



Metal-cutting band saws

Metal-cutting band saws

Metal-cutting mitre band saws MBS – particularly quiet and precise. Ideal for use on the construction site and on the road.

- ▶ Ideal for sawing steel, aluminium, copper, PVC and Teflon
- ▶ Continuously adjustable, electronic speed control from 30-80 m/min.
- ▶ Extremely low noise - up to 60% quieter than comparable metal-cutting band saws
- ▶ Low vibration and wear thanks to special gearbox with two large hardened steel gears
- ▶ Guaranteed cutting precision of max. 0.3 mm run-out over 100 mm cut length
- ▶ Each machine is individually precision tested in Italy
- ▶ DC drive motor, low speed and carbon brushes for up to 10x longer service life
- ▶ Electronic temperature and amperage draw monitoring prevents overload
- ▶ Cast band pulleys with ground running surface, without rubber supports, thus suitable for dry and wet cutting
- ▶ Massive saw bow made of cast aluminium (retroactively adjustable as of MBS 125) and with robust transport protection
- ▶ Two moving, adjustable saw band guides with chip scraper made of metal
- ▶ Very stable base plate with anti-slip feet
- ▶ Easy to service as all components are easily accessible



MBS 105



MBS 125



MBS 150

Manual

Technical specifications	MBS 105	MBS 125	MBS 150	MBS 155 K
Art. no.	3630105	3630125	3630150	3630152
Rating	1 010 W	1 010 W	2 000 W	2 000 W
Electrical connection	230 V / 1 Ph ~ 50 Hz			
Saw band speed	30/80 m/min			
Saw band dimensions	1 335 x 13 x 0.65 mm	1 440 x 13 x 0.65 mm	1 735 x 13 x 0.9 mm	1 735 x 13 x 0.9 mm
Dimensions (L x W x H)	630 x 300 x 410 mm	700 x 350 x 410 mm	875 x 420 x 465 mm	1 010 x 420 x 1 335 mm
Weight	20.5 kg	23.5 kg	35 kg	91 kg
Scope of supply	• Material stop • Bi-metal saw band M42 T6-10	• Material stop • Bi-metal saw band M42 T6-10	• Material stop • Bi-metal saw band M42 T6-10	• Material stop • Bi-metal saw band M42 T6-10 • Chassis • Coolant system • Coolant channel

Cutting areas MBS 105

	○	●	□	▮
90°	105	73.5	110 x 60	100 x 105
45°	70	49	65 x 75	70 x 50
60°	-	-	-	-

Cutting areas MBS 125

	○	●	□	▮
90°	125	87.5	125 x 120	120 x 125
45°	80	56	110 x 70	70 x 110
60°	45	31.5	70 x 40	40 x 70

Cutting areas MBS 150

	○	●	□	▮
90°	150	105	150 x 140	130 x 150
45°	100	70	120 x 90	90 x 130
60°	55	38.5	70 x 55	55 x 70

Cutting areas MBS 155 K

	○	●	□	▮
90°	150	105	150 x 140	85 x 160
45°	95	66.5	105 x 90	75 x 130
60°	60	42	65 x 60	60 x 65



- ▶ Two large tempered steel gearwheels for maximum service life
- ▶ DC drive motor, low speed and carbon brushes for up to 10x longer service life



Impressively quiet!

Maximum service life
Continuously variable
30-80 m/min.
Use of coolants possible for
all models



MBS 155 K



Fig. shows MBS 105 on
machine chassis MUG 1



Fig. shows MBS 150 on
universal work table UWT 3200
with clamped workpiece

Saw bands MBS 105	Art. no.
Bi-metal 1 335 x 13 x 0.65 mm M 42 Z 6-10	3650011
Bi-metal 1 335 x 13 x 0.65 mm M 42 Z 10-14	3650012

Saw bands MBS 150/ MBS 155 K	Art. no.
Bi-metal 1 735 x 13 x 0.65 mm M 42 Z 6-10	3650017
Bi-metal 1 735 x 13 x 0.65 mm M 42 Z 10-14	3650018

Saw bands MBS 125	Art. no.
Bi-metal 1 440 x 13 x 0.65 mm M 42 Z 6-10	3650014
Bi-metal 1 440 x 13 x 0.65 mm M 42 Z 10-14	3650015

Accessories	Art. no.
Universal workbench UWT 3200*	5900020
Machine chassis MUG 1**	3630000
High performance spray "Mecutspray" 500ml	38760.1150
"Chipmag" – Magnetic swarf removal device	3850010

*only fits MBS 150 without installation adapter; adapter Art. no. 3630125-1 required for installation on the MBS 125.

** only fits MBS 105, MBS 125, MBS 150, MTS 356, OPTIsaw S 100G (Optimum)

Saw band sets	Art. no.
for MBS 105	3650020

consisting of:
1 x saw band BI-M 1 335 x 13 x 0.65 t6-10°
1 x saw band BI-M 1 335 x 13 x 0.65 t6-10
1 x saw band BI-M 1 335 x 13 x 0.65 t10-14

for MBS 125	3650021
-------------	---------

consisting of:
1 x saw band BI-M 1 440 x 13 x 0.65 t6-10°
1 x saw band BI-M 1 440 x 13 x 0.65 t6-10
1 x saw band BI-M 1 440 x 13 x 0.65 t10-14

MBS 150/155K	3650022
--------------	---------

consisting of:
1 x saw band BI-M 1 735 x 13 x 0.9 t6-10°
1 x saw band BI-M 1 735 x 13 x 0.9 t6-10
1 x saw band BI-M 1 735 x 13 x 0.9 t10-14



- ▶ Cast wheels with ground running surfaces and tapered roller bearings
- ▶ Without rubber supports and thus suitable for cutting with cooling (saw band does not slip off)
- ▶ Saw band tensioning at front, adjustable via handwheel



- ▶ Dual adjustable saw band guides, instead of just one
- ▶ Swarf scraper made of metal instead of felt to avoid wear



- ▶ Saw bow re-adjustable as of MBS 125



- ▶ Mitre square precisely adjustable; can be read off on scale



- ▶ Continuously variable speed control from 30-80 m/min.



Vertical metal-cutting band saws

VMBS – Vertical metal-cutting band saws with a robust and proven design including band welding unit, e models with electrical table feed

- ▶ Extremely robust design; entire machine body made of steel
- ▶ User-friendly operating concept
- ▶ With workplace lighting
- ▶ Tilting work table made of cast iron
- ▶ Continuously variable speed
- ▶ Band tensioning and band speed display
- ▶ Dust protection system for swarf
- ▶ Integrated band welding unit with annealing, cutting and grinding unit
- ▶ With rip fence

Manual



VMBS 1408



VMBS 1610

➡ With 2-gear drive

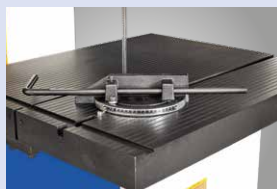


VMBS 1610 E

➡ With 2-gear drive
➡ With electric table feed

Models	VMBS 1408	VMBS 1610	VMBS 1610E
Art. no.	3951407	3951610	3951611
Technical data			
Throat	356 mm	396 mm	396 mm
max. cutting height	205 mm	255 mm	255 mm
Table size	500 x 500 mm	550 x 600 mm	550 x 600 mm
Table size additional table	-	-	-
Working height	990 mm	1 000 mm	1 000 mm
Table swivel range left/right	12°/15°	12°/15°	5°/ 5°
Table swivel range front/rear	8°/8°	8°/8°	-
Saw band length	2 880 mm	3 140 mm	3 140 mm
max. saw band width	13 mm	16 mm	16 mm
Saw band speed (1st gear)	20 - 80 m/min	20 - 80 m/min	20 - 80 m/min
Saw band speed (2nd gear)	-	250 - 1 000 m/min	250 - 1 000 m/min
Saw band welding device performance	13 mm	16 mm	16 mm
Wheel Ø	368 mm	408 mm	408 mm
Ø Additional wheel at top	-	-	-
Motor output 400 V / 50 Hz	0.75 kW	1.5 kW	1.5 kW
Table travel	-	-	300 mm
Max. table load	150 kg	150 kg	150 kg
Dimensions	850 x 600 x 1740 mm	940 x 675 x 1840 mm	940 x 675 x 1840 mm
Weight	275 kg	410 kg	435 kg

Saw bands for metal-cutting band saws	Art. no.
VMBS 1408 (bi-metal M 42)	
2 880 x 10 x 0.9 mm 10-14 Vario	3651110
2 880 x 13 x 0.65 mm 6-10 Vario	3651210
2 880 x 13 x 0.65 mm 8-12 Vario	3651212
2 880 x 13 x 0.65 mm 10-14 Vario	3651214
VMBS 1610 / VMBS 1610 E (bi-metal M 42)	
3 140 x 13 x 0.65 mm 6-10 Vario	3651310
3 140 x 13 x 0.65 mm 8-12 Vario	3651312
3 140 x 13 x 0.65 mm 10-14 Vario	3651314



► Mitre stop for mitre cuts



► Manual material feed



► Circle cutting unit



► Magnifying glass



► Workplace lighting



VMBS 2012 H

- With 2-gear drive
- With circle cutting unit
- With mitre stop for mitre cuts
- With manual material feed
- Saw band guide height-adjustable via hand wheel



VMBS 2012 HE

- With 2-gear drive
- With electric table feed
- With circle cutting unit
- With mitre stop for mitre cuts
- Saw band guide height-adjustable via hand wheel



► Saw band guide height-adjustable via hand wheel



► User-friendly operating concept



► All models with integrated belt welding unit

Models	VMBS 2012H	VMBS 2012HE
Art. no.	3952011	3952012
Technical data		
Throat	508 mm	508 mm
max. cutting height	305 mm	305 mm
Table size	600 x 700 mm	600 x 700 mm
Table size additional table	-	-
Working height	1 016 mm	1 016 mm
Table swivel range left/right	10°/45°	10°/45°
Table swivel range front/rear	-	-
Saw band length	4 030 mm	4 030 mm
max. saw band width	27 mm	27 mm
Saw band speed (1st gear)	15 - 125 m/min	15 - 125 m/min
Saw band speed (2nd gear)	165 - 1 500 m/min	165 - 1 500 m/min
Saw band welding device performance	19 mm	19 mm
Wheel Ø	515 mm	515 mm
Ø Additional wheel at top	-	-
Motor output 400 V / 50 Hz	2.2 kW	2.2 kW
Table travel	-	300 mm
Max. table load	350 kg	350 kg
Dimensions	1 090 x 810 x 2 030 mm	1 090 x 810 x 2 030 mm
Weight	590 kg	625 kg

Saw bands for metal-cutting band saws	Art. no.
VMBS 2012/ VMBS 2012E (bi-metal M 42)	
4 030 x 13 x 0.65 mm 6-10 Vario	3651710
4 030 x 13 x 0.65 mm 8-12 Vario	3651712
4 030 x 13 x 0.65 mm 10-14 Vario	3651714
4 030 x 20 x 0.9 mm 6-10 Vario	3651720
4 030 x 20 x 0.9 mm 8-12 Vario	3651722
4 030 x 20 x 0.9 mm 10-14 Vario	3651724
4 030 x 27 x 0.9 mm 6-10 Vario	3651730
4 030 x 27 x 0.9 mm 8-12 Vario	3651732
4 030 x 27 x 0.9 mm 10-14 Vario	3651734

Vertical metal-cutting band saws

VMBS – Vertical metal-cutting band saws with a robust and proven design including band welding unit, e models with electrical table feed

- ▶ Extremely robust design; entire machine body made of steel
- ▶ User-friendly operating concept
- ▶ With workplace lighting
- ▶ Tilting work table made of cast iron
- ▶ Continuously variable speed
- ▶ Band tensioning and band speed display
- ▶ Dust protection system for swarf
- ▶ Integrated band welding unit with annealing, cutting and grinding unit
- ▶ With rip fence

Manual



VMBS 2613

- ➡ With 2-gear drive
- ➡ With circle cutting unit
- ➡ With mitre stop for mitre cuts
- ➡ With manual material feed
- ➡ Saw band guide height-adjustable via hand wheel

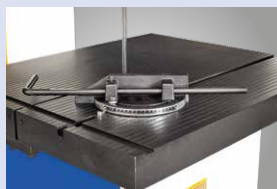


VMBS 2613E

- ➡ With 2-gear drive
- ➡ With electric table feed
- ➡ With circle cutting unit
- ➡ With mitre stop for mitre cuts
- ➡ Saw band guide height-adjustable via hand wheel

Models	VMBS 2613	VMBS 2613E
Art. no.	3952612	3952613
Technical data		
Throat	658 mm	658 mm
max. cutting height	330 mm	330 mm
Table size	600 x 700 mm	600 x 700 mm
Table size additional table	-	-
Working height	1 000 mm	1 000 mm
Table swivel range left/right	10°/45°	10°/45°
Table swivel range front/rear	-	-
Saw band length	4 680 mm	4 680 mm
max. saw band width	27 mm	27 mm
Saw band speed (1st gear)	15 - 125 m/min	15 - 125 m/min
Saw band speed (2nd gear)	165 - 1 500 m/min	165 - 1 500 m/min
Saw band welding device performance	19 mm	19 mm
Wheel Ø	665 mm	665 mm
Ø Additional wheel at top	-	-
Motor output 400 V / 50 Hz	2.2 kW	2.2 kW
Table travel	-	300 mm
Max. table load	350 kg	350 kg
Dimensions	1 340 x 810 x 2190 mm	1 340 x 810 x 2190 mm
Weight	665 kg	710 kg

Saw bands for metal-cutting band saws	Art. no.
VMBS 2613 / VMBS 2613 E (bi-metal M 42)	
4 680 x 13 x 0.65 mm 6-10 Vario	3651810
4 680 x 13 x 0.65 mm 8-12 Vario	3651812
4 680 x 13 x 0.65 mm 10-14 Vario	3651814
4 680 x 20 x 0.9 mm 6-10 Vario	3651820
4 680 x 20 x 0.9 mm 8-12 Vario	3651822
4 680 x 20 x 0.9 mm 10-14 Vario	3651824
4 680 x 27 x 0.9 mm 6-10 Vario	3651830
4 680 x 27 x 0.9 mm 8-12 Vario	3651832
4 680 x 27 x 0.9 mm 10-14 Vario	3651834



► Mitre stop for mitre cuts



► Manual material feed



► Circle cutting unit



► Magnifying glass



► Workplace lighting



VMBS 3612

- ➡ With 2-gear drive
- ➡ With circle cutting unit
- ➡ With mitre stop for mitre cuts
- ➡ With manual material feed
- ➡ Saw band guide height-adjustable via hand wheel



VMBS 3612E

- ➡ With 2-gear drive
- ➡ With electric table feed
- ➡ With circle cutting unit
- ➡ With mitre stop for mitre cuts
- ➡ Saw band guide height-adjustable via hand wheel

Models	VMBS 3612	VMBS 3612E
Art. no.	3953611	3953612
Technical data		
Throat	915 mm	915 mm
max. cutting height	305 mm	305 mm
Table size	600 x 700 mm	600 x 700 mm
Table size additional table	450 x 700 mm	450 x 700 mm
Working height	1 016 mm	1 016 mm
Table swivel range left/right	10°/45°	10°/45°
Table swivel range front/rear	-	-
Saw band length	5 020 mm	5 020 mm
max. saw band width	27 mm	27 mm
Saw band speed (1st gear)	15 - 125 m/min	15 - 125 m/min
Saw band speed (2nd gear)	165 - 1 500 m/min	165 - 1 500 m/min
Saw band welding device performance	19 mm	19 mm
Wheel Ø	515 mm	515 mm
Ø Additional wheel at top	368 mm	368 mm
Motor output 400 V / 50 Hz	2.2 kW	2.2 kW
Table travel	-	-
Max. table load	350 kg	350 kg
Dimensions	1 760 x 810 x 2 060 mm	1 760 x 810 x 2 060 mm
Weight	800 kg	835 kg

Saw bands for metal-cutting band saws

VMBS 3612 / VMBS 3612 E (bi-metal M 42)

5 020 x 13 x 0.65 mm 6-10 Vario	3651910
5 020 x 13 x 0.65 mm 8-12 Vario	3651912
5 020 x 13 x 0.65 mm 10-14 Vario	3651914

5 020 x 20 x 0.9 mm 6-10 Vario	3651920
5 020 x 20 x 0.9 mm 8-12 Vario	3651922
5 020 x 20 x 0.9 mm 10-14 Vario	3651924

5 020 x 27 x 0.9 mm 6-10 Vario	3651930
5 020 x 27 x 0.9 mm 8-12 Vario	3651932
5 020 x 27 x 0.9 mm 10-14 Vario	3651934

Metal-cutting band saws

The various heavy-duty, industrial type metal-cutting band saw operating concepts - user friendly and clear cut



BMBS 230 x 280 H-DG



BMBS 300 x 320 CNC-G



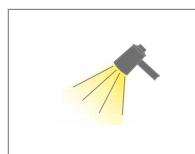
BMBS 300 x 320 HA-DG



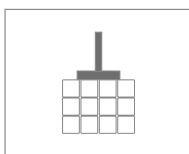
HMBS 500 x 750 HA-DG-X



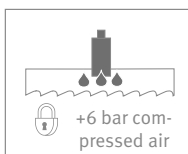
Explanation of the various equipment and accessory details:



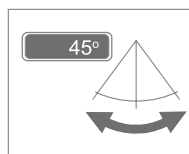
Workplace lighting



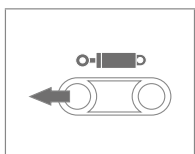
hydr. bundle clamping unit



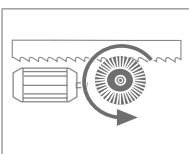
Micro-spraying system



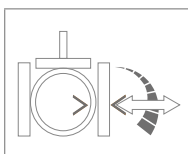
Digital angle display on saw arm



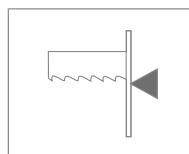
Hydraul. band tensioning unit



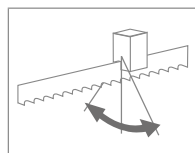
Motorised swarf brush



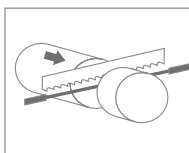
Pressure regulator on vice



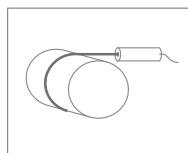
Display for lowering speed at control panel (mm/min)



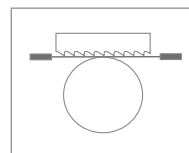
Cut path monitoring



Material start sensor



Cutting line laser



Autom., zero-contact setting of upper working position



Explanation of the METALLKRAFT designations
Metal-cutting band saws with heavy-duty industrial design

BMBS	Swivel frame Metal Band Saws
HMBS	Horizontal Metal Band Saws
HVMB	Horizontal/Vertical Metal-cutting Band Saws
G	Machine cuts simple mitres (G)
DG	Machine cuts Double mitres (G)
H	Saw with partially hydraulically controlled functions
HA	(H) Semi-Automatic machine
NC	Partially automated NC operation
CNC	Automated CNC operation
X	advanced electronics taking the material properties into consideration



Commissioning & professional initial training

When purchasing a Metallkraft machine, we recommend that customers call in one of our specialists to complete commissioning and provide induction training on site.

Commissioning and initial training for standard machines	Art. no. EINWMET
Initial training & training for CNC controls	EINWCNCMET
Duration of commissioning and initial training for custom machines*	EINWGBPMET

* DBM, MBBS, FSM, HTBS, MSBM Pro, controlled PRM and MRB, GBP, LMS 400A and metal band saws with X-control

Commissioning includes:

- Installing the machine
- (Unloading and transporting the machine to the installation location; providing the electrical and pneumatic connections, and the floor anchors or assembly plates are the purchaser's responsibility.)
- Cleaning, tooling and aligning
- Checking all functions

Initial training on the machine includes:

- an exhaustive explanation of the controls
- an explanation of the individual functions
- Setting and explaining the basic parameters
- Explaining the safety instructions as per best practices

For programmable models, additionally:

- an exhaustive explanation of the controls
- an explanation of the individual functions
- Setting and explaining the basic parameters
- Explaining the safety instructions as per best practices

Duration of commissioning and initial training: 8 hours per day, including travel times to and from the site, plus travel expenses at €0.69 per km, plus any charges for overnight stays as applicable.

If the initial training time is 8 hours, the travel time is invoiced at €48 /hour.

This also applies for any different or additional services, which must be ordered separately on site and will be invoiced on individual basis.

If the customer requires and requests installation and connecting of the machine, the customer is obliged to support our technician to the best of customer's ability and to provide the required helpers, tools and equipment at customer's own expense.

The control panel on our H models

Function of our H models:

The Version H saws have a hydraulic cylinder that controls lowering of the saw arm. The operator can switch between manual mode and gravity mode with a selector switch. In manual mode,

the sawing arm is lowered by hand. In gravity mode, the sawing action is started by pressing a pushbutton; the saw arm is lowered through its own weight; the lowering speed can be regulated using a choke valve under the control panel.

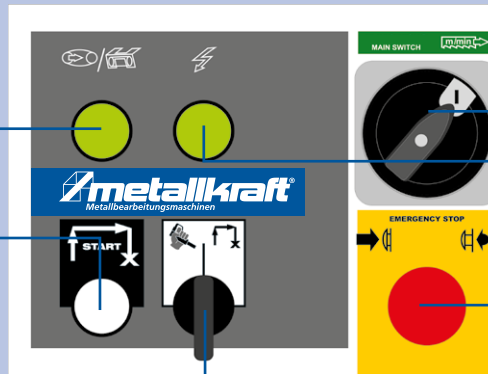
The cut is executed at the selected band speed, and the saw band stops automatically after completing the cutting action. The saw arm is always lifted manually. The lowering cylinder automatically shuts off on reaching the top end position.

Standard

- ▶ Check lamp for saw band tension:
- lit green when the band tension is correct and the saw band cover is closed

- ▶ Start of cycle - pressing the button starts the sawing action.

- ▶ Switch for switching the mode
Work mode switches between manual and gravity mode (lowering of the saw arm through its own weight)



- ▶ Switch for selecting the band speed in 2 stages, e.g.: Position 1: 35 m/min., Position 2: 70 m/min.
- ▶ This switch is the main switch at the same time

Indicator lamp shows whether the machine is switched on at the main switch

Emergency off switch - switches the machine off during a cycle

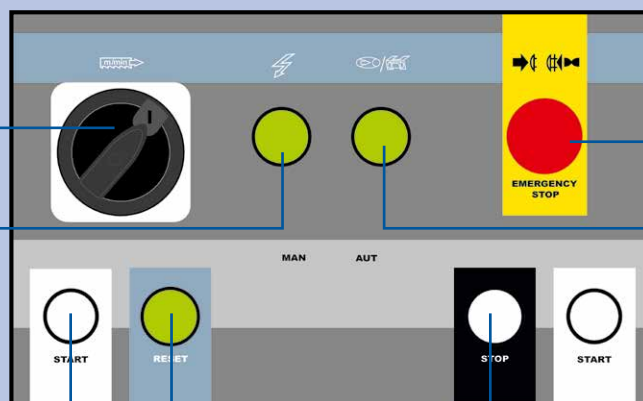
BMBS 300 x 320 H-DG

- ▶ Switch for selecting the belt speed in 2 stages, e.g.,:
Position 1: 35 m/min.
Position 2: 70 m/min.

- ▶ Check lamp for saw band tension:
- lit green when the band tension is correct and the saw band cover is closed

- ▶ Start of cycle - pressing the button starts the sawing action.

- ▶ RESET button



Emergency off switch - switches the machine off during a cycle

Indicator lamp shows whether the machine is switched on at the main switch

Stop switch - switches the machine off during a cycle

Metal-cutting band saw controls

The control panel on the semi-automatic machines (HA)

Function of the semi-automatic machines:

The Version HA sawing machine have hydraulic functions that support a semi-automatic mode of operation. After starting the machine, the vice automatically clamps the workpiece. The saw cut

is performed at the selected band speed. The lowering motion automatically stops at the bottom end position; the saw arm moves to its top end position. The vice opens automatically so that the operator only needs to move the material.

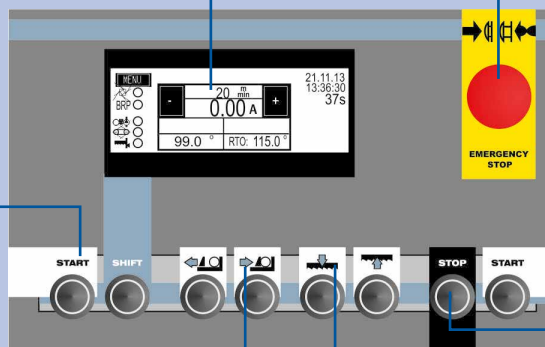
The sawing action can be interrupted at any time by enabling the stop function. The band is freed and the saw arm moves out of the cutting channel without opening the vice or switching off the machine.

- ▶ Large digital display with functions such as:
 1. MENU button for actuating the various menu items shown on the screen
 2. Workpiece/cut counter
 3. BRP display*
 4. Hydraulic system status display
 5. Saw band tension display
 6. Saw arm position display
 7. Saw band speed display

- ▶ Start of cycle - pressing the button starts the saw's processing cycle. The saw arm must be in the top end position for this to happen.

- ▶ Vice control - if the vice is still open before the cycle starts, the control unit automatically closes it after starting the cycle, and opens it again after completing the work step.

- ▶ Saw arm control - controls the up and down motion of the saw arm



- ▶ Emergency off switch - switches the machine off during a cycle

Control field

START

- ▶ in semi-automatic mode, for starting the cut
- ▶ For safety reasons, both start buttons must be pressed at the same time

STOP

- ▶ Interrupts the cut in any position
- ▶ The cycle continues after pressing the Start button

*BRP - saw band monitoring

The BRP display is activated if a maximum value of the saw band motor in Amperes is exceeded. The sawing frame stops the feed motion while the saw band continues to run and discharges the swarf from the cutting channel. Once the load on the saw band has been reduced to a minimum, the sawing process continues normally.

The control panel on the semi- and fully-automatic CNC versions

Saws with CNC control can be operated in semi- and fully-automatic mode.

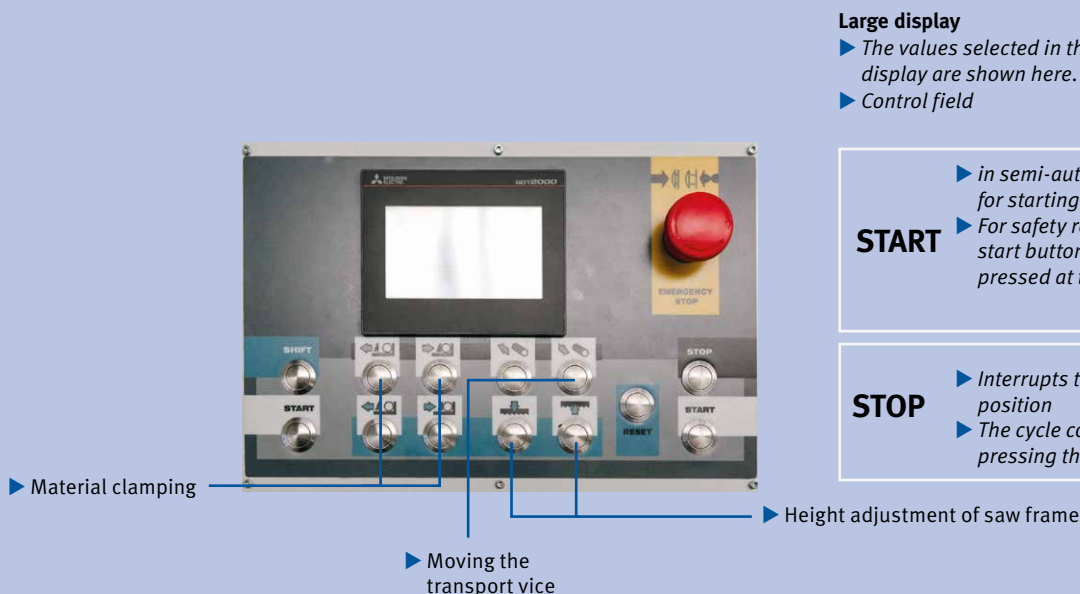
Function of the semi-automatic machines:

In semi-automatic mode, the saw works as stated in the function description for semi-automatic machines.

Fully-automatic operating mode:

Nine different tasks can be programmed on the fully-automatic CNC versions. The program contains the steps and cut lengths for each task. The work steps for feeding in the material are automatically computed by a processor. It is possible to call up

various cutting sequences and automatically run programs with different cutting lengths one after another.



Large display

- ▶ The values selected in the information display are shown here.
- ▶ Control field

START

- ▶ in semi-automatic mode, for starting the cut
- ▶ For safety reasons, both start buttons must be pressed at the same time

STOP

- ▶ Interrupts the cut in any position
- ▶ The cycle continues after pressing the Start button

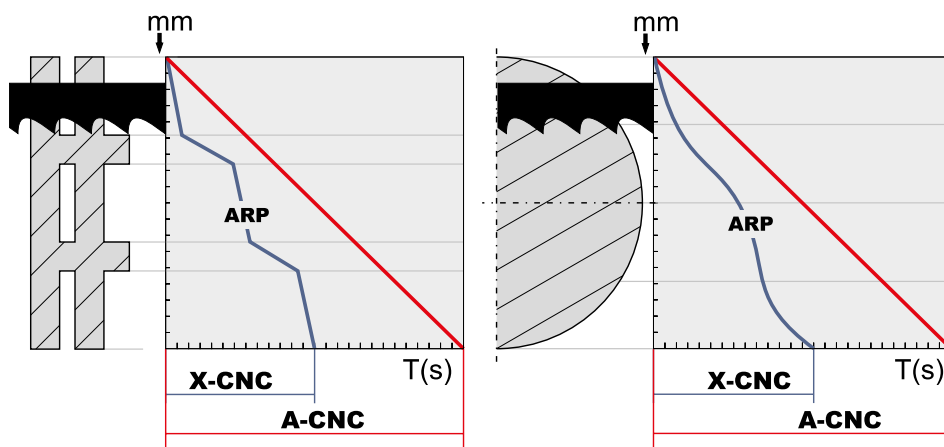
*BRP - saw band monitoring

The BRP display is activated if a maximum value of the saw band motor in Amperes is exceeded. The sawing frame stops the feed motion while the saw band continues to run and discharges the swarf from the cutting channel. Once the load on the saw band has been reduced to a minimum, the sawing process continues normally.

