



PERFECT COMPONENTS.
PERFECT SYSTEMS.

A MEMBER OF  HTI GROUP

Planetary Saw

Cut and Chamfer

The different cutting and chamfering processes are performed with highest possible precision independent of „out-of-round“ state or wall thickness of the pipe. A mechanical sensor at the cutting arm continuously follows the pipe and ensures a permanent adjustment of the chamfer depth.

Chip Exhauster

Double Exhauster

Exhausterhood at the cutting and chamfering tool. Exhausting spot is on the bottom of the rotor-carriage. The chips are collected in appropriate bags which are fixed at the frame of the saw.

Clamping of the Pipe

Traditional System

This consists of two pairs of fixed clamping jaws which clasp the pipe over the total circumference. One set of clamping jaws is required for each pipe diameter (O.D.). The exchange of the clamping jaws can be done in shortest time.

Universal System

This consists of an appliance with progressive closing, which clamps the pipe on 8 (8 + 8) positions and so adjusts itself to the actual diameter. The 8 arms grip the pipe surface independently of each other and assure a secure clamping also in case of „out-of-round“ pipes.

Technical Data		TAB 10-125	TAB 32-200	TRS 10-125	TRS 25-160	TRS 32-250	TRS 63-400	TRS 100-500	TRS 110-630	TRS 110-800
Pipe diameter	mm	10/125	20/218	10/125	25/160	32/250	63/400	100/500	110/630	110/800
Extrusionspeed max.	m/min.	36	28	20	17	16	4.5	7.0	5	4.5
Pipe length, min. (+/- 3 mm)	mm	125	200	1500	1300	1300	1000	1150	1100	1500
Wall thickness, max.	mm	1/25	1.5/35	10	20	40	70	70	70	70
Max. moving distance *	mm	800	1200	1000	500	500	1000	1000	1000	1000
Average sound pressure level	dB(A)	81.7	79	81	81	82	79.9	79.5	79.5	79.5
Installed power	kW	1.85	5.2	5.2	5.9	5.9	7.5	7.5	8.0	8.5
Working pressure compressed air system	bar	6	6	6	6	6	6	6	6	6
Air consumption	Nl/cycle	25	58	81	60	63	120	120	120	160
Working pressure hydraulic aggregat	bar	-	-	20	20	20	20	20	20	20
Length	mm	2520	3090	3500	3573	3670	4235	4235	4235	4235
Width	mm	1156	1370	750	1352	1449	1518	1675	2090	2090
Height	mm	2460	2400	2420	2312	2342	3039	3001	4255	4255
Weight	kg	950	1100	800	1300	1350	2150	2280	3100	3750

*) extended stroke for faster extrusion speed on request

Standard

- TRS saw: combined cutting and chamfer system (no chips inside the pipe)
- adjustment of the chamfer depth
- TAB saw: without chamfer system
- chip exhausting system
- cutting arm adapted with sensor for exact chamfer, even of oval pipes
- dynamical balance of the cutting rotor
- traditional pipe clamping system
- rotor carriage of low noise

Options

- universal pipe clamping system
- electronical control of the clamping jaws opening
- numerical control CNC for snatch cut
- automatic synchronisation with the extrusion speed
- hydraulic control for the carriage
- jumbo bag: drainbag (1050 x 1050 x H 2040 mm) on the carriage of the exhauster system
- telescope channel connection from the saw to the belling machine/tacking installation
- extended stroke for faster extrusion speed

Complete line

The TRS planetary saw is one component of a complete pipe extrusion line offered

- by High Tech Extrusion consisting of
- CON/TTS/TTM/OMNIA XTR twin-screw extruder
 - RK/RKS RKT Streamliner pipe head
 - DVK double-chamber-/VK vacuum spray tank
 - SB spray bath
 - RAE belt-/RA multiple caterpillar haul-off
 - TRS planetary saw
 - Socket forming machine
 - Tip table