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CUT SAW SP720

RANDEK 

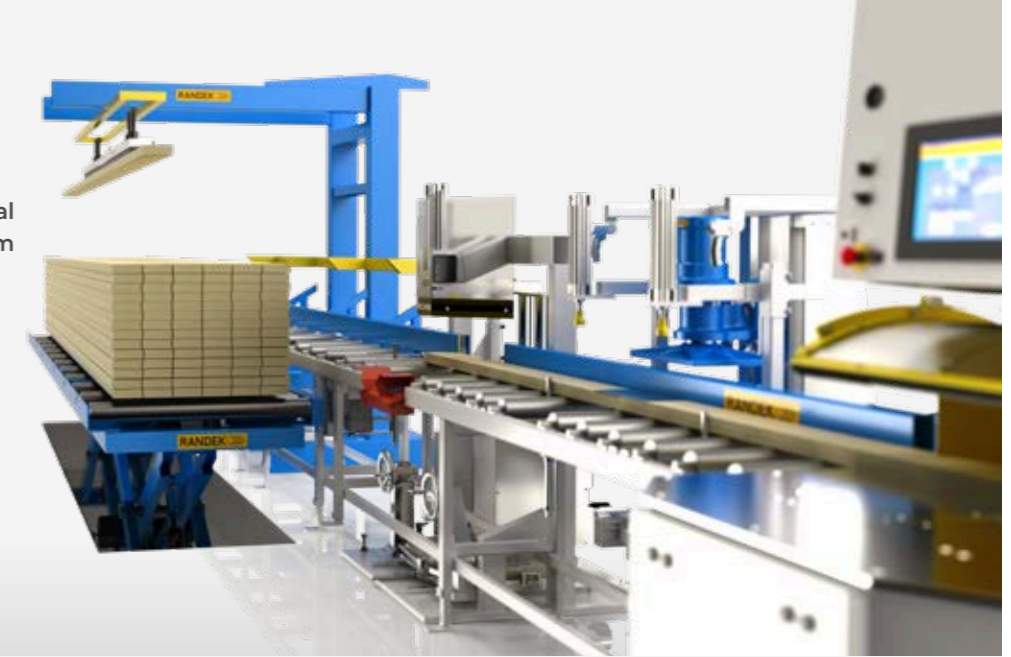
BUILDING THE FUTURE

SAWS WITH ANGLED AND INCLINED CUTS

Randek's SP720 series provides reliable cut saws that are a major asset to roof truss and house producers around the world.

The SP720 cut saw is effective, easy-to-use and accurate. It has been on the market for a long time and is continuously improved in close contact with our many customers. The blade on this semi-automatic saw supports both angled as well as inclined cuts, which mean it can make any cuts you may require. You can also use the large diameter blade to cut several sections of stacked timber simultaneously.

Timber picker with additional modular handling system



- Angled cuts from 0° to 360° and inclined cuts from 90° to 28°
- Cut heights up to 250 mm, possible to cut three pieces of timber each cutting cycle
- Computer controlled, resulting in fast adjustment
- Fixation of timber near the cutting area resulting in accurate cutting

