

The Complete KASTO Program: Economic Sawing and Storing of Metal

Expertise right
down the line.

For over 160 years, KASTO has been recognized for quality and innovation, and offers a complete range of metal cutting saws, as well as storage and retrieval systems. Thanks to an ongoing development of new technologies and constant optimization process of machine concepts, KASTO has achieved the status of market leader in sawing and storing of metals.

KASTO's Sawing Machines



From the basic hacksaw to the high-performance automatic bandsaw capable of economically processing bar stock, blocks or plates of all grades, KASTO has the best solution for every challenge: Universal bandsaws and circular saws for light and medium applications, hacksaws employing the pushing-arching-cutting motion originated by KASTO, and production bandsaws and circular saws designed to cut medium to difficult materials.

KASTO's Storage Systems



Rapid access, optimum space utilization, clear and accurate view of stored inventory—KASTO storage systems' excelling features. And there's more! Fully automatic sawing centers, cantilever bar and sheet metal storage systems or cassette storage and commissioning systems, combined sawing and storage systems with integrated inventory control computers. As a one-source supplier, KASTO delivers the complete system, both hardware and software.

KASTO's Service



KASTO's comprehensive service program includes everything: from commissioning and training to maintenance support, service contracts, readily available spare parts and on-site service. KASTO's service incorporates individual consulting and immediate support with well-qualified teleservice. And of course, KASTO service is available worldwide.

