

Multi-Wire Cutter

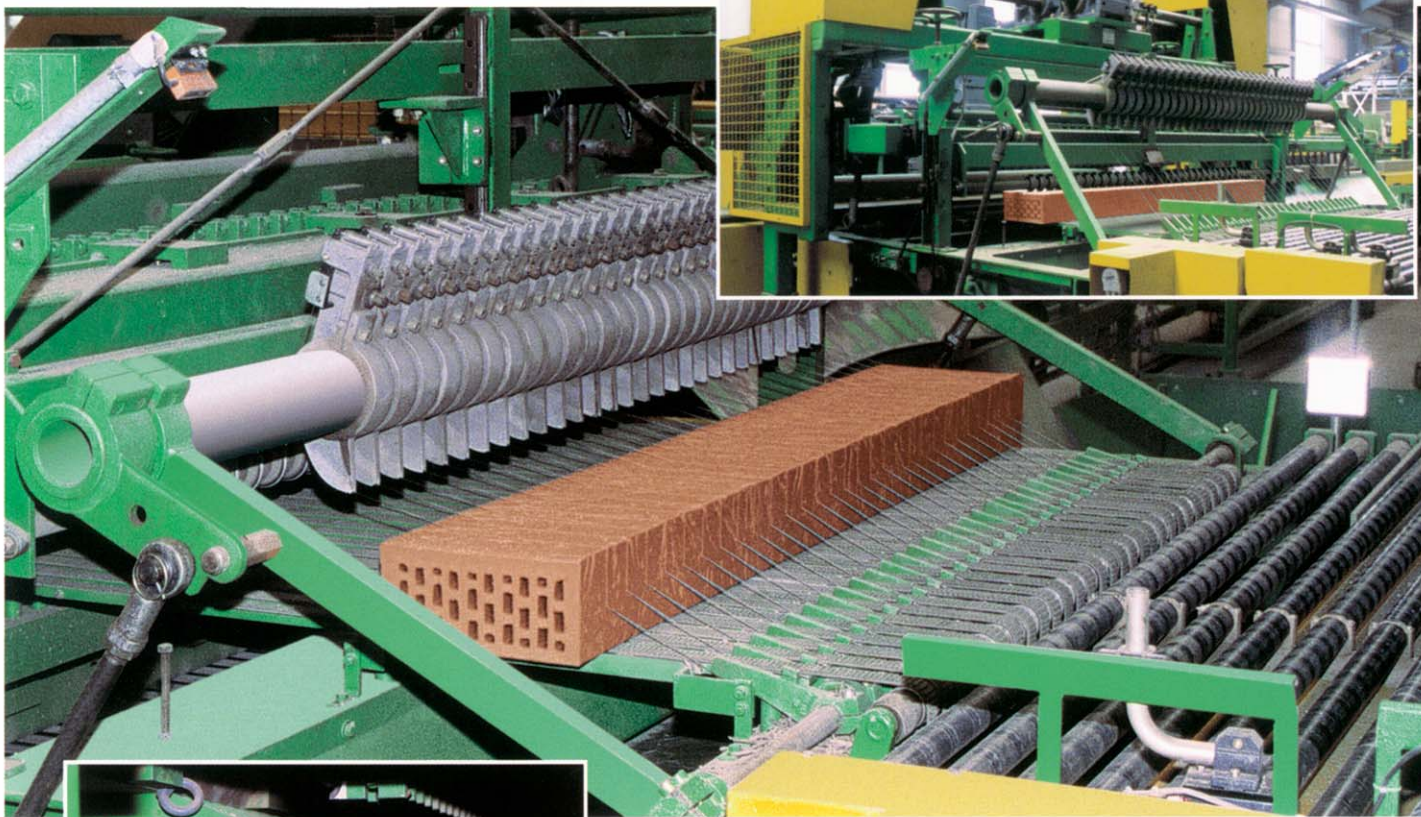
Sizes

Facing bricks DF, NF etc.
Common bricks 2 DF to 20 DF
Pavers
As well as other ceramic products:
e.g. hollow bricks,
single and multiple clay column

Technical characteristics

- 1..... Base frame of stable steel welded design.
- 2..... The clay column is transported via belts.
- 3..... The drive parts are maintenance-free.
- 4..... The clay column is transported accurately into the chamfering device, the transport from the chamfering position to the cutting position is done directly without transferring to another belt.
- 5..... The drives are frequency controlled.

The cutter is suitable for soft and stiff extrusion.



