



KASTO $hba$ . Large Bandsawing Machines for Heavy-Duty Production.

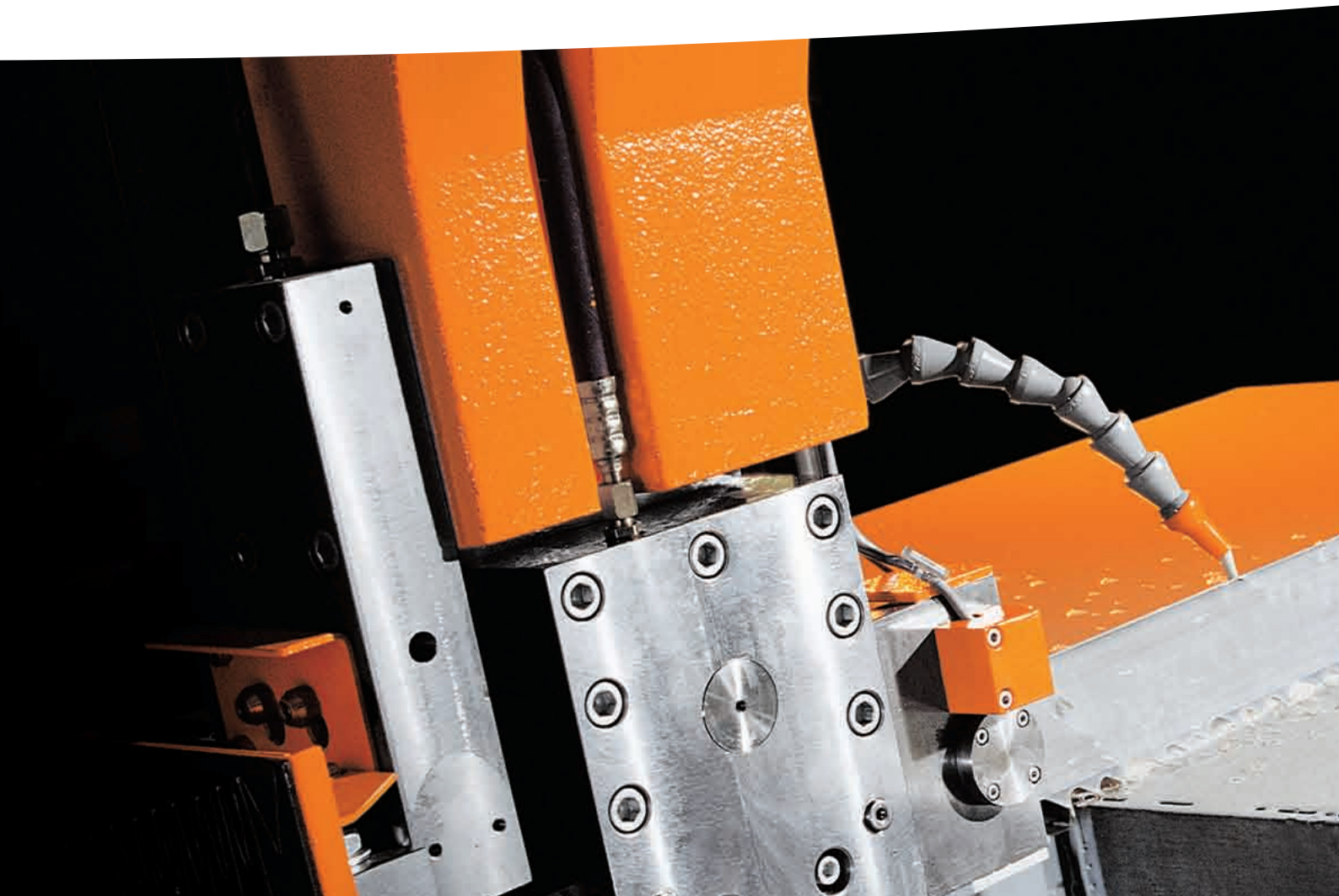
## Efficient cutting of large workpieces: KASTO*hba*.

Well-thought-out design for greater effectiveness.