The control panel on the semi-automatic HA-X models



Function of the ARP system for high precision cuts and a long service life



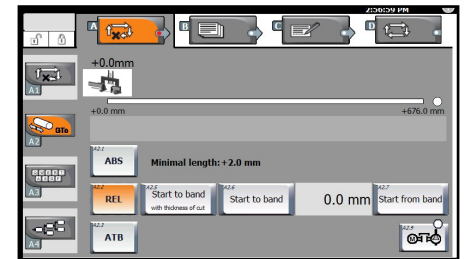
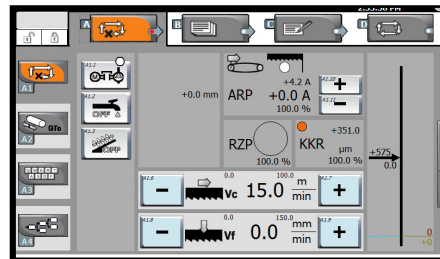
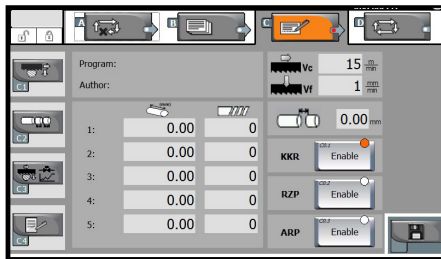
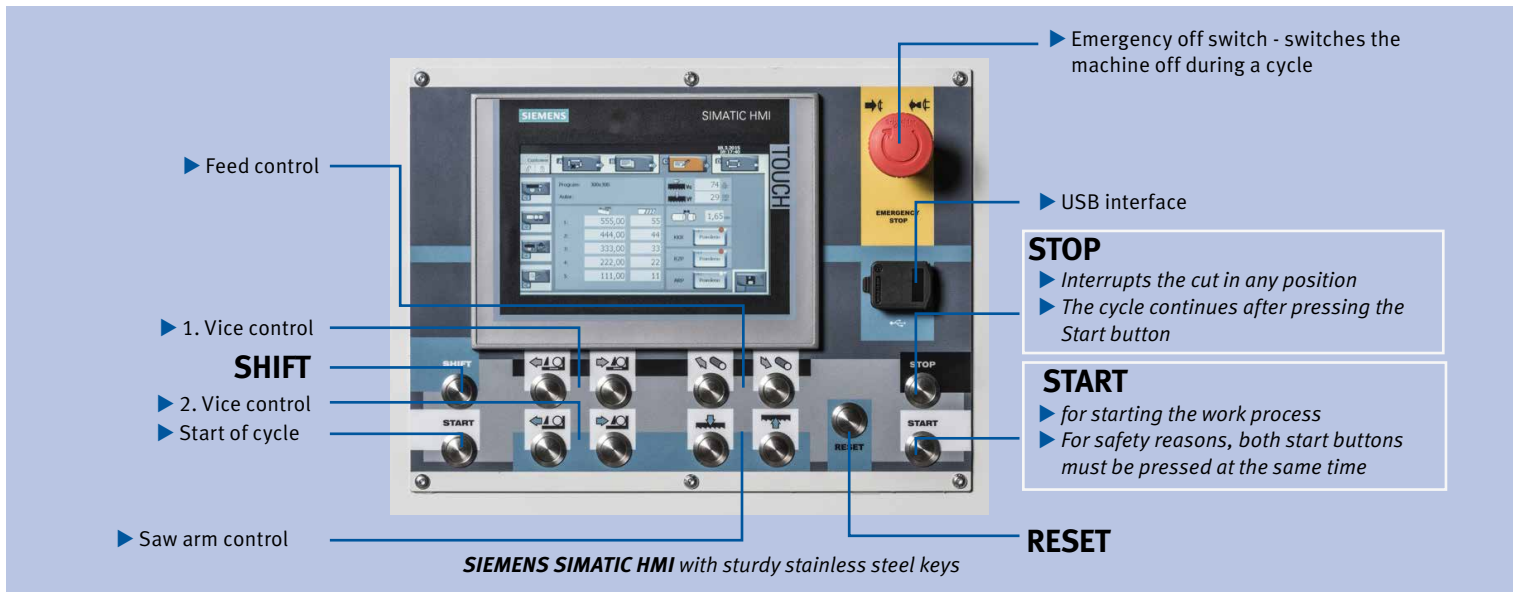
The ARP system ensures automatic control of saw arm movements depending on the material's current cutting resistance value based on the cutting forces that occur. As the resistance increases, the ARP system automatically reduces the lower speed, thus ensuring optimum cutting results with a high degree of angular precision.

As the resistance drops, the ARP accelerates the lowering speed. The automatically optimised lowering speed automates the work process and increases the saw blade's service life. The ARP system is delivered with all X version saws. **This helps you save money with improved cutting results, and you benefit from the improved saw band service life.**



Metal-cutting band saw controls

The control panel of our X models for 90° cuts



User-friendly environment:

- The control system communicates with the machine operator in the operator's native language
- Graphical touchscreen with intuitive control and understandable pictograms
- Four windows for optimising the required parameters for a quick start of operations

Technical description

- Data transmission option via the USB interface
- Multiple access levels protected by user accounts
- Easy uploading of new software versions

Function description:

- The control system supports creating up to 1 000 programs with cutting parameters. Each program can be quickly found with a search filter (depending on the quality of the material, order number, number of workpieces, cut lengths, cutting data and much more).
- **KKR mode (option):** Cutting path control permanently measures the straightness of the cut
- **ARP mode:** The automatic cut feed control has been further optimised so that the operator only need to set the load stages (Amperes) during the cut. We recommend using this function when cutting materials with different wall thicknesses (cross cut).

- **RZP mode:** Cut feed control by setting the cutting zones to match the cross-section shape and size of the material to be processed (recommended with HM saw bands)

Setting up the material feed:

- Normal, staged, *TOF* (= incremental), *CMU* (= feed with automatic opening of the cutting zone)

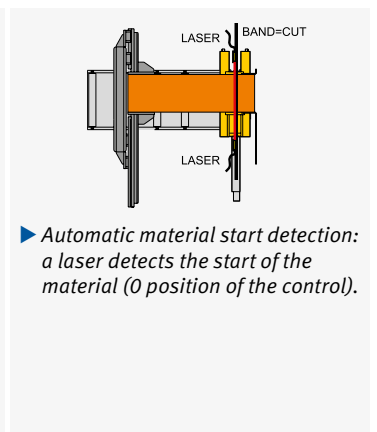
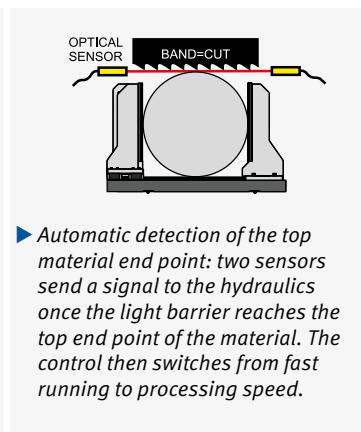
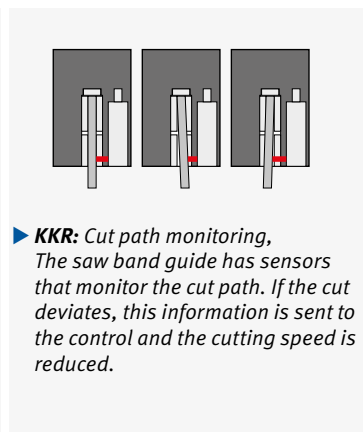
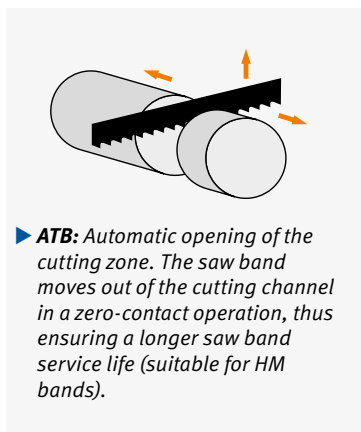
Improved GTO mode:

- Feed to the selected position. Functions: *ABS*, *REL*, *ATB*

ATB mode:

- Automatic movement of the material into the cutting zone, without needing to perform a pilot cut after inserting new material into the machine.

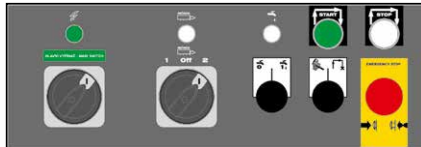
! Available as a factory option for the models HMBS 300 x 300 CNC, HMBS 400 x 400 CNC, HMBS 510 x 510 CNC, HMBS 700 x 750 CNC, HMBS 850 x 1 000 CNC:



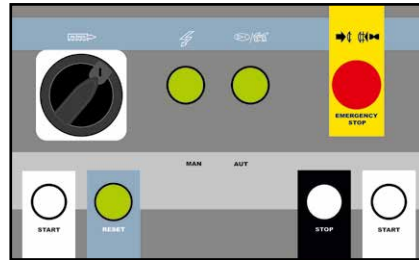
The control panels on our H models



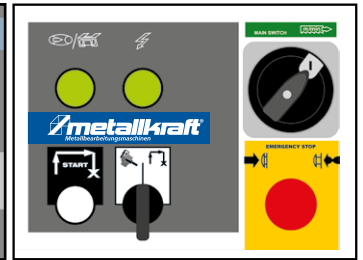
BMBS 220 x 250 H-G



BMBS 250 x 315 H-DG

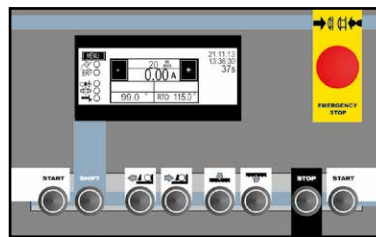


BMBS 300 x 320 H-DG



BMBS 230 x 280 H-DG

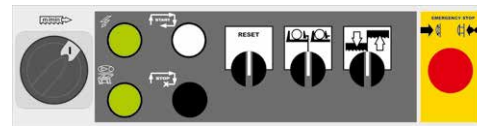
The control panels on our HA models



BMBS 230 x 280 HA-DG

BMBS 300 x 320 HA-DG

BMBS 460 x 600 HA-DG



BMBS 250 x 315 HA-DG

The control panels on our CNC models



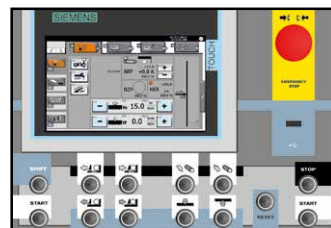
BMBS 230 x 280 CNC

BMBS 300 x 320 CNC

HMBS 400 CNC

HMBS 360 x 500 CNC

The control panels on our X models



HMBS 300 x 300 CNC X

HMBS 340 CNC-DG-X

HMBS 400 x 400 CNC X

HMBS 510 x 510 CNC X

HMBS 700 x 750 HA X

HMBS 700 x 750 CNC X

HMBS 850 x 1000 CNC X

HMBS 5000 CNC X

HVMB 850 x 1000 Xtreme

HMBS 1200 x 1400 HA X

HVMB 1200 x 1600 Xtreme



HMBS 500 x 750 NC-DG X BC 2000

HMBS 500 x 750 HA-DG X

BMBS 220 x 250 H-G

Hydraulic swivel frame metal-cutting band saw for mitre cuts of up to +60°.

Manual

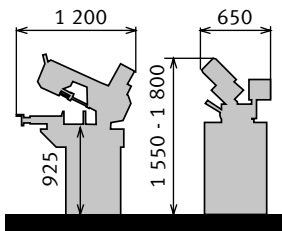
- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ Horizontally swivelling saw arm
- ▶ Two-pole drive motor supports saw band speeds of 30 and 65 m/min
- ▶ Saw band tension monitoring - electro-mechanically via micro-switches
- ▶ When the saw arm lifts, the solenoid valve locks the lowering cylinder in top position, thus removing the need for additional locking on the cylinder
- ▶ Saw arm tilted by 25° for a longer saw band service life
- ▶ Precise and sturdy band guides with adjustable tungsten carbide plates
- ▶ After completing the cutting action, the saw band automatically stops in the bottom end position.
- ▶ Saw arm lowering through gravity or manually
- ▶ With continuously variable, constant saw arm lowering speed via hydraulic cylinder



! For an exhaustive explanation of the controls, see pages 227 – 231



BMBS 220 x 250 H-G



BMBS 220 x 250 H-G

! We are always happy to perform sample cutting for your material. Call us for details!

- Scope of delivery:**
- › Saw band
 - › Coolant pump
 - › Operating tool
 - › Adjustable stop

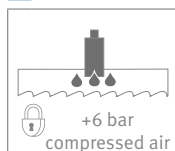
Model	BMBS 220 x 250 H-G
Art. no.	3680001
Technical specifications	
Motor output 3 x 400 V/50 Hz	0.75-1.1 kW
Speed stages	2
Saw band speeds	30 / 65 m/min
Saw band dimensions	2 450 x 27 x 0.9 mm
Dimensions (L x W x H)	1 200 x 650 x 1 800 mm
Table height material feed	925 mm
Weight	270 kg

Clamping ranges

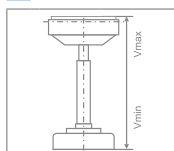
mm	0°	45°	60°	$\frac{b}{a \times b}$
	220	160	90	X
	120 *	85 *	55 *	X
	230 x 190	160 x 90	90 x 90	230 x 120

* recommended values

3640010

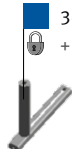


3649167



3649078

+ 3649080



3649080



3649079

+ 3649080+ 3649078



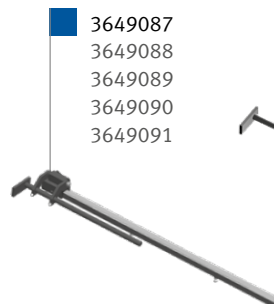
3649087

3649088

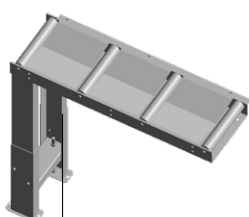
3649089

3649090

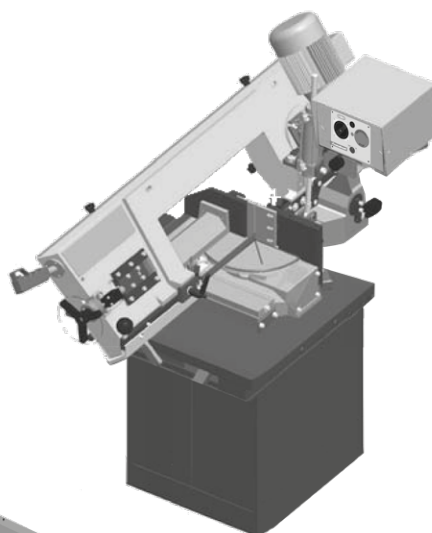
3649091



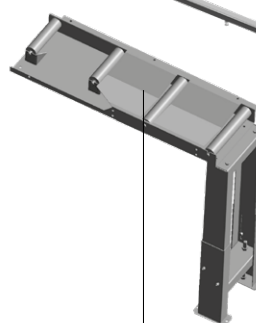
3649092



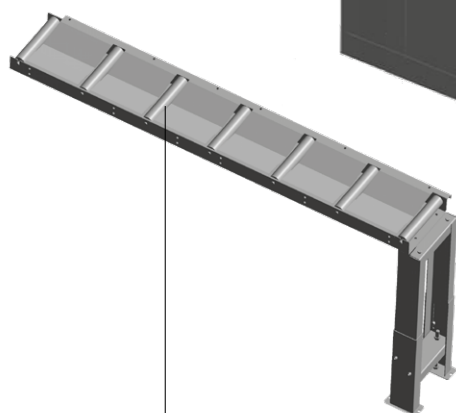
3649076



3649087



3601751



3649077



3649166



3649170

Optional accessories (only available from factory)

Motor + gearbox for cutting stainless steel (23/46 m/min.) 3640076

Roller conveyors 290 mm (incl. legs)

1 000 x 290 mm, roller conveyor 200 kg/m 3649076

2 000 x 290 mm, roller conveyor 200 kg/m 3649077

Connecting roller conveyor f. 60° cuts between saw and roller conveyor incl. connecting parts 3649170

M42 saw bands

2 450 x 27 x 0.9 mm 5-8 TPI Sprint 3655122

2 450 x 27 x 0.9 mm 10-14 TPI Sprint 3655123

2 450 x 27 x 0.9 mm 3-4 TPI Sprint Plus 3655120

2 450 x 27 x 0.9 mm 2-3 TPI Sprint Plus 3655121

2 450 x 27 x 0.9 mm 4-6 TPI Sprint-Medium-VS 3655119

2 450 x 27 x 0.9 mm 3-4 TPI X-FIT (PU=5) 3655800

2 450 x 27 x 0.9 mm 4-6 TPI X-FIT (PU=5) 3655801

Accessories, roller conveyors 290 mm

Coolant concentrate 5 l 3601751

Spraying agent 5 l, micro-dosing unit 3608020

lateral Steering roll 200 mm, mobile 3649078

(requires: 3649080*)

lateral Guide roller 200 mm, rigid 3649080

Horizontal bundle clamping roller 290 mm 3649079

(requires: 3649080* + 3649078*)

Additional leg for increasing the load bearing capacity 3649166

Roller support, height-adjustable, width 290 mm, 3649167

load-bearing capacity 200 kg

Roller support, height-adjustable, width 280 mm, 3649169

load-bearing capacity 100 kg

1 m folding stop with measuring scale 3649087

2 m folding stop with measuring scale 3649088

3 m folding stop with measuring scale 3649089

4 m folding stop with measuring scale 3649090

5 m folding stop with measuring scale 3649091

additional stop 3649092

* must be ordered with your order!

When ordering a roller conveyor, always state whether you need a feed or discharge conveyor

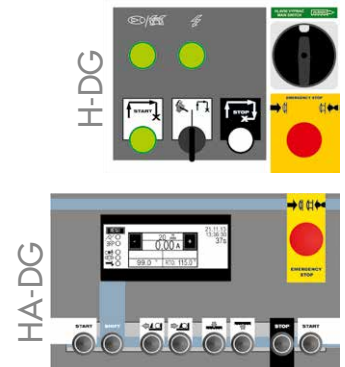
More saw bands and info on Page 283

BMBS 230 x 280 H-DG / BMBS 230 x 280 HA-DG

Hydraulic swivel frame metal-cutting band saw for mitre cuts from +60° to -45°, HA version fully-hydraulic with semi-automatic mode of operation

- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ Precise and sturdy band guides with adjustable tungsten carbide plates
- ▶ Saw band tension monitoring - electro-mechanically via micro-switches
- ▶ with cooling system on the saw band guides
- ▶ with swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ When the saw arm lifts, the solenoid valve locks the lowering cylinder in top position, thus removing the need for additional locking on the cylinder (H-DG)
- ▶ Continuously variable band speed (HA-DG)
- ▶ Saw arm tilted by 25° for a longer saw band service life
- ▶ After completing the cutting action, the saw band automatically stops
- ▶ Saw arm lowering manually or through deadweight (H-DG)
- ▶ BRP - saw band monitoring (HA-DG)
- ▶ After starting the cutting cycle, the vice automatically clamps - after completing the action, it returns to its original position (HA-DG)
- ▶ Turntable for mitre adjustment

Manual



! For an exhaustive explanation of the controls, see pages 227 – 231



Quality made in Europe



BMBS 230 x 280 H-DG

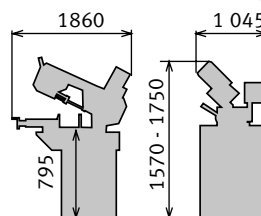


BMBS 230 x 280 HA-DG

Clamping ranges

mm	0°	45°	60°	45°	a x b
	230	195	125	185	X
	150 *	110 *	80 *	110 *	X
	280 x 180	180 x 170	120 x 110	180 x 120	180 x 120

* recommended values

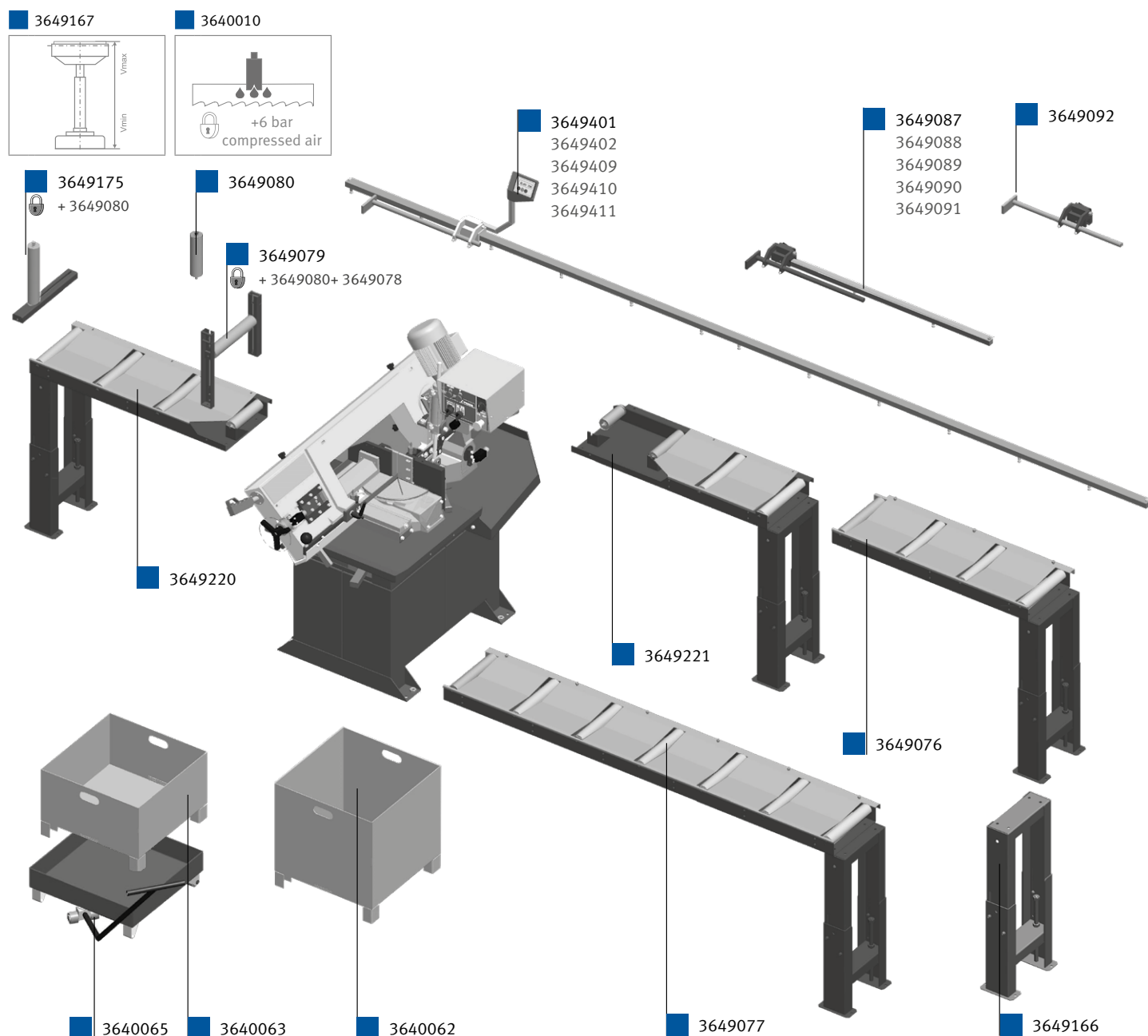


Model	BMBS 230 x 280 H-DG	BMBS 230 x 280 HA-DG
Art. no.	3680013	3690026
Technical specifications		
Motor output 3 x 400 V/50 Hz	0.75-1.1 kW	1.5 kW
Speed stages	2	Continuously variable
Saw band speeds	35 / 70 m/min	20 - 100 m/min
Saw band dimensions	2 720 x 27 x 0.9 mm	2 720 x 27 x 0.9 mm
Dimensions (L x W x H)	1 650 x 885 x 1860 mm	1860 x 1 045 x 1750 mm
Table height material feed	795 mm	795 mm
Weight	280 kg	395 kg
min. remaining workpiece length	22 mm	22 mm

Scope of delivery:

- ▶ Saw band
- ▶ Coolant pump
- ▶ Operating tool
- ▶ Vice with quick release
- ▶ Cut probe (HA-DG)
- ▶ Swivelling control panel (HA-DG)

! We are always happy to perform sample cutting for your material. Call us for details!



Optional accessories (only available from factory)		Accessories, roller conveyors 290 mm	
Micro-spraying system	3640010	Coolant concentrate 5 l	3601751
Accessories		Spraying agent 5 l, micro-dosing unit	3608020
Workpiece container	3640062	2 m folding stop with measuring scale	3649088
Swarf container	3640063	3 m folding stop with measuring scale	3649089
Trolley for swarf container and workpiece container	3640065	4 m folding stop with measuring scale	3649090
Roller conveyor width 290 mm		5 m folding stop with measuring scale	3649091
1 000 x 290 mm, roller conveyor 200 kg/m	3649076	additional stop	3649092
2 000 x 290 mm, roller conveyor 200 kg/m	3649077	1 m stop with digital measuring display	3649401
Connecting roller conveyor 1 000 x 290 mm feed side	3649220	2 m stop with digital measuring display	3649402
Connecting roller conveyor 1 000 x 290 mm discharge side	3649221	3 m stop with digital measuring display	3649409
Accessories, roller conveyors 290 mm		4 m stop with digital measuring display	3649410
lateral Steering roll 200 mm, mobile	3649078	5 m stop with digital measuring display	3649411
(requires: 3649080*)		Saw bands	
lateral Guide roller 200 mm, rigid	3649080	2 720 x 27 x 0.9 mm 5-8 TPI M42 Sprint	3655508
Horizontal bundle clamping roller 290 mm	3649079	2 720 x 27 x 0.9 mm 6-10 TPI M42 Sprint	3655510
(requires: 3649080* + 3649078*)		2 720 x 27 x 0.9 mm 10-14 TPI M42 Sprint	3655514
Additional leg for increasing the load bearing capacity	3649166	2 720 x 27 x 0.9 mm 2-3 TPI M42 Sprint Plus	3655603
Roller support, height-adjustable, width 290 mm, load-bearing capacity 200 kg	3649167	2 720 x 27 x 0.9 mm 3-4 TPI M42 Sprint Plus	3655604
1 m folding stop with measuring scale	3649087	2 720 x 27 x 0.9 mm 4-6 TPI M42 Sprint-Medium-VS	3655606
(requires: 3649076*)		2 720 x 27 x 0.9 mm 2-3 TPI M51 Sprint Plus	3655703
		2 720 x 27 x 0.9 mm 3-4 TPI M51 Sprint Plus	3655704
		2 720 x 27 x 0.9 mm 4-6 TPI M51 Sprint Plus	3655706
		2 720 x 27 x 0.9 mm 3-4 TPI X-FIT (PU=5)	3655805
		2 720 x 27 x 0.9 mm 4-6 TPI X-FIT (PU=5)	3655806

* must be ordered with your order!

Automatic pivot frame metal-cutting band saw for mitre cuts from 0° to +60° right

- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ Precise and sturdy band guides with adjustable tungsten carbide plates
- ▶ Hydraulically controlled system for both vises, and the saw arm's up and down motion
- ▶ Material feed via ball screw
- ▶ With swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ Saw arm tilted by 25° for a longer saw band service life
- ▶ BRP - saw band monitoring
- ▶ The jaws on the two vises are equipped with long stroke hydraulic cylinders as standard; this removes the need to preset to the material cross-section to be cut
- ▶ With pivoting cutting gap for mitre adjustment -> thus avoiding cutting the saw table

Automatic



! For an exhaustive explanation of the controls, see pages 227 – 231



We are always happy to perform sample cutting for your material. Call us for details!

