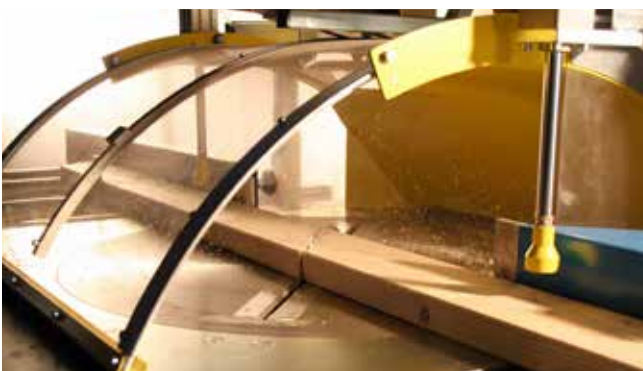


Cut Saw **SP720**



Saws with angled and inclined cuts

Randek's SP720 series provides reliable cut saws that are a major asset to roof truss and house producers around the world.

The SP720 cut saw is effective, easy-to-use and accurate. It has been on the market for a long time and is continuously improved in close contact with our many customers. The blade on this semi-automatic saw supports both angled as well as inclined cuts, which mean it can make any cuts you may require. You can also use the large diameter blade to cut several sections of stacked timber simultaneously.

- **Angled cuts from 0° to 360° and inclined cuts from 90° to 28°**
- **Cut heights up to 260 mm, possible to cut three boards each cutting cycle**
- **Computer controlled, resulting in fast adjustment**
- **Fixation of timber near the cutting area resulting in accurate cutting**



