

FLASH BUTT WELDING MACHINES

FOR ALL TYPES OF BANDSAW BLADES |
FOR BAND KNIVES | FOR CONTINUOUS
PROCESSING OF STEEL STRIP



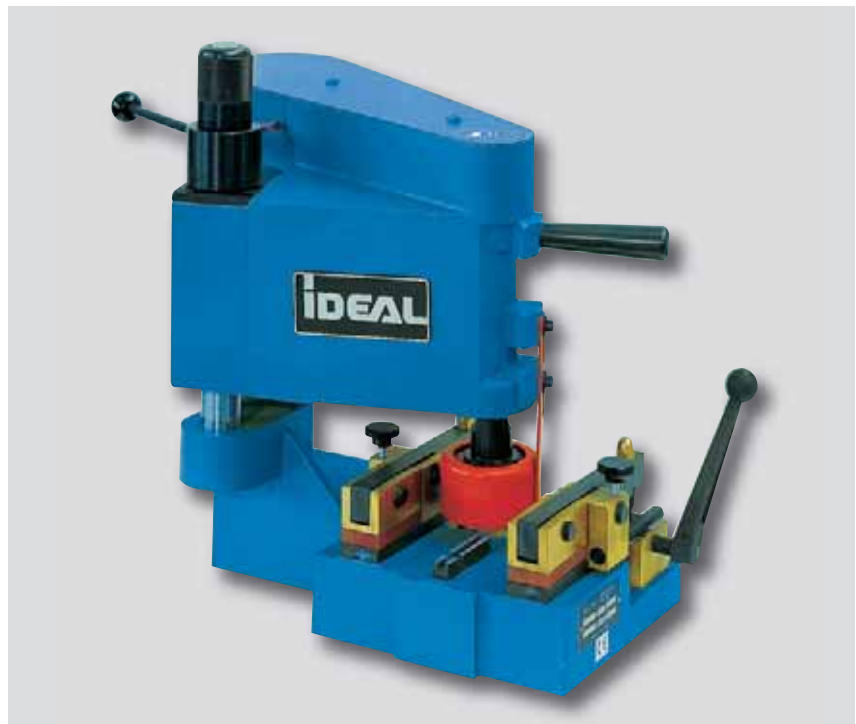
TYPES BAS 040 - BAS 120



Bandsaws, band knives
and steel strip upto
40 mm wide,
from 0,35 mm thick

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We design and
manufacture
according to
DIN EN ISO 9001



Grinding machine type SMH 060

THE FLASH BUTT WELDING MACHINES OF TYPE BAS

High productivity by modern flash butt welding technology ?
Your reliable response to the increased quality requirements of your
customers ? • Production according to DIN ISO standards ?

No problem with the BAS series !

- Years of experience in strip joining technology
- Permanent research and development generated from customers requirements from all over the world
- Constant high quality
- Sturdy design with long life

... protect your competitive advantage today and in future

BAS ... MACHINES FOR VERSATILE USE

- to manufacture small, medium or big series of all types of bandsaws and band knives
- to obtain solid welds within strip processing lines

BAS ... an established, extensive machine concept,
tailor-made according to your requirements.





Shear type AHE 050



Bandsaws, band knives
and steel strip upto
40 mm wide,
from 0,35 mm thick

THE CORRECT SOLUTION FOR WELDING OF NARROW AND THIN STRIPS

- Sturdy design with precise guidance of welding jaw
- Precise current switch on and off by Thyristor contactor
- Electronic, manually and infinitely adjustable annealing device
- Manual clamping device producing high clamping forces
- Adjustable and easily interchangeable pressure dies
- Connection for water cooling of basic electrodes

Type BAS 040





Bandsaws, band knives
and steel strip upto
50 mm / 60 mm wide,
from 0,4 thick



Type BAS 050 on a movable working table with grinding motor type SMH 060 and shear type AHE 080

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WELL PROVEN MACHINES FOR THE MEDIUM WORKING RANGE

BAS 050-01 / BAS 060-01 equipped with manual clamping device

BAS 050-11 / BAS 060-11 and BAS 065-11 equipped with hydraulic clamping device (clamping of blade ends by pedal switches)

Type BAS 050

- Flashing produced by motorized cam disc
- Upsetting force produced by precisely adjustable spring loaded mechanism
- Annealing device for smooth adjustment of voltage
- Annealing time from 0 to 10 minutes
- Automatic pressure relief during annealing process
- Connection of water cooling of basic electrodes





