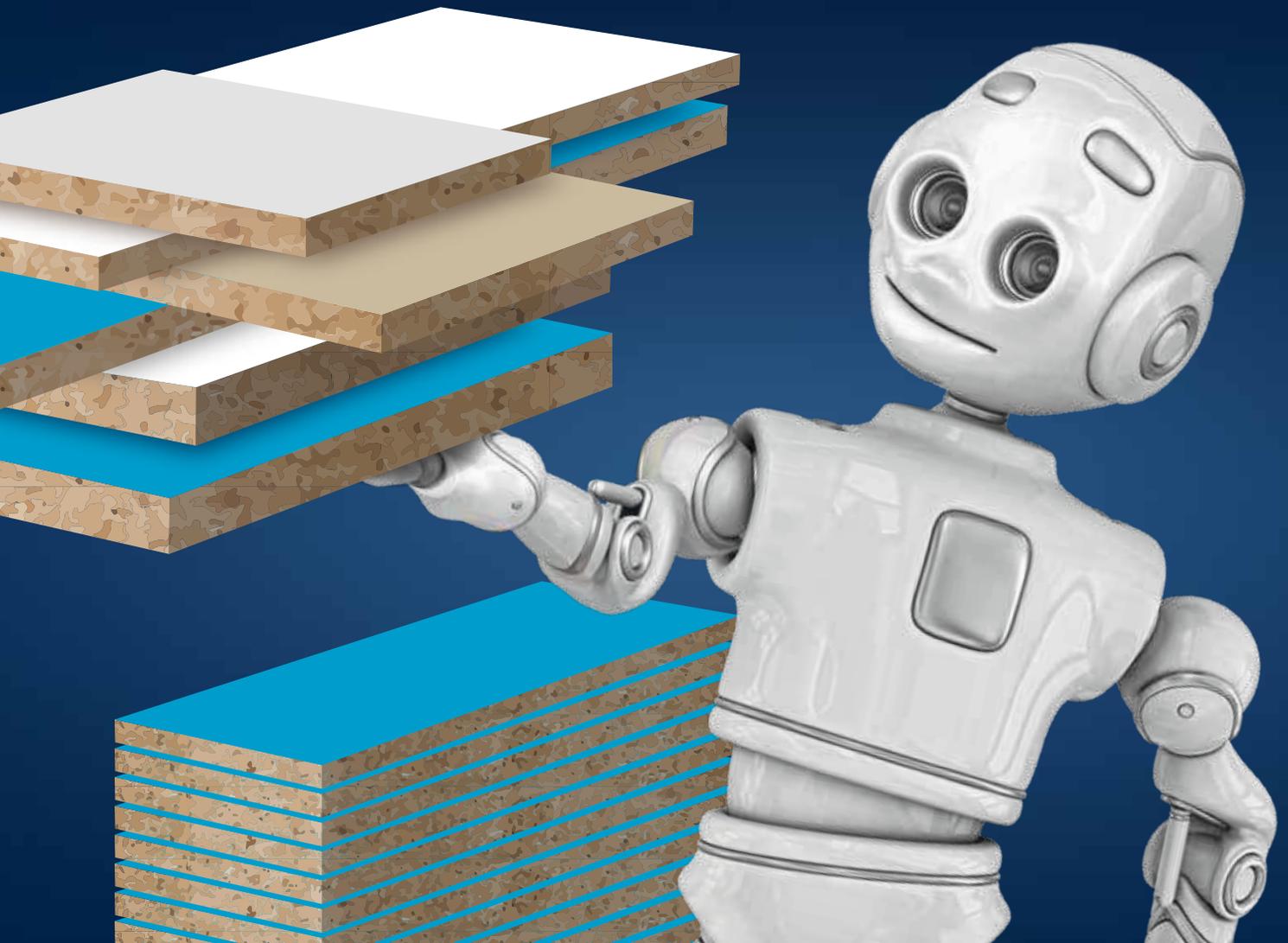
Manually versatile. Incredibly flexible.

Our panel dividing saws

SAWTEQ B-300 flexTec

SAWTEQ B-400 flexTec

YOUR SOLUTION





Robot performance and operating freedom in one

Robotics is the key to highly efficient batch size 1 production in the cutting process. The crux of the matter is that cutting cells equipped with this up to now have been designed from A to Z for the requirements and processes in single-panel cutting. This makes them extremely efficient and highly productive, but limits the range of use of the saws.

Such concepts are often not appropriate for companies with a wide variety of work and a limited production area. That is why the panel dividing experts at HOMAG have now developed an innovative hybrid concept combining the two: the robot performance for automated batch size 1 panel cutting and the wide range of processing options of classic HOMAG saws.

The names of these innovations are SAWTEQ B-300 flexTec and SAWTEQ B-400 flexTec. Both saws are equipped with an integrated robot and are technically capable of fully automated batch size 1 production over longer distances. Alternatively, these two saws can be operated manually as usual – totally flexibly and as needed: for cutting books, for example.

YOUR SOLUTION

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Proven technology in new combinations

THE BASIC MODELS AT A GLANCE

- SAWTEQ B-300 flexTec as single saw
- SAWTEQ B-300 flexTec as single saw with lifting table
- SAWTEQ B-400 flexTec as single saw
- SAWTEQ B-400 flexTec as single saw with lifting table

1

Saw design

Essentially, the two basic models correspond in both design and features to the SAWTEQ B-300 and the SAWTEQ B-400. For customers, this means that they will get a panel dividing saw that has proven itself in practice many times over and embodies quality and reliability.

2

Robot technology

The SAWTEQ B-300 flexTec and SAWTEQ B-400 flexTec are equipped with the same robot technology as the well-established batch size 1 cell SAWTEQ B-320 flexTec. Your advantage: in this point too, you are opting for proven technology and maximum reliability.