SPL728 with outfeed bench and lift table



Timber picker with additional roller conveyor system



Stacker ready to place a layer onto the lift table

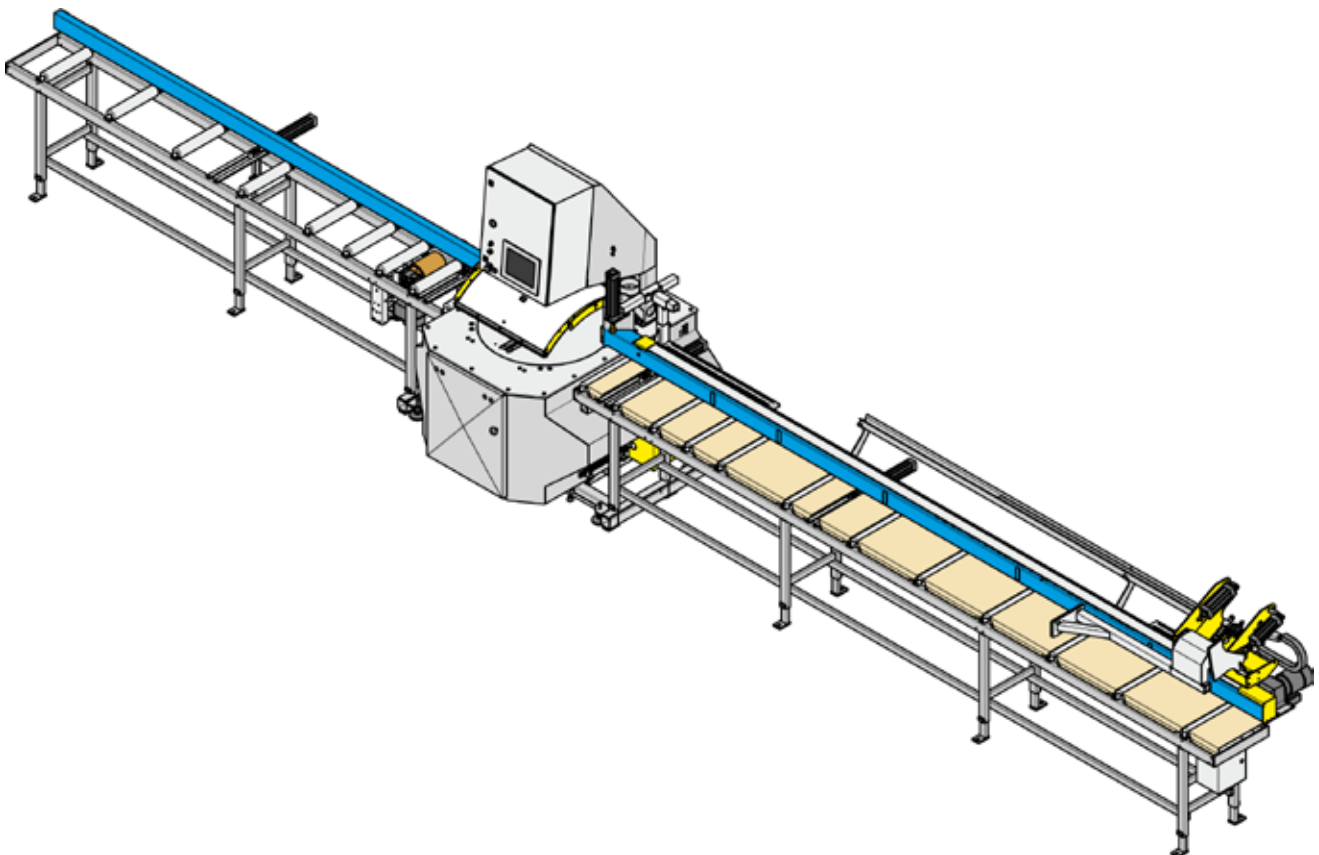


Board is ready to be slid or flipped down to the infeed bench.

Customize the saw to your needs

The SP720 is extremely versatile as it can be connected to machines such as stackers, pickers, splicing presses and milling machines. Randek has an extensive range of peripheral equipment, which means that the saws can be specially configured to meet your particular needs.

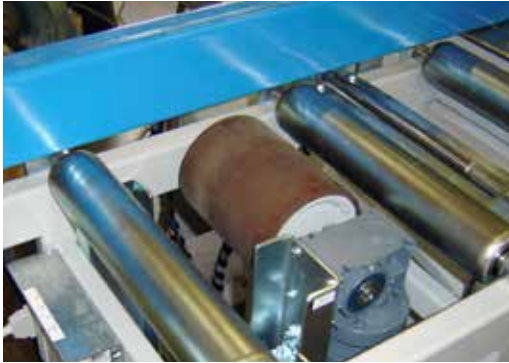
- Available in left to right or right to left wood feeding direction
- Available with or without inclined cuts (SPL728 or SP722)
- Infeed benches from 4-11 meters
- Outfeed benches from 6-13 meters
- Different stacking methods
- Timber picker from one or multiple timber packages
- Printers, Milling machines, Drilling units, Splicing presses etc.
- Customized roller conveyors for your facilities



Example of a common version of the SPL728 cut saw.

Infeed bench

The SP720 infeed benches comes in different lengths with standard equipment. The bench consists of non driven 400 mm rollers and a separate timber feeder along with retracting devices and plungers.



The retracting devices fix and press the timber against the back fence and straighten the board to secure a precise cut. The retracting device is operated automatically and is activated when making a cut in the timber.

The plunger holds down the timber to the saw table. It is operated as the retracting device, automatically when cutting the timber.

The plunger and retracting device is designed to fixate the timber near the cutting point resulting in a very high accuracy, the most accurate cut saw on the market according to our customers.

The transport of the timber is done with the Timber feeder which transports the timber along the infeed and outfeed benches to the proper position. The Timber feeder is operated manually with a push button.