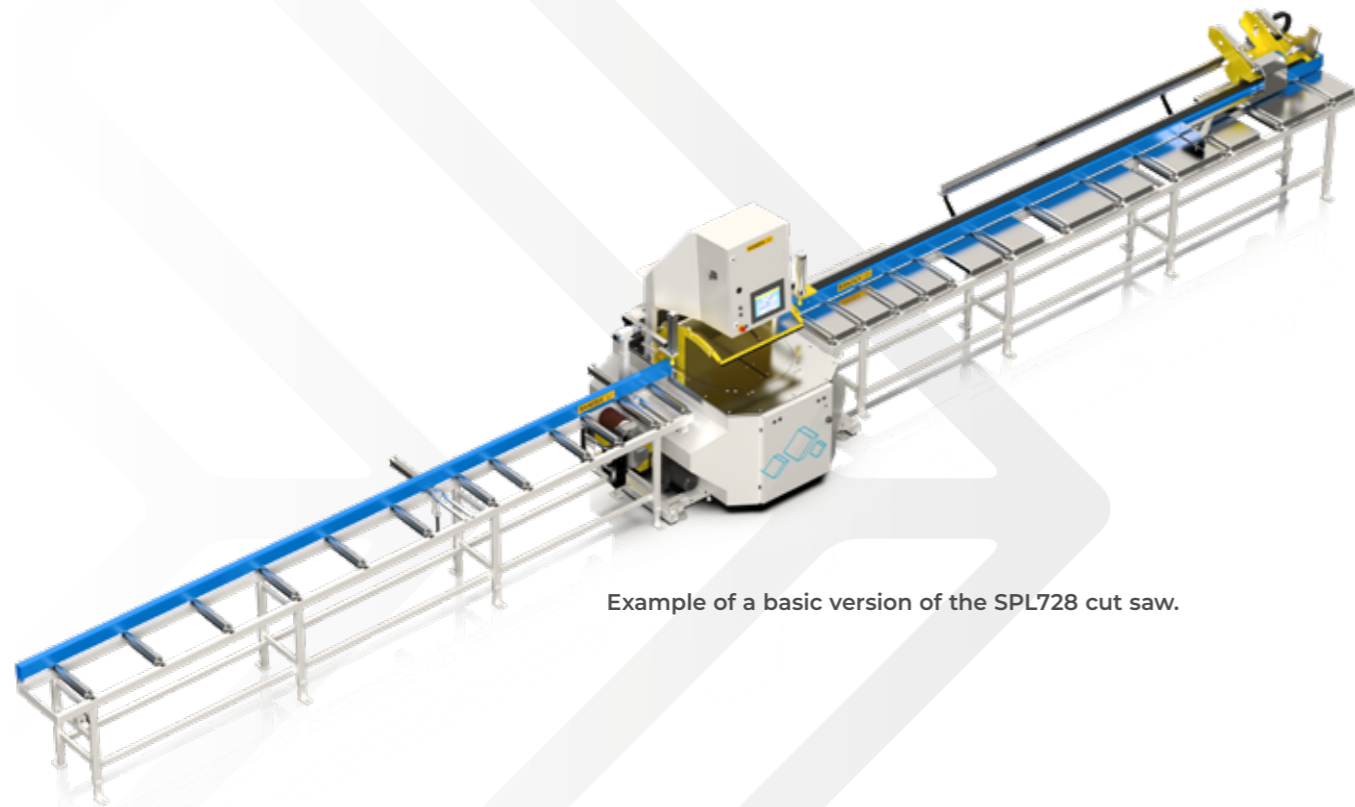
Stacker placing a layer onto the lift table.



SPL728 with outfeed bench and lift table

CUSTOMIZE THE SAW TO YOUR NEEDS

The SP720 is extremely versatile as it can be connected to machines such as stackers, pickers, splicing presses. Randek has an extensive range of peripheral equipment, which means that the saws can be specially configured to meet your particular needs.



Example of a basic version of the SPL728 cut saw.

- Available in left to right or right to left wood feeding direction
- Available with or without inclined cuts (SPL728 or SP722)
- Infeed benches from 4-11 meters
- Outfeed benches from 6-13 meters
- Different stacking methods
- Timber picker
- Printer, Milling machine, Splicing press etc
- Customized modular handling system



INFEED BENCH

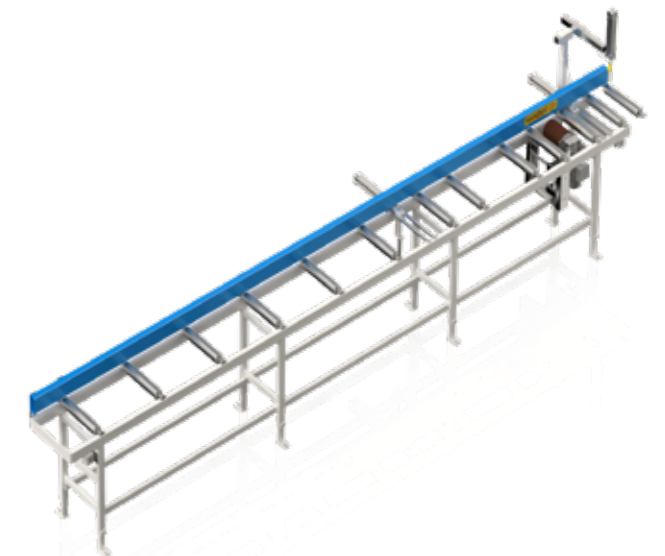
The SP720 infeed benches comes in different lengths with standard equipment. The bench consists of non driven 400 mm rollers and a separate timber feeder along with retracting devices and plungers.

The retracting devices fix and press the timber against the back fence and straighten the timber to secure a precise cut. The retracting device is operated automatically and is activated when making a cut in the timber.

The plunger holds down the timber to the saw table. It is operated as the retracting device, automatically when cutting the timber.