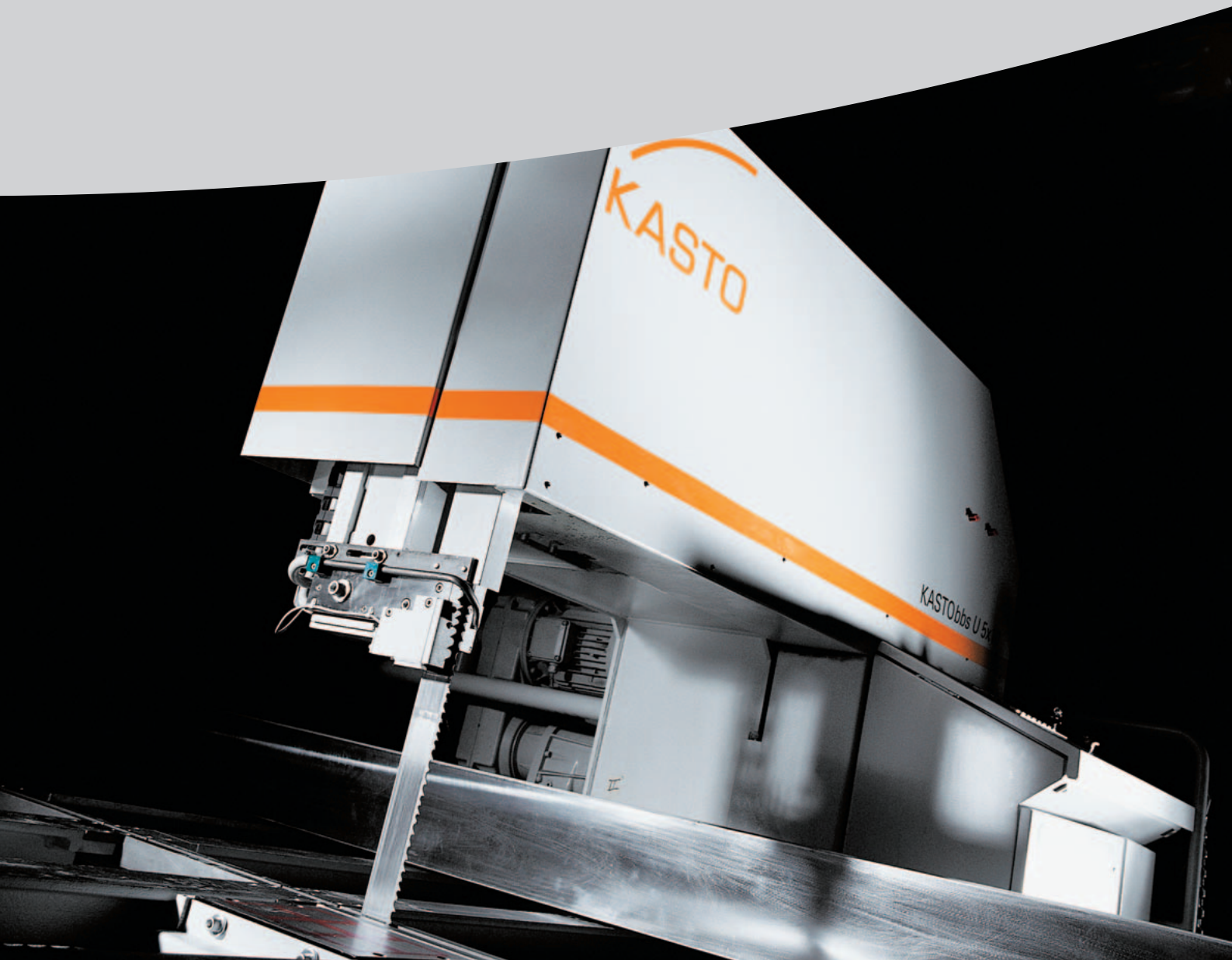
Your KASTO Partner

KASTO
Maschinenbau GmbH & Co. KG
Industriestr. 14
77855 Achern/Deutschland
Telefon +49 7841 61-0
Telefax +49 7841 61-355
E-Mail kasto@kasto.de
Internet <http://www.kasto.de>

**KASTO®**



Block and Plate Bandsawing Machines for
Longitudinal Cuts.



KASTO Block Bandsaws: Efficient Large Dimension Cutting.

Blocks, plates, notching cuts:
With KASTO Block Bandsaws.

Specifically designed for longitudinal cutting, the KASTO Block Bandsaw is the right choice for cutting different dimensions from blocks or plates; squares or flats. This principle is perfectly suited to trim plate layers and to perform notching cuts. With the use of bi-metal or carbide tipped saw blades, all material qualities – from aluminium to difficult to cut materials – can be handled with superior cutting performance. The KASTO Block Bandsaws have proven applications in steel mills and steel service centres – as well as in the tool and die industry.

Cutting lengths up to
12.000 mm!

KASTO Block and Plate Saws are available in cutting heights from 360 mm to 1.860 mm. Depending on table length, maximum cutting lengths from 2.000 mm to 12.000 mm are possible.

All machines offer an infinitely variable remote adjustment of the blade speed via plus-minus keys at the operating panel. A wide accessory range of material handling, measuring and clamping devices completes the adaptation possibilities. For example, optional measuring stops with digital display make the set-up process faster, mechanical clamping devices lock different material formats safely onto the supporting table, hydraulically lifting and lowering roller conveyors or hydraulic ball lifting tables allow fast positioning of the heaviest workpieces.

KASTO**bs**: To cut extremely large workpieces.





With the longitudinal cutting method of the KASTO Block and Plate Bandsaws, the saw unit moves – and not the workpiece.

Economic, versatile and space-saving.

The KASTO Block and Plate Bandsaws utilize the longitudinal cutting method. Under this design principle, the saw unit moves with pretensioned side-mounted rollers on precisely machined rails. The workpiece is locked on the saw table. This reduces the machine footprint by approx. 50 %, resulting in lower space costs. The fully welded, distortion-free construction of the saw head, with adjustable height of the blade guides, ensures quiet running and vibration-free working for accurate results, shorter cutting times and longer tool life. The electronically controlled saw feed guarantees short cutting times because it can be optimally adapted to material quality and material cross section. The saw blade speed is also infinitely variable.

Designed and engineered for people and technology.

Safe and easy operation.

All display and operating elements are located on the moving control panel. This permits an optimum view of the workpiece and safe control throughout the cutting procedure. The optional infrared remote control actuates the saw frame movements as well as the horizontal and vertical motions of the powered roller rails for more freedom of movement and control during set-up.

