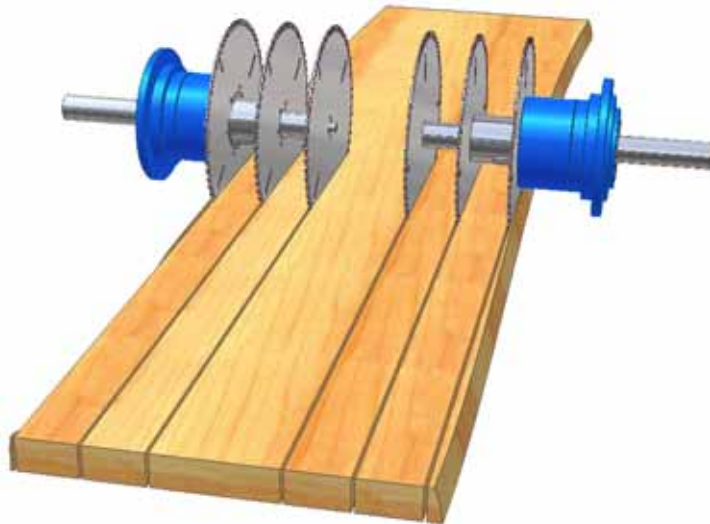




***THE CIRCULAR SAWS
BCO 800/60 - 120 - 180
For edging, multi-rip
and cant sawing***



Brødbæk & Co. A/S offers a wide range of circular saws.

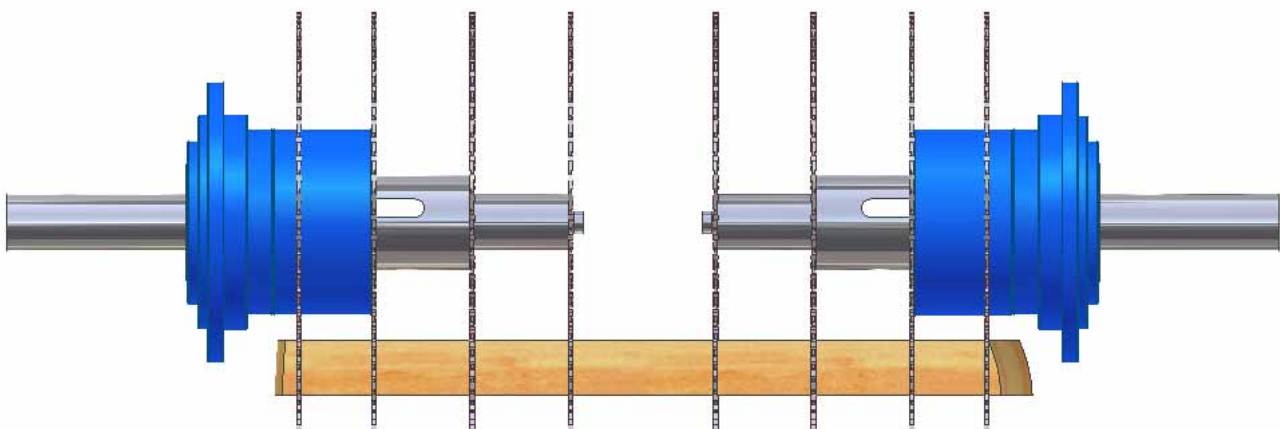
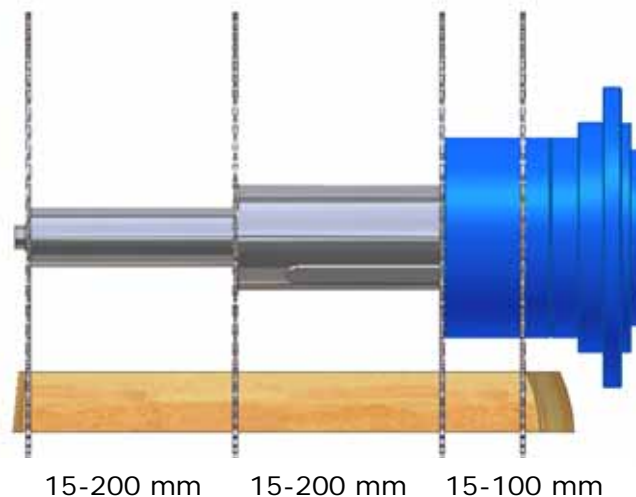
This brochure shows a few examples, but as the entire range of BCO saws is modular, all saws are adapted to match customer requirements exactly.

Our new circular saw BCO 800, versions 800/60, 800/120 and 800/180, is based on experiences we have gained from 20 years in the sawmill business.