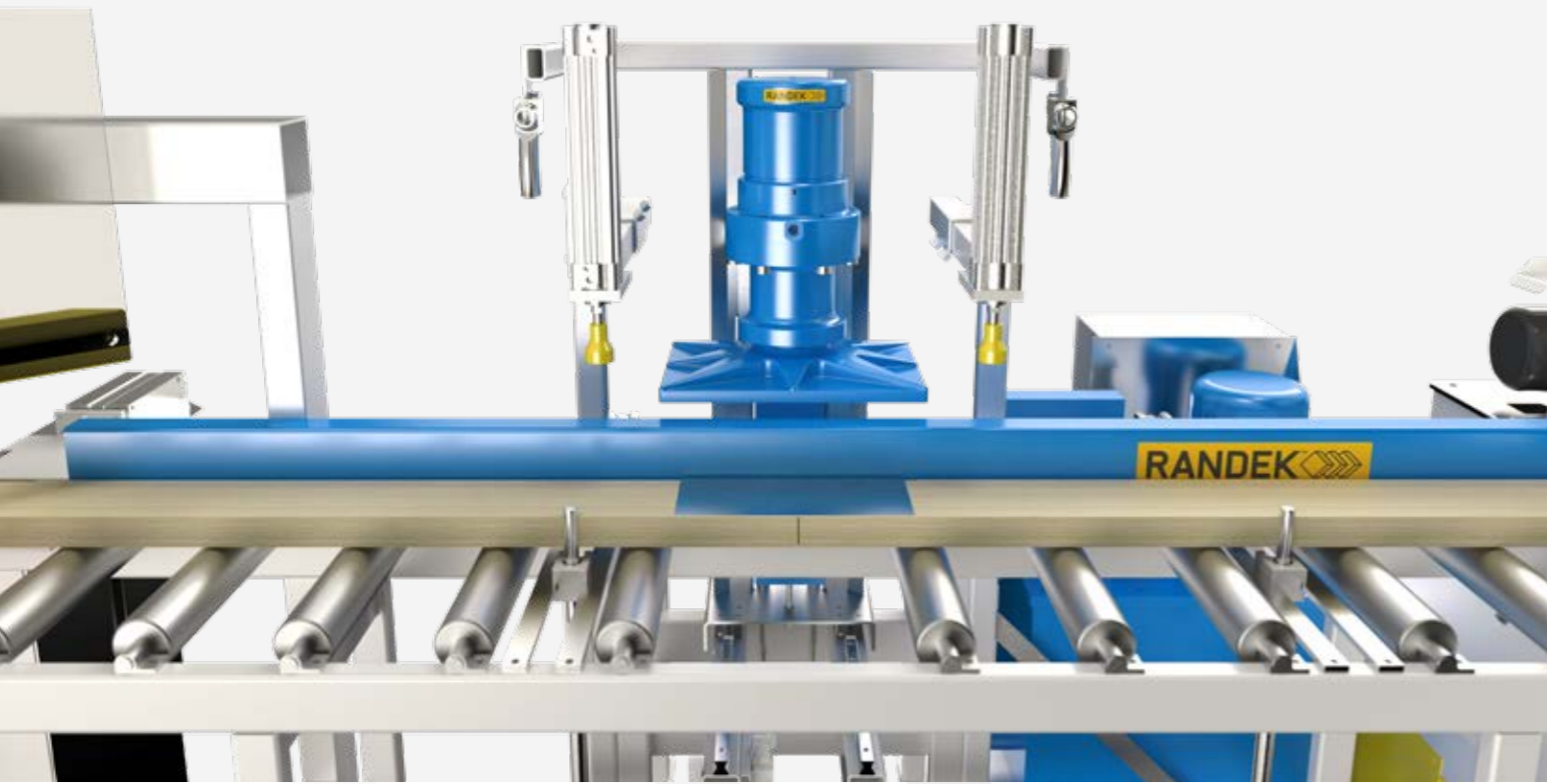
The plunger and retracting device is designed to fixate the timber near the cutting point resulting in a very high accuracy, the most accurate cut saw on the market according to our customers.

The transport of the timber is done with the Timber feeder which transports the timber along the infeed and outfeed benches to the proper position. The Timber feeder is operated manually with a push button.



Technical Description

Roller diameter	76 mm
Roller length	400 mm
Timber feeder roller diameter	155 mm
Timber feeder speed	44 m/min
Air and electrical supply from the saw.	



INFEEED BENCH WITH SPLICING PRESS

The **Splicing press** is used for nail plate splicing of timber directly on the infeed bench of the saw. It enables an efficient production with a minimum of waste as you can splice the timber together to an infinite length before cutting.

The press force is 35 tonne and the bench is equipped with plungers and retracting devices to ensure timber alignment when splicing.

The press is operated manually with two hand pistol grip activation.