Bandsaws, band knives
and steel strip upto
50 mm wide,
from 0,35 mm thick

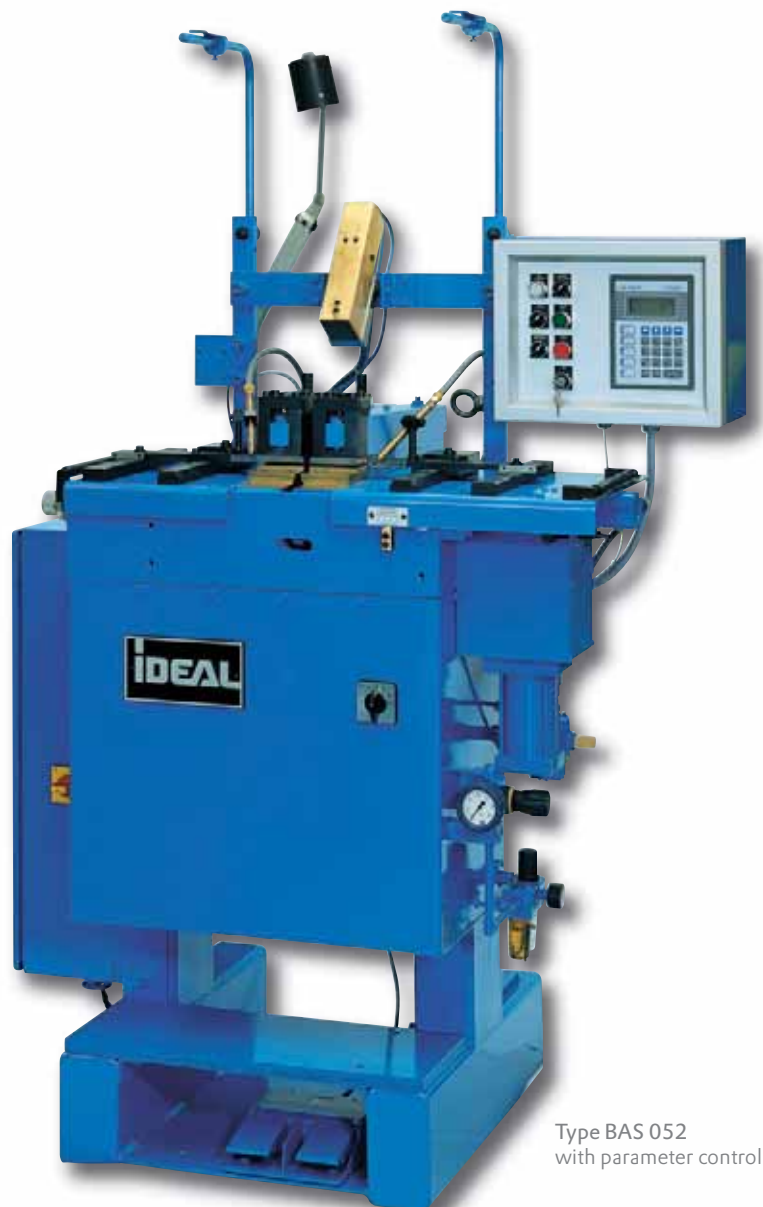
Type BAS 065-11 having a particularly wide welding range, widely used in distributor and saw servicing shops, with auto-annealing device on request

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THE PRODUCTION MACHINES FOR THE SMALL AND MEDIUM WORKING RANGE

- Ease of operation and rapid weld cycle by pneumatic clamping device
- Good view of clamping area
- Pneumatic upsetting cylinder
- Automatically acting prepressure cylinder
- Easily and rapidly adjustable alignment stops
- Automatic machine cycle for welding/annealing process

