

360x500 GH-LR (version 6)

Gravitational band saw machine. Working movement of the arm is caused by the weight of the arm itself, speed is regulated by a choke valve and hydraulic cylinder.

The machine is designed for cutting of material in vertical and angle cuts, angle cuts are possible to set fluently from 0 to 60 grades to the right and from 0 to 60 grades to the left. Change of angle using quick clamping handle.

It is suitable for piece production and small series production. Thanks to its robust construction it enables cutting of wide range of profiles and full materials.

Construction:

- The machine is constructionally designed in that way, so that it corresponds to extreme exertions in productive conditions.
- The arm of the machine is robust, heavy weldment and it is designed so that a toughness and a precision of cut was ensured. Arm is 2 grades sloped, it increases the lifetime of blade.
- The arm is situated in pretightened slide bushes with a teflon friction surface.
- Down working positions of the arm are controlled by the cam and microswitches. The arm stops automatically after reaching the down position. The arm is lifted by the operator manually.
- The vice is welded. The jaw is made from cast iron. Jaw ensures the safe clamping of the material.
- Jaws of the main vice move in steel leading.
- Moving jaw of the vice is manual with a wheel and trapeze thread. Fixation by the handle with the excenter.
- Basic part of the vice moves according to the direction of the angle cut setting, fixation is made by the handle.
- Turn table is cast iron. Turn table situated on cone roller bearings.
- Manually turning of the table for angle cuts, the position of the turntable is fixed by the lever with the excenter. The position of the turntable for vertical cutting is arrested automatically by the spring mechanism.
- General angles are adjusted by the nonius.

Basic equipment of machine:

- The blade leading in guides with hardmetal plates and leading bearings and along cast iron pulleys.
- There is a guide situated on the firm beam on the drive side. On the tightening side there is the guide situated on the moving beam.
- The guide beams of moving band guide is adjustable. Manual adjustment and fixing of the guide beams.
- Guide holder moves in adjustable dovetail groove.
- The saw-band is equipped with a guard, which protects the operator from millings and cutting emulsion.
- Mechanic tightening of the blade.
- Automatic indication of blade tension.
- A cleaning brush for perfect cleaning and function of blade, passive driven by pulley.
- Drive of machine is solved by worm gear box with permanent oil filling. Three phase engine with double winding, two cutting speeds. Thermoprotection of engine.
- The cooling system distributes cutting emulsion to the band guides.
- Base with a tank for chips.
- Indication of blade tightening and opening of the cover.
- Controlling 24 V.
- There is a controlling panel ergonomically situated on the flexible console. The control panel is equipped with a safety button, which stops the saw. There is also a feed regulator and buttons, which control the various available movements.

Basic accessories of machine:

- Band saw blade.
- Set of spanners for common service.
- Manual instructions in electronic form (CD).

Operating cycle:

Manually controlled quick clamping vice, cut is regulated by a hydraulic damper and a restrictor choke valve. operator cutting speed. After finishing the cut machine will stop itself automatically and an operator lifts the arm manually to the start position. Feeding of material is manually.

cutting parameters

		0°	45°	60°	45°	60°	b
	D [mm]	360	360	300	360	300	x
	D [mm]	250*	180*	130*	180*	130*	x
b	axb [mm]	500x350	420x300	300x200	420x260	250x280	500x220

* Recommended values. Recommendations of band blade producers are to be followed when choosing to cut full material, their dimensions are limited by available size of the teeth for the specific type of the band.

° Cutting of the bundle without upper vice HP. HP = accessory for additional price. The cutting parameters are limited when using.

the shortest cutting	5	mm
the smallest divisible diameter	3	mm
the shortest rest during one cut	35	mm

performance parameters

drive of the blade	kW	2,0/2,6
pump of the cooling emulsion	kW	0,05
total input	kW	2,9
cutting speed – fluently set	m/min	42/85
diameter of the blade	mm	4780x34x1,1
electric connection		3x400V, 50 Hz, TN-S

control

feed of the Frame to the cut	by its own weight, the speed is regulated by a by-passing valve and hydraulic cylinder
feed of the material	manually
clamping of material	manually
bend tension	manually
cleaning of the blade	A cleaning brush for perfect cleaning and function of blade, passive driven by pulley

A cleaning brush for perfect cleaning and function of blade, passive driven by pulley

Parameters						
length	width	Height		height of the table	weight	
[L]	[B]	[Hmin]	[Hmax]	[V]	(kg)	
2800	1080	1470	2340	812	682	