3

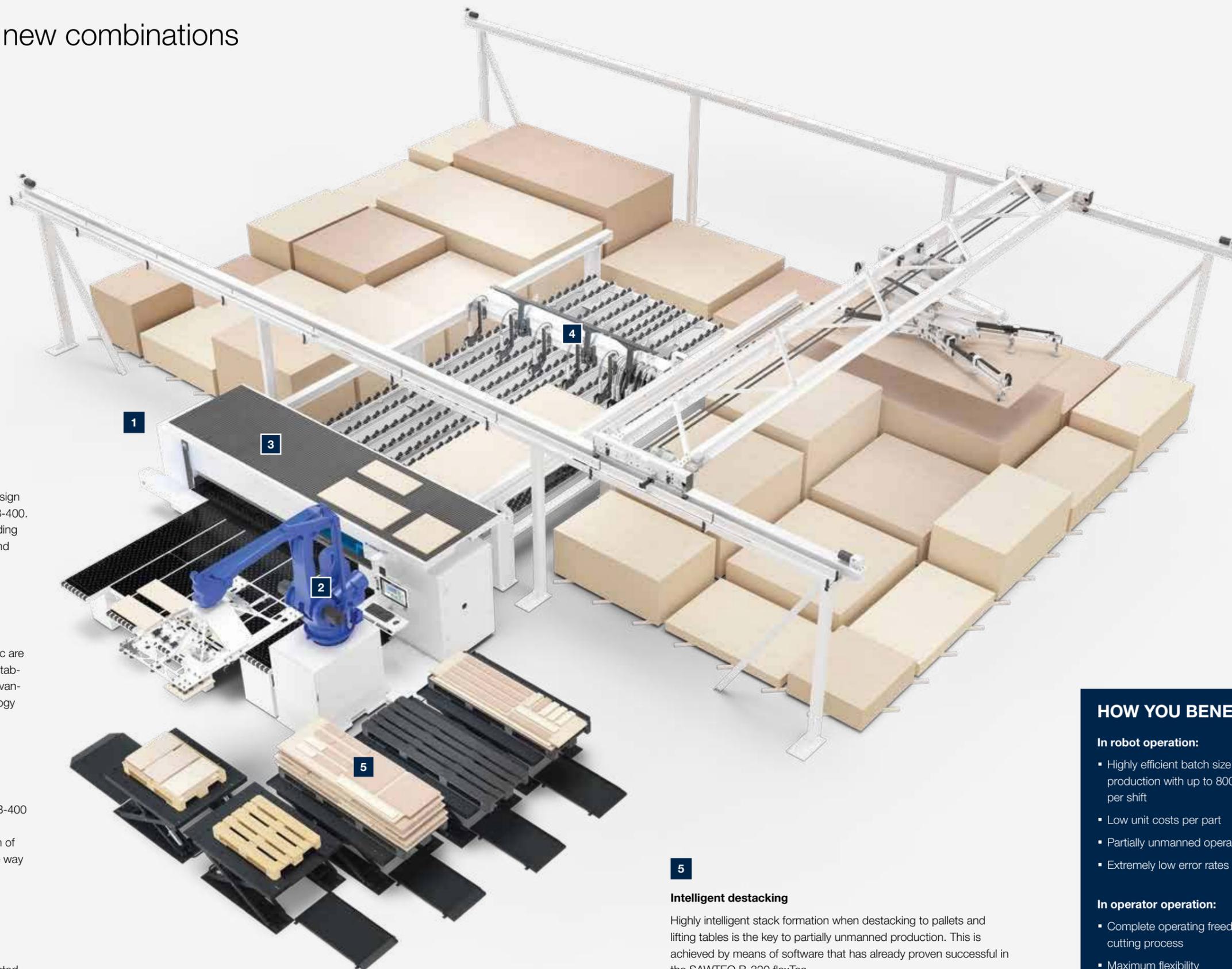
Wide variety of features

The robot saws SAWTEQ B-300 flexTec and SAWTEQ B-400 flexTec can be extensively customized to match different requirements and manufacturing environments. A wealth of optional technical features make sure of this in the same way as they do for panel dividing saws without robot.

4

Feeding options

Whether by hand, via a linked storage system, an integrated lifting table, the separate HOMAG HBX 150 gantry or a feeding station located at the side of the saw, there are many technologies for feeding panels to choose from. Find out more from page 20 onwards.



5

Intelligent destacking

Highly intelligent stack formation when destacking to pallets and lifting tables is the key to partially unmanned production. This is achieved by means of software that has already proven successful in the SAWTEQ B-320 flexTec.

When it comes to destacking hardware, the SAWTEQ B-300 flexTec and the SAWTEQ B-400 flexTec can be individually customized to meet your requirements. Find out more from page 22 onwards.

HOW YOU BENEFIT

In robot operation:

- Highly efficient batch size 1 production with up to 800 parts per shift
- Low unit costs per part
- Partially unmanned operation
- Extremely low error rates

In operator operation:

- Complete operating freedom in the cutting process
- Maximum flexibility
- For cutting books of panels or thin panels, for example

Your flexTec benefits at a glance



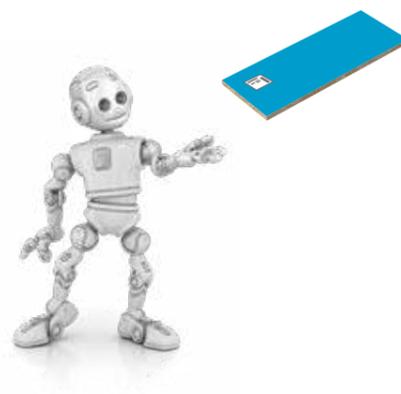
Fully automated batch size 1 cutting process

- Both saws are optimized for the single-panel cutting process in trade establishments, but are also suitable for use in industry
- The modular design provides the basis for numerous variants – individually aligned to your requirements
- The result: seamless workflows with high throughput in a compact space
- Minimum operator involvement, low tool and maintenance costs
- High output with up to 800 parts per shift in robot operation



An investment that pays off

- Precisely predictable benefits can be calculated as early as the planning stage thanks to HOMAG simulation software
- Attractive price / performance ratio
- Significantly reduced unit costs in batch size 1 production
- Low personnel costs due to fully automated, partially unmanned production
- High availability of the robot
- Low life-cycle costs



