

**250x315 GH-LR (version 3)**

Gravitational band saw machine. Working movement of the arm is caused by the weight of the arm itself, speed is regulated by a 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 45 grades to the left.

It is suitable for piece production and small series production. Thanks to its rugged 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 standard exertions in productive conditions. That is why all carrying parts are made as cast-iron castings (solidity, absorption of vibrations and stops). Parts of arm, vice and turn table is cast iron.
- The arm of the machine is made of cast iron and it is designed to ensure the power and the precision of the cut. Arm is 25 grades sloped, it increases the lifetime of blade.
- 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 made from cast iron. Jaws ensure safe clamping of the material.
- The manually operating vice is placed in an adjustable dovetail groove.
- Moving jaw of the vice is manual with a wheel and trapeze thread.
- 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.
- Manual turning of the table for angle cuts, angle fixation using quick clamping lever.
- 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 in whole working range. Manual adjustment and fixing of the guide beams.
- Guide holder moves in adjustable dovetail roof.
- 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 passive driven cleaning brush for perfect cleaning and function of blade.
- 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.

**Basic accessories of machine:**

- Measuring end stop.
- 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]	250	190	120	170	x	250
	D [mm]	150*	110*	80*	110*	x	150*
 b	axb [mm]	290x200	190x140	120x140	200x70	200x120	290x200

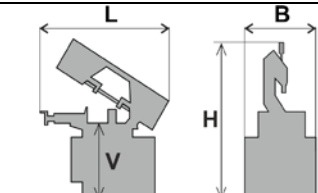
\* Recommended values. Recommendations of band blade producers are to be followed when choosing to cut full material, their dimensions are limited by available size of the teeth for the specific type of the band.

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

the shortest cutting	14	mm
the smallest divisible diameter	10	mm
the shortest rest during one cut	14	mm

performance parameters		
drive of the blade	kW	0,75/1,1 kW
drive of the pump of the cooling emulsion	kW	0,045
<b>total input Ps=</b>	kW	1,64
cutting speed	m/min	37/74
diameter of the blade	mm	2825x27x0,9
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	pasive cleaning brush

Parameters						
length	width	Height max	height min	height of the table	weight	
[L]	[B]	[Hmax]	[Hmin]	[V]	(kg)	
1550	750	1870	1420	970	380	