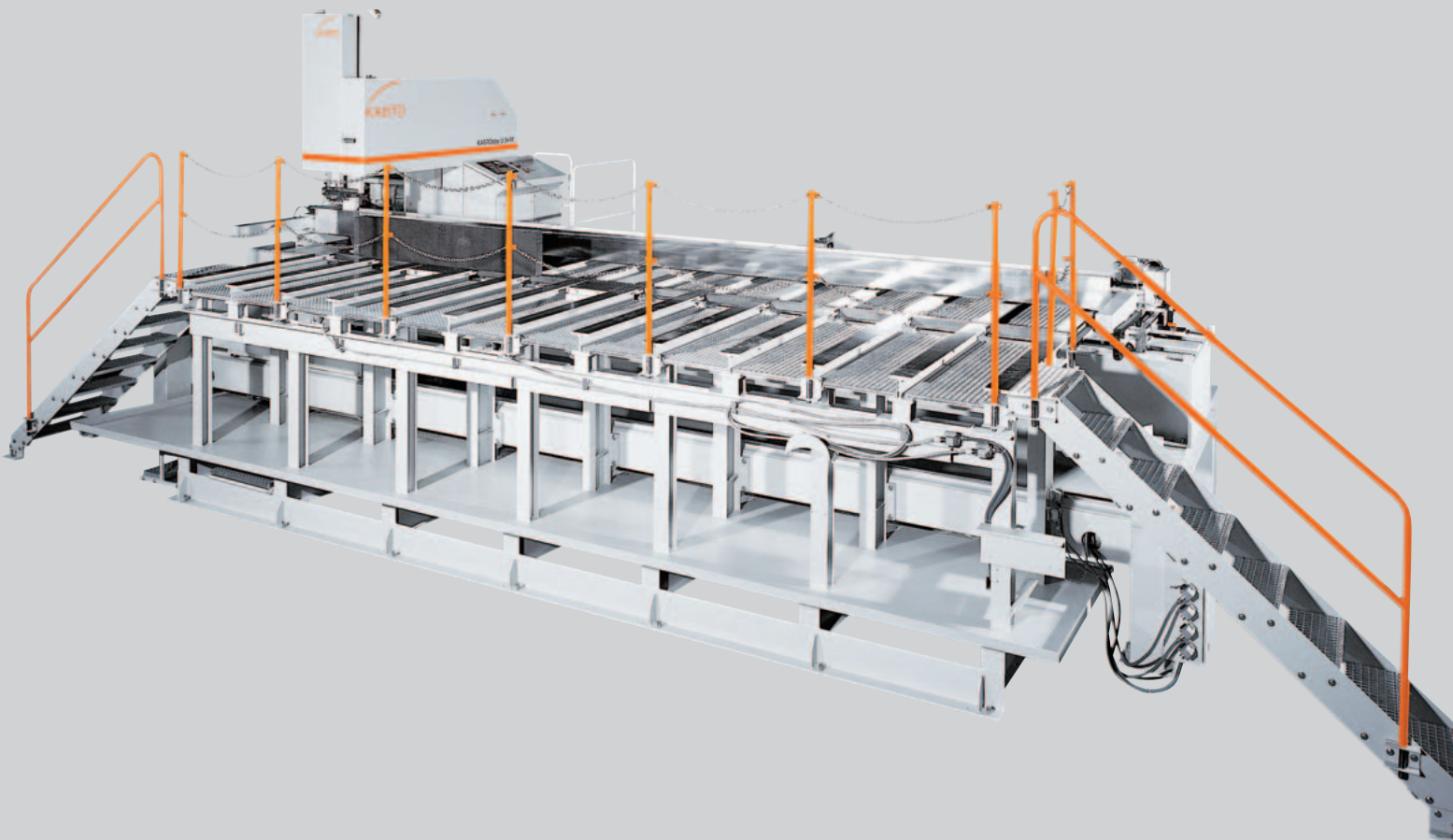
With all models of the KASTObbs Bandsaws, the hydraulically pretensioned carbide guides are equipped with a clearance stroke system for fast and easy blade change.

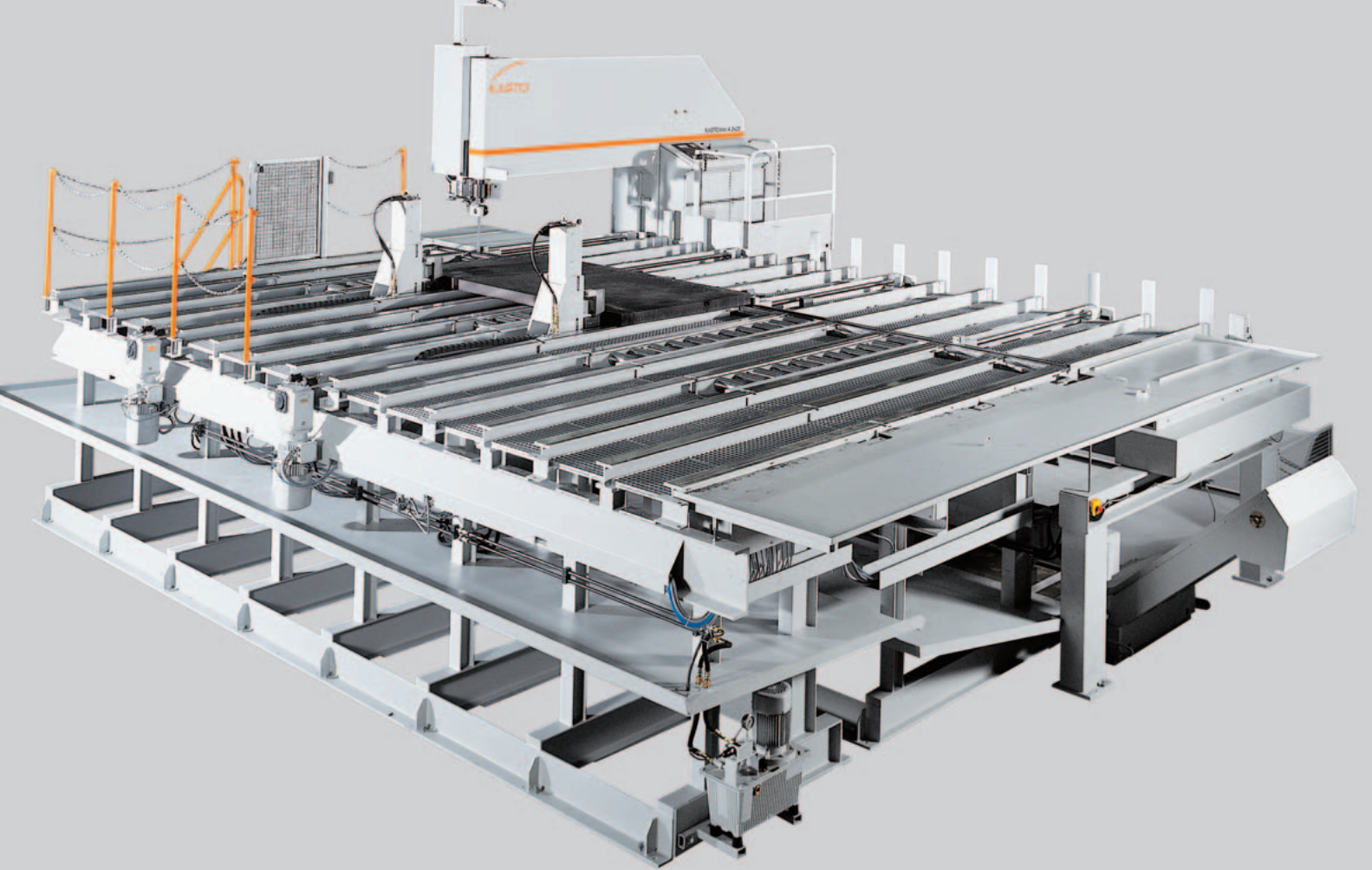
Total control: KASTO CompactControl and EasyControl.

