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ALO 283

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Setting machine for power hacksaw blades



THE SYSTEM COMPRISES:

Setting unit
Infeed magazine
Outfeed magazine

CAPACITY:

Band widths:	20 - 75 mm	¾ - 3"
Band thickness:	Up to 2.5 mm	Up to 0.1"
Overall setting accuracy:	±0.02 mm	±0.001"
Symmetry accuracy:	±0.02 mm	±0.001"
Max. group length:	80 mm	3.15"
Tooth pitch:	¼ - 32 tpi	





Picture showing infeed magazine



Picture showing collect magazine

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 / 3" or less. After the setting operation the blade will be transported out to a screw collect magazine.

Both infeed and collect magazine takes approx.200 blades.

OPTIONS:

ALO 283/186 Automatic set gauge.

A CCD camera for automatic set control can be built in line with the setter. The camera controls the set blades against custom set tolerance. Continuous information will be shown on the PC screen about the blades set within tolerance. If the set exceeds any of the set-up tolerances the machine stops and reason why is showed on the screen.

The set values are stored and/or can be printed out at any time by user request, or automatically after a predefined batch, or at an automatic out of tolerance stop. At system startup time an automatic self test of the set gauge computer and the camera is done.

The system also includes a speed and blade counter.

TECHNICAL SPECIFICATION:

Blade width:	20 - 75mm	0.8 - 3"
Blade thickness:	Up to 2.5mm	Up to 0.1"
Blade length:	270 - 510mm	10,5 - 20"
Tooth pitch:*	¾ - 32 tpi	
Setting tolerance:	±0.02 mm	±0.001"
Symmetry tolerance:	±0.02 mm	±0.001"
Max. feed length:	125 mm. See remarks.	5" See remarks.
Capacity:	20 - 30 blades / min	
Approx. magazines capacity:	200 blades.	
Air pressure:	6.3 bar	91 psi
Voltage:	230 VAC ±10 %, 1-phase, 50-60 Hz ±1%, directly earthed system	
Weight:	325 kg	715 lb

REMARKS:

ALO 283 can set all forms of groups and teeth with a repeated pattern of max 125 mm / 5"
 Max. VIP setting / band thickness: 1.1 mm / 0.043" 2/3, 3/4, 4/6, 6/8, 6/10, 8/12, 10/14 VIP
 1.8 mm / 0.072" 2/3, 3/4, 4/6, 6/8 VIP
 2.5 mm / 0.1" 2/3, 3/4, 4/6 VIP

