Workline
Manual / Semiautomatic / Automatic

BOMAR, spol. s r.o.
Těžební 1236/1
627 00, Brno
Česká Republika

Tel. + 420 533 426 100
info@bomar.cz

www.bomar.cz
Workline manual

A gravity bandsaw, designed for double-sided mitre cuts and for cutting material up to 350 mm in diameter, provides high quality at an affordable price. The excellent cutting power results coming from these features: a hard-metal band precision guide, an arm joint laid in slide bearings, a 27 mm (34 mm) high saw band, and a synchronous running brush for chips disposal.

The work cycle starts with manual lifting of the arm to the required position and setting the angle for mitre cuts. Thanks to a large angle scale located within the operator’s field of vision it is easy to set the required angle precisely. The material is inserted and clamped. An innovated vice allows the material to be clamped in several ways. The saw band speed is set on the ergonomic control panel located in the front of the machine. The basic equipment of the machine includes a frequency converter that allows the band’s optimal speed to be set against the processed material within the 20-120 m/min range, this significantly increases both – the saw band lifetime and the machine productivity.

The machine is started by pressing the Start button, the arm downfeed speed is set with an overflow valve, and the cutting is performed.

When the cutting is completed, the arm remains in the lower position and the saw band turns off. The machine is intended for occasional cutting profile as well as full materials of smaller diameters in one-shift operation workshops.

Workline 410.280 DG / Technical parameters

<table>
<thead>
<tr>
<th>Working mode</th>
<th>Manual</th>
</tr>
</thead>
<tbody>
<tr>
<td>Smallest sawing diameter</td>
<td>ø 10 mm</td>
</tr>
<tr>
<td>Shortest length of cut-off piece</td>
<td>90 mm</td>
</tr>
<tr>
<td>Saw band speed</td>
<td>20 - 120 m/min</td>
</tr>
<tr>
<td>Saw band dimensions</td>
<td>3,800 x 27 (25) x 0,9 mm</td>
</tr>
<tr>
<td>Drive</td>
<td>2,2 kW, 3 x 400 V, 50 Hz</td>
</tr>
<tr>
<td>Machine dimensions</td>
<td>Length: 1,020 mm / Width: 1,148 mm / Height: 1,427 mm / Weight: 530 kg</td>
</tr>
</tbody>
</table>

Workline 510.350 DG / Technical parameters

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<tr>
<td>Saw band speed</td>
<td>20 - 120 m/min</td>
</tr>
<tr>
<td>Saw band dimensions</td>
<td>4,780 x 34 (32) x 1,1 mm</td>
</tr>
<tr>
<td>Drive</td>
<td>3 kW, 3 x 400 V, 50 Hz</td>
</tr>
<tr>
<td>Machine dimensions</td>
<td>Length: 1,070 mm / Width: 2,148 mm / Height: 1,450 mm / Weight: 685 kg</td>
</tr>
</tbody>
</table>
Innovative accessories / selection

**Micro-spray-system**
For ideal cutting of pipes and profiles, the micro-spray unit applies a grease film on the tooth points and lateral sides of the saw band.

**Laser liner**
The laser unit copies the exact line in the saw band axis to the material. Laser liner allows precise adjustment of the marked material.

**Tenzomat**
A precise measuring tool for the control of the saw band tension when a new band is installed.

**Additional coolant inflow**
The additional coolant inflow is used for extra wide materials. If there is a need to get more coolant during the cut.

**Pistol for machine cleaning**
Tool for fast and easy cleaning of the machine from chips and burrs.

**Workspace lighting**
A lamp for lighting the workspace, adjustable and mounted on the flexible arm.

**Saw band tension indicator**
The saw band tension indicator provides permanent control of the band tension, even during the machine operation.

**Digital angle indicator**
Providing an accurate reading of the arm angles position on well readable digital display.

**System T / material conveyors**
With the bearing capacity up to 600 kg/m and a wide range of accessories and connection pieces to BOMAR band saws, the T system is an ideal partner for handling materials in your workshop. Thanks to the default lengths of 2 and 3 m, the roller tracks may be flexibly adjusted to any environment.