Perfect handling

- Fully automatic rip and cross cutting with just one saw
- No more manual panel handling, instead the option for unmanned operation – depending on the version – freely selectable depending on the operating mode
- The robot even takes care of handling the offcuts, provided that offcuts are automatically destacked to a place reserved for this purpose or returned to the store
- Automatic labeling of the finished parts is possible – with part- and order-specific information for further manufacturing operations
- In manual operating mode, it is furthermore possible to cut books of panels or to cut thin or larger/smaller-than-average panels in the usual way. The robot itself can process panels up to 3,200 mm long



Unmanned operation

- In robot mode, unmanned operation is possible over longer distances
- The robot moves the panels using gentle vacuum technology, works accurately, requires little maintenance and is highly available
- Production interruptions are almost completely ruled out with the proven industrial robot (almost 100% availability)
- No special robotics or programming knowledge is required
- Extremely low error rate in robot operation



Recuts almost at will

- Full flexibility in cutting pattern design thanks to recut technology
- Allows unlimited recuts provided that the panel materials comply with certain minimum and maximum dimensions
- Head sections, and therefore main parts of any length, are possible



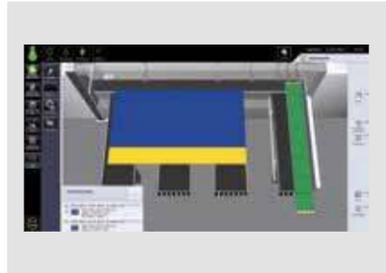
Systematic safety

- For robot operation, the operator terminal at the saw is moved to a safe position. The position is continuously checked by sensors whilst the robot is working
- During robot operation, the saw can be operated from a separate machine terminal that is located outside the enclosed safety area
- During manual operation, the external operator terminal is automatically switched off
- A (three-color) indicator light on the fence informs operating personnel of the current operating status of the saw
- The fold-down air cushion tables are raised during automatic operation

No special robotics or programming knowledge is required!

Software

Always up to date, intelligent and developed by HOMAG experts: tailored software solutions ranging from optimization to machine control and destacking allow you to get the most out of your saw. Highly efficiently and reliably.



MACHINE CONTROL SYSTEM

CADmatic 5 – the change in perspective

The latest generation of the HOMAG saw controller features a new assistance graphic that clearly shows the machine operator what he has to do next. Compared to the previous process graphic that showed all the work steps of the saw (and can still be called up if required), this new graphic represents a 180-degree change in perspective!

Highlights:

- The new 3D assistance graphic supports the operator and is intuitive to operate, which shortens the training period and reduces errors to a minimum
- This results in efficient processes and a steady output
- Simple handling via tapping and swiping (touch functions)
- Quick change between the individual sections
- Graphically supported diagnostics
- powerTouch user interface
- Ready for connection to tapio
- 21" full-HD widescreen monitor with multi-touch display

Find out more in the “CADmatic” brochure.



OPTIMIZATION

intelliDivide (optional feature)

Simply upload the parts list. Done! The result? A choice of several alternatives for cutting patterns and entire runs. That's how easy intelliDivide makes it.

In detail: the cloud-based optimization software intelliDivide utilizes significantly higher computing capacities than are available for locally installed optimization software and can therefore swiftly provide the user with multiple variants of an optimization result.

This means that with intelliDivide, the operator can choose from a variety of options, including a result based purely on reducing waste, a result based on the shortest machine time or on the simplest handling, perfectly adapted to the relevant requirements.

Applications are varied and are geared towards both the trade and industry. Would you, for example, occasionally like to optimize cutting patterns without having to buy, install and maintain a software solution? Then intelliDivide is just what you need. This is because you can use intelliDivide quite simply on an on-demand basis, as software as a service.

However, intelliDivide is also very interesting for large companies. Why is that so? Because, via the cloud, you can optimize your cutting patterns extremely quickly, intelligently and accurately with the help of a powerful calculation engine.

Good to know: the SAWTEQ B-300 flexTec and SAWTEQ B-400 flexTec saws come tapio-ready straight from the factory.



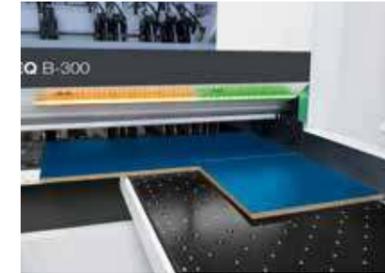
OPTIMIZATION

Cut Rite (optional feature)

Efficiency through planning: this short phrase sums up the key benefits of the Cut Rite software. With this world-leading software solution, you can optimize waste and systematically lower the overall costs for cutting.

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

Find out more in the “Cut Rite” brochure.



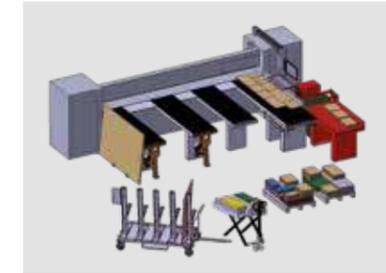
DESTACKING AIDS

Granted: in the case of the SAWTEQ B-300 flexTec and the SAWTEQ B-400 flexTec, the robot will probably usually perform the destacking work. Without any help and entirely automatically. You nevertheless quite frequently work in the operator operation mode? In this case, HOMAG can optionally offer you powerful destacking aids.

intelliGuide basic (optional feature)

intelliGuide basic always shows the operator the next step directly at the saw. The system accomplishes this by means of an LED strip at the cutting line. The LED strip produces light signals that appear directly in operator's field of vision.

- Colored LED signals at the cutting line allow intuitive operation and a quicker and safe way of working
- Using the colored LED elements, machine operators can immediately see if a part has been fully processed, needs to be cut again or can be disposed of as waste
- Based on the LEDs that are lit up, the operator can determine whether the workpiece being processed meets the required specifications



Destacking concept (optional feature)

The destacking concept guides the operator from depositing the first part to forming the perfect stacked pallet. This has been achieved by combining software and hardware in an overall concept. The software tells the machine operator when and where he should stack each particular part. You select the appropriate hardware according to your requirements. Altogether, this adds up to improved efficiency and ergonomics for all work steps. Times and routes that do not add value are systematically reduced.

