

ALO 184-B

Setting machine with programmable feed unit and SGS camera system for band saw blades



The new generation ALO setting machine that together with the SGS camera system will help you to monitor and get in full control of the setting process and quality.

New features include programmable linear servo feed pawl unit which enables varying feed lengths and set patterns.

Adjustments such as setting height and the feed units pick-up and drop-off positions can be saved in the HMI making the set-up or change-over of the machine easy and quick for the operator.

Another novelty is pneumatical blade guide clamping which simplifies loading and unloading and ensures that bands are guided correct.

A completely new design of the machine head and clamping unit with very few and durable parts ensures high availability and higher set precision even on more demanding sizes and materials.

CAPACITY:

Band width:	12 - 67mm	Setting tolerance:	±0.01mm
Band thickness:	0.4 - 1.6mm	Symmetry tolerance:	±0.01mm
Tooth pitch:	0.5 - 32 tpi		

- Modular design, coilers and SGS camera system can be added as options
- A programmable feed pawl system give new possibilities, like variable feed lengths
- Straight and fixed band back position through the machine from coiler to coiler
- New enforced clamping system that also eliminates overclamping issues
- Automatic set symmetry adjustment

OPTIONS / ACCESSORIES:



ALO 61201
Grinding fixture



ALO 61207
Grinding fixture



ALO 83-60
Set gauge



ALO 880
Coiler



ALO 106 CUBE
Coil handling system





New programmable linear servo carry out the feeding of the blade.



Operator friendly HMI gives full control of the setting operation.



Completely new design of the machine for the setting demands of today and tomorrow.



With the SGS camera system you get in control of the setting result and quality

The new band saw setting machine 184-B can handle all known forms and groups of teeth with a repeated feed pattern of max 125mm. In addition, the machine with its new linear servo feed unit, can be set-up to alternate different stroke lengths, opening possibilities for never before seen group lengths and patterns.

The band is guided by pneumatically operated band guides to assure that the band is held in position and also facilitates loading and unloading of the bands. Bands are always oriented from the back, and the setting head are adjusted up or down with an electrical motor for different band widths, making changeover between widths very easy for the operator.

The clamping jaws is adjusted by two micrometres, if clamping pressure is adjusted to high, there is a safety feature that will give, before mechanical failure occurs. Minor adjustments of the clamping can be done while the machine is running.

The setting head can also be tilted to optimize the set result over long groups. Overall set are adjusted with micrometres.

In the operator friendly HMI all the set related values can be saved making change-over and set-up easy for the user. The automatic adjustment of set balance based on the SGS camera readings are carried out by an actuator during setting operation.

The feed pawls and setting tools are of the same standard as on previous ALO setting machines, on certain sizes of setting tools minor adjustments are needed before use in ALO 184.

A high resolution CCD line camera measures the set teeth and stops the machine if the set is out of the set-up tolerances. Information about the set as well as what caused the stop, will be shown on the computer monitor. The operator will also get advice how to adjust the machine to correct any faults in the setting result.

TECHNICAL SPECIFICATION:

Band width:	(12) 20-67mm (12mm by change of clamping jaws)
Band thickness:	0.4-1.6mm
Overall setting accuracy:	± 0.01mm
Symmetry accuracy:	± 0.01mm
Tooth pitch:	Up to 32 tpi
Max stroke length:	125mm
Weight:	810kg
Air pressure:	6.3bar
Standard voltage:	400VAC ±10% 3-phase, 50-60 Hz ±1% directly earthed system, other voltages available upon request.
Max power consumption:	3 kVA
Space requirement (l x w x h):	2x1.5x2m

