

**SPRINT**  
**1320/1321**



**The benchmark for flexibility  
and high productivity**

**Your partner for productivity and precision**

**HOLZ-HER**®  
**Special Machines**

## SPRINT 1320/1321

### Two series, individual equipment packages

- **SPRINT 1320**  
Nine high-performance basic units – including a copying cutter unit for processing post-forming profiles and perfect post-finishing – for applying plastic edges of up to 3 mm and solid-wood edges of up to 15 mm. The workpieces can be up to 55 mm thick. The maximum feed speed is 18 m/min and makes it a leader in terms of processing speed.
- **SPRINT 1321**  
Joining cutter as standard: All machines in the 1321 series are additionally equipped with a joining cutter unit.
- **SPRINT 1320-2 and 1321-2**  
The final digit 2 indicates that the basic machines have motorized pressure beam adjustment.
- **SPRINT 1320-5 and 1321-5**  
As well as motorized pressure beam adjustment, these models also comprise as standard the additional grooving unit 1841 for flat grooving and folding.
- **SPRINT 1320-6 and 1321-6**  
Equipped as standard with the profile cutter unit 1932 for surface and end profiling and grooving and also with motorized pressure beam adjustment.



### Perfect jointing

Fast, superior finish-processing of plastic and solid-wood edges.

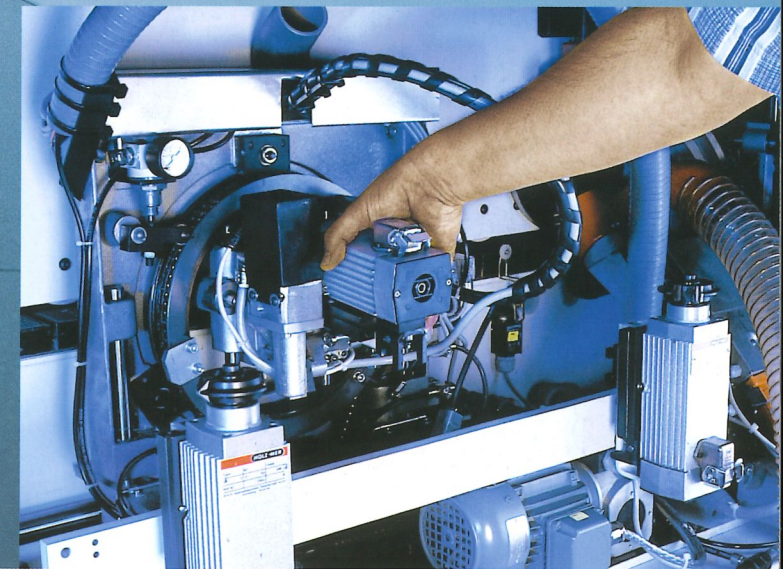
### SPRINT 1321

The jointing cutter unit upstream of the glue application system eliminates even very small tears in the surface layer.

### Central pressure beam adjustment and more than 40 equipment options

The centrally adjustable pressure beam ensures precise guidance of the workpieces, which are often delicate. In order to process different profile shapes in a rational and perfect manner in one operation, besides the basic equipment more than 40 variants are available to the user. In this way, the SPRINT 1320/1321 can be adapted to specific tasks and thus provides a flexible machine concept which is unparalleled.

The image shows shaping cutter unit 1983 with a manual tool changer (fully automatic tool changer optionally available)



### Rapid and professional edgebanding in a single operation

With increasing numbers of items for edge finishing, operations and thus productivity must continually be optimized. This is possible only with the corresponding machine equipment suitable for these requirements. The SPRINT 1320/1321 series from HOLZ-HER sets a benchmark in terms of productivity and flexibility for edgebanders. Absolute precision in jointing quality goes without saying. The SPRINT 1320 and 1321 edgebanders have a performance spectrum which is suitable for both industrial works and also specialists with above-average requirements.

