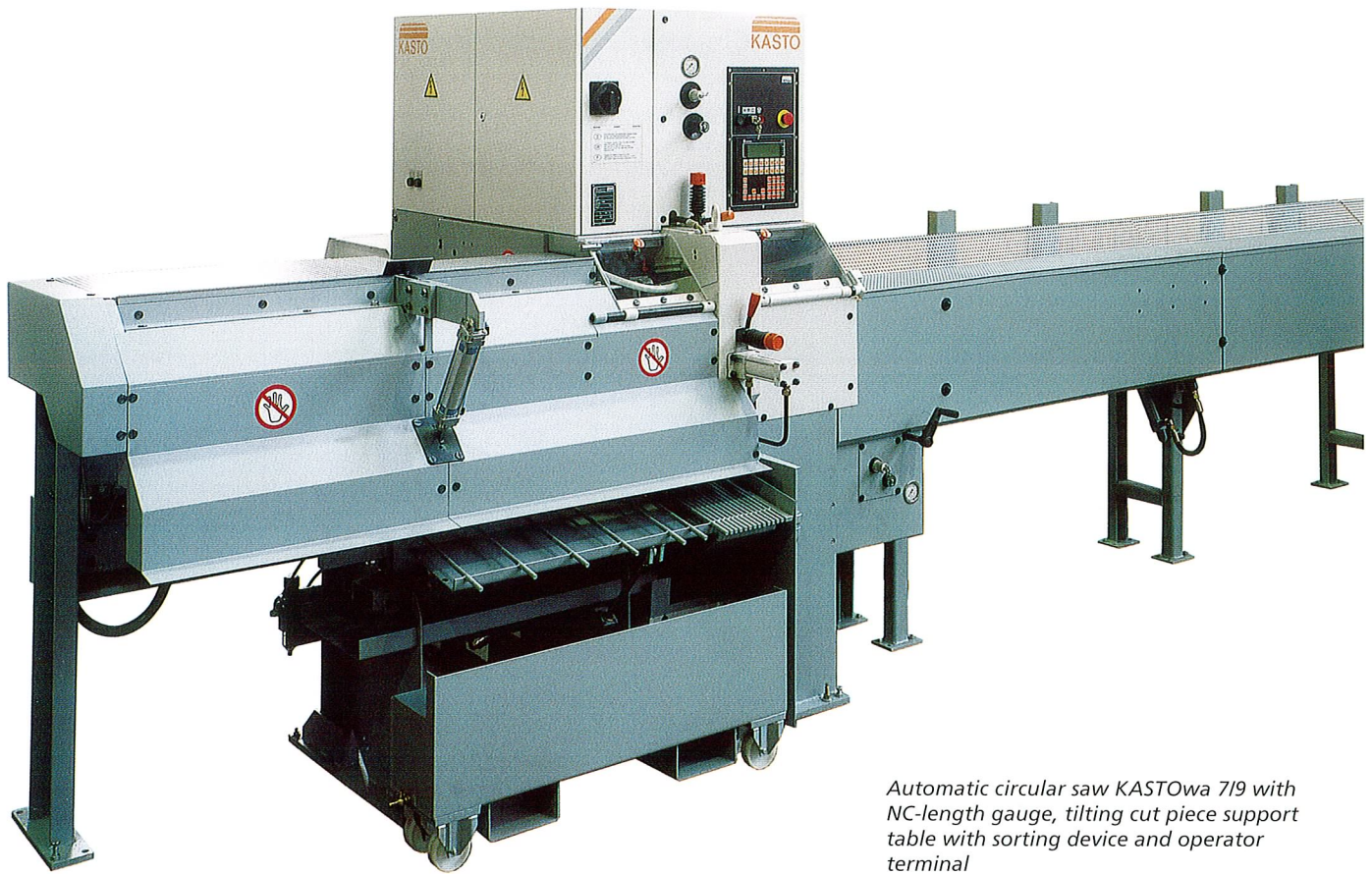




## **Automatic Circular Sawing Machines Series KASTOwa 719**

*for Cutting of Pieces in Large Batches of Steel and NF-Metals*





Automatic circular saw KASTOwa 719 with NC-length gauge, tilting cut piece support table with sorting device and operator terminal