Easy operation, less scrap, higher efficiency: With the KASTO CompactControl! Soft function keys with easy to understand symbols ease the operation of the machine. The logical user guidance delivers all important status and error messages in plain text. The economic components of the KASTO CompactControl:

- Supervision of deviation of cut by *BandControl*, of minimum blade speed by *SpeedControl*, of coolant flow by *FlowControl*.
- The optional *EasyControl* saw control adapts the saw feed and cutting speed to the material quality and dimension, on the basis of material data previously entered in the technological memory.
- Memory for up to 500 material master data records.

KASTObbs U 5x10 with laser and additional stairs (optional equipment).





Automatic Block Bandsaw KASTObbs A
3x20 saw length 6.200 mm with two
plate feed units.

Automation possibilities for the
KASTObbs.

- Saw control *EasyControl* with job memory and technological memory to store material data such as quality and dimension.
- Additional table and automatic feed units upgrade the KASTObbs U (semi-automatic) into a KASTObbs A (fully automatic)
- Hydraulically driven roller rails for a load up to 7,5 t per rail with separate hydraulic unit.
- Moving workpiece stop, driven by electric motor.
- Electro-permanent clamping magnets for front and back material supporting table.

Focused on accuracy.

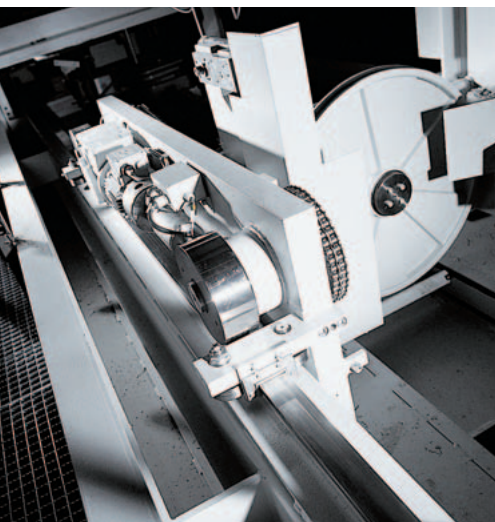
KASTObbs: High performance for heavy industry applications.

The ideal saw for high performance operation, the KASTObbs commands an impressive presence combined with quiet power. Whether heavy weights or large dimensions, the KASTObbs provides excellent handling and a high degree of automation. All operating elements are located on the moving operating panel. This ensures a safe view of the workpiece and saw blade as well as perfect control of the work process. The electronically controlled saw feed guarantees an optimum feed adjustment. With its robust construction and guides, the KASTObbs is qualified for all applications in heavy industry production. The welded saw head, especially developed for the heavy industry, is running remarkably quiet and virtually vibration-free. The result: A decrease in cutting times and optimum utilization of the blade life. The best for all qualified sawing applications – whether in steel service centres or steel mills: The KASTObbs.

