

ALO 191-MS1

Induction tooth hardening, mechanical straightening of bandsaw blades



Pictures shows ALO 191-MST1 with extra tempering generator

THE SYSTEM COMPRISES:	CAPACITY:
Feed unit	Band width 6 - 38 mm (other widths on request)
Hardening generator and inductor	Band thickness 0.4 - 1.4mm
Mechanical straightening unit	Tooth pitch 0,5 - 6 tpi
Closed coolant system	Hardening generator frequency 3 MHz

- High efficiency and low energy consumption generators with air-cooled oscillator tubes.
- Band feeder with a pulling 4-wheel drive system designed for accurate speed and guiding.
- Electromagnetic brake for optimal control of band tension.
- High reproducibility due to parameters are saved for individual products and easy to recall
- Fast and easy start up and change over.

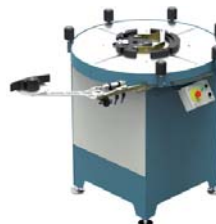
OPTIONS / ACCESSORIES:



ALO 90915/16/17/18
Collapsible coil center



ALO 831
Double coiler



ALO 880
Electric coiler



ALO 106 CUBE
Coil handling system



Tooth hardening inductor with air quench

MACHINE DESCRIPTION

Band feeder

The band feeder consists of two units, one 4-wheel feed unit, the other as an adjustable brake to control the band tension by using an electro magnetic friction brake. Both units are equipped with two pairs of inclined rolls. The four rolls on the feed unit are driven by a servomotor, and the speed is controlled by a servo controller. The oscillating circuit with the inductor are located between the brake and the feed units such that the band is pulled through the inductor at a controlled tension

Generator

The hardening generator are enclosed in a separate aluminium cabinet, equipped with separate oscillating circuit connected to the cabinet via coaxial cable. The generator are air cooled, thus limiting the cooling water requirements to inductor and oscillating circuit only. The generator is equipped with a chopper for infinitely variable control of the output power.

Inductors

The inductors are made of copper tubing and can be custom made for different pitches and band gauges. They are adjustable in height for different blade widths and sideways for different blade gauges. The inductors are interchangeable and can easily be replaced.

Straightening device

The straightening device consists of a pair of rolls situated between the hardening and tempering inductors. The rolls are driven and are mechanically adjustable in height for different band widths. The straightening force is mechanically controlled by a fine threaded screw system

TECHNICAL SPECIFICATION:

Band width:	6 - 38 mm	(other widths on request)
Band thickness:	0.4 - 1.4 mm	
Tooth pitch:	0,5 - 6 tpi	
Capacity:	5 - 15 m/min	
Air pressure:	6.3 bar	91 psi
Standard voltage:	400VAC $\pm 10\%$ 3-phase, 50-60 Hz $\pm 1\%$ directly earthed system (other voltages available upon request)	
Power consumption (at max output power):	20 kVA	

ALO 191-MS1 is also available with a inline tempering generator ALO 191-MST1

Other customer requirements may be discussed between customer and ALO.

