

Precision non-stop.

BR 100s

Band straightening machine

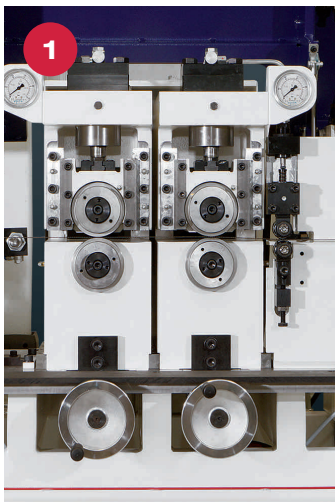


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BR 100s

The automatic Kesel band straightening machine BR-100s was especially developed for straightening the longitudinal camber of metal bandsaw blades. This machine ensures in an efficient process a constant high quality as an perfect condition for satisfied customers. The reduction of waste gives another fast chance to see the cost effectiveness of this machine.

The machine can be ordered in two design options regarding the coil handling direction; right to left (BR-100s R) and left to right (BR-100s L).



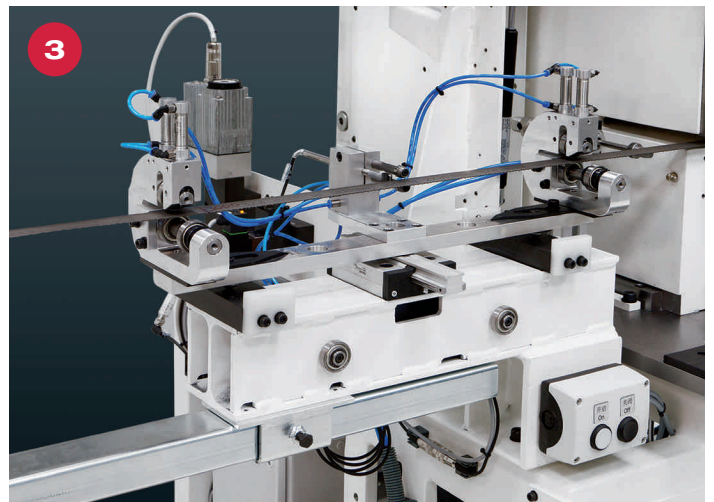
Roller positioning unit

The pairs of straightening rollers are manually adjustable in horizontal position. Therefore, the straightening track spacing can be adjusted for each individual band width and tooth depth.



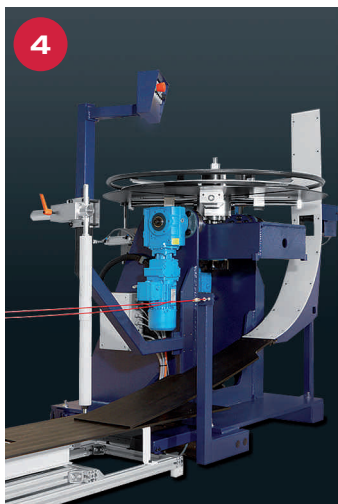
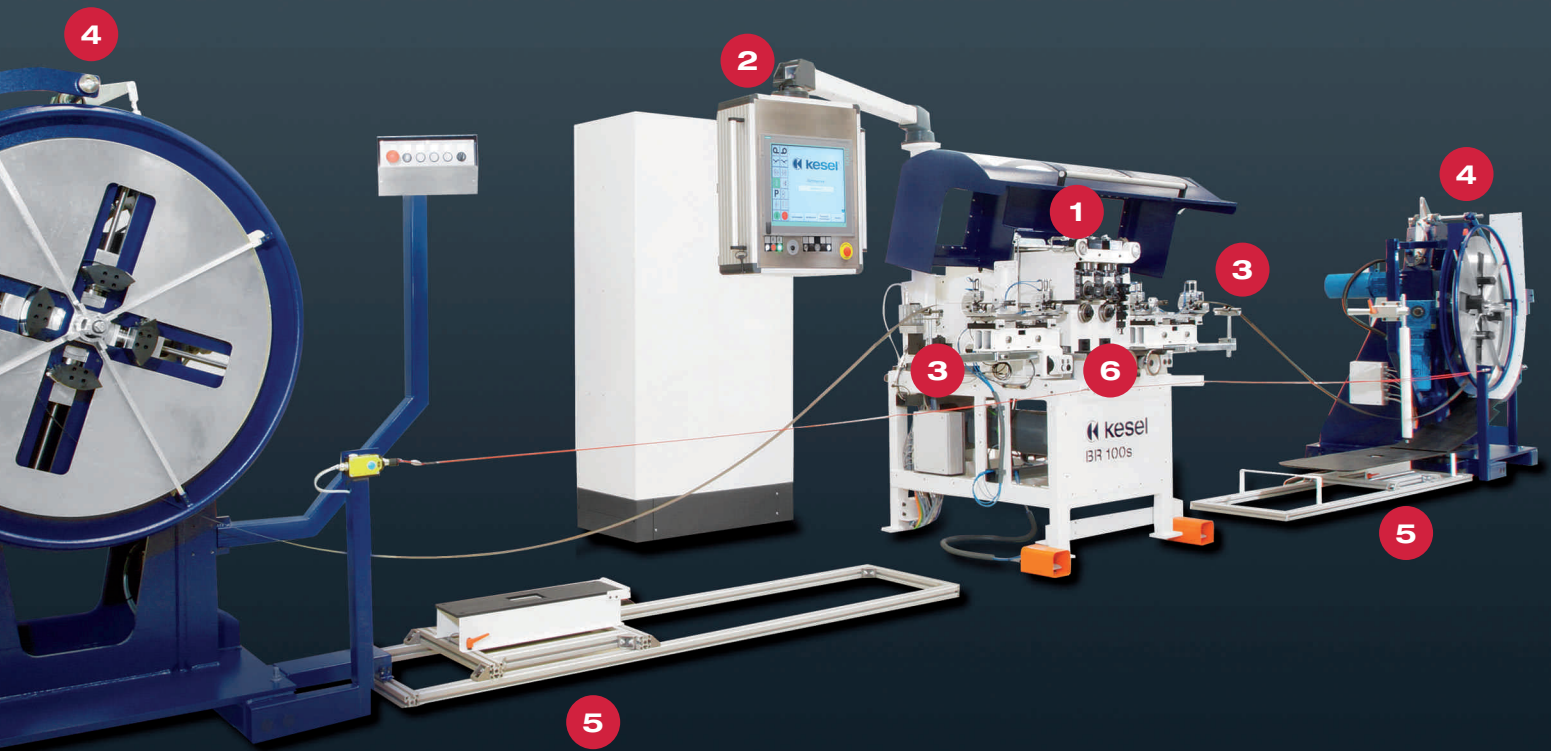
Control unit