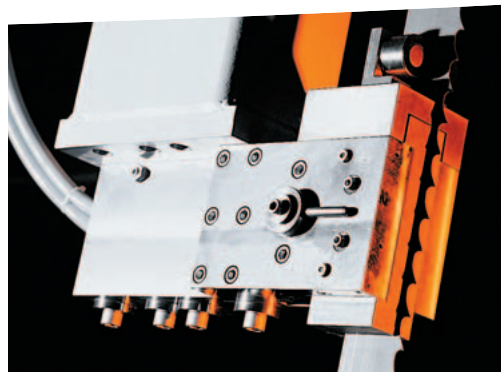
User-friendly: The standard CompactControl sawing machine control.



Saw head moves with hardened rollers on wear and tear free rails.



Hydraulically pretensioned carbide guides of the saw blade, with clearance stroke system, designed for efficient blade change.



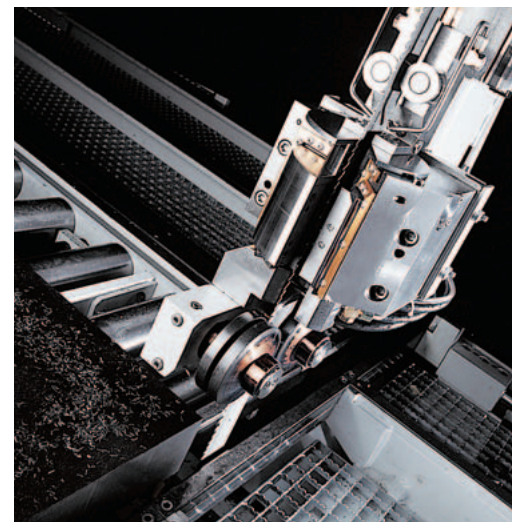
In 0° position, the KASTObbs cuts longitudinally to roller conveyor.

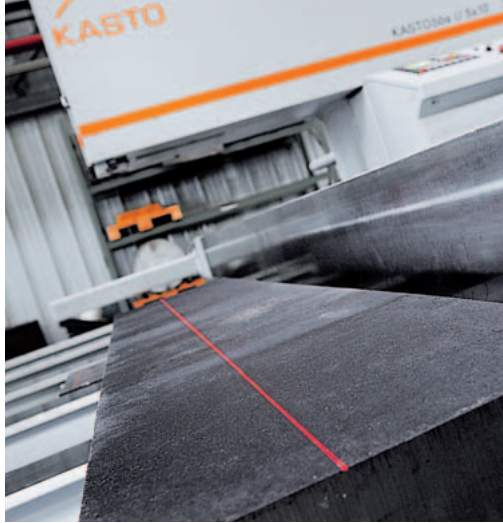


Optional: Hydraulic clamping device to lock plates.

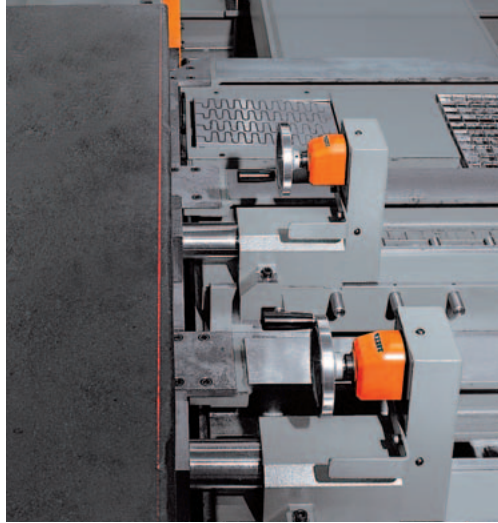


Saw direction diagonal to roller conveyor after blade twist by 90°.

