

Construction Series – invincible automatic machines

Combination of machines for producing steel structures with a proprietary feeding system designed specially for double mitre cuts represents a perfect ultimate solution for a fully automatic operation for steel structures. With both-sided angles up to 60° range, the feeding system ensures remains of short lengths. The feeding unit is equipped with stable rollers and a vertically adjustable connection device.



Elaborated to every detail



Micro-spray system

Ideal for cutting pipes and sections – the MICRONIZER micro-spray unit applies a grease film on the teeth points and the rear side of the band.



Chips removing pistol

The chip removing pistol serves for fast and simple cleaning of the machine from chips and burrs.



Band-tension measuring device

TENZOMAT - a sensitive and precise device for measuring the band tensioning, providing the control of the band tensioning after tool replacement.



LaserLiner

A laser unit copies the exact line in the saw band axis to the material. LaserLine allows precise adjustment of a marked material.



Halogen light

A strong halogen light for comfortable lighting of the whole workspace.



Third coolant supply

For extra wide materials, a third coolant supply is installed. The coolant supply is flexible and may be adjusted individually to the material shape.



Construction 615.340
Construction 820.450
Construction 1150.600

System X/XP – Strong partner in handling

A very flexible solution for difficult tasks. A unique system of profiles allows the roller tracks of the X system to be individually adjusted, bearing capacity to be increased, and the distance between rollers changed as requested by the customer. The X system is completed with a wide range of accessories and connection parts.



High flexibility system

Thanks to the innovative system of the X and XP roller track profiles, the maximum flexibility may be achieved. The series-produced roller tracks may be extended anytime with other bearing rollers and supporting feet. Accessories, such as vertical rollers, may be easily installed additionally.



Transverse feeding units – Possible individual adjustment

The System X offers a wide range of various feeding units, from chain conveyers and trolley feeding systems to units with a draw hook. Transverse feeding systems may be located individually on handling devices.



Length measurement systems – precise cut sizes

Length measurement systems for the X/XP systems are compatible with all handling units, and thanks to their front location they enable operation with driven roller tracks.



A special design of measurement stops for combinations with vertical rollers enables the device to be arranged individually.



Mitre cuts left

The feeding clamping vice moves to its maximum to ensure remains (waste) of the shortest lengths possible.



Mitre cuts right

The feeding clamping vice moves to its maximum to enable feeding to the saw band as close as possible.



Short remains

The proprietary clamping device ensures remains of significantly shorter lengths.



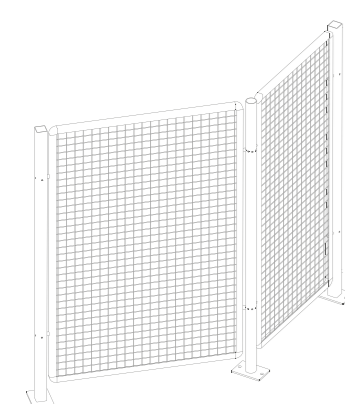
Reduced clamping jaw

The saw clamping jaw is reduced and during operation replaced with feeding clamping jaws.

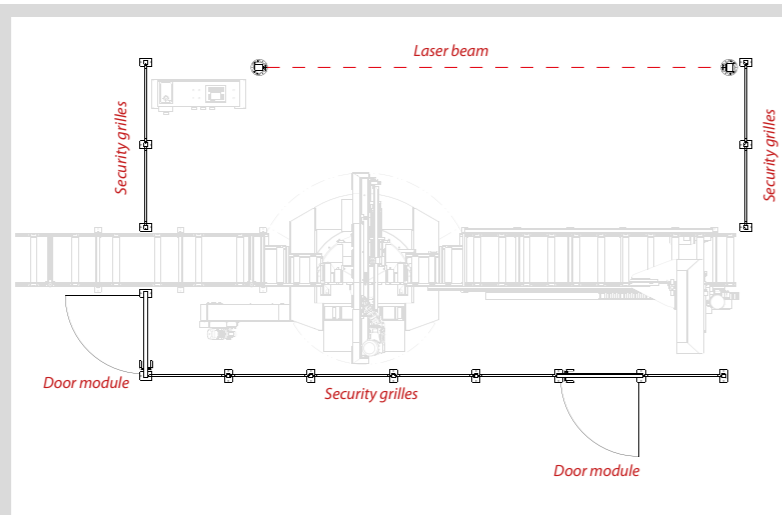
securflex®

Safety system

Personnel are them most valuable part of every business and must be protected in compliance with current safety criteria. The SECURFLUX safety system allows every device to be secured individually, depending on the environment and requirements.



- Grids of various widths and 1,600 or 2,000 mm height.
- Doors in various widths made as swinging, sliding or double-wing.
- Maintenance units with an off-take hook and electronic lock
- Laser light lock systems to extensive safety
- Several safety sections possible!



A complex safety system for a fully automatic double mitring saw in compliance with valid EU machinery Directives.