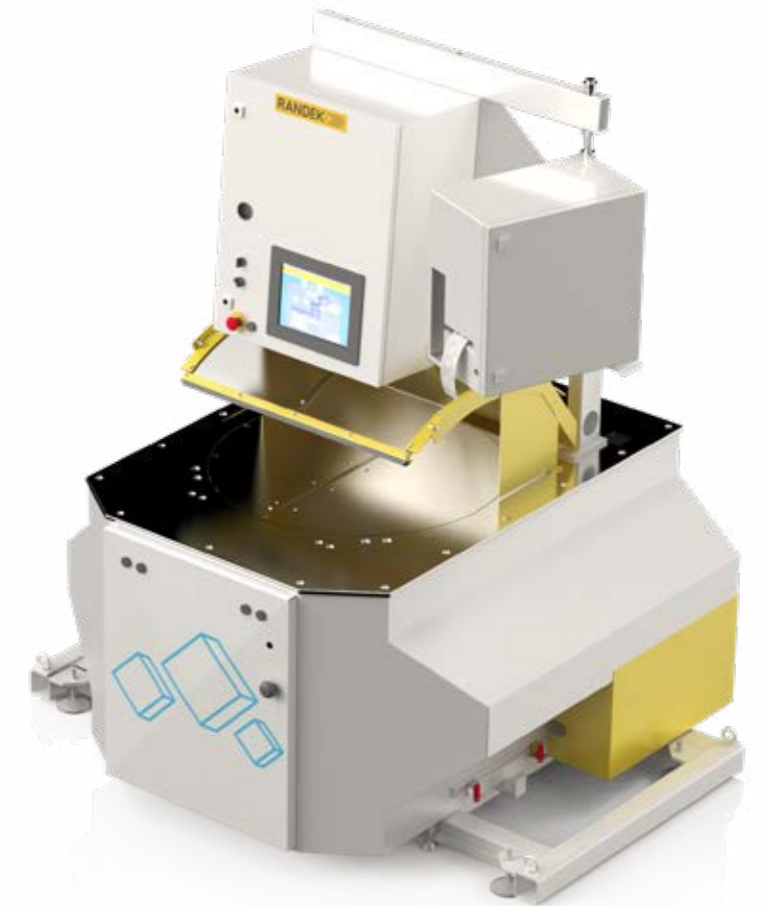
Technical Description	Minimum	Maximum
Roller diameter	76 mm	
Roller length	400 mm	
Timber feeder roller diameter	155 mm	
Timber feeder speed	44 m/min	
Nail plate length	-	420 mm
Nail plate width	-	300 mm
Timber thickness	45 mm*	130 mm
Hydraulic pressure	227 bar (35 tonne)	
Electricity requirements	3x400 VAC +N+PE 20A 50 Hz Contact Randek for consultation	
* Minimum timber thickness can be reduced with a spacer plate. Air supply from the saw.		

SAW UNIT

The saw units are delivered in two main models: **SP722** and **SPL728**.

The main difference is the possible cut types. The SP722 have the capability to turn the blade between 0-180° while the SPL728 can turn from 0-360° and slant the blade between 90-28°.

The saws are equipped with a protective saw blade cover which is automatically activated and lowered when the operator makes his cuts. The touch screen is placed conveniently in front of the operator for easy access and possibility to view and change the work process.



