

It is a highly efficient automatic hydraulically controlled band-saw with multiple material feed.

The machine is designed for vertical cuts.

It is suitable for serial production in industrial premises. Thanks to its robust construction enables to cut wide range of materials including stainless steels and tool steels both profiles and full materials.

#### **Control system:**

- Machine is equipped with an electronic system SIEMENS. It uses touch display and PLC, which enable communication with operator. A control system of machine possibilities of automatic regulation of the cutting feed rate , electronic setting of upper and down position of the Arm. A control system of machine displays a working states as blade speed, cutting feed and a state of single working movements. A part of a system are also inputs and outputs for connection of an above-standard accessories.
- The machine enables to work with two modes:
- SEMIAUTOMATIC CYCLE: The machine cuts the material immediately in a semiautomatic mode. The operator uses the feeder of the machine for the manipulation with the material and for the exact feed of the material into the cutting zone. The movement of the feeder is realized by manual buttons or by GTO function. After starting GTO function the operator sets the position of the feeder, presses START button and feeder goes to the set position.
- AUTOMATIC CYCLE: the feeder feeds the material according to the set programm. The operator sets the cutting programm, machine realizes these programmes, it is possible to make 99 different programmes. The part of one programme is a complete setting of the cut: blade speed, feed speed, setting of an automatic regulation, setting of the height of the bar to be cut, setting of the length of the bar and number of pieces. The length and number of pieces it is possible to set in 99 lines, the machine feeds differently set lengths automatically.
- Cutting feed rate is regulated by hydraulic throttle valve leaded by servomotor enabling very precise feed rate. The operator sets in the program needed feed rate (mm/min) and the machine will set it up. In this way there are no external factors influencing cutting feed like temperature (viscosity) of hydraulic oil. Two basic regimes of automatic system regulation (ASR): ARP a RZP.
- RZP= System allows to set the optimal cutting feed rate depending on material band position. Cutting feed rate is regulated on beginning and end of cut. It is suitable for using of carbide blades.
- ARP = System of the automatic regulation of the cutting feed rate depending on the cutting resistance of the material or blunting the blade.
- Systém offers two basic modes of ARP: BIMETAL and CARBIDE.
- BIMETAL mode is suitable for optimization of the cutting feed when cutting profiles by bimetal blades. The cutting feed is higher if the blade cuts sides of the profile. As the blade reaches the full material, the system reduces the cutting feed automatically so that teeth gap of the blade would not be filled.
- CARBIDE mode is suitable for cutting of full bars. If the blade is excessively loaded is the cutting feed reduced on 50 % and cut is finished by this speed.
- Externally situated controlling panel - its position does not depend on the position of turntable position during angular cuts. There is equipped with a safety button, which stops the saw. There is also a feed regulator and buttons which controls the various available movements.
- Safety module with autodiagnosis.

#### **Construction:**

- The machine is constructionally designed in that way, so that it corresponds to extreme exertions in productive conditions. Massive construction enables using of carbide blades comfortably.
- The arm of machine with columns situated as near the clamping vice as possible minimizes vibrations and enables max. cutting performance.
- The arm of the machine is robust, heavy weldment and it is designed so that a toughness and a precision of cut was ensured.
- The arm moves along two columns using a four row linear leading with a high loading capacity. Arm movement using two hydraulic cylinders.
- The robust steel pulleys sloped of 25 degrees regarding the level of the cut. Thanks to sloped arm the twist of the blade is eliminated and there is possibility to bring the blade closer to the minimal distance from the linear leading on columns. This arrangement eliminates vibrations and enables the max. cutting performance of the machine.
- Upper position automatically using Pegas DPP system (touching lathe placed closely below tooth of blade: T-bar, linear leading, microswitch, adjusting screw) or using of incremental sensor for measuring of a position above material. Upper cutting position of frame is detected automatically using control system after setting of the size parameters of cutted material.
- Down position using adjusting stop and microswitch. After reaching of bottom position arm goes to upper position automatically.
- Main vice with divided jaw that clamps the material in front of as well as behind the cut. The jaws allow a safe grip. The optimization of the chip movement through the fixed jaw directly to the chip extractor.
- Jaws of the main vice move on two rails of linear leading using hydraulic cylinder. One jaw is longstroke (the movement by longstroke hydraulic cylinder), one is fixed.
- Regulation valves for setting a vice pressure in hydraulic system.
- Very rigid feeder with the feeding step 500 mm moves on four rails of the linear leading by hydraulic cylinders.
- There are two speeds of the feeder (micro feed when approaching the position). Periodic mode (feeder moves between zero position and the position of the set length of feed) or consecutive mode (feeder moves to the limit position, clamps the material and feed it to the cut consecutively).
- Incrementally straight sensor for indication of the position of the feeder and GTO (go to position) function.
- Indication of material in the feeder: optic sensor - it notices that there is a material in the feeder. If there is no material in

the feeder, the signal reflects on the glass that is situated on movable jaw and it goes back to the sensor. The machine stops feeding and waits for another bar.