CONSTRUCTION

Construction Series – Your specialist for steel structures

The Construction product series includes fine machines for producing steel structures with all attributes for the use in the production process or implementation in production lines. During the Construction series development, requirements for the use in the production were taken into account and the machine was optimised for cutting steel girders.

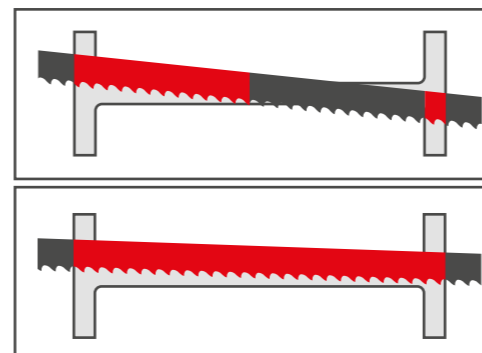


Equipment as an argument

- Highly sensitive regulation of the cutting pressure for optimal cutting time and precise angle of cut sizes.
- Double section of both-sided mitre cuts up to 60°.
- Automatic angle adjustment from the control panel with 0.1° accuracy
- Continuous regulation of the band speed with a frequency converter within the 20–90 m/min range
- Tilted position (6°) of the saw frame for a shorter cutting channel
- Sectional clamping vice with round jaws for optimal clamping also for acute angles
- Additional vertical clamping unit, freely-adjustable according to the material width
- Clamping pressure regulation for preventing occurrence of deformations in thin-walled materials
- Precious, preloaded linear guiding for a solid set saw frame and band guide arm.
- Simple and understandable control with a large display and communication in a decoded text.

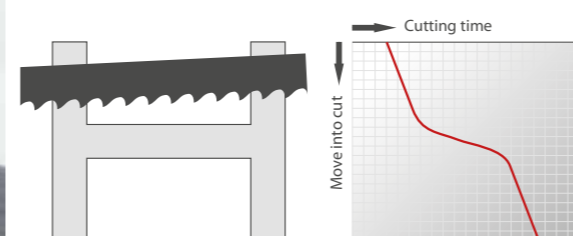
6° angle adjustment – Higher feeding speed

With the 6° angle adjustment of the saw frame faster and more precise cuts may be performed thanks to the use of smaller teeth. The cutting channel is significantly shortened thanks to a steep gradient of the saw band in the horizontal section of the H girder. Thus smaller teeth may be selected and downfeed increased for the vertical section of the girder. In combination with the ADFR (Automatic Downfeeding Regulation) this means faster, more precise cuts and longer saw band lifetime.



ADFR Highest precision. Fast cutting. Minimal wear

The ADFR system regulates automatically and in real time the coordination of the cutting pressure and downfeeding. The saw band current loading and the cutting course according to the material shape are regulated with a sensor. With materials of bigger cross-sections, the cutting channel is extended and the saw band loading increased. If the downfeeding in this section is not adjusted automatically, the saw band lifetime may profoundly shorten or the cutting time may significantly extend due to smaller downfeeding.



Elaborated to every detail



Clamping pressure regulation included in the basic version

The Construction series saws are all equipped with clamping pressure regulation. Adjustment is made directly on the front side of a tilted bracket, enabling the clamping pressure to be adapted individually to thin-walled materials.

Saw band guiding

The saw band is guided precisely thanks to accurately ground hardmetal guiding elements with large guiding rollers.

Sensitive downfeeding

All Construction series saws are equipped with the ADFR system. Sensitive downfeed regulation reduces the cutting time and extends the saw band lifetime.

Always firm clamping

Semicircular, sectional clamping jaw of the Construction series provides firm clamping directly on the band for every mitre cut.



Comfortable central unit

The machine is controlled through a central control unit equipped with a foil keyboard and a large display. All necessary control elements are located on a single panel.



Automatic cutting angle adjustment

The cutting angle is adjusted automatically on the control panel. Fast and precise adjustment of the cutting angle steps by 0.1° thanks to a precise measurement system and drive dimensioning.



Massive guiding

The flexible guiding arm is laid in two large linear guides and is always adjusted with the clamping vice of the machine. This guarantees the smallest possible distance between the saw band and clamped material.



Firm clamping and minimal wear

Rear jaws of the clamping vice are fitted with hardened guide rails directly on the clamping edge.