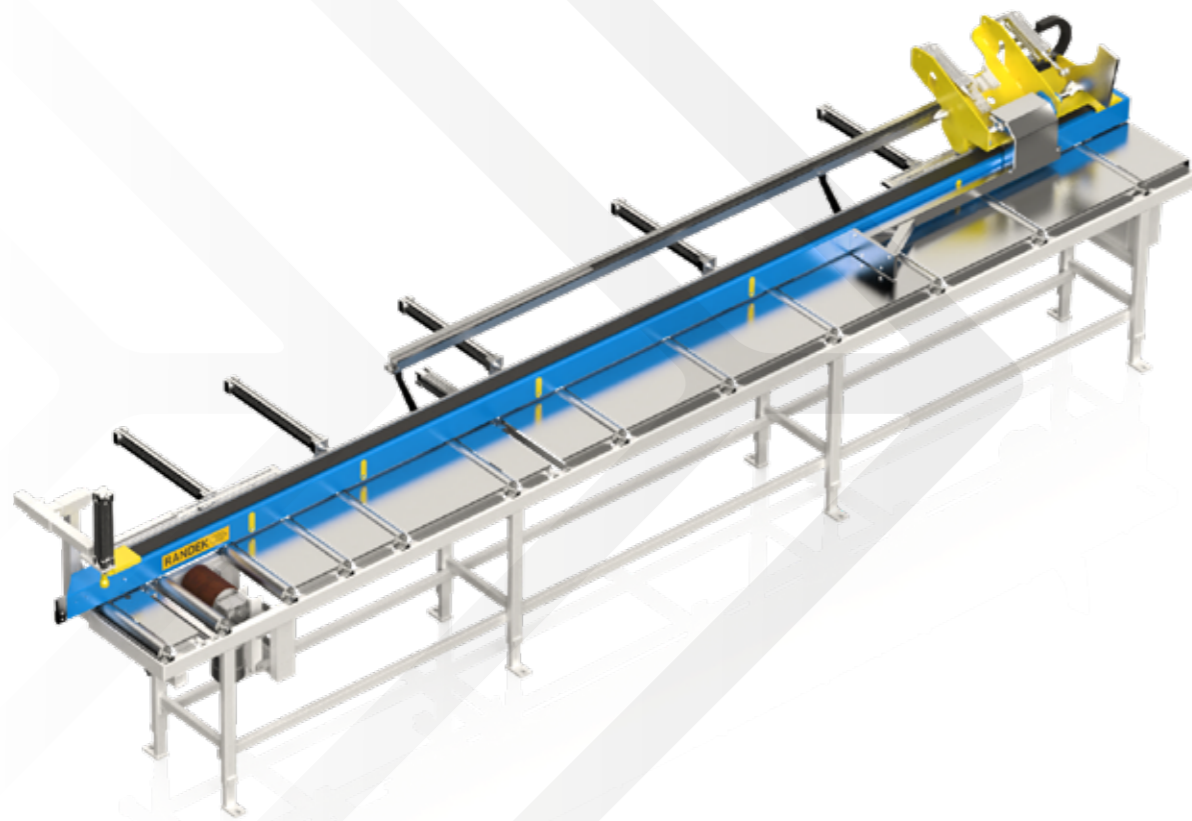
Technical Description	SP722	SPL728
Angular cuts	0° – 180°	0° – 360°
Inclined cuts	-	90° – 28°
Center line adjustment	0 – 250 mm	0 – 250 mm
Saw blade	700 mm	700 mm
Saw motor	5,5 kW	7,5 kW
Electricity requirements	3x400 VAC +N+PE 35A 50 Hz Contact Randek for consultation	
Need to be connected to a external dust exhaust - Air speed	4xØ125mm - 30 m/s	

SP722 SPL728	SP722 SPL728	SPL728	SPL728	SPL728

OUTFEED BENCH

SP720 Outfeed benches are equipped with Randek LX length stop. The stop positions itself according to the timber which is to be processed. The stop can position itself to cut pieces down to 50 mm and up to the complete length of the outfeed bench + 400 mm.

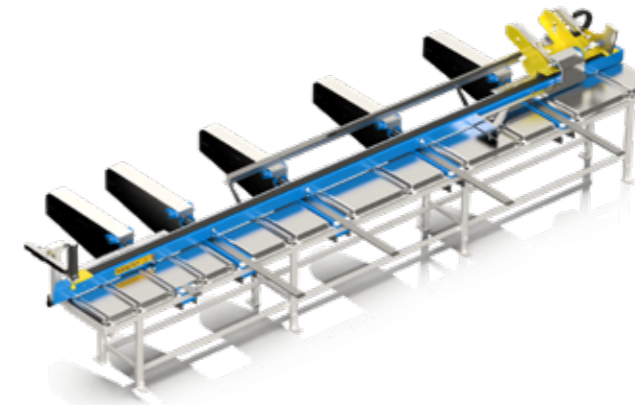
Just as the infeed bench, the outfeed bench is equipped with retracting devices and plungers for accurate cutting.



OUTFEED BENCH WITH STACKER

The stacking unit is an outfeed bench used for automatic stacking of timber on a hydraulically leveled table. When the timber is cut, it is automatically transported forward using a timber feeder until the back end of the timber reaches a sensor. Then the timber is pushed off the outfeed bench onto supporting arms.

The pusher will push the timber onto the supporting arms until one complete layer is filled. The supporting arms will then retract and drop the layer onto the stack. The lift table will lower itself one layer down making it possible for another layer to be piled. Cassettes with pushers and supporting arms are mounted on the back of the bench. The complete working cycle is fully automated. The feeding device is fitted with brake and reversible movement for straight ended packs.



Length	Timber feeder
5800 mm	No
7000 mm	No
8200 mm	No
9400 mm	No
10600 mm	No
11800 mm	No
13000 mm	No

Technical Description	
Roller diameter	76 mm
Roller length	400 mm
Max timber length	Bench length + 400 mm
Air and electrical supply from the saw.	