Scope of delivery:

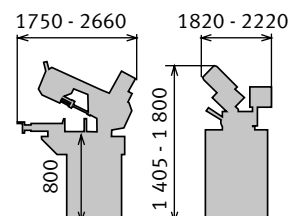
- › Saw band
- › Operating tool
- › Vice with quick release

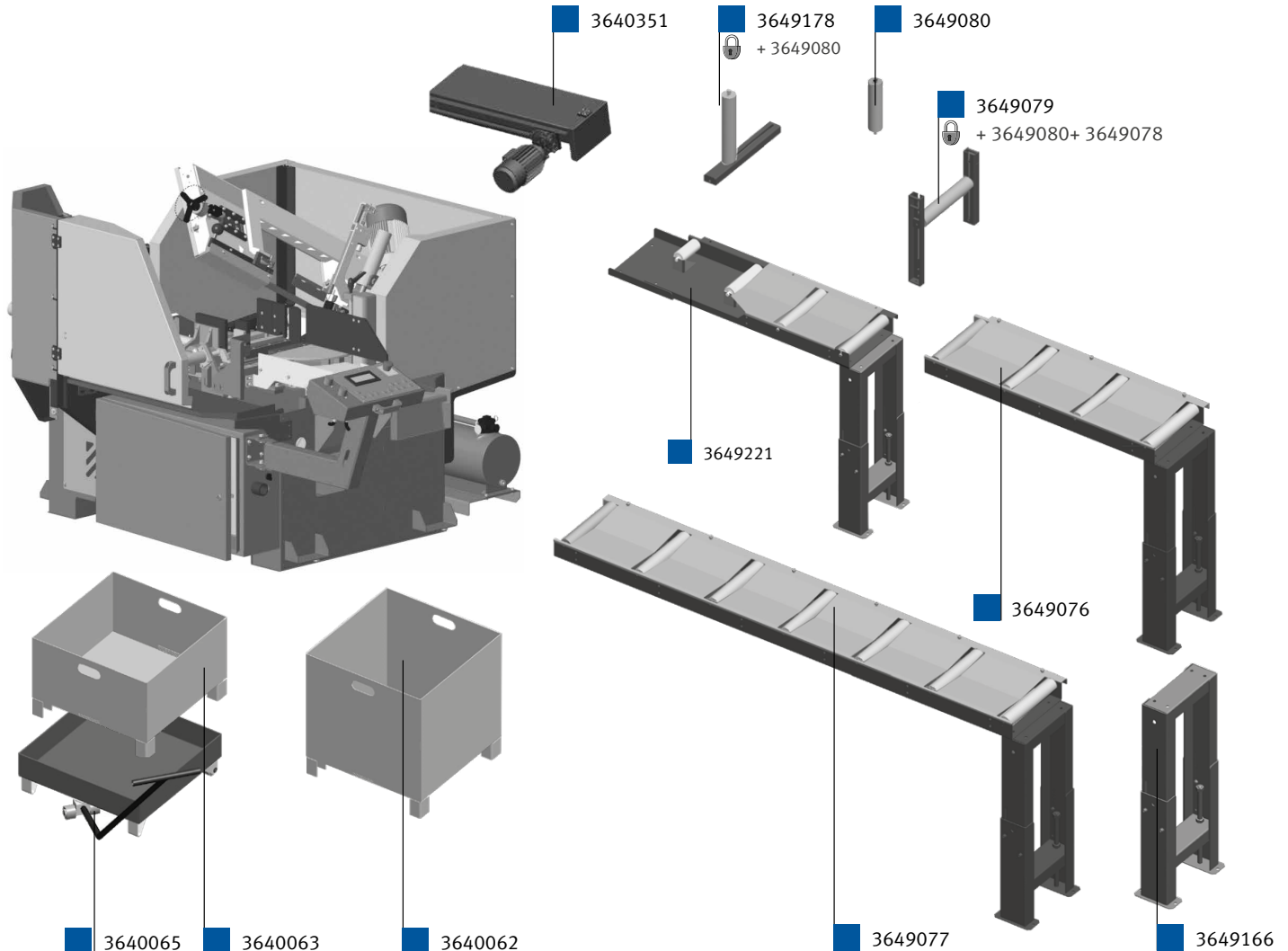
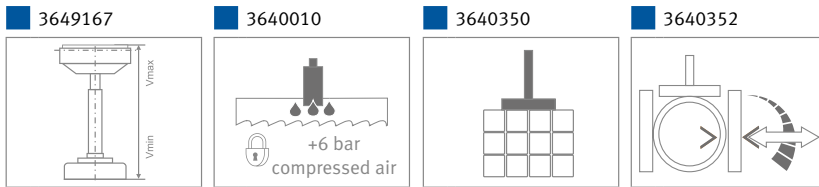
Model	BMBS 230 x 280 CNC-G
Art. no.	3690053

Technical specifications	
Motor output 3 x 400 V/50 Hz	1.5 kW
Speed stages	Continuously variable
Saw band speeds	20 - 100 m/min
Saw band dimensions	2 720 x 27 x 0.9 mm
Dimensions (L x W x H)	2 305 x 2 260 x 1 780 mm
Table height material feed	800 mm
Weight	770 kg
min. remaining workpiece length	120 + 20 mm

Clamping range

mm	0°	45°	60°	
	230	180	100	X
	150*	110*	80*	X
	280 x 210	180 x 150	100 x 70	280 x 130





Optional accessories (only available from factory)

Art. no.	
3640010	Micro-spraying system
3640350	Hydraulic bundle clamping unit
3640351	Chip conveyor
3640352	Pressure regulator on vice

Accessories

3640062	Workpiece container
3640063	Swarf container
3640065	Trolley for swarf container and workpiece container

Roller conveyor width 290 mm

3649076	1 000 x 290 mm, roller conveyor 200 kg/m
3649077	2 000 x 290 mm, roller conveyor 200 kg/m
3649221	Connecting roller conveyor 1 000 x 290 mm discharge side

Accessories, roller conveyors 290 mm

3649078	lateral Steering roll 200 mm, mobile (requires: 3649080*)
3649080	lateral Guide roller 200 mm, rigid
3649079	Horizontal bundle clamping roller 290 mm (requires: 3649080* + 3649078*)
3649166	Additional leg for increasing the load bearing capacity
3649167	Roller support, height-adjustable, width 290 mm, load-bearing capacity 200 kg

Saw bands

3655508	2 720 x 27 x 0.9 mm 5-8 TPI M42 Sprint
3655510	2 720 x 27 x 0.9 mm 6-10 TPI M42 Sprint
3655514	2 720 x 27 x 0.9 mm 10-14 TPI M42 Sprint
3655603	2 720 x 27 x 0.9 mm 2-3 TPI M42 Sprint Plus
3655604	2 720 x 27 x 0.9 mm 3-4 TPI M42 Sprint Plus
3655606	2 720 x 27 x 0.9 mm 4-6 TPI M42 Sprint-Medium-VS
3655703	2 720 x 27 x 0.9 mm 2-3 TPI M51 Sprint Plus
3655704	2 720 x 27 x 0.9 mm 3-4 TPI M51 Sprint Plus
3655706	2 720 x 27 x 0.9 mm 4-6 TPI M51 Sprint Plus
3655805	2 720 x 27 x 0.9 mm 3-4 TPI X-FIT (PU=5)
3655806	2 720 x 27 x 0.9 mm 4-6 TPI X-FIT (PU=5)

* must be ordered with your order!

More saw bands and info on Page 283

When ordering a roller conveyor, always state whether you need a feed or discharge conveyor

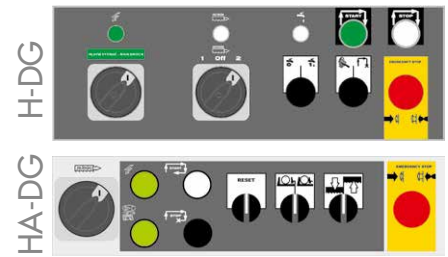
BMBS 250 x 315 H-DG / BMBS 250 x 315 HA-DG

Hydraulic swivel frame metal-cutting band saw for mitre cuts from +60° to -45°, HA version fully-hydraulic with semi-automatic mode of operation

- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ Precise and sturdy band guides with adjustable tungsten carbide plates
- ▶ When the saw arm lifts, the solenoid valve locks the lowering cylinder in top position, thus removing the need for additional locking on the cylinder
- ▶ Saw band tension monitoring - electro-mechanically via micro-switches
- ▶ with cooling system on the saw band guides
- ▶ with swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ Saw arm tilted by 25° for a longer saw band service life
- ▶ Saw lowering manually or through deadweight (H-DG)
- ▶ After completing the cutting action, the saw band automatically stops
- ▶ After starting the cutting cycle, the vice automatically clamps - after completing the action, it returns to its original position (HA-DG)

Manual

Semi-automatic



! For an exhaustive explanation of the controls, see pages 227 – 231



BMBS 250 x 315 H-DG



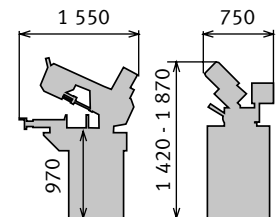
BMBS 250 x 315 HA-DG

Scope of delivery:

- ▶ Saw band
- ▶ Operating tool
- ▶ Cross-cut fence 1 metre
- ▶ Chip brush
- ▶ Coolant pump

! We are always happy to perform sample cutting for your material. Call us for details!

Model	BMBS 250 x 315 H-DG	BMBS 250 x 315 HA-DG
Art. no.	3680007	3690093
Technical specifications		
Motor output 3 x 400 V/50 Hz	0.75-1.1 kW	0.75-1.1 kW
Speed stages	2	2
Saw band speeds	37 / 74 m/min	37 / 74 m/min
Saw band dimensions	2 825 x 27 x 0.9 mm	2 825 x 27 x 0.9 mm
Dimensions (L x W x H)	1 550 x 750 x 1 870 mm	1 550 x 750 x 1 870 mm
Table height material feed	970 mm	970 mm
Weight	380 kg	420 kg
min. remaining workpiece length	14 mm	14 mm

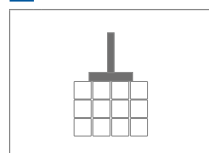


Clamping ranges BMBS 250 x 315 H-DG / 250 x 315 HA-DG

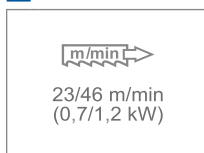
mm	0°	45°	60°	45°	a ^b
	250	190	120	170	-
	150*	110*	80*	110*	-
	290 x 200	190 x 140	120 x 140	200 x 70	200 x 120

* recommended values

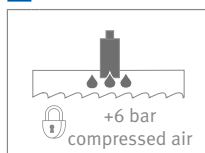
3640104



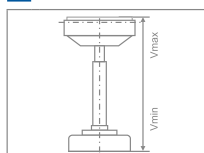
3640077



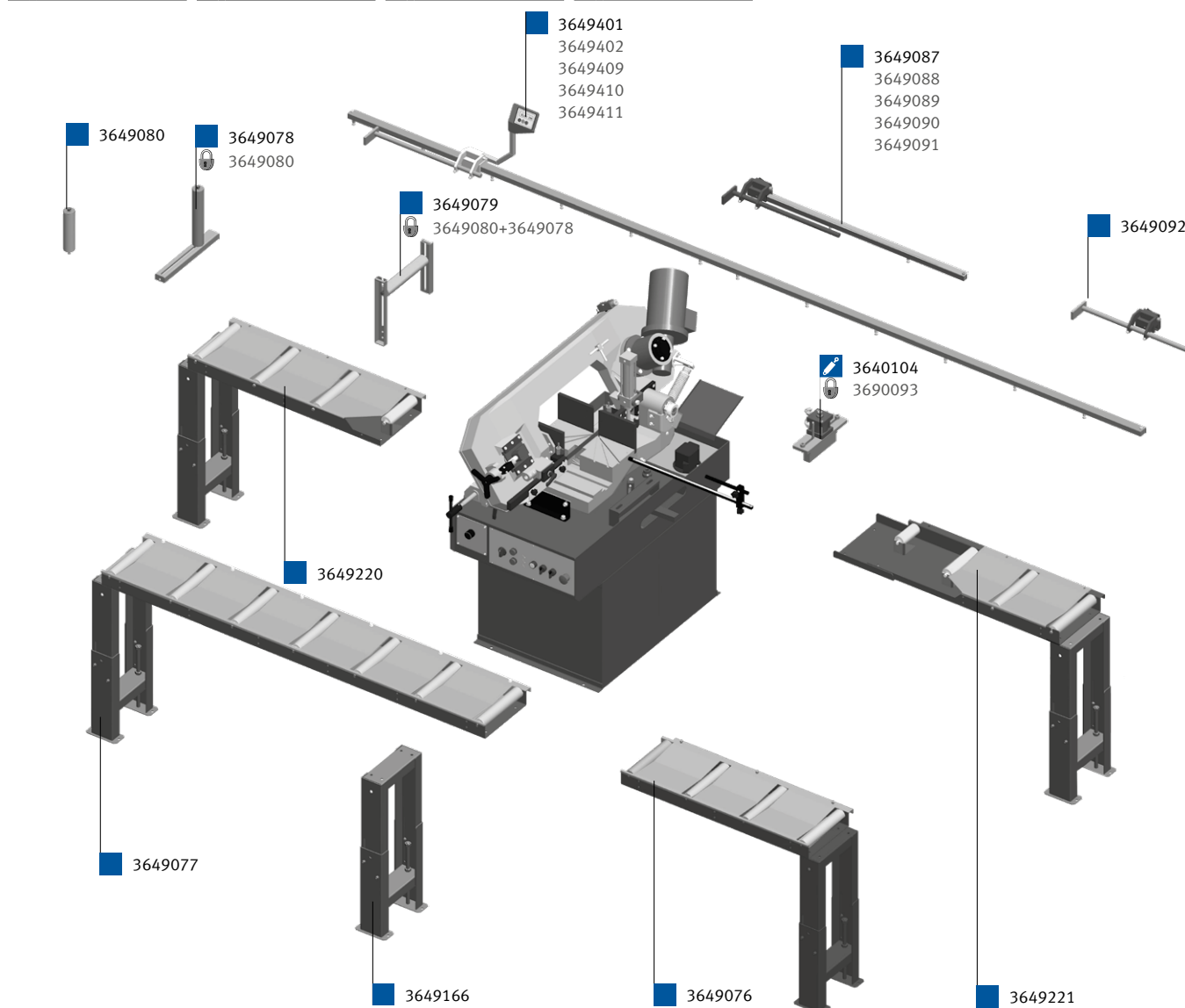
3640010



3649167



S (mm)	Vmin (mm)	Vmax (mm)
290	760	980



Optional accessories (only available from factory)

Micro-spraying system	3640010
Motor + gearbox for cutting stainless steel (23/46 m/min.)	3640077
Hydraul. Bundle clamping unit (for HA-DG only)	3640104

Accessories

Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065

Roller conveyors 290 mm (incl. legs)

1 000 x 290 mm, roller conveyor 200 kg/m	3649076
2 000 x 290 mm, roller conveyor 200 kg/m	3649077
1 000 x 290 mm connecting roller conveyor feed side	3649220
1 000 x 290 mm connecting roller conveyor discharge side	3649221

Accessories, roller conveyors 290 mm

Lateral guide roller, moving (requires: 3649080*)	3649078
Lateral guide roller, rigid	3649080
Horizontal bundle clamping roller 290 mm (requires: 3649080* + 3649078*)	3649079

Accessories, roller conveyors 290 mm

Additional leg for increasing the load bearing capacity	3649166
Roller support, height-adjustable, width 290 mm, load-bearing capacity 200 kg	3649167
1 m folding stop with measuring scale	3649087
2 m folding stop with measuring scale	3649088
3 m folding stop with measuring scale	3649089
4 m folding stop with measuring scale	3649090
5 m folding stop with measuring scale	3649091
additional stop	3649092
1 m stop with digital measuring display	3649401
2 m stop with digital measuring display	3649402
3 m stop with digital measuring display	3649409
4 m stop with digital measuring display	3649410
5 m stop with digital measuring display	3649411

M42 saw bands

2 825 x 27 x 0.9 mm 3-4 TPI Sprint Plus	3655220
2 825 x 27 x 0.9 mm 2-3 TPI Sprint Plus	3655221
2 825 x 27 x 0.9 mm 4-6 TPI Sprint-Medium-VS	3655219
2 825 x 27 x 0.9 mm 5-8 TPI Sprint	3655222
2 825 x 27 x 0.9 mm 10-14 TPI Sprint	3655223
2 825 x 27 x 0.9 mm 3-4 TPI X-FIT (PU=5)	3655810
2 825 x 27 x 0.9 mm 4-6 TPI X-FIT (PU=5)	3655811

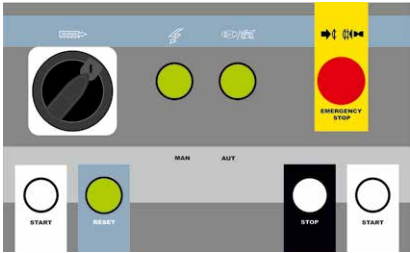
* must be ordered with your order!

BMBS 300 x 320 H-DG

Hydraulic swivel frame metal-cutting band saw for mitre cuts from +60° to -45°.

- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ With hydraulically controlled sawing functions
- ▶ Saw arm tilted by 25° for a longer saw band service life
- ▶ Saw band drive with low-maintenance, oil-lubricated worm gear
- ▶ With rugged 3-phase motor
- ▶ Motor includes overload protection
- ▶ Ball-bearing borne turntable
- ▶ With swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ Saw arm tilted by 25° for a longer saw band service life
- ▶ Swivelling saw arm from +60° to -45°
- ▶ With swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ Vice with manual material clamping unit and quick release unit for lateral adjustment of the vice

Manual



! For an exhaustive explanation of the controls, see pages 227 – 231



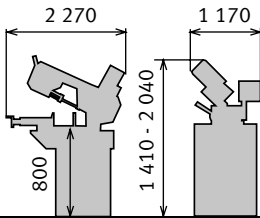
We are always happy to perform sample cutting for your material. Call us for details!

Scope of delivery:

- › Saw band
- › Operating tool
- › Cross-cut fence 1 metre
- › Swarf clearing brush
- › Swivelling control panel
- › Coolant pump

Model	BMBS 300 x 320 H-DG
Art. no.	3680012

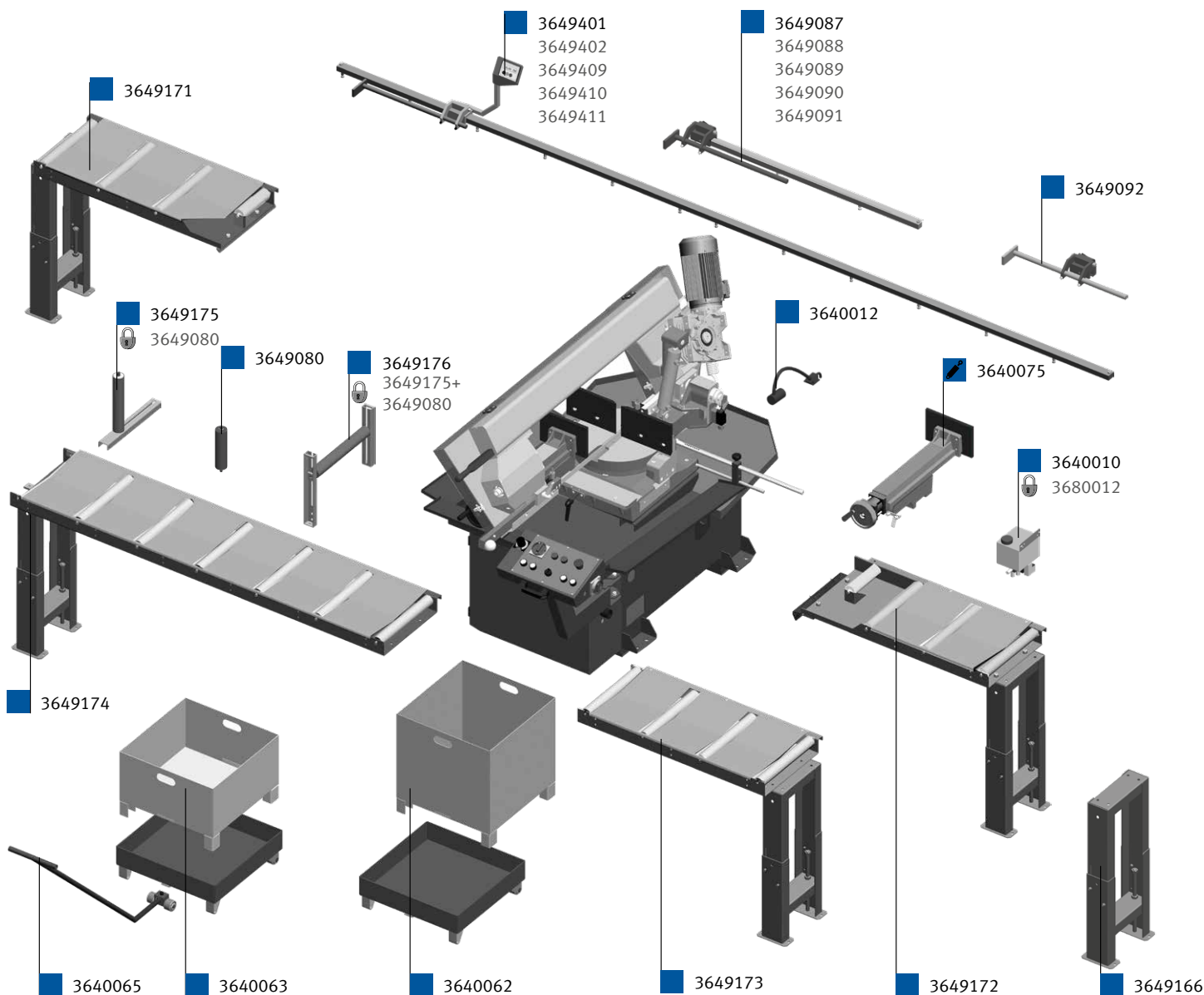
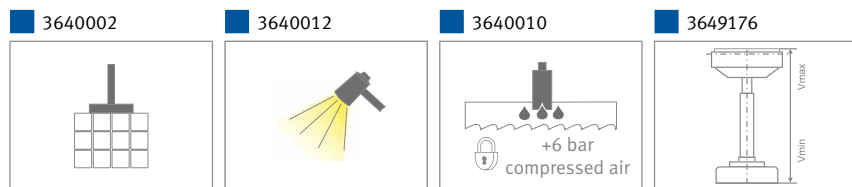
Technical specifications	
Motor output 3 x 400 V/50 Hz	1.4-2.0 kW
Speed stages	2
Saw band speeds	35 / 70 m/min
Saw band dimensions	3 660 x 27 x 0.9 mm
Dimensions (L x W x H)	2 270 x 1 170 x 2 040 mm
Table height material feed	800 mm
Weight	548 kg
min. remaining workpiece length	30 mm



Clamping ranges

mm	0°	45°	60°	45°	a ^b
	300	300	200	280	-
	180*	110*	80*	110*	-
	320 x 300	305 x 250	200 x 200	260 x 200	230 x 160

* recommended values



Optional accessories (only available from factory)	Art. no.
Workplace lighting	3640012
Micro-spraying system	3640010
Manual bundle clamping unit	3640002
Vice downstream of cut	3640075
Accessories	
Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065
Roller conveyors 390 mm	
Connecting roller conveyor 390 mm feed side, f. 60° cuts between saw and roller conveyor, 200 kg/m	3649171
Connecting roller conveyor 390 mm discharge side, f. 60° cuts between saw and roller conveyor, 200 kg/m	3649172
1 000 x 390 mm, roller conveyor 200 kg/m	3649173
2 000 x 390 mm, roller conveyor 200 kg/m	3649174
M42 saw bands	
3 660 x 27 x 0.9 mm 3-4 TPI X-FIT (PU=5)	3655815
3 660 x 27 x 0.9 mm 4-6 TPI X-FIT (PU=5)	3655816

Accessories, roller conveyors 390 mm	Art. no.
lateral Steering roll 200 mm, mobile (requires: 3649080*)	3649175
lateral Guide roller 200 mm, rigid	3649080
Horizontal bundle clamping roller 390 mm (requires: 3649080 + 3649175)	3649176
Additional leg for increasing the load bearing capacity	3649166
Roller support, height-adjustable, width 390 mm, load-bearing capacity 200 kg	3649177
1 m folding stop with measuring scale	3649087
2 m folding stop with measuring scale	3649088
3 m folding stop with measuring scale	3649089
4 m folding stop with measuring scale	3649090
5 m folding stop with measuring scale	3649091
1 m stop with digital measuring display	3649401
2 m stop with digital measuring display	3649402
3 m stop with digital measuring display	3649409
4 m stop with digital measuring display	3649410
5 m stop with digital measuring display	3649411
additional stop	3649092

* must be ordered with your order!

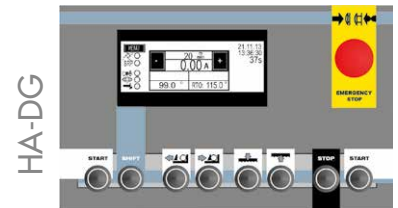
BMBS 300 x 320 HA-DG

Semi-automatic swivel frame metal-cutting band saw for mitre cuts of +60° up to -45° with frequency converter

- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ With hydraulically controlled sawing functions
- ▶ Saw arm tilted by 25° for a longer saw band service life
- ▶ Saw band drive with low-maintenance, oil-lubricated worm gear
- ▶ With rugged 3-phase motor
- ▶ Motor includes overload protection
- ▶ Ball-bearing borne turntable
- ▶ With swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ BRP - saw band monitoring
- ▶ Continuously variable band speed (**HA-DG**)
- ▶ Hydraulic vice with manual quick release for lateral adjustment
- ▶ End switches control the upper and lower end positions of the saw arm
- ▶ With cut probe

Automatic

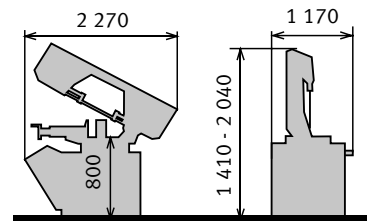
Semi-automatic



! For an exhaustive explanation of the controls, see pages 227 – 231



BMBS 300 x 320 HA-DG



Info & video



Scope of delivery:

- › Saw band
- › Operating tool
- › Cross-cut fence 1 metre
- › Cut probe
- › Swivelling control panel
- › Coolant pump

We are always happy to perform sample cutting for your material. Call us for details!

Model	BMBS 300 x 320 HA-DG
Art. no.	3690041

Technical specifications	
Motor output 3 x 400 V/50 Hz	2.4 kW
Speed stages	Continuously variable
Saw band speeds	20-100 m/min
Saw band dimensions	3 660 x 27 x 0.9 mm
Dimensions (L x W x H)	2 270 x 1 170 x 2 040 mm
Table height material feed	800 mm
Weight	585 kg
min. remaining workpiece length	30 mm

Clamping ranges

mm	0°	45°	60°	45°	 ^b / _a
	300	300	200	240	X
	180 *	110 *	80 *	110 *	X
	320 x 300	300 x 250	200 x 200	260 x 200	230 x 120

* recommended values

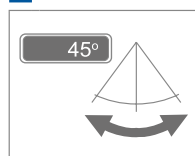


Bundle cutting with clamping device

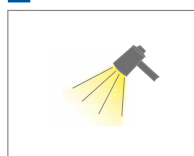


max. bundle cut ^b/_a x ^{a/_b}

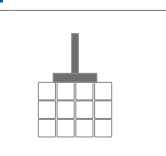
3640150



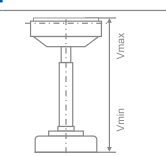
3640012



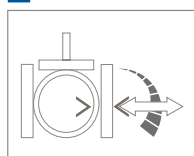
3640086



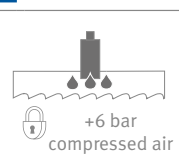
3649177



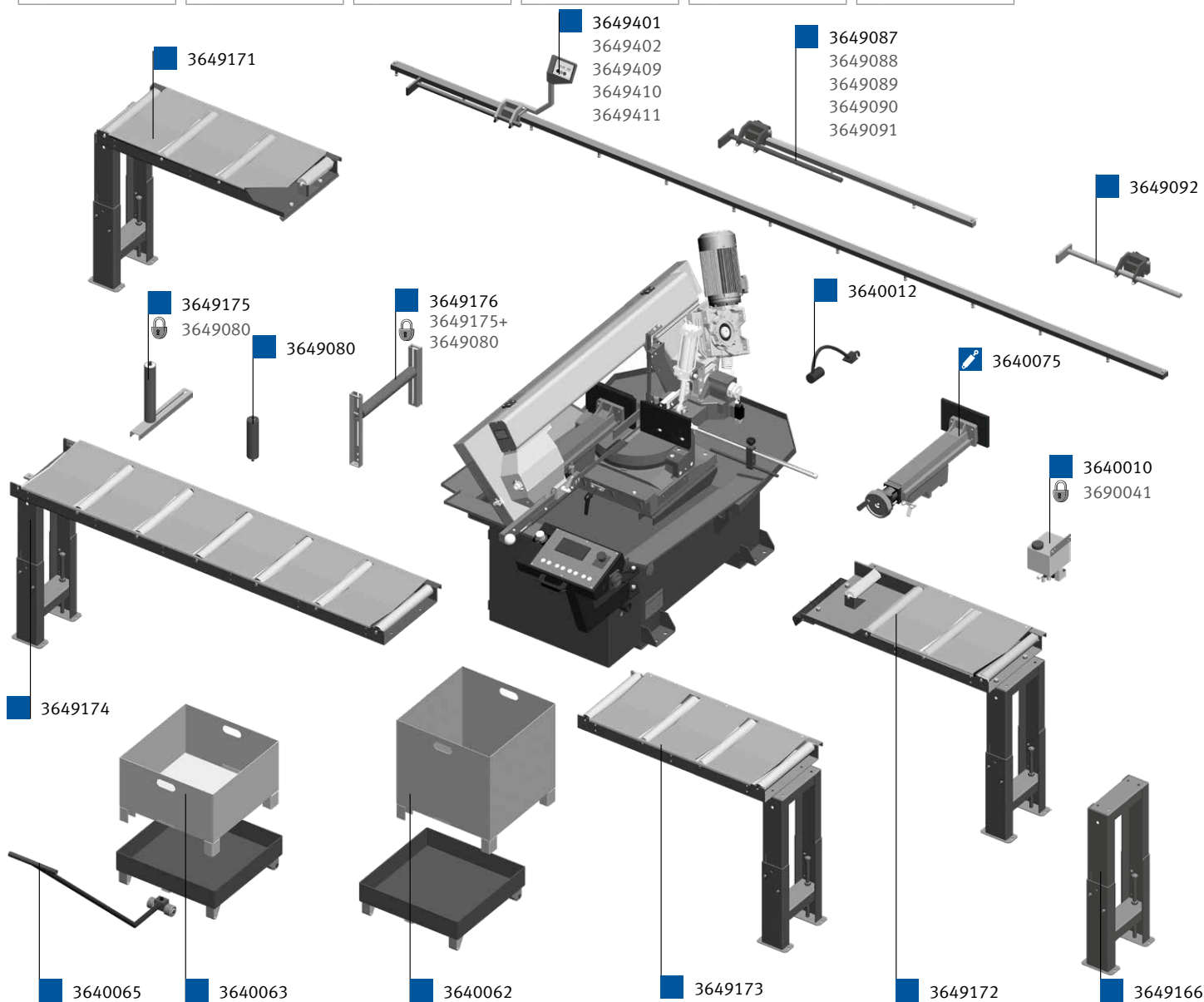
3640069



3640010



Quality
made in
Europe



Optional accessories (only available from factory)

Optional accessories (only available from factory)	Art. no.
Workplace lighting	3640012
Micro-spraying system	3640010
Pressure regulator on vice	3640069
Hydraulic bundle clamping unit for HA	3640086
Digital angle display on saw arm model 3690041	3640150
Vice downstream of cut with hydraulic material clamping	3640107

Accessories

Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065
Coolant concentrate 5 l	3601751
Spraying agent 5 l, micro-dosing unit	3608020

Roller conveyors 390 mm

Connecting roller conveyor 390 mm feed side, f. 60° cuts between saw and roller conveyor, 200 kg/m	3649171
Connecting roller conveyor 390 mm discharge side, f. 60° cuts between saw and roller conveyor, 200 kg/m	3649172
1 000 x 390 mm, roller conveyor 200 kg/m	3649173
2 000 x 390 mm, roller conveyor 200 kg/m	3649174

M42 saw bands

3 660 x 27 x 0.9 mm 3-4 TPI X-FIT (PU=5)	3655815
3 660 x 27 x 0.9 mm 4-6 TPI X-FIT (PU=5)	3655816

Accessories, roller conveyors 390 mm

Accessories, roller conveyors 390 mm	Art. no.
lateral Guide roller 200 mm, moving (requires 3649080)	3649175
lateral Guide roller 200 mm, rigid	3649080
Horizontal bundle clamping roller 390 mm (requires: 3649080 + 3649175)	3649176
Additional leg for increasing the load bearing capacity	3649166
Roller support, height-adjustable, width 390 mm, load-bearing capacity 200 kg	3649177
1 m folding stop with measuring scale	3649087
2 m folding stop with measuring scale	3649088
3 m folding stop with measuring scale	3649089
4 m folding stop with measuring scale	3649090
5 m folding stop with measuring scale	3649091
1 m stop with digital measuring display	3649401
2 m stop with digital measuring display	3649402
3 m stop with digital measuring display	3649409
4 m stop with digital measuring display	3649410
5 m stop with digital measuring display	3649411
additional stop	3649092

* must be ordered with your order!

