



CNC cut-off system overcomes Health and Safety issues for dressing castings

When manufacturing castings, a not inconsiderable portion of the costs arises in the dressing shop. In many firms these working sequences are very cost-intensive and time-consuming, mainly because the level of automation is very low. Finding suitable personnel is often a great problem, as the work is very demanding.



Plants where the castings can be finished in a more rational manner can relieve the strain for foundries with regard to costs and labour.

The abrasive cut-off machine now presented by Reichmann has a combination of features not found previously in cut-off systems:

The machine table is designed as a coordinate table with X and Y axis movement.

An NC revolving table with rotation through 360° is mounted on this table.

The cut-off spindle can be pivoted by program control through 90° by a hydraulic cylinder, so that horizontal and vertical cuts can be carried out after clamping just once.

All the axes are hydraulically driven and have NC control. This permits high processing speeds and very good repeatability of the severance cuts.

In many cases it is possible to cut off sprue so precisely that further trimming is not required.

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Programming does not require any special previous knowledge as it is carried out by the teach-in method.

In conjunction with the user-friendly control panel, the control system permits easy correction of individual steps, without having to rewrite the entire program. Corrections of programs already stored can be implemented quickly at any time.

The installation is equipped with an intelligent pallet changer system.

During the cut-off process inside the sound-insulated cabin, the finished workpiece is unloaded and an untreated part is loaded. This reduces unproductive time.

The control can hold two programs at the same time, so a mixture of A and B parts can be processed. Alternatively, it is also possible to process parts that have to be cut by the shift method, because not all the cuts are accessible from one side.

When setting up all the sequences of movements, the proportional valve technology used permits operation with infinitely variable speed via a manual master lever.

The laser beam positioning aid is also particularly useful. A laser beam projects the position of the severance cut onto the workpiece, thus facilitating the setting-up of the machine.

Experience in service shows that this system makes the processing times in the dressing shop considerably shorter leading to enormous cost savings.

Technical characteristics:

Space required: 4520 x 3600 x 2800 mm

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Driving power for cutting drive:	90 kW
Depth of cut:	820 mm
Pallet dimensions:	850 x 1200 mm
Cutting-off wheel:	600 x 6 x 60 mm, offset or straight
Recommended suction power:	6000 cbm/hour
Peripheral speed:	80 m/sec.

Cutting-off head 0° - 90° for horizontal or vertical cutting

Tiltable by hydraulic cylinder, interlocked by teach-in program

Read-only memory for up to 100 machining programs

For data storage, the memory can be transcribed onto a PC with a serial data transfer interface.

Reichmann machines are available from their exclusive UK agents Messrs. Surface Technology Products Ltd., who can be contacted on 0121 359 4322

Encl. Colour photo

For further information contact Klaus Lehnen on 0121 359 4322

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