The **automatic circular sawing machines KASTOwa 719** are expressly designed and manufactured for the automatic sawing of cut pieces in large quantities of steel and nonferrous metals under heavy duty operation. Typical users include automotive parts manufacturers, cold extrusion plants or forging plants, manufacturers of fittings, valves and electrical components or with steel service centres. Depending on the machinability of the material and required production rate HSS-solid saw blades and/or carbide tipped circular saw

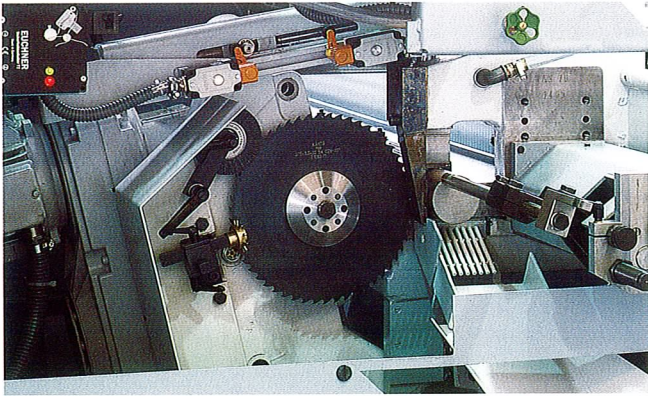
blades will be employed at suitable cutting speeds for highest possible cutting performance. The unique arrangement of saw gearing and four-point bar clamping guarantees the shortest possible cutting stroke. Fast feeding of the bar and hydraulically cushioned length gauge, as well as fast cycling, ensure high production rates of accurate cut pieces and high reliability. Various optional equipments are available for bar- and cut piece handling up to interlinking with storage equipment or with other machining centres.



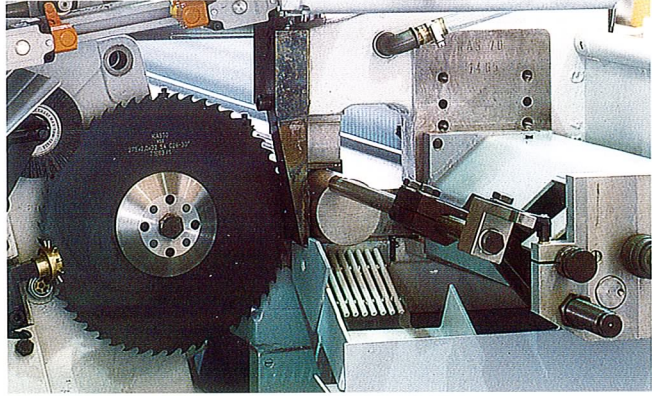
Technical Data:	KASTOwa 7	KASTOwa 9-R	KASTOwa C 7	KASTOwa M 9
Material	Steel	Steel tube	Steel	NF-metals
Type of saw blade	HSS-solid	HSS-solid	Carbide tipped	HSS-solid/carbide tipped
Saw blade diameter (Ø mm)	250/275	250/275/315	250/285	250/275/315
Cutting range: Round (Ø mm)	15-70	15-90 (tube)	15-70	15-90
Square (HxW mm)	15-65	15-80 (tube)	15-60	15-80
Rectangular (HxW mm)	15x15	15x15	15x15	15x15
Cutting speeds (m/min)	120x60 8-100	120x75 (tube) 8-114	70x60 40-160	120x75 525/1050 1) 800/1600
Saw blade drive (kW)	1.8/2.7	1.8/2.7	5.5	9/11,5 1)
Min. remnant (mm)	35	35	65	35/65

1) Other cutting speed ranges and saw blade drive motor, also with frequency-converter, upon request

