

FILA 31 – A Circular saw for veneer packs with motor feed

Technical data

Useful cutting length	mm	3100
Daylight opening between clamping beam and table surface	mm	65
Electric connected load		
- Feeding motor	kW	0,55
- Saw motor	kW	2,20
- Cutter motor (*)	kW	1,10
Feeding speed adjustment	m/min	0 ÷ 20
Compressed air pressure	bar	6 ÷ 8
Compressed air consumption	Nl/ciclo	2

(*) option upon request



WORKING CYCLE

The steps of the working cycle follow in fully automatic way with PLC control:

- after clamping the veneer pack with the pressure beam, we give the start
- the sawing unit goes up to its upper position and the circular saw starts
- the carriage with the sawing unit runs longitudinally along the table as far as the limit point on the right side or to where the sawing of the pack ends
- after cutting the sawing unit goes down to its lower position and the circular saw stops

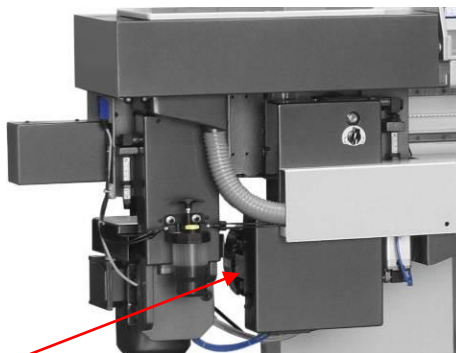
- the front table moves ahead so to open the space for the milling unit
- the milling unit lifts up to its upper position and the cutter starts
- the carriage begins to run back while the cutter operates the finishing cut
- when the carriage reaches the end of the travel on the left side, the milling unit goes down to its lower position and the cutter stops
- the front table moves back towards the closed position

STANDARD EQUIPMENT :

- Circular saw unit with pneumatic lifting and lowering
- Precision ball ways for the traverse of the circular saw unit carriage
- Axial adjustment of the saw, stepless adjustment range from 0 to 3 mm, by means of handwheel
- Mechanical adjustment of the height of the saw
- Cable and hose carrier for compressed air hoses, electric wires and suction hose
- Central system of lubrication
- Stepless feeding speed adjustment from 0 to 20 m/min. by means of potentiometer
- Torsion bar on the clamping beam
- HM circular saw Ø 180 mm
- Suction hose
- EC safety rules
- Service tools

SPECIFICATIONS

Strong and heavy frame so to give the best accuracy thanks to the high flexional and torsional stiffness.



The motors of the mobile unit with saw blade and cutter are located inside the lower frame out from the position of the operator, on the opposite side, so to assure a range of operations free from any obstacle.

Wide clamping beam complete with torsion bar.



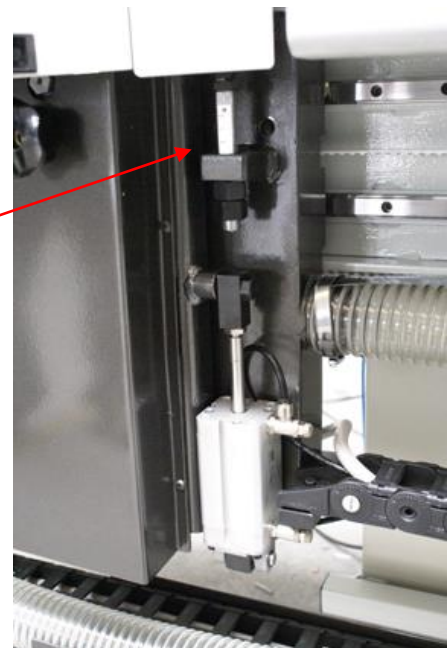
The saw and cutter units go down under the cutting area for the traverse reverse. The cutter unit can be lowered under the saw unit when the finishing cut with the cutter is not necessary.



