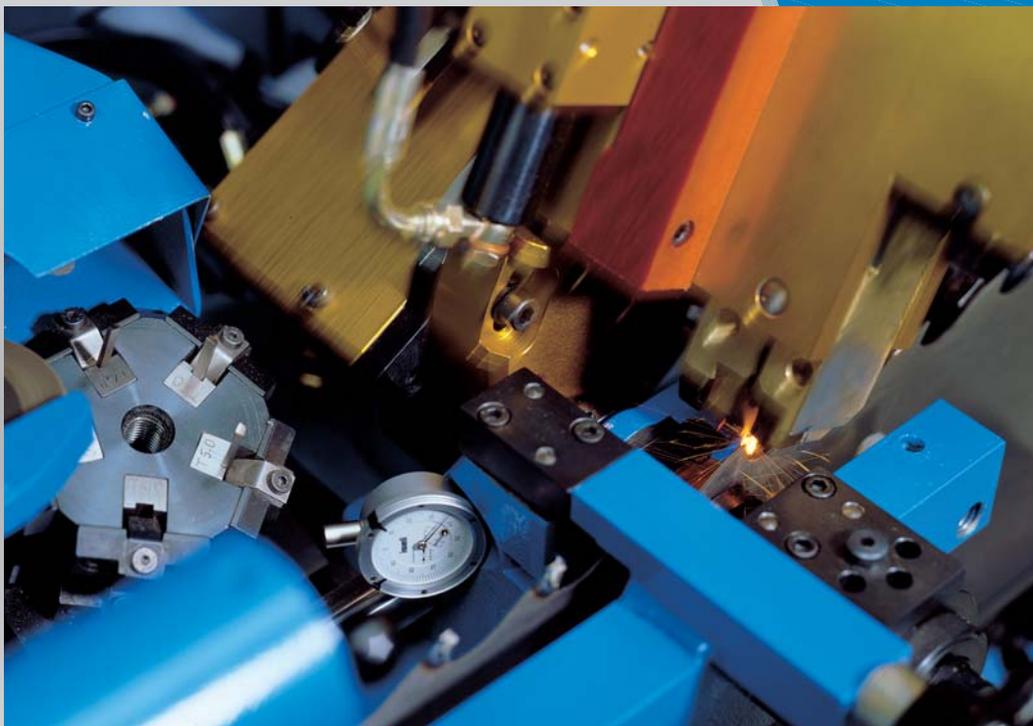


## Fully automatic stellite® tipping machine

The most cost effective  
tipping system



Tooth by tooth  
for a fine faced tooth  
giving burr free finish.



Control unit

### Specifications

#### Automatic Stellite-tipping machine SAA

- Blade thickness: 0,8 to 3,6 mm
- Tooth pitch: 13 to 115 mm
- Tooth height: 5 to 40 mm
- Front rake angle: 10 to 35°
- Band saw blades  
Blade width: 60 - 400 mm  
Blade length: 5600 - 14000 mm
- Narrow band saws: 25 - 60 mm
- Circular saw blades  
Diameter: 250 - 1200 mm  
Bore diameter: 22 - 210 mm
- Gang saw blades  
Blade width: 80 - 160 mm  
Blade length: unlimited
- Working speed: 8 teeth/mn maximum
- Round stellite: Ø 3,2 / 4,0 / 5,0 / 6,4 mm
- Preformed stellite: T 2,5 / 3,0 / 3,5 / 4,0 mm  
4,5 / 5,0 / 5,5 / 6,0 / 6,5 mm
- Cutting-wheel: 115 / 1 x 22 mm
- Connected load: 25 amp.
- Weight of machine: 875 kg, without support  
Height of machine: 170 cm
- Seaworthy packing: 4 m³ approx.

Special executions on request.

Subject to alteration in design for technical improvements.

 **Zertifikat ISO 9001**



HF-annealing device

## Main features

- Well proven stellite tipping system with excellent reputation.
- The stellite is welded on the saw by resistance welding method.
- The structural condition of the stellite does not change during welding. Cracks and holes in the stellite are thus avoided.
- The stellite is welded vertically and the tip size can be adjusted in length from 4 mm to 10 mm.
- Stellite is picked-up from the magazine (5 rods 1000 mm in length each) and is then cut off by a cutting off wheel.

- Pre-shaped (square) stellite from 2,5 to 6,5 mm and round stellite from 3,2 to 6,4 mm dia can be used.
- No need for elaborate saw preparation and grinding of the saw tip before tipping.
- New tips can be directly welded onto existing tips.