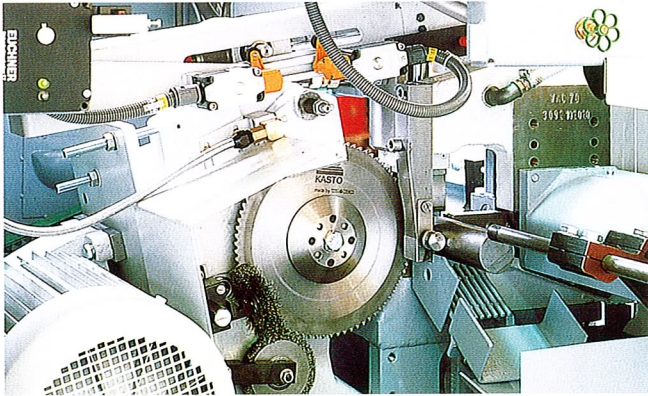
## Always economic at high production rates and for various sawing jobs



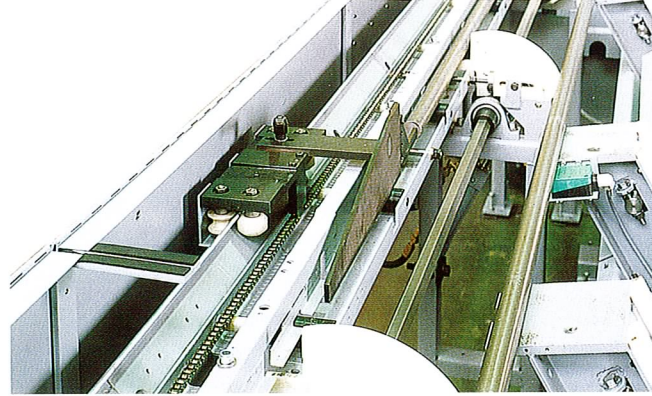
**HSS-solid saw blades** for the cutting of steel and non-ferrous metals, best suited cutting speeds and tooth geometries, for solid bar, tubes and profiles.



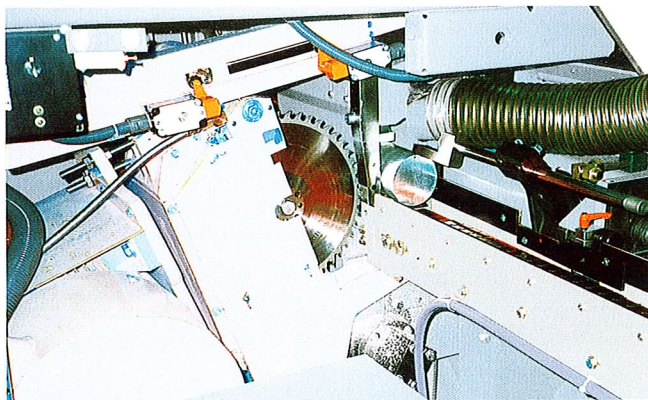
**Short cutting- and idle times**, shortest possible stroke of the blade by optimum location of the saw gearing pivot shaft for all work piece forms and dimensions.



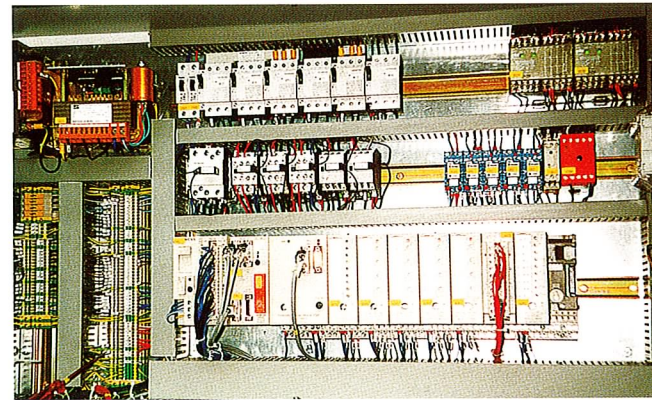
**Disposable carbide tipped saw blades** with cutting with 2 mm for the sawing of steel, for solid bar, cutting 2 – 5 times faster.



**Accurate cut pieces**, hydraulically cushioned and swiveling out length gauge with micrometer adjustment, bar pusher carriage with adjustable feed speed up to 40 m/min, optimum use of the bar length – min. remnant length 35 – 65 mm.