Find out more in the “Handling” brochure.



CADmatic destacking module (optional feature)

Which part goes where? The CADmatic destacking module answers this question by means of an integrated destacking graphic. The individual parts are color-coded in the cutting pattern and also in the assistance graphic. This means the operator can see on the monitor exactly when he must place a particular part on a particular pallet.

An additional advantage is that the operator sees not only which part he must place on a particular pallet, but also the precise position on the pallet where the part is to be placed.

Standard features

The SAWTEQ B-300 flexTec and the SAWTEQ B-400 flexTec are equipped with everything you need for highly efficient and even partially unmanned manufacturing.



Robot with suction traverse

At the heart of these saws is a tried-and-tested industrial robot with a specially developed suction traverse. The robot is responsible for all the handling of the panels, strips and parts. This is fully automatic, highly flexible, error-free and efficient.

The basic principle: using the suction traverse, the robot gently lifts the material, moves it under the pressure beam and aligns the part to be processed against the right-angled fence. Then, it is automatically pushed backwards into the clamps. After sensors have checked the position and orientation, the cutting process starts. Afterwards, the robot collects the processed part and either aligns it again for the next cut, stores it temporarily or destacks it.



Parts buffer

The system has a parts buffer directly above the pressure beam. This is where the robot temporarily deposits parts that are to be either destacked or fed to the saw again later.

In order to ensure maximum process reliability, the parts buffer is equipped with a cleaning station for the aligning suction cups of the traverse. Dust deposits on the suction cups are regularly blown off.

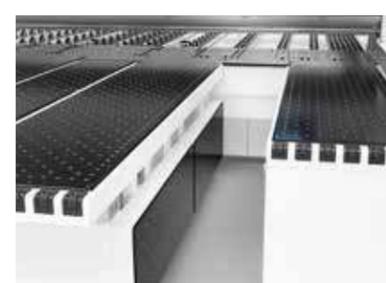
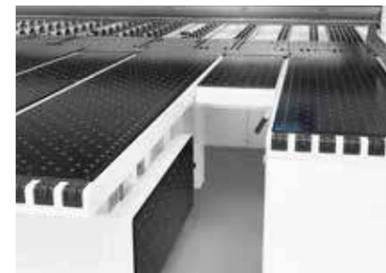


Fully automatic labeling

A must in robot operation and an advantage in operator operation: the labeler is an integral part of the standard configuration. It labels the finished parts or books of parts automatically – even when several strips are processed simultaneously side by side (Power Concept).

Good to know: the labeler is located near the pressure beam, i.e. in your field of vision. Furthermore, whether panels are fed from the side, front or rear is irrelevant for the labeling process. The position of the label can be individually controlled if desired – even right up next to the right-angled fence.

- Label size: 76 x 76 mm
- 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



Fold-down air cushion tables

- The gaps between the air cushion tables are each equipped with two fold-down tables
- The additional tables in the first gap are equipped with air jets as standard
- In operator operation, the tables can be folded down or up to allow free access to the cutting line or to prevent thin materials from sagging and increase the work surface
- For robot operation, the additional tables are raised and all gaps closed



Automatic outfeed fence

- Pushes panel remnants from the rear machine table to the front
- Included as a standard feature as it is essential for robot operation

The outfeed fence can only be used in robot operation.



Patented: central side pressure device

- Integrated directly in the saw carriage – 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 panels, laminates or sensitive materials to be processed perfectly. Another key feature here is the book-height-dependent control of the contact pressure: the higher the book, the greater the pressure

Standard features



Clamps

- Robust clamps, all with two fingers
- Gentle positioning of material
- The bottom fingers of the clamps can be removed at any time 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 precisely held and guided 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



Handy cleaning flap

Quick and convenient: the area under the saw carriage is easily accessible via flaps, allowing easy removal or vacuuming of cutting waste.



Patented dustEx technology

dustEx guides dust and chips on a direct route towards the extraction system. How does it work? By means of combination air jets and optimized extraction geometry at the right-angled fence. Furthermore, the machine table is fully equipped with air jets. This is particularly advantageous when cutting sensitive material or handling especially heavy panels and books. To round off the dustEx package, we recommend using a dust-trap curtain.



One saw carriage, numerous benefits

- Torsion-resistant, rugged and resilient basic design of the steel plate body for maximum dynamics and precision
- Infinitely variable feed 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 arm (patent)
- Energy saving feature: main saw motor is not raised



Power-Loc system

Making it quick and easy to change the saw blade.



Program fence for precision and dimensional accuracy

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

Rugged pressure beam for first-class cut quality

- Increased pressure beam elevation. The suction traverse can move under the pressure beam
- 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
- The result is accurate cuts, for books too
- With height control on request (available as an option)

Optional features

The HOMAG SAWTEQ B-300 flexTec and SAWTEQ B-400 flexTec saws are designed for maximum flexibility. This is achieved by the innovative machine concept, but also by the many optional features. The choice is yours!



Feed-stacking table with integrated feed

When linked to a simple storage system, the saw has to stop working briefly when a new panel is fed. The feed-stacking table ensures smooth, faster cycles: while one panel is still being cut, the storage system already positions the next panel(s) on the feed-stacking table with integrated feed.

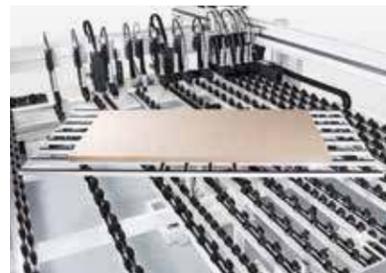
- Ideal in combination with the HOMAG panel labeling system
- Can be retrofitted
- Plug & Play: easy add-on
- Without alignment
- Perfectly matched to the saw (height, width, roller rails)
- Virtually no more idle time



Panel labeling system

The innovation for saws with automatic storage integration: the HOMAG panel labeling system labels the panel before it is cut – independently of the saw, in non-productive time that previously went unused. It can also be combined with the feed-stacking table with integrated feed.

