

# STA

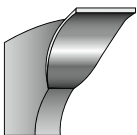
## Fully automatic, hydraulic controlled swaging machine for band and gang saw blades



The swaging of saw teeth is, in addition to setting, another way of ensuring that the saw is cut free during cutting. For the swaging process, an swaging excenter is placed in front of the saw tooth. The saw tooth is held against it with an anvil. By turning the swaging excenter, the saw material is displaced towards the tooth tip. When the swaging process is finished, the swaging excenter turns back to its original position.

### Highlights

- ✓ The ISEL STA has a robust steel design. The machine is hydraulically controlled and equipped for band saws.
- ✓ The same tooth can be swaged once or twice and shaped in a single pass
- ✓ All the work processes are hydraulically controlled
- ✓ The blade feed is effected by the swage die so that accurate positioning of the saw tooth is guaranteed
- ✓ Swaging densifies the tooth point of the saw tooth of what results in a smoother and more accurate cut of the wood and a higher production
- ✓ By swaging, the tooth tip of the saw tooth is compressed, thus achieving a longer working life
- ✓ The swaging excenter is mounted on both sides and can be moved axially. It can be used in 10 different positions
- ✓ The clearance- and the rake angle, the width to be shaped and the tooth pitch are easily set according to scales, without changing any machinery parts



SWAGED TOOTH

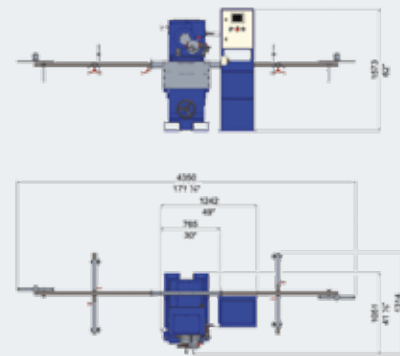


SWAGED TOOTH  
SHAPED



SWAGED TOOTH  
GRINDED

### Technical Data



#### GENERAL INFORMATION:

Tooth pitch	18 – 76 mm
Tooth height	from 10 mm
Clearance angle	5° – 28°
Rake angle	5° – 35°
Working speed	approx. 6 T / min

#### BAND SAW BLADES:

Blade length	from 5'300 mm
Blade width (Standard)	81 – 360 mm
Blade width (Option)	from 50 mm

#### GANG SAW BLADES:

Toothing length	up to 1'500 mm
Blade width (Standard)	75 – 180 mm

#### SPECIAL ACCESSORIES:

Swaging excenter (Standard)	Ø 10, 12, 14 mm
Side dies set, clearance angle	5° or 7°

#### PROPERTIES:

Electrical connection	400V 3Ph N
Connected load	3.0 kVA

#### AIR (ONLY FOR LUBRICATION UNIT):

Compr. air supply	6 bar
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