Article Number (Left ->Right)	Article Number (Right -> Left)	Length	Timber feeder
109448AE	109448AA	4000 mm	Yes
109448AF	109448AB	5800 mm	Yes
109448AG	109448AC	8200 mm	Yes
109448AH	109448AD	10600 mm	Yes



Technical Description

Roller diameter	76 mm
Roller length	400 mm
Timber feeder roller diameter	155 mm
Timber feeder speed	44 m/min
<i>Air and electrical supply from the saw.</i>	

Infeed bench with splicing press

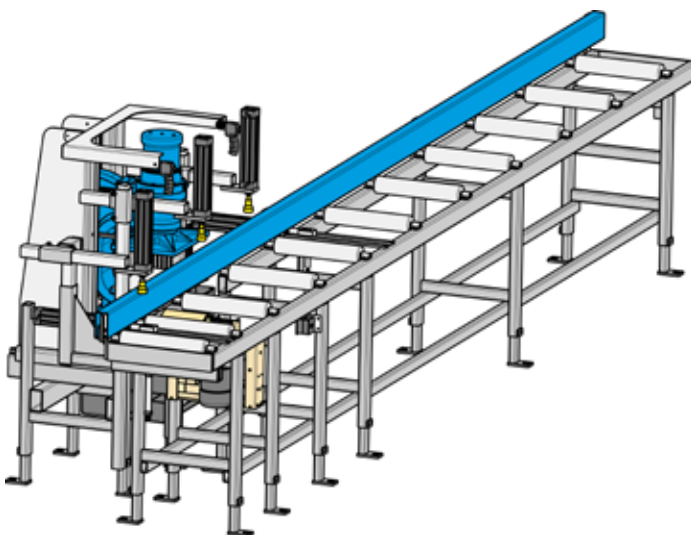
Splicing press SKARV 35 is used for nail plate splicing of timber directly on the infeed bench of the saw. It enables an efficient production with a minimum of waste as you can splice the timber together to an infinite length before cutting.



The press force is 35 tonne and the bench is equipped with plungers and retracting devices to ensure timber alignment when splicing.

The press is operated manually with two hand pistol grip activation.

Article Number (Left ->Right)	Article Number (Right -> Left)	Infeed bench equipped with	Length	Timber feeder
109448AP	109448AL	Splicing press 35 tonne	4000 mm	Yes
109448AM	109448AI	Splicing press 35 tonne	5800 mm	Yes
109448AN	109448AJ	Splicing press 35 tonne	8200 mm	Yes
109448AO	109448AK	Splicing press 35 tonne	10600 mm	Yes

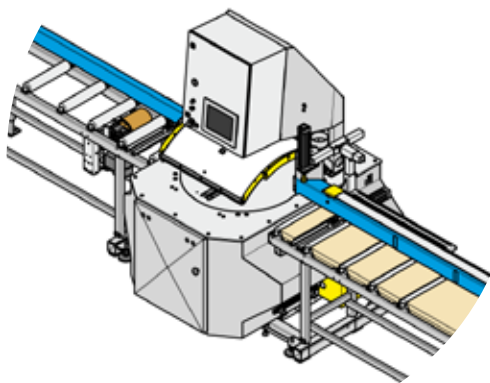


Technical Description	Minimum	Maximum
Roller diameter	76 mm	
Roller length	400 mm	
Timber feeder roller diameter	155 mm	
Timber feeder speed	44 m/min	
Nail plate length	-	420 mm
Nail plate width	-	300 mm
Timber thickness	45 mm*	130 mm
Hydraulic pressure	227 bar (35 tonne)	
Electrical supply	3x400 VAC +N+PE 20A 50 Hz	
* Minimum timber thickness can be reduced with a spacer plate. Air supply from the saw.		

Saw unit

The saw units are delivered in two main models: SP722 and SPL728. The main difference is the possible cut types. The SP722 have the capability to turn the blade between 0-180° while the SPL728 can turn from 0-360° and slant the blade between 90-28°.

The saws are equipped with a protective saw blade cover which is automatically activated and lowered when the operator makes his cuts. The touch screen is placed conveniently in front of the operator for easy access and possibility to view and change the work process.