Additionally we are pleased to highlight the following improvements:

- Increased saw feeding speed – up to 400 m/min.
- 15 to 500 mm cut between saw blades
- 800 mm passage width
- Saw operates in feeding direction
- Better service/maintenance access, especially at blade changing
- Equipped with 3 hard-chromed outfeed rollers
- Heavy-duty design, that is over-dimensioned shafts, bearings and bushings are used

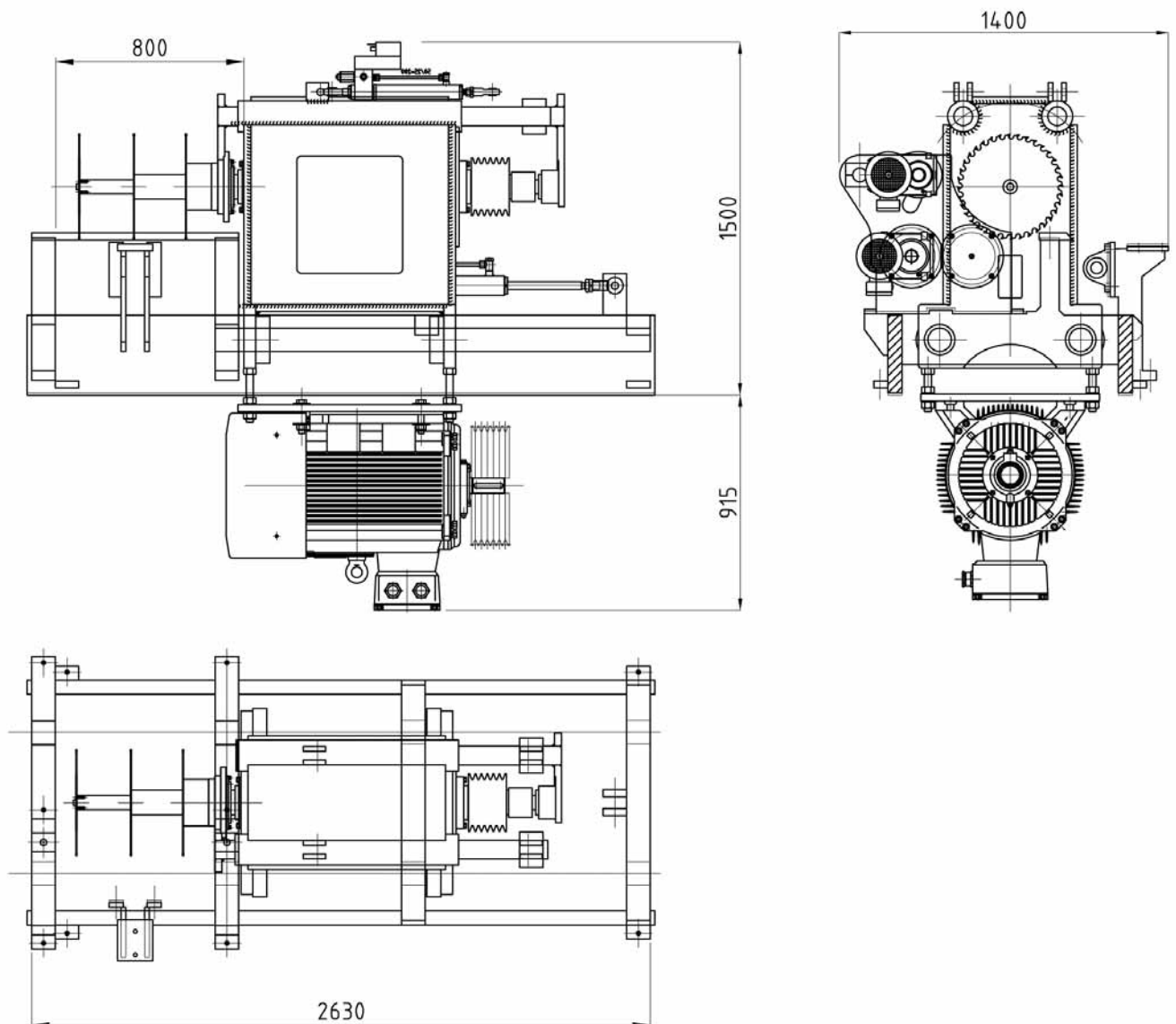
1 saw head with up to 3 movable saw blades, plus various combinations of fixed measurements



