

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
---	-----------------

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, SKU : 253752



KNUTH on YouTube Information to the point

On our YouTube channel you can find videos for nearly all machines from our program. We show the machines from current deliveries and you get an impression of the handling, the processing quality and the machining performance.

**Are you interested in a machine for which you cannot find a current video?
Please feel free to contact us!**