



Horizontal Mitre Cutting Bandsaws

ABS 325 H NC

SKU : 423502

CUSTOM MODEL

The ABS-H NC series is characterized by a swiveling and stable dual column frame. In the fully automatic mode, manual cutting angles of up to 45 degrees can be set, semi-automatically up to 60 degrees are possible. The saw blade speed is infinitely variable. Workpiece clamping and the automatic material feed are controlled hydraulically. The Siemens control unit KP 400 S offers simple programming with a large memory capacity. Components from well-known suppliers and first-class workmanship guarantee high availability.

- Double column design with linear guide
- Miter band saw with hydraulic workpiece clamping
- Siemens Simatic KP 400
- High-precision hydraulic workpiece feed
- Stroke height adjustment with optical sensor
- Hydraulic clamping for bundle cutting



TECHNICAL SPECS

WORKING AREA

Minimum cut length	25 mm
Remaining length	295 mm

CUTTING CAPACITIES

Feed per single stroke (max.)	500 mm
Cutting speed	20 m/min - 100 m/min
Cutting capacity 0° (round)	325 mm
Cutting capacity 0° (flat) (length x width)	400 mm x 315 mm
Cutting capacity 0° (square)	315 mm
Cutting capacity 30° (round)	325 mm
Cutting capacity 30° (flat) (length x width)	380 mm x 315 mm
Cutting capacity 30° (square)	315 mm
Cutting capacity 45° (round)	300 mm
Cutting capacity 45° (flat) (length x width)	300 mm x 315 mm
Cutting capacity 45° (square)	300 mm
Max. feed length (multiple strokes)	6000 mm

ACCURACIES

Positioning accuracy (multiple strokes)	0.3 mm - 0.5 mm
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CUTTING CAPACITY IN SEMI-AUTOMATIC MODE

Cutting capacity 60° (round)	200 mm
Cutting capacity 60° (flat) (length x width)	200 mm x 315 mm
Cutting capacity 60° (square)	200 mm

DRIVE CAPACITY

Motor rating main drive	2.2 kW
Motor rating hydraulic pump	1.5 kW
Motor rating coolant pump	0.12 kW

MEASURES AND WEIGHTS

Blade dimensions	4380 mm x 34 mm x 1.1 mm
Overall dimensions (length x width x height)	2.13 m x 2.15 m x 1.65 m
Weight	1860 kg



All switches and controls are conveniently arranged on a stand-alone control panel



PRODUCT DETAILS

- The ABS H NC is a fully automated horizontal band saw series with parallel guiding system, which is ideally suited for series productions with miter cuts in solid materials, tubes, and profiles
- The torsionally rigid guideway frame provides excellent stability and vibration-damping characteristics
- The combination of linear guides and box ways result in low maintenance, long tool life and extreme ruggedness under heavy production conditions
- The fully automated mode allows miter cut angles up to 45°, and the semi-automatic mode up to 60°
- A slight 3° inclination of the saw frame on the cutting axis increases cutting capacity and saw blade life
- Rigid high-precision carbide saw blade guides ensure high vertical angular accuracy
- The reliable hydraulic unit provides the drive power for the automatic workpiece feed, and also the controlled clamping force for workpiece clamping
- Hydraulically controlled saw frame micro-feed
- The reliable Siemens Simatic KP 400 PLC allows for easy and convenient programming for a fully automated operation
- Unnecessary downtime is reduced by an optically controlled change-over from rapid feed to work feed
- A motor with infinitely variable speeds transmits power via a continuous-operation idler gear to the machine drive wheel
- The correct saw blade tension can be verified directly at the pressure gauge display
- An automatic band breakage control, a high-performance coolant system, and a chip brush complement the standard equipment package

This machine is equipped with helpful accessories for cutting pipes:

- Hydraulic bundle clamping
- Hydraulic saw blade tensioning
- Roller Conveyor 3m
- Minimum quantity cooling
- Laser pointer
- Clamping force controlled at operator panel

CONTROLS & SOFTWARE

Siemens Simatic KP 400 SPS-control

Siemens Simatic KP400

- Number of programs: 1
- Working steps in the program: 10

STANDARD EQUIPMENT

Siemens Simatic KP 400 SPS-control
Automatic workpiece feed (hydraulic)
Hydraulic part clamping
hydraulic cutting angle clamping
Hydraulic top clamping
Hydraulic sawblade tensioning
Digital angle display
Optical height adjustment
Saw-band
Saw blade cleaner brush
Roller table (3 meter)
Coolant system
Operating tools
Operator manual

OPTIONAL EQUIPMENT

- 3 meter roller table for ABS S 325 NC / ABS H 325 NC, SKU : 253752