3. TECHNICAL DATA

3.1. Machine installation plan

3.2. Weight of machine

	Values in kg
FLM 180	ca. 5700
FLM 230	ca. 6200
FLM 330	ca. 7600
FLM 430	ca. 9000
FLM 580	ca. 10400

	180	**230**
Basic machine with desk	ca. 2000	ca. 2300
Switch cabinet	ca. 850	ca. 850
Air flotation tables (x 3)	ca. 220	ca. 220
Feeder with trailing cable installation	ca. 425	ca. 500
Box of accessoires	ca. 60	ca. 60
Feeder carrier, rails	ca. 775	ca. 840
Feet, supports, etc.	ca. 250	ca. 250
Panelling	ca. 150	ca. 160
Turn table	ca. 750	ca. 1000

	330	**430**
Basic machine with desk	ca. 2900	ca. 3500
Switch cabinet	ca. 850	ca. 850
Air flotation tables (x 3)	ca. 220	ca. 220
Feeder with trailing cable installation	ca. 650	ca. 800
Box of accessoires	ca. 60	ca. 60
Feeder carrier, rails	ca. 970	ca. 1100
Feet, supports, etc.	ca. 250	ca. 250
Panelling	ca. 180	ca. 200
Turn table	ca. 1500	ca. 2000

	580
Basic machine with desk	ca. 4100
Switch cabinet	ca. 1000
Air flotation tables (x 3)	ca. 220
Feeder with trailing cable installation	ca. 950
Box of accessoires	ca. 60
Feeder carrier, rails	ca. 1260
Feet, supports, etc.	ca. 250
Panelling	ca. 220
Turn table	ca. 2500

3.3. Machine data

Feeder speed	
forwards	25 m / min
backwards	25 m / min
Rate of saw feed:	
forwards	0.2-50 m / min
backwards	50 m / min
Motor power	
Saw motor	up to 21 kW at 50/60Hz
Scorer motor	1.5 kW at 50/60 Hz
Clamp opening	130 mm

3.4. Accuracy of machine:

Straightness of cut	
	± 0.1 mm for 3 m cutting length
Dimensional accuracy	
	± 0.2 mm length
	± 0.2 mm width
	± 0.3 mm diagonal
Angular accuracy	
	± 0.2 mm for 1 m side length

3.5. Requirements of suction system

The machine must be connected to a suction system of adequate size. The requirements for the suction parts can be ascertained from the values below. The connected loads refer to a flow rate of 20 m/s.

The suction system must always be in operation during the cutting process. The staff should not be exposed to excessive amounts of dust. There are two terminals in the switch cabinet (terminals xx) which transmit the message "Saw on" to the suction system.

Attention: Only use sucking tubes which are made of unflammable Material.

The saw must not be used without an adequately sized suction system.

Suction connection and connected loads of the individual suction nozzles

Pressure beam	**ø 120 mm**
Minimum air flow	20 m/s
Pressure loss	1237 Pa
Volume flow	813 m³ / h

Sawing edge	**ø 80 mm**
Minimum air flow	20 m/s
Pressure loss	460 Pa
Volume flow	362 m³ / h

Chip conduit	**ø 120 mm**
Minimum air flow	20 m/s
Pressure loss	1237 Pa
Volume flow	813 m³ / h

Recommended suction volume	
	Values in m³ / h at 32 m / sec
FLM 180	approx. 3200

Recommended negative pressure	
At saw	3000 Pa

3.6. Requirements of pneumatic system

Pneumatic device works without oil (dry air)

The compressed air supply is connected via an instant connector at the maintenance unit.

Maximum air consumption:
The maximum air consumption is 1600 standard litres/min

Operating pressure:
The operating pressure is 6 bar min. and 8 bar max.

3.7. Requirements of electrical system

Electrical connection values:

Voltage	400 V
Power	30 kW
Frequency	50 Hz

The electrical connections must be performed by an electrical specialist according to the relevant regulations.
Both the general and the specific local safety and accident prevention regulations must be observed during the electrical installation.

Electrical connection by specialist

3.8. Saw blades used

Main saw blade make "Leuco 104370-188473 Topline" *Main saw blade*

Diameter	450 mm
Inner bore diameter	30 mm
Saw blade thickness	3.2 / 4 mm
Number of teeth	72
Tooth form	flat trapezoid

Main saw blade make "Leuco – DIA 204080-799008/1 7037807 Pa.192" *Main saw blade*

Diameter	350 mm
Inner bore diameter	30 mm
Saw blade thickness	3.2 / 4 mm
Number of teeth	48
Tooth form	roof flat

Used tools should be equivalent to prEN 847-1.

Instructions:

a) Only use saw blades which are recommended by the manufacturer for tensioning.

b) Saw blades should be mainteanced regularly and if necessary exchanged.

c) While carrying out maintenance work appropriate devices and tool holders should be used to avoid injuries.

d.) The RPM-speed has to be adjusted to the used saw blade!
(check for a maximum speed printed on saw blade)

For other saw blades the values for dust,- and noise emission cannot be guaranteed.

3.9. Emission levels

3.9.1. Noise emissions

Workstation-related emission level:

LpAeq 72.4 dB (A) in idle state - LpAeq 81.1 dB (A) for machining

Acoustic capacity level: 2 Units
No load: 93,7 dB (A)
Working: 101,1 dB (A)
Instability allowance: K=4 dB (A)
Measured according to prEN 1870-2:1995

The indicated prices are emissions values but they do not present work station values automatically.
Though a correlation between emission and imission level exists, it does not automatically refer to the fact that measures of precautions are needed. Factors, which influence the current immission level at the working station, comprise the duration of the effects, the peculiarity of the working space, different noises, ect. for instance the number of machines and other neighbourly activities.

3.10. Conversion of units

1 l / min	=	0.03531 ft^3 / min
1 m / sec	=	3.2808 ft / sec
32 m / sec	=	105 ft / sec
1 m^3 / h	=	35.31 ft^3 / h
1 kW	=	1.36 HP