- Smallest part size 170 x 170 mm
- Up to 10 labels/min, optionally up to 15 labels/min
- Labeling independent of cutting process
- Saves time, because non-productive time is used productively
- Optimizes handling during destacking, because all the parts are already labeled
- Simplifies and speeds up production processes
- Automated parts tracking
- Can be retrofitted
- For smooth processes



Rotation device for headcuts

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



Power Concept PROFESSIONAL

At the heart of this technology is a clamp that can be moved separately. Using this clamp, several strips with different cross cuts can be cut to length together. Even very narrow strips are precisely cut. Like this, Power Concept PROFESSIONAL accelerates overall production and significantly increases material throughput.

Power Concept works with:

- An additional clamp that operates independently
- Clamps on the program fence that can be raised out of the overlapping work area as needed
- Re-sorting the strips directly at the saw so that they are ideally matched to Power Concept PROFESSIONAL. This is based on existing optimization data for the shortest machining times



Power Concept PRACTIVE (for saws without lifting table)

This is the low-cost version of the successful Power Concept PROFESSIONAL. Power Concept PRACTIVE can be used on saws without lifting table with the following feeding variants:

- Feeding via a feeding station in front of the saw
- Feeding via a simple storage connection
- Feeding via the HBX 150 feed gantry

The advantage: Power Concept PRACTIVE can do everything that constitutes Power Concept, but can be integrated more easily and therefore more economically.

POWER CONCEPT

Up to **40%** more output



Lower costs per cut

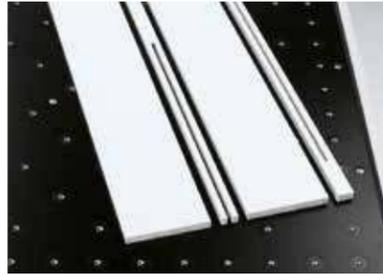


Significantly improved material flow



High material throughput

Optional features



Cut-out and stress elimination cut

Stress in the material is released when it is cut and can affect the quality of dimensions and cuts. The stress elimination cut option provides the solution. Systematic preliminary cuts can be defined during optimization and release the tension in the material. In operator operation, the cut-out feature allows you to produce even cut-outs and insertion grooves immediately too – for example for doors or kitchen sinks.

Stress elimination cut can be used in operator and robot operation.
Cut-out feature can be used in operator operation only.

Automatic angle cut device

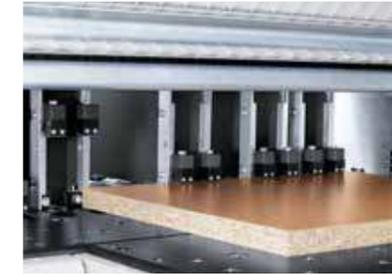
This technology completes angle cuts fully automatically, after you have entered the respective data in the CADmatic control.

Can only be used in operator operation.



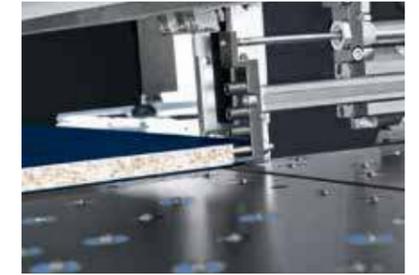
Cutting gap closers

Open and close automatically during the machine cycle, preventing narrow strips or trimmings from getting caught in the cutting line.



Program-activated clamps

This option prevents damage to edges. Now also available: clamp activation in “measuring” mode.



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



Soft Touch 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. HOMAG has a range of solutions in its portfolio designed to meet these requirements. Simply ask your customer advisor.



Grooving and turbo grooving

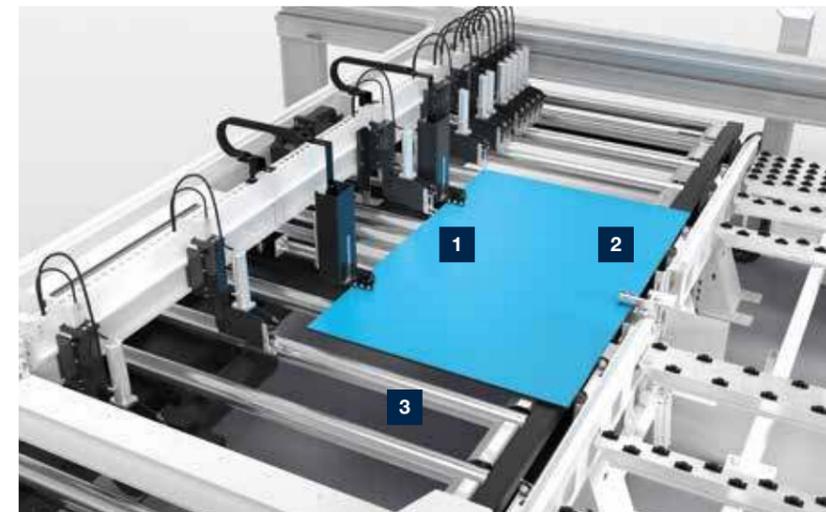
These options save you an entire production step in subsequent processing. This is because your saw will also groove the panel material. The turbo-grooving option completes the grooves even much faster than a processing center.

Can only be used in operator operation.



High-precision laser guide beam

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



1

Micro-feed for thin panels (for lifting-table saws only)

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

2

Hold-back device for thin panels (for lifting-table saws only)

For thin panels from a thickness of 3 mm.

3

Extra impetus for feeding (for lifting-table saws only)

The automatically driven roller conveyor integrated in the lifting table and additional roller conveyors on the side ensure fast stack changeover.

Optional features



Dust-trap curtain

- Attached to the rear of the pressure beam
- Protects operators from dust
- Improves extraction



Additional start-stop button

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



Automatic waste removal

1

Vibrating conveyor: cutting waste that falls through the waste flap collects here

2

Waste chopper: cuts waste into small pieces, facilitating its removal

3

Elevating waste conveyor belt: transports waste to the container, for example



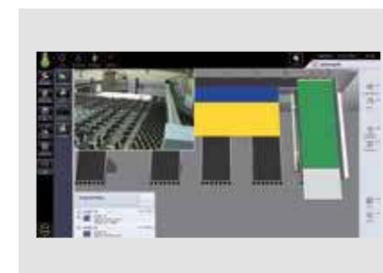
Scissor lift pallet truck "HuGo"

The scissor lift pallet truck "HuGo" is equipped with automatic height control and facilitates ergonomic and intelligent destacking processes. A light barrier controls the automatic raising and lowering of the pallet truck, allowing you to reach all the parts on the pallet at an ideal working height – at an edge banding machine, for example.