The large bandsaws of the KASTO*hba* series combine modern machine tool design and KASTO's extensive experience in the efficient, cost-effective cutting of large workpieces. This combination results in exceptionally solid construction, high rigidity and extremely good vibration dampening, short cutting times and high cutting performance. These are the outstanding features for effective utilization in the engineering industry and tool manufacture, heavy industry, shipbuilding and forging as well as in the steel production and steel service centre industries.

A wide variety in sizes adapts to individual requirements.

Three machine sizes cover the cutting ranges from 1.060 x 1.260 mm (KASTO*hba* 10 x 12) to 1.320 x 1.720 mm (KASTO*hba* 13 x 17). All three sizes are available as semi-automatic machines KASTO*hba* U and as fully automatic machines KASTO*hba* A. For the larger models there are either roller conveyors with feed vices for handling of very long work pieces, or NC-controlled movable ball screw feed tables in the delivery program. Upon request, additional well-thought-out equipment for cutting with carbide tipped saw blades is available. A wide range of accessories allows any model of machine to be tailored to the tasks at hand.





Rigid, polymer casting saw  
head construction:  
Designed for fast cutting.

The outstanding rigidity of the saw head (a composite construction of steel and polymer casting) ensures superb vibration dampening, quiet running of the saw blade and high cutting accuracy. The KASTO $h$ ba twin column machines cut profiles, tubes and solids up to a width of 1.720 mm fast and very clean. The superior stability of the polymer casting construction is especially important when sawing difficult to cut materials, resulting in shorter cutting times and longer saw blade life.

Precise and virtually maintenance-free guides:  
Your guarantee for durability  
and repetitive accuracy.

Automatic material feed is assured with accurately controllable ball screw. Precise, large dimensioned guides guarantee accurate material feeds at all times. The saw feed takes place at ground and hardened rails via adjustable, pretensioned rollers or play-free, virtually friction-free linear guides. This ensures constant and repeatable feed values.



For economic cuts up to 1.260 mm: *KASTOhba A 10 x 12*.

*KASTOhba A 10 x 12* with optional carbide package:

- Higher blade speed: 15 - 190 m/min, required power 18 kW
- Adaptable, extremely strong gearbox for saw blade drive
- Hydraulic separation of band clamping and band guide
- Special blade guides for carbide tipped blades
- Adaptable saw feed control for beginning and end of cut
- Control of minimum rpm
- Adjustable chip removal brush; optional: automatically self-adjusting brush

Carbide packages are available for each size of the *KASTOhba*!

*KASTOhba A 10 x 12*: Standard saw motor with 11 kW, in the carbide package with 18 kW.





Cutting range 1.060 x 1.260 mm:  
The KASTOhba 10 x 12 cuts even  
extremely large workpieces.

**KASTOhba series – additional  
options:**

- Special cutting speeds
- Extended saw feed control for feeds less than 1 mm/min for extremely difficult to cut material
- Central lubrication system
- Preselectable automatic incline of saw unit by 1°. Ideal for trim cuts of forged or scaled material.
- Extension of material support table up to 6.000 mm (236.22")
- Additional, strong horizontal vice
- Device for perpendicular set-up and clamping of short, heavy remnants:
  - Two electro-magnets and an electronic control unit
- Hydraulic alignment device with separate hydraulic unit to align heavy workpieces on the infeed table
- Heavy-duty, rail-guided material cart for long shafts
- Pendulum operation for fast change between two workpieces (table version)



# Performance in every respect is its aim: KASTOhba A 13.

## KASTOhba A 13: Fast and safe cutting

The KASTOhba 13 offers a cutting range of 1.320 x 1.320 mm with square material. With an 11 kW saw drive, the bi-metal or carbide tipped saw blades cut even difficult to cut material efficiently. The hydraulic horizontal vice offers a side shift cylinder of the fixed clamping jaw for safe material transport. The KASTO *EasyControl* with memory for repeat cutting jobs and characteristic material features for operating the fully automatic KASTOhba A 13 contributes considerably to economical cutting, providing at the same time an extraordinary safety package.