With its defined geometric shape, the new design clearly shows the position of the series. Excellent stability as a basis for precision and also a large amount of space and good accessibility to the units are the prerequisites for efficient operation. The new HOLZ-HER control facility allows extremely simple operation. Set-up and retrofitting of the machine has never been easier. The patented HOLZ-HER glue application system – one of the key units in edge finishing – ensures a reliable join between the workpiece and the edge and represents high cost-effectiveness.

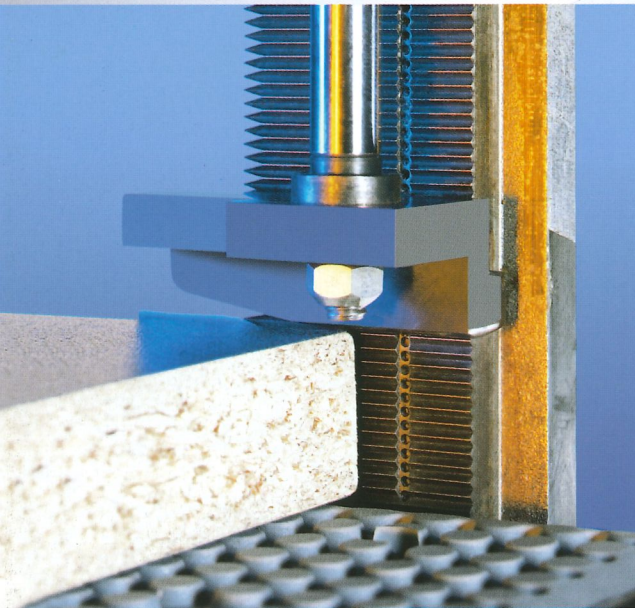
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## **SPRINT 1320/1321**



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 controlled application of glue takes place as required, and therefore consumption is extremely efficient. Costs remain low and there is no unnecessary waste. The closed heating system prevents any irritation caused by odours. Since only the precisely required amount of glue is melted in each case, discoloration or scorching is prevented. When the reserves of glue are coming to an end, the control facility displays the message "Refill glue" in plain text and in good time.



### **Fast change of glue**

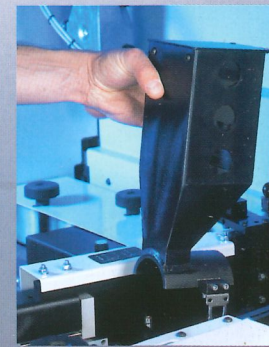
One particular strong point of the cartridge system is the possibility of changing from EVA to PUR glue in a rapid and rational manner during processing or of changing the colour of the glue. The cartridge is simply replaced. There is no need for complex cleaning of the glue container.

### **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 to say twice as fast as in conventional systems - and saves up to 95% power.

## **One of a kind – the 1905 MULTI-SYSTEM**

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



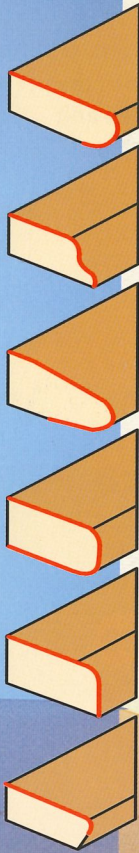
## **Glue application system – for a secure join**

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 1905/1906M 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 nozzles and the pores in the workpiece are filled. The result is an extremely durable flat join.



### Power PC with touchscreen

Comfortable and direct operation of all functions via a 15" touchscreen.



