

From MAY 1, 2017 adjusted:

- Location of the control panel on a flexible console.
- Digital display rotation angles standard
- Digital display of the height position of the frame in %
- Vice is equipped with a hydraulic cylinder fully open. This eliminates the need to handle loop

Semiautomatic machine with hydraulic manipulation.

The machine is designed for cutting of material in vertical and angle cuts, angle cuts are possible to set fluently from 0 to 60 grades to the right and from 0 to 60 grades to the left. Change of angle using quick clamping handle.

It is suitable for piece production and small series production. Thanks to its robust construction it enables cutting of wide range of profiles and full materials.

Control system:

- The Controller with PLC MITSUBISHI and features an automatic feed control BRP.
- Control panel MITSUBISHI as standard equipment. It uses touch display and PLC, which enable semi-automatic cutting (basic setting included) as well as communication with operator.
- Controller show lot of information about cutting process on the display: Cutting cycle indication, indication BRP, indication, blade tightening, time of the cut, loading of blade in amperes, speed of the blade, cutting times measuring, list of error messages.
- User's setting: autostop of hydraulic unit, mode of arm moving after end of the cut, mode fast moving of the arm, mode time lag of shift speed, mode blade moving, mode jaw moving after cutting cycle finish, diagnostic of inputs and outputs.
- STOP function – cutting : it enables to stop cutting by pressing STOP button at any time. The Frame goes up with the running blade without opening the vice.
- **Regulation of cutting speed** (moving to cut) is manual and uses throttle valve placed beside control panel. Automatic (safety) regulation of shift speed PEGAS BRP. Principle: Machine will stop after exceeding set loading (defined in amperes).
- 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.

Construction:

- The machine is constructionally designed in that way, so that it corresponds to extreme exertions in productive conditions.
- The arm of the machine is robust, heavy weldment and it is designed so that a toughness and a precision of cut was ensured.
- Drive pulley and tighten pulley are both metal castings.
- **The upper arm position is handling by the button on control panel. Digital display of upper position in %.**
- The down working position of the arm controlled by the microswitch. In the end position microswitch is on, arm goes to selected upper position.
- The vice is welded. The jaw is made from cast iron. Jaw ensures the safe clamping of the material.
- The hydraulically operating vice with long travel is placed in an adjustable dovetail groove.
- Moving jaw of the vice is handled by long stroke hydraulic cylinder.
- Basic part of the vice moves according to the direction of the angle cut setting, fixation is made by the handle.
- Turn table is cast iron. Turn table situated on cone roller bearings.
- Manual turning of the table for angle cuts, the position of the turntable is fixed by the lever with the excenter. The position of the turntable for vertical cutting is arrested automatically by the spring mechanism.
- The angles indicated on the digital display on the control panel MITSUBISHI. Reading of angle by incremental sensor and magnetic tape.

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 moving band guide is adjustable.** Manual adjustment and fixing of the guide beams.
- Guide holder moves in adjustable dovetail roof.
- The saw-band is equipped with a guard, which protects the operator from millings and cutting emulsion.
- Mechanic tightening of the blade.
- Automatic indication of blade tension.
- **Cleaning brush for perfect cleaning and function of blade, driven by puller**
- Drive of machine is solved by worm gear box with maintenanceless oil filling. Three-phases electromotor with double winding, with a frequency converter for a fluent regulation of the blade speed from 20 to 100 m/min. Sturdy flange with shaft. Termoprotection of engine.
- The cooling system distributes cutting emulsion to the band guides.
- Massive base with a tank for chips. Base is designed for manipulation with machine by pallet truck and also by any high lift truck.
- Indication of blade tightening and opening of the cover.
- Controlling 24 V.
- Maschine is equipped with hydraulic system which controls all functions of that machine. It pushes the arm to cut, pulls up the arm and opens and closes vices.











Basic accessories of machine:

- Band saw blade.
- Set of spanners for common service.
- Manual instructions in electronic form (CD).

Operating cycle:

After manual adjustment of the jaws the operator starts the cycle with a switch on the control panel. The hydraulic cylinder of the vice grips the material and the saw starts working. The cutting speed of the arm is controlled by a throttle valve. Arm and vice movements after cut finish following set user parameter. The vice opens and the operator can handle the material.

Cutting parameters

|  | |  0° |  45° |  60° |  45° |  60° |  ^b / _a | |
|---|----------|--|---|---|---|---|---|---------------------|
|  | D [mm] | 360 | 360 | 300 | 360 | 300 | X | |
|  | D [mm] | 250* | 180* | 130* | 180* | 130* | X | |
|  | axb [mm] | 500x360 | 440x240 | 290x280 | 400x290 | 300x170 | 500x220 | *recommended values |

Performance parameters

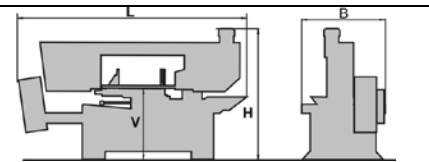
| | | |
|---------------------------------|-------|---------------------|
| drive of the blade | kW | 3,0 |
| drive of the hydraulic agregate | kW | 0,05 |
| pump of the cooling emulsion | kW | 0,44 |
| total input | kW | 7,7 |
| cutting speed – fluently set | m/min | 20-100 |
| diameter of the blade | mm | 4780x34x1,1 |
| electric connection | | 3x400v, 50 Hz, TN-S |

Control

| | |
|------------------------------|-----------------------------------|
| feed of the Frame to the cut | hydraulically |
| feed of the material | manually |
| clamping of material | hydraulically |
| bend tension | manually |
| cleaning of the blade | cleaning brush driven by a pulley |

Parameters

| length | width | Height | | height of the table | weight |
|--------|-------|--------|--------|---------------------|--------|
| [L] | [B] | [Hmax] | [Hmin] | [V] | (kg) |
| 2873 | 1080 | 2360 | 1420 | 812 | 715 |



Corrected: Pevná Markéta 24.3.2017