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Prepared: AP  
Approved: MS

ALO Center AB  
Industrivägen 10  
SE-792 32 Mora Sweden  
+46 250 94900  
info@alocenter.se  
www.alocenter.se



# ALO 487-MH

## ALO 487-MH

Setting and induction tooth hardening machine  
for hand saw blades



### CAPACITY:

Blade thickness: 0.5 - 1.6 mm  
Max blade length: 650 mm  
Max. group length: 150 mm

Tooth pitch: 4 - 12 tpi  
Setting tolerance:  $\pm 0.02$  mm  
Symmetry tolerance:  $\pm 0.02$  mm

### OPTIONS / ACCESSORIES:



ALO 81-60  
Set gauge



ALO 61201  
Grinding fixture



ALO 61207  
Grinding fixture





Sensor positioner and magnetic carrier



Laser sensor tooth positioner and setting unit



Hardening unit



Outfeed magazine

## MACHINE DESCRIPTION

ALO 487-MH is design for the hand saw blade market and can handle all known forms and groups of teeth with a repeated feed pattern up to 150mm.

The setting unit is easy to adjust mechanically, supported by an operator friendly HMI, making change over between different blades widths very easy.

The parallel clamping jaws are located on the front of the machine and are adjustable by two micrometers, equipped with a display showing the value.

All blades <150 mm length can be set in one set cycle.

150-650 mm blades requests two or more set cycles depending on the length of blade and setting tools. With custom made setting tools the machine can set all known tooth forms and setting patterns which are repeated within a length of 150 mm or less.

The generator is equipped with an automatic anode current regulator that will control the anode current, thus ensuring a stable power during hardening.

A flash guard unit monitors the hardening inductor area and automatically shuts down the machine if a flash-over are detected.

The inductor is made of copper tubing and can be custom made for different pitches and blade gauges.

The setting and hardening are integrated making the sequences fully automatic and all functions are controlled by a PLC.

## TECHNICAL SPECIFICATION:

Band thickness:	0.5 - 1.6 mm
Max. blade length:	650 mm
Max. group length:	150 mm
Tooth pitch:	4 - 12 tpi
Setting tolerance:	±0.02 mm
Symmetry tolerance:	±0.02 mm
Capacity:	6 blades / min at a blade length of 550 mm
Air pressure:	5 bar
Voltage:	400 VAC, ± 10%, 1-phase, 50-60 Hz ± 1%, directly earthed system
Space requirement (LxWxH):	3 x 3 x 2 m
Weight:	1 500 kg