



**The PSU 450 A
Automatic High-Performance
Circular Sawing Center**



The flexible PC-controlled high-performance circular sawing system PSU 450 A is designed for the utmost cost-effective production of small and large quantity runs.

- The PSU 450 A features up to three servo-motorized axis to ensure a precise positioning with regard to length, mitre angle setting and output gripper unit (optional)
- The material to be cut off is held by means of the output gripper unit. After the cut, the cut piece is removed from the working area in axial direction and put at a defined place.
- Extraordinarily short cycle times due to the hydraulically-controlled saw stroke
- The high-performance, load-independent positioning drives help reduce cycle times, too
- A standard feature in the saw is an innovative, dynamic saw drive technology that ensures premium cutting results.

Options:

- A freely programmable disposal unit (output grippers) including a servomotorized axis
- For sorting: the cut pieces are put at pre-programmed position
 - Output grippers help position the material for multiple cuts and mitre cutting, even at the end of a bar
 - Remnant pieces can be reduced to a minimum

Behringer Eisele PSU 450 A

Modular High-Performance Circular Sawing System PSU 450 A

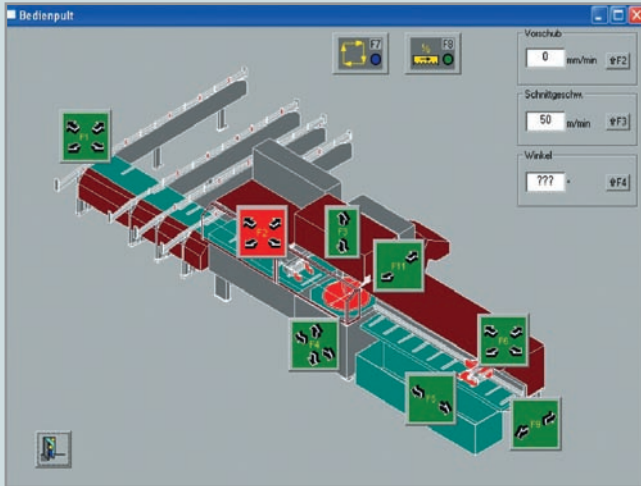
Graphical interactive PC control unit with up to three servo-motorized axis for material feed, mitre table, and discharge of cut-off and remnant pieces.



System solutions by BEHRINGER EISELE

BEHRINGER EISELE offers a wide range of system solutions. Flat, bundle and inclined loading magazines for material loading can be linked to the machine for universal applications and to suit your specific requirements. The cut pieces can be removed and sorted by tiltable roller conveyors, disposal conveyor belts or chain conveyors with sorting units.