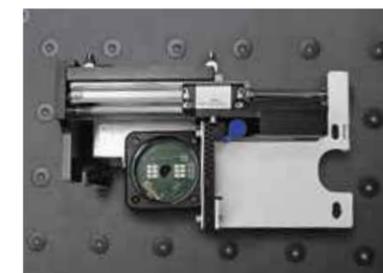
Label printer

The label printer is simply integrated in the robot pedestal. With it, you can create custom labels for manual part labeling directly at the saw and design them as required with a barcode, text or even graphics. If you also use our Cut Rite optimization software, the material goes directly to the next process step with printed instructions. In this way, you can integrate the saw perfectly in your production flow.



Everything in view – with video monitoring

- Display of the camera image via the CADmatic control software
- You always have the rear machine table and feed system in view
- Camera pictures can be recorded if required for error diagnostics and workflow optimization purposes and sent to the HOMAG Service department

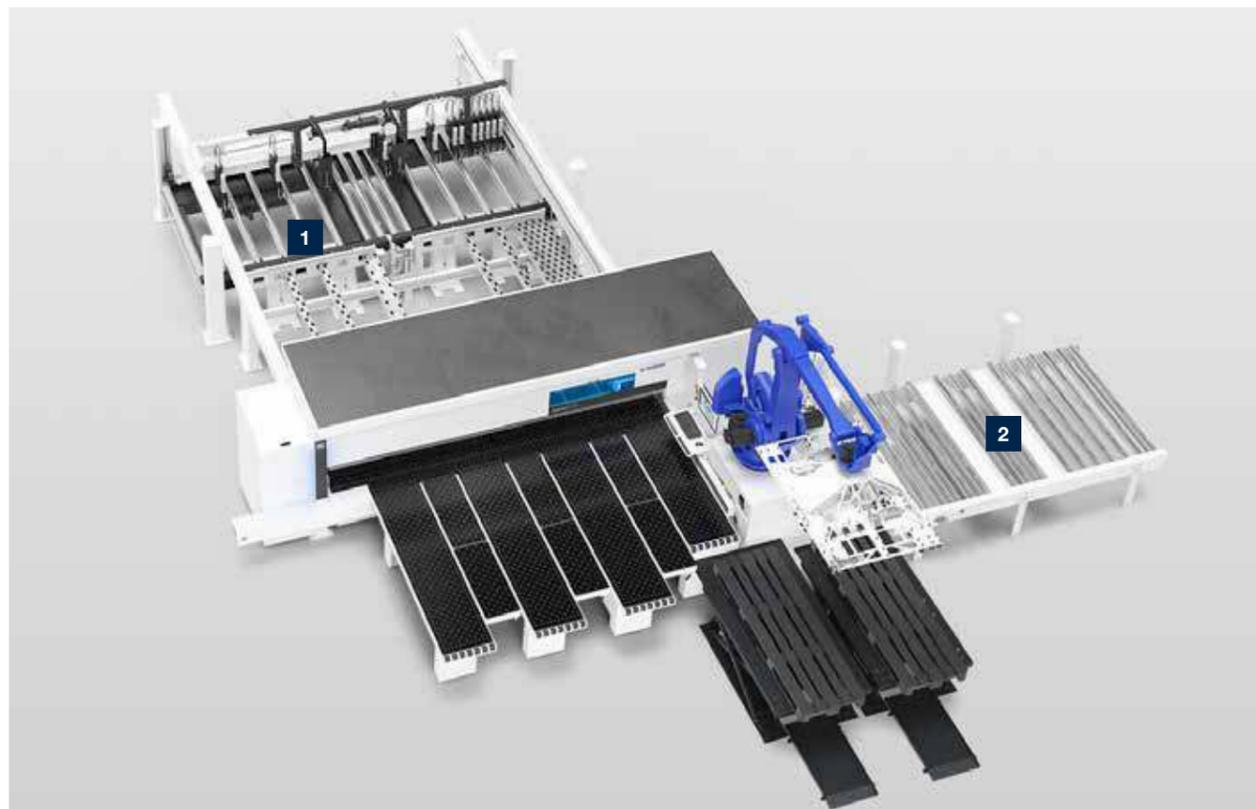


Patented: camera-controlled scoring saw adjustment

- This option allows the scoring saw to be adjusted fully automatically. Manual adjustment is still possible – controlled by the software via input on the touchscreen.
- Optimum measuring results: the camera selects the color of lighting and the exposure time itself
- The simple adjustment takes no longer than a minute
- High-precision adjustment

Feeding variants

For the robot saws SAWTEQ B-300 flexTec and SAWTEQ B-400 flexTec, flexibility starts right at the feeding stage. Which variant is your favorite?



1

Feeding via lifting table

- In the case of lifting-table saws, panels are fed via an electro-hydraulic four-column lifting table
- Automatic determination of book height
- Equipped as standard with longitudinal profiles and sensing device
- Also suitable for thin materials from 9.5 mm upwards. Suitable for materials from 3 mm upwards if equipped with the optional micro-feed and hold-back device (page 17)
- Maintenance-free and no lubrication required
- In order to ensure precise cuts, the backing wall is not attached to the machine bed

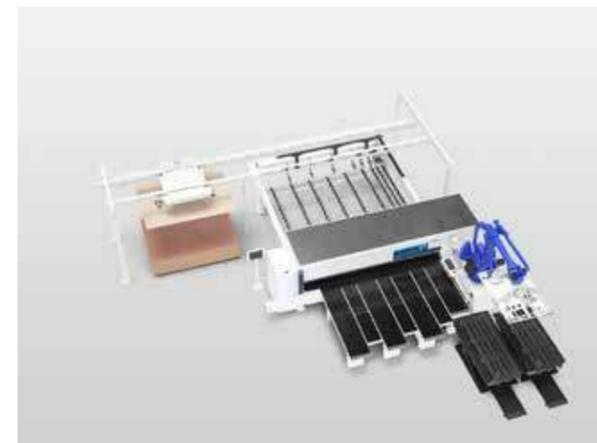
2

Robot feeding via roller conveyor at the side

NEW: HOMAG has designed a table with roller conveyor, positioned at the side, specifically for the SAWTEQ B-300 flexTec and SAWTEQ B-400 flexTec panel dividing saws.