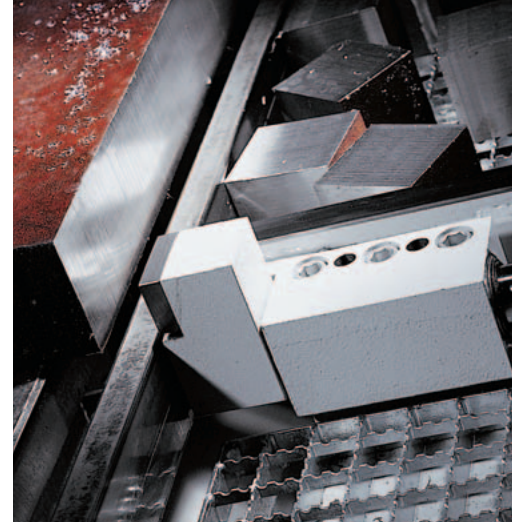




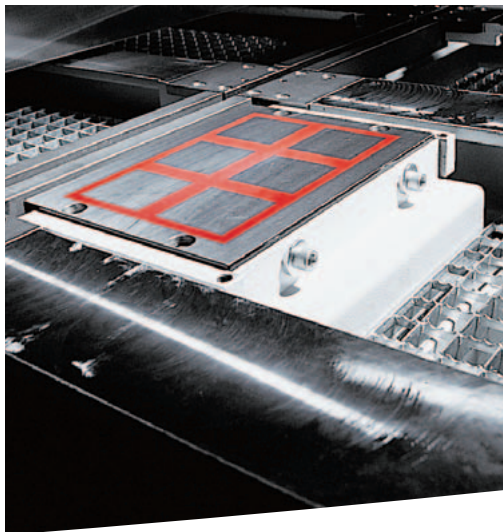
Laser lamp projects cutting line onto workpiece.



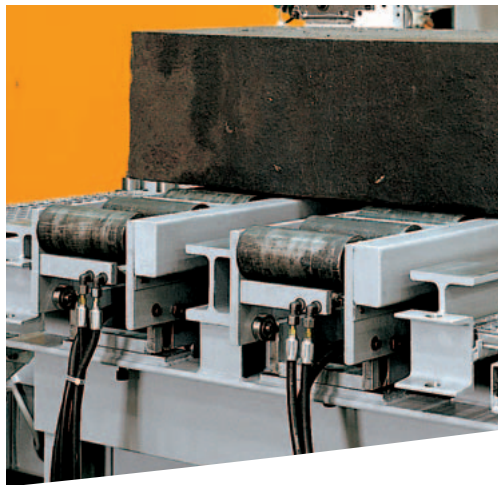
Mechanical workpiece stop, fast and easy to adjust.



Hydraulic workpiece stop positions plates on automatic block bandsaws.



Clamping magnets for smaller workpieces. Adhesive force: up to 45.000 Newton.



Handling aid for heaviest workpieces: Hydraulically lifting and lowering, driven roller rails.



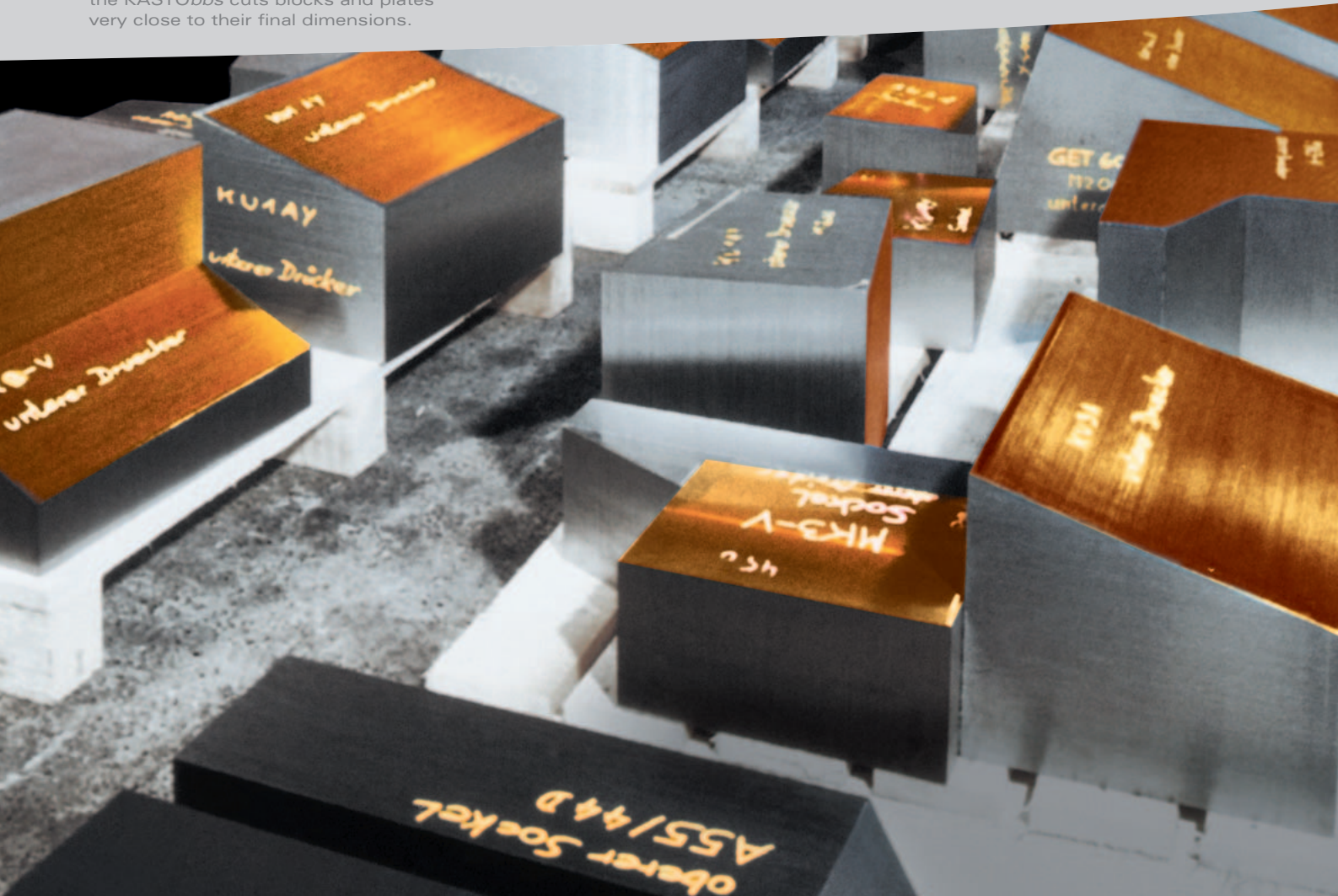
For the perfect overall view and mobility during machine set-up: Cordless infrared remote control.

