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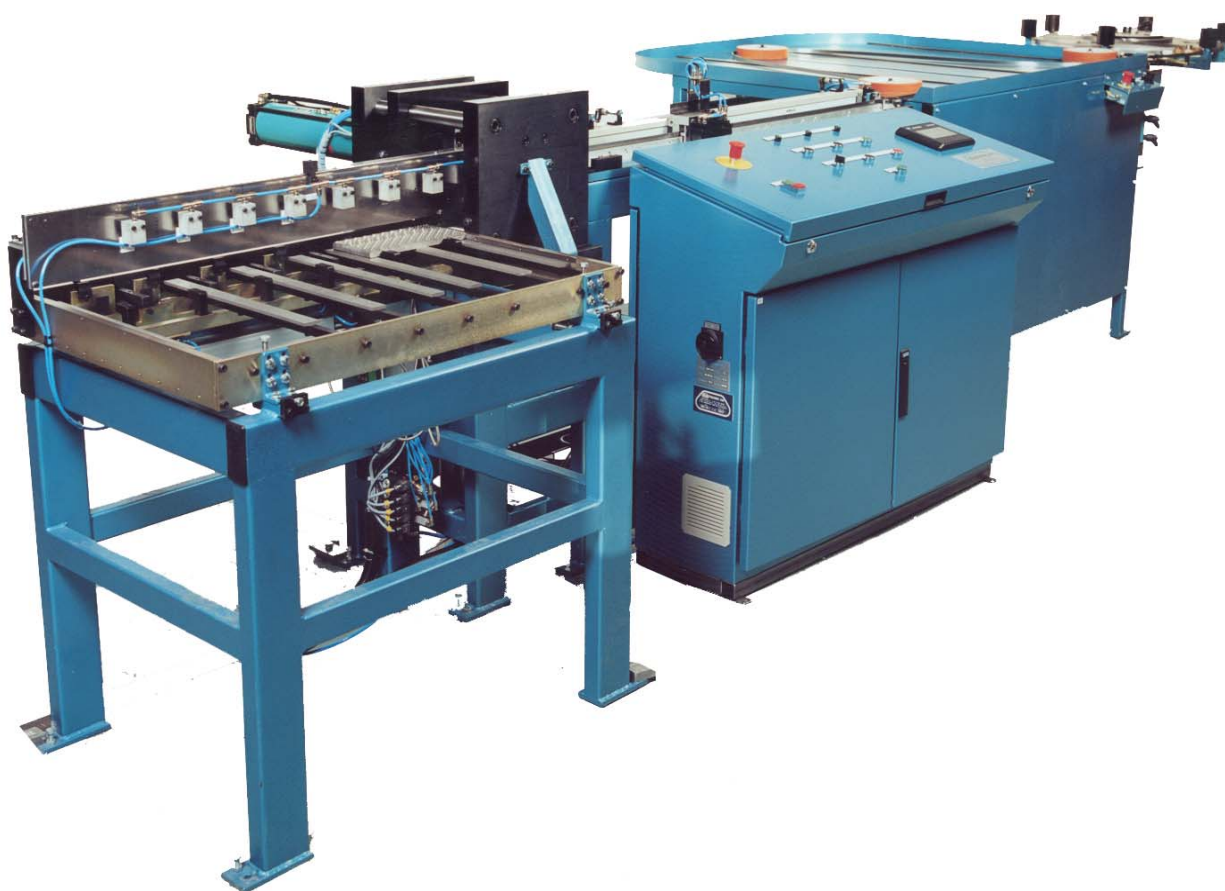
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ALO 600-40-1

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Cut to length machine for blades



THE SYSTEM COMPRISES:

Pay off coiler
Band loop controller
Feed and punch unit
Collect magazine

CAPACITY:

Blade width: 10 - 25 mm
Blade thickness: 0.3 -1.1 mm
Feed length: 254 - 915mm
Approx. capacity: 35 blades/min





Feeding system with programmable linear feeder.



*Collect magazine with pneumatic press.
Blades are vertically stacked.*

MACHINE DESCRIPTION

The band is fed from the decoiler via a band loop controller to a blade feeding system, which is done by a programmable linear feeder capable to handle blade lengths up to 36" in one feed cycle.

The blade is locked with a clamping device during the punch operation and the return stroke of the feed unit.

The punching is done with a pneumatic press. At the punching operation the tang of the blades and the holes are formed with hard metal die cutters mounted in a pillar stand, which with die cutters can easily be dismantled for regrinding or exchange. (One set of punch and die incl.).

Length and number of blades are chosen on a keyboard and surveillance of the machine operations is done via a programmable controller. Blade parameters can/will be stored under a program number and operator will through an interactive program only have to choose blade type number and how many blades to cut.

Up to 3 different blade lengths/types can be ordered/set up and machine will automatically change from first, to second and third type without any down time.

Machine set up or change over will take from 30 seconds to maximum 5 minutes if going from shortest to longest blade type. The controller will also signal when machine or punch tools require service. An air motor will feed the blade out of punching device into drop position for the collect magazine.

The blades drop down to a magazine packing mechanism that feed the blades into the magazine where they are vertically stacked. Specification below is valid for standard machine, custom modifications on request.

TECHNICAL SPECIFICATION:

Band width:	10 - 25 mm
Band thickness:	0.3 - 1.1 mm
Feed length:	254 - 915 mm
Linear feeder accuracy:	0.08 mm
Blade length accuracy:	0.1 mm (L=430mm)
Approx. capacity:	35 blades/min
Coiler ID:	325 mm
Coiler OD:	820 mm
Approx. magazine capacity:	450 blades
Press capacity:	8 metric tons
Air pressure:	6.3 bar
Voltage:	380 VAC, $\pm 5\%$, 3-phase, 50 – 60 Hz $\pm 1\%$
Space requirement (l x w x h):	3.3 x 1.6 x 1.1m
Weight:	450 kg