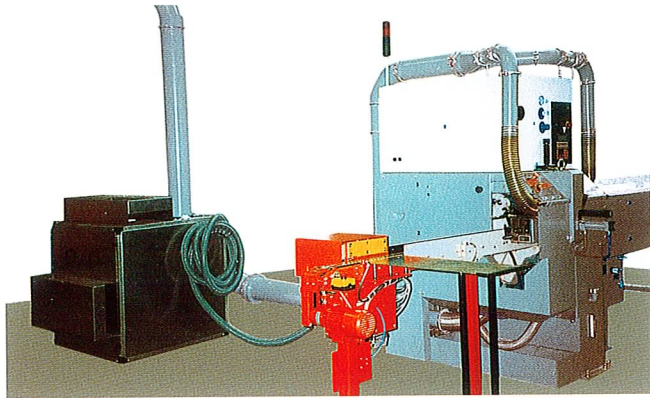


**Carbide tipped saw blades**, for the sawing of e.g. hard Aluminium alloys, saw blade drive by AC-motor with frequency converter for infinitely adjustable cutting speeds, optimum tuned tooth geometry, chip suction unit.

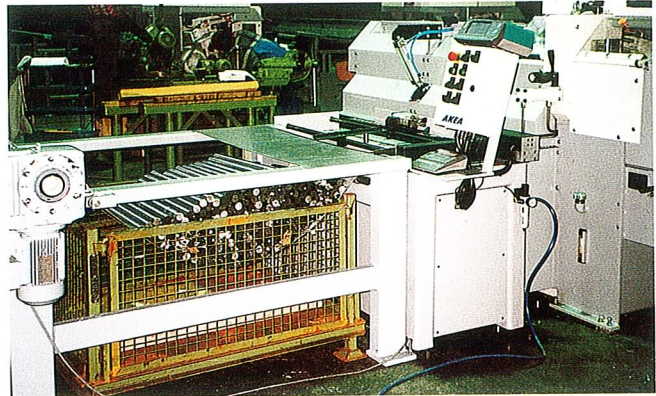


**Safe cycling of the machine**, high reliability because of field-proven components for the hydraulic and electric equipment, sequence control for the automatic cycling by means of PLC-unit. Ergonomic design, reduced noise level, fulfilling CE-Rules by electrically interlocked covers and doors.

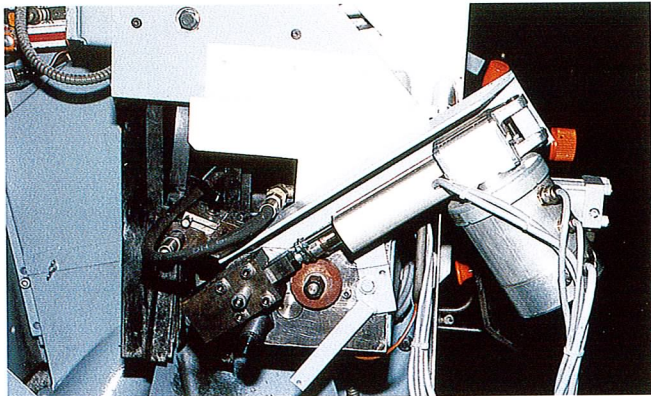
## Machines and sawing lines for customer-specific sawing applications



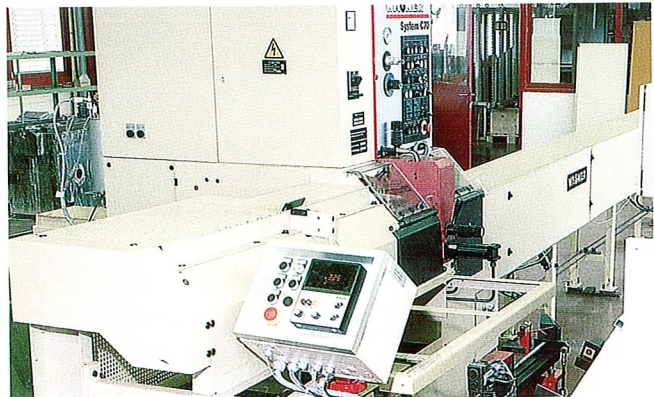
**Automatic circular saw KASTOwa M 9**, for cutting Aluminium forging blanks with carbide tipped saw blade, with chip suction unit and cut pieces discharge conveyor to interlink with the parts heater.



