

ALO 681

Setting machine for hand hacksaw blades



THE SYSTEM COMPRISES:

Setting unit
Feed magazine
Collector magazine

CAPACITY:

Blade length: 250 - 315 mm
Blade width: 10 - 25 mm
Blade thickness: 0 - 1.5 mm
Tooth pitch: 2 - 32 tpi
Setting tolerance: ± 0.02 mm
Symmetry tolerance: ± 0.02 mm
Capacity: 20 - 30 blades / min

OPTIONS / ACCESSORIES:



ALO 81-60
Set gauge



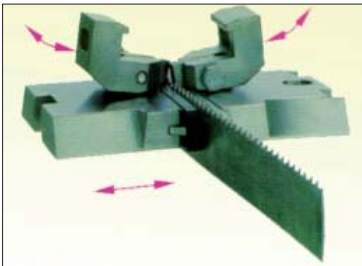
ALO 61201
Grinding fixture



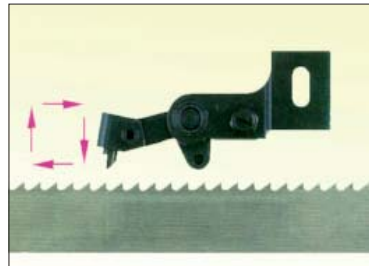
Feed magazine will separate and feed one blade at a time to the setting unit.



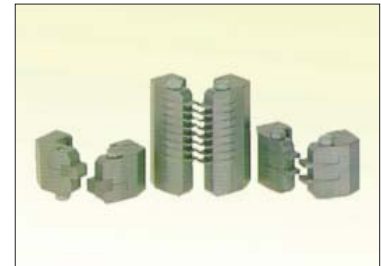
Feed and screw collector magazine will stack up to 700 blades.



The oscillary motion of and angle on the setting tools result in minimal damage on the sawblade teeth. The clamping jaws hold the blade firmly during the setting operation.



Due to self lifting system the feed pawl will not damage the tooth tip during the return stroke.



Standard setting tools for 3/4 - 32 regular tpi. as well as custom made vary pitch tools available.

MACHINE DESCRIPTION

This setting machine is fully automatic and all functions are controlled by a programmable controller. The in feed magazine, separates and feeds one blade at a time to the setting unit. The whole length of the blade may be set, or portions at each end may be left unset.

Setting symmetry and over all set is easy to adjust with micrometers. During the setting operation the blade is clamped by clamping jaws to make it possible for the oscillatory moving setting tools to set the teeth to perfection. Control panel allowing machine to be operated in manual, auto and step by step mode. The setting speed is variable by use of a thyristor control.

With custom made setting tools the machine will set all known tooth forms and setting patterns with a repeated pattern within a length of 75 mm or less.

After the setting operation the blade will be transported out to a screw collect magazine. Both infeed and collect magazine takes approx. 700 blades.

TECHNICAL SPECIFICATION:

Blade width:	10 - 25 mm
Blade thickness:	0 - 1.5 mm
Tooth pitch:*	2 - 32 tpi
Setting tolerance:	±0.02 mm
Symmetry tolerance:	±0.02 mm
Max. feed length:	80 mm. See remarks.
Capacity:	20 - 30 blades / min
Approx. magazines capacity:	700 blades.
Air pressure:	6.3 bar
Power consumption (normal):	0.5 kVA
Voltage:	230 VAC ±10 %, 1-phase, 50-60 Hz ±1%, directly earthed system
Weight:	400 kg
Space requirement (l x w x h):	1.8 x 1.3 x 1.45 m