AMADA MACHINE TOOLS EUROPE

Band Saw Machines

HA / HFA Series
Fully automatic band saw machines for series production

HA / HFA Series:

Fully automatic band saw machines with impressive technology

The optimum solution for economic cutting of solid, shaped and hollow materials in all material qualities – single cut or in a bundle.

FEATURES

HA/HFA-250W and HA/HFA-400W

Compact and robust fully automatic band saw machines in stable swivel joint design for economic cutting of solid, shaped and hollow materials in all material qualities including Inconel, Hastelloy and titanium – single cut or in a bundle. In automatic operation, the cut-off length and piece count can be preselected.

The combined feed pressure system has the benefit of selecting the feed pressure according to the sawing task.
For example, constant pressure for difficult to machine solid material, load-dependent feed for tubes and profiles.

Short cycle times due to patented quick approach system with automatic
changeover from rapid work feed to feed. An integrated chip conveyor is included in the basic equipment.

The **HFA models** also have an automatic zero stop for material start detection.

The NC controller provides the requirement for automatic sawing using selectable cut-off lengths from 0 to 470 mm (370 mm), with multiple infeed up to 9999 mm.

The saw cut is permanently monitored using skewed cut detection.

DETAILS

Quick approach bar

- Completely automatic changeover from rapid feed to feed
- Reduction of the cycle times

NC controller

Enables preselection of different cut-off lengths and piece counts.

- Adjustment of the band speed
- Display

Bundle clamping unit

Enables the sawing of material in a bundle. The bundle clamping unit is connected to the hydraulic circuit of the machine using quick-release couplings.

Chip conveyor

- Hydraulically driven chip conveyor with buffer zone
- Optimum separation of chips and coolant

Cutting accuracy monitoring

High process reliability due to cutting accuracy monitoring. In the case of deviations – also for the length feeder – the machine switches off automatically.

Automatic zero stopper

Automatic positioning of the material to be sawn.
The material is positioned exactly using the rear vice.

HA / HFA SERIES ACCESSORIES

HA Series Standard Accessories

- Chip conveyor
- Feed pressure controller
- Cut-off length adjustment
- Multiple infeed
- Piece counter
- Driven chip brush
- Hydraulic band tension
- Steppless adjustable band speed
- Quick approach
- Cut-off and guide plates

HFA Series Standard Accessories

- Chip conveyor
- Feed pressure controller
- Cut-off length adjustment
- Multiple infeed
- Piece counter
- Driven chip brush
- Hydraulic band tension
- Steppless adjustable band speed
- Quick approach
- Cut-off and guide plates
- Automatic zero stopper
- Cutting accuracy monitoring
- NC cut-off length programming
- Error reporting system

HA/HFA Series Special Accessories

- Bundle clamping device
- Pressure-reducing device
- Operating hours counter
- Roller conveyor not driven
- Roller conveyor driven
- Length stop
- Roller stand

SAW BLADES

The saw blades from AMADA have been developed for diverse intended purposes. Here are some examples of bimetal saw blades which have been optimized for special application areas. As a tool for general applications, we recommend our „SGLB“ product. Further information can be obtained from our Sales Department.

PROTECTOR M42 (patented)

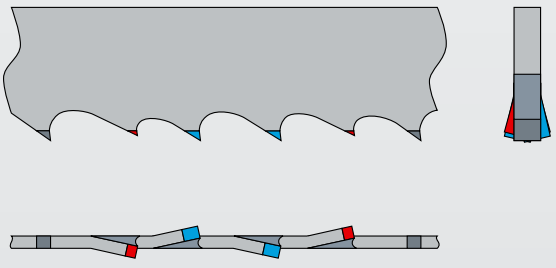
Saw blades specially for profile steel and tubes with reinforced tooth back for reduction of tooth breakouts.

SUPER HLG (patented)

Tooth height difference and precision offsetting result in friction reduction. Wide application area from normal steel to difficult to machine materials.

MAGNUM HLG (patented)

Tooth height difference and precision offsetting result in friction reduction. Outstanding cutting performance for tool steel.



SUPER HL (patented)

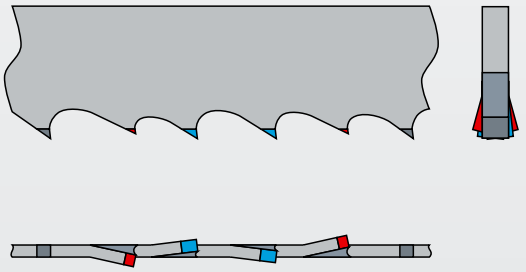
The sectional cutting channel reduces the cutting resistance. For materials in the medium and large diameter range. For materials with internal clamping, an Anti-Pinching variant is available.