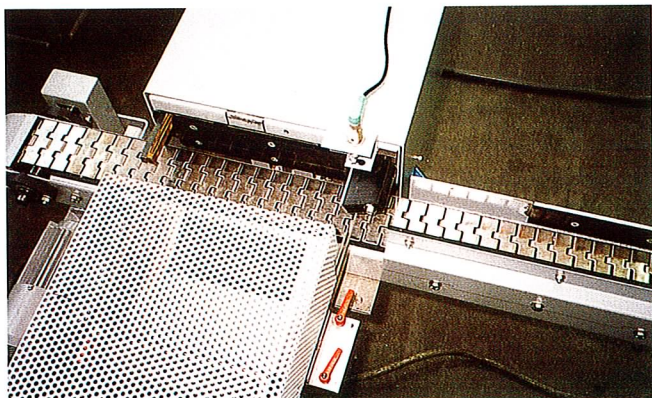
**Automatic carbide saw KASTOwa C 7** for the cutting of gear shafts, interlinked with a cut piece length measuring station – 100 % checking –, controlled cut piece discharge in container.



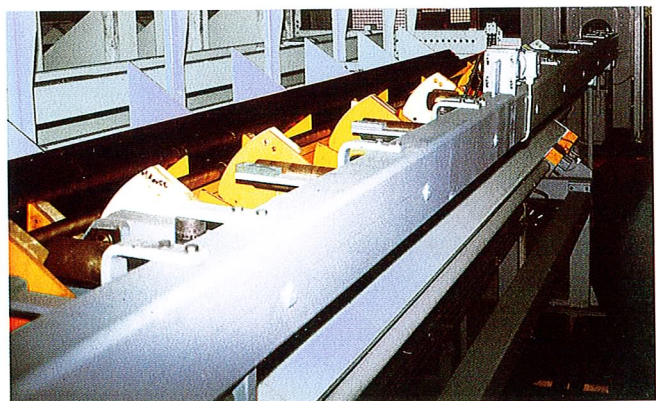
**Device Gevo** for volume-/weight accurate cut pieces as blanks for cold extrusion or forging. A glass scale measures the effective bar diameter, the calculator then determines the new length and automatically initiates a correction of the length gauge setting.



**Automatic carbide sawing line KASTOwa C 7** interlinked with end machining equipment for shafts up to 1000 mm long or a bush deburring machine.

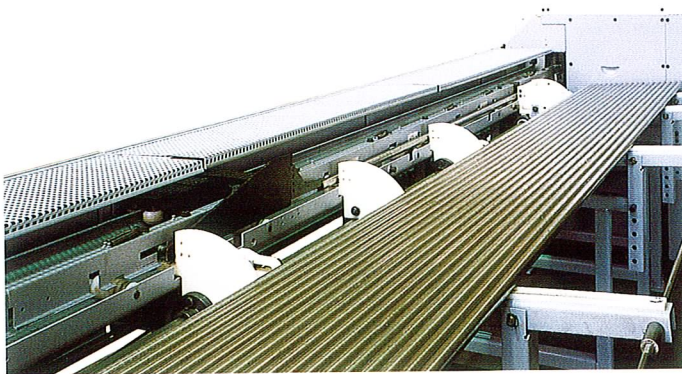


**Cut piece discharge conveyor** for protective cut piece handling with push off unit for transfer of the cut pieces to intermediate storage or to other machining equipment or to a parts heater.

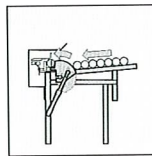


**Sawing from the storage system**, the sawing machine is directly supplied from a KASTO storage system including bar singling device.