Magnetic drilling

Deburring

Metal grinding

Cutting

Notching & punching

Bending

Presses

Circular saws

Roller conveyors

Metal-cutting band saws

BMBS 300 x 320 CNC-G

Fully-automatic CNC-controlled swivel frame metal-cutting band saw for mitre cuts of up to +60°

- ▶ Hydraulically controlled system for both vises, and the saw arm's up and down motion
- ▶ Material feed via ball screw
- ▶ Includes frequency converter as standard for continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ BRP - saw band monitoring
- ▶ The jaws on the two vises are equipped with long stroke hydraulic cylinders as standard; this removes the need to preset to the material cross-section to be cut
- ▶ With pivoting cutting gap for mitre adjustment
→ thus avoiding cutting the saw table

Automatic



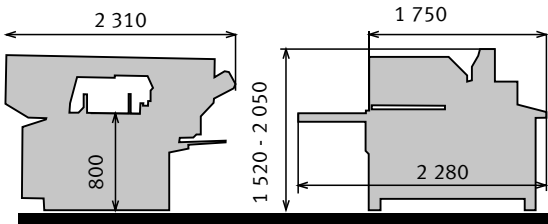
! For an exhaustive explanation of the controls, see pages 227 – 231



Info & video

- Scope of delivery:**
- › Saw band
 - › Operating tool
 - › Digital angle display
 - › Cut probe
 - › Chip brush
 - › Swivelling control panel
 - › With band tension monitoring
 - › Long stroke cylinder on both vises
 - › Frequency converter,
 - › Coolant pump

Model	BMBS 300 x 320 CNC-G
Art. no.	3690055
Technical specifications	
Motor output 3 x 400 V/50 Hz	2.4 kW
Speed stages	Continuously variable
Saw band speeds	20-100 m/min
Saw band dimensions	3 660 x 27 x 0.9 mm
Dimensions (L x W x H)	2 310 x 2 710 x 2 050 mm
Table height material feed	800 mm
Weight	800 kg
Minimum size of material	20 mm
Remaining piece length	115+20 mm

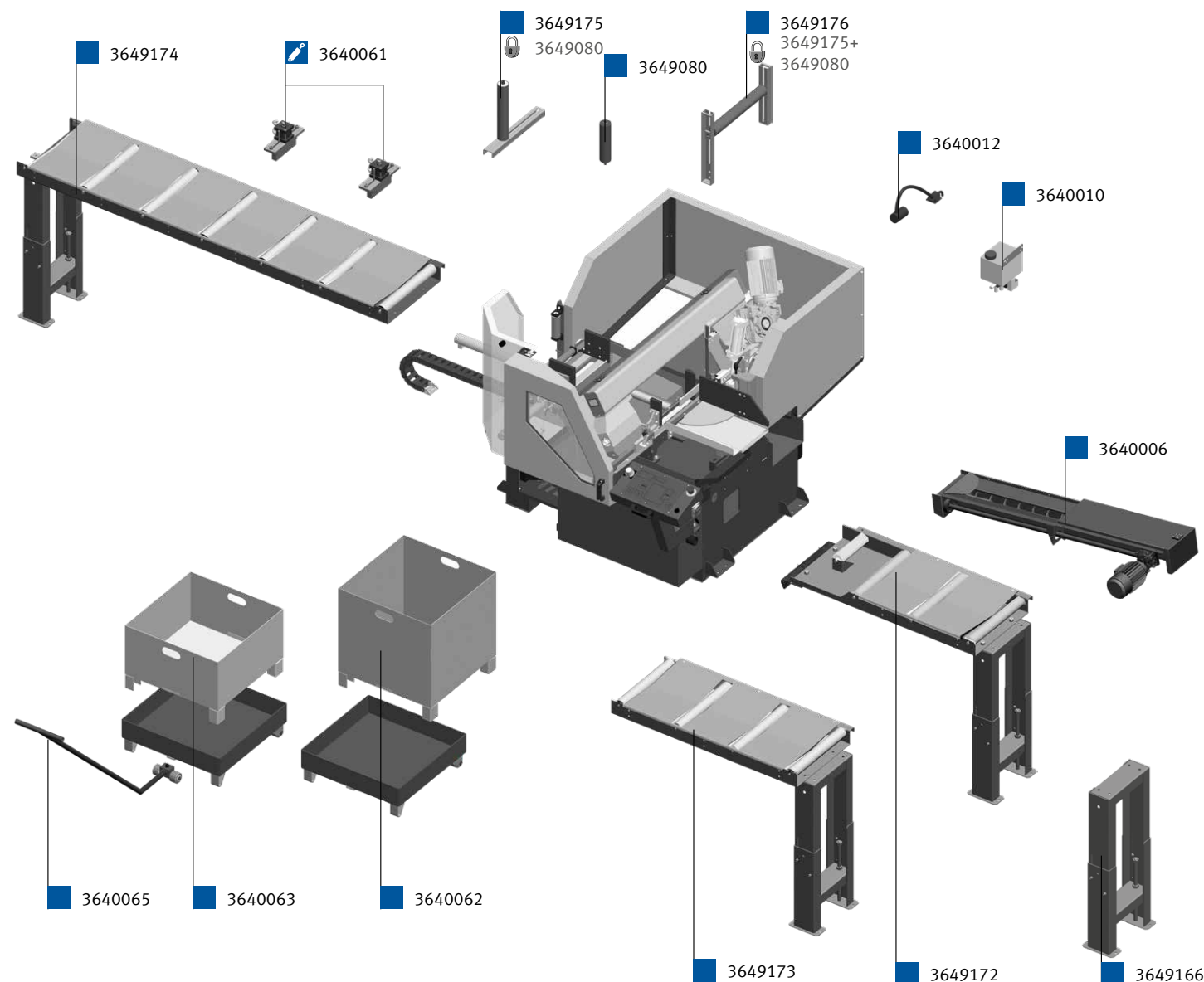
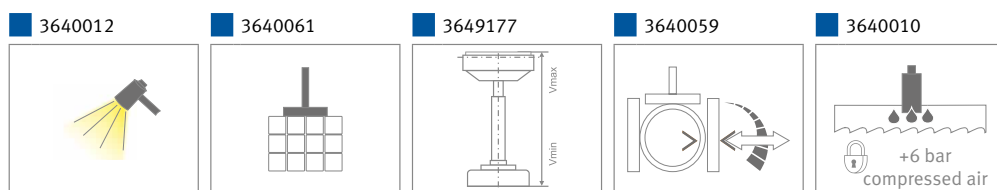


Clamping ranges

mm	0°	45°	60°	a x b
	300	300	200	X
	180 *	110 *	80 *	X
	320 x 300	300 x 250	200 x 200	230 x 120

* recommended values

! We are always happy to perform sample cutting for your material. Call us for details!



Optional accessories (only available from factory)	Art. no.
Workplace lighting	3640012
Micro-spraying system	3640010
Pressure regulator on vice	3640059
Hydr. bundle clamping unit	3640061
Chip conveyor incl. swarf container	3640006
Accessories	
Coolant concentrate 5 l	3601751
Spraying agent 5 l, micro-dosing unit	3608020
Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065

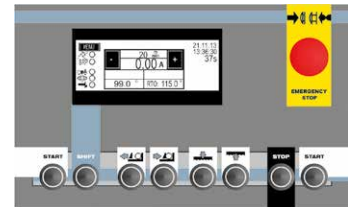
Roller conveyors 390 mm	Art. no.
Connecting roller conveyor 390 mm discharge side, f. 60° cuts between saw and roller conveyor, 200 kg/m	3649172
1 000 x 390 mm, roller conveyor 200 kg/m	3649173
2 000 x 390 mm, roller conveyor 200 kg/m	3649174
Accessories, roller conveyors 390 mm	
lateral Guide roller 200 mm, moving (requires 3649080)	3649175
lateral Guide roller 200 mm, rigid	3649080
Horizontal bundle clamping roller 390 mm (requires: 3649080 + 3649175)	3649176
Additional leg for increasing the load bearing capacity	3649166
Roller support, height-adjustable, width 390 mm, load-bearing capacity 200 kg	3649177
M42 saw bands	
3 660 x 27 x 0.9 mm 3-4 TPI X-FIT (PU=5)	3655815
3 660 x 27 x 0.9 mm 4-6 TPI X-FIT (PU=5)	3655816
* must be ordered with your order!	

BMBS 360 x 500 HA-DG

Semi-automatic swivel frame metal-cutting band saw for mitre cuts of +60° up to -60° with frequency converter

- ▶ designed for industrial use
- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ Saw band drive with low-maintenance, oil-lubricated worm gear
- ▶ With rugged 3-phase motor including overload protection
- ▶ Saw band guide with adjustable tungsten carbide plates
- ▶ With mechanical saw band tensioning, and monitoring via micro-switch
- ▶ Cooling system on the saw band guides
- ▶ Includes frequency converter for continuously variable adjustment of the saw band speed from 20 – 100 m/min.
- ▶ With BRP saw band monitoring as standard

Semi-automatic



! For an exhaustive explanation of the controls, see pages 227 – 231



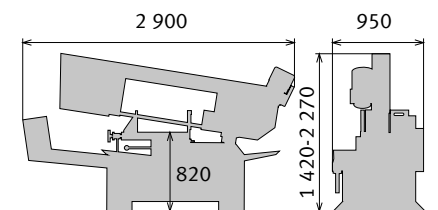
! We are always happy to perform sample cutting for your material. Call us for details!

Scope of delivery:

- › Saw band
- › Operating tool
- › Swarf clearing brush
- › Coolant pump
- › Digital angle display (HA-DG only)

Model	BMBS 360 x 500 HA-DG
Art. no.	3690090

Technical specifications	
Motor output 3 x 400 V/50 Hz	3.0 kW
Speed stages	Continuously variable
Saw band speeds	20-100 m/min
Saw band dimensions	4 780 x 34 x 1.1 mm
Dimensions (L x W x H)	2 900 x 950 x 2 270 mm
Table height material feed	820 mm
Weight	715 kg
min. remaining workpiece length	35 mm



Clamping ranges

mm	0°	45°	60°	45°	60°	 ^a ^b
	360	360	300	360	300	X
	250 *	180 *	130 *	180 *	130 *	X
	500 x 340	440 x 220	310 x 220	430 x 220	300 x 220	500 x 220

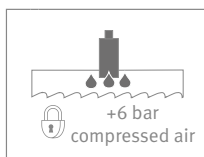
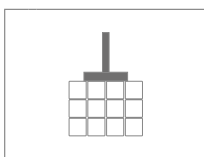
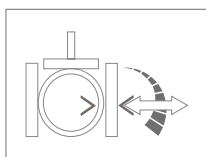
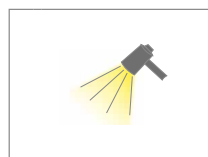
* recommended values

3640012

3640146 (HA-DG)

3649331 (H-DG)
3640001 (HA-DG)

3640010



3649324
3649325

3649329
3649101

3649101

3649316

3649122
3649322

3649123
3649322

3649048
3649051

3649129
3649321

3649125
3649321

3640065

3640063

3649326
3649327

3640062

3649341

3649322

3649323

3649330

3649321

3649320

Optional accessories (only available from factory)

Micro-spraying system	3640010
Workplace lighting	3640012
Pressure regulator on vice	3640146
Vice downstream of cut	3649316
Hydraulic bundle clamping unit	3640001

Optional accessories (only available from factory)

Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065

Roller conveyors 520 mm

Roller conveyor 1 000 x 520 mm	3649320
Roller conveyor 2 000 x 520 mm	3649321
Motorised roller conveyor 2 000 x 520 mm	3649322
Extension to motorised roller conveyor 2 000 x 520 mm	3649323
Feed roller conveyor for 60° cuts 2 000 x 520 mm	3649324
Feed roller conveyor for 60° cuts, motorised 2 000 x 520 mm	3649325
Discharge roller conveyor for 60° cuts 2 000 x 520 mm	3649326
Discharge roller conveyor for 60° cuts, motorised 2 000 x 520 mm	3649327

Roller conveyor lightweight type 250 kg/m

Art. no.	
Roller conveyor 2 000 x 520 mm (6 rollers)	3649340
Roller conveyor 2 000 x 520 mm (10 rollers)	3649341

Roller conveyor heavy-duty type 1 000 kg/m

Art. no.	
lateral guide roller, moving for roller conveyors (requires: 3649328)	3649329
Lateral guide roller, rigid	3649328
height-adjustable roller 700 kg/m	3649330
Additional roller 520 mm (requires: 3649320 + 3649321)	3649311
2 m stop fixed with measuring scale	3649129
2 m stop with digital measuring display	3649125
Electro-mechanical stop for motor. Roller conveyor with scale (requires: 3649322)	3649122
Electro-mechanical stop for motor. Roller conveyor/digital display (requires: 3649322)	3649123
2 m extension for stop with measuring device	3649048
2 m extension for stop with digital display	3649051
M42 saw bands	
4 780 x 34 x 1.1 mm 2-3 TPI Sprint Plus	3655400
4 780 x 34 x 1.1 mm 3-4 TPI Sprint Plus	3655401
4 780 x 34 x 1.1 mm 4-6 TPI Sprint-Medium-VS	3655402
4 780 x 34 x 1.1 mm 5-8 TPI Sprint	3655403
4 780 x 34 x 1.1 mm 3-4 TPI X-FIT (PU=5)	3655825
4 780 x 34 x 1.1 mm 4-6 TPI X-FIT (PU=5)	3655826

* must be ordered with your order!

More saw bands and
info on Page 283

When ordering a roller conveyor,
always state whether you need a
feed or discharge conveyor

Automatic pivot frame metal-cutting band saw for mitre cuts from 0° to +60° right

Automatic

- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ Precise and sturdy band guides with adjustable tungsten carbide plates
- ▶ Hydraulically controlled system for both vises, and the saw arm's up and down motion
- ▶ Material feed via ball screw
- ▶ With swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ Includes frequency converter as standard for continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ BRP - saw band monitoring
- ▶ The jaws on the material clamps are equipped with long stroke hydraulic cylinders as standard; this removes the need to adjust the setup for the material cross-section to be cut



! For an exhaustive explanation of the controls, see pages 227 – 231



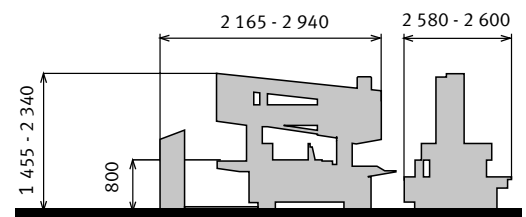
BMBS 360 x 500 CNC-G

We are always happy to perform sample cutting for your material. Call us for details!

Scope of delivery:

- › Saw band
- › Front/rear safety perimeter
- › Vice with quick release
- › Continuously variable adjustment of the saw band speed
- › Workplace lighting
- › Automatic band guide setting
- › Driven swarf clearing brush
- › Hydraulic band tensioning unit
- › Operating tool

Model	BMBS 360 x 500 CNC-G
Art. no.	3690092
Technical specifications	
Motor output 3 x 400 V/50 Hz	3.0 kW
Speed stages	Continuously variable
Saw band speeds	20 - 100 m/min
Saw band dimensions	4 780 x 34 x 1.1 mm
Dimensions (L x W x H)	2 940 x 2 600 x 2 340 mm
Table height material feed	800 mm
Weight	1 500 kg
min. remaining workpiece length	120 + 20 mm

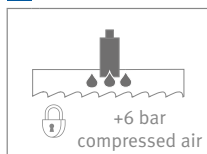
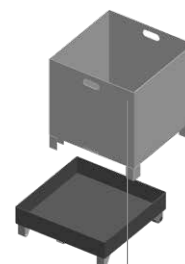
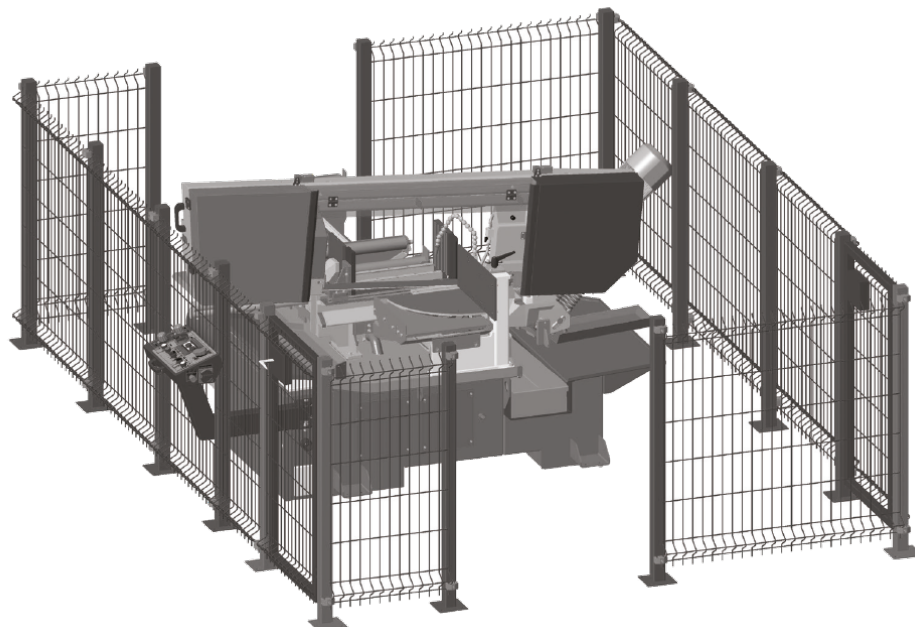


Clamping ranges

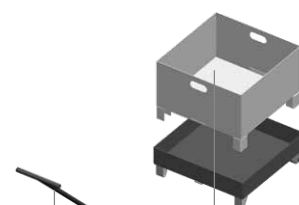
mm	0°	45°	60°	a x b
360	360	300	X	
250*	180*	130*	X	
500 x 340	440 x 220	310 x 220	500 x 220	

* recommended values

3640010


+6 bar
compressed air


3640062



3640065

3640063

3649311



3649341



3649321



3649320



3640006



3649330



3649329

3649328

Optional accessories (only available from factory)

Hydraulic bundle clamping unit	3640360
Micro-spraying system	3640010
Workplace lighting	3640012
Chip conveyor	3640006
Pressure regulator on vice	3640362

Accessories

Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065

Roller conveyor lightweight type 250 kg/m

Roller conveyor 2 000 x 800 mm (6 rollers)	3649340
Roller conveyor 2 000 x 800 mm (6 rollers)	3649341

Roller conveyor heavy-duty type 1 000 kg/m

1 000 x 520 mm roller conveyor	3649320
2 000 x 520 mm roller conveyor	3649321
2000 x 520 mm discharge roller conveyor for 60° cuts	3649326

Accessories for roller conveyor heavy-duty type

lateral Guide roller, rigid	3649328
lateral Adjustable guide roller (requires 3649328*)	3649329
Roller support 520 mm, height-adjustable max. load-bearing capacity 700 kg	3649330
Additional roller 520 mm (requires 3649320 and 3649321*)	3649311

M42 saw bands

4 780 x 34 x 1.1 mm 2-3 TPI Sprint Plus	3655400
4 780 x 34 x 1.1 mm 3-4 TPI Sprint Plus	3655401
4 780 x 34 x 1.1 mm 4-6 TPI Sprint-Medium-VS	3655402
4 780 x 34 x 1.1 mm 5-8 TPI Sprint	3655403
4 780 x 34 x 1.1 mm 3-4 TPI X-FIT (PU=5)	3655825
4 780 x 34 x 1.1 mm 4-6 TPI X-FIT (PU=5)	3655826

* must be ordered with your order!

More saw bands and
info on page 283

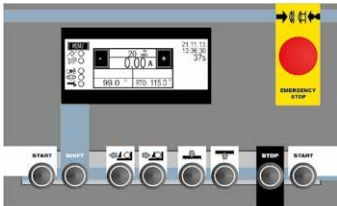
When ordering a roller conveyor,
always state whether you need a
feed or discharge conveyor

BMBS 460 x 600 HA-DG

Semi-automatic swivel frame metal-cutting band saw for mitre cuts of +60° up to -60° with frequency converter

Semi-automatic

- ▶ For sawing, e.g., stainless steel, tool steel, hollow sections and full materials
- ▶ With completely hydraulically controlled sawing functions
- ▶ Saw band drive with low-maintenance, oil-lubricated worm gear
- ▶ With rugged 3-phase motor including overload protection
- ▶ Saw band guide with adjustable tungsten carbide plates
- ▶ With swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ Cooling system on the saw band guides
- ▶ The vice is equipped with a long stroke hydraulic cylinder as standard; this removes the need to preset to the material cross-section to be cut
- ▶ The clamping jaws can move throughout the entire clamping area
- ▶ BRP - saw band monitoring
- ▶ With frequency converter for continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ With STOP function - the sawing action can be interrupted at any time by pressing a switch. The band continues to run while the arm moves out of the cutting channel



! For an exhaustive explanation of the controls, see pages 227 – 231

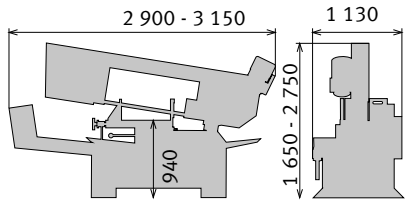


We are always happy to perform sample cutting for your material. Call us for details!

Scope of delivery:

- › Saw band
- › Operating tool
- › Digital angle display
- › Coolant pump

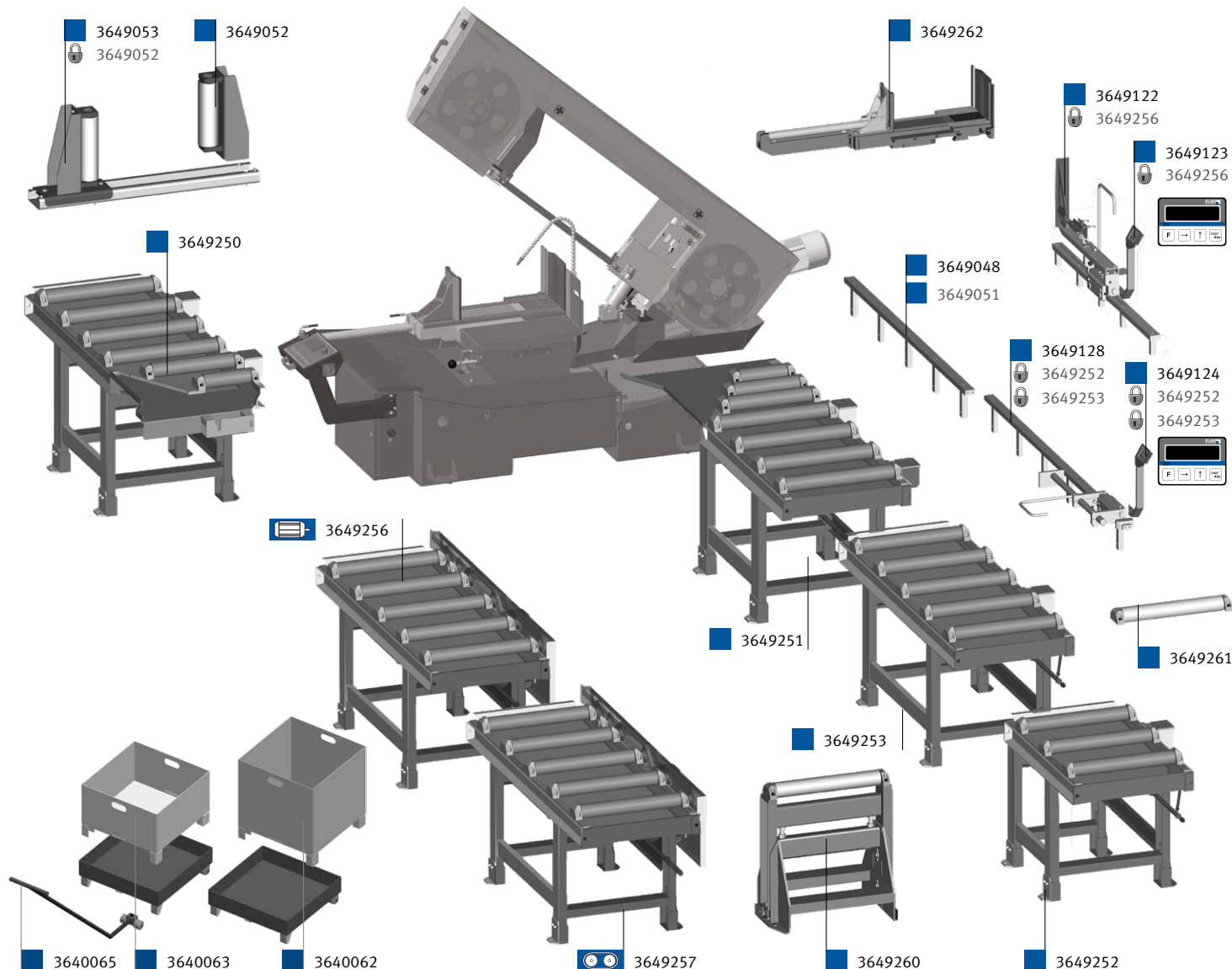
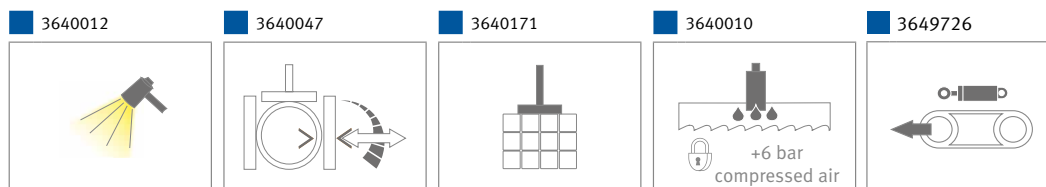
Model	BMBS 460 x 600 HA-DG
Art. no.	3690067
Technical specifications	
Motor output 3 x 400 V/50 Hz	4.0 kW
Speed stages	Continuously variable
Saw band speeds	20-100 m/min
Saw band dimensions	5 380 x 41 x 1.3 mm
Dimensions (L x W x H)	3 550 x 1 130 x 2 750 mm
Table height material feed	940 mm
Weight	1 270 kg



Clamping ranges BMBS 460 x 600 HA-DG

mm	0°	45°	60°	45°	60°	 ^b / _a
	460	460	320	460	320	X
	400 *	280 *	200 *	280 *	190 *	X
	600 x 460	470 x 240	330 x 180	470 x 250	320 x 240	600 x 250

* recommended values



Optional accessories (only available from factory)

Micro-spraying system	3640010
Hydraulic bundle clamping unit	3640171
Hydraul. band tensioning unit	3649726
Hydraulic vice downstream of cut	3649262
Workplace lighting	3640012
Pressure regulator on vice	3640047

Accessories

Workpiece container	3640062
Swarf container	3640063
Trolley for swarf and workpiece container	3640065

Roller conveyors (incl. legs and connecting adapter) 600 mm

Feed roller conveyor for 60° cuts between saw and roller conveyor including connection plate, 1 000 kg/m	3649250
Discharge roller conveyor for 60° cuts between saw and roller conveyor including connection plate, 1 000 kg/m	3649251
1 000 x 620 mm feed/discharge roller conveyor, 1 000 kg/m	3649252
2 000 x 620 mm feed/discharge roller conveyor, 1 000 kg/m	3649253

Roller conveyor heavy-duty type 1 700 kg/m

Motorised roller conveyor 2 000 x 620 mm	3649256
2 000 x 620 mm roller conveyor extension motorised (requires 3649256)	3649257

Roller conveyors lightweight type 350 kg/m	Art. no.
Roller conveyor 2 000 x 620 mm (6 rollers)	3649355

Roller conveyor heavy-duty type 1 700 kg/m

lateral guide roller, moving for roller conveyors (requires: 3649052*)	3649053
Lateral guide roller, rigid	3649052
Roller support, height-adjustable, width 600 mm, load-bearing capacity 700 kg	3649260
Additional roller 600 mm	3649261
2 m stop fixed with measuring scale	3649129
2 m stop with digital measuring display	3649125
Electro-mechanical stop for roller conveyor motorised with scale (requires 3649256)	3649122
Electro-mechanical stop for roller conveyor motorised with digital measuring display (requires 3649256)	3649123
2 m extension for stop with measuring device	3649048
2m extension for stop with digital measuring display	3649051

M42 saw bands

5 400 x 41 x 1.3 mm 3-4 TPI Sprint Plus	3655230
5 400 x 41 x 1.3 mm 2-3 TPI Sprint Plus	3655231
5 400 x 41 x 1.3 mm 4-6 TPI Sprint Plus	3655232

* must be ordered with your order!