**Measuring stops System T**
Next to the wide program for roller conveyors inclusive accessories the System T offers measuring stops in various designs. Their operation is from manual to CNC control.

**Sample assembly**
Workline 410.280 DG
Conveyor T440 with steel rollers
Connection part T440 light
Connection part T440 left
TRA Manual material length stop with digital display

**Accessories, material conveyors**
Workline DG band saw is supplied with unmodulated equipment. With intelligent optional equipment and accessories, the machine may be adapted precisely to individual requirements. With a wide range of accessories and connection pieces to BOMAR band saws, the handling "T" System is an ideal partner for handling material in your workshop. For handling heavier materials the X series conveyors may be used. Thanks to their default length, roller tracks may be flexibly adjusted to any environment.
Workline semiautomatic

This semiautomatic bandsaws, designed for double-sided mitre cuts and for cutting material up to 450 mm in diameter, provides high quality at an affordable price. The excellent cutting power results coming from these features: a hardmetal band precision guide, an arm joint laid in slide bearings, solid saw band, and a synchronous running brush for chips disposal. Material clamping and arm downfeed are controlled hydraulically, material feed is controlled manually. The whole work cycle is completed at the press of the Start button: the material is clamped, the saw band starts up, cutting is carried out, the arm is raised to the default position, and the vice is opened. After switching the machine to the manual mode, all functions may be controlled separately. Thanks to a large angle scale located within the operator’s field of vision it is easy to set the required angle precisely. The saw band speed is set on the ergonomic control panel located in the front of the machine. The basic equipment of the machine includes a frequency converter that allows the band’s optimal speed to be set against the processed material within the 20-120 m/min range; this significantly increases both the saw band lifetime and the machine productivity. Standard equipment of Workline semiautomatic machines includes automatic downfeed pressure regulation dependent on the resistance of the processed material.

Equipment as an argument

- Continuous both-sided mitre cuts up to 60°
- A large, easy-to-read angular scale on the front side of the machine by the mitre cuts clamping lever
- A full-stroke hydraulic vice with a tightening system
- An easily movable clamping vice for mitre cuts
- A large hydraulic unit
- Brushes for removing chips, synchronous with the band speed
- A simple, easy-to-read control panel
- Electronic control of the band tensioning and rupture

The incredible clamping device for mitre cuts – with double laying – can be moved easily.

The ADFR system regulates automatically and in real time the coordination of the cutting pressure and downfeeding.

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Workline 410.280 DGH

Working mode semiautomatic
Smallest sawing diameter ø 10 mm
Length of cut-off piece 60 mm
Saw band dimensions 3 800 x 27 (25) x 0,9 mm
Drive 2,2 kW, 3 x 400 V, 50 Hz
Saw band speed 20 - 120 m/min
Machine dimensions Length - 1 070 mm / Width - 2 148 mm / Height - 1 428 mm / Weight - 570 kg

Workline 610.450 DGH

Working mode semiautomatic
Smallest sawing diameter ø 10 mm
Length of cut-off piece 60 mm
Saw band dimensions 5 200 x 34 x 1,1 mm
Drive 3 kW, 3 x 400 V, 50 Hz
Saw band speed 20 - 120 m/min
Machine dimensions Length - 1 443 mm / Width - 2 781 mm / Height - 1 564 mm / Weight - 800 kg

Workline 510.350 DGH

Working mode semiautomatic
Smallest sawing diameter ø 10 mm
Length of cut-off piece 60 mm
Saw band dimensions 4 780 x 34 (32) x 1,1 mm
Drive 3 kW, 3 x 400 V, 50 Hz
Saw band speed 20 - 120 m/min
Machine dimensions Length - 1 070 mm / Width - 2 568 mm / Height - 1 500 mm / Weight - 710 kg
Accessories, material conveyors

Workline DGH bandsaw is supplied with unrivalled equipment. With intelligent optional equipment and accessories, the machine may be adapted precisely to individual requirements. With a wide range of accessories and connection pieces to BOMAR band saws, the handling “T” System is an ideal partner for handling material in your workshop. For handling heavier materials the X series conveyors may be used. Thanks to their default length, roller tracks may be flexibly adjusted to any environment.

