



**DANOBAT**

# VL/VP

HIGH  
PRODUCTION  
VERTICAL CUTTING



# VERTICAL CUTTING SOLUTIONS

DANOBAT designs and manufactures solutions of vertical cutting using leading-edge technology for different sectors. They are versatile solutions with machines ready to easily fit in with customer's applications, as well as different materials: stainless steel, inconel, duplex, superduplex, tool steels, all types of mild and low-carbon steel, titanium, graphite, aluminium, etc.

Its rigid, steady and compact design ensures the highest standards of accuracy. The saw head, manufactured in a single piece, together with the moving guide arm, hydraulically clamped during the cutting process, achieves a high performance and quality machining results.

The vertical band saws are classified according to the height and maximum width of the component to be cut, as well as its length. Depending on the component's dimensions, DANOBAT offers 2 ranges: VP and VL.

Machines with different levels of automation as well as a wide range of options have been developed to suit different customer's requirements.

We provide comprehensive solutions, covering all the technical and after sales needs, integrated from beginning to end, reliable and profitable.







## SERVICE

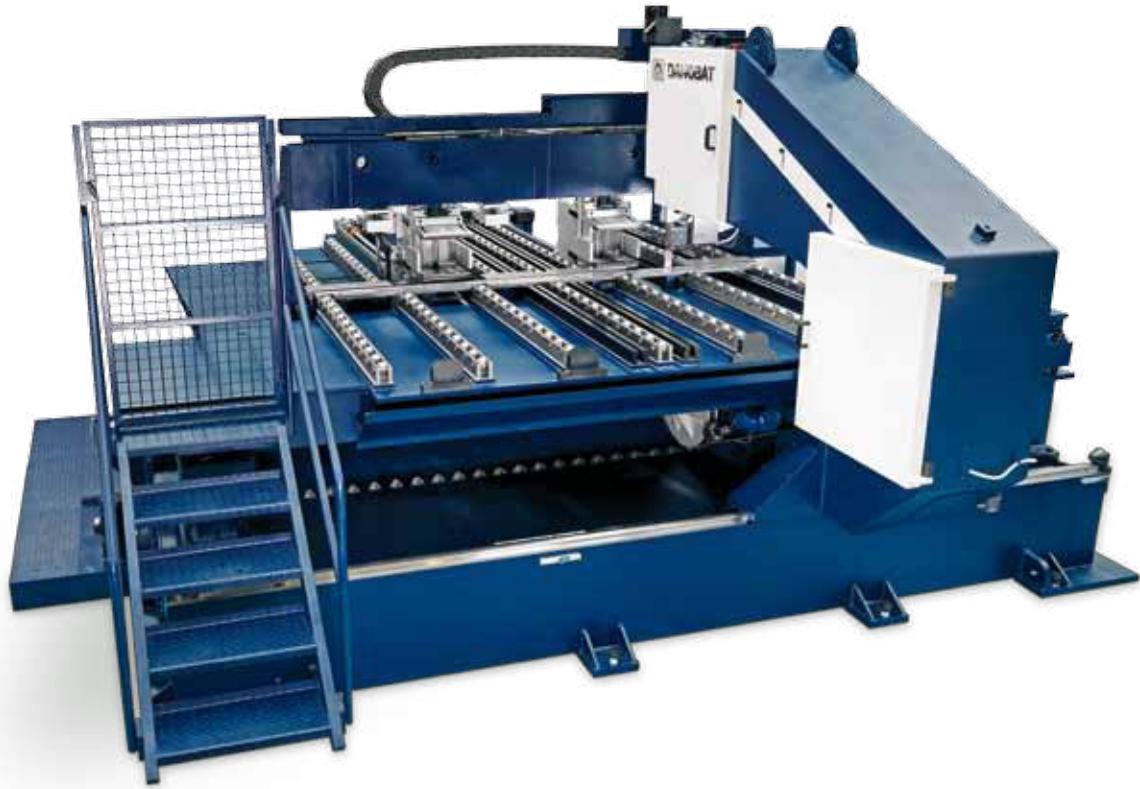
DANOBAT has a Cutting Advice Department for performing machining time studies for the customer's parts and optimization of his production process.

The high level of commitment of DANOBAT toward the customer, lasts throughout the life of the machine. The company offers services such as telediagnosis, preventive maintenance and teleservice.



## VERTICAL CUTTING **SOLUTIONS**

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## **VL, VERSATILITY AND HIGH PRODUCTION FOR MEDIUM AND BIG SIZE PIECES**

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The machine is designed for cutting difficult materials with maximum quality. The saw head contains a robust arm to reduce vibrations and achieve high production rates and long blade life.