## Pre-storage an feeding of the bars



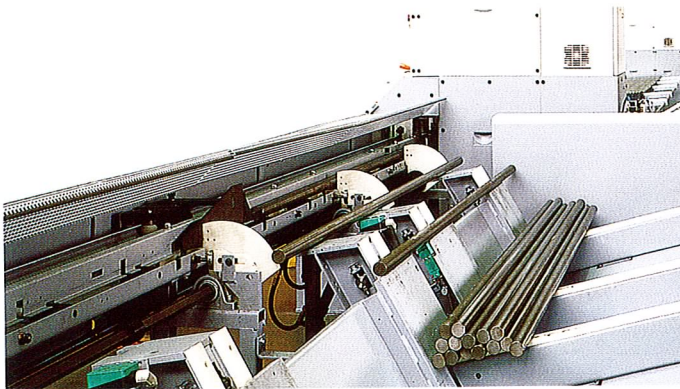
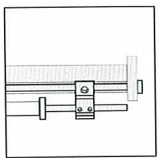
**Inclined magazine**, with 750 mm storage depth for bars up to 6000 mm is part of the basic equipment, extensions up to 12000 mm bar length are possible, suited for round-, square- and rectangular bars, bar feeding by pusher carriage driven by oil motor an chain.



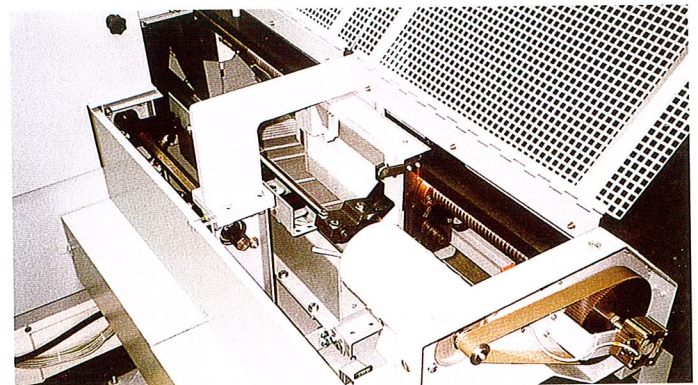
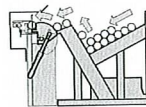
## Measuring and discharge of the cut piece



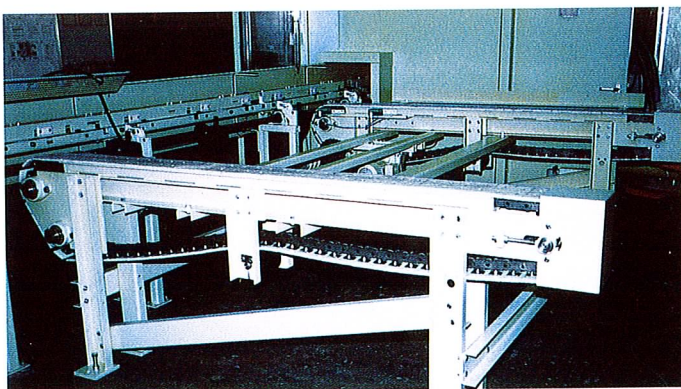
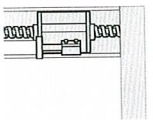
**Length gauge**, basic design for cut piece length 8 – 300 mm, hydraulically cushioned, with micrometer adjustment, manually positioned, cut piece discharge via chute with sorting gate for cut pieces, trim cuts and remnants.



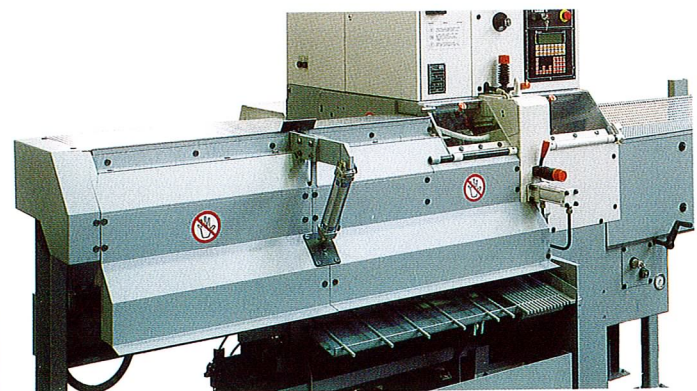
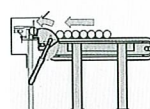
**Bundle loader** for round- and square bars in length up to 6000/10000 mm, bundle weight 3 or 5 tons. Singling and loading onto the infeed roller track by means of hydraulically operated disks.