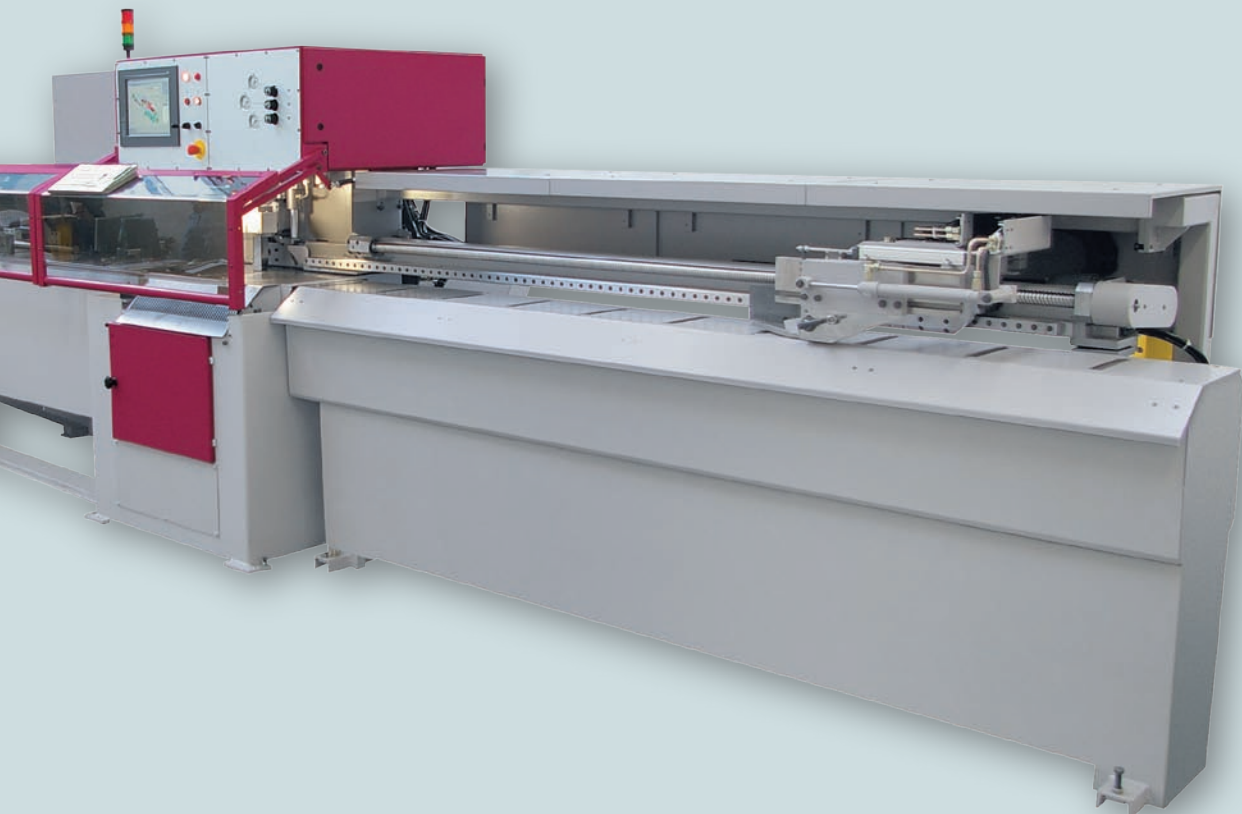




PC Control

With our specially developed software and its simple and clear programming features you will always be on the inside track. It is based on the comprehensive BEHRINGER know-how in the field of process optimization.

- The graphic display allows for simple and convenient operation for the end-user
- The operator's panel is clearly arranged and displays actual values and manual functions
- The operator can program future jobs during the production process
- Order data base with a clear and logic input mask for a large variety of cuts
- Flexible order programming with manual or automatically-optimized bar optimization feature
- Automatic calculation of sawing parameters
- Integrated tool administration for varying sawing tasks
- Network-compatible
 - Networking with planning systems via open sawing order interface
 - The end-user has the ability to link more work stations for production scheduling
- Easy to service and user-friendly thanks to error diagnosis feature and display of service and maintenance intervals



Technical Data of the PSU 450 A

Modell		PSU 450 A
Maximum saw blade diameter	mm (inch)	450 (17.72)
Rectangular material 90°	mm (inch)	240 x 70 (9.45 x 2.76)
Rectangular material 45°	mm (inch)	170 x 70 (6.69 x 2.76)
Rectangular material 30°	mm (inch)	120 x 70 (4.72 x 2.76)
Square material 90°	mm (inch)	140 (5.51)
Square material 45°	mm (inch)	125 (4.92)
Square material 30°	mm (inch)	100 (3.94)
Round material 90°	mm (inch)	150 (5.91)
Round material 45°	mm (inch)	145 (5.71)
Round material 30°	mm (inch)	120 (4.72)
Drive performance	kW (HP)	7.1 (9.65)
Standard speed	min ⁻¹ / RPM	6-80
Feed rate – infinitely variable	mm/sec (inch/sec)	0 - 14 (0 - 0.55)
Rapid return of saw blade	mm/sec (inch/sec)	75 (2.95)
Turntable swivelling to both sides	(degree)	30 - 90 - 30
Single stroke	mm (inch)	1490 (58.66)
Multiple stroke	mm (inch)	9999.9 (393.70)
Material feed rate	mm/sec (inch/sec)	500 (19.69)
Reversing speed	mm/sec (inch/sec)	500 (19.69)
Weight	approx. kg (approx. lb)	2600 (5730)
Dimensions L x W x H	mm (inch)	4200 x 1345 x 2050 (165.35 x 52.95 x 80.71)

Possible cutting sequences



90° cuts - same length



90° cuts - varying lengths



Cuts at same angles and at same or different lengths



Cuts at changing angle settings and at same or different lengths



Cuts at different angles and different lengths

Accessories



Bundle loading magazine
Automatic loading of materials of different shape



Bar loading magazine
Automatic loading of round bars



Flat loading magazine
Automatic loading of different material profiles - the generalist



Tiltable roller conveyor
Sorting of the cut-off and remnant pieces by means of a sorting device (mounted at the front and at the rear side of the machine) and ability to transfer to subsequent devices.



Disposal conveyor belt
One or more disposal or buffer stations, depending on application and requirements. For example, transfer to brush de-burring stations, furnaces, robots etc., or to marking stations for marking or stamping the cut pieces.



Hinge chain conveyors
For long cut-off lengths, we recommend disposal grippers in connection with a chain conveyor and/or a roller conveyor with sorting positions.



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Subject to technical modifications