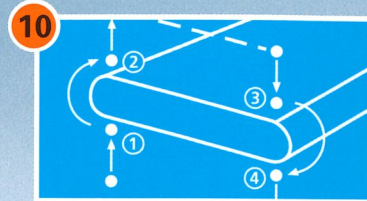
## HOLZ-HER control facility – high standards safeguard it for the future

- Power PC control for rational set-up and retrofitting
- Windows-like user 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
- Integrated path control
- Interval indicator for very short workpiece spacings
- VGA screen
- Rotatable and tiltable operating panel at eye level
- Anti-dust touch keyboard with soft keys
- Individual management for up to ten users
- Online maintenance (optional), rapid exchange of data with HOLZ-HER Service
- Barcode interface (optional)

## Perfect system solution – convenient to operate

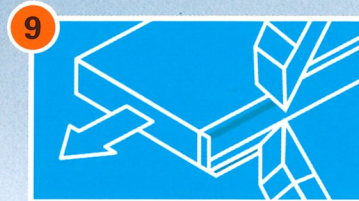
The new HOLZ-HER control facility is extremely high-performance. Use is made of an ambitious industrial processor and a modern CAN bus system for data exchange on a standard platform. The integrated synchronous bus system further increases the precision in terms of control of the units. The well-designed ergonomics of the operating panel with a VGA screen – if desired with a 15" touchscreen function – offers particular comfort during operation. It is effective and makes it pleasing to work with the intelligent HOLZ-HER control concept.

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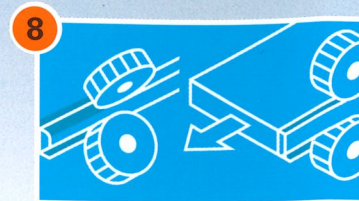
**Shaping cutter unit –**

for processing the vertical front and rear edges of the workpiece and the top and bottom corner points or their profiles.



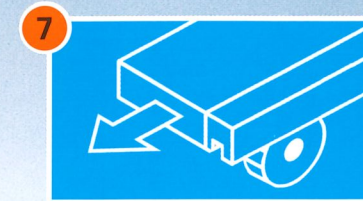
**Scraper unit –**

for perfect smoothing of radii and cuts on plastic edges. Available with motorized adjustment if desired, alternatively with six motorized axles for processing different radii.



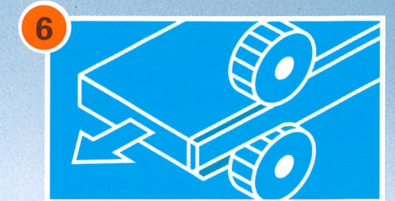
**Multifunction unit –**

for flush, radius and chamfer cuts. Optionally available with motorized adjustment between radius and flat cuts. Alternatively, cutter unit with six motorized axles for processing different radii up to 5 mm.



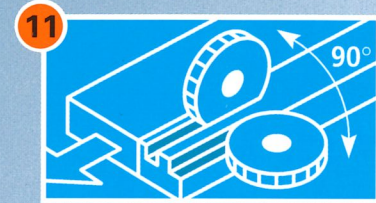
**Grooving unit –**

for creating longitudinal grooves and for folding surfaces towards the workpiece edge (1320-5 and 1321-5).



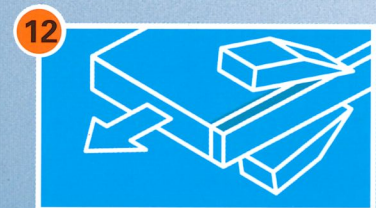
**Cutter unit –**

for cut-length and coiled edging from 0.4 to 15 mm edge thickness. Panel thickness up to 50 mm (optional).



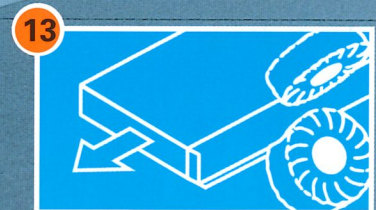
**Profile cutter unit –**

for surface and end grooving or profiling (1320-6 and 1321-6).



