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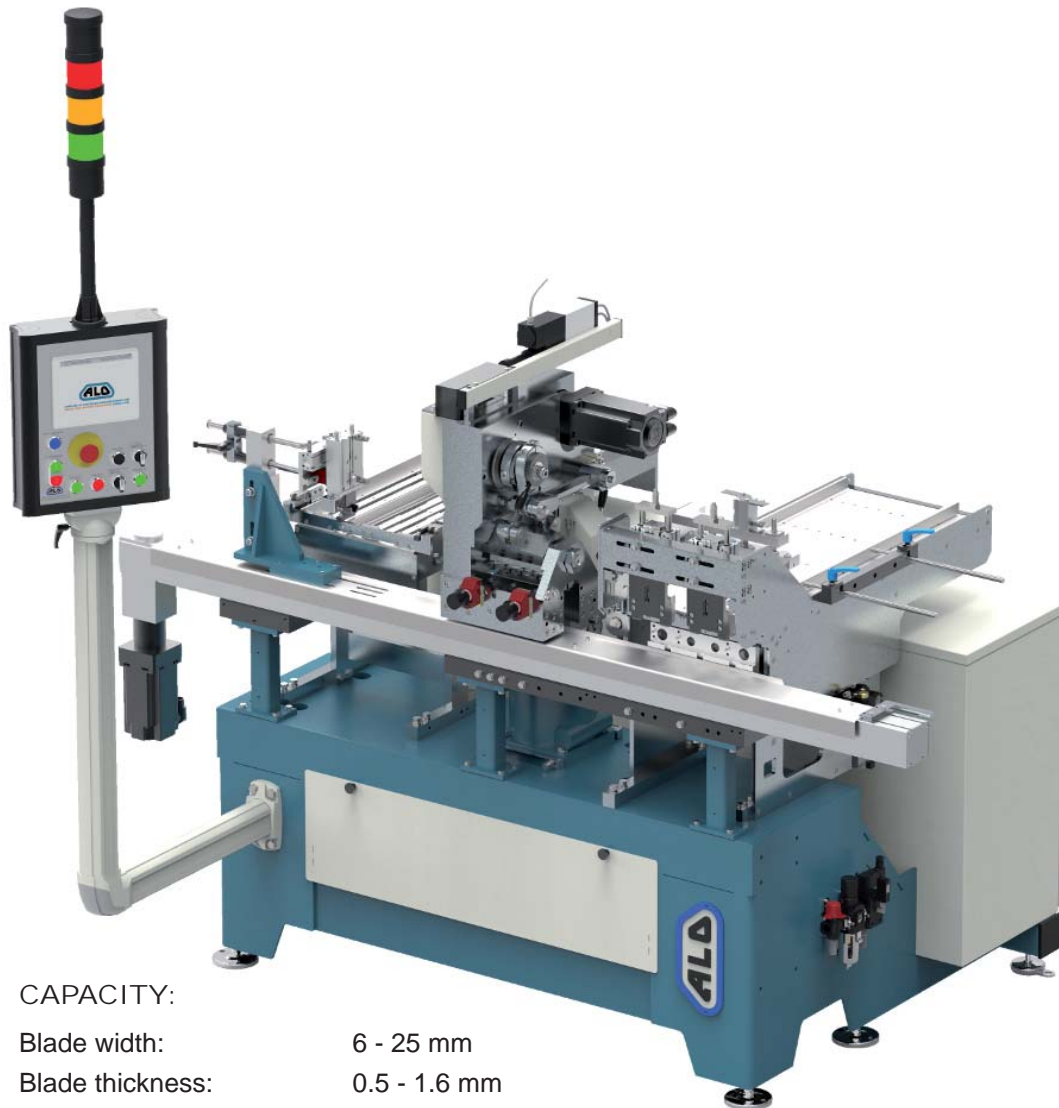


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ALO 787-M

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Automatic setting machine for jig and reciprocating saw blades



CAPACITY:

Blade width:	6 - 25 mm
Blade thickness:	0.5 - 1.6 mm
Blade length:	65 - 315 mm
Setting tolerance:	± 0.01 mm
Symmetry tolerance:	± 0.01 mm

OPTIONS / ACCESSORIES:



ALO 81-57
Table top set gauge



ALO 81-60
Set gauge



ALO 61201
Grinding fixture



ALO 61207
Grinding fixture





Infeed magazine ready to fill up the batch with a new blade package.



Outfeed magazine with pick and place unit.



Improved clamping together with digital micrometer makes clamping adjustments easier.

MACHINE DESCRIPTION

The setting machine is fully automatic and all functions are controlled by a programmable controller. The feeding magazine, for approx. 700 blades, separates and feeds one blade at the time into the blade carrier that is mounted on a linear feeder. The feeder transports the blade to position for setting and to unload position. A blade pick unit takes the set blade from the carrier and drops it into the out-magazine.

The whole length of a 150 mm (6") blade can be set, or portions of the blade can be left unset. Overall set is easy to adjust with micrometer micrometer. Fine adjustment of overall set are made with an actuator from the HMI with the advantage that fine tuning can be carried out in increments while machine is running in auto mode.

The setting motion is controlled by a servo motor. Adjustments of the height position of the setting unit are powered by an electrical motor controlled from the HMI. A pneumatic cylinder locks the pillar stand in position after any height adjustment. Parameters can be stored in the PLC/HMI and reloaded to the process next time the same particular product should be run in the machine.

The machine is universal but requests blade related parts, like blade carriers and magazine inserts, to be able to handle blades with shaped backs.

TECHNICAL SPECIFICATION:

Blade width:	6 - 25 mm
Band thickness:	0.5 - 1.6 mm
Blade length:	65 - 315 mm
Max. set length / set cycle:	150 mm
Tooth pitch:*	2 - 32 tpi
Setting tolerance:	±0.01 mm
Symmetry tolerance:	±0.01 mm
Capacity:	33 blades / min at a blade length of 150-300 mm
Air pressure:	6.3 bar
Voltage:	400 VAC, ± 10%, 3-phase, 50-60 Hz ± 1%, directly earthed system
Space requirement (l x w x h):	1.8 x 1.3 x 1.45 m
Weight:	990 kg

* Setting tools are not included in the machine price.