Overview of technical data

Model	Angle	Blade Width	Table Length	Table Width	Table Height
Construction 615.340	0°	340 mm	615x340 mm	615x340 mm	340 mm
	right 45°	340 mm	400x340 mm	400x340 mm	340 mm
	right 60°	260 mm	260x340 mm	260x340 mm	260 mm
	vlevo 45°	340 mm	400x340 mm	400x340 mm	340 mm
	vlevo 60°	260 mm	260x340 mm	260x340 mm	260 mm
Saw blade		5360x34x1,1 mm			
Driving power		3 kW			
Band speed		20–90 m/min			
Construction 820.450	0°	500 mm	820x500 mm	820x500 mm	500 mm
	right 45°	500 mm	560x500 mm	560x500 mm	500 mm
	right 60°	500 mm	360x500 mm	360x500 mm	360 mm
	vlevo 45°	500 mm	560x500 mm	560x500 mm	500 mm
	vlevo 60°	500 mm	360x500 mm	360x500 mm	360 mm
Saw blade		6470x41x1,3 mm			
Driving power		4 kW			
Band speed		20–90 m/min			

Model	Angle	Blade Width	Table Length	Table Width	Table Height
Construction 1150.600	0°	600 mm	1150x600 mm	1150x600 mm	600 mm
	right 45°	600 mm	790x580 mm	790x580 mm	580 mm
	right 60°	530 mm	790x530 mm	790x530 mm	530 mm
	vlevo 45°	600 mm	790x580 mm	790x580 mm	580 mm
	vlevo 60°	530 mm	790x530 mm	790x530 mm	530 mm
Saw blade		8370x54x1,1 mm			
Driving power		5,5 kW			
Band speed		20–90 m/min			

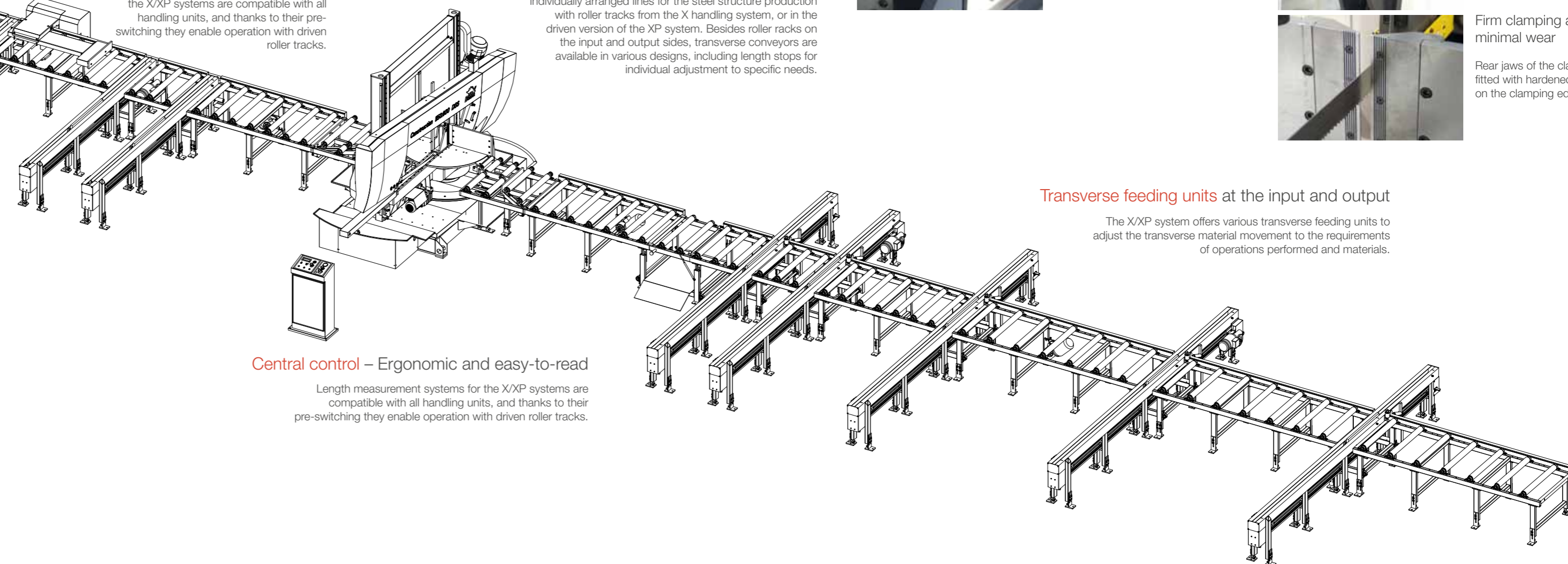


Certified safety

All saws of the Workline series are delivered with a Declaration of conformity with the current machinery EU Directive, issued by TÜV Süd for the Czech Republic.

Length measurement systems – precise cut sizes

Length measurement systems for the X/XP systems are compatible with all handling units, and thanks to their pre-switching they enable operation with driven roller tracks.



Central control – Ergonomic and easy-to-read

Length measurement systems for the X/XP systems are compatible with all handling units, and thanks to their pre-switching they enable operation with driven roller tracks.

Easy integration to steel-structure production devices

The Construction series may be easily integrated to individually arranged lines for the steel structure production with roller tracks from the X handling system, or in the driven version of the XP system. Besides roller racks on the input and output sides, transverse conveyors are available in various designs, including length stops for individual adjustment to specific needs.

Transverse feeding units at the input and output

The X/XP system offers various transverse feeding units to adjust the transverse material movement to the requirements of operations performed and materials.