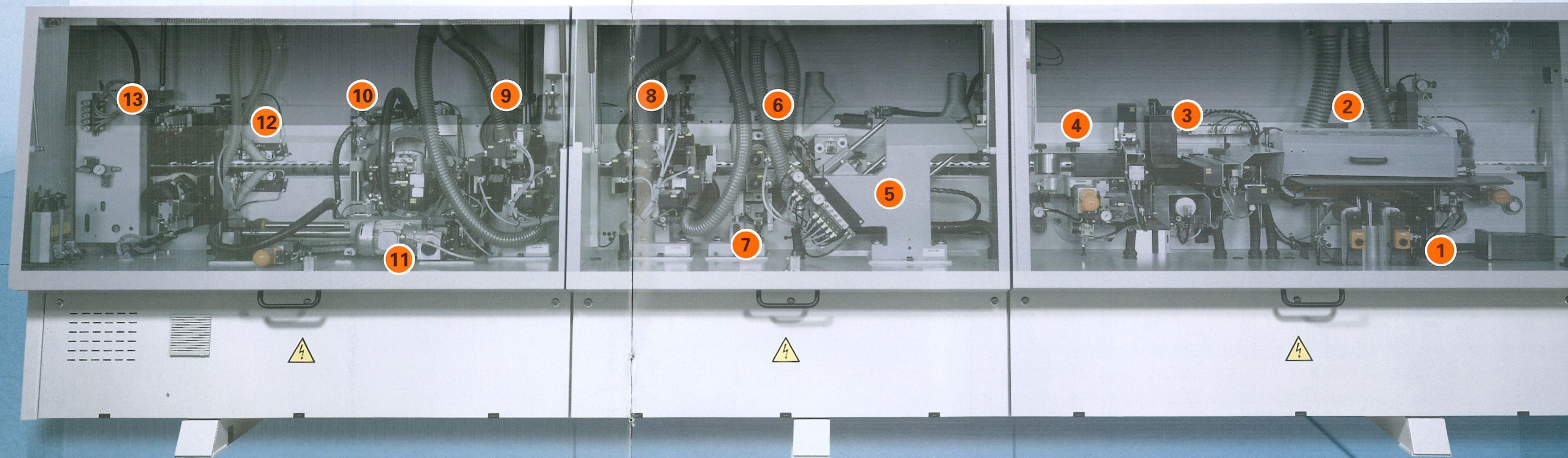
**Flat scraper –**

clean post-finishing of the surface – no need for manual post-finishing.



**Buffer unit –**

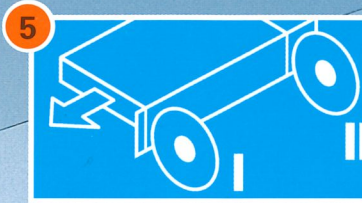
for perfect post-finishing of edges and surfaces for absolutely clean finishing.



### Units as required and superior in terms of performance

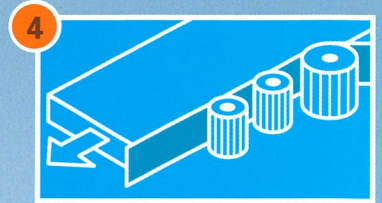
More than 30 high-performance unit versions are available in order to adapt the machines of the SPRINT 1320/1321 series exactly to the use profile. Each individual unit is designed for high durability. The new design concept provides the technology with a lot of space, and the units are clearly placed and easily accessible, for example for changing tools.

Pneumatically controlled or motorized versions are optionally available for many units. The stable transport chain runs on precision guides and transports the workpieces reliably 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.



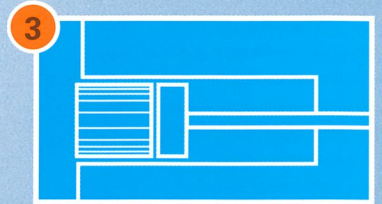
**End trimming unit –**

two powerful 0.35 kW motors for a high feed speed and greater throughput. The penetrating linear cut ensures precise, tear-free end trimming.



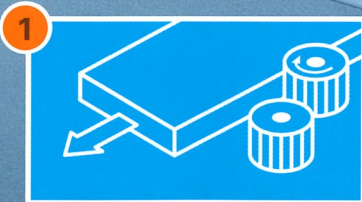
**Pressure unit –**

high pressing pressure for clean edge gluing. Pressure unit with pneumatic control of the first roller and with two conical downstream pressure rollers.