- A pre-assembled stack of panels is placed on the roller conveyor at the side
- A panel separator positioned here raises the top panel each time so that the robot can fetch it with the aid of the suction traverse and feed it to the saw

This feeding variant can only be used in robot operation.



Vacuum feeding via HBX 150 (for single saws without lifting table only)

Automation in the smallest of spaces is the promise made by the HBX 150 gantry vacuum feeding system. It fetches the next panel from the stacking station next to or behind the saw, turns it if required and places it in the saw. With maximum care of material and fully automatically during the saw cycle.

- A choice of various layouts, to suit specific requirements and available space
- With traveling lifting device and suction traverse
- Turning device for up to 90 degree rotation
- With automatic weight determination
- For especially ergonomic handling
- Manufactured by Barbaric

Find out more in the “HBX 150” flyer.



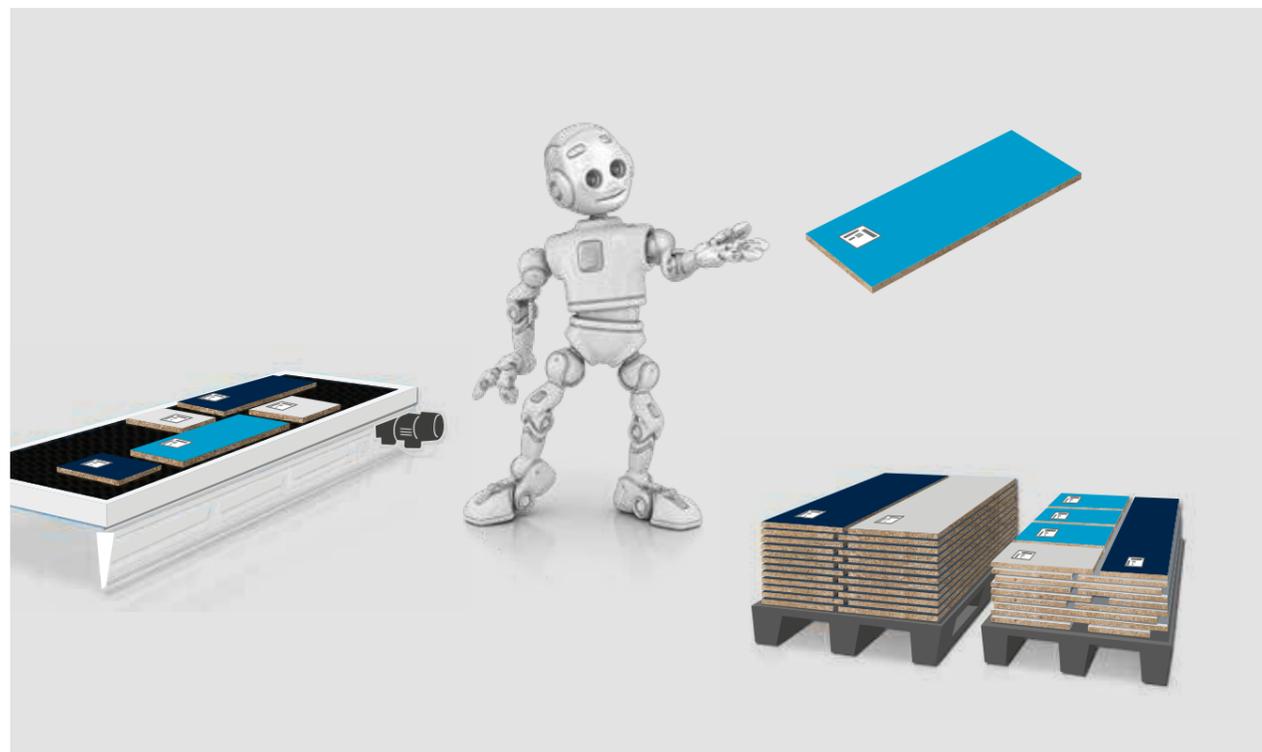
Feeding via a horizontal storage system

For customers with very demanding automation requirements, HOMAG offers tailored horizontal storage systems – ranging from small systems for the trade sector to large industrial solutions. These systems allow you to noticeably speed up your processes and reduce your costs per part.

- Small footprint
- Attractive price
- Movable in x and y directions
- Saw and storage system compatible with each other
- Perfect handling – even with just one machine operator
- Easy, ergonomic operation
- Storage system controls the saw

Intelligent destacking

HOMAG has developed a destacking software solution with a completely new algorithm. This software, the robot and the lifting tables enable the saws to operate unmanned over long distances.



The advantage: operators are not required over long distances

Equipped with lifting tables in the robot's field of action, the saws can work unmanned over long distances, depending on the destacking variant chosen.

The operating principle: clever and highly automated

The finished parts exit the saw in the order in which they are cut. To obtain the optimum destacking order for stable stacks and subsequent processing, the HOMAG experts have developed a new algorithm.

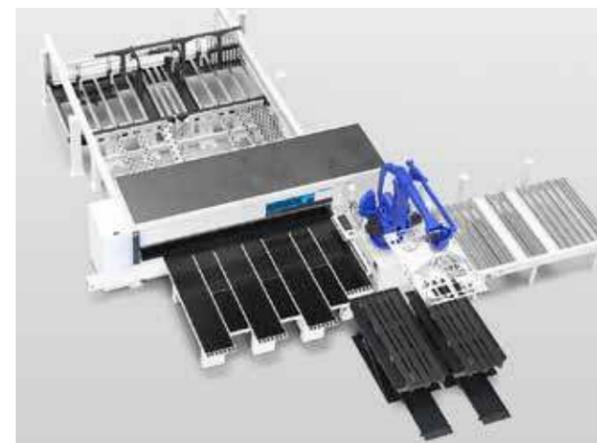
Equipped with this intelligence, the robot systematically creates stable stacks, utilizing the parts buffer too in the destacking process where appropriate. Like this, the lifting tables are used more intelligently than ever to form perfect stacks.