Intelligent cutting software, iCS®, guarantees maximum performance, achieving longer blade life and reducing cutting times. iCS calculates automatically cutting parameters for each type of material. This way, cutting speed changes depending on the cutting section at each moment and it makes adjustment on both entering and exiting of the material. Among other applications, iCS includes an intelligent cutting system and allows to program running in of bandsaw blades automatically.

It allows to cut special materials with carbide blades and get the best cutting performance and blade life.

Automatic feeding and positioning, as well as semiautomatic operation are offered, depending on the production level required.

Vices are manufactured of steel plates, grooved and tempered with the aim of avoiding premature wearing when feeding. Vices are tilting to offer a secure and correct clamping and feeding of material.

External and internal table, in automatic models, are provided with rollers, that guarantee an optimal displacement of the material, as well as a high accuracy positioning.

Compact design to reduce the floor space needed in the production plant. Thus, ergonomic: coolant protection and collection system, touch control panel integrated in the electric cabinet and easy and fast blade changing system.

# VL

## TECHNICAL SPECIFICATIONS FOR AUTOMATIC AND SEMIAUTOMATIC MODELS

| CHARACTERISTICS                        |            | VL 50.70                 | VL 150.120               | VL 30.150                             |
|--|------------|--------------------------|--------------------------|---------------------------------------|
| Maximum capacity<br>(height x throat)  | mm<br>inch | 700 x 500<br>20 x 28     | 1500 x 1200<br>47 x 60   | 1500 x 300<br>12 x 60                 |
| Table length                           | mm<br>inch | 4000 ; 6000<br>157 ; 236 | 3000 ; 4000<br>118 ; 157 | 3000 ; 4000 ; 6000<br>118 ; 157 ; 236 |
| Feeding stroke<br>for automatic models | mm<br>inch | 1500<br>60               | Not applicable           | 1500 ; 2500 ; 3000<br>60 ; 100 ; 118  |

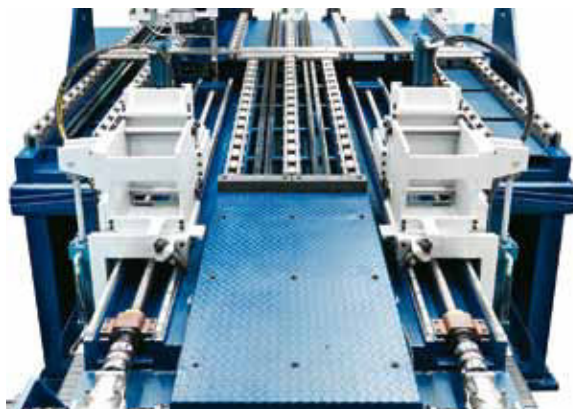
| CHARACTERISTICS                        |            | VL 80.150                             | VL 150.150             | VL 70.200                            | VL 60.250              |
|--|------------|---------------------------------------|------------------------|--------------------------------------|------------------------|
| Maximum capacity<br>(height x throat)  | mm<br>inch | 1500 x 800<br>32 x 60                 | 1500 x 1500<br>60 x 60 | 2000 x 700<br>28 x 80                | 2500 x 600<br>24 x 100 |
| Table length                           | mm<br>inch | 3000 ; 4000 ; 6000<br>118 ; 157 ; 236 |                        |                                      |                        |
| Feeding stroke<br>for automatic models | mm<br>inch | 1500 ; 2500 ; 3000<br>60 ; 100 ; 118  | Not applicable         | 1500 ; 2500 ; 3000<br>60 ; 100 ; 118 |                        |

\* Blade dimensions and main motor power according to your requirements

\*\* Other specifications up on request



▲ Accurate positioning



▲ Automatic feeding system



## SPECIAL APPLICATIONS

### OTR TYRES

Band saw machine designed for cutting Off-the-road tyres.



### BIG VALVES

Band saw machine specially designed for getting high cutting accuracy in very hard materials, such as: inconel, duplex, superduplex, ... used afterwards for manufacturing big valves.



### AEROSPACE

Band saw machine prepared for getting high production rates cutting aluminium and titanium.



## OPTIONS

### TILTING VICES

The machine can be equipped with tilting vices. These clamps turn 90°, so the table is free of obstacles and make the loading of the pieces easier.

Available for VL range.



### HYDRAULIC VERTICAL CLAMPING

It consists of a bridge with a vertical clamps, adjustable to different length pieces.

It guarantees the cutting quality, especially in irregular materials.

