

ALO 193

Tooth hardening and tempering of bow saw blades



THE SYSTEM COMPRISES:

Pay off coiler
Hardening generator
Tempering generator
Hardening and tempering inductors
Closed cooling system
Band feeder
Quench system
Take up coiler

CAPACITY:

Band Width: 10 - 25 mm
Band thickness: 0.4 - 1.3 mm
Tooth pitch: Acc. to spec.
Capacity: 5 - 25 m/min

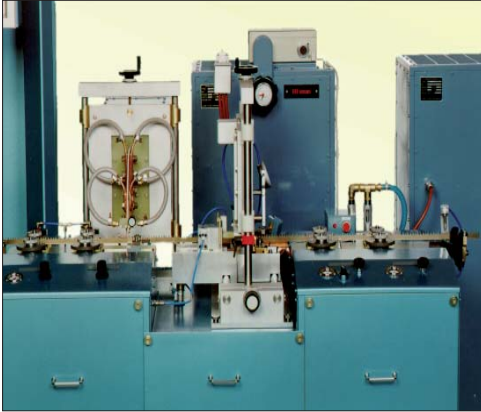
OPTIONS / ACCESSORIES:



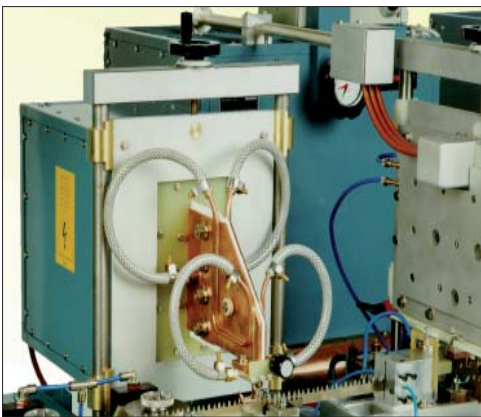
ALO 822
Double coiler



ALO 106 CUBE
Coil handling system



Feed unit with hardening and tempering unit



Tempering circuit

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 circuits with the inductors are located between the brake and the feed units such that the band is pulled through the inductors at a controlled tension.

Generators

The hardening and tempering generators are enclosed in separate aluminium cabinets, equipped with separate oscillating circuits connected to the cabinets via coaxial cables. The generators are air cooled, thus limiting the cooling water requirements to inductors and oscillating circuit only.

The hardening generator is equipped with an automatic anode current regulator, thus ensuring a stable power during the hardening operation. The tempering generator is equipped with a chopper for infinitely variable control of the output power.

Inductors

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

TECHNICAL SPECIFICATION:

Band width:	10 - 25 mm
Band thickness:	0.4 - 1.3 mm
Tooth pitch:	Acc. to spec.
Capacity:	5 -25 m/min
Coiler ID:	300 - 315 mm
Coiler OD:	820 mm
Max coil weight:	300 kg
Air pressure:	6.3 bar
Voltage:	220 - 480 VAC, 3-phase, 50 - 60 Hz direct earthed system
Space requirement (l x w x h):	4 x 2 x 2m
Power consumption (at max output power):	20 kVA

Other customer requirements may be discussed between customer and ALO.