## KASTOhba A 13: Factory standard equipment.

- Saw frame and blade guide arms adjust fully automatically to material height and width via light barriers
- Saw control KASTO *EasyControl* (accessory)
- Feed control with KASTO *Universal Hydraulics UH* provides long blade life and accurate cuts due to precise feed control – even with extremely slow feeds
- Cut monitoring KASTO *BandControl*
- Hydraulically pretensioned carbide slideways of saw blade
- Hydraulic and electrical control of saw blade tensioning
- Attached hydraulic system is easily accessible
- Safety barrier on infeed side
- Chip conveyor, designed to handle long chips
- Chip removal brush, motor-driven



# KASTO Saw Controls: optimal for every application.

KASTO saw controls are principally based on industrial PCs and are available in different power levels but with a standardised Look and Feel. The colour touch screen, icon-based operator guidance, the online language switching, and an extensive process visualisation allow for easy handling and efficient order processing. The integrated Soft-PLC is programmed in STEP 7® for simplified diagnostics.

## KASTO BasicControl:

- ... the optimum control for easy handling and save sawing
- Industrial PC with 5.7"-colour touch screen without hard disk.
  - Software and data management on exchangeable multi media card.
  - Input of up to 99 orders with flexible input of quantity, cut-off length and further order data.
  - Integrated technology tables for cutting speed and manual adjustment of saw feed.
  - Management and display of process data (e.g. cutting time, cycle time), tool/blade data (e.g. cut area, cutting performance) etc.
  - Extensive diagnostic functions.

Saw control KASTO BasicControl. For easy operation and safe cutting.



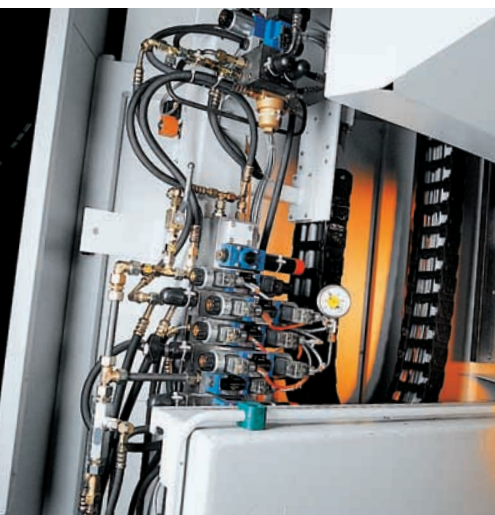
PC control EasyControl with 10" touch colour display, network interface, automatic arrangement of cutting technologies according to the material qualities.



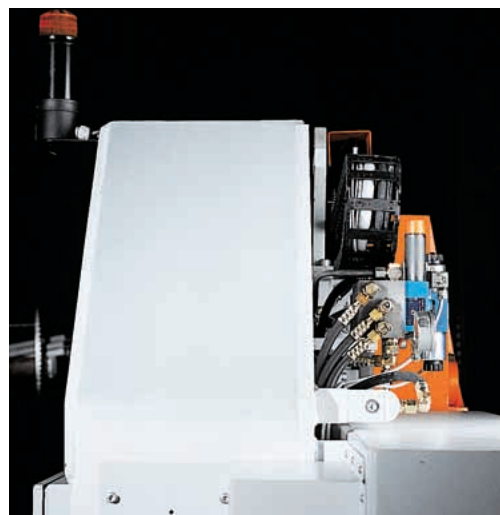
For blade guide close to the workpiece and accurate cuts: KASTOhba with strong blade guide arms.



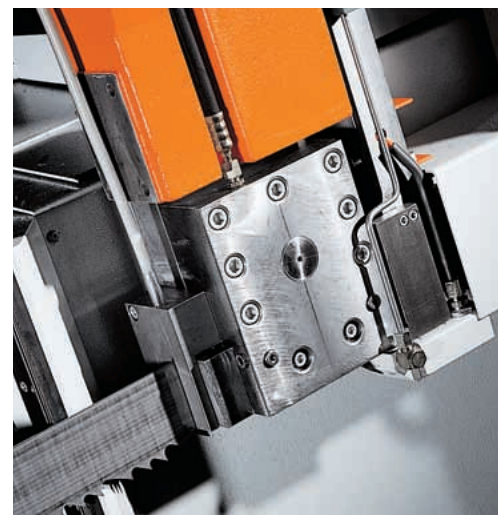
Strong and reliable: The hydraulic system of the KASTOhba.