Technical Description	Minimum	Maximum
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Roller diameter		76 mm
Roller length		400 mm
Timber feeder roller diameter		155 mm
Timber feeder speed		44 m/min
Stack width	-	800 mm
Stack height	-	900 mm*
Timber length	50 mm**	Bench length + 400 mm
Electricity requirements		3x400 VAC +N+PE 16A 50Hz Contact Randek for consultation

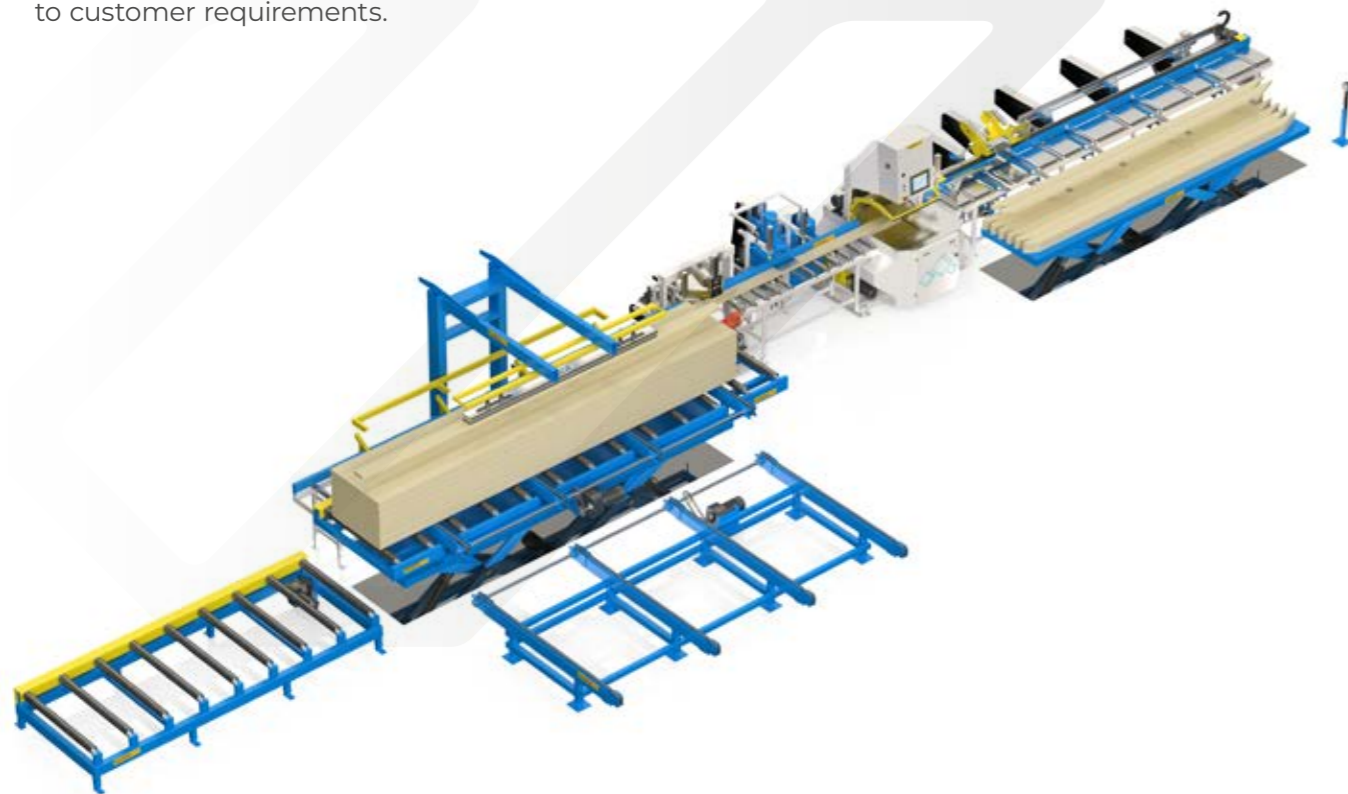
Outfeed bench equipped with	Length	Timber feeder
Timber stacker with lift table	5800 mm	Yes
Timber stacker with lift table	7000 mm	Yes
Timber stacker with lift table	8200 mm	Yes
Timber stacker with lift table	9400 mm	Yes
Timber stacker with lift table	10600 mm	Yes
Timber stacker with lift table	11800 mm	Yes
Timber stacker with lift table	13000 mm	Yes

* When the lift table is submerged in the concrete floor
 ** Minimum length for stacking function = 1200 mm
 Air supply from the saw.

MODULAR HANDLING SYSTEM



- For handling and feeding of entire piles of timber the saw and timber picker can be equipped with a modular handling system. The system can be configured according to customer requirements.