Additional equipment for the KASTObbs:

- Additional stop plate
- Mechanical workpiece stop
- Workpiece stop, adjustable by motor
- Additional supporting beam
- Manual clamping device
- Infrared remote control of saw head
- Heating for hydraulic oil
- Heating for switch cabinet
- Heating for coolant
- Laser lamp
- Clamping magnets for inner and outer table
- Lifting and lowering roller rails

Technical Data <i>KASTObbs</i>	U 3 x 6	U 3 x 20 ²⁾	U 4 x 16 ²⁾	U 5 x 10
Required power	3,5 / 6,0 kW	7,5 kW	7,5 kW	7,5 kW
Cutting speed, infinitely variable	12 - 130 m/min	14 - 75 m/min	14 - 75 m/min	14 - 75 m/min
Cutting height	420 / 400 mm ¹⁾	420 mm	520 mm	620 mm
Cutting height with cutting control	360 / 340 mm ¹⁾	360 mm	460 mm	560 mm
Cutting depth	660 mm	2.060 mm	1.660 mm	1.060 mm
Cutting length from – to (1.000 mm steps)	2.000 - 6.000 mm	3.000 - 7.000 mm	3.000 - 7.000 mm	3.000 - 6.000 mm
Carrying capacity p.1.000 mm table length (outer table)	4 t	8 t	8 t	8 t
Table support width (outer table)	1.200 mm	2.000 mm	1.500 mm	1.500 mm
Table support width (inner table)	660 mm	2.060 mm	1.660 mm	1.100 mm
Table support height	1.285 mm	1.550 mm	1.550 mm	1.350 mm
Dimensions with cutting length 3.000 mm				
Length	6.585 mm	6.850 mm	6.850 mm	6.650 mm
Width	2.995 mm	5.690 mm	5.000 mm	3.830 mm
Width with open protective cover	3.585 mm	7.060 mm	6.360 mm	5.010 mm
Height (without laser)	2.750 mm	3.215 mm	3.490 mm	3.620 mm
Carrying capacity (outer table)	12 t	26 t	24 t	24 t
Weight	8.000 kg	16.500 kg	15.000 kg	14.000 kg

The time for secondary machining operations is greatly reduced because the *KASTObbs* cuts blocks and plates very close to their final dimensions.



U 6 x 16	U 8 x 10	U 8 x 20	U 10	U 12 x 15	U 18 x 15
7,5 kW	7,5 kW	7,5 kW	7,5 kW	5,5 - 8,0 kW	5,5 - 10,0 kW
14 - 75 m/min	14 - 75 m/min	14 - 75 m/min	14 - 75 m/min	8 - 80 m/min	8 - 80 m/min
720 mm	920 mm	920 mm	1.120 mm	1.320 mm	1.920 mm
660 mm	860 mm	860 mm	1.060 mm	1.260 mm	1.860 mm
1.660 mm	1.060 mm	2.060 mm	1.060 mm	1.560 mm	1.560 mm
3.000 - 6.000 mm	3.000 - 6.000 mm	6.000 mm	3.000 - 6.000 mm	3.000 - 7.000 mm	3.000 - 4.000 mm
8 t	8 t	8 t	8 t	10 t	20 t
1.500 mm	1.500 mm	2.000 mm	1.500 mm	2.000 mm	2.000 mm
1.660 mm	1.100 mm	2.060 mm	1.100 mm	1.560 mm	1.560 mm
1.550 mm	1.340 mm	1.550 mm	1.350 mm	1.710 mm	1.710 mm
6.850 mm	6.650 mm	9.850 mm ³⁾	6.650 mm	7.000 mm	7.650 mm
5.000 mm	3.830 mm	5.915 mm	3.830 mm	5.180 mm	5.450 mm
6.360 mm	5.010 mm	7.325 mm	5.010 mm	6.315 mm	6.660 mm
3.490 mm	3.620 mm	3.560 mm	3.820 mm	5.265 mm	6.450 mm
24 t	24 t	48 t	24 t	50 t	70 t
15.000 kg	14.000 kg	21.200 kg	14.500 kg	26.600 kg	30.500 kg