Art.No. (SPL728)	Art.No. (SP722)	Electrical cabinet equipment				
		printer	Lbl. feeder	Timber picker	Stacker	Pneumatic pusher
113738AA	114419AA		1 pcs			
113738AB	114419AB		2 pcs			
113738AC	114419AC		2 pcs	✓		
113738AD	114419AD		3 pcs	✓		
113738AE	114419AE		2 pcs		✓	
113738AF	114419AF		3 pcs	✓	✓	
113738AG	114419AG		2 pcs			✓
113738AH	114419AH		3 pcs	✓		✓
113738AI	114419AI	✓	1 pcs			
113738AJ	114419AJ	✓	2 pcs			
113738AK	114419AK	✓	2 pcs	✓		
113738AL	114419AL	✓	3 pcs	✓		
113738AM	114419AM	✓	2 pcs		✓	
113738AN	114419AN	✓	3 pcs	✓	✓	
113738AO	114419AO	✓	2 pcs			✓
113738AP	114419AP	✓	3 pcs	✓		✓

Technical Description	SP722	SPL728
Angular cuts	0° – 180°	0° – 360°
Inclined cuts	–	90° – 28°
Center line adjustment	0 – 250 mm	0 – 250 mm
Saw blade	700 mm	700 mm
Saw motor	5,5 kW	7,5 kW
Electrical supply	3x400 VAC +N+PE 35A 50 Hz	
Air supply	7 bar ≈ 500 NL/min	
Dust exhaust - Air speed	30 m/sec	

Examples of possible cuts for each saw model

SP722 SPL728	SP722 SPL728	SPL728	SPL728	SPL728

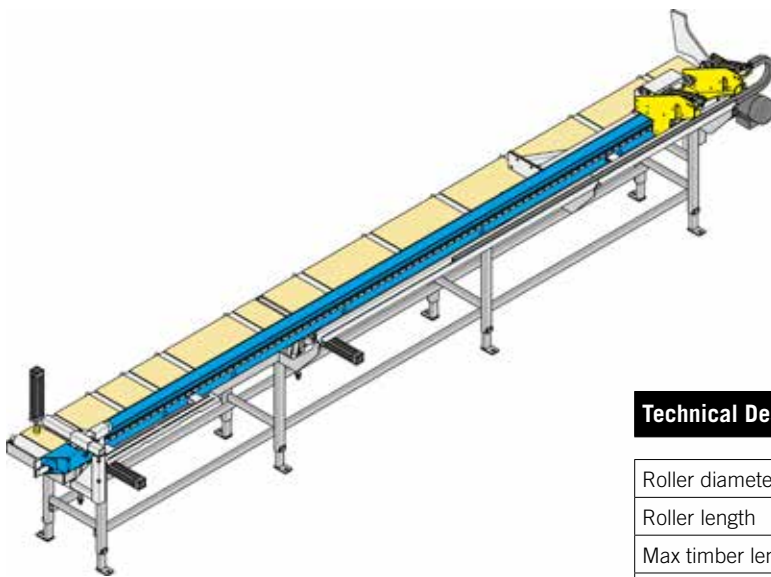
Outfeed bench

SP720 Outfeed benches are equipped with Randek LX length stop. The stop positions itself according to the timber which is to be processed. The stop can position itself to cut pieces down to 50 mm and up to the complete length of the outfeed bench + 400 mm.



Just as the infeed bench, the outfeed bench is equipped with retracting devices and plungers for accurate cutting.

Article Number (Left ->Right)	Article Number (Right -> Left)	Length	Timber feeder
114101AA	114062AA	5800 mm	No
114101AB	114062AB	7000 mm	No
114101AC	114062AC	8200 mm	No
114101AD	114062AD	9400 mm	No
114101AE	114062AE	10600 mm	No
114101AF	114062AF	11800 mm	No
114101AG	114062AG	13000 mm	No



Technical Description

Roller diameter	76 mm
Roller length	400 mm
Max timber length	Bench length + 400 mm
<i>Air and electrical supply from the saw.</i>	

Outfeed bench with stacker

The stacking unit SPL-ST is an outfeed bench used for automatic stacking of timber on a hydraulically leveled table.

