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## **TSD CSF 2 / DOUBLE END ROUNDING OFF TENONING MACHINE with HOPPERFEED**



**TECHNICAL FEATURES – DOUBLE END ROUNDING OFF TENONING MACHINE**  
**(basic version)**

Controlled Axes n° 1

**STROKES**

Max working length ( stand. )	mm	1200
Max working length ( opt. )	mm	2200
Min working length	mm	150
Max tenon width	mm	100 + 2R
Max tenon depth	mm	40
Min tenon depth	mm	10
Max. tenon thickness	mm	25
Inclination of the heads		+45° - 22°

**MOTORS POWER**

Motor for cutter rotation	HP	4 x 2
Motor for cutter revolution (with inverter)	HP	1 x 2
Motor for movement of the R.H. unit	Hp	1

**SPEED**

Cutter holder shaft speed ( stand. )	RPM	9000
Cutter holder shaft speed ( opt. )	RPM	12000

**TOOLS**

Cutters supplied with the machine n° 2

**DIMENSIONS**

Overall dimensions with stroke X = 1200 3200x1650x1800mm

## **STRUCTURE :**

The machine is composed by:

- Stabilised and deeply ribbed frame, with constant section designed to grant the maximum rigidity and straightness of all the loading conditions in time;
- Two working heads installed on mobile uprights with a high degree of rigidity, which slide in the direction X and Y of the frame and rotate around a vertical axis;
- Working heads tiltable around a horizontal axis



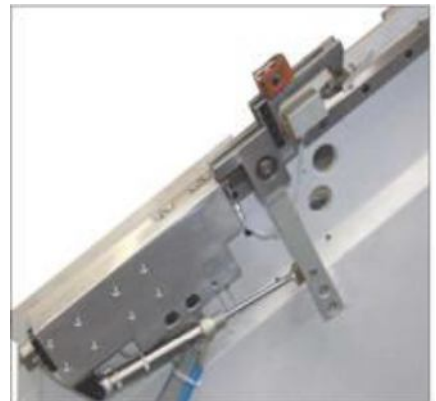
## **MOVEMENT OF THE AXES :**

### **Linear positioning Axes:**

Oversized REXROTH / MANNESMANN ball blocks that grant absolute rigidity and reliability in time.

All movements are controlled by gearboxes (that don't require any clearance or periodical adjustments).

Modified piece-holder carriages to support the above mentioned special ball blocks.



## LOADING SYSTEMS

The machine is equipped with automatic hopperfeed model CSF2. It offers the following advantages:

- Bent pieces can be loaded and unloaded automatically even without any special piece-holder devices and the minimum working length is 150 mm.
- The loading and unloading movements are synchronised in order to avoid collisions between already machined pieces and pieces to be machined.
- Automatic lining-up of machined pieces on guides placed in front of the operator who can therefore easily collect / remove them and check their quality .
- Piece-holder carriages slide on hardened ground guides, reducing the min. working length (150 mm) and also reaching high productivity (2000 tenons/hour).
- Double clamping system both from the top and from the bottom, allowing the choice of the most suited reference surface.
- Tiltable supports adjustable in height for bent pieces.
- Possibility to machine tenons on both ends of the piece at the same time, with all possible angles.
- Possibility to incline vertically and horizontally short pieces.



## TENON ADJUSTMENT

- Inclination, width and length adjustments of the tenons are made by means of external handles, even while the machine is working.
- Such adjustments can be stored in a program, in an appropriate macro.



## WORKING HEADS

- Working heads mounted on angular contact high precision bearing to eliminate clearances;
- Continuous revolution of the cutter around the piece;
- Standard cutter rotation speed 9.000 rpm, or 12.000 rpm as an optional, according to the application.
- Two standard cutters included.

