

ALO 390

Induction tooth hardening and tempering for bow saw blades



CAPACITY:

Band width: 19 - 25 mm

Band thickness: 0.4 - 1.3 mm

Hardening generator frequency is: 27 MHz.

Tempering generator frequency is: 1.5 MHz.

THE SYSTEM COMPRISES:

Hardening generator

Tempering generator

Hardening and tempering inductors

Blade feeder

Closed coolant system

Collector magazine

The combination of high production rate, easy handling, low power consumption and an automatic active control system leads to high quality and low production costs.

OPTIONS / ACCESSORIES:



ALO 822
Double coiler



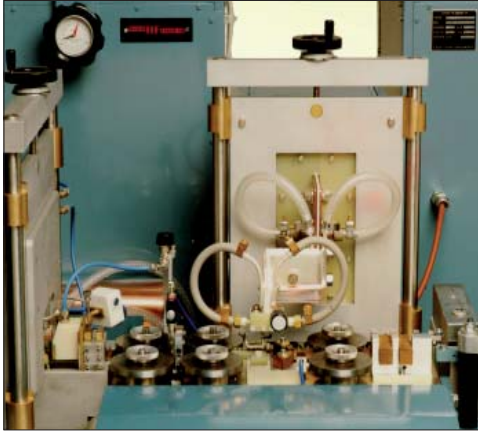
ALO 831
Double coiler



ALO 880
Electrical coiler



ALO 106 CUBE
Coil handling system



Hardening unit with flash guard and tempering unit



Collect magazine with inc-jet printer (option)

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:	19 - 25mm
Band thickness:	0.4 - 1.3mm
Min blade length:	320 mm
Capacity:	5 - 25 m/min
Magazine capacity:	500 blades
Air pressure:	6.3 bar
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

Other customer requirements may be discussed between customer and ALO.