It is possible to cut in bundles, and increase the production level with maximum accuracy.

Available for VL range.



### LASER LAMP

A laser light beam is reflected onto the piece showing the cutting line.

This option helps the user to manipulate and position the material in semiautomatic models.

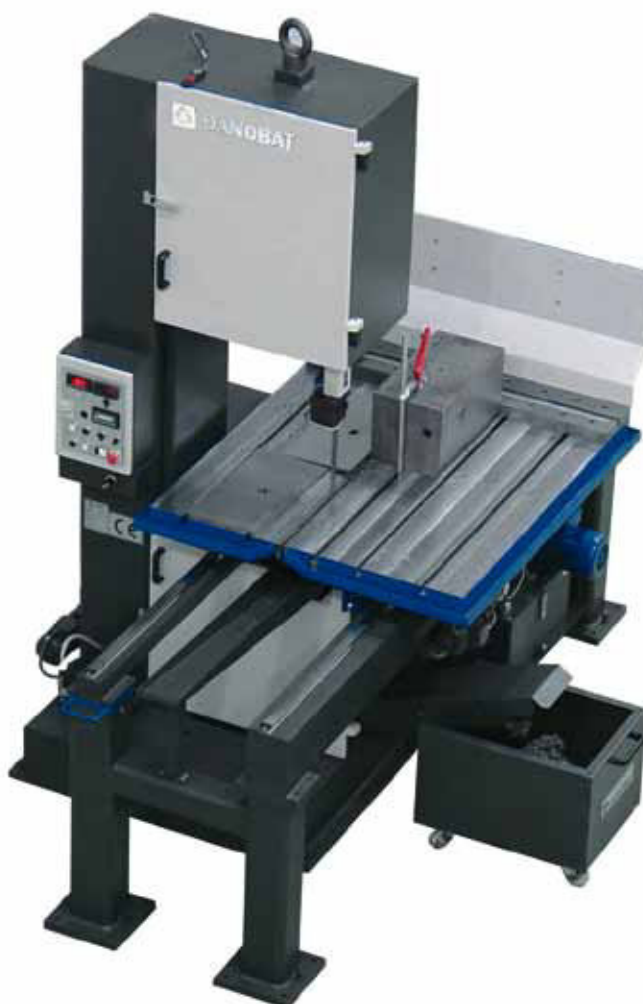
Available for VP and VL ranges.



# VP

## Reliability for pieces up to 500 mm

- Saw head is filled in with concrete polymer: it provides the necessary rigidity to get high production rates.
- Milimeter rule and positioning stop system to make the manipulation of the pieces easier.
- Robust table and calculated to support different density materials, designed with T-slots for an easy securing of work pieces.
- Due to the design of the table, it is easy to load any piece.
- Efficient and reliable cut: the machine is equipped with table movement speed control, so the technician can adapt the cutting speed at any time in order to optimize the performance of the machine.



| CHARACTERISTICS                       |              | VP<br>50.50.120                          | VP<br>50.50.210 |
|---------------------------------------|--------------|--|-----------------|
| Maximum capacity<br>(height x throat) | mm<br>inch   | 500 x 500<br>20 x 20                     |                 |
| Table length                          | mm<br>inch   | 1200<br>47                               | 2100<br>82      |
| Blade dimensions                      | mm<br>inch   | 5265 x 41 x 1,3<br>207.28 x 1.61 x 0.051 |                 |
| Main motor power                      | kW<br>Hp     | 5,5<br>7.5                               |                 |
| Blade speed                           | m/min<br>ppm | 16 - 140<br>53 - 462                     |                 |
| Maximum weight                        | kg<br>lb     | 5000<br>10300                            | 8000<br>17600   |

## OTHER SAWING AND DRILLING SOLUTIONS



- ▶ Horizontal bandsaws



- ▶ Mitre bandsaws



- ▶ 3D plasma cutting



- ▶ Drilling units



- ▶ Thermal cutting and drilling



MORE INFORMATION ABOUT DANOBAT  
VERTICAL CUTTING SOLUTIONS

[www.danobatgroup.com](http://www.danobatgroup.com)

If your mobile phone has the QR code Reader tool you will be able to go directly to our site at [www.danobat.com](http://www.danobat.com)

**DANOBATGROUP**

**DANOBAT**  
Arriaga kalea, 21  
E-20870 ELGOIBAR (Gipuzkoa) Spain

Tel.: + 34 943 74 81 50  
Fax: + 34 943 74 81 82  
[salewsaws@danobat.com](mailto:salewsaws@danobat.com)  
[www.danobatgroup.com](http://www.danobatgroup.com)