The cutting cell is equipped with a laser scanner. It measures the height of the stacks of parts on the lifting tables in real time so as to ensure that the lifting tables are positioned at the ideal height.

The result: all-round efficiency

- The robot can destack parts according to an optimization strategy based on either destacking location or downstream processes
- The robot always tries to utilize the maximum stack height
- It forms absolutely stable and, at the same time, fewer stacks than is normal when manually destacking
- Actions by machine operators are rarely required, and no longer needed at all over long distances

This reduces the space required for handling tasks. All this adds up to a rapid return on investment.



Lifting table variants for every requirement

Diversity of materials, picking destinations, number of orders processed in parallel: there are many parameters that decide the best number, size and positioning of the lifting tables in each individual case. Requirements can vary greatly. That's why the HOMAG panel dividing experts work together with you to develop the best possible lifting table layout for your production facility.

- The minimum requirement is two small lifting tables
- The maximum number that can be combined with each other is three large and two small lifting tables
- Feeding by robot via a roller conveyor at the side limits the number of lifting tables and positioning options

Performance and level of automation tailored to your needs



TECHNICAL DATA*	B-300 FLEXTEC	B-300 FLEXTEC WITH LIFTING TABLE
Saw blade projection (mm)	80 (optional: 95)	80 (optional: 95)
Cutting length (mm)	3,800 / 4,300	3,800 / 4,300
Lifting table width (mm)	-	2,200
Program fence speed (m/min)	up to 90	up to 90
Saw carriage speed (m/min)	up to 130 (optional: 150)	up to 130 (optional: 150)
Main saw motor (kW)	50 Hz: 11 (optional: 18 or 24) 60 Hz: 11 (optional: 21 or 28)	50 Hz: 11 (optional: 18 or 24) 60 Hz: 11 (optional: 21 or 28)
Scoring saw motor (kW)	1.5 (optional: 2.2)	1.5 (optional: 2.2)
Average total air requirement (NL/min)	400	470
Compressed air requirement (bar)	6	6
Extraction system (m³/h)	3,800; 26 m/sec	3,800; 26 m/sec
Max. stack height without pit (mm)		560
Max. stack weight (t)		4
Processing height (mm)	920	920
Air cushion table (mm)	3/4 x 2,160	3/4 x 2,160

TECHNICAL DATA*	B-400 FLEXTEC	B-400 FLEXTEC WITH LIFTING TABLE
Saw blade projection (mm)	110 (optional: 125)	110 (optional: 125)
Cutting length (mm)	3,800 / 4,300	3,800 / 4,300
Lifting table width (mm)	-	2,200
Program fence speed (m/min)	up to 90	up to 90
Saw carriage speed (m/min)	up to 130 (optional: 150)	up to 130 (optional: 150)
Main saw motor (kW)	50 Hz: 18 (optional: 24) 60 Hz: 21 (optional: 28)	50 Hz: 18 (optional: 24) 60 Hz: 21 (optional: 28)
Scoring saw motor (kW)	2.2	2.2
Average total air requirement (NL/min)	420	490
Compressed air requirement (bar)	6	6
Extraction system (m³/h)	3,800; 26 m/sec	3,800; 26 m/sec
Max. stack height without pit (mm)		560
Max. stack weight (t)		4
Processing height (mm)	920	920
Air cushion table (mm)	3/4 x 2,160	3/4 x 2,160

* Values relate to the standard version



HOMAG LifeCycleService

Optimal service and individual consultations are included in the purchase of our machines. We provide support through service innovations and products that are tailored exactly to your company's requirements. With short response times and

fast customer solutions, we can guarantee excellent availability and cost-effective production for the entire life cycle of your machine.

1,200
service employees worldwide

> 90%
fewer on-site visits due to successful remote diagnostics

5,000
customer training sessions per year

> 150,000
machines electronically documented
in 28 languages in eParts



HOMAG Finance – tailor-made financial solutions

- We offer you tailored financing proposals for your machinery or plants. Our financial advice goes hand in hand with our expertise relating to technical questions. Your personal contact person will take care of the whole process
- The benefits for you: you can invest in new technologies without delay, while remaining financially flexible



Remote service

- Hotline support for the control system, mechanics, and process technology from our remote service specialists. This results in around 90% fewer on-site service visits!
- Mobile applications such as ServiceBoard reduce costs by providing fast assistance in the event of malfunctions via mobile live video diagnostics, online service messages and eParts, the online spare parts shop



Spare part service

- Identify, request and order spare parts 24/7 via www.eParts.de
- Parts available locally worldwide through sales and service companies, as well as sales and service partners
- Reduction in downtimes due to specific replacement part and wear part kits



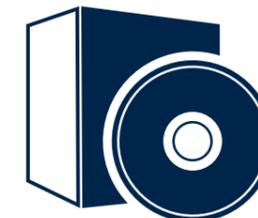
Modernization

- Keep your machine pool up to date and increase both the productivity and product quality. Meet future product requirements today!
- We provide support through upgrades, modernizations, and individual consultations and development



Training

- Thanks to training that is precisely tailored to your needs, your machine operators can operate and maintain HOMAG machines as efficiently as possible
- You will also receive customer-specific training material with tried-and-tested exercises



Software

- Telephone support and advice from Software Support
- Digitization of your sample parts using 3D scanning saves time and money in comparison with reprogramming
- Retrospective networking of your machine fleet with intelligent software solutions from design through to production



Field service

- Increased machine availability and product quality thanks to certified service personnel
- Regular checks through maintenance / inspection ensure that your products are of the highest quality
- Minimized downtimes in the event of unforeseeable malfunctions due to the high availability of our technicians

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YOUR SOLUTION