## Further qualities

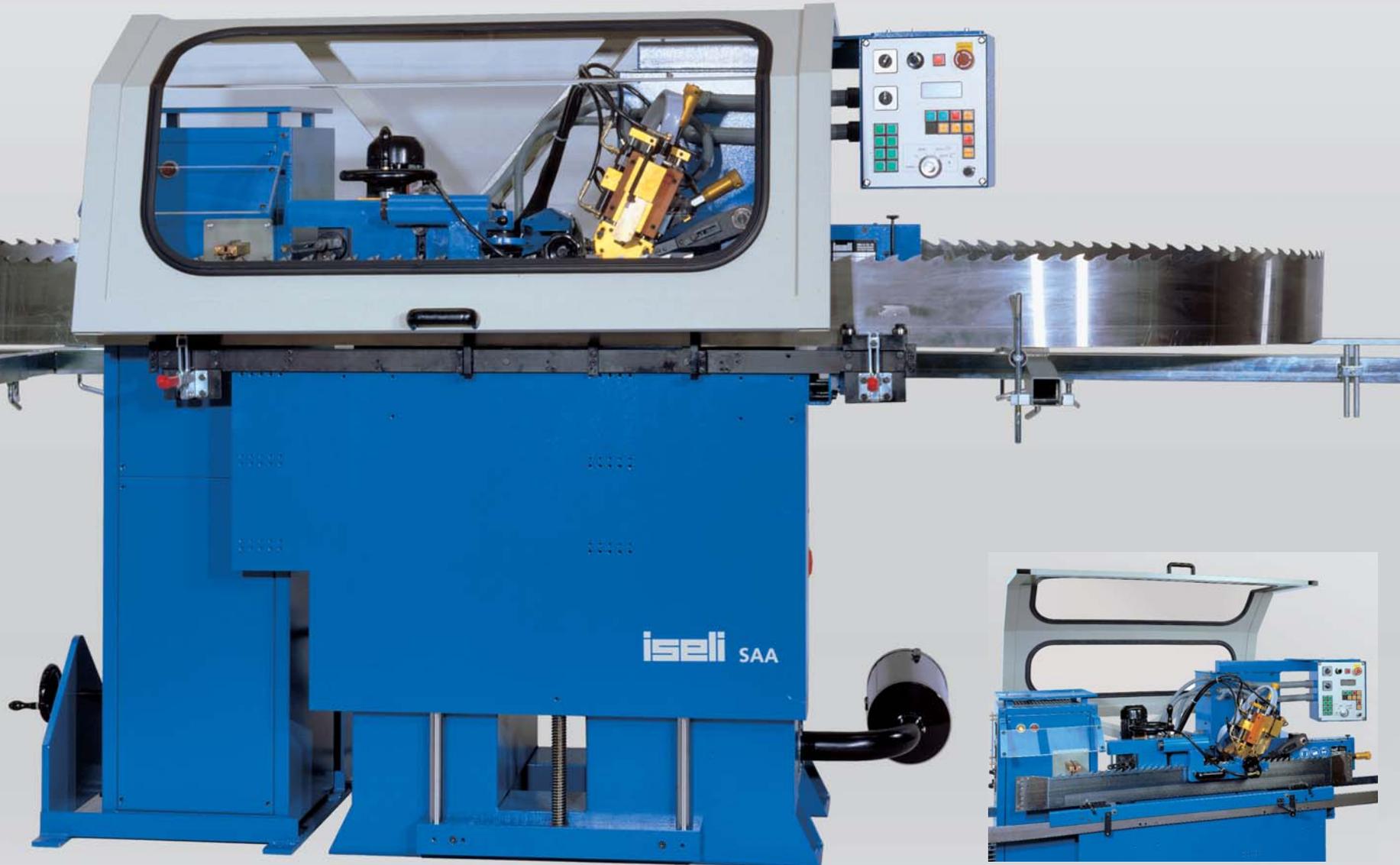
- Easy adjustments allow band, circular and gang saw blades to be tipped on the same machine.
- Tipping and high frequency annealing of the band saw blades is carried out automatically in one process.
- The machine is equipped with easy to use programmable control unit eliminating the need of expert operation.

- The central height adjusting device gives hassle free installation of the saw blade.
- Due to the hydraulic system each working speed of each part of the machine can be adjusted individually.
- The working speed of the machine is about 7 teeth per minute.

## Options (on request)

- Carrousel centrally adjustable in height for left- and right-running band saw blades.
- Single stands for heavy band saw blades.
- Additional supports for double toothed band saw blades.
- Equipment for circular saw blades with centering devices for bores dia. from 22 to 210 mm.
- Equipment for gang saw blades for widths from 80 to 200 mm.
- Equipment for very small (mini) gang saw blades with special programme.

**iseli** SAA



Gang saw blades