Outstanding vibration dampening for extremely quiet running: Machine head in steel jacket polymer casting composite structure.



Easily accessible and exchangeable in less than 5 minutes: The saw blade of the KASTOhba.





## KASTO EasyControl:

... the ideal control for optimum order processing

- Industrial PC with 10"-colour touch screen without hard disk.
- Software and data management on exchangeable multi media card.
- Input of up to 200 orders (optionally extendible) with flexible input of order data in tabular order diagram. It is possible to copy and enter orders.
- Integrated material and article management based on database principle.
- Self-optimising technology database based on article, material and tool data as well as the latest process parameters. Capacity to backup the optimised technology data to the selected article.
- Pre-calculation of order processing and machine utilisation hours of the complete order pool.
- Storage and analysis of all processes, statistics and tool data. Output is possible onto a USB stick for further processing e.g. in Excel.
- Extensive software options such as creating and saving of cutting lists, data export and import functions, connection to the higher-ranking Enterprise Resource Planning (ERP) or production management systems etc.

The support table can be delivered in lengths of 2, 3, 4, 5 or 6 m.



The optional magnet clamping plates keep remnants in position.



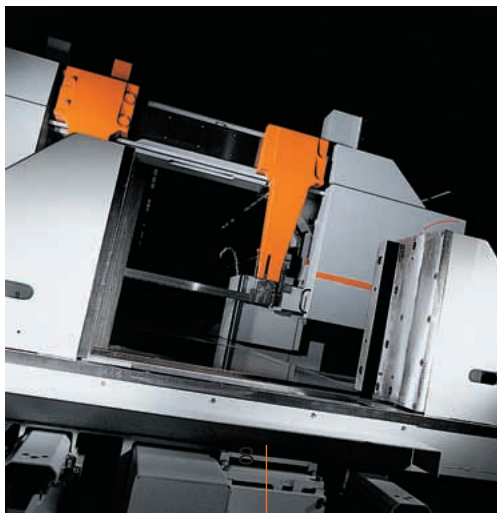
The infrared control allows cable-free mobility during set-up.



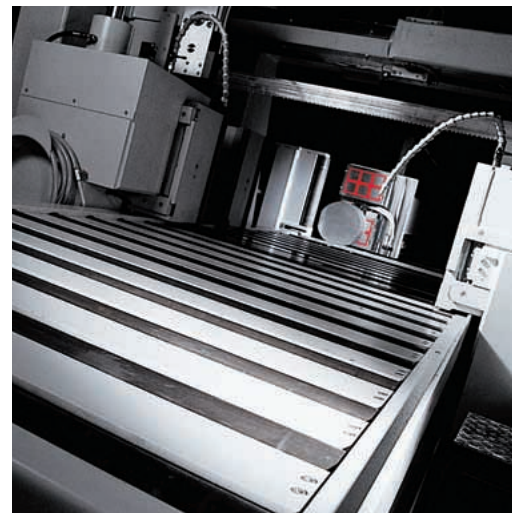
Roller conveyor with gripped rollers.



Additional equipment: Hydraulic vice on the movable support table.



Roller conveyors for loads of 4 – 12 t/m are available in many lengths.