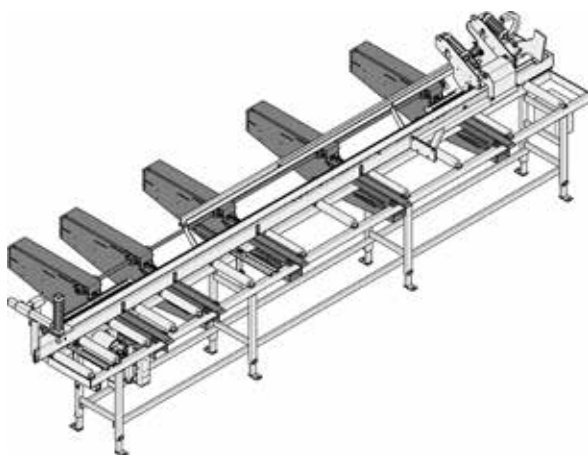


When the timber is cut, it is automatically transported forward using a timber feeder until the back end of the timber reaches a sensor. Then the timber is pushed off the bench onto swords.

The pusher will push one board after another out on the sword until one complete layer is filled. The sword will then retract and drop the layer onto the stack. The lift table will lower itself one layer down making it possible for another layer to be piled. Cassettes with pushers and swords are mounted on the back of the bench.

The complete working cycle is fully automated. The feeding device is fitted with brake and reversible movement for straight ended packs.

Article Number (Left ->Right)	Article Number (Right -> Left)	Outfeed bench equipped with	Length	Timber feeder
114101AO	114062AO	Timber stacker with lift table	5800 mm	Yes
114101AP	114062AP	Timber stacker with lift table	7000 mm	Yes
114101AQ	114062AQ	Timber stacker with lift table	8200 mm	Yes
114101AR	114062AR	Timber stacker with lift table	9400 mm	Yes
114101AS	114062AS	Timber stacker with lift table	10600 mm	Yes
114101AT	114062AT	Timber stacker with lift table	11800 mm	Yes
114101AU	114062AU	Timber stacker with lift table	13000 mm	Yes



Technical Description	Minimum	Maximum
Roller diameter		76 mm
Roller length		400 mm
Timber feeder roller diameter		155 mm
Timber feeder speed		44 m/min
Stack width	-	800 mm
Stack height	-	900 mm*
Timber length	50 mm**	Bench length + 400 mm
Electrical supply		3x400 VAC +N+PE 16A 50Hz
* When the lift table is submerged in the concrete floor		
** Minimum length for stacking function = 1200 mm		
Air supply from the saw.		

Outfeed bench with pushers

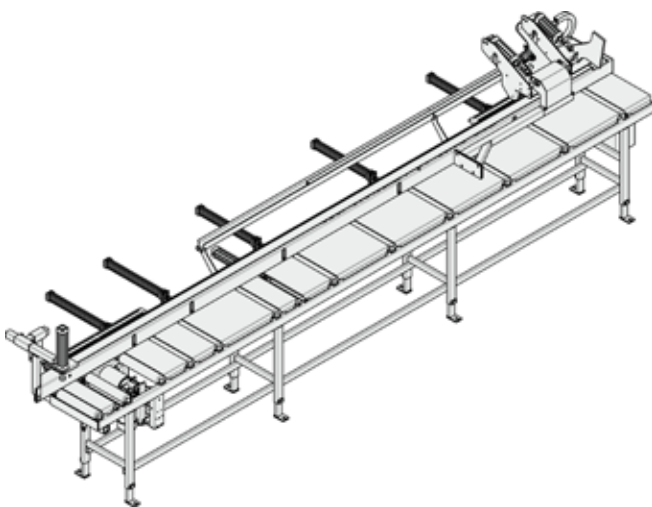
Stacking unit SPL-PU is an outfeed bench used for semi-automatic stacking of timber and only equipped with pushers.