1) with cutting length 5.000 and 6.000 mm

2) also available in automatic version

3) cutting length 6.000 mm

Contour-close notching cuts lower costs and save time.

The KASTObbs with universal application possibilities covers a wide variety of sawing tasks. For example, the sawing of single pieces from blocks and plates very close to their final dimensions. The machining times for subsequent machining steps, especially milling, are reduced considerably. Another advantage: The notched "scrap pieces" remain intact for further use (see examples in left picture). This reduces the number of different material sizes and subsequently decreases the capital tied up in inventory.

Highly economic: The "KASTO effect": Superior, cost-effective performance.

By investing in design quality refinements, KASTO not only ensures shorter idle times but also increases blade life, namely by extremely quiet running as well as a generous design of all machine components. All assemblies are well proven in heavy-duty operations around the world.

Favourable solution for high demands.

Low in price – outstanding performance.

The KASTO*bloc* or KASTO*plate* provide an excellent balance in price and accuracy. The “light” version of the KASTO*bbs* is cost-favourable with superior performance: This machine has all the advantages of the “big one” – the same feed unit, same cutting performance and same cutting accuracy as well as same very easy access. All workpieces on the table can be reached by hand. Coolant container and chip conveyor are integrated into the table; the length of the chip conveyor is identical with the saw length.

Safe handling.

The KASTO*bloc* or the KASTO*plate* is the ideal machine for cutting smaller block dimensions or lower plate weights – (up to 6 tons). The optimum handling aids of the KASTO*bloc* or KASTO*plate* are ideally suited for cutting-up remnants. A 1 ton block can be moved with just one finger. The moving and swivelable operating panel ensures clear overview and safety.





Hydraulic, electronically supervised saw blade tensioning. The height of the upper blade guide can be hydraulically adjusted.



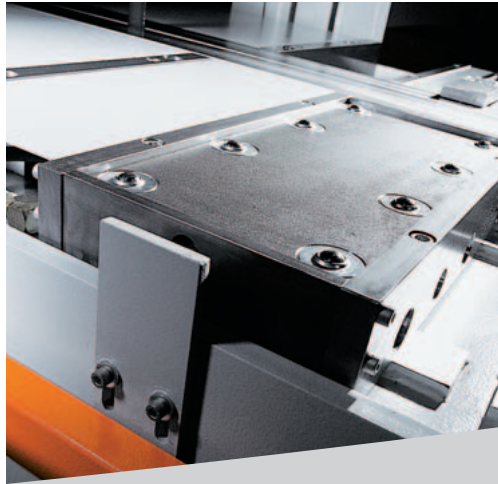
Plug-in, mechanical clamping unit.



Mechanical measuring stop with digital display, fast and easy to adjust.



Easy and fast saw blade change.



Easy handling of heavy blocks and plates due to hydraulically lifting and lowering ball lifting tables.



Widening of outer table to machine large workpieces.

Technical Data	KASTOplate U 3	KASTObloc U 5
Required power	4,0 kW	4,0 kW
Cutting speed, infinitely variable	17 - 110 m/min	17 - 110 m/min
Cutting height without cutting control	320 mm	580 mm
Cutting height with cutting control	280 mm	540 mm
Cutting depth	660 mm	660 mm
Cutting length	2.100 - 3.100 - 4.100 mm	2.100 - 3.100 - 4.100 mm
Carrying capacity (outer table)	3,5 - 5,0 - 6,0 t	3,5 - 6,0 - 6,0 t
Carrying capacity (inner table)	3,5 - 5,0 - 4,0 t	3,5 - 5,0 - 4,0 t
Table support width	660 mm	660 mm
Table support height	1.200 mm	1.200 mm
Length	4.560 - 5.560 - 6.560 mm	4.560 - 5.560 - 6.560 mm
Width, including grate	2.610 mm	2.610 mm
Height	3.200 mm	3.200 mm
Weight	7.500 - 8.000 - 8.500 kg	7.500 - 8.000 - 8.500 kg