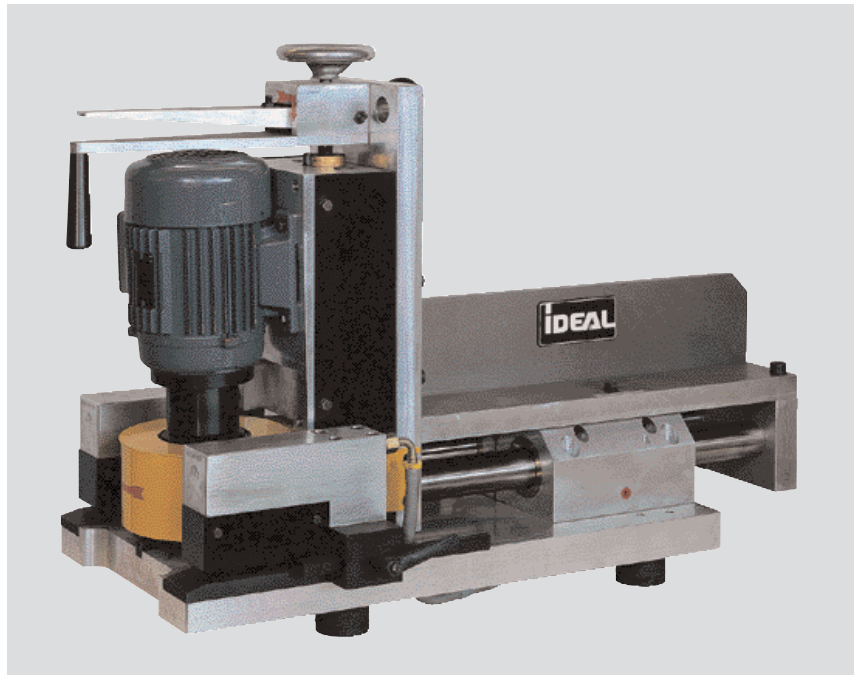
Shear type AHE 080



Type BAS 052
with parameter control



Bandsaws, band knives
and steel strip upto
100 mm / 120 mm wide,
from 0,4 thick

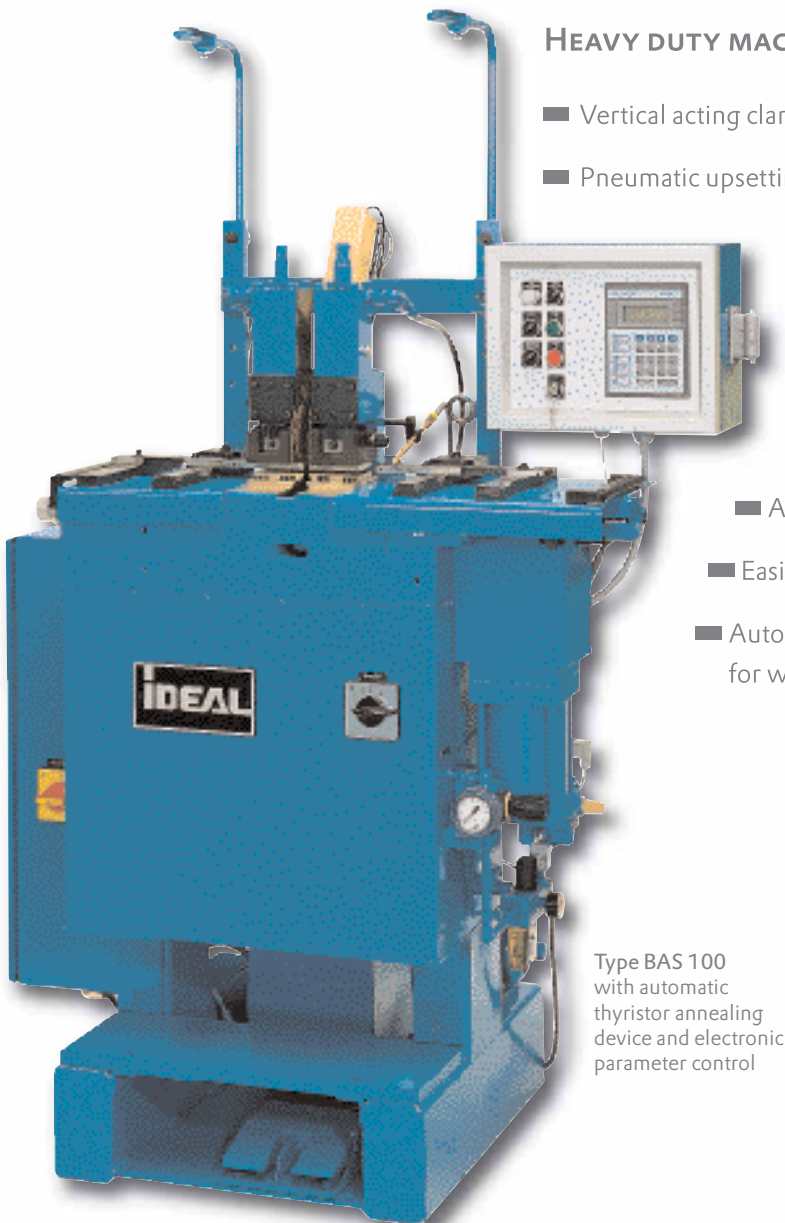


Grinding machine type SMP 120

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HEAVY DUTY MACHINES FOR THE UPPER WORKING RANGE

- Vertical acting clamping device equipped with hydraulic cylinders
- Pneumatic upsetting cylinder
- Transformer with reinforced secondary discs
- Continuously adjustable gear motor for variable flashing speed
- Annealing device for smooth adjustment of voltage
- Automatically acting pre-pressure cylinder
- Easily and rapidly adjustable alignment stops
- Automatic machine cycle for welding/annealing process