Operation method

In cycles

Cutting system

Vertical cut: with wires arranged for running in opposite direction
(TB max = 550 mm, TH max = 400 mm, TS min = 50 mm)
Side cut: segment cut (clay column dimension, see drawing 806 257)
Side cut: Push through cutter

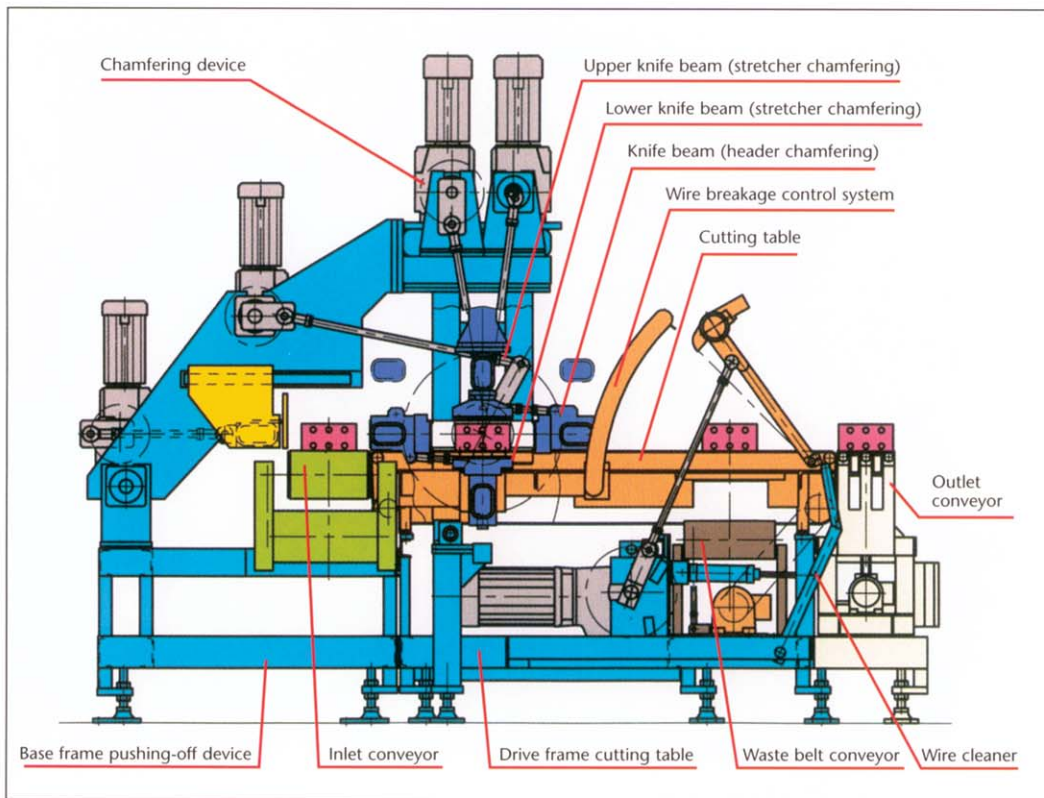
KELLER HCW offers innovative technologies for the production of:

- Bricks, hollow bricks and roof tiles
- Facing bricks and pavers
- Split and floor tiles
- Refractory products as well as
- Measuring and control system
- Automation

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Drawing No.
685 412

Additional equipment

Chamfering device with all-round chamfering.
Chamfering rollers with drive unit for easy chamfering.
Scraper for the bottom side of the cut product.
Cutting out device.

Loading of pallets

Automatic lath loader for 2, 3 or 4 laths
Automatic lath loader in double design
Transfer gripper in connection with the product grouping conveyor with controlled drive.
For direct setting (stiff extrusion) loading of pallets is not required.

Cutting tables

(one cutting table is required for each cutting thickness)

Each cutting table is equipped as follows:
Belt conveyor with drive shaft, cutting frame, wire breakage control device.
Wire cleaner – chamfering rollers if required.

Effective output

The output depends on the slug length as well as on the design of the cutter.

Number of cuts/h:

(Cutter without chamfering device – former design)

Slug length (GS) mm	Cutter length (A) mm	Pallets/h (RH)
GS = 750 - 950 mm	A = 1200 mm	RH = 950
GS = 950 - 1150 mm	A = 1400 mm	RH = 900
GS = 1150 - 1350 mm	A = 1600 mm	RH = 830
GS = 1350 - 1550 mm	A = 1800 mm	RH = 770
GS = 1550 - 1750 mm	A = 2000 mm	RH = 700
GS = 1750 - 1950 mm	A = 2200 mm	RH = 630

The output of a cutter with chamfering device can be up to 600 pallets/h.

The output of a push through cutter can be up to 1,000 pallets/h (after consulting the construction department)

Chamfering is done in one position.

Note:

Observe the output of the automatic pallet loader and of the transfer device !!!!

Additional equipment

Chamfering device with chamfering tools (on all sides), number of tools: number of cut products + 1.

For each cutting thickness (TS) stretcher and header knives are required (FT + 1).

For each additional height additional "header knives" are required as they chamfer around the edge.

Operating examples

The multi-wire cutter can work together with the following machinery:

- Automatic lath loader.
- Transfer device with grouping conveyor for cut products
The driving gear of the transfer gripper is controlled electrically and adopts the speed of the grouping conveyor. According to requirements it has to be checked if frequency regulation or d.c. current regulation is preferred.
- Robots with gripper for pallet loading.
- Robots with gripper for direct setting on kiln cars.