

ALO 181

Setting machine for band saw blades



CAPACITY:	
Band widths:	6 - 50 mm
Band thickness:	Up to 1.6 mm
Overall setting accuracy:	±0.02 mm
Symmetry accuracy:	±0.02 mm
Max. group length:	75 mm
Tooth pitch:	¼ - 32 tpi

ALO 181 are available in three different models:

- ALO 181-50-C For ALO 185 set gauge with free standing coilers
- ALO 181-50-D For ALO 185 set gauge without coilers
- ALO 181-50-E For ALO 185 set gauge with free standing electrical coilers

OPTIONS / ACCESSORIES:



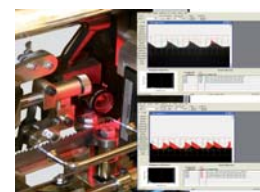
ALO 104 CUBE
Coil handling system



ALO 822
Double coiler



ALO 185-011
Auto symmetry control



ALO 181-Vision
Position control system



ALO 81-60
Set gauge



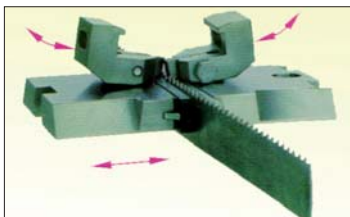
ALO 61201
Grinding fixture



The feeding device does not come in contact with the tooth tip. The feeding pin is made of hard metal and interchangeable to match different tooth forms.



Setting tools are available in a wide range of sizes and models, standard or customer specified.



Picture showing clamping jaws and setting tools movement during setting.

MACHINE DESCRIPTION

Setting unit

The ALO 181 can set all forms and groups of teeth, such as raker, alter, wavy or vary pitch with a repeated pattern of 75 mm or less. The machine is universal and easy to adjust for different band dimensions, strokes and tooth forms.

All wear surfaces are made of hard metal or coated with hard chrome. The clutch and gearbox are immersed in oil. The band saw blade are guided through a guide system and clamped by a pair of mechanically timed clamping jaws during the setting sequence, assuring a consistent setting result. The oscillary motion of the setting tools together with the angled setting dies gives a minimal tooth deformation. The setting speed is adjustable by means of a potentiometer.

Setting tools

Setting tools for $\frac{3}{4}$ - 32 tpi available as standard tools. Tools for group setting or vary pitch are custom made after specification. The hard metal dies can easily be replaced.

Payoff / takeup coilers

The coilers are driven by a pneumatic motor with regulator and valve, thus the speed and torque are infinitely variable. The speed and band tension are automatically regulated by means of a pneumatic valve mechanism. The coilers may be driven clockwise or counter clockwise and are equipped with collapsible centre for easy loading and unloading.

TECHNICAL SPECIFICATION:

Band width:	6 - 50 mm
Band thickness:	Up to 1.6 mm
Overall setting accuracy:	± 0.02 mm
Symmetry accuracy:	± 0.02 mm
Tooth pitch:	$\frac{3}{4}$ - 32 tpi
Max. group length:	75 mm
Weight:	430 Kg
Air pressure:	6.3 bar 91 psi
Voltage:	400VAC $\pm 10\%$ 3-phase, 50-60 Hz $\pm 1\%$ directly earthed system
Power consumption (at max output power):	0.44 kVA
Space requirement (l x w x h):	3.1 x 1.7 x 1.45 m

REMARKS:

ALO 181 can set all forms of groups and teeth with a repeated pattern of 75 mm

Max. VIP setting / band thickness:	1.1 mm	2/3, 3/4, 4/6 VIP
	0.9 mm	2/3, 3/4, 4/6, 6/8 VIP
	0.65 mm	2/3, 3/4, 4/6, 6/8, 6/10, 8/12, 10/14 VIP

Band width between 6-10 mm requires a narrow band kit, part number 8149-A, 8149-B or 8149-C.