- There is a roller conveyer which supports material in whole feeded lenght.
- The feeder clamping vice is a robust steel weldment. Jaws ensure safe clamping of the material.
- Jaws of the feeding vice move along two-rails linear using hydric cylinder. One jaw is long stroke (the movement by longstroke hydraulic cylinder). Second jaw is short stroke (utilization during bar feeding: not jaw wearing out, not slipping of material). Short stroke jaw is suitable for feeding of deformed material.
- Cutting zone is opened from side of the feeder device automatically, extends the blade lifetime when arm is moving to top position.

#### **Basic equipment of machine:**

- The blade leading in guides with hardmetal plates and leading bearings and along cast iron pulleys.
- There is a guide situated on the firm beam on the drive side. On the tightening side there is the guide situated on the moving beam.
- The guide beams of the blade are adjustable in the whole working range. A giude moving is connected with a vice-jaw movement so that to achieve the minimum distance of the guide and material. That is why it is not neccessary to set the position manually.
- The guide beam of the blade is placed in linear rails (2 linear rails and 4 bearings) with high bearing capacity.
- The saw-band is equipped with a guard, which protects the operator from millings and cutting emulsion.
- Machine has hydraulic band tightening.
- Automatic indication of blade tension.
- A cleaning brush is driven by an electroengine and ensures perfect cleaning of a blade.
- There is a planet gear box drive and a three-phase electroengine, a fluent regulation of a circumferential blade speed by a frequency converter for a fluent change of blade speed. CAUTION: Drive with planet gearbox corresponds with drive with worm gearbox and engine of approx. double multiple power.
- The cooling system for emulsion, leaded to the guides of the blade and by LocLine system directly to the cut groove.
- Massive base with a tank for chips and with chip extractors. Base is designed for manipulation manipulation with machine by pallet truck and also by any hight lift truck.
- Indication of blade tightening and opening of the cover.
- Controlling 24 V.
- Machine is equipped with hydraulic system which controles all functions of that maschine. It pushes the arm to cut, pulls up the arm, opens and closes vices, moving of feeder.

#### **Basic accessories of machine:**

- Chip extractor
- Lighting of workink space.
- Band saw blade.
- Set of spanners for common service.
- Manual instructions in eletronic form (CD).

#### **Operating cycle:**

After starting the machine, vices clamp after starting the machine, the machine makes the cut by a set speed, the cutting zone in the down position of the arm is released - the longstroke jaw of the firm vice open, the feeder moves the material to the firm vice, the arm lifts up to the set upper position. The material is moved by the feeder – periodic regime (feeder moves between zero position and the position of the set lenght of feed) or consecutive regime (feeder moves to the limit position and clamps the material and feed it to the cut consecutively). The main vice clamps the material, the vice of the feeder is still closed and the whole procedure repeats. The operator only loads the material and removes the cut material. It is possible to regulate the cutting speed of the arm and the blade speed during cutting.

**cutting parameters**

	D [mm]	D [mm]	axb [mm]	axb [mm]
	400	400*	400x400	400x400
	x	x	400x250	400x250

\*recommended values

The shortest cutting	mm	10
The smallest divisible diameter	mm	85
The shortest rest during one cut	mm	50
If the saw is equipped with ABP* (option), necessary minimum of cut material is:	mm	100
The shortest rest in automatic cycle	mm	110
Minimum of cut material in automatic mode, if the saw is equipped with option: upper vice placed on main vice and ABP* system together:	mm	300
One feed step of the material Min	mm	3
One feed step of the material max	mm	550
If the saw is equipped with (option): upper vice placed on main vice and ABP* system together, maximal feeding is reduced:	mm	425
Multiple feed	mm	9999

\* ABP = automatic, contactless setting of working

**Performance parameters**

drive of the blade	kW	4,0
drive of the hydraulic aggregate	kW	1,5
pump of the cooling emulsion	kW	0,12
electroengine of the cleaning of the blade	kW	0,12
electroengine of the drive of the worm chip extractor	W	
total input	kW	12,8
cutting speed – fluently set	m/min	20-100
diameter of the blade	mm	5580x41x1,3
electric connection		3x400V, 50 Hz

**Control**

feed of the frame to the cut	hydraulically
feed of the material	manually
clamping of material	hydraulically
bend tension	hydraulically
cleaning of the blade	A cleaning brush is driven by an electroengine

**Parameters**

length	width	Height		height of the table	weight	
[L]	[B]	[Hmax]	[Hmin]	[V]	(kg)	
2970	2600	2080	2100	775	2740	