

Changes: 230x280 A-CNC-R

2.8.2018 – change of parameter – weight 780 Kg

230x280 A-CNC-R (version 1)

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

The machine is designed for vertical and angular cuts. Angles setting (turning of the bow) manually:

- fluently between 0° and +45° right in automatic mode
- fluently between 0° and +60° right in semi-automatic mode

It is suitable for serial production and 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 the control, programmable PLC MITSUBISHI FX5U.
- Blade drive as well as the feeder movements are fully controlled by the frequency inverters MITSUBISHI.
- The coloured touch screen MITSUBISHI GT 2104 enables easy communication with an operator. It shows working conditions (blade speed, moving to the cut, cutting parameters etc.)
- The length and quantity are set by the control panel. Machine will optimize all next calculations itself. It is possible to set 15 different programs for quick lengths setting.
- Type of material feed: Normal or INCREMENTAL
- Machine enables semi-automatic and automatic mode (all movements are controlled automatically).
- Regulation of shaft 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).
- The ergonomical control panel is mounted on the movable console. The control panel is equipped with mechanical buttons and digital display of the machine control system. Mechanical buttons control basic saw movements (arm, vice, feeder) and cutting cycle start. The safety button is present on the panel as well. All buttons are highly resistant in anti-vandal version.

Construction:

- The machine is constructionally designed in that way, so that it corresponds to standard exertions in productive conditions.
- The arm of the machine is made of cast iron and it is designed to ensure the power and the precision of the cut. Arm is 25 grades sloped, it increases the lifetime of blade.
- The arm rotated by a shaft (joint) which is supported by adjustable conical bearings
- Drive pulley and tighten pulley are both metal castings.
- Upper working arm position controlled by automatic stopper (DPP)
- The down working position of the arm controlled by the microswitch. After reaching bottom working position the arm stops in the position set in the system.
- The vice is welded. 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.
- Very massive feeder moves using hydraulic cylinder and two sharpened bars and teflon cases.
- There is a floating seating of the feeding vice in the feeder, it means that the feeding vice moves in perpendicular sense regarding the feeding sense. The stationary jaw of the feeding vice copies the possible roughness of feeded material and the wearing out of mechanical parts of the feeder is eliminated.
- The feeder moves the material to be cut to the main vice according to the set length that was adjusted by the operator in the controlling panel. The position of the feeder is indicated by electromagnetic sensor and measuring magnetic tape. For a perfect placing of a feeder, feeder moves to end positions by a slow velocity.
- 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.
- The vice is made from cast iron. Jaws ensure safe clamping of the material.
- Hydraulically controlled vice of the feeder. Moving jaw of the vice is placed in adjustable dovetail groove and is handled by long stroke hydraulic cylinder in whole range.
- Turn table is cast iron.
- Manual turning of the table for angle cuts, the position of the turntable is fixed by the lever with the excenter.
- Angles (degrees) are shown at the touch screen MITSUBISHI. Angle indication using incremental sensor and a 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 groove.
- 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.











- 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.
- Machine is equipped with hydraulic system which controls all functions of that machine. It pushes the arm to cut, pulls up the arm, opens and closes vices, moving of feeder.

Basic accessories of machine:

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

Operating cycle:

The machine automatically grips the material in the main vice and the feeder moves into a position determined by the processor (i.e. the required length of the cut and a constant added length); the feeder-vice's jaw stays open. The arm moves into the cut; after cutting the material, it moves into the upper position. The feeder moves by the constant added length (exactly to a position determined by the processor) and the feeder jaw grips the material. The vice is released; the feeder moves the material into the zero position (by the required length). The main vice grips, the feeder-vice is released and the entire cycle is repeated. The operator only removes the sawn material.

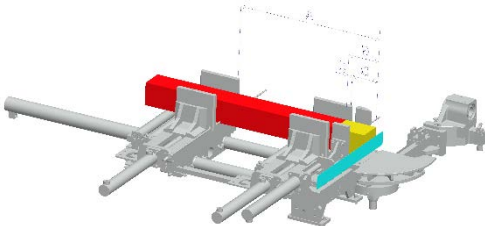
Cutting parameters							
							
	D [mm]	230	180	100	X	X	X
	D [mm]	150*	110*	80*	X	X	X
	axb [mm]	280x210	180x150	100x70	X	X	280x130

* Recommended values. Recommendations of band blade producers are to be followed when choosing to cut full material, their dimensions are limited by available size of the teeth for the specific type of the band.

° Cutting of the bundle without upper vice HP. HP = accessory for additional price. The cutting parameters are limited when using.



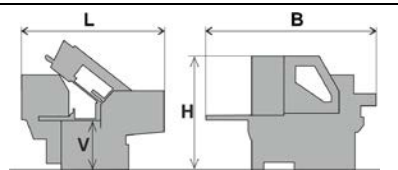
ATTENTION: automatic cutting cycle: only for 90 degree (0 degree) and 45 degree. Semiautomatic cutting cycle (without material feeding into the cut and feeder device in a very left position): for angle cutting to the right 60 degrees.

	A: One feed step of the material max	500	mm
	A: One feed step of the material Min	3	mm
	A: Multiple feed	9999	mm
	B: The shortest rest in automatic cycle (c+d)	120+20*	mm
	The smallest divisible diameter	5	mm
	The smallest divisible diameter in automatic cycle	15	mm

* d = recommended value. The customer may change the value depending the weight or grade of the material.

performance parameters		
drive of the blade	kW	1,5
drive of the hydraulic agregate	kW	0,85
pump of the cooling emulsion	kW	0,09
electroengine of the drive of the worm chip extractor-accessories	kW	0,12
installed power of the machine Pi	kW	2,35
electric input of the machine Ps	kW	3,84
cutting speed – fluently set	m/min	20-100
diameter of the blade	mm	2720x27x0,9
electric connection		3x400V, 50 Hz, TN-S

control	
Feed of the Frame to the cut	Hydraulically
Feed of the material	Hydraulically
Clamping of material	Hydraulically
Angle turning	Manually
Angle turning fixation	Manually
Bend tension	Manually
Cleaning of the blade	Passive cleaning brush

Parameters						
Lenght	Width	Height		Height of the table	Weight	
[L]	[B]	[Hmin]	[Hmax]	[V]	(kg)	
2305	2260	1405	1780	800	780	