

2. SCOPE OF SUPPLY

Pos.	Description
1	<p>Cutting group</p> <p>Base: composed by a heavy structure in normalized welded sheet, in which, linear sliding guides are seated in the superior side, for the support of the cut carriage and, there is a side lodging for the rack that allow the motion of the same carriage.</p> <p>Some shock absorber and carriage block systems are mounted at the ends of the base, for emergency, in order to avoid damages to the rack and pinion system.</p> <p>Carriage: It is composed by a normalized welded steel structure on which all tables have been worked for the support and the lodging of units for the sliding of the cut heads, the clamps and the control group dimensioned for the tracking.</p> <ul style="list-style-type: none"> • The cut heads are two and work in opposite way both on longitudinal and transversal axe from the center of the tube. They are composed each one by a reduction gear properly dimensioned with "0" play gears which allow the rotation of the mandrel on which the blade is seated. • The clamps are lodged in two portals of big dimensions positioned close to blades in order to give the max stiffness to the system. They are powered by one hydraulic cylinder each one manufactured in alloyed steel quenched on surface. • The tracking group is manufactured with a rack and pinion control, manufactured with vertical axe. <p>The unit is equipped with 5 brushless motors controlled by drivers of last generation. Carriage driving: 1 Brushless motor; Axes X: 2 Brushless motors; Axes Y: 2 Brushless motor; Blades are moved by AC motors controlled by Inverter.</p>
2	<p>Clamp group</p> <p>A double clamp group both at inlet and outlet side arrange the blocking of the tube during the phase of cut in order to avoid dangerous vibrations.</p>
3	<p>Electrical switch cabinet & control devices</p> <p>with SIEMENS PLC</p> <p>Power Supply 380 V / 3 Phase / 50 Hz</p> <p>Power Supply variation +/-10% - +/-2 Hz</p> <p>Solenoid valve voltage 24 VDC</p> <p>Auxiliary equipment voltage 110 VAC / 24VDC</p>
4	<p>Encoder group</p>
5	<p>Hydraulic equipment composed of a main power unit, connecting pipes electro valves and actuators.</p> <p>The main power unit consist of the motor with pump, pressure control valve and relieve valve, all components assembled on the oil tank. It is completed by an oil-air heat exchanger, oil level and temperature controls.</p> <p>Electro valves are assembled near the various actuators, like cylinders or motors.</p> <p>ELECTRO VALVES: ATOS</p> <p>PUMPS: MARZOCCHI</p> <p>HEAT EXCHANGERS: MG</p>
6	<p>Available tooling and spares (t.b.d.)</p>
7	<p>Available documentation (t.b.d.)</p>

1. TECHNICAL DATA

Manufacturer	Addafer (Italy)
Year	2018
Working sense	left to right
Material type	Cold, Hot Rolled Steel, Galvanized Din ST 37.2, ST 44.3, ST 52.3
Yield Strength	190 - 355 MPa
Ultimate tensile Strength	270 - 490 MPa
Elongation	12% - 26 %
Round Tube	50,0 - 273,1 mm
Square Profile	40x40 - 200x200 mm
Rectangular profile	60x40 - 200x150 mm
Thickness	1,5 - 9,5 mm
Tubes length	3 - 12 m
Working speed	0 - 60 m/min
Length tolerance	+/- 1,5 mm
Blades diameter	350 to 450 mm
Pass-line height	1000 mm
Dimensions (approx.)	8,0 x 3,5 m

<i>Indicative maximum speeds for diameters and thicknesses</i>								
OD	Thickness (mm)							
mm.	2	3	4	5	6	7	8	10
50	60	60	59	57	55	53	52	51
63,5	60	60	58	56	54	52	51	49
70	56	55	54	53	52	51	50	48
76,1	51	51	50	50	49	48	48	47
80	50	50	49	49	48	48	47	46
89	48	48	48	48	47	47	46	45
101,6	47	47	46	46	46	45	44	43
114,3	45	45	44	44	44	44	43	42
127	43	43	43	43	42	42	42	41
139,7	42	42	42	41	41	41	41	40
159,5	40	40	40	39	39	39	39	38
168,3	39	39	38	38	38	38	38	37
193,7	36	36	36	35	35	35	34	32
219,3	34	34	34	33	33	33	32	30
254,2	30	30	29	29	29	28	28	28
273,1	27	27	26	26	26	25	25	25

→ Limit between 1 and 2 blades cut

Notes: the speed for square/rectangular pipes is reduced 5% to 10% of the above table
Speeds are calculated using the best blade for each diameter/thickness and on 12m length

DOUBLE BLADE FLYING SAW ADDAFER DB10



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