

ALO 183

Setting machine for band saw blades



CAPACITY:

Band widths:	20 - 100 mm
Band thickness:	Up to 2.54 mm
Overall setting accuracy:	±0.02 mm
Symmetry accuracy:	±0.02 mm
Max. stroke length:	125 mm
Tooth pitch:	3/4 - 32 tpi

ALO 183 are available in two different models:

- ALO 183-100-C For ALO 185 set gauge with free standing coilers
- ALO 183-100-D For ALO 185 set gauge without coilers
- ALO 183-100-E For ALO 185 set gauge with free standing electrical coilers

OPTIONS / ACCESSORIES:



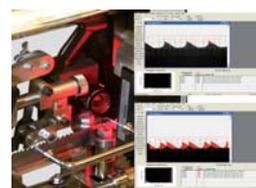
ALO 104 CUBE
Coil handling system



ALO 822
Double coiler



ALO 185-012
Auto symmetry control



ALO 183-Vision
Position control system

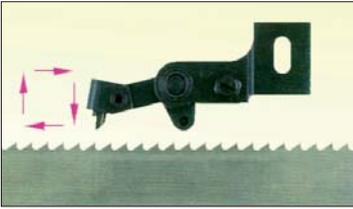


ALO 83-60
Set gauge



ALO 61201
Grinding fixture

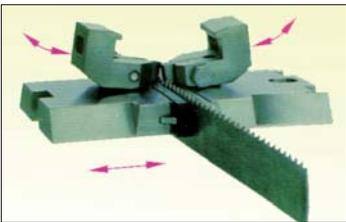




The feeding device does not come in contact with the tooth tip. The feeding pin is of hard metal and interchangeable to match different tooth forms.



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 183 can set all forms and groups of teeth, such as raker, alter, wavy or vary pitch with a repeated pattern of 125 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 gear box 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 teeth 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:	20 - 100 mm	See remarks
Band thickness:	Up to 2.54 mm	
Overall setting accuracy:	± 0.02 mm	
Symmetry accuracy:	± 0.02 mm	
Tooth pitch:	$\frac{3}{4}$ - 32 tpi	
Max. stroke length:	125 mm	See remarks
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):	0.5 kVA	
Space requirement (l x w x h):	3.6 x 1.7 x 1.45 m	

REMARKS:

ALO 183 can set all forms of groups and teeth with a repeated pattern of 125mm

Max. VIP setting / band thickness:	2.5 mm	2/3, 3/4, 4/6 VIP
	1.8 mm	2/3, 3/4, 4/6, 6/8 VIP
	1.1 mm	2/3, 3/4, 4/6, 6/8, 6/10, 8/12, 10/14 VIP