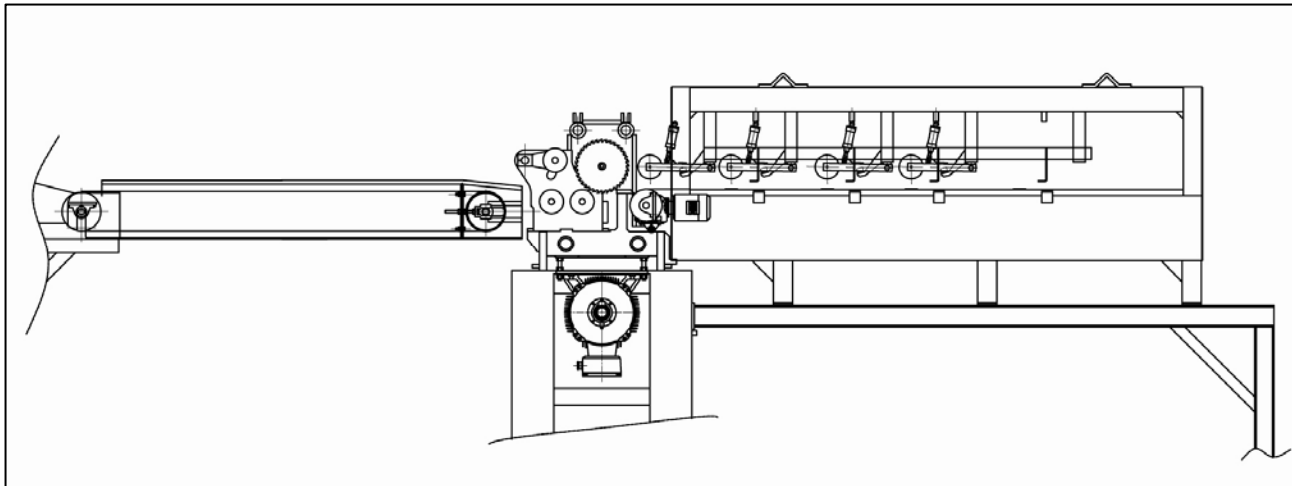
2 saw heads with up to 6 movable saw blades, plus various combinations of fixed measurements

Technical data for the new circular saws BCO 800/60-120-180

Type		60	120	180
Board length min.	m	1.25	2.0 (1.5)	2.0 (1.5)
Max. passing width	mm	800	800	800
Edging width, min.-max.	mm	15-450	15-450	15-450
Board thickness	mm	12-60	12-120	50-180
Saw blade diameter	mm	450	530	650
Saw shaft diameter, hard chromed	mm	105	105	105
Saw shaft	rpm	3400	2800	2300
Feeding speed	m/min.	30-400	30-300	30-150
Main motors, max.	kW	2 x 160	2 x 160	2 x 160
Hydraulic networks	kW	5.5	5.5	5.5
Weight with main motors	kg	5,000-9,000	5,000-9,000	5,000-9,000



Modular building of infeed and outfeed equipment secures many different solutions for saw-mill lines.



1. Advanced sit-down version using the BCO 800/60 as an edger with $\varnothing 450$ mm saw blades. It operates at a cutting depth of 12-60 mm and a feeding speed of up to 400 m/min. Dependent on board length this machinery processes up to 50 boards/min. Trimming saws can be placed at infeed of transverse conveyor.
2. Stand-up version BCO 800/120 equipped with $\varnothing 530$ mm saw blades. Cutting depth 12-120 mm and feeding speed up to 300 m/min. Dependent on board length this machinery processes up to 35 boards/min.
3. A combined version using the BCO 800/180. Equipped with $\varnothing 650$ mm saw blades cutting depth is 50 to 180 mm and feeding speed up to 150 m/min. This machinery cuts boards and cants.

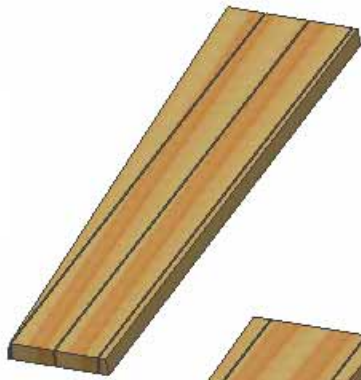
Measuring:

The lines can be equipped with various measuring equipment and optimizing software.

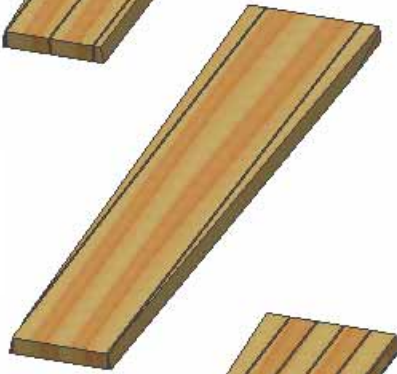
1. Full face scanning of upper side or upper and under side of timber. The laser and camera equipment are built in modules, length each 1 m, and can be combined according to required board length
2. Point laser scanning. Calculation and optimization are based on software and PC from Microtec
3. Laser and photocell measuring. Calculation and optimization are based on PLC
4. Measuring can be carried out in combination with - or overruled by – a manually made decision in accordance with cutting pattern by using a push-button or chalk marking

Dependent on measurements and cutting patterns boards/timber can be aligned for skewing, centring or for following a base line.