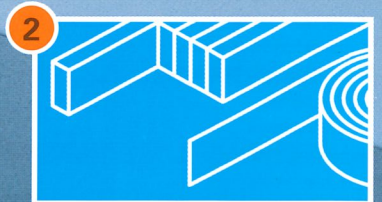
**Glue application –**

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



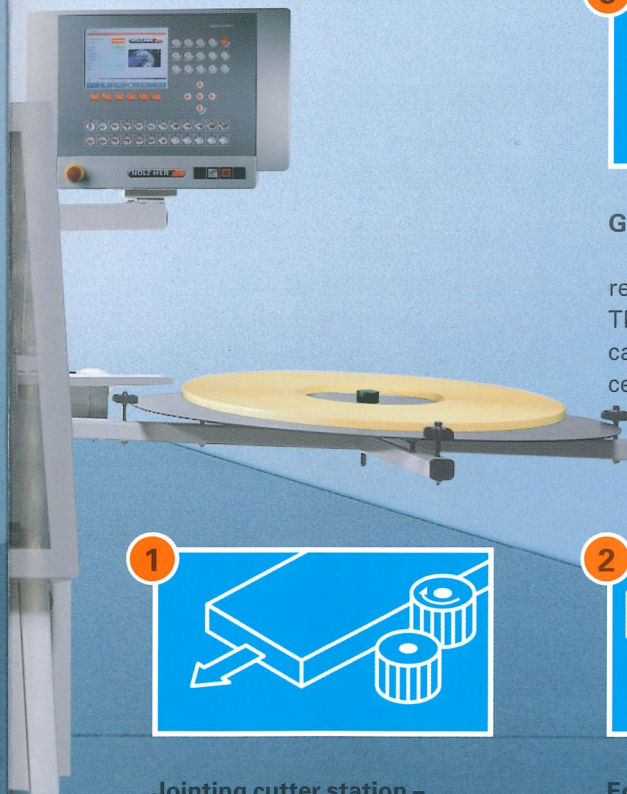
**Jointing cutter station –**

for cutting the edge surfaces of materials in panel form (2 x 2.0 kW).



**Edging feed –**

fully automatic, user-friendly feeding of cut-length and coiled edging.



## Unit equipment

	1320-1	1320-2	1320-5	1320-6	1321-1	1321-2	1321-5	1321-6
<b>Joining cutter unit 1961</b>								
2 x 2.0 kW, 200 Hz, 12000 rpm								
Two plunge-controlled cutter units (up and down cutting modes), plunge travel 5 mm	-	-	-	-	✓	✓	✓	✓
<b>Edging feed 1903</b>								
Support plate Ø 820 mm, max. loading capacity 40 mm	✓	✓	✓	✓	✓	✓	✓	✓
<b>Glue application system 1906 M</b>								
Patented cartridge system for EVA and PUR glue								
1.9 kW, manual recharge, magazine capacity: one cartridge (approx. 330 grams)	✓	✓	✓	✓	✓	✓	✓	✓
<b>Glue application system 1905</b>								
Multi-system for EVA and PUR glues in cartridge and pellet form. Cartridge shaft with four cartridges (approx. 1.4 kilograms), pellet shaft for approx. 1.5 kilograms	○	○	○	○	○	○	○	○
<b>Glue application system 1910</b>								
Glue roller for EVA pellets	○	○	○	○	○	○	○	○
Application in up and down run								
<b>Pressure unit 1913</b>								
Three rollers, one roller motor-driven.								
Optional: pneumatic individual control of all pressure rollers	✓	✓	✓	✓	✓	✓	✓	✓
<b>End trimming unit 1918</b>								
2 x 0.35 kW, 300 Hz, 9000 rpm								
Tilting from 0 to 10 degrees	✓	✓	✓	✓	✓	✓	✓	✓
<b>Cutter unit 1823</b>								
2 x 0.6 kW, 300 Hz, 18000 rpm	○	○	-	○	○	○	-	○
<b>Grooving unit 1841</b>								
1 x 3.8 kW, 200 Hz, 12000 rpm								
Sawing blade diameter min. 135 mm, max. 160 mm	-	-	✓	-	-	-	✓	-
Sawing blade width min. 1.5 mm, max. 5 mm								
<b>Multifunction unit 1942 M</b>								
2 x 0.6 kW, 300 Hz, 18000 rpm								
Tilting range from 0 to 15 degrees	✓	✓	✓	✓	✓	✓	✓	✓
<b>Multifunction unit 1942 MOT 2</b>								
As 1942 M, but with motorized adjustment	○	○	○	○	○	○	○	○
<b>Scraper unit 1929</b>								
Two scraper carriers, up to max. R = 3 mm	✓	✓	✓	✓	✓	✓	✓	✓
<b>Scraper unit 1929 MOT 2</b>								
As 1929, but with motorized adjustment	○	○	○	○	○	○	○	○
<b>Cutter unit 1983</b>								
1 x 0.6 kW, 300 Hz, 18000 rpm	✓	✓	✓	-	✓	✓	✓	-
<b>Profile cutter unit 1932</b>								
1 x 3.8 kW, 200 Hz, 12000 rpm								
Including frequency converter 200 Hz	-	-	-	✓	-	-	-	✓
<b>Flat scraper 1964</b>								
Top and bottom separately controlled	○	○	○	○	○	○	○	○
<b>Buffer unit 1940</b>								
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. Please ask your HOLZ-HER dealer for details of the features included. All rights reserved in respect of changes in design and features.