Handwheel for the adjustment of the saw blade axial position. Stepless adjustment range $0 \div 3$ mm

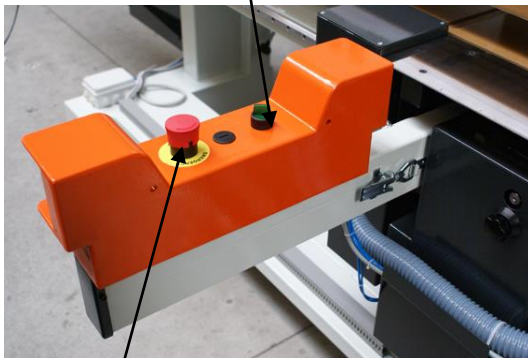
Two slide-ways with accurate linear ball-bearings

Saw blade height adjustment. Stepless adjustment range 40 mm. Pneumatic lifting and lowering.



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ON / OFF electric switch



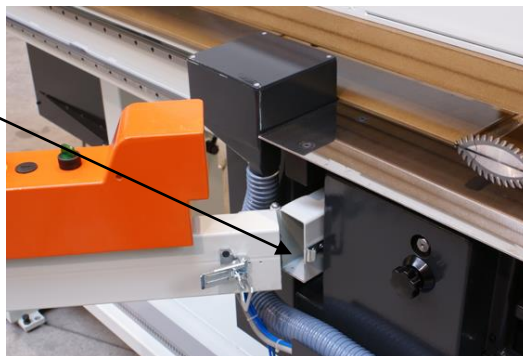
Emergency
button

Two-hands control for the saw blade
and the cutter rotation.



Switches for UP / DOWN of the
saw blade and the cutter.

The arm can be turned against the
frame when you are not working
so to save space.



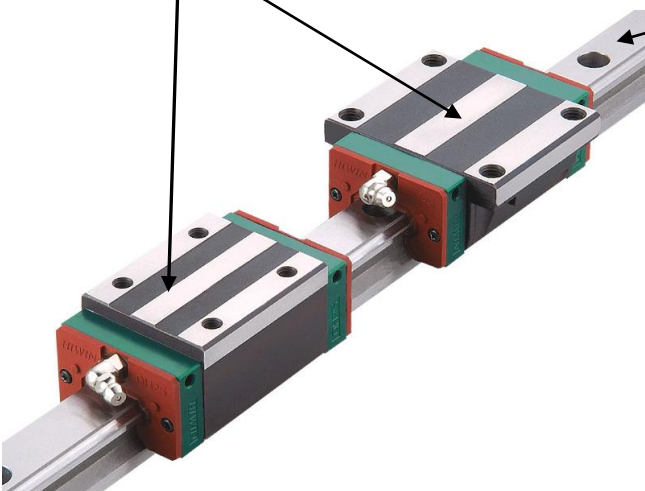
CASATI MACCHINE

The suction hoses from the saw/cutter units to the fixed mouth connected with the factory suction plant are held in the hose and cable carrier.



Linear bearings

Rail track



There is the same **linear motion system** for all the running parts in the machine: two parallel rail tracks and linear ball-bearings (slide units) assure **super precise linear motion accuracy**.

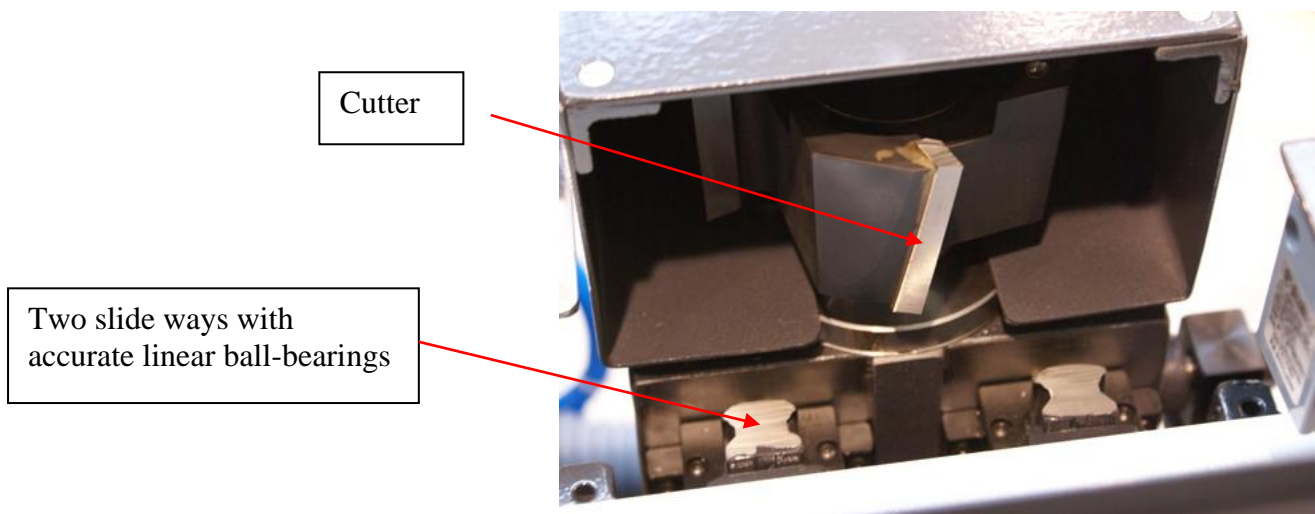
The benefits of the shape with its ball-to-ball groove contact, that give **great rigidity, high moment rigidity and backlash taking up**, are well known.