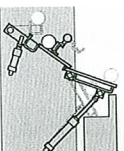
**NC-length gauge**, for cut piece lengths up to 300/1000/2000/3000 mm, positioned by means of motor with brake and frequency-converter, possibility to enter max. 20 data sets i.e. cut piece length and the requested number of pieces.



**Flat magazine**, horizontally moving transport chains with plastic plates for smooth cross feeding of bars with delicate surface, particularly suited for of rolled or extruded shapes.



**Tilting cut piece support table**, with sorting device for long cut pieces, up to 7000 mm, pneumatically actuated stop rail to align the rolling down cut pieces, also employed in case of interlinking with other machine.

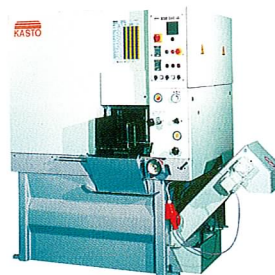


## KASTO-Industry Program

High-Performance Metal Sawing Machines for all industry and steel service applications.

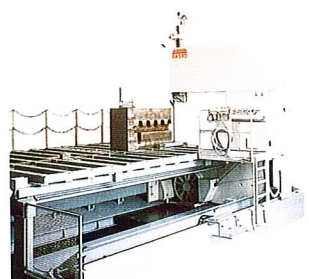
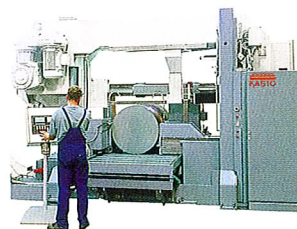
### Production-Bandsawing Machines

The saw models SSB and KASTOTEC – equipped with saw head of polymer casting – guarantee highest cutting capacity and saw band life time for the discriminating use in production facilities.



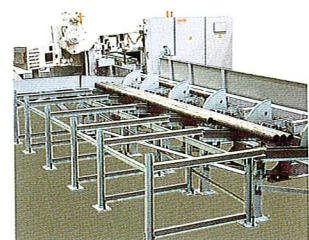
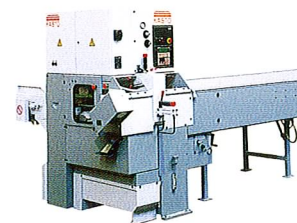
### Large Bandsawing Machines

The semi- or fully automatic KASTO-Large Bandsawing Machines with a cutting range up to 2.000 mm (78.7") are designed for cutting and handling of heavy workpieces in rough production: KASTOTEC – Horizontal Bandsawing Machines, BBS-Block- and Plate Bandsaws.



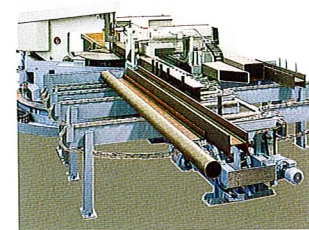
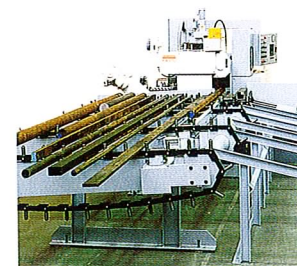
### Inclined Magazine-Sawing Machines

Fully automatic inclined magazine machines are used for cutting of large piece numbers. Depending on requirement, fast circular saws, model WA, KASTOSPEED resp. GKS or PKS, or Bandsawing Machines, type SSB or KASTOTEC, for large diameters are used.



### Programmable Magazine-Sawing Machines

Programmable Magazine Sawing Machines for straight and sometimes also mitre cuts are ideally suited for the order manufacturing of small and medium batch sizes with little personnel. Besides circular saws, type GKS or PKS, bandsaws of the types SSB, KASTOTEC and MODULAR are used.



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