ISELI – PRECISION FOR A PERFECT CUT

ISELI develops and manufactures grinding machines, complex processing machines and automation for a perfect saw shop at manufacturers of tools, service providers as well as for sawmills in the field of sharpening technology for band, gang and circular saw blades in the area of wood, aluminum, plastic and metal. Convince yourself of our expertise and experience for a perfect cut !

Swiss quality by tradition

As a traditional family business, today already managed by the third generation, ISELI is developing sharpening machines with the latest technologies and excellent engineering – made in Switzerland.

ISELI system technology is convincing thanks to its maximum operating convenience, flexibility in the applications as well as to adaptation to customer requirements. Its outstanding quality makes ISELI sharpening machines a future-proof investment.

Together ahead of the competition

As a customer, you benefit on one hand from our fair, partnership-based cooperation and on the other from our continuous development of the machining and sharpening processes. An additional advantage is the intelligent optimization in process and product handling.

Sharpening solutions for band and gang saws

Sharpening solutions for circular saws

Sharpening solutions for hand tools

Sharpening solutions for industrial blades

Sharpening solutions for chain saws

Service

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BNA 100

FULLY AUTOMATIC STELLITE TIPPING MACHINE FOR EQUIPPING SAW TEETH BY PLASMA WELDING PROCESS

Well-engineered technology in the plasma welding process, with servo drives as well as robust construction and simple operability.

SPECIFICATIONS

GENERAL INFORMATIONS:

Tooth pitch	10 - 100 mm
Blade thickness	from 0.6 mm
Front rake angle	10 - 40°
Tooth height	up to 30 mm
Working speed	up to 10 Z. / min.

BAND SAW BLADES:

Blade width (Standard)	100 - 360 mm
Blade width (Option)	from 40 mm
Blade length	from 6'000 mm

PROPERTIES:

Connection load w/o annealing	6,3 kVA / 5,0 kW
Connection load w annealing	8,5 kVA / 7,1 kW
Compressed air	6 bar, 30 l / min
Weight	approx. 1'350 kg

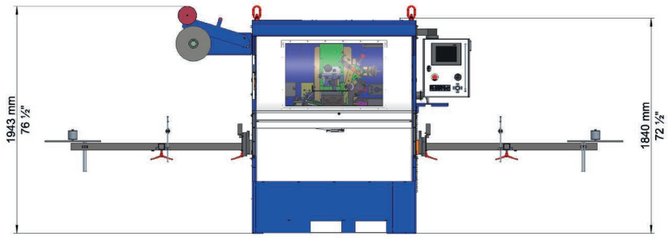
Subject to alteration in design
for technical advancement.

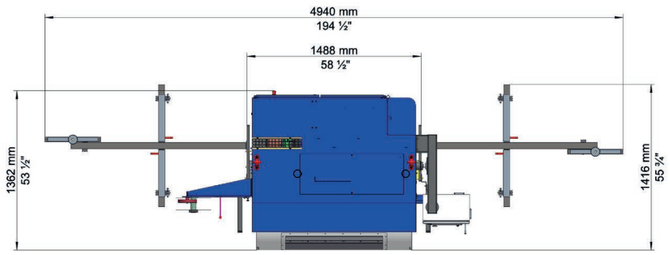
PROVEN TECHNOLOGY FOR TOP QUALITY

The BNA 100 is tipping your band, gang and circular saw blades in plasma welding process. The plasma welding process with an inert gas guarantees a very strong connection between the stellite and the body. In addition to sophisticated technology, the BNA 100 is characterized by its robust design, ease of operation and price-performance ratio. The high availability and operational reliability of the machine makes it the best possible stellite tipping machine for all applications, be it in the sawmill, sharpening service or saw production.

Due to the massive central block, the BNA 100 is extremely robust, precise and low vibrating. And all this with compact dimensions and maximum functionality. Cooling, welding unit and the optional annealing station are completely integrated into the machine. The swivel hood with large viewing window effectively prevents contamination, enables convenient insertion of the saw blades and visual inspection of the machining process when closed.

SPACE REQUIREMENTS



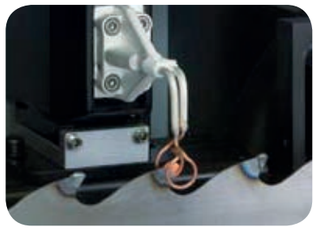


OPTIONS

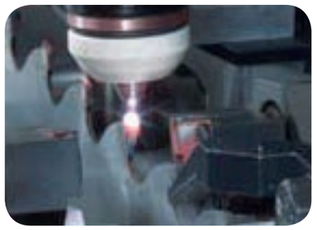
- Grinding dust extraction
- High frequency annealing station
- Monitoring of the annealing temperature (pyrometer)
- Equipment for bandsaws, circular saws, gang saws & mini gang saws
- Equipment for double toothed band saw blades
- Auxiliary backfeeder, loading system on lateral blade support
- Program for Vario toothing
- Electrodes grinding device
- Remote Access

HIGHLIGHTS

- High quality, robust and state-of-the-art stelite tipping machine in plasma welding process.
- Processing of band, circular, frame and mini frame saws possible.
- Stable and centred machine construction. Robust, precise and low-vibration.
- Welding unit, cooling and optional annealing station are integrated in the machine.
- Encapsulated machine - welding fumes can be extracted by suction.
- Simple operation and handling.
- Easy repair of broken teeths.
- Burner adaptation to the operating conditions (two burner types for optimum adaptation to the saw dimensions).
- Annealing of the welding connection with the torch, or optionally with a high-frequency annealing device.
- Operation with monogas and bigas possible.
- CNC controlled axis for stellite feeding and positioning.
- High process reliability.
- Central motorized saw blade height adjustment.
- Automatic stelliting machine in plasma welding process:
  - Homogeneous connection with the raw material.
  - Shorter grinding times / lower grinding wheel consumption.
  - Use of low-cost stellite.
  - Higher stelliting speed.
  - Highest economic efficiency.
  - Designed for rod and wire Stellite.
- Precise shaping of the incisors by means of mould jaws.



For optimal saw tooth condition: The integrated monitoring of the annealing temperature (option)



Stellite application in mould blocks for economical use of stellite and short grinding times.