

"Heavy-Builts"



Hasko

Flooring and Woodworking Machinery Since 1930

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DESCRIPTION

(Subject to Conditions of Sale)

Hasko HSRF OPTIMIZING INFEED TABLES FOR GANG RIPSAWS

(For Medium-To-High Production Straight-Line Gang Ripping Operations)

FEATURES:

The **Hasko HSRF** Infeed Table for up to 36" wide Gang Ripsaws is a heavy duty, high speed, movable or fixed guide infeed system for straight line gang rip operations. This machine is suitable for any fixed arbor gang rip saw where there is a desire for optimization for board yield and/or target cuts. Movable guide positioning is obtained via inputs from scanning software or operator actuated (visual via laser lights). Final pricing is determined by method of rip selection and other automated or manual operations in the application. The standard machine is configured for right to left lumber flow or "Right Hand". Opposite hand feed or left to right is available as an option.

The **HSRF** is heavily constructed and incorporates an innovative fabricated ribbed tubular steel mainframe. The new ribbed vibration dampening framework provides very versatile access into the rolls for optional live chain feed systems and jump chains.

The roll case consists of (eleven) 4" diameter x 35.5" long canted rolls driven by a 2 H.P. gear motor and "V"-belt drive.

The movable guide assembly consists of a rigid heavy gauge structural aluminum beam mounted on two large linear bearing rails that mount on the inner mainframe. The guide is faced with replaceable steel wear strips. The shifting guide is quickly traversed and accurately positioned by a 1 H.P. servomotor and cog belt drive system via inputs from the operator or scanning software.

The pinch roll system ensures positive acceleration and feeding into the gang rip saw. The pinch roll system consists of an 8" diameter top hold-down roll with a vulcanized rubber coating and a powered knurled and hard chrome plated bottom feed roll. The bottom roll is variable speed (up to 400 FPM) via an inverter drive system. When the proximity switch senses the board, the pinch roll shifts to the down position via a pneumatic cylinder to ensure positive feeding.

Seven powered lateral 60-pitch pop-up chain beams transfer the lumber from the infeed deck to the guide. The chains are continuously powered by a 1 H.P. gear motor and maintain positive lead to the guide while the board is being shifted to the targeted rip position. Once the target position is set, the chain beams pneumatically shift to their lowered position allowing the canted and pinch rolls to accelerate the board into the rip saw.

MACHINE SAFETY, GUARDING, OSHA - Subject to Conditions of Sale

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The **HSRF** is PLC controlled if used with operator defined selections. If the selections are made by a scanning system, the Motion Control is managed by a PC and is compatible with most available scanning software packages. The standard machine allows the operator to reference laser lights aligned with the saws on the gang rip and position the guide to targeted cut lines. Once the board is in position, it is released and enters the saw. The manual operator defined system or automated scanning system does require a delivery system with a method to separate boards ("board dealer") and a delivery deck that incorporates stops for operators to inspect rip selections.

STANDARD SPECIFICATIONS:

DIMENSIONAL:

- 221" long x 84" wide
- Roll deck height adjustable from 37"- 41"
- 63" highest point at pinch roll frame
- Weight – 8700 lbs (estimated)

CANTED ROLL CASE:

- Eleven 4" diameter x 35.5" long feed rolls canted at a fixed lead angle
- Canted feed rolls driven by 2 HP gear motor and preset constant speed 334 FPM

PINCH ROLL ASSEMBLY:

- One 8" Diameter x 34" long steel top roll with vulcanized rubber coating in a pivot yoke weldment
- Pinch roll driven by 1 H.P. inverter-controlled variable speed gear motor
- Air cylinder actuation and tensioning
- Pinch roll system feed speed is variable via inverter drive from 200-400 FPM

LATERAL INFEED JUMP CHAIN BEAMS:

- Seven #60 pitch cross feed chains
- Cross chains driven by 1 HP single speed gear motor for 200 FPM (higher speeds optional)
- Air cylinder actuation

LUMBER GUIDE:

- Heavy gauge structural aluminum beam mounted on two large linear bearing rails
- Shifting guide is traversed by a 1 H.P. servo gear motor
- Wear surfaces on the guide beam are faced with replaceable steel wear strips

STANDARD CONTROLS:

- NEMA 12 electrical enclosures, 460VAC standard
- A programmable logic controller (PLC) coordinates all machine functions
- All controls are mounted on a control console pendant at pinch roll area

FUNCTION:	LOGIC:	ACTIVATOR:
Main Power	On/Off	Push Buttons (2)

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Feed Rolls Rotate	On/Off	Push Buttons (2)
Cross Chain & Pinch Roll	Up/Down	Push Button
Cross Beam	Left/Right	Push Buttons (2)
Pinch Roll	Up/Down	Proximity Switch
E-STOP	Off	Push/Pull Button
Pinch Roll Down (pinch)	Push-Down/Release-Up	Spring Loaded Button

CAPACITIES:

- Longest material: 16 feet
- Shortest material: 36 inches
- Widest material: 28 inches
- Thickness of material: 1/2 to 2-1/2 inches