! When ordering a roller conveyor, always state whether you need a feed or discharge conveyor

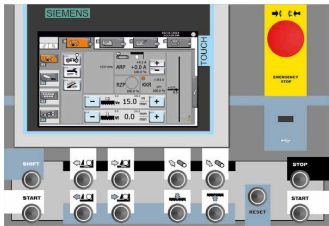
More saw bands and
info on Page 283

HMBS 340 CNC-DG-X

Fully-automatic two-column horizontal metal-cutting band saw with ARP system for for mitre cuts from +60° to -45° and 1 000 mm material feed length

Automatic

- ▶ designed for industrial use
- ▶ Extremely stable and robust structure
- ▶ Saw band drive with low-maintenance, oil-lubricated worm gear
- ▶ Including SIEMENS Simatic control and SIEMENS electrical system
- ▶ Ball screw controlled material and saw feed
- ▶ With rugged 3-phase motor
- ▶ Includes frequency converter for continuously variable adjustment of the saw band speed from 20 – 100 m/min.
- ▶ Motor includes overload protection
- ▶ Saw band guide with adjustable tungsten carbide plates
- ▶ A completely hydraulically-controlled system controls the machine clamping force work sequences
- ▶ With swivelling saw arm up to +60°



! For an exhaustive explanation of the controls, see pages 227 – 231



Figure shows accessories not included in scope of delivery

Scope of delivery:

- › Saw band
- › Coolant pump
- › Operating tool
- › Pressure regulator on vice
- › Continuously variable adjustment of the saw band speed
- › Driven swarf clearing brush
- › Chip conveyor for stainless steel incl. swarf container
- › 64-bit control system
- › Workplace lighting
- › Operating tool
- › Automatic material feed of 1 000 mm
- › Safety perimeter

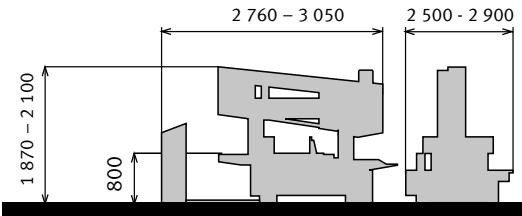
! We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 340 CNC-DG-X
Art. no.	3691341
Technical specifications	
Motor output 3 x 400 V/50 Hz	3.0 kW
Speed stages	Continuously variable
Saw band speeds	20 - 100 m/min
Saw band dimensions	4 780 x 34 x 1.1 mm
Dimensions (L x W x H)	3 050 x 2 900 x 2 100 mm
Table height material feed	800 mm
Weight	2 150 kg
min. remaining workpiece length	310 mm

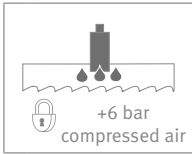
Clamping ranges HMBS 340 CNC-DG-X

mm	0°	45°	60°	45°
	350	350	230	350
	250	180*	130*	180*
	500 x 340	385x340	220 x 340	390 x 340
	340 x 340	340 x 340	340 x 220	340 x 340

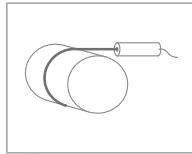
* recommended values



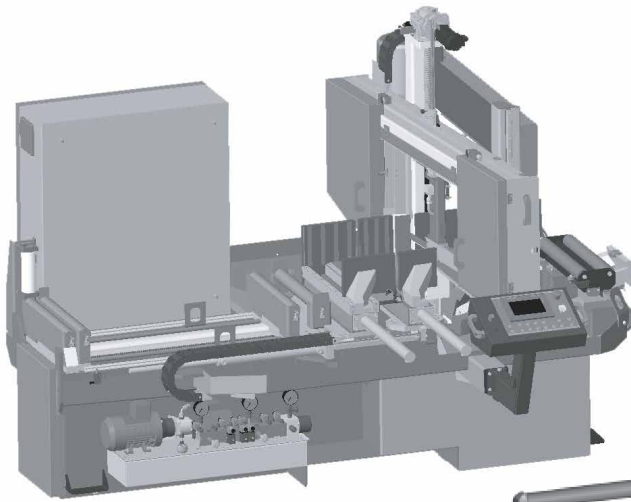
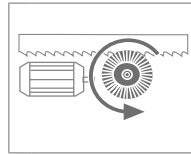
3640010



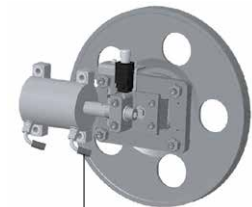
3640011



3649709



3649720



3640039



3649341



3649311



3649321



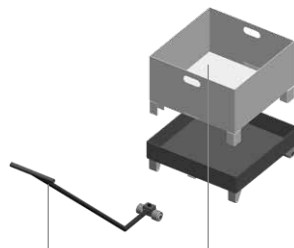
3649129



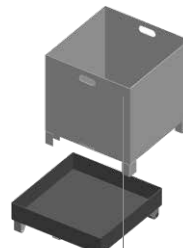
3649125



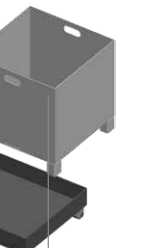
3649330



3640065



3640063



3640062



3649320



3649329



3649328

Optional accessories (only available from factory)

motorised swarf brush	3649709
Micro-spraying system	3640010
Cutting line laser	3640011

Accessories

Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065
Coolant concentrate 5 l	3601751
Spraying agent 5 l, micro-dosing unit	3608020

Roller conveyor lightweight type 250 kg/m

Roller conveyor 2 000 x 520 mm (6 rollers)	3649340
Roller conveyor 2 000 x 520 mm (10 rollers)	3649341

Roller conveyor heavy-duty type 1 000 kg/m

Roller conveyor 1 000 x 520 mm	3649320
Roller conveyor 2 000 x 520 mm	3649321

Accessories for roller conveyor heavy-duty type

Lateral guide roller	3649328
Lateral guide roller, adjustable	3649329
height-adjustable roller 700 kg/m	3649330
Additional roller 520 mm	3649311
2 m stop fixed with measuring scale	3649129
2 m stop with digital measuring display	3649125

M42 saw bands

4 780 x 34 x 1.1 mm 2-3 TPI Sprint Plus	3655400
4 780 x 34 x 1.1 mm 3-4 TPI Sprint Plus	3655401
4 780 x 34 x 1.1 mm 4-6 TPI Sprint-Medium-VS	3655402
4 780 x 34 x 1.1 mm 5-8 TPI Sprint	3655403
4 780 x 34 x 1.1 mm 3-4 TPI X-FIT (PU=5)	3655825
4 780 x 34 x 1.1 mm 4-6 TPI X-FIT (PU=5)	3655826

* must be ordered with your order!

HMBS 500 x 750 HA-DG/ HMBS 500 x 750 HA-DG X

Semi-automatic two column horizontal metal-cutting band saw for mitre cuts of +60° to -60°, designed for industrial use

- ▶ Semi-automatic, hydraulically controlled two-column guided steel design
- ▶ For cutting sections and full materials
- ▶ Bearings for adjusting the saw frame for angle cuts with smoothed guide surfaces on the machine body
- ▶ A hydraulically controlled system controls the machines work sequences
- ▶ Linear guides on both columns ensure perfect cutting results
- ▶ BRP - saw band monitoring (HA-DG)
- ▶ Front band guide automatically moves in parallel with the moving vice jaw
- ▶ HA-DG X with ARP system
- ▶ Saw band tilted by 7° for improved cutting performance and a longer service life
- ▶ With horizontally swivelling saw arm from +60° to -60°
- ▶ Continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ Safety display for saw band tension and protective hood open
- ▶ Emulsion cooling with liquid distribution across the saw band guides in the cutting channel
- ▶ For straight cuts, clamping of the material upstream and downstream of the cut through two-part vice



driven cleaning brush for cleaning and maintenance of the saw band



Scope of delivery:

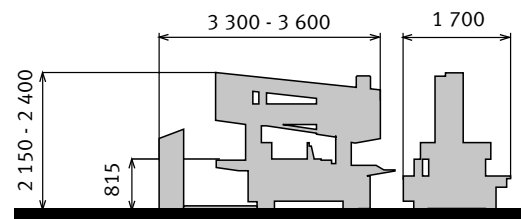
- › Saw band
- › Operating tool
- › Two rugged support rollers
- › Frequency converter,
- › Hydraulic angle adjustment
- › Swarf purging gun
- › Digital angle display
- › Coolant pump
- › Pressure regulator on vice

Scope of supply HA-DG X:

- › Workplace lighting

We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 500 x 750 HA-DG	HMBS 500 x 750 HA-DG X
Art. no.	3690075	3690076
Technical specifications		
Motor output 3 x 400 V/50 Hz	4.0 kW	4.0 kW
Speed stages	Continuously variable	Continuously variable
Saw band speeds	20-100 m/min	20-100 m/min
Saw band dimensions	6 500 x 41 x 1.3 mm	6 500 x 41 x 1.3 mm
Dimensions (L x W x H)	3 600 x 1 700 x 2 400 mm	3 600 x 1 700 x 2 400 mm
Table height material feed	815 mm	815 mm
Weight	2 000 kg	2 000 kg



Clamping ranges HMBS 500 x 750

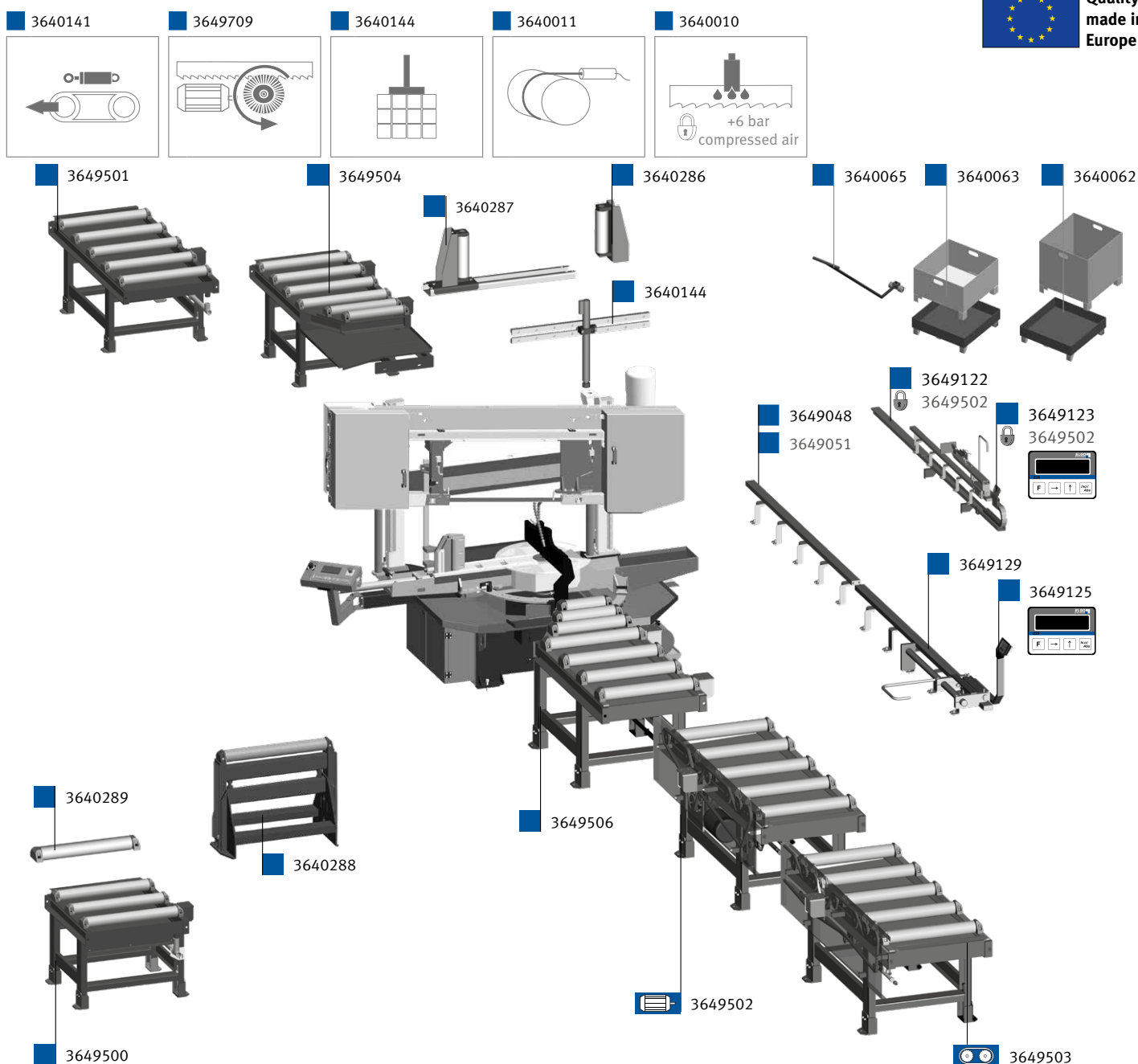
mm	 0°	 45°	 60°	 45°	 60°	 a ^b
	500	500	330	500	300	X
	400 *	280 *	200 *	280 *	190 *	X
	750x480	500x480	330x480	500x480	300x480	750x260

* recommended values

Semi-automatic



! For an exhaustive explanation of the controls, see pages 227 – 231



Optional accessories	Art. no.	Roller conveyors lightweight type 350 kg/m	Art. no.
Hydraul. Bundle clamping unit	3640144	Roller conveyor 2 000 x 620 mm (6 rollers)	3649360
Hydraul. band tensioning unit	3640141	Accessories, roller conveyors	
Micro-spraying system	3640010	lateral guide roller, moving	3640287
Cutting line laser	3640011	Lateral guide roller, rigid	3640286
motorised swarf brush	3649709	Roller support, height-adjustable, width 620 mm, load-bearing capacity 700 kg	3640288
Chip conveyor (HA-DG-X only)	3640142	Additional roller 1 000 mm (requires: 3649500/3649501*)	3640289
Accessories		2 m stop fixed with measuring scale	3649129
Workpiece container	3640062	2 m stop with digital measuring display	3649125
Swarf container	3640063	Electro-mechanical stop for motor. Roller conveyor with scale (requires: 3649502)	3649122
Trolley for swarf container and workpiece container	3640065	Electro-mechanical stop for motor. Roller conveyor with digital display (requires 3649502*)	3649123
Coolant concentrate 5 l	3601751	2 m extension for stop with measuring device	3649048
Spraying agent 5 l, micro-dosing unit	3608020	2 m extension for stop with digital display	3649051
Roller conveyors heavy-duty type 1 700 kg/m		M42 saw bands	
1 000 x 800 mm roller conveyor	3649500	6 500 x 41 x 1.3 mm 2-3 TPI Sprint Plus	3655240
2 000 x 800 mm roller conveyor	3649501	6 500 x 41 x 1.3 mm 3-4 TPI Sprint Plus	3655241
Motorised roller conveyor 2 000 x 800 mm	3649502	6 500 x 41 x 1.3 mm 5-8 TPI Sprint	3655242
2 000 x 800 mm motorised extension	3649503		
1 000 x 800 mm feed roller conveyor	3649504		
1 000 x 800 mm discharge roller conveyor	3649506		

* must be ordered with your order!

When ordering a roller conveyor, always state whether you need a feed or discharge conveyor



More **saw bands** and
info on Page 283

Fully-automatic two-column horizontal metal-cutting band saw ARP system for for mitre cuts from +60° to -60° and 2 000 mm transporter

Automatic

- ▶ For cutting bar materials, including stainless steels and tool steels, both sections and solid materials
- ▶ Semi-automatic and automatic operation individually selectable
- ▶ For straight cuts, clamping of the material upstream and downstream of the cut through two-part vice
- ▶ With ARP system: Automatic control of the cutting feed speed as a function of the material cross section, or saw band tpi
- ▶ Saw band tilted by 7° for improved cutting performance and a longer service life
- ▶ The clamping jaw moves throughout the entire cutting area

- ▶ Hydraulically controlled angle adjustment of the saw frame
- ▶ Front band guide automatically moves in parallel with the moving vice jaw
- ▶ Cooling system on the saw band guides
- ▶ Continuously variable adjustment of the saw band speed from 20 - 100 m/min.



! For an exhaustive explanation of the controls, see pages 227 – 231



HMBS 500x750 NC-DG X BC 2 000

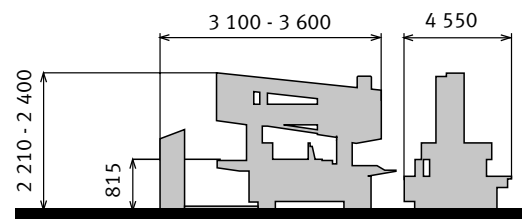
Scope of delivery:

- ▶ Saw band
- ▶ Front/rear safety perimeter
- ▶ Operating tool
- ▶ With automatic transporter 2 000 mm as standard
- ▶ Workplace lighting
- ▶ Pressure regulator on vice
- ▶ Continuously variable adjustment of the saw band speed
- ▶ Driven swarf clearing brush
- ▶ 64-bit control system
- ▶ Workplace lighting
- ▶ Coolant pump

We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 500x750 NC-DG X BC 2 000
Art. no.	3690080

Technical specifications	
Motor output 3 x 400 V/50 Hz	5.5 kW
Speed stages	Continuously variable
Saw band speeds	20-100 m/min
Saw band dimensions	6 500 x 41 x 1.3 mm
Dimensions (L x W x H)	3 600 x 5 880 x 2 400 mm
Table height material feed	815 mm
Weight	4 150 kg
min. remaining workpiece length	30 mm



Clamping ranges HMBS 500 x 750 NC-DG X 2 000

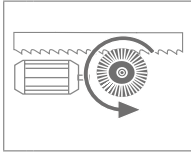
mm	0°	45°	60°	45°	60°	a ^b
	500	500	330	500	300	X
	400 *	280 *	200 *	280 *	190 *	X
	750 x 480	500 x 480	330 x 480	500 x 480	300 x 480	750 x 450

* recommended values

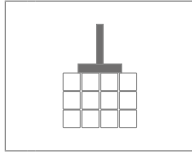
New



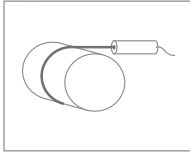
3649709



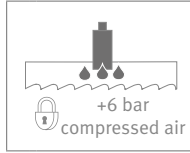
3640147



3640011



3640010



3649504



3640289



3640065



3640062

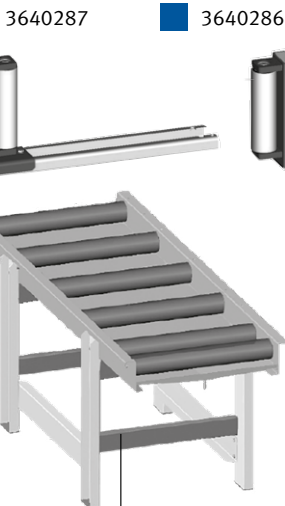


Standard

3640287



3640286



3649360



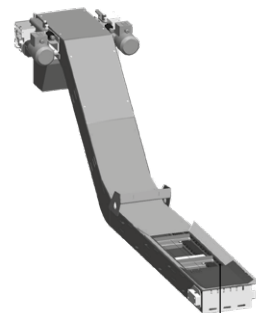
3640288



3649500



3649501



3640142

Optional accessories

Chip conveyor	3640142
Hydraul. Bundle clamping unit	3640147
Micro-spraying system	3640010
Cutting line laser	3640011
Motorised swarf brush	3649709

Accessories

Workpiece container	3640062
Trolley for swarf container and workpiece container	3640065
Roller conveyors lightweight type 350 kg/m	
Roller conveyor 2 000 x 620 mm (6 rollers)	3649360

Roller conveyors heavy-duty type 1 700 kg/m

1 000 x 800 mm roller conveyor	3649500
2 000 x 800 mm roller conveyor	3649501
2 000 x 800 mm feed roller conveyor	3649504

Accessories, roller conveyors

lateral guide roller, moving for roller conveyors	3640287
Lateral guide roller, rigid	3640286
Roller support, height-adjustable, width 620 mm, load-bearing capacity 700 kg	3640288
Additional roller 620 mm	3640289

M42 saw bands

6 500 x 41 x 1.3 mm 2-3 TPI Sprint Plus	3655240
6 500 x 41 x 1.3 mm 3-4 TPI Sprint Plus	3655241
6 500 x 41 x 1.3 mm 5-8 TPI Sprint	3655242

*** must be ordered with your order!**

When ordering a roller conveyor, always state whether you need a feed or discharge conveyor

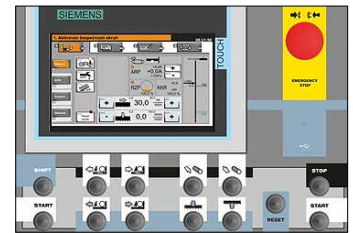
More saw bands and info on Page 283

HMBS 300 x 300 CNC X

Fully-automatic two-column horizontal metal-cutting band saw with ARP system for heavy duty industrial use

Automatic

- ▶ For sawing, e.g., stainless steel, tool steel, sections and full materials
- ▶ Compact design with short distance between saw arm guide and vice for low-vibration operation
- ▶ Saw arm with stroke measuring sensor for determining the position above the workpiece and an additional bottom end position sensor
- ▶ Saw band guide with adjustable tungsten carbide plates
- ▶ Rugged saw band guide borne on linear guides
- ▶ Front band guide automatically moves in parallel with the moving vice for more stable saw band guiding
- ▶ Continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ Hydraulically driven swarf brush



! For an exhaustive explanation of the controls, see pages 227 – 231

Info & video



Scope of delivery:

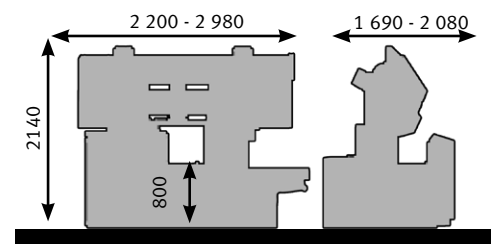
- › Full cladding
- › Saw band
- › Operating tool
- › Chip conveyor
- › Frequency converter,
- › Workplace lighting
- › Automatic band guide setting
- › Coolant pump
- › Cut probe
- › Hydraulic band tensioning unit
- › Pressure regulator on vice



We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 300 x 300 CNC X
Art. no.	3690098

Technical specifications	
Motor output 3 x 400 V/50 Hz	3.0 kW
Speed stages	Continuously variable
Saw band speeds	20 - 100 m/min
Saw band dimensions	4 520 x 34 x 1.1 mm
Dimensions (L x W x H)	2 980 x 2 080 x 2 140 mm
Table height material feed	800 mm
Weight	1 420 kg
max. feed length for 1 x feed unit	505 mm
min. remaining workpiece length CNC operation	120 mm***

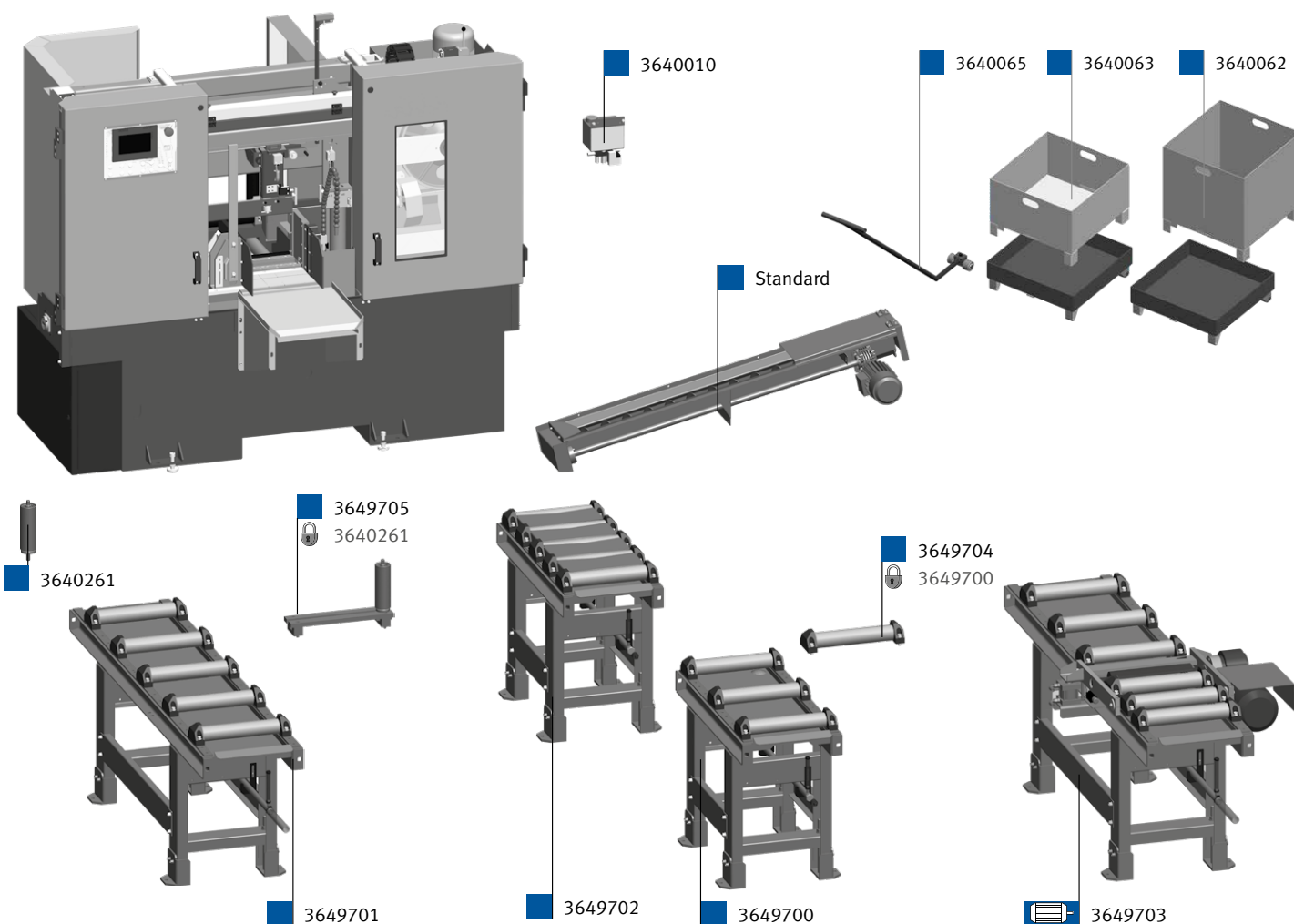
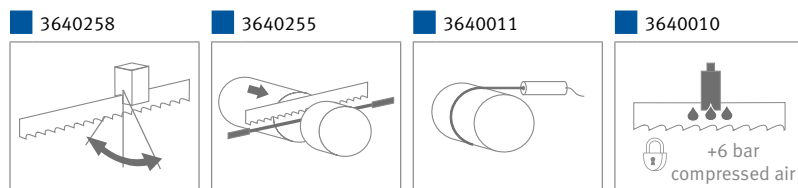


Clamping ranges HMBS 300 x 300

mm	0°	 b a x b
	300	X
	250 *	X
	300 x 300	300 x 220

* recommended values

*** Recommended minimum value. This value can change depending on the weight of surface of the material to be cut.



Optional accessories (only available from factory)	Art. no.	Roller conveyors	Art. no.
Cutting line laser	3640011	Roller conveyor 1 000 x 350 mm	3649700
Micro-spraying system	3640010	Roller conveyor 2 000 x 350 mm	3649701
Material start sensor	3640255	Connecting roller conveyor discharge side	
Cut path monitoring	3640258	1 000 x 350 mm with cover plates between rollers	3649702
Accessories		Roller conveyor 2 000 x 350 mm	
Workpiece container	3640062	with one electrically driven roller This roller is hydraulically height adjustable via a separate control	3649703
Swarf container	3640063	Accessories, roller conveyors	
Trolley for swarf container and workpiece container	3640065	lateral guide roller, moving for roller conveyors	3649705
Coolant concentrate 5 l	3601751	Lateral guide roller, rigid	3640261
Spraying agent 5 l, micro-dosing unit	3608020	Additional roller 350 mm	3649704

* must be ordered with your order! **(incl. legs and connecting adapter)

HMBS 400 CNC

Fully-automatic two-column horizontal metal-cutting band saw for industrial use

Automatic

- ▶ For sawing, e.g., stainless steel, tool steel, sections and full materials
- ▶ Precise and sturdy band guides with adjustable tungsten carbide plates
- ▶ Rugged top saw band guide due to linear guides
- ▶ Saw band angled by 7°
- ▶ Automatic band guide setting
- ▶ Doors open at sides to facilitate saw band replacement
- ▶ Material is tensioned before and after cutting
- ▶ Additional hydraulic cut pressure control
- ▶ continuously variable adjustment of the saw band speed from 20 - 100 m/min.
- ▶ With cut probe as standard



! For an exhaustive explanation of the controls, see pages 227 – 231

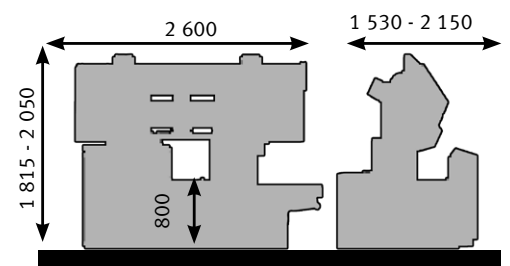


Scope of delivery:

- › Workplace lighting
- › Saw band
- › Operating tool
- › Frequency converter,
- › Material feed 550 mm
- › With cut probe as standard
- › Automatic band guide setting
- › Mechanically driven swarf brush
- › Hydraulic cut pressure control
- › Coolant pump
- › Hydraulic band tensioning unit
- › Chip conveyor with swarf container

Model	HMBS 400 CNC
Art. no.	3690161

Technical specifications	
Motor output 3 x 400 V/50 Hz	3.0 kW
Speed stages	Continuously variable
Saw band speeds	20 - 100 m/min
Saw band dimensions	4 520 x 34 x 1.1
Dimensions (L x W x H)	2 600 x 2 150 x 2 050 mm
Table height material feed	800 mm
Weight	1 300 kg
Minimal cross cut length	10 mm
Minimum size of material	30 mm
Remaining piece length in HA operation	50 mm
Remaining piece length in CNC operation	120 mm
Minimum material feed	3 mm
Feed length	490 mm
Maximum feed length	9 999 mm



Clamping ranges

mm	0°	 a b
	400	X
	250 *	X
	400 x 400	400 x 220

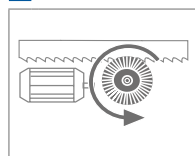
* recommended values

! We are always happy to perform sample cutting for your material. Call us for details!