# SPRINT 1320/1321

## Technical data

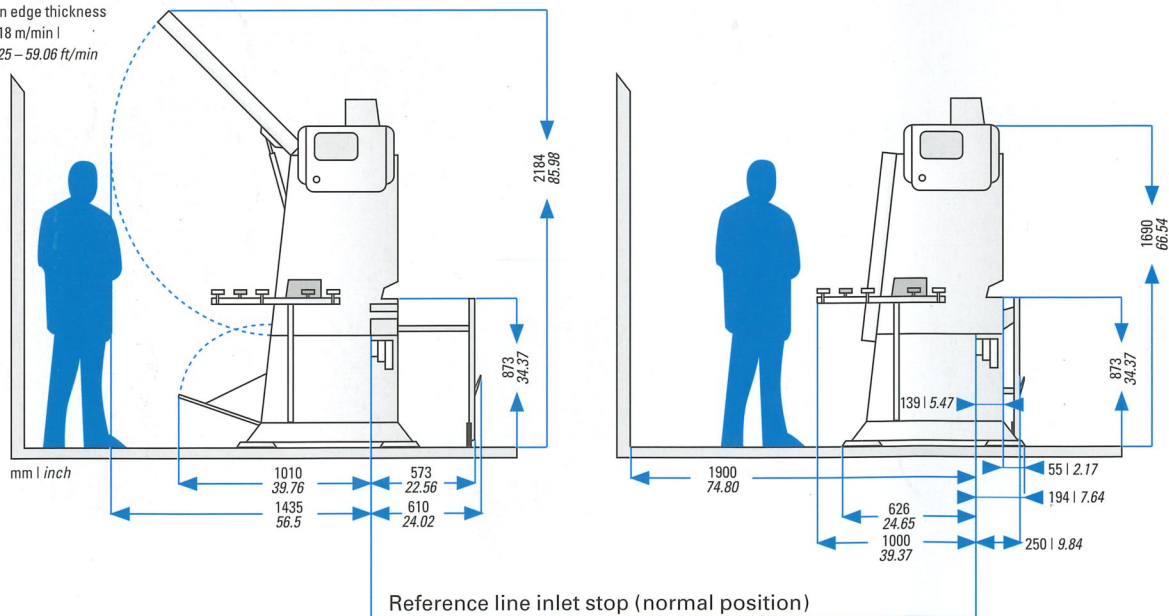
	1320-1		1320-2		1320-5		1320-6		1321-1		1321-2		1321-5		1321-6	
<b>Machine dimensions</b>																
Overall length (mm   inch)	5525	217.52	5525	217.52	5525	217.52	5525	217.52	6480	255.12	6480	255.12	6480	255.12	6480	255.12
<b>Working dimension<sup>1)</sup></b>																
Workpiece thickness min./max. <sup>2)</sup> (mm   inch)	6/60	0.23/2.36	6/60	0.23/2.36	6/60	0.23/2.36	6/60	0.23/2.36	6/60	0.23/2.36	6/60	0.23/2.36	6/60	0.23/2.36	6/60	0.23/2.36
Edging thickness <sup>2)</sup> (mm   inch)	0,4 - 15	0.01-0.59	0,4 - 15	0.01-0.59	0,4 - 8	0.01-0.31	0,4 - 15	0.01-0.59	0,4 - 15	0.01-0.59	0,4 - 15	0.01-0.59	0,4 - 8	0.01-0.31	0,4 - 15	0.01-0.59
Edging height max. <sup>2)</sup> (mm   inch)	65	2.56	65	2.56	65	2.56	65	2.56	65	2.56	65	2.56	65	2.56	65	2.56
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
<b>Feed speed</b>																
Feed speed (m/min   ft/min)	12,5 <sup>3)</sup>	41.01 <sup>3)</sup>	12,5 <sup>3)</sup>	41.01 <sup>3)</sup>	12,5 <sup>3)</sup>	41.01 <sup>3)</sup>	12,5 <sup>3)</sup>	41.01 <sup>3)</sup>	12,5 <sup>3)</sup>	41.01 <sup>3)</sup>	12,5 <sup>3)</sup>	41.01 <sup>3)</sup>	12,5 <sup>3)</sup>	41.01 <sup>3)</sup>	12,5 <sup>3)</sup>	41.01 <sup>3)</sup>
<b>Extraction</b>																
Jointing cutter unit (m <sup>3</sup> /h)	-	-	-	-	-	-	-	-	900	900	900	900	900	900	900	900