Technical Data		KASTO <b>hba</b> A/U 10 x 12	KASTO <b>hba</b> A/U 13 x 13	KASTO <b>hba</b> A/U 13 x 17
<b>Cutting range</b>				
Cutting range ●	mm	300 - 1.060 (11.81 - 41.73")	300 - 1.320 (11.81 - 51.97")	500 - 1.320 (19.68 - 51.97")
Cutting range ■ (h x w)	mm	1.060 x 1.260 (41.73" x 49.61")	1.320 x 1.320 (51.97" x 51.97")	1.320 x 1.720 (51.97" x 67.72")
Smallest dimension to be cut (h x w)	mm	20 x 300 (0.79 x 11.81")	20 x 300 (0.79 x 11.81")	20 x 500 (0.79 x 19.68")
Feed system with automatic version		Support Table	Support Table	Support Table
Automatic feed length	mm	2.100 - 6.100 (82.68" - 240.25")	2.100 - 6.100 (82.68" - 240.25")	2.100 - 6.100 (82.68" - 240.25")
Shortest cut-off length	mm	10 (0.39")	10 (0.39")	10 (0.39")
<b>Measurements and weights</b>				
Length	mm	5.720 / 1.700 (225.20 / 66.93")	5.720 / 1.700 (225.20 / 66.93")	5.720 / 1.700 (225.20 / 66.93")
Machine width (incl. chip conveyor)	mm	5.470 (6.460) (215.35 (254.33)")	6.000 (7.050) (236.22 (277.56)")	6.450 (7.450) (253.94 (293.31)")
Height (saw head in highest position)	mm	3.420 (134.65")	4.200 (165.35")	4.250 (167.32")
Size of support table (l x w)	mm	2.500 x 1.250 (98.42 x 49.21")	2.500 x 1.320 (98.42 x 51.97")	2.500 x 1.720 (98.42 x 67.72")
Carrying capacity of support table	t	20 (44.000 lbs.)	34 (74.800 lbs.)	44 (96.800 lbs.)
Material support height	mm	700 (27.56")	700 (27.56")	700 (27.56")
Weight	kg	19.100 / 10.500	20.000 / 12.100	22.000 / 14.100
<b>Performance characteristics</b>				
Total connected power	kW	20 (26.4 hp)	20 (26.4 hp)	20 (26.4 hp)
Option carbide tipped blade: Total connected power	kW	27 (35.64 hp)	27 (35.64 hp)	27 (35.64 hp)
Required power saw motor	kW	11 (14.52 hp)	11 (14.52 hp)	11 (14.52 hp)
Option carbide tipped blade: Required power saw motor	kW	18 (23.76 hp)	18 (23.76 hp)	18 (23.76 hp)
Cutting speed (infinitely variable)	m/min	12 - 90 (39.37 - 295.28'/min)	12 - 90 (39.37 - 295.28'/min)	12 - 90 (39.37 - 295.28'/min)
Saw blade dimension	mm	11.430 x 80 x 1,6 (450 x 3.15 x 0.06")	12.780 x 80 x 1,6 (503.15 x 3.15 x 0.06")	13.460 x 80 x 1,6 (529.92 x 3.15 x 0.06")

### KASTO**hba** accessories.

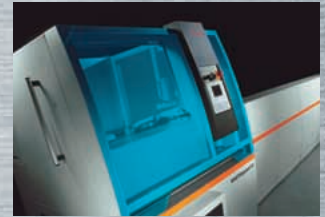
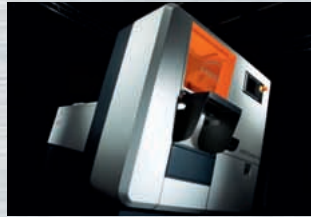
- Safety package, recommended for unmanned operation
- Carbide package
- Movable operating panel, ideal with outfeed roller conveyors
- Heating for switch cabinet, hydraulics and cooling lubricant for problem-free use in cold facilities
- Cooling for hydraulic oil and switch cabinet
- Infrared remote control
- Cutting depth adjustment
- Laser lamp
- Infeed and outfeed periphery for different performance ranges

# The Complete KASTO Program: Economic Sawing and Storing of Metal.

Expertise right  
down the line.

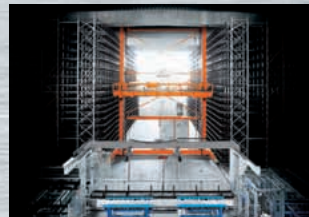
For over 160 years, KASTO has been recognized for quality and innovation, and offers a complete range of metal cutting saws, as well as storage and retrieval systems. Thanks to an ongoing development of new technologies and constant optimization process of machine concepts, KASTO has achieved the status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



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