



## ***Cutting bar stock without burr***

The new wet cutting unit NTS 450 from Reichmann & Sohn GmbH, Weißenhorn, cuts chrome-plated and ground piston rods producing edges free from burr and without mechanical damage for an English excavator manufacturer.



As Surtech's partner for turn key projects, the Reichmann company supplied, in addition to the wet cutting facility with automatic loading magazine, an unloading gripper including workpiece magazine for the cut piston rods, a marking module for identifying the cut workpieces and a coolant treatment system with magnetic separator and paper belt filter.

### **The operating sequence in detail**

Single bars, six metres long, are transferred manually into the loading magazine. The concept for the feed device, in conjunction with a laser light barrier, makes it possible to measure the length of the rods before cutting.

This guarantees optimum utilisation of material - focussing completely from the outset on a product with high quality at the end. Precise feeding with repeating high tolerance accuracy of the cutting stock into the cutter unit is achieved by servo-drive technology - which again

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positively determines the quality of the cutting process.

The actual cutting process for the piston rods which are hard on the outside and "soft" inside uses the "**oscillation wet cutting method**" specific to Reichmann. This means: No residual burr and therefore no additional cost-intensive further processing, but sharp and clear edges for a highly accurate fit. The result of this technology is snow-white cut surfaces without blue discoloration.

The cut piston rods are transferred onto hardened rollers and into the output magazine by unloading grippers. The integrated marking module is directly connected to the machine control and transfers product-specific data to the piston rods. Identification for further processing is thus assured. The loading and unloading of the piston rods were designed as separate sequences of the process, giving the user particularly short cycle times.

The Siemens S7-300 machine control with its operator prompting and touch panel is designed for the special conditions in manufacture. This means that even novices can learn to operate the wet cutting system safely and in a very short time.

Messrs. Reichmann und Sohn GmbH are represented in the UK by Surface Technology Products Ltd in Birmingham

pr/cuttingbarstock

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photo of the NTS 450 bar stock cutting machine attached

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