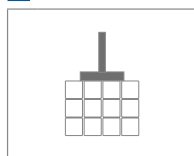


Quality
made in
Europe

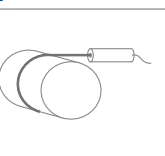
3649709



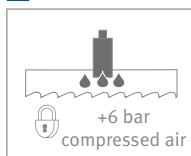
3649712



3640011



3640010



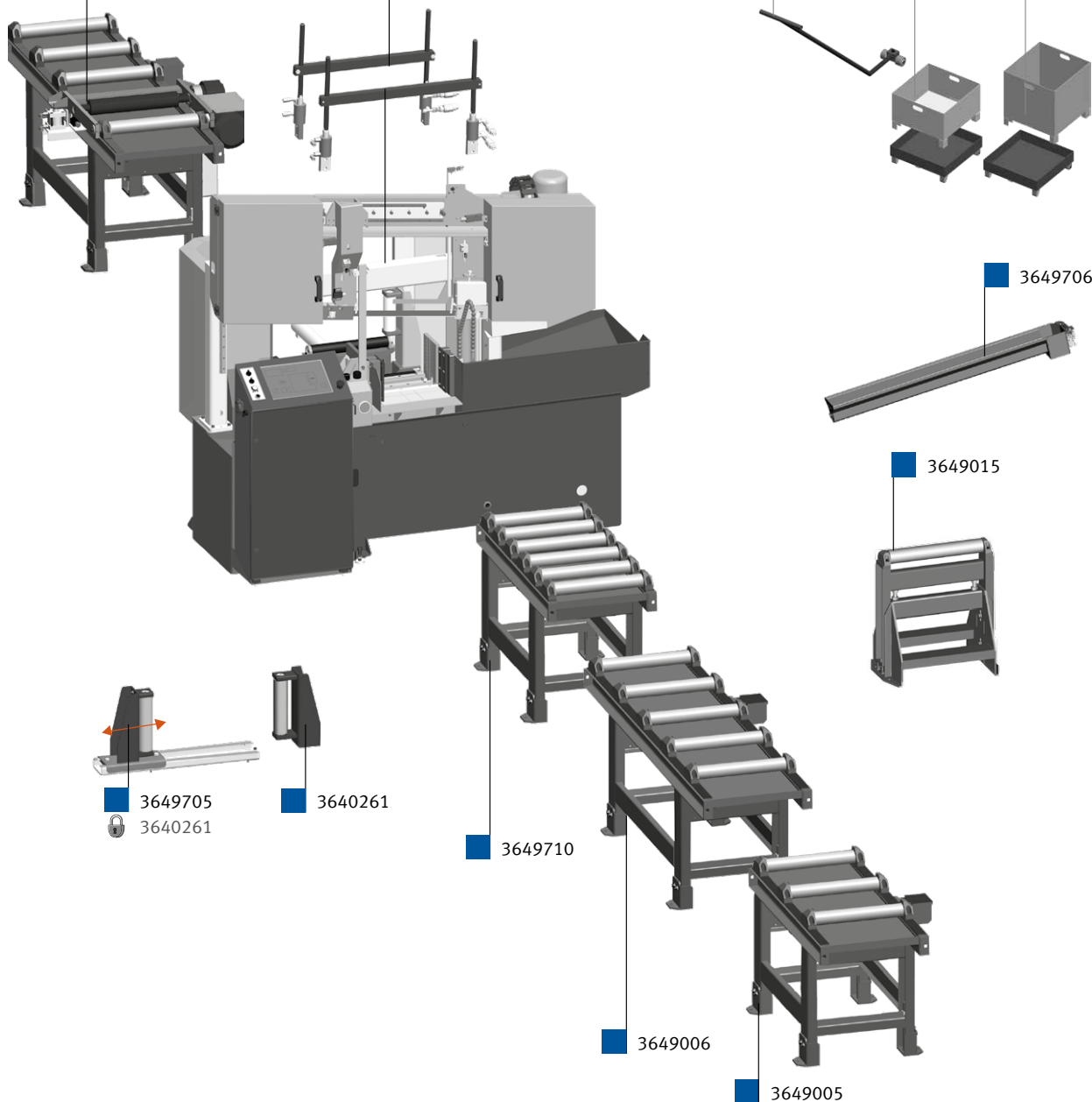
410 VZM-2000

3649712

3640065

3640063

3640062



Optional accessories (only available from factory)

	Art. no.
Micro-spraying system	3640010
Cutting line laser	3640011
Chip conveyor for stainless steel chips incl. swarf container	3649706
Hydraul. Bundle clamping unit	3649712
motorised swarf brush	3649709

Accessories

Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065
Coolant concentrate 5 l	3601751
Spraying agent 5 l, micro-dosing unit	3608020

Roller conveyor lightweight type 250 kg/m

Roller conveyor 2 000 x 520 mm (6 rollers)	3649350
--	---------

Roller conveyors

	Art. no.
1 000 x 450 mm roller conveyor	3649005
2 000 x 450 mm roller conveyor	3649006
1 000 x 450 mm discharge roller conveyor for short cuts (7 rollers/m) 1 000kg/m	3649710
Roller conveyor 2 000 x 450 mm with one electrically driven roller This roller is hyd- raulically height adjustable via a separate control	3649711

Accessories, roller conveyors

lateral guide roller, moving for roller conveyors	3649705
Lateral guide roller, rigid	3640261
Roller support, height-adjustable, width 450 mm, load-bearing capacity 700 kg	3649015

* must be ordered with your order! **incl. legs and connecting adapter

More saw bands and
info on Page 283

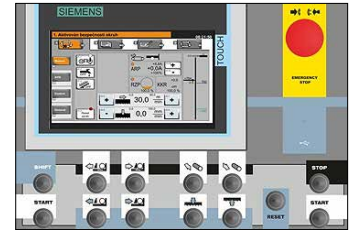
When ordering a roller conveyor, always state
whether you need a feed or discharge conveyor

HMBS 400 x 400 CNC X

Fully-automatic two-column horizontal metal-cutting band saw with ARP system for heavy duty industrial use

Automatic

- ▶ For sawing, e.g., stainless steel, tool steel, sections and full materials
- ▶ Compact design with short distance between saw arm guide and vice for low-vibration operation
- ▶ Includes frequency converter as standard for continuously variable adjustment of the saw band speed
- ▶ With motorised swarf brush
- ▶ Material feed 700 mm
- ▶ Hydraulic band tensioning unit
- ▶ Saw arm with stroke measuring sensor for determining the position above the workpiece support and an additional bottom end position sensor
- ▶ Rugged saw band guiding with linear guides, with adjustable tungsten carbide plates
- ▶ Offcut clamping



! For an exhaustive explanation of the controls, see pages 227 – 231



▶ Swarf brush motor



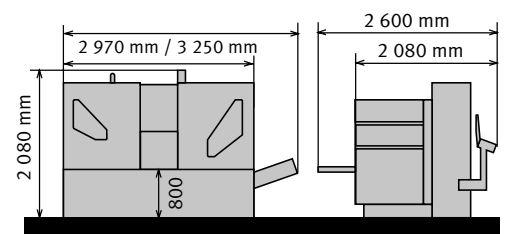
Scope of delivery:

- › Full cladding
- › Saw band
- › Operating tool
- › Chip conveyor with swarf container
- › Workplace lighting
- › Automatic band guide setting
- › Coolant pump
- › Cut probe

We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 400 x 400 CNC X
Art. no.	3690079

Technical specifications	
Motor output 3 x 400 V/50 Hz	4.0 kW
Speed stages	Continuously variable
Saw band speeds	20 - 100 m/min
Saw band dimensions	5580 x 41 x 1.3 mm
Dimensions (L x W x H)	2 970 x 2 600 x 2 200 mm
Table height material feed	800 mm
Weight	2 740 kg
Minimal cross cut length	10 mm
Minimum size of material	85 mm
Remaining piece length in HA operation	50 mm
Remaining piece length in CNC operation	110 mm
Minimum material feed	3 mm
Feed length	550 mm
Maximum feed length	9 999 mm

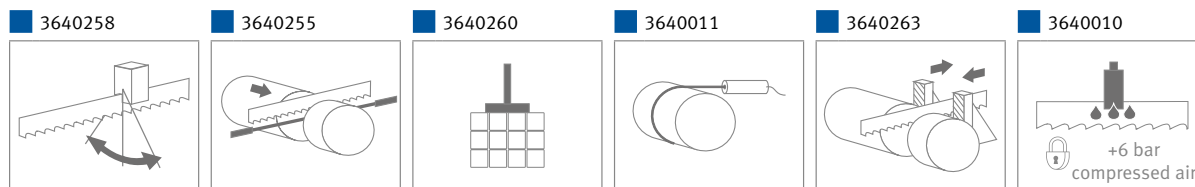


Clamping ranges HMBS 400 x 400

mm	0°	
	400	X
	400 *	X
	400 x 400	400 x 250

* recommended values

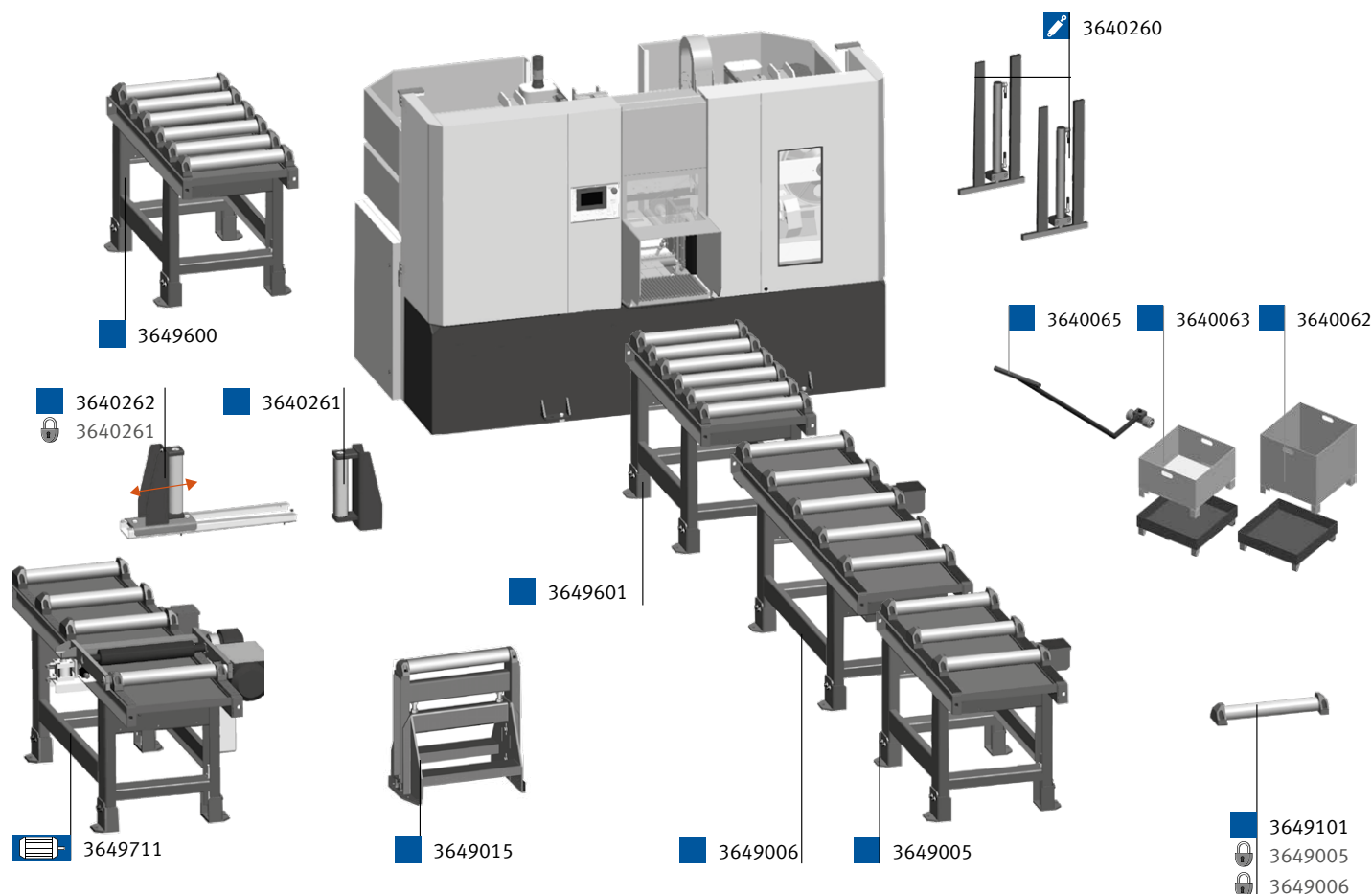
 $\frac{b}{a \times b}$ max. bundle cut



2-column linear guide
with hydr. cylinder



Offcut clamping



Optional accessories (only available from factory)	Art. no.	Roller conveyors**	Art. no.
Set 2 x hydr. bundle clamping unit	3640260	1 000 x 450 mm feed roller conveyor with coolant drain	3649600
Cutting line laser	3640011	1 000 x 450 mm discharge roller conveyor with coolant drain and a guide roller at the side	3649601
Micro-spraying system	3640010	1 000 x 450 mm roller conveyor	3649005
Material start sensor	3640255	2 000 x 450 mm roller conveyor	3649006
Cut path monitoring	3640258	Roller conveyor 2 000 x 450 mm with one electrically driven roller This roller is hydraulically height adjustable via a separate control	3649711
Spring-loaded clamping jaws on vice	3640263	Accessories, roller conveyors	
Accessories		lateral guide roller, moving for roller conveyors (requires: 3640261*)	3640262
Workpiece container	3640062	Lateral guide roller, rigid	3640261
Swarf container	3640063	Roller support, height-adjustable, width 450 mm, load-bearing capacity 700 kg/m	3649015
Trolley for swarf container and workpiece container	3640065	Additional roller 450 mm	3649101
Coolant concentrate 5 l	3601751	* must be ordered with your order! *incl. legs and connecting adapter	
Spraying agent 5 l, micro-dosing unit	3608020		

HMBS 510 x 510 CNC X

HMBS 510 x 510 CNC X – fully automatic two-column horizontal metal-cutting band saw with SIEMENS control unit

Automatic

- ▶ For sawing, e.g., stainless steel, tool steel, sections and full materials
- ▶ Material feed 670 mm
- ▶ Saw arm with stroke measuring sensor for determining the cut start position
- ▶ Saw band guide with adjustable tungsten carbide plates
- ▶ Saw band wheels tilted through 25° for a longer saw band service life
- ▶ Clamping of the material upstream and downstream of the cut through two-part vice
- ▶ Line guides on both columns
- ▶ Rugged top saw band guide
- ▶ Hydraulic band tensioning unit
- ▶ With motorised swarf clearing brush
- ▶ Controller with 99 program memory slots with up to 99 setting options



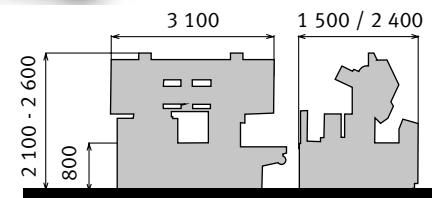
! For an exhaustive explanation of the controls, see pages 227 – 231



Scope of delivery:

- › Workpiece chute
- › Saw band
- › Operating tool
- › Cut probe
- › Workplace lighting
- › Chip conveyor with swarf container
- › Automatic band guide setting
- › Frequency converter,
- › Coolant pump
- › Cutting channel opens when saw band moves to top position

Model	HMBS 510 x 510 CNC X
Art. no.	3690019
Technical specifications	
Motor output 3 x 400 V/50 Hz	7.5 kW
Speed stages	Continuously variable
Saw band speeds	15 - 80 m/min
Saw band dimensions	6 060 x 54 x 1.6 mm
Dimensions (L x W x H)	3100 x 2 400 x 2 600 mm
Table height material feed	800 mm
Weight	6 220 kg
max. feed length for 1 x feed unit	50 mm
min. remaining workpiece length CNC operation	120 mm

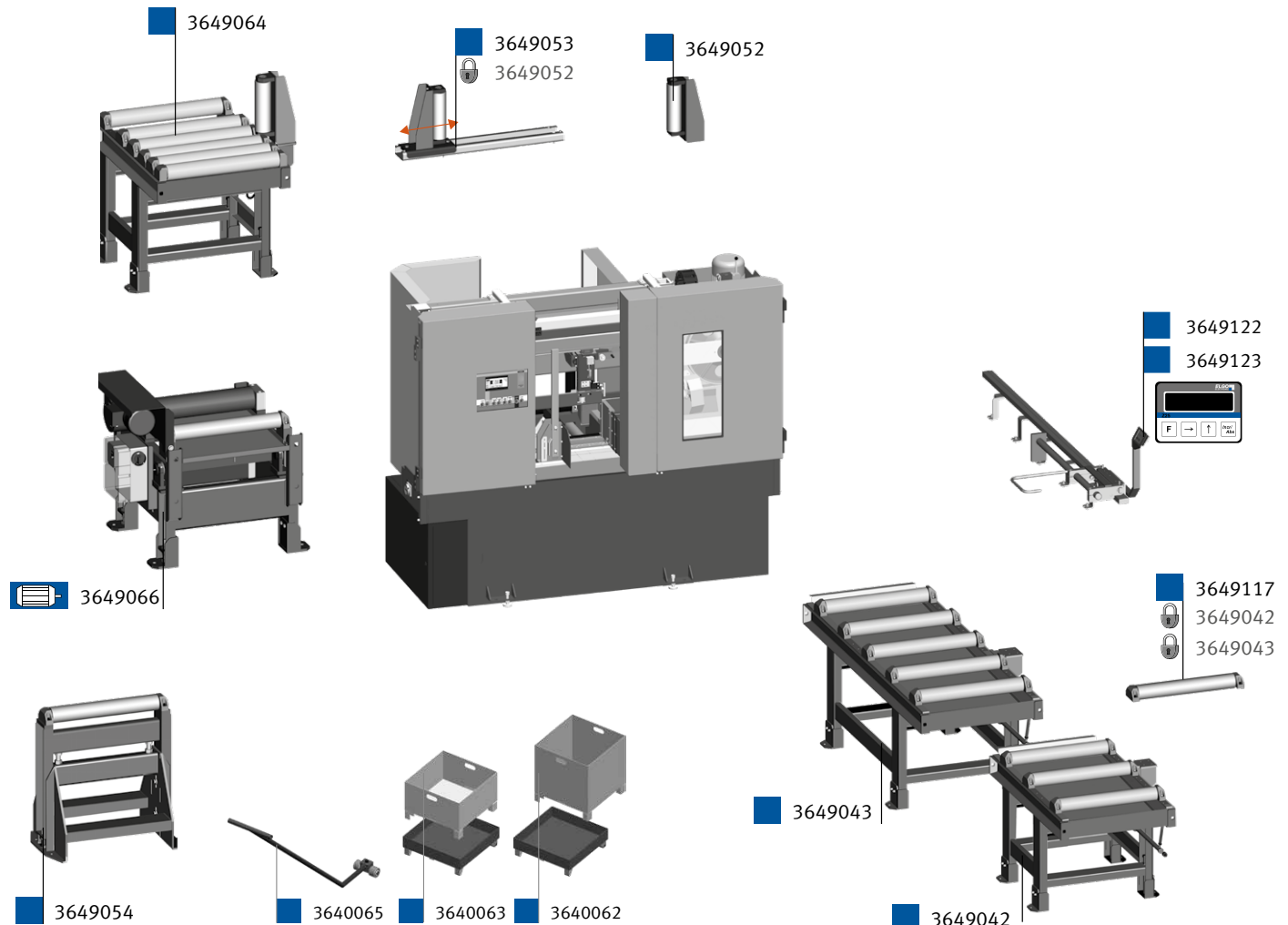
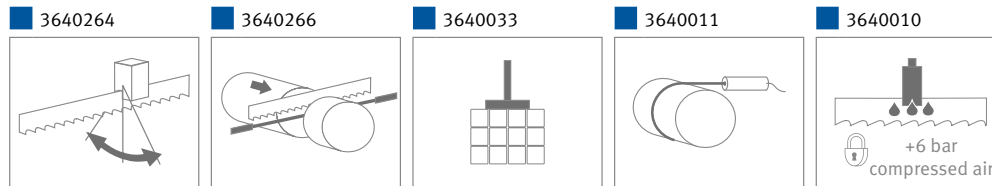


HMBS 510 x 510 CNC X	
Minimal cross cut length	10 mm
Minimum size of material	75 mm
Remaining piece length during a cut	50 mm
Remaining piece length in CNC operation	120 mm
Minimum material feed	3 mm
Feed length	670 mm
Maximum feed length	9 999 mm

Clamping ranges HMBS 510 x 510

mm	0°	a	b
510	X		
510 *	X		
510 x 530		500 x 450	

* recommended values



Optional accessories	Art. no.
Set 2 x hydr. bundle clamping unit (for CNC versions)	3640033
Cutting line laser	3640011
Micro-spraying system	3640010
Cut path monitoring	3640264
Precise automatic workpiece feeding	3640266
Accessories	
Workpiece container	3640062
Swarf container	3640063
Trolley for swarf container and workpiece container	3640065
Coolant concentrate 5 l	3601751
Spraying agent 5 l, micro-dosing unit	3608020
Roller and measuring tracks**	
1 000 x 620 mm roller conveyor	3649042
2 000 x 620 mm roller conveyor	3649043
1 000 x 620 mm feed roller conveyor with one guide roller at the side	3649065
Hydraulic lifting roller	3649066

Accessories, roller and measuring tracks	
lateral guide roller, moving for roller conveyors (requires: 3649052*)	3649053
Lateral guide roller, rigid	3649052
Roller support, height-adjustable, width 620 mm, load-bearing capacity 1,000 kg	3649054
Additional roller 620 mm (requires 3649042*/3649043*)	3649117
M42 saw bands for HMBS 510 x 510 CNC X	
6 060 x 54 x 1.6 mm 3-4 TPI Sprint Plus	3655007
6 060 x 54 x 1.6 mm 2-3 TPI Sprint Plus	3655107

* must be ordered with your order! *incl. legs and connecting adapter

More saw bands and
info on Page 283

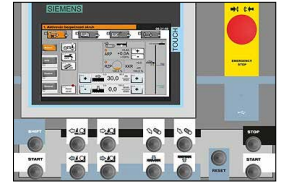
When ordering a roller conveyor,
always state whether you need a
feed or discharge conveyor

HMBS 5000 CNC X

Fully-automatic two-column horizontal metal-cutting band saw for industrial use and optimal cutting times

Automatic

- ▶ Saw band speed up to 150 m/min
- ▶ Saw band feed with ARP system for automatic feed matching
- ▶ Carbide program for use of carbide saw bands
- ▶ Material feed and sawing frame driven by ball screws
- ▶ Materials library with predefined sawing parameters and characteristics
- ▶ Hydraulic band tensioner
- ▶ Cut progress monitoring
- ▶ Hydraulic saw band guides
- ▶ Coolant tank can be removed to front
- ▶ Automatically adjustable linear saw band guidance
- ▶ Saw band tension double guide
- ▶ Wheels with counterbearing for smoother cutting action
- ▶ Cutting channel flushing



! For an exhaustive explanation of the controls, see pages 227 – 231



Scope of delivery:

- › Saw band
- › Operating tool
- › Two LED workplace lights
- › ARP system
- › Frequency converter,
- › Motorised swarf clearing brush
- › Automatic band guide setting
- › Chip conveyor

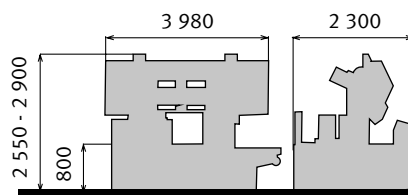
! We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 5000 CNC X
Art. no.	3691500

Technical specifications	
Motor output 3 x 400 V/50 Hz	15 kW
Speed stages	Continuously variable
Saw band speeds	15 - 150 m/min
Saw band dimensions	7 680 x 54 x 1.6 mm
Dimensions (L x W x H)	3 980 x 2 300 x 2 900 mm
Table height material feed	800 mm
Weight	7 735 kg

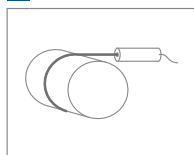
Clamping ranges

mm	 0°	
	550	x
	550*	x
	550 x 620	550x350
	550x550	x

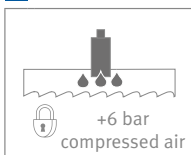


* recommended values for full material

3640011



3640010



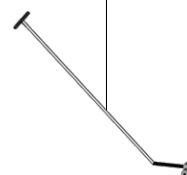
3649054



3640131



3640065



3640062



3640063



3649797

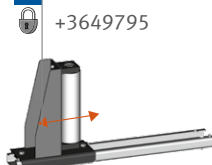
+3649790

+3649791



3649796

+3649795

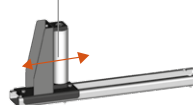


3649795



3649053

+3649052



3649052



3649117

+3649042

+3649042



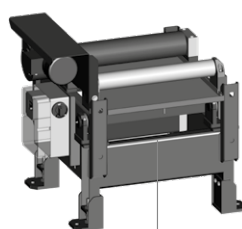
3649790



3649791



3649066



3649043



3649042



Optional accessories (only available from factory)

Optional accessories (only available from factory)	Art. no.
Chip conveyor	3640131
Cutting line laser	3640011
Micro-spraying system	3640010

Accessories

Workpiece container	3640062
Swarf container	3640063
Trolley for swarf and workpiece container	3640065
Coolant concentrate 5 l	3601751
Spraying agent 5 l, micro-dosing unit	3608020

Roller conveyors heavy-duty type 1 700 kg/m

1 000 x 620 mm roller conveyor	3649042
2 000 x 620 mm roller conveyor	3649043
Hydraulic lifting roller	3649066

Accessories, heavy-duty roller conveyors

Accessories, heavy-duty roller conveyors	Art. no.
--	----------

height-adjustable roller	3649054
Lateral guide roller, rigid	3649052
lateral Guide roller, moving	3649053
Additional roller 620 mm	3649117

Roller conveyors ultra-heavy-duty type 2 000 kg/m

Roller conveyor 1 000 x 570 mm with hardened rollers	3649790
Roller conveyor 2 000 x 570 mm with hardened rollers	3649791

Accessories, ultra-heavy-duty roller conveyors

lateral guide roller, rigid - height 650 mm	3649795
lateral guide roller, moving - height 650	3649796
Additional roller 570 mm	3649797

* must be ordered with your order! ** Explanations, see page 283

More saw bands and
info on Page 283

When ordering a roller conveyor, always state
whether you need a feed or discharge conveyor

HMBS 700 x 750 HA X

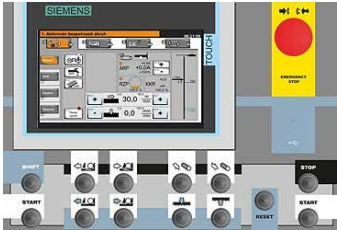
Semi-automatic two-column horizontal metal-cutting band saw with SIEMENS control unit for heavy-duty industrial use

Semi-automatic

- ▶ Linear guides on both columns ensure perfect cutting results
- ▶ Rugged 3-phase motor including overload protection
- ▶ The vice is equipped with a long stroke cylinder to compensate for larger differences in cross-sections
- ▶ Band guide with adjustable tungsten carbide plates
- ▶ Hydraulic vice pressure control



▶ Front band guide automatically moves in parallel with the moving vice for more precise saw band guiding



! For an exhaustive explanation of the controls, see pages 227 – 231

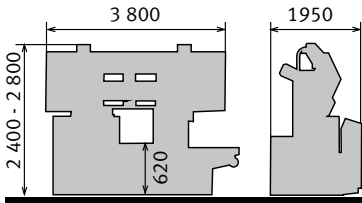


Scope of delivery:

- › Saw band
- › Operating tool
- › Workplace lighting
- › Motorised swarf brush
- › Frequency converter,
- › Coolant pump
- › Hydraulic band tensioning unit

We are always happy to perform sample cutting for your material. Call us for details!