With its Siemens control unit this band straightening machine is the first representative of the S-generation. The device is operated via a 19" touch panel with Windows operation system.



Measuring station

The machine is equipped with two floating-measuring stations. One station measures the camber of the incoming band, the second station measures the straightening result of the band. The measurement results are displayed on the screen and can be documented. The measuring sensors are analog sensors equipped with carbide tips.



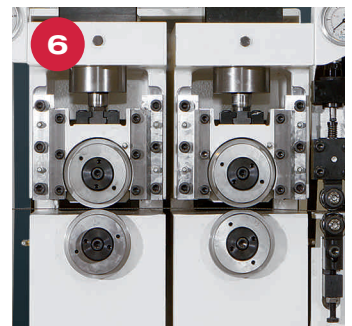
Coiling system

The coiling system can be operated in both directions. Tilting the coils by 90° for horizontal loading is optional. Protective discs prevent damage to the tooth profile of the bandsaw blades. The control unit of the band straightening machine regulates the rotational speed of the coiling system. Control buttons for start, stop, emergency stop, coil retaining and coil tilting (optional) are mounted to each coiling system.



Loop control

Ultrasonic sensors measure the horizontal position of the band loops for the incoming as well as the outgoing band. The control unit regulates the rotational speed of the coiling system.



Straightening rollers

Two hydraulically operated pairs of straightening rollers represent one straightening unit which is controlled via a specially developed software. The bands are straightened in horizontal direction, thus the pairs of straightening rollers are arranged vertically. The advantage of a horizontally positioned band lies in the fact that the band material's own weight does not affect the measurement results.

Specification BR 100s

Work piece data	
Band width min.	12 mm
Band width max.	100 mm
Band thickness min.	0.65 mm
Band thickness max.	1.60 mm
Control unit	
Siemens control unit S-generation. Operated via a 19" touch panel.	
Operating system	Windows
Clamping system	
Hydraulically operated straightening rollers	
Straightening accuracy	
Accuracy	< 0.5 mm/m
Band velocity	
Velocity	2 - 40 m/min
Electrical connection	
Voltage	3 x 400 - 480 V, TN-C-S
Connecting power	20 kW
Fuse	50 A
Pneumatic compressed air	6 bar
Coiling system	
Options	- tilting - non tilting
Max. coil diameter	800 mm
Max. coil weight	180 kg
Adjustable hub	300 - 700 mm
Coil fixture with four jaws	centric hand feed
Dimensions and weight	
Installation dimensions	max. 12,000 x 2,600 mm (incl. control cabinet and coiling system)
Machine weight	approx. 3,300 kg (incl. control cabinet and coiling system)
Options	
Coil handling direction	left > right right > left

Additional accessories upon request