When the timber is cut it is automatically transported forward until the back end of the timber reaches a sensor. The timber is then pushed out from the outfeed bench automatically. The pushers are mounted on the outfeed bench.

The feeding device is fitted with brake and reversible movement for straight ended packs.

This option does not include any handling of the timber outside the outfeed bench.

Article Number (Left ->Right)	Article Number (Right -> Left)	Outfeed bench equipped with	Length	Timber feeder
114101AV	114062AV	Timber pusher	5800 mm	Yes
114101AX	114062AX	Timber pusher	7000 mm	Yes
114101AY	114062AY	Timber pusher	8200 mm	Yes
114101AZ	114062AZ	Timber pusher	9400 mm	Yes
114101BA	114062BA	Timber pusher	10600 mm	Yes
114101BB	114062BB	Timber pusher	11800 mm	Yes
114101BC	114062BC	Timber pusher	13000 mm	Yes



Technical Description	Minimum	Maximum
Roller diameter		76 mm
Roller length		400 mm
Timber feeder roller diameter		155 mm
Timber feeder speed		44 m/min
Timber length	50 mm*	Bench length + 400 mm
Electrical supply		3x400 VAC +N+PE 16A 50Hz
* Minimum length for stacking function = 1200 mm Air supply from the saw.		

Timber Picker

The timber picker SPL-TP600 picks timber with two vacuum pads from one or multiple piles and places them onto the infeed bench. Positioning of the pads is made with sensors placed on the



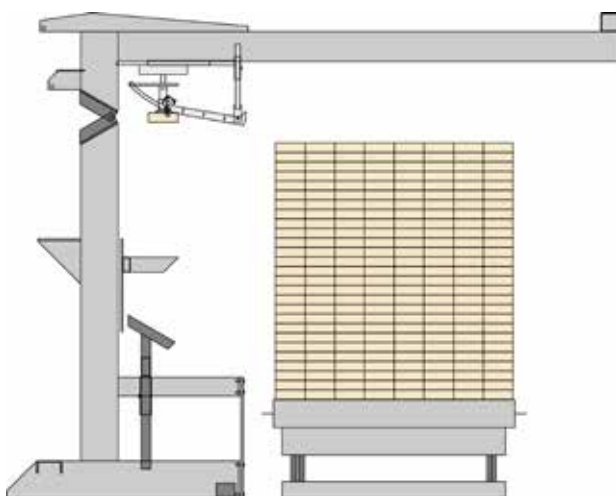
picker. The timber is placed on a elevator and lowered to the infeed bench. The operator is given the possibility to flip or slide the board down on the rollers. This option is available for roof truss producers who want to align their timber with the board's natural curve to the roof truss.

When the timber feeder drops the board on the elevator, it immediately begins to pick the next board. This gives a capacity of approximately 5 boards/minute. The timber feeder accepts different sizes and lengths of material in the pile as long as thickness is the same

through each layer of the pile.

Article Number	Timber piles	Extra timber feeder
120503AA	1	Yes

- Higher capacity in saw line
- Reduce heavy lifts for the operator
- Tilting function of the board
- One or multiple timber piles