Cutter unit (m <sup>3</sup> /h)	2 x 280	2 x 280	2 x 280	2 x 280	280	280	2 x 280	2 x 280	2 x 280	2 x 280	2 x 280	2 x 280	280	280	2 x 280	2 x 280
Scraper unit (m <sup>3</sup> /h)	280	280	280	280	280	280	280	280	280	280	280	280	280	280	280	280
Profile cutter unit (m <sup>3</sup> /h)	-	-	-	-	280	280	280	280	-	-	-	-	280	280	280	280
Static underpressure																
Jointing cutter unit (Pa)	-	-	-	-	-	-	-	-	1490	1490	1490	1490	1490	1490	1490	1490
Cutter unit (Pa)	1650	1650	1650	1650	1650	1650	1650	1650	1650	1650	1650	1650	1650	1650	1650	1650
Min. air speed (m/sec.   ft/sec.)	20	65.62	20	65.62	20	65.62	20	65.62	20	65.62	20	65.62	20	65.62	20	65.62
Jointing cutter unit connection Ø (mm   inch)	-	-	-	-	-	-	-	-	125	4.92	125	4.92	125	4.92	125	4.92
Cutter unit connection Ø (mm   inch)	2 x 70	2 x 2.75	2 x 70	2 x 2.75	70	2.75	2 x 70	2 x 2.75	2 x 70	2 x 2.75	2 x 70	2 x 2.75	70	2.75	2 x 70	2 x 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
Profile cutter unit connection Ø (mm   inch)	-	-	-	-	70	2.75	70	2.75	-	-	-	-	70	2.75	70	2.75
<b>Compressed air</b>																
Compressed air connection (bar)	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6

<sup>1)</sup> Depending on equipment

<sup>2)</sup> Depending on edge thickness

<sup>3)</sup> Optional: 8 - 18 m/min |

26.25 - 59.06 ft/min



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