

KASTO Ltd

**Proposal and Specification
Used**

KASTO Circular sawing machine

MODEL: KASTO_{wa} M9 HW-HSS-Alu/Ms-Cu*

****For Cu you need to change the pulley and belt to give
400/800m/min speed***

£ 35.000.00 +Vat

A rare 2nd hand machine in excellent condition,

Model Nr : WAM90 s/n 3093 102 181; Year 2002

KASTOWaM9 circular saw, with heavy duty central swarf extraction system,

Technical Data Sheet KASTOwa M 9 – HW/HSS – Al/Ms

08/05

Saw blade Ø	250	275	315	mm
Saw blade bores	32/4 x 9/50	32/4 x 9/50	32/4 x 9/50	mm
Saw blade clamping flange	110	110	110	mm
Cutting range rounds				
Solid bar	15 – 55	15 – 70	15 – 90	Ø mm
Standard- and thick-walled tubes	15 – 55	15 – 70	15 – 90	Ø mm
Thin walled tubes	15 – 45	15 – 60	15 – 80	Ø mm
Cutting range squares				
Solid bar and tubes	15 – 45	15 – 60	15 – 80	mm
Cutting range rectangular				
Solid bar min.	15 x 15	15 x 15	15 x 15	mm
Tubes and profiles up to	120 x 40	120 x 55	120 x 75	mm
Saw gearing				
Cutting speeds, 2 speeds only for Brass +Aluminium	695 - 1270	700 - 1400	800 + 1600	m/min
Saw blade feed rate				
infinitely adjustable		approx. 125 – 6000		mm/min
Rapid return		approx. 10000		mm/min
Drive powers				
Saw blade		9.5/12.5		kW
Hydraulic pump		1.4/1.8		kW
Workpiece clamping				
Clamping force, infinitely adjustable		8000 – 2000		N
Bar feed				
Bar pusher carriage feed motion		7.5 - 40		m/min
Rapid return speed		80		m/min
Inclined magazine				
Bar length		3100 – 6000		mm
Storage depth		1000		mm
Max. single bar weight		200		kg
Total load max.		1000		kg
Working height		1100		mm
Electrical equipment:	According to EN 60204 rules Operating voltage 400 Volt, 50 Hz Control voltage 24 V-DC On request other voltages for an extra charge			
Type of mains:	TN mains according to IEC 364/VDE 0100			

Protective measures

against indirect contact: Over-current protector (zero balancing).
The mains supply of the operator (size and characteristic of the main fuse selected as well as the total impedance of PE and outer conductor in the supply line to the machine) has to be designed in such a way that the permissible shutdown time in the event of an error is not exceeded.
The use of a differential current switch in the mains incoming supply is not permitted.

Painting: Structural painting RAL 7035 light grey

**Pos. 1.0 Machine with length gauge
for cut piece lengths 8 – 300 mm,
Cut off discharge via chute with sorting gate**

Pos. 74-09 Swarf suction unit

For the efficient suction of the produced almost dry **aluminium chips**.

Technical data:

Air throughput	approx. 3200	m ³ /h
Pressure difference	approx. 530	dPa
Transport speed	25	m/sec
Transport pipe	125	mm Ø
Connection to machine	125	mm Ø
Drive motor of radial fan	11	KW

Equipment:

Flexible tubing between the connecting flange in the guard panel of the machine and the funnel of the saw blade guard in special design.

Radial fan, with direct drive, complete with casing, inspection opening, drain plug for eventual water gathering, noise reducing cabin with self supporting panels.

Suction and transport pipe in welded steel design, including tubes, elbows, transition pieces, flanges, gaskets, screws, etc. Max. distance between fan and cyclone container 6-8 metres. Max. 3 elbows, max height 4000mm.

Cyclone chip separator in sturdy design with intake tube and outgoing air tube as well as expansion cylinder to smooth and guide the swarf discharge into a customer supplied container

Support frame for the cyclone chip separator in heavy duty welded design, opening between supports approx. 1200 mm, discharge case approx. 1300 mm above floor

Filter cloth to cover the customer supplied container with rubber band fixation at the discharge case.

Suction hose approx. 7 m long for the manual cleaning of the machine and vice area of flying chips with injector-device JN, for connection with factory

compressed air-line with air operated suction and blow nozzle, including bracket for storing.

Pos. 70-11 Pneumatic impact wrench

for fast saw blade exchange, including holding bracket, hose with fittings for connection to factory compressed air-line with 1 – 7 bar

Pos. 70-65 Central rapid adjustment of the **Guide Rail in the infeed roller track to the bar cross section by means of hand crank and chains**

Pos. 3.6 Flat magazine

In particular for rectangular bars and shapes, for cross feeding of bars without damages to the surface of the bars, for bar length 3000 – 6000 mm, consisting of:

4 chain type cross feed units with plastic plates, width approx. 200 mm, pitch length between stanchions approx. 2250 mm, drive by gear motor (P = 0.75 kW) and one common shaft, usable storage length (loading width) approx. 1400 mm, loading height approx. 1000 mm.

Functioning:

The single bars are deposited on the chain cross feed units. The loading discs of the infeed roller track turn in receiving position and initiate via contact the drive of the chains. The drive is stopped once a contact switch signals that one bar arrived in singling- and loading position. This bar is then loaded onto the infeed roller track by means of the loading discs.

One initiator along one cross feed unit signals "still x bars available".

Backward protection by light-barrier and protection fence element at one front side

TERMS AND CONDITIONS

Delivery

Ex-stock KASTO Ltd, subject to prior sale

Carriage

Extra, at cost