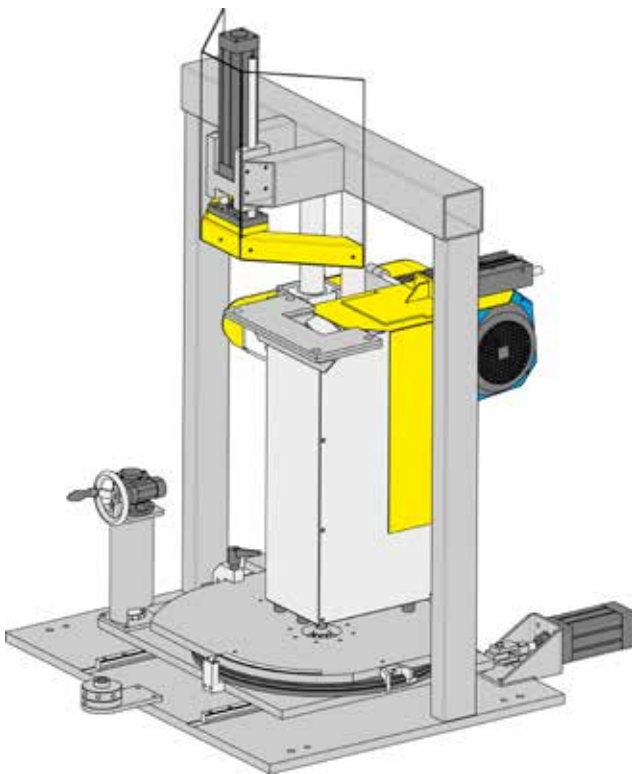
Technical Description	Minimum	Maximum
Timber Length	2700 mm	6400 mm
Timber Width	70 mm*	300 mm
Pile Height	-	1900 mm
Timber Pile Weight	-	4000 kg**
Capacity	5 items/min.	
Electrical supply	3x400 VAC +N+PE 16A 50 Hz	
Air supply	7 bar - 200 l/min.	
* The minimum timber width can be reduced to 45 mm with smaller vacuum pads		
** Lift table capacity		

Milling machine

Milling machine SPL-FVS375 is a milling machine that can be used individual or together with SPL728 and SP722 cutting saws. The milling machine can be manually adjusted between 0-45° operating angles. The depth of the cut is 120 mm and the depth movement is made manually.



Article Number	Cutter	Centre line	Angled cut
123378AA	180 mm - Ø375 mm	Manually	Manually



Technical Description	Minimum	Maximum
Cut angle	0°	45°
Cut depth	0 mm	120 mm
Cutter	180 mm - Ø375 mm	
Mill motor	7,5 kW	
Dust exhaust, airspeed	30 m/sek	
Electrical supply	3x400 VAC 35 A - 50 Hz	
<i>Air supply from the saw.</i>		

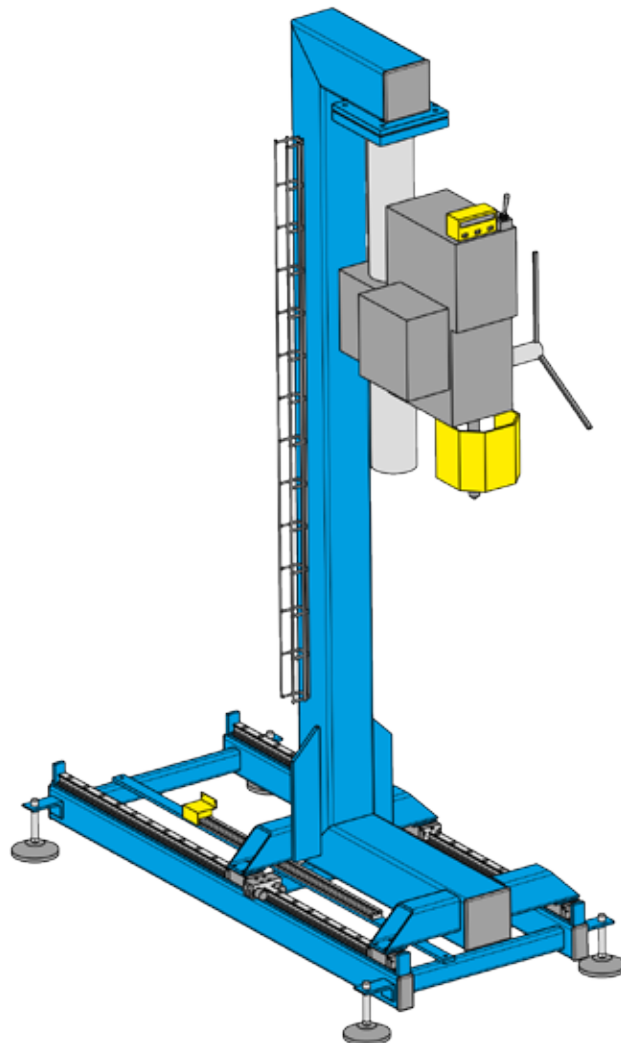
Drilling Unit

The drilling unit SPL-DU is another option for the periphery of the saws of the SP720 series. The drilling unit is installed on the outfeed bench and the length positioning of the board is done automatically by stop.