Innovative accessories / selection

- **Micro-spray-system**
  For ideal cutting of pipes and profiles, the micro-spray unit applies a grease film on the tooth points and lateral sides of the saw band.

- **Laser liner**
  The laser unit copies the exact line in the saw band axis to the material. Laser Liner allows precise adjustment of the marked material.

- **Tenzomat**
  A precise measuring tool for the control of the saw band tension when a new band is installed.

- **Additional coolant inflow**
  The additional coolant inflow is used for extra wide materials. If there is a need to get more coolant during the cut.

- **Workspace lighting**
  A lamp for lighting the workspace, adjustable and mounted on the flexible arm.

- **Saw band tension indicator**
  The saw band tension indicator provides permanent control of the band tension, even during the machine operation.

- **Vice pressure regulation**
  The pressure regulation of both cylinders is centrally preset, firstly to be avoided by thin-walled pipes and profiles.

- **Digital angle indicator**
  Providing an accurate reading of the arm angles position on well readable digital display.

- **Micro-spray-system**
  For ideal cutting of pipes and profiles, the micro-spray unit applies a grease film on the tooth points and lateral sides of the saw band.

**System T / material conveyors**

With the bearing capacity up to 600 kg/m and a wide range of accessories and connection parts for BOMAR band saws, the T system is an ideal partner for handling materials in your workshop. Thanks to the default lengths of 2 and 3 m, the roller tracks may be flexibly adjusted to any environment.

**System X / material conveyors feeding heavy material**

Highly flexible handling solutions for heavy feed. Thanks to the unique profile system can be the System X roller conveyors individually adjusted to customer wishes any time, the load bearing increases or if you like the roller distances changes. The accessories and bodywork parts high volume program integrates the System X spectrum.
Workline automatic

This automatic bandsaw is a maximally flexible machine suitable for small-quantity production. It is designed for performing single-sided mitre cuts up to 60° in the semiautomatic mode, and for cutting material up to 350 mm in diameter in the automatic mode. It provides high quality at an affordable price. The excellent cutting power results from these features: a hardmetal band precision guide, an arm joint laid in slide bearings, a 34 mm high saw band, and a synchronous running brush for chips disposal. Material clamping and arm downfeed are performed by hydraulic full-stroke vices. Material feed is controlled hydraulically, too.

Workline automatic machines are enclosed with a safety grid. When performing mitre cuts, the rear cover shall be open, preventing the performance of the automatic cycle.

The whole cutting cycle is controlled with a simple dialogue system on an LCD panel. After switching the machine to the semiautomatic mode, all functions are controlled with a membrane keyboard. Thanks to a large angle scale located within the operator’s field of vision it is easy to set the required angle precisely. The saw band speed is set on the ergonomically designed control panel connected to the machine with flexible hoses. The basic equipment of the machine includes a frequency converter that allows the band’s optimal speed to be set against the processed material within the 20-120 m/min range; this significantly increases both the saw band lifetime and the machine productivity. Standard equipment of Workline automatic machines includes automatic downfeed pressure regulation dependent on the resistance of the processed material.

The main vice of Workline automatic machines are equipped with an innovated clamping system – offering comfortable operation with a full-stroke cylinder and stable support of material in the clamping vice.

Equipment as an argument

- Feeding length 600 mm at a simple stroke, total feeding up to 9,999 mm
- New main vise fitted with a tightening system for full fitting of workpieces and the best material clamping
- Full-stroke cylinder for the feeding and main vices
- Continuous regulation of the band speed with a frequency converter within the 20-120 m/min range
- Automatic pressure regulation during cutting – according to the material shape and quality
- Brushes for removing swarf, synchronous with the band speed
- Control system with a large display and foil keyboard
- Movable control panel with all control elements located on the front side of the machine

Technical parameters

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<td>Brushes</td>
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<td>Control system</td>
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With the bearing capacity up to 600 kg/m and a wide range of accessories and connection parts for BOMAR band saws, the handling “T” System is an ideal partner for handling material in your workshop. For handling heavier materials the X series conveyors may be used. Thanks to their default length, roller tracks may be flexibly adjusted to any environment.

For more information about the machine and the possibility of extending it, please contact our sales department.