

Data Sheet

Reference No.: 54748

Boru kesme makinesi

Brand: RATTUNDE
Model:
YoM, approx.: 2004 used
Reconditioned:
Controls: SIEMENS

Feedstock Tube

external diameter min.:	10 mm
Dış Çapı maks.:	90 mm
wall thickness min.:	0.8 mm
wall thickness max.:	8 mm
length min.:	150 mm
length max.:	3000 mm

Additional Information:

Integrated Tube Cutting Line – Standard Configuration
The integrated tube cutting line is a fully automated system for the precise processing of tubes and profiles. It combines cutting, brushing/deburring, washing, drying, measuring, and stacking into one continuous process. All workpieces are 100% inspected within the line for length, inner and outer diameter, and defective parts are automatically sorted out. System Components Bundle loading magazine Tube separation unit Sawing unit Brushing and deburring machine Washing machine with dryer Length measurement control Outer and inner diameter inspection (Keyence sensors, measuring mandrels up to 500 mm) Stacking handling with magnetic gripper Safety devices (protective fence, light barriers, etc.) The bundle loading magazine is designed for tube lengths up to 9 m. The system allows for damage-free separation and positioning of the tubes. After cutting, the tubes are deburred, cleaned, dried, and automatically stacked for further transport. Main Technical Data Specification Value Overall length approx. 13,000 mm Width approx. 3,600 mm Height approx. 2,350 mm Floor load approx. 1,500 kg/m² Operating temperature 15 °C – 40 °C Relative humidity max. 90 % Connection Requirements Electrical: Control system: Siemens 840 D Installed power: approx. 125 kW Fuse protection: 200 A Power supply: 3 × 95 mm² + 1 × 50 mm² PEN (IEC 364-4-41 / VDE 0100 Part 410) Pneumatic: Compressed air: approx. 3.5 m³/min, 6–10 bar (dry and filtered) Water: ¾" water connection for washing machine with dryer Filling volume: 1,400 l Tube Processing Parameters Parameter Value Max. bundle weight 5,000 kg Outer diameter range 10–90 mm Wall thickness 0.8–8 mm Tube shape Round and profile



tubes Raw material length 3,000–9,000 mm Cut lengths 150–3,000 mm Material Steel, stainless steel, Docol 800 DpAg, 26MnB5, 34MnB5 Max. saw blade width 3 mm Measuring and Inspection Systems Length measurement: Keyence sensor with SPC evaluation Inner/outer diameter inspection: Measuring mandrels with force detection (1–100 N) Repeatability: ± 0.1 mm Data analysis: PC-based evaluation software including documentation Performance Data Processing speed depends on tube diameter, length, and material Max. part weight per cut: 25 kg Machining accuracy: ± 0.05 mm + saw blade tolerance (max. ± 0.10 mm total) Max. stacking weight: 45 kg Positioning accuracy for stacking: 0.5 mm Corrosion Protection All machine and safety components are finished with a high-quality base coat. Machine color: RAL 5010 (Forster Blue) Safety guards: RAL 1003 (Signal Yellow) Special Features Fully automated workflow from bundle loading to sorted stacking SPC-controlled measurement and documentation system Carbide-compatible sawing technology High process reliability with integrated inspection and monitoring systems Compact design with excellent machining precision

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Photos & Documents

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