The drill position across the board is manually adjustable on the front of the bench. It is easy to change drill types.

Article Number

126224AA



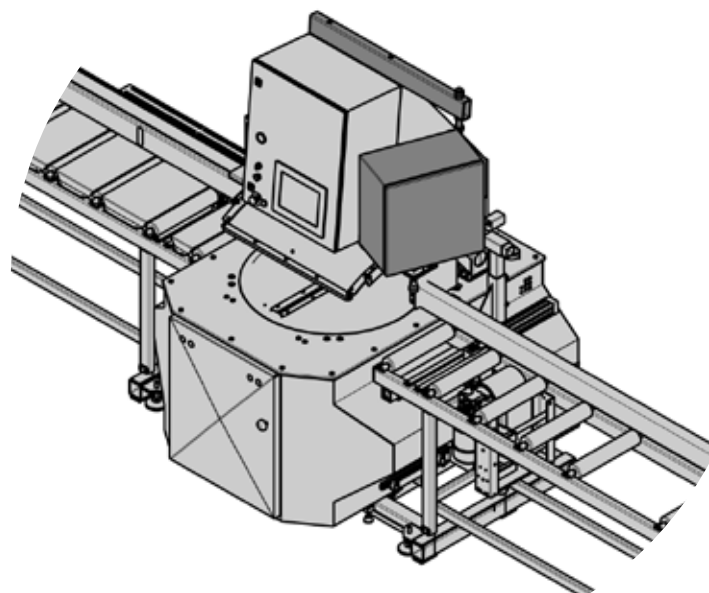
Label Printer

The printer is connected to the PLC on the saw and prints information such as name of company, name of cad file, width, length and thickness. The printer is installed in a cabinet for safe and dust free operation. The operator button is placed on the cabinet and prints on demands.



Print methods: Thermal transfer or direct thermal.

Article Number	Placement
114437AA	Right
114446AA	Left



The software

The saw is equipped with an industrial PC with a touch screen that displays automatic calculations and changes. You are able to follow the saw process and always know on what cut in which board you are.



You are able to make your own boards, or simply import complete projects from market leading house and truss dimensioning programs. All you need to do is start sawing.

Since the software is developed in windows environment, the operating system Windows XP makes it simple to integrate the saw with the corporate network, allowing for network transfer of the projects scheduled to be done.



The software is available in many different languages.



The operator can easily follow the work process on the screen.

Randek in brief

Randek develops, manufactures and markets high-performance machines and systems for prefabricated house manufacturing. The product range consist of: cut saws, wall-, floor- and roof lines, roof truss system, butterfly tables and special machines. The automation level stretches from fully automated to manual.

The company history goes back to the 1940s and began working in close cooperation with the first prefabricating house producers. Today leading house producers in 36 countries are using Randek machines and system.



Cut saws

High quality and well tested saws with different automation grades. Also specialized saws for custom applications.



Wall-, Roof- and Floor lines

Complete product program for manufacturing of walls, floors and roofs. From manual to fully automatic systems.



Roof truss systems

Adapted equipment for rational manufacturing of roof trusses. From traditional systems to fully automatic.



Butterfly tables

Flexible and well tested butterfly tables. Simple or advanced with a wide range of options.



Specialized machinery

Customized machinery developed for specific applications, Automatic stucco machine, Beam insulating machine, Roof board machine and Window frame machine.



Services

A wide range of services such as Factory Layout designs, Machine maintenance, House building systems and Financing.