

BNA 100

Fully automatic Stellite tipping machine for equipping of the saw teeth by plasma welding process



Highlights

- ✓ All components integrated in the machine: welding unit, complete cooling, annealing station (optional)
- ✓ Encapsulated machine - welding fumes can be extracted
- ✓ Stable and centred machine design. Robust, precise and low-vibration
- ✓ Simplest repair of broken teeth
- ✓ Annealing of the welded joint with the torch or optionally with a high-frequency annealing device
- ✓ **Stelliting machine using the plasma welding process:**
 - Secure, homogeneous connection with the parent material
 - Shorter grinding times / lower grinding wheel consumption
 - Use of low-cost stellite
 - Higher stelliting speed
 - Highest economic efficiency
 - Designed for rod as well as wire stellite



Stellited tooth in plasma welding process

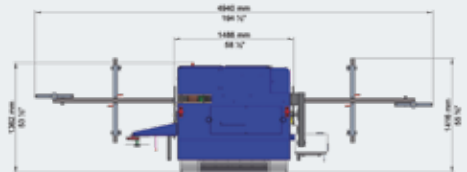
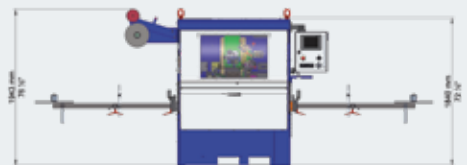


Stellited tooth in resistance welding process

The BNA 100 stellites your saw blades using the plasma welding process. The plasma welding process with inert gas guarantees a very strong connection between the stellite and the base body.

In addition to sophisticated technology, the BNA 100 is particularly characterised by its robust design, its ease of operation and its price-performance ratio.

Technical Data



GENERAL INFORMATION:

Rake angle	10 – 40°
Working speed	up to 10 T / min

BAND SAW BLADES:

Tooth pitch	10 – 100 mm
Blade length	from 6'000 mm
Blade width (Standard)	75 - 340 mm
Blade width (Option)	35 - 290 mm
Blade thickness	from 0.6 mm

CIRCULAR SAW BLADES:

Tooth pitch	10 - 40 mm
Diameter	Ø 220 - 900 mm
Bore	Ø 20 - 240 mm
Blade thickness	1.0 - 6.0 mm

GANG SAW BLADES:

Tooth pitch	10 - 100 mm
Blade length (Total)	from min. 800 mm
Blade length (Tooth length)	up to max. 1800 mm
Blade width	80 - 240 mm
Blade thickness	from 1.6 mm

PROPERTIES:

Connected load without annealing	6.3 kVA / 5.0 kW
Connected load with annealing	8.5 kVA / 7.1 kW
Compressed air	6 bar, 30 l/min
Weight	approx. 1'350 kg