

SAA

Fully automatic stellite tipping machine for equipping of the saw teeth by resistance welding process



ISELL stellites your saw blades using the plasma welding process as well as the resistance welding process.

The stellinging process, which has been tried and tested thousands of times, is used to fit band, circular and gang saws.

Highlights

- ✓ The structure of the stellite is not changed during welding, therefore no cracks or holes occur in the stellite
- ✓ No tooth tips need to be cut before stellinging. If the saws are stelled repeatedly, the residual stellite does not have to be grinded away.
- ✓ The loading of band saws is fully automatic. These are annealed in the same annealed via high frequency in the same operation.
- ✓ The machine is equipped with a programmable control, which ensures very easy operation of the machine
- ✓ No expert is required
- ✓ The hydraulic control makes it possible to set each working speed individually set
- ✓ The stellite is welded in vertically and can be adjusted in length from 4 - 10 mm. can be adjusted
- ✓ With the same machine, band, circular and gang saws can be stelled by simple can be set up by simple retooling

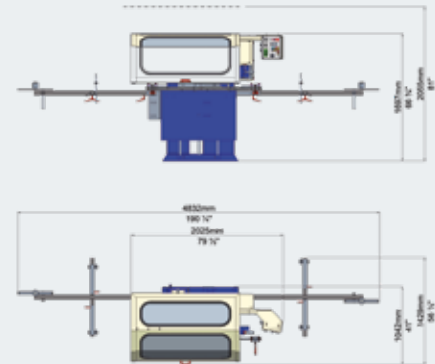


Stellited tooth in plasma welding process



Stellited tooth in resistance welding process

Technical Data



GENERAL INFORMATION:

Blade thickness	0.8 – 3.2 mm
Tooth pitch	13 – 115 mm
Tooth height	up to 30 mm
Rake angle	10 – 30°
Working speed	approx. 8 T / min**

BAND SAW BLADES:

Blade width (Standard)	60 – 360 mm
Blade width	from 5'600 mm
Blade width (Option)	25 – 80 mm

CIRCULAR SAW BLADES:

Diameter	250 – 1'200 mm
Bores	22 – 210 mm

GANG SAW BLADES:

Blade width	80 – 180 mm
Tooth length	up to 1'500 mm

PROPERTIES:

Electrical connection	400V 3Ph N
Connected load	9,6 kVA
Welding transformer	300 A