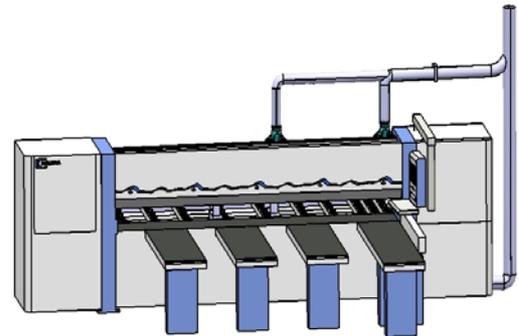


The dust extraction unit on the pressure beam and chip channel disposes of the chips produced during sawing.

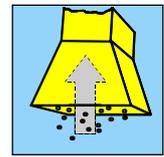
Features	Values
Extraction lines $\varnothing$	See layout plan
Speed	26 m/s
Minimum vacuum $\Delta p$	
• Pressure beam	12 HPa
• Chip channel	4 HPa



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**Contents:**

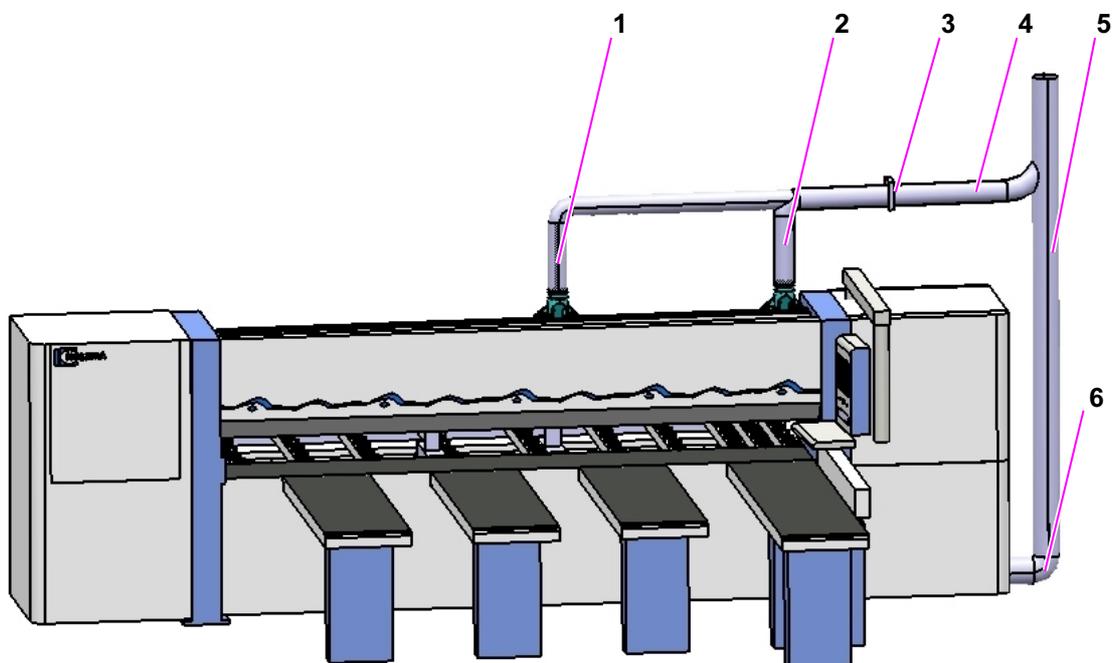
1	Connection	2
2	Operation	4



## 1 Connection

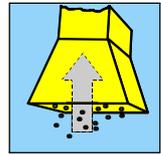
### Connection of saw to extraction system

- Connection to an adequately dimensioned extraction system
- Required extraction capacity
- ➔ See **Machine Installation Plan**
- Flexible connections **1 + 2** because of vertical movement of pressure beam
- Slide valve **3** (provided by customer) prevents trim from entering system
- Drive for slide valve provided by HOLZMA
- ➔ See **Wiring diagram**



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1 / 2	Flexible connection on pressure beam
3	Slide valve, supplied by customer
4	Inlet pipe pressure beam
5	Total inlet pipe $\varnothing$ d
6	Inlet pipe chip channel



**Note:**

There are 2 terminals **1 / 2** (potential-free, colour of wire: orange) in the wiring cabinet to connect the extraction system to the machine control

⇒ Extraction system switches on automatically whenever saw is started

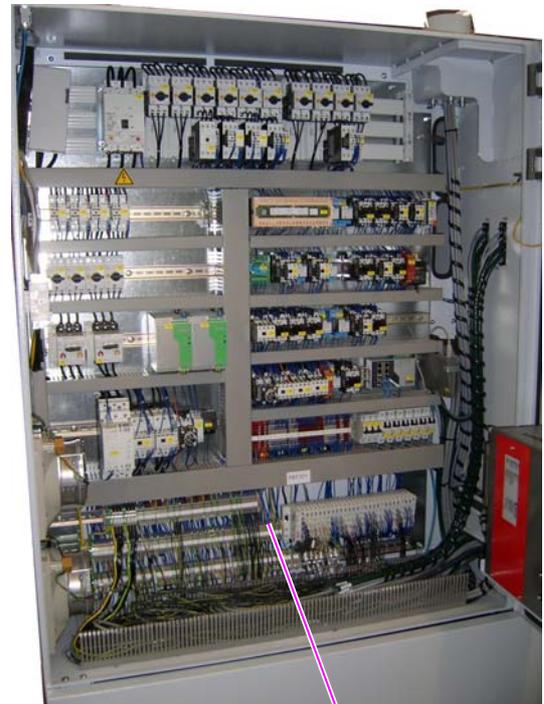
→ See **Wiring diagram**



**Caution:**

- All extraction pipes must be earthed to avoid electrostatic charge
- Extraction tubes must be of **non-combustible** material
- Flexible plastic hoses must be of flame-resistant material conforming to **DIN 4102-B1**

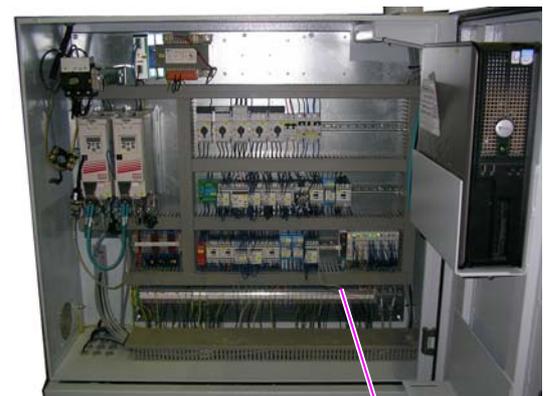
→ **Risk of fire!**



1

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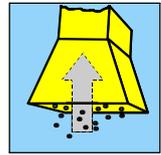
1 Terminals



2

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2 Terminals (series 250)



## 2 Operation



**Caution:**  
Extraction system must always be running when saw is in operation!