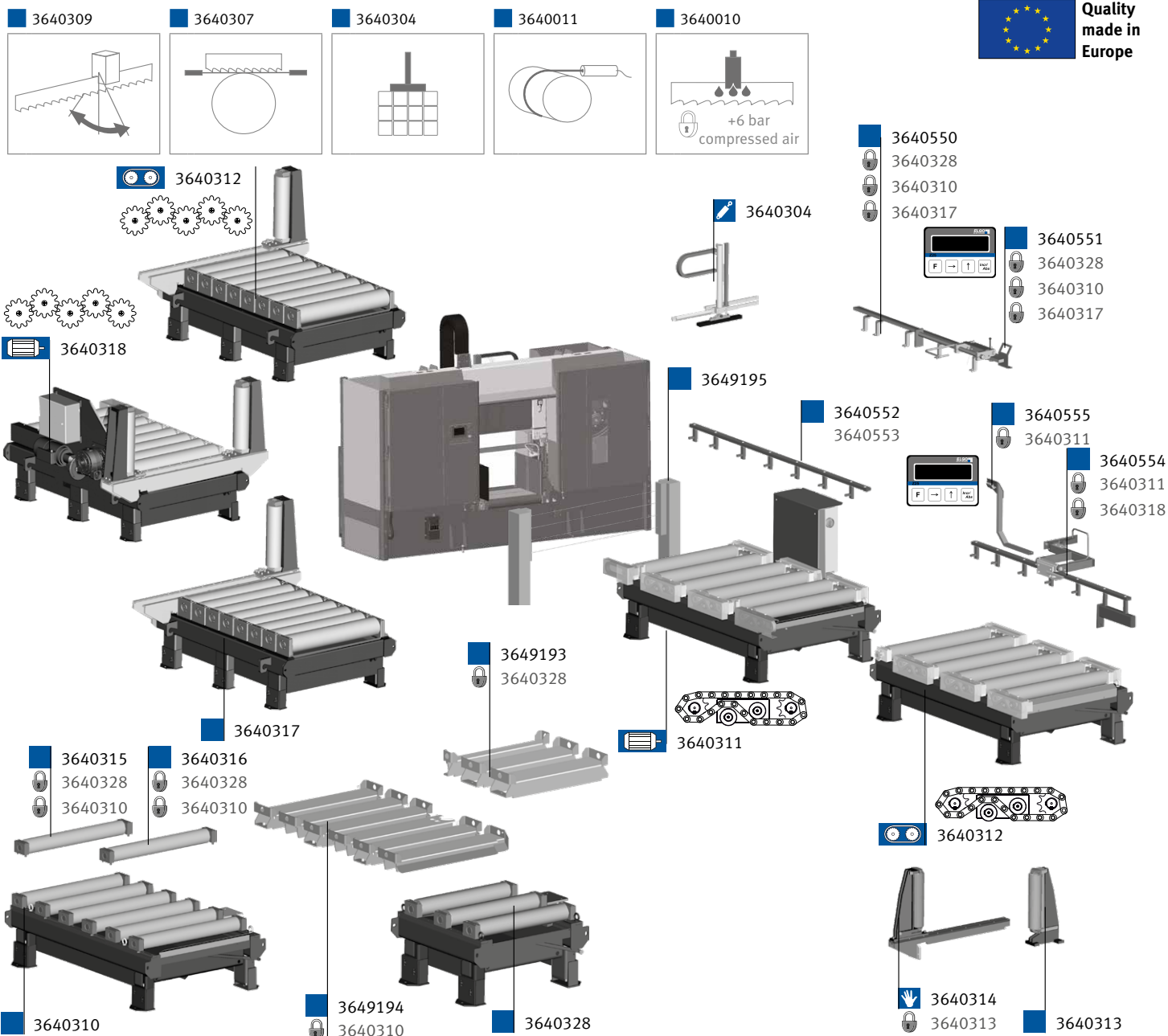
Model	HMBS 700 x 750 HA X
Art. no.	3690082
Technical specifications	
Motor output 3 x 400 V/50 Hz	11 kW
Speed stages	Continuously variable
Saw band speeds	15 - 80 m/min
Saw band dimensions	7 680 x 67 x 1.6 mm
Dimensions (L x W x H)	4 100 x 1 950 x 2 700 mm
Table height material feed	620 mm
Weight	5950 kg



Clamping ranges

mm	0°	a x b
	700	X
	700 *	X
	750 x 700	750 x 450

* recommended values for full material



Optional accessories (only available from factory)	Art. no.
Hydraul. Bundle clamping unit	3640304
Cutting line laser	3640011
Micro-spraying system	3640010
Material start sensor	3640307
Cut path monitoring	3640309
Safety light barrier	3649195
Roller conveyors	
1 000 x 800 mm roller conveyor	3640328
2 000 x 800 mm roller conveyor	3640310
Motorised roller conveyor 2 000 x 800 mm	3640311
2 000 x 800 mm motorised extension	3640312
requires: 3640311*	
2 000 x 800 mm feed/discharge roller conveyor heavy-duty version	3640317
2 000 x 800 mm feed/discharge roller conveyor, motorised / heavy-duty version	3640318
2 000 x 800 mm extension motorised / heavy duty version	3640319

Accessories, roller and measuring tracks	Art. no.
lateral guide roller, moving for roller conveyors (requires: 3640313*)	3640314
Lateral guide roller, rigid	3640313
Additional roller 800 mm (requires 3640328*/3640310*)	3640315
Idler rollers tempered to 55 HRC (requires 3640328/ 3640310)	3640316
1 m casing for roller conveyor (requires 3640328)	3649193
2 m casing for roller conveyor (requires 3640310)	3649194
2 m stop with measuring scale - heavy-duty version (requires 3640328*/3640310*/3640317*)	3640550
2 m stop with dig. measuring display - heavy duty version, (requires 3640328*/3640310*/3640317*)	3640551
2 m extension for stop with scale and measuring scale - heavy duty version	3640552
2 m extension for stop with digital display - heavy duty version	3640553
Electro-mechanical stop for motor. Roller conveyor with scale - heavy duty version (requires 3640311*/3640318*)	3640554
Electro-mechanical stop for motor. Roller conveyor with digital display - heavy duty version (requires: 3640311*)	3640555

M42 saw bands	
7 680 x 67 x 1.6 2-3 TPI Sprint Plus	3655410
7 680 x 67 x 1.6 3-4 TPI Sprint-Medium-VS	3655411

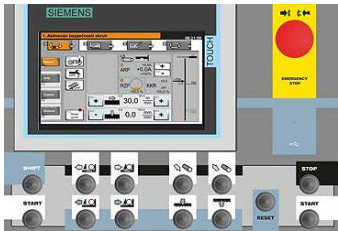
* must be ordered with your order! *incl. legs and connecting adapter

HMBS 700 x 750 CNC X

Automatic two column horizontal metal-cutting band saw with ARP system for heavy-duty industrial use

Automatic

- ▶ The vices are equipped with long stroke cylinders
- ▶ Clamping pressure control
- ▶ the fixed, hydraulically-controlled jaw on the vice moves back by 5 mm, thus improving the workpiece feed
- ▶ End switches control the upper and lower end positions of the saw arm
- ▶ Clamping of the material upstream and downstream of the cut through two-part vice
- ▶ Band guide with adjustable tungsten carbide plates
- ▶ Compact design with short distance between saw arm guide and vice for low-vibration operation
- ▶ electronic setting of the saw arm's top and bottom positions
- ▶ permanent monitoring of the saw band and feed speeds
- ▶ USB interface



! For an exhaustive explanation of the controls, see pages 227 – 231



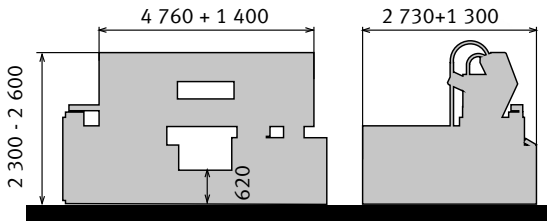
Scope of delivery:

- › Saw band
- › Operating tool
- › Workplace lighting
- › Autom. band guide setting
- › Motorised swarf clearing brush
- › Frequency converter,
- › Swivelling control panel
- › Coolant pump
- › Hydraulic band tensioning unit

We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 700 x 750 CNC X
Art. no.	3690083

Technical specifications	
Motor output 3 x 400 V/50 Hz	11 kW
Speed stages	Continuously variable
Saw band speeds	15 - 80 m/min
Saw band dimensions	7 680 x 67 x 1.6
Dimensions (L x W x H)	7 000 x 2 750 x 2 700 mm
Table height material feed	620 mm
Weight	12 500 kg

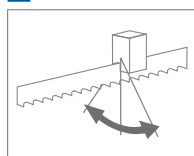


Clamping ranges

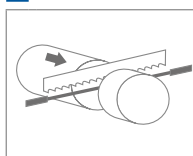
mm	0°	$\begin{matrix} b \\ a \times b \end{matrix}$
	700	x
	700 *	x
	750 x 700	750 x 450

* recommended values

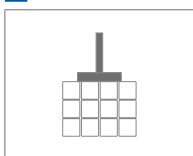
3640309



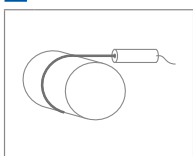
3640306



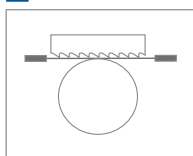
3640327



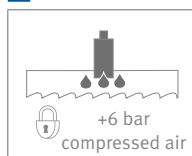
3640011



3640307



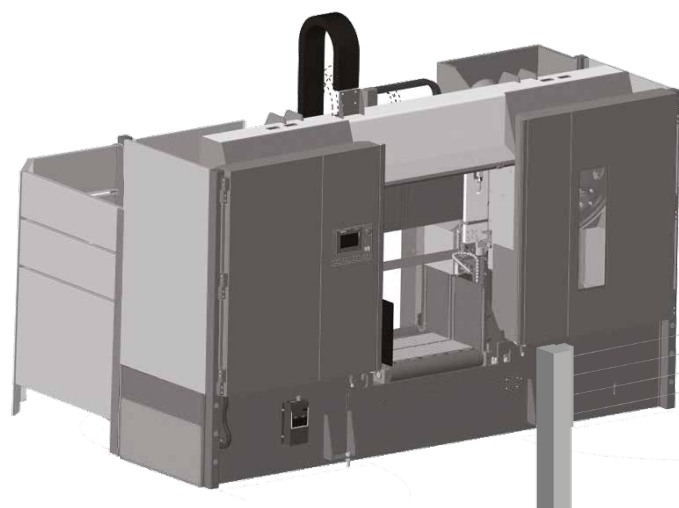
3640010



Quality
made in
Europe



► Clamping of the material upstream and downstream of the cut through two-part vice



3649195

3649194
3640310

3640315
3640328
3640310

3640316
3640328
3640310

3640314
3640313

3640313

3649193
3640328

3640317

3640310

3640328

Optional accessories (only available from factory)

Art. no.	
3640327	Hydraul. Bundle clamping unit
3640011	Cutting line laser
3640010	Micro-spraying system
3640306	Automatic material start sensor **
3640307	Automatic detection of the top material end point **
3640309	Cut path monitoring **
3649195	Safety light barrier

Roller conveyors

3640328	1 000 x 800 mm roller conveyor
3640310	2 000 x 800 mm roller conveyor
3640317	2 000 x 800 mm feed/discharge roller conveyor heavy-duty version

Accessories, roller and measuring tracks

Art. no.	
3640314	lateral guide roller, moving for roller conveyors (requires: 3640313*)
3640313	Lateral guide roller, rigid
3640315	Additional roller 800 mm (requires 3640328*/3640310*)
3640316	Idler rollers tempered to 55 HRC (requires 3640328/ 3640310)
3649193	1 m casing for roller conveyor (requires 3640328)
3649194	2 m casing for roller conveyor (requires 3640310)
3655410	M42 saw bands 7 680 x 67 x 1.6 2-3 TPI Sprint Plus
3655411	7 680 x 67 x 1.6 3-4 TPI Sprint-Medium-VS

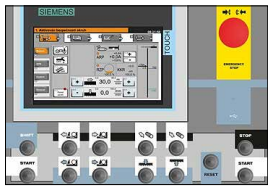
* must be ordered with your order! ** Explanations, see page 283

HMBS 850 x 1 000 CNC X

Fully-automatic two-column horizontal metal-cutting band saw with ARP system for heavy-duty industrial applications

Automatic

- ▶ For sawing, e.g., stainless steel, tool steel, sections and full materials
- ▶ Material feed 700 mm
- ▶ Saw band guide with adjustable tungsten carbide plates
- ▶ Robust, automatically adjustable saw band guide with cooling system
- ▶ With hydraulic band tensioning
- ▶ Line guides on both columns
- ▶ With motorised swarf clearing brush



! For an exhaustive explanation of the controls, see pages 227 – 231



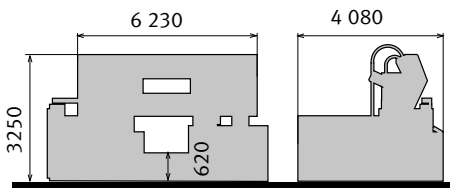
Scope of delivery:

- › Saw band
- › Operating tool
- › Workplace lighting
- › Chip conveyor
- › Frequency converter,
- › Material feed 700 mm
- › Coolant pump

! We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 850 x 1000 CNC X
Art. no.	3690094

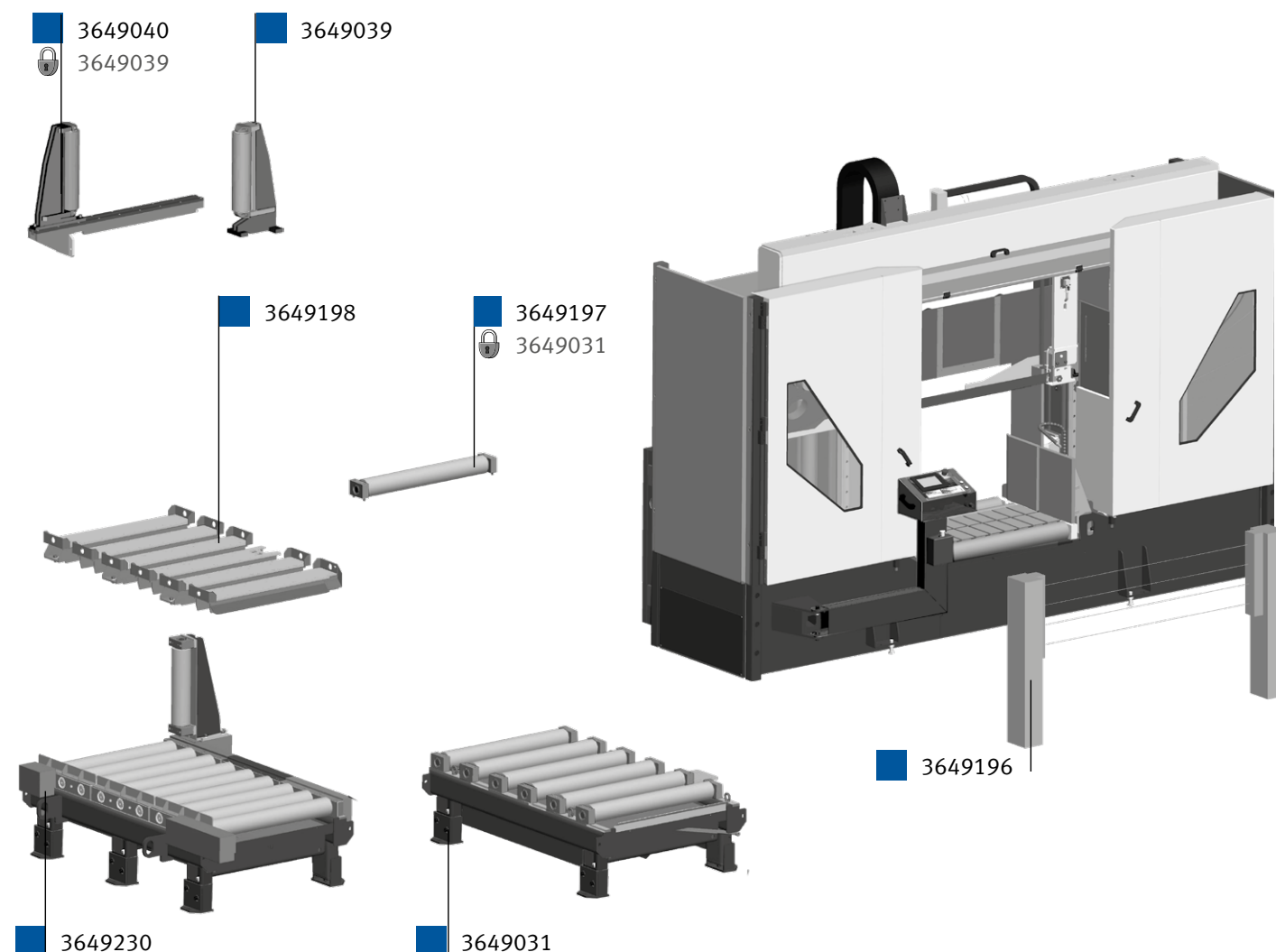
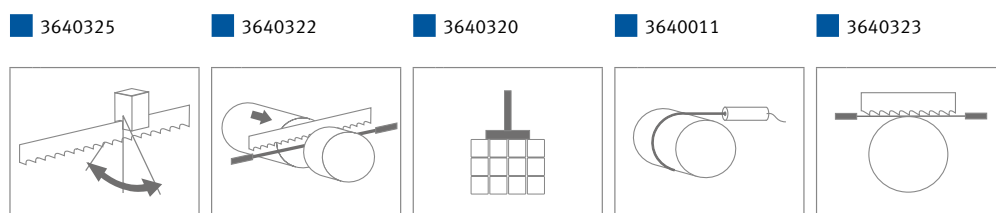
Technical specifications	
Motor output 3 x 400 V/50 Hz	11 kW
Speed stages	Continuously variable
Saw band speeds	15–80 m/min
Saw band dimensions	9 490 x 67 x 1.6 mm
Dimensions (L x W x H)	6 230 x 4 080 x 3 250 mm
Table height material feed	620 mm
Weight	13 700 kg
Remaining piece length	50 mm



Clamping ranges

mm	0°	
	850	x
	850 *	x
	1 000 x 850	1 000 x 610

* recommended values



Optional accessories (only available from factory)	Art. no.	Accessories, roller conveyors 1 000 mm	Art. no.
Light barrier	3649196	lateral guide roller, moving for roller conveyors (requires: 3649039*)	3649040
Cutting line laser	3640011	Lateral guide roller, rigid	3649039
Automatic detection of the top material end point **	3640323	Additional roller 1 000 mm (requires: 3649031*)	3649197
Cut path monitoring **	3640325	2 m casing for roller conveyor (requires 3649031*)	3649198
Roller conveyors		M42 saw bands	
2 000 x 1 000 mm roller conveyor 5 000 kg/m	3649031	9 490 x 67 x 1.6 2-3 TPI Sprint-Medium-VS	3655011
2 000 x 1 000 mm heavy-duty roller conveyor, 7000 kg/m	3649230	9 490 x 67 x 1.6 3-4 TPI Sprint Plus	3655111

More saw bands and
info on Page 283

When ordering a roller conveyor, always state
whether you need a feed or discharge conveyor

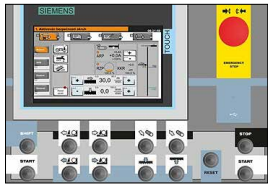
* must be ordered with your order! ** Explanations, see page 283

HMBS 1200 x 1400 HA X

Semi-automatic/fully-automatic two column horizontal metal-cutting band saw with ARP system for heavy-duty industrial use

Semi-automatic

- ▶ Developed for cutting full materials
- ▶ A hydraulic system controls the machines automated work sequences
- ▶ Band guide with adjustable tungsten carbide plates
- ▶ End switches control the upper and lower end positions of the saw arm
- ▶ Linear guides on both columns ensure perfect cutting results
- ▶ Wheels tilted for a longer saw band service life



For an exhaustive explanation of the controls, see pages 227 – 231

- ▶ with solid, precision 2-column guide
- ▶ Linear guides on both columns ensure perfect cutting results

- ▶ Chip conveyor as standard

HMBS 1 200 x 1 400 HA X
Fig. with optional 2nd vice

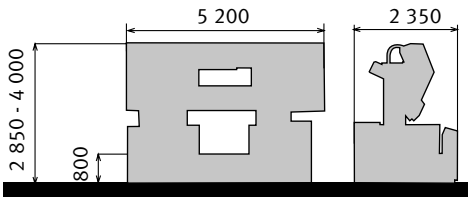
Scope of delivery:

- › Saw band
- › Operating tool
- › Two workplace lights
- › ARP system
- › Chip conveyor
- › Frequency converter,
- › Cooling system on the saw band guides
- › Motorised swarf clearing brush
- › Automatic band guide setting

We are always happy to perform sample cutting for your material. Call us for details!

Model	HMBS 1200 x 1400 HA X
Art. no.	3690052

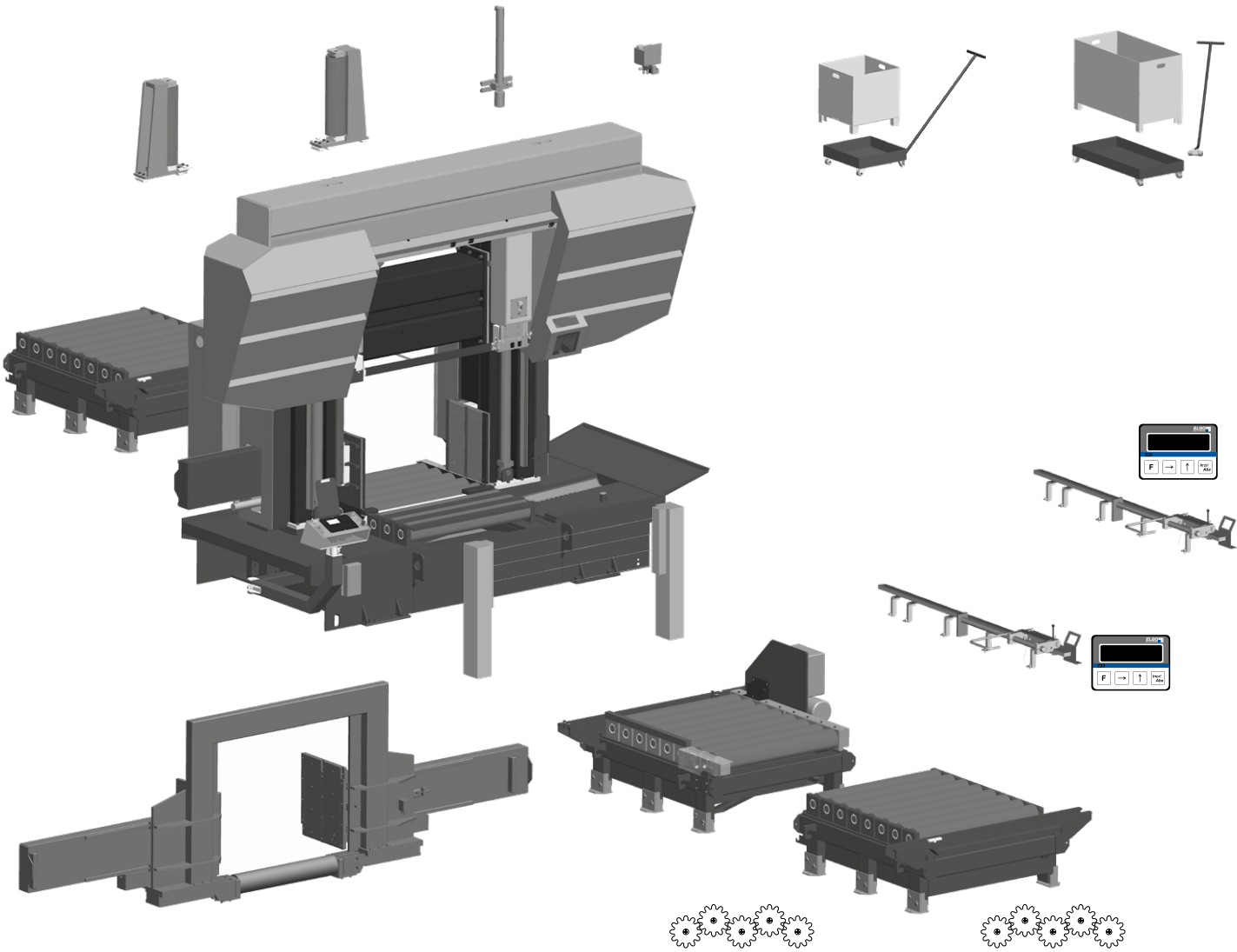
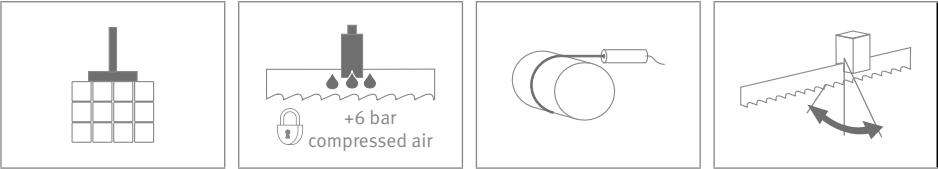
Technical specifications	
Motor output 3 x 400 V/50 Hz	11 kW
Speed stages	Continuously variable
Saw band speeds	15–80 m/min
Saw band dimensions	11 650 x 80 x 1.6 mm
Dimensions (L x W x H)	5 200 x 2 350 x 4 000 mm
Table height material feed	800 mm
Weight	25 000 kg



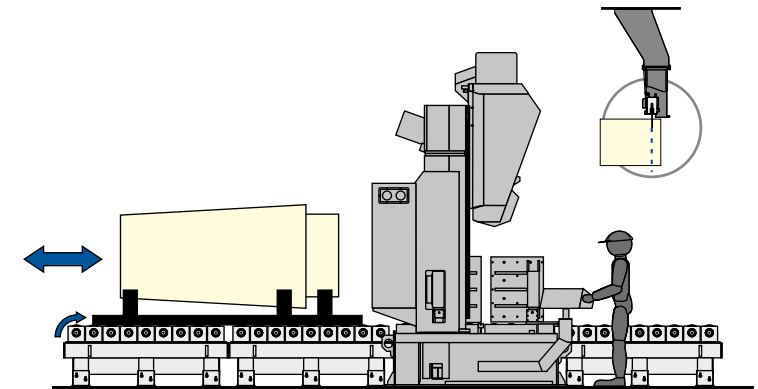
Clamping ranges

mm	0°
	1 200
	1 200 *
	1 200 x 1 400

* recommended values



! Accessories for HMBS 1 200 x 1 400 on request!



Magnetic drilling

Deburring

Metal grinding

Cutting

Notching & punching

Bending

Presses

Circular saws

Roller conveyors

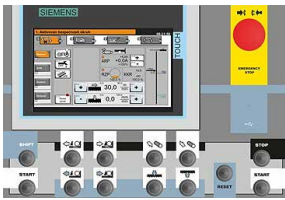
Metal-cutting band saws

HVMBS 850 x 1 000 Xtreme

Semi-automatic two column horizontal metal-cutting horizontal/vertical band saw with moving material support table for heavy-duty industrial use

- ▶ Developed for cutting full materials
- ▶ Material movements are handled by a moving clamping table borne on a linear guide and actuated by an independent control
- ▶ Saw band swivels through 90° - ideal for notching in blocks of solid material
- ▶ Automatic band guide with adjustable tungsten carbide plates and cooling system
- ▶ A hydraulic system controls the machines automated work sequences
- ▶ With an electrically driven swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ The wheels are tilted for a longer saw band service life
- ▶ With continuously variable saw band speed setting
- ▶ End switches control the upper and lower end positions of the saw arm
- ▶ Saw arm with stroke measuring sensor for determining the position above the workpiece support plus an additional bottom end position sensor

Semi-automatic



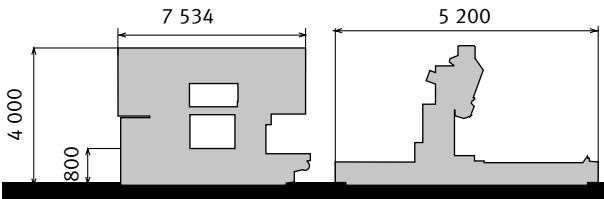
! For an exhaustive explanation of the controls, see pages 227 – 231

- Scope of delivery:**
- › Saw band
 - › Operating tool
 - › Two workplace lights
 - › ARP system
 - › Chip conveyor
 - › Moving clamping table with 2 500 mm stroke
 - › Automatic band guide setting
 - › Frequency converter



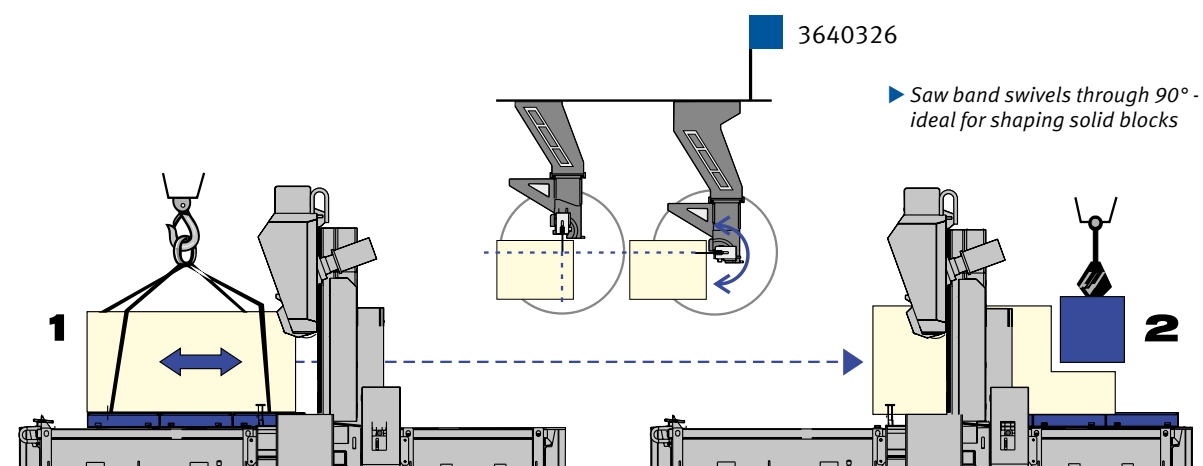
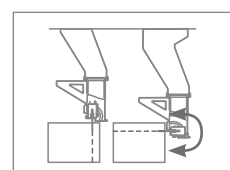
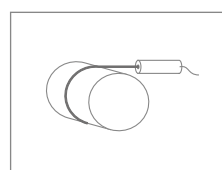
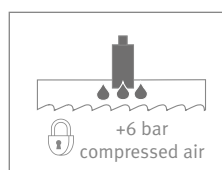
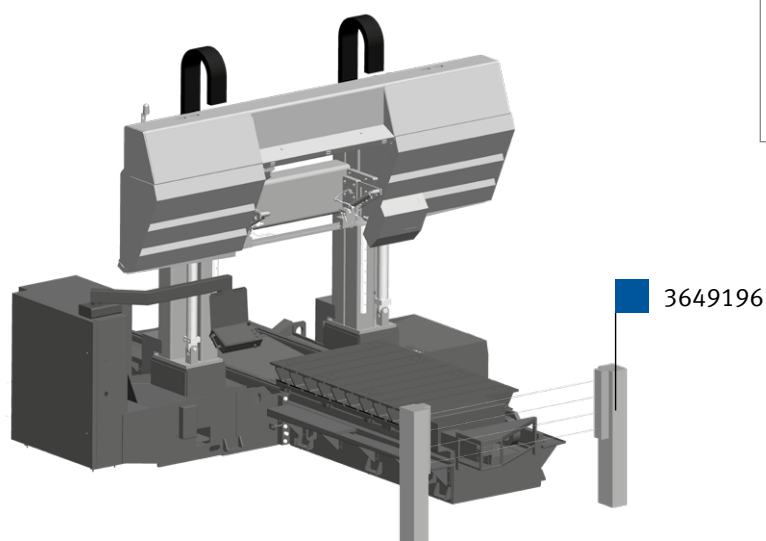
Model	HVMBS 850 x 1 000 Xtreme
Art. no.	3690020

Technical specifications	
Motor output 3 x 400 V/50 Hz	11.0 kW
Speed stages	Continuously variable
Saw band speeds	15–80 m/min
Saw band dimensions	9 080 x 67 x 1.6 mm
Dimensions (L x W x H)	5 200 x 7 534 x 4 000 mm
Table height material feed	800 mm
Weight	12 500 kg



We are always happy to perform sample cutting for your material. Call us for details!

