

"Heavy-Builts"



# Hasko

Flooring and Woodworking Machinery Since 1930

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DESCRIPTION

(Subject to Conditions of Sale)

## Hasko SRMA ShiftMaster HIGH PRODUCTION GANG RIP SAWS

(The Latest Technological Achievement To Rip Saw Flexibility)

### FEATURES:

The new **Hasko SRMA ShiftMaster Gang Rip** is a Heavy Duty, High-Speed Roll Feed Shifting Saw Gang Rip having approximately 27.75" of usable saw area. A wide range of cut selections can be obtained via the use of three AC Brushless Servo Actuated shifting saw mechanisms. The standard cut configuration includes one 13.5" long shifting saw sleeve assembly and (2) single shifting saw assemblies --- or optionally configured with one 13.5" long shifting saw sleeve assembly, one single shifting saw assembly and one shifting 1.5" wide hogging saw assembly.

The standard machine's 4-1/16" diameter splined arbor is powered by a 75 H.P. 3450 R.P.M. direct-coupled motor. A removable interlocked outboard bearing assembly provides support at end of arbor. Arbor braking is achieved through the use of an air actuated disc and caliper braking system.

An electric feed drive system powers four (top and bottom infeed and top and bottom outfeed) 8" diameter rolls. Upper and lower rolls are knurled and hard chrome plated. Feed rolls are air-tensioned with interlocked air-quick-release to prevent raising with arbor powered. The machine is equipped with two rows of top and one row of bottom anti-kickback fingers with an air actuated release mechanism. The machine is equipped with a touch screen control console, and free-standing NEMA electrical panel housing the PLC, magnetic relays, inverters, and electronic devices utilizing 110-volt control circuits for machine operation on 440/60/3. The front feed roll guard is control interlocked to prevent machine operation when removed.

### Optional Hasko SRMA-H In-Line Pre-Hogger

The **Hasko Model SRMA-H Inline Pre-Hogger™** is designed to couple in-line with the **Hasko SRMA Gang Rip** Saw and utilizes one or two shifting hog saws effectively dimensioning board edges before the primary gang rip saw. This is an innovative and cost-effective solution for eliminating unusable ripped edgings plus the added benefit of creating two additional cut selections at the **Hasko SRMA Gang Rip**.

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

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## SRMA ShiftMaster Gang Rip Saws

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### FEED DRIVE SYSTEM:

**Hasko SRMA ShiftMaster** Gang Rip Saws employ four driven 8" diameter chromed and knurled feed rolls. Two (infeed and outfeed) 20 HP SEW Gear Reduction Units coupled to a wet gearbox with shaft drive to the feed rolls produce an efficient and powerful feed drive system. Upper rolls are provided with pneumatic tension to feed a wide array of poorly manufactured lumber when necessary and to provide the exclusive **Hasko Quick-Clear™** jam-freeing feature when activated. The machines features standard variable feed rates of 250-450 FPM via an inverter drive system.

### ELECTRICAL:

One main free standing electrical panel with safety disconnects houses magnetic relays, inverter drives, and other electronic and electrical components. The operator's touch screen control console is pendant mounted on the machine at eye level. All control circuitry is 120 VAC. The machine is equipped with emergency stops and guard interlocks. Interlocked upper rolls prevent raising while under power. 460/60/3 standard.

### OPTIONAL OPTIMIZING INFEED TABLE:

The **Hasko HSLS High Speed Laser Scanning System** with optional Bow-Busting is a simple but robust and cost effective width optimizing option that can improve your overall yield and lumber utilization while obtaining optimum production. While specifically designed for use with **Hasko** Gang Rip Saws and **Hasko HSRF** Shifting Guide Infeed systems, the **HSLS** will easily integrate with other ripping systems. This system is ideal for manufacturers of hardwood flooring, lineal mouldings, dimension, and other rip-to-size operations.

The system consists of: (1) Optional board dealer, (2) High-speed heavy-built scan conveyor, (3) Intermediate board stop, (4) Light curtain style of laser scanner with alignment guide at second board stop, (5) Servo-positioned array of laser lines to display solutions, and (6) Touch screen interface used for data reporting and programming. An optional busting saw can be included to reduce loss due to side bow. This scanner is generally to optimize boards for an infeed table with servo-driven guide and straight line fixed arbor gang saw.

This is one of the simplest rip optimizing systems available in the industry and will provide accurate solutions for any arbor stack up. The software is both user friendly and versatile. The software settings are matched to the hardware at the factory leaving only a few operational settings to be programmed into the system by the operator. All data entry and changeovers are quick and easy via the systems touch screen.

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## SRMA ShiftMaster Gang Rip Saws

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### SRMA ShiftMaster Gang Rip Saws

#### SPECIFICATIONS:

(Updated: 8/15/06)

#### MOTOR SPECIFICATIONS

Arbor Motor (Direct Coupled by Lovejoy Sure Flex)	75 H.P. 3450 RPM Std. (100, 125, and 150 H.P. Opt)
Arbor Braking System	Disc and Caliper, Air Actuated & Via E-Stop
Feed Drive Motors	(2) 20 H.P. TEFC Sew EuroDrive Gear Units
Electrical Panel	NEMA Standards, Free Standing
System Electrical Requirements	460 Volt-60 Cycle-3 Phase Standard (Others Optional)

#### FEED DRIVE SYSTEM

Number of Powered Feed Rolls	Four, 8" Diameter, Chrome Plated and Knurled
Feed Roll Power Transmission	One infeed and One Outfeed 20 H.P. Sew Euro-Drive
Upper Feed Roll Tensioning	Pneumatic, With Interlock to Prevent Raising Arbor
Feed Speed	250 - 450 FPM (Standard)

#### SAW MOVEMENT

Number of Shifting Saw Mechanisms	Three
Type of Actuator	Servo Driven Zero Lash Ball Screw
Actuator Drive Type	Baldor AC Brushless Servo
Type of Feedback	Absolute Encoder
Actuator Drive Type	Baldor AC Brushless Servo

#### TOOLING

Saw Size	14" O.D. x 5-1/8" Bore
Sleeve Size	13.5" usable space X 5-1/8" O.D.
Saw Spacers	5-1/8" Bore x 8" O.D.

#### CAPACITIES

Thickness	1/4" - 2-1/2"
Shortest Material	30"
Useable Saw Space	27" inside saw to outside saw
Widest Board Width that will pass through machine	30"
Estimated Weight (Less Hydraulic Unit)	18,500#
Machine Area (Length x Width x Height)	78" L X 113" W X 70" H
Foot Print (Length x Width)	56" x 96"
Bed Line	36"