OPTIONAL EXTRAS UPON REQUEST :

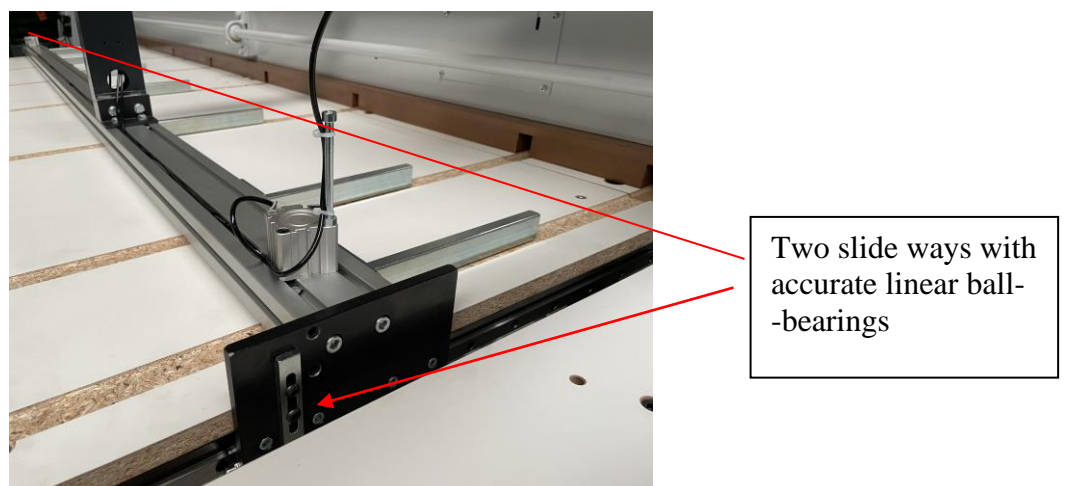
Milling unit for the finishing cut.

The HM-cutter is included.

The cutter can be pneumatically lifted and lowered. The setting range is 50 mm.



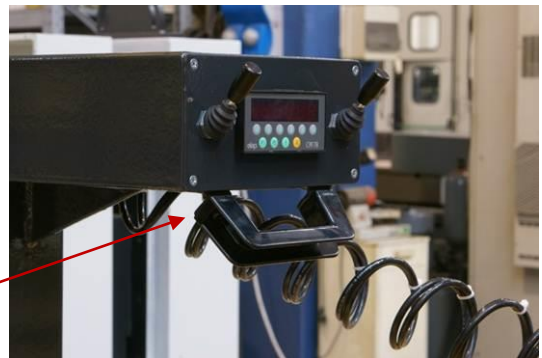
- **Back table** with mobile fence sliding on precision ball ways and pneumatic clamping devices (max. distance of the fence mm 600)





The back fence includes pneumatic clamping devices.
It is lowerable so to disappear under the working surface when it is not used.

Compact overall dimensions of the back table.



- **Electronic read-out** showing the distance between fence and cutting line, including strong handle for the wide traversese.

- **Fixed front table** for machine with circular saw unit only.



- **Mobile front table** for machine with circular saw and cutter units. In automatic way it moves ahead when the cutter is working and moves back to close after the milling operation. It is pneumatically driven.



- **Laser** showing the cutting line.



We reserve the right to change specifications and design without notice. The images are inserted for illustrative purposes.