TIMBER PICKER



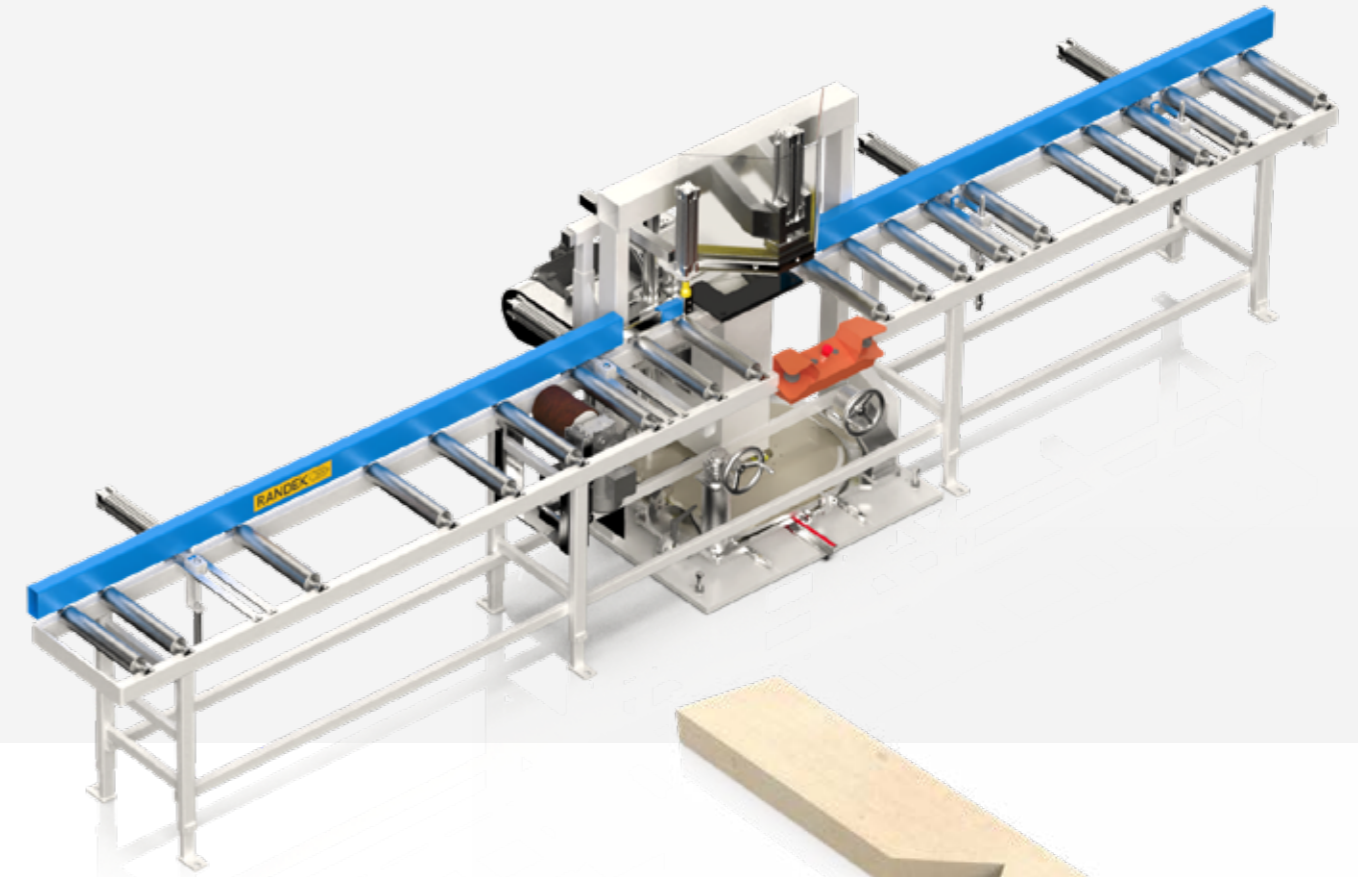
The timber picker picks timber with two vacuum pads from the timberpile and places them onto the infeed bench. Positioning of the pads is made with sensors placed on the picker. The timber is placed on a elevator and lowered to the infeed bench. The operator is given the possibility to flip or slide the timber down on the rollers. This option is available for roof truss producers who want to align their timber with the timber's natural curve to the roof truss.

When the timber feeder drops the timber on the elevator, it immediately begins to pick the next board. This gives a capacity of approximately 5 pieces/minute. The timber feeder accepts different sizes and lengths of material in the pile as long as thickness is the same through each layer of the pile.