Clamping ranges	
mm	0°
	850
	1 000 x 850
	2 000 x 850



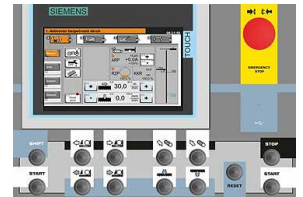
Optional accessories	Art. no.
Micro-spraying system	3640010
Cutting line laser	3640011
Safety light barrier	3649196
Hydraulically swivelling saw band guide	3640326

HVMBS 1 200 x 1 600 Xtreme

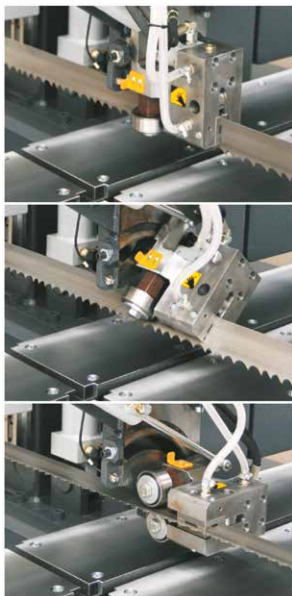
Semi-automatic two column horizontal/vertical metal-cutting band saw with moving feed table for heavy-duty industrial use

Semi-automatic

- ▶ Developed for cutting full materials
- ▶ Material movements are handled by a moving clamping table borne on a linear guide and actuated by an independent control
- ▶ Saw band swivels through 90° - ideal for notching in blocks of solid material
- ▶ Automatic band guide with adjustable tungsten carbide plates and cooling system
- ▶ A hydraulic system controls the machines automated work sequences
- ▶ With an electrically driven swarf clearing brush for optimum cleaning and maintenance of the saw band
- ▶ The wheels are tilted for a longer saw band service life
- ▶ With continuously variable saw band speed setting
- ▶ End switches control the upper and lower end positions of the saw arm
- ▶ Saw arm with stroke measuring sensor for determining the position above the workpiece support plus an additional bottom end position sensor



! For an exhaustive explanation of the controls, see pages 227 – 231



- ▶ Saw band swivels through 90° - ideal for notching in blocks of solid material



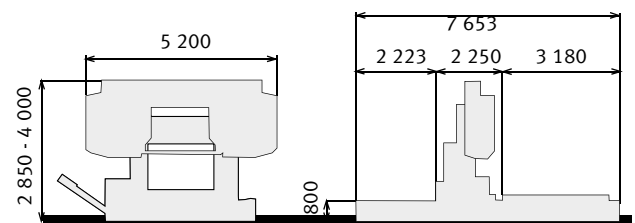
Scope of delivery:

- › Saw band
- › Operating tool
- › Automatic band guide setting
- › Chip conveyor
- › Electrically driven swarf clearing brush
- › Workplace lighting
- › Frequency converter,

We are always happy to perform sample cutting for your material. Call us for details!

Model	HVMBS 1 200 x 1 600 Xtreme
Art. no.	3690032

Technical specifications	
Motor output 3 x 400 V/50 Hz	11 kW
Speed stages	Continuously variable
Saw band speeds	15–80 m/min
Saw band dimensions	11 650 x 80 x 1.6 mm
Dimensions (L x W x H)	5 200 x 7 653 x 4 000 mm
Table height material feed	800 mm
Weight	30 350 kg

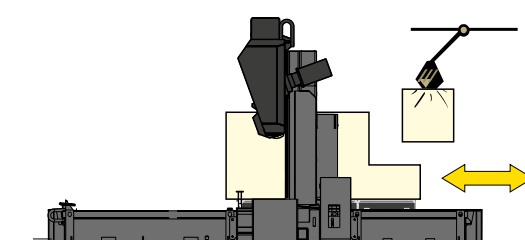
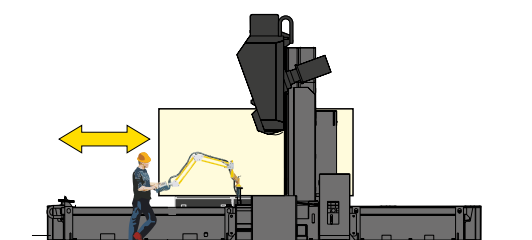
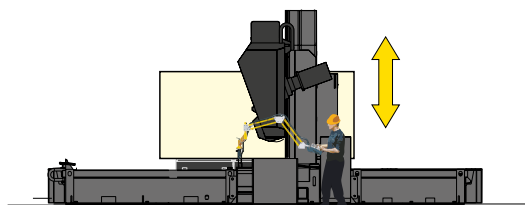
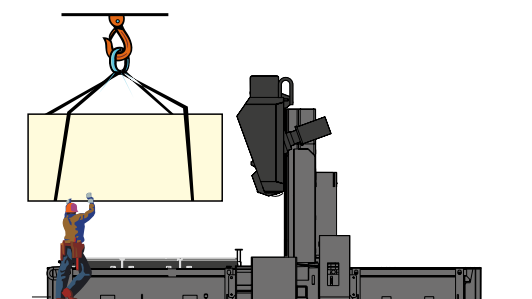


Clamping ranges

mm	0°
	1 200
	1 600 x 1 200
	1 600 x 3 000



► Moving clamping table with 2 500 mm stroke and T grooves



- Material feed on HVMBS 1 200 x 1 600 Xtreme**
- Material feed by clamping table
 - The table is borne on linear guides and is actuated by a separate control
 - The feed speed is continuously variable
 - Solid work table with T grooves

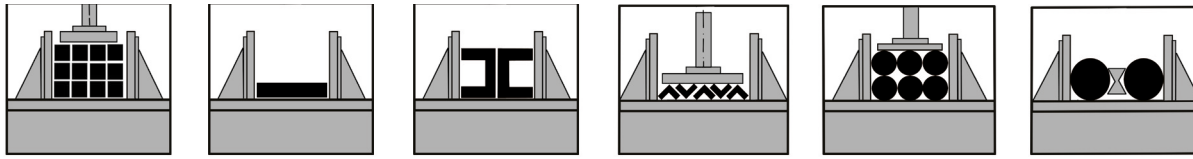
! Accessories for HVMBS 1 200 x 1 600 Xtreme on request!

Overview of saw bands

Information on metal-cutting band saws and saw bands

Clamping the material

- ▶ Clamp the material to allow for vibration-free operation of the saw band to the extent possible
- ▶ In case of bundle cutting, weld the ends if needed (this improves the cut performance and service life)



Coolant

The coolant helps to prevent overheating of the saw tooth and the workpiece, and it transports the swarf away from the cut location.

It is normal to saw all steels while using a cooling emulsion. Cast iron is normally dry sawn. Cutting oil helps you achieve good cutting results when sawing case-hardened steels, higher-alloyed tool steels, heat-treated steels, stainless steels (VA) and titanium.

Running in correctly: a guarantee for long service lives.

Like all tools, saw bands need to be correctly run in. This guarantees the longest service lives and it saves tool and tooling costs.

The very sharp tooth tips must not be fully exposed to load when you start cutting. Premature overload can cause the tooth tips to break out. Correct running in helps to round the blades perfectly.

Bi-metal saw bands

For the first 300 - 500 cm² of cut surface, the saw band runs at half the feed speed and the recommended cutting speed

After the running in time, the feed is gradually increased to the intended value. If vibrations or vibration noises occur at the start of cutting, you need to make minor adjustments to the cutting speed.

Carbide saw bands

We recommend the following application values for at least the first 30 minutes:

Material diameters up to 600 mm cutting speed = 30 m/min. (feed speed = 5 mm/min)

Material diameters above 600 mm cutting speed = 25 m/min. (feed speed = 3 mm/min)

The cutting and feed speeds can gradually be increased simultaneously to the desired maximum value when the saw band is completely vibration free.

Cutting speed and feed

The cutting speed (band speed) depends on the strength, grade and cross-section of the material to be sawed. The higher the strength, the lower the speed you need to select. Smaller diameters can be sawed at higher speeds than larger diameters. Thin-walled pipes and sections, and sharp edges, are sawed at a low speed, and at a constant feed rate (pressure) where possible.

Materials

Cutting speed in m/min
(M42)

- Construction steel/Machining steel
- Case-hardened steels/Heat-treated steels
- Unalloyed tool steels/Rolled steels
- Alloyed tool steels/High-speed steels
- Stainless steels
- Heat resistant steels/Highly heat-resistant alloys

80-90

45-75

40-60

30-40

20-35

15-25

The chip shape itself tells you if the speed and feed are correct:



thin or powdery chips - increase the feed speed



loosely rolled chips - cutting values correct



thick, heavy of blue chips - cutting values too high

- ▶ In case of vibration, minimally adjust the cutting speed (m/min) up or down.
- ▶ As blunting increases, increase the feed rate slightly

Teeth arrangement recommendations for solid materials:

Variable toothing		
Material cross-section	Teeth per inch	
mm	tpi	Tooth shape
as of 550	0.75/1.25	K
380 - 750	1/1.5	K
250 - 550	1.4/2	K
120 - 350	2/3	K
80 - 140	3/4	K
60 - 110	4/6	K
40 - 70	5/7 5/8	K
30 - 60	6/10	K
20 - 40	8/11 8/12	K
up to 25	10/14	K

K = combined tooth

Teeth arrangement recommendations for pipes:

Thin-walled sections (0° rake angle)							
Wall thickness	Section external diameter (D) in mm						
(S) in mm	20	40	60	80	100	120	150
2	14	14	14	14	14	14	10/14
3	14	14	14	14	10/14	10/14	8/11 8/12
4	14	14	10/14	10/14	8/11 8/12	8/11 8/12	6/10
5	14	10/14	10/14	8/11 8/12	8/11 8/12	6/10	6/10
6	14	10/14	8/11 8/12	8/11 8/12	6/10	6/10	5/7 5/8
8	14	8/11 8/12	6/10	6/10	5/7 5/8	5/7 5/8	5/7 5/8
10	-	6/10	6/10	5/7 5/8	5/7 5/8	5/7 5/8	-

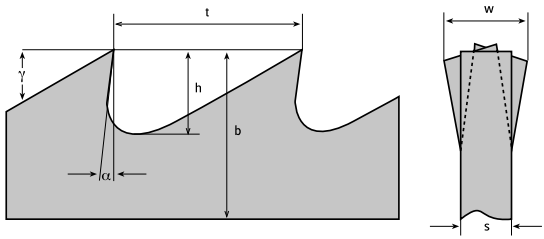
N = Standard tooth

H = Hook tooth

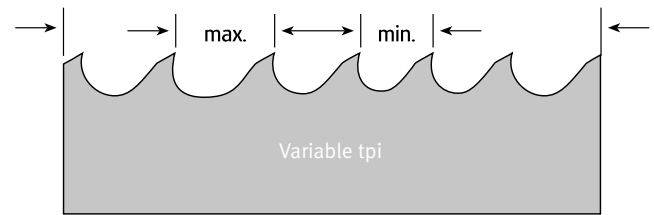
Combined teeth layouts 1,4/2, 2/3, 3/4, 4/5, 4/6 with 10° rake angle: these tooth shapes are particularly well suited to cutting solid, high-alloyed, long-chipping steel grade materials;

The use of 3/4 tooth layout allows for a good, clean cut surface in the upper Ø range up to 140 mm material cross-section.

Saw band geometry

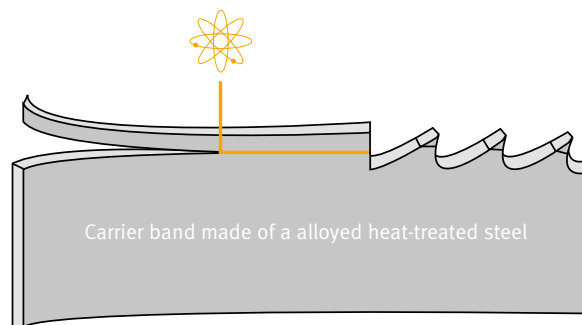


Teeth per inch



The distances between teeth change in a tooth group. Combined toothing of the saw band is designated by reference to the largest or smallest tooth in the tooth group.

Bi-metal



So flexible:

The carrier band on the bi-metal saw band consists of a specially alloyed heat-treated steel. Highly flexible with a strength of approx. 50 HRC. Long fatigue life and excellent in terms of the band run, this is an optimal basis.

Tough and resilient:

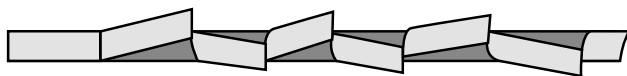
Tooth tips made of heat-treated HSS steel, M42 and M51 grades, guarantee maximum wear resistance thanks to mature heat treatment techniques and a defined structural state.

Optimally joined:

The carrier band and the HSS flat wire are optimally and immutably joined by electron or laser beam welding.

All the benefits:

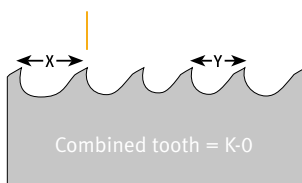
The premium bi-metal saw band combines the flexibility of the carrier with the enormous wear resistance of HSS high speed steel. Each tooth tip of the finished saw band consists of heat-treated HSS steel, tough, resilient to load and with great performance.



In addition to the tooth shape and tpi, the exact set of the saw band is definitive for its performance. An application-specific set guarantees correct cutting by the saw band. It prevents the band jamming - which is important for difficult steels. The set type and width is precisely matched to the cutting task:

Tooth shapes

Only the right choice of tooth shape optimally cuts your material with low vibration. There are various basic types here:

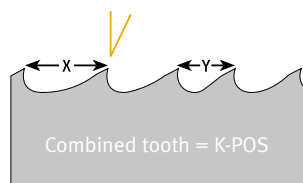


Specialist for:

- ▶ long-chipping, tough materials
- ▶ large cross-sections

Data:

- ▶ positive rake angle
- ▶ 2 to 6 TPI



Specialist for:

- ▶ low-vibration cutting
- ▶ Profiles

Data:

- ▶ Rake angle of 0°
- ▶ variable TPI from 3/4 to 10/14 TPI



We are always happy to perform sample cutting for your special material.
Call us for details!

Saw bands

M42 Sprint saw bands

The section expert for small to medium wall thicknesses

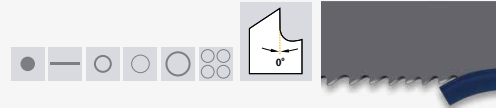
Dimensions	Variable tooth groups					
mm	3/4	4/6	5/8	6/10	8/12	10/14
6 x 0.90						K
10 x 0.90						K
13 x 0.65			K	K	K	K
13 x 0.90				K	K	K
20 x 0.90		K	K	K	K	K
27 x 0.90	K	K	K	K	K	K
34 x 1.10	K	K	K	K	K	K
41 x 1.30	K	K	K	K		
54 x 1.60		K*	K*			

K = combined tooth *Special article

The combined with a 0° rake angle in combination with the group set will cut thin-walled sections with little vibration. Short-chipping material is processed with ease. The M42-SPRINT bi-metal saw band improves the service life and achieves good cutting quality.

The specialist for:

- ▶ popular steel grades up to approx. 1 400 N/mm² tensile strength
- ▶ NE sections
- ▶ Individual and bundle cuts
- ▶ Sections with low or medium wall thickness
- ▶ Steel sheets on vertical plate sawing systems



M42 Sprint Plus saw bands

Powerful for materials with medium to large dimensions

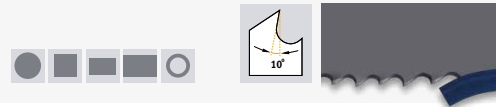
Dimensions	Variable tooth groups				
mm	0.75/1.25	1.4/2	2/3	3/4	4/6
20 x 0.90					K
27 x 0.90			K	K	K
34 x 1.10		K	K	K	K
41 x 1.30		K	K	K	K
54 x 1.30		K	K	K	K
54 x 1.60	K	K	K	K	K
67 x 1.60	K	K	K		
80 x 1.60	K	K			

K = combined tooth *Special article

The combined tooth with a positive rake angle in combination with the group set will cut solid material and thick-walled sections with little vibration, while improving the cutting performance and achieving a smooth surface.

The specialist for:

- ▶ popular steel grades up to approx. 1 400 N/mm² tensile strength
- ▶ NE sections
- ▶ Individual and bundle cuts
- ▶ Medium to large sized workpieces
- ▶ Thick-walled sections



M42 Sprint Medium VS saw bands

The multifunctional talent for many cutting tasks

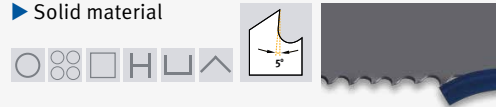
Dimensions	Variable tooth groups				
mm	2/3	3/4	4/6	5/7	8/11
20 x 0.90					K-V
27 x 0.90		K-V	K-V	K-V	K-V
34 x 1.10	K-V	K-V	K-V	K-V	
41 x 1.30	K-V	K-V	K-V		
54 x 1.30		K-V			
54 x 1.60	K-V	K-V	K-V		
67 x 1.60	K-V	K-V			

K-V = reinforced combined tooth

The new reinforced HL combined tooth with a positive rake angle in combination with the group set will cut solid material and thick-walled sections with very little vibration, while improving the cutting performance, achieving a smooth surface and an impressive service life.

The specialist for:

- ▶ small to medium-sized swivel frame machines
- ▶ popular steel grades up to approx. 1 400 N/mm² tensile strength
- ▶ Individual and bundle cuts
- ▶ Sections and beams
- ▶ Solid material



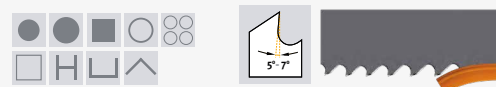
M42-X-FIT saw bands

The all rounder for small to medium-sized workpieces

Dimensions	Variable tooth groups				
mm	2/3	3/4	4/6	5/7	8/11
20 x 0.90					K-V
27 x 0.90		K-X	K-X	K-V	K-V
34 x 1.10	K-V	K-X	K-X	K-V	
41 x 1.30	K-X C-TEC	K-V C-TEC	K-X		
54 x 1.30		K-X			
54 x 1.60	K-X C-TEC	K-X C-TEC			
67 x 1.60	K-X C-TEC	K-X C-TEC			

K-X = reinforced, aggressive combined tooth
K-V = reinforced combined tooth

- ▶ The all-purpose band
- ▶ Specially developed tooth shape
- ▶ For processing a particularly large range of materials
- ▶ Universal deployment for solid material and sections
- ▶ Economical
- ▶ Reduces stock levels
- ▶ The specialist for solid material and sections



M51 Sprint Plus saw bands

Extra wear resistant teeth for steels and alloys of medium dimensions

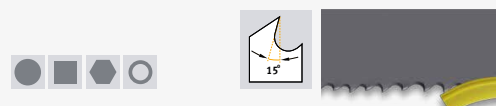
Dimensions	Variable tooth groups		
mm	2/3	3/4	4/6
27 x 0.90	K	K	K
34 x 1.10	K	K	K
41 x 1.30	K	K	
54 x 1.60	K		
67 x 1.60	K		

K = combined tooth *Special article

The combined with an extremely positive rake angle in combination with the group set will cut thin-walled sections with little vibration. Tooth tips made of HSS M 51 additionally improve the band service life, in particular for problematic materials.

The specialist for:

- ▶ popular steel grades up to approx. 1 700 N/mm² tensile strength
- ▶ Corrosion and acid-resistant steels
- ▶ Nickel based alloys
- ▶ Titanium and special bronzes
- ▶ Solid material medium dimensions
- ▶ Thick-walled sections



Saw bands for all Metallkraft metal band saws



Quality Made in Germany

Saw bands for metal-cutting band saws	Art. no.	€ plus VAT	Saw bands for metal-cutting band saws	Art. no.	€ plus VAT	Saw bands for metal-cutting band saws	Art. no.	€ plus VAT
VMBS 1408 (bi-metal M 42)			BMBS 220 x 250			BMBS 300 x 320		
2 880 x 10 x 0.9 mm 10-14 Vario	3651110		2 450 x 27 x 0.9 mm 5-8 TPI	3655122		3 660 x 27 x 0.9 mm 5-8 TPI	3656301	
2 880 x 13 x 0.65 mm 6-10 Vario	3651210		2 450 x 27 x 0.9 mm 6-10 TPI	3655127		3 660 x 27 x 0.9 mm 6-10 TPI	3656302	
2 880 x 13 x 0.65 mm 8-12 Vario	3651212		2 450 x 27 x 0.9 mm 10-14 TPI	3655123		3 660 x 27 x 0.9 mm 10-14 TPI	3656303	
2 880 x 13 x 0.65 mm 10-14 Vario	3651214		2 450 x 27 x 0.9 mm 3-4 TPI	3655120		3 660 x 27 x 0.9 mm 3-4 TPI	3656304	
VMBS 1610 / VMBS 1610 E (bi-metal M 42)			2 450 x 27 x 0.9 mm 2-3 TPI	3655121		3 660 x 27 x 0.9 mm 2-3 TPI	3656305	
3 140 x 13 x 0.65 mm 6-10 Vario	3651310		2 450 x 27 x 0.9 mm 4-6 TPI	3655119		3 660 x 27 x 0.9 mm 4-6 TPI	3656306	
3 140 x 13 x 0.65 mm 8-12 Vario	3651312		2 450 x 27 x 0.9 mm 3-4 TPI	3655125		3 660 x 27 x 0.9 mm 2-3 TPI	3656307	
3 140 x 13 x 0.65 mm 10-14 Vario	3651314		2 450 x 27 x 0.9 mm 2-3 TPI	3655126		3 660 x 27 x 0.9 mm 3-4 TPI	3656308	
VMBS 2012 / VMBS 2012 E (bi-metal M 42)			2 450 x 27 x 0.9 mm 3-4 TPI (PU 5)	3655800		3 660 x 27 x 0.9 mm 4-6 TPI	3656309	
4 030 x 13 x 0.65 mm 6-10 Vario	3651710		2 450 x 27 x 0.9 mm 4-6 TPI (PU 5)	3655801		3 660 x 27 x 0.9 mm 3-4 TPI (PU 5)	3655815	
4 030 x 13 x 0.65 mm 8-12 Vario	3651712		BMBS 230 x 280			3 660 x 27 x 0.9 mm 4-6 TPI (PU 5)	3655816	
4 030 x 13 x 0.65 mm 10-14 Vario	3651714		2 720 x 27 x 0.9 5-8 TPI	3655508		BMBS 360 x 500 / HMBS 340		
			2 720 x 27 x 0.9 6-10 TPI	3655510		4 780 x 34 x 1.1 mm 5-8 TPI	3655403	
4 030 x 20 x 0.9 mm 6-10 Vario	3651720		2 720 x 27 x 0.9 10-14 TPI	3655514		4 780 x 34 x 1.1 mm 6-10 TPI	3655405	
4 030 x 20 x 0.9 mm 8-12 Vario	3651722		2 720 x 27 x 0.9 2-3 TPI	3655603		4 780 x 34 x 1.1 mm 2-3 TPI	3655400	
4 030 x 20 x 0.9 mm 10-14 Vario	3651724		2 720 x 27 x 0.9 3-4 TPI	3655604		4 780 x 34 x 1.1 mm 3-4 TPI	3655401	
			2 720 x 27 x 0.9 4-6 TPI	3655606		4 780 x 34 x 1.1 mm 4-6 TPI	3655402	
4 030 x 27 x 0.9 mm 6-10 Vario	3651730		2 720 x 27 x 0.9 2-3 TPI	3655703		4 780 x 34 x 1.1 mm 3-4 TPI (PU 5)	3655825	
4 030 x 27 x 0.9 mm 8-12 Vario	3651732		2 720 x 27 x 0.9 3-4 TPI	3655704		4 780 x 34 x 1.1 mm 4-6 TPI (PU 5)	3655826	
4 030 x 27 x 0.9 mm 10-14 Vario	3651734		2 720 x 27 x 0.9 4-6 TPI	3655706		BMBS 460 x 600		
VMBS 2613 / VMBS 2613 E (bi-metal M 42)			2 720 x 27 x 0.9 mm 3-4 TPI (PU 5)	3655805		5 380 x 41 x 1.3 mm 3-4 TPI	3655230	
4 680 x 13 x 0.65 mm 6-10 Vario	3651810		2 720 x 27 x 0.9 mm 4-6 TPI (PU 5)	3655806		5 380 x 41 x 1.3 mm 2-3 TPI	3655231	
4 680 x 13 x 0.65 mm 8-12 Vario	3651812		BMBS 250 x 315			5 380 x 41 x 1.3 mm 4-6 TPI	3655232	
4 680 x 13 x 0.65 mm 10-14 Vario	3651814		2 825 x 27 x 0.9 mm 5-8 TPI	3655222		HMBS 350 x 400		
			2 825 x 27 x 0.9 mm 6-10 TPI	3655226		4 520 x 34 x 1.1 mm 5-8 TPI	3655201	
4 680 x 20 x 0.9 mm 6-10 Vario	3651820		2 825 x 27 x 0.9 mm 10-14 TPI	3655223		4 520 x 34 x 1.1 mm 6-10 TPI	3655218	
4 680 x 20 x 0.9 mm 8-12 Vario	3651822		2 825 x 27 x 0.9 mm 3-4 TPI	3655220		4 520 x 34 x 1.1 mm 3-4 TPI	3655001	
4 680 x 20 x 0.9 mm 10-14 Vario	3651824		2 825 x 27 x 0.9 mm 2-3 TPI	3655221		4 520 x 34 x 1.1 mm 2-3 TPI	3655101	
			2 825 x 27 x 0.9 mm 4-6 TPI	3655219		4 520 x 34 x 1.1 mm 3-4 TPI (PU 5)	3655820	
4 680 x 27 x 0.9 mm 6-10 Vario	3651830		2 825 x 27 x 0.9 mm 3-4 TPI	3655224		4 520 x 34 x 1.1 mm 4-6 TPI (PU 5)	3655821	
4 680 x 27 x 0.9 mm 8-12 Vario	3651832		2 825 x 27 x 0.9 mm 4-6 TPI	3655225		HMBS 400 x 400		
4 680 x 27 x 0.9 mm 10-14 Vario	3651834		2 825 x 27 x 0.9 mm 3-4 TPI (PU 5)	3655810		5 580 x 41 x 1.3 mm 3-4 TPI	3655600	
VMBS 3612 / VMBS 3612 E (bi-metal M 42)			2 825 x 27 x 0.9 mm 4-6 TPI (PU 5)	3655811		5 580 x 41 x 1.3 mm 2-3 TPI	3655601	
5 020 x 13 x 0.65 mm 6-10 Vario	3651910		BMBS 240 x 280			HMBS 300 x 300 & HMBS 400		
5 020 x 13 x 0.65 mm 8-12 Vario	3651912		2 980 x 27 x 0.9 mm 5-8 TPI	3655206		4 520 x 34 x 1.1 mm 2-3 TPI	3655520	
5 020 x 13 x 0.65 mm 10-14 Vario	3651914		2 980 x 27 x 0.9 mm 6-10 TPI	3655207		4 520 x 34 x 1.1 mm 3-4 TPI	3655521	
			2 980 x 27 x 0.9 mm 10-14 TPI	3655208		4 520 x 34 x 1.1 mm 4-6 TPI	3655522	
5 020 x 20 x 0.9 mm 6-10 Vario	3651920		2 980 x 27 x 0.9 mm 3-4 TPI	3655013		HMBS 500 x 750		
5 020 x 20 x 0.9 mm 8-12 Vario	3651922		2 980 x 27 x 0.9 mm 2-3 TPI	3655115		6 500 x 41 x 1.3 mm 5-8 TPI	3655242	
5 020 x 20 x 0.9 mm 10-14 Vario	3651924		2 980 x 27 x 0.9 mm 4-6 TPI	3655116		6 500 x 41 x 1.3 mm 2-3 TPI	3655240	
			2 980 x 27 x 0.9 mm 2-3 TPI	3655212		6 500 x 41 x 1.3 mm 3-4 TPI	3655241	
5 020 x 27 x 0.9 mm 6-10 Vario	3651930		2 980 x 27 x 0.9 mm 3-4 TPI	3655213		HMBS 510 x 510		
5 020 x 27 x 0.9 mm 8-12 Vario	3651932		2 980 x 27 x 0.9 mm 4-6 TPI	3655214		6 060 x 41 x 1.6 mm 3-4 TPI	3655007	
5 020 x 27 x 0.9 mm 10-14 Vario	3651934		BMBS 290 x 290 & BMBS 290 x 320			6 060 x 54 x 1.6 mm 2-3 TPI	3655107	
			3 100 x 27 x 0.9 mm 5-8 TPI	3655200		HMBS 700 x 750		
Saw bands for metal-cutting band saws	Art. no.	€ plus VAT	3 100 x 27 x 0.9 mm 6-10 TPI	3655209		7 680 x 41 x 1.6 mm 3-4 TPI	3655410	
MBS 105			3 100 x 27 x 0.9 mm 10-14 TPI	3655204		7 680 x 67 x 1.6 mm 2-3 TPI	3655411	
1 335 x 13 x 0.65 mm 6-10 TPI	3650011		3 100 x 27 x 0.9 mm 3-4 TPI	3655000		HMBS 850 x 1 000 & HVMBS 850 x 1 000		
1 335 x 13 x 0.65 mm 10-14 TPI	3650012		3 100 x 27 x 0.9 mm 2-3 TPI	3655100		9 080 x 41 x 1.6 mm 3-4 TPI	3655011	
MBS 125			3 100 x 27 x 0.9 mm 4-6 TPI	3655146		9 080 x 67 x 1.6 mm 2-3 TPI	3655111	
1 440 x 13 x 0.65 mm 6-10 TPI	3650014		3 100 x 27 x 0.9 mm 2-3 TPI	3655227		HMBS 1 200 x 1 400, HVMBS 1 200 x 1 600 Xtreme,		
1 440 x 13 x 0.65 mm 10-14 TPI	3650015		3 100 x 27 x 0.9 mm 3-4 TPI	3655228		11 650 x 80 x 1.6 mm 3-4 TPI	3655113	
MBS 150			3 100 x 27 x 0.9 mm 4-6 TPI	3655229		11 650 x 80 x 1.6 mm 2-3 TPI	3655114	
1 735 x 27 x 0.9 mm 6-10 TPI	3650017							
1 735 x 13 x 0.9 mm 10-14 TPI	3650018							
MBS 155								
1 735 x 27 x 0.9 mm 6-10 TPI	3650017							
1 735 x 13 x 0.9 mm 10-14 TPI	3650018							

- M42 Sprint saw bands
- M42 Sprint Plus saw bands
- M42 Sprint Medium VS saw bands
- M42-X-FIT saw bands
- M51 Sprint Plus saw bands

See left-hand side for explanations