SIGMA (patented)

Sectional cutting channel using patented tooth geometry for reduction of cutting resistance. Can be used for difficult to machine materials. Particularly recommended for stainless steels.

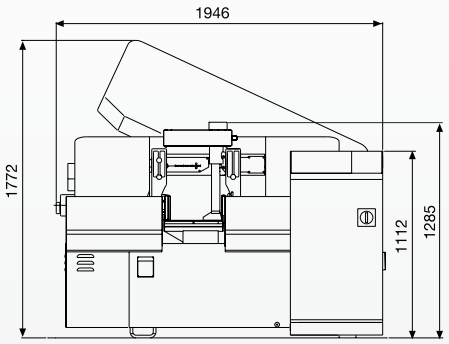
MAGNUM HL (patented)

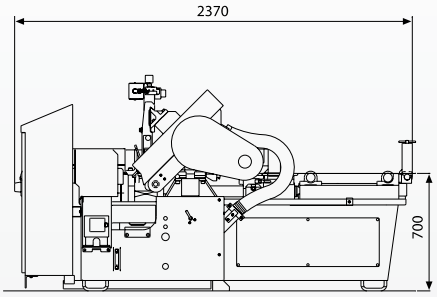
High-performance tooth tip material and sectional cutting channel using patented tooth geometry. Can be used for difficult to machine materials including high heat-resistant special alloys.



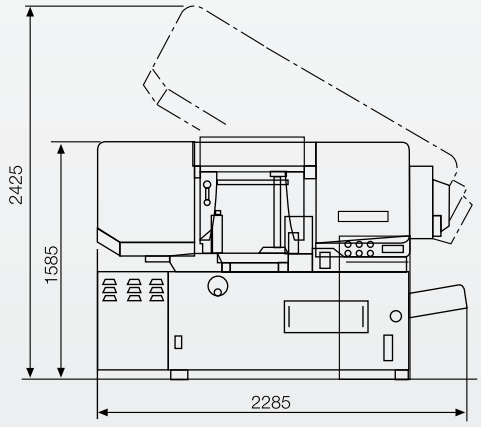
DIMENSIONS

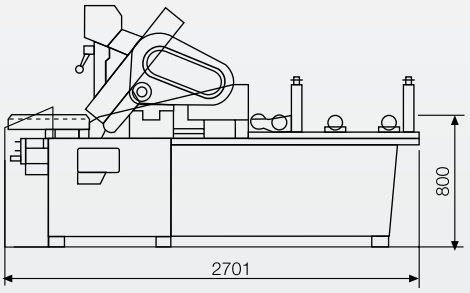
HA-250W
HFA-250W





HA-400W
HFA-400W





TECHNICAL DATA

	HA-250W	HFA-250W
Cutting capacity	Ø 250 mm H 250 x W 300 mm	Ø 250 mm H 250 x W 270 mm
Bundle cutting	max. W 200 x H 150 mm min. W 100 x H 50 mm	
Motor output	Saw band operation: 3,70 kW Hydraulics: 0,75 kW Coolant pump: 0,18 kW	
Saw blades dimensions	34 x 1,1 x 3.505 mm	
Belt speed	24 - 90 m/min, steppless adjustable	
Automatic material feed	5 - 3.300 mm (1 Feed: 370 mm)	5 - 9.999 mm (1 Feed: 370 mm)
Table load capacity	1.500 kg	
Working table height	700 mm	
Electric Equipment	400 V, 50 Hz	
Machine net weight	1.500 kg	
Coolant tank	85 l	85 l

	HA-400W	HFA-400W
Cutting capacity	Ø 420 mm □ 415 x 415 mm	Ø 420 mm □ 400 x 400 mm
Bundle cutting	max. W 300 x H 200 mm min. W 180 x H 50 mm	
Motor output	Saw band operation: 5,5 kW Hydraulics: 1,5 kW Coolant pump: 0,18 kW	
Saw blades dimensions	41 x 1,3 x 4.570 mm	
Belt speed	15 - 90 m/min, steppless adjustable	
Automatic material feed	0 - 4.230 mm (1 Feed: 470 mm)	5 - 9.999 mm (1 Feed: 470 mm)
Table load capacity	2.500 kg	
Working table height	800 mm	
Electric Equipment	400 V, 50 Hz	
Machine net weight	2.200 kg	
Coolant tank	120 l	120 l

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The cutting performance data in this catalogue is affected by material, tooling and cutting conditions.
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