Type BAS 100
with automatic
thyristor annealing
device and electronic
parameter control



Shear type APE 121



Control board with printer interface

Flash Butt Welders of type BAS can be equipped with various options. You decide on the optimal, tailor-made machine concept according to your individual requirements:

BAS 040, BAS 050, BAS 060, BAS 065

- Infra-red spectral pyrometer for contact-free measuring and indication of manually selected annealing temperature
- Automatic Thyristor annealing device with infrared spectral pyrometer for automatic adjustment of annealing temperature of one pre-selected reference value

BAS 051, BAS 052

- Pneumatic fast loading device for bandsaws and strips upto 20 mm wide

BAS 051, BAS 052, BAS 100, BAS 120

- Automatic Thyristor annealing device with infra-red spectral pyrometer for automatic adjustment of annealing temperature of several, pre-selected and graded reference values
- Electronic parameter control for monitoring of welding current, upsetting force and welding time, with printer interface for external parameter documentation
- Pneumatically operated centering device for strip ends in the clamping device

BAS 100, BAS 120

- Clamping device for band knives with spring-suspended and separately adjustable pressure segments
- Hydraulic deburring tool for removal of weld burr from both flat sides of blades

(Other solutions available on request.)



Operation unit with display

	BAS 040	BAS 050-01	BAS 050-11	BAS 060-01	BAS 060-11	BAS 065-11	BAS 051	BAS 052	BAS 100	BAS 120
Capacity at 50 % duty cycle, kVA	3,5	4,5	4,5	10	10	20	7,5	25	25	45
Metal bandsaws (bi-metall, tungsten) mm	3-27 0,118"- 1,063"	6-34 0,236"- 1,339"	6-34 0,236"- 1,339"	10-41 0,394"- 1,614"	10-41 0,394"- 1,614"	10-54 0,394"- 2,126"	6-41 0,236"- 1,614"	6-50 0,236"- 1,969"	15-81 0,591"- 3,189"	25-105 0,984"- 4,134"
Wood-cutting bandsaws, mm	5-40 0,197"- 1,575"	6-50 0,236"- 1,969"	6-50 0,236"- 1,969"	10-60 0,394"- 2,362"	10-60 0,394"- 2,362"	10-60 0,394"- 2,362"	6-50 0,236"- 1,969"	6-54 0,236"- 2,126"	15-100 0,591"- 3,937"	25-120 0,984"- 4,724"
Stainless steel bandsaws, mm	5-20 0,197"- 0,787"	6-30 0,236"- 1,181"	6-30 0,236"- 1,181"	10-40 0,394"- 1,575"	10-40 0,394"- 1,575"	10-40 0,394"- 1,575"	6-50 0,236"- 1,181"	6-50 0,236"- 1,181"	15-50 0,591"- 1,969"	25-60 0,984"- 2,362"
Bandknives for leather, foam, mm	5-20 0,197"- 0,787"	6-30 0,236"- 1,181"	6-30 0,236"- 1,181"	10-40 0,394"- 1,575"	10-40 0,394"- 1,575"	10-40 0,394"- 1,575"	6-50 0,236"- 1,969"	6-50 0,236"- 1,969"	25-80 0,984"- 3,150"	30-120 1,181"- 4,724"
Steel strip (plain) max. cross section mm ²	40	75	70	90	100	90	100	150	200	250
Steel strip max. clamping width, mm	40	50	50	60	60	60	50	50	100	120
Weight net/gross, kg (approx.)	80/ 100	140/ 185	180/ 220	250/ 350	290/ 390	290/ 390	460/ 560	460/ 560	600/ 700	625/ 725
Packing dimensions width x height x depth, mm	590x 730x 640	1000x 880x 680	1000x 880x 680	1150x 1000x 900	1150x 1000x 900	1150x 1150x 1150	1200x 1070x 1380	1200x 1070x 1380	1000x 1350x 1700	1000x 1350x 1700

BANDSAW SHEARS

- Blade shears designed for burr-free, square cutting of saw blade ends
- Shear knives manufactured from special tool steel for long life, multi-edged
- Adjustable stops for matching of tooth pitch for welding of bandsaws
- Gripping jaws for non-slip clamping of strip during cutting process
- Various models for different strip widths and cross sections, manually or pneumatically operated, for single or double cutting

GRINDING MACHINES

- Grinding machines for deburring of weld joints, equipped with three-phase motor, on/off-switch and working height adjustment
- Manual eccentric clamping device or pneumatically operated clamping device
- Infinite adjustment of grinding level by rim screw
- Additional lever for precise adjustment of grinding body



LEADER IN WELDING
TECHNOLOGY SINCE 1923

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