- Higher capacity in saw line
- Reduce heavy lifts for the operator

Technical Description	Minimum	Maximum
Timber Length	2700 mm	6400 mm
Timber Width	70 mm*	300 mm
Pile Height	-	1900 mm
Timber Pile Weight	-	4000 kg**
Capacity	5 pieces/min.	
Electricity requirements	3x400 VAC +N+PE 16A 50 Hz Contact Randek for consultation	
Air supply	7 bar - 200 NL/min	
* The minimum timber width can be reduced to 45 mm with smaller vacuum pads		
** Lift table capacity		

MILLING MACHINE

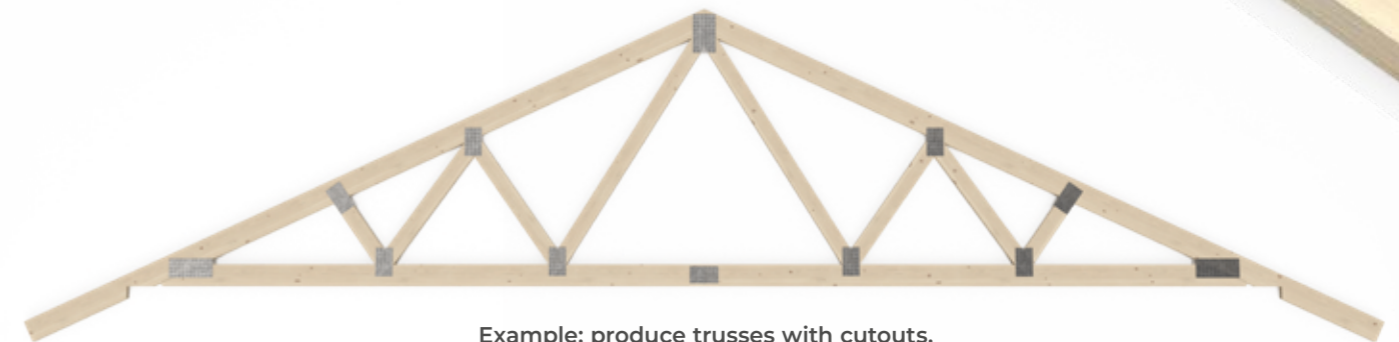


The milling machine can be used individually or together with the SPL saw. Manually adjustable between 0-45° operating angles. The depth of the cut is 120 mm and the depth movement is made manually.

The milling unit makes it possible to cut straight or angular v-shaped cuts.



Technical Description	Minimum	Maximum
Milling angle	0°	45°
Milling depth	0 mm	120 mm
Milling cutter	Standard: 180 mm - Ø375 mm	
Motor	7,5 kW	
Dust extraction, air flow	30m/sec	
Electricity requirements	35A	
	Contact Randek for consultation	
Compressed air is fed from the saw unit		



Example: produce trusses with cutouts.

LABEL PRINTER

The **label printer** is connected to the PLC on the saw and prints information such as name of company, name of cad file, width, length and thickness. The printer is installed in a cabinet for safe and dust free operation. The operator button is placed on the cabinet and prints on demands.

Print methods: Thermal transfer or direct thermal.

Placement

Right

Left



THE SOFTWARE

The **saw** is equipped with an industrial PC with a touch screen that displays automatic calculations and changes. You are able to follow the saw process and always know on what cut in which piece you are.

You are able to make your own cut data, or simply import complete projects from market leading house and truss dimensioning 3D - programs. All you need to do is start sawing.

Since the software is developed in windows environment, the operating system makes it simple to integrate the saw with the corporate network, allowing for network transfer of the projects scheduled to be done.



The operator can easily follow the work process on the screen.

SWEDISH QUALITY LASTS

Randek are pioneers in creating innovative automation solutions for customers within the prefabricated house manufacturing industry since the 1940s. Today, Randek is one of the world's leading suppliers of high-performance machines, robotic solutions and complete systems with production lines holding several world records in production capacity.

PRODUCTS/SYSTEM



CUT SAWS

Sturdy reliable cut saws delivered to house and roof truss manufacturers all over the world. From manual to fully automated



WALL, FLOOR AND ROOF PRODUCTION LINES

A comprehensive product range with tailor-made systems for prefab manufacturing of walls, floors and ceilings. From manual to fully automated.



ROBOTIC SYSTEM

Randek Robotics develop advanced systems in robotic automation. Delivering efficiency to customers in Europe, China, North and South America since the 1990s.



ROOF TRUSS SYSTEM

Equipment for traditional and effective manufacturing of roof trusses and a revolutionising automated roof truss production system.



BUTTERFLY TABLES

Innovative wall-turning tables. From moderate manual wall-turning tables to advanced with a range of options.

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