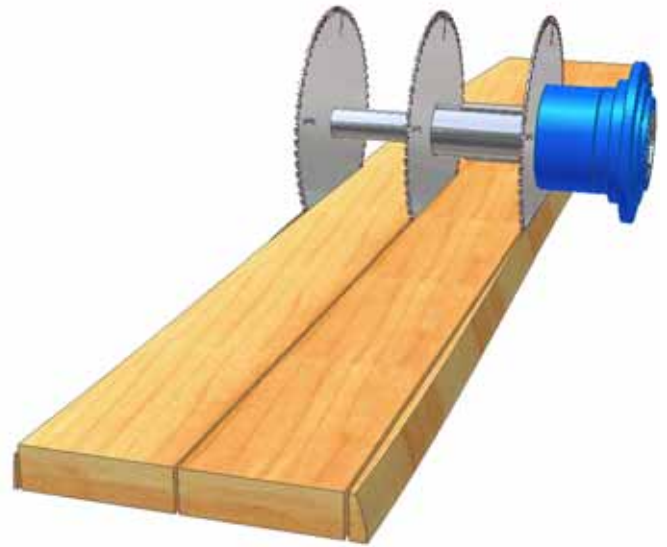
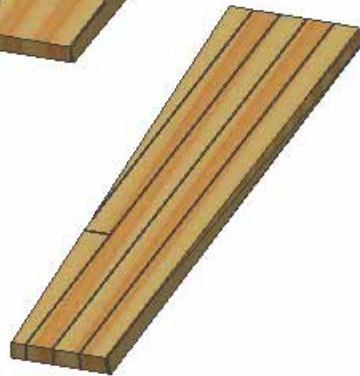
Board optimizing
by skewing



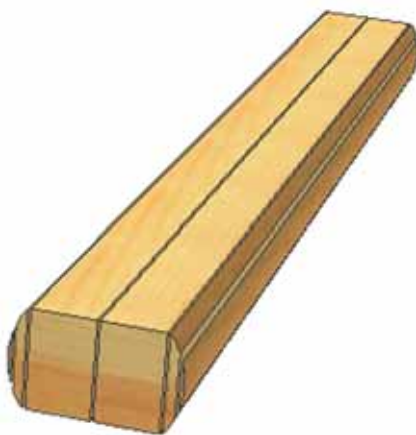
Board optimizing
by centring



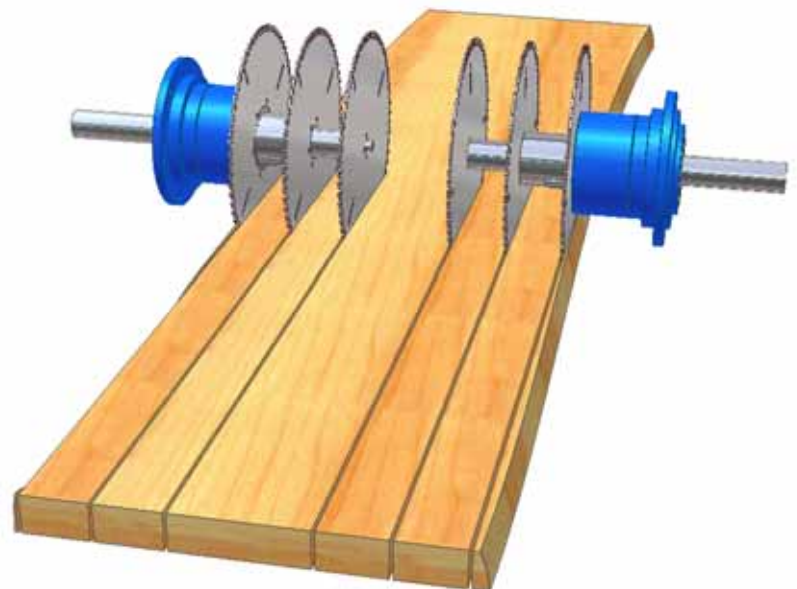
Board optimizing
by following base
line. Yield is im-
proved as the
conicity of the tim-
ber results in an
extra board



Cutting with 1 head with 3 blades giv-
ing 2 variable board measurements



Optimized centre yield and
side boards cut from a cant



Cutting with 2 heads and 6 blades giving
5 variable board measurements

Below another modular built solution based on our indeed flexible circular saw. The BCO 800/180 circular saw is mainly used for cant sawing - here shown in combination with our chipper canter BCO 500. Equipped with $\varnothing 650$ mm saw blades the cutting depth will be 50 to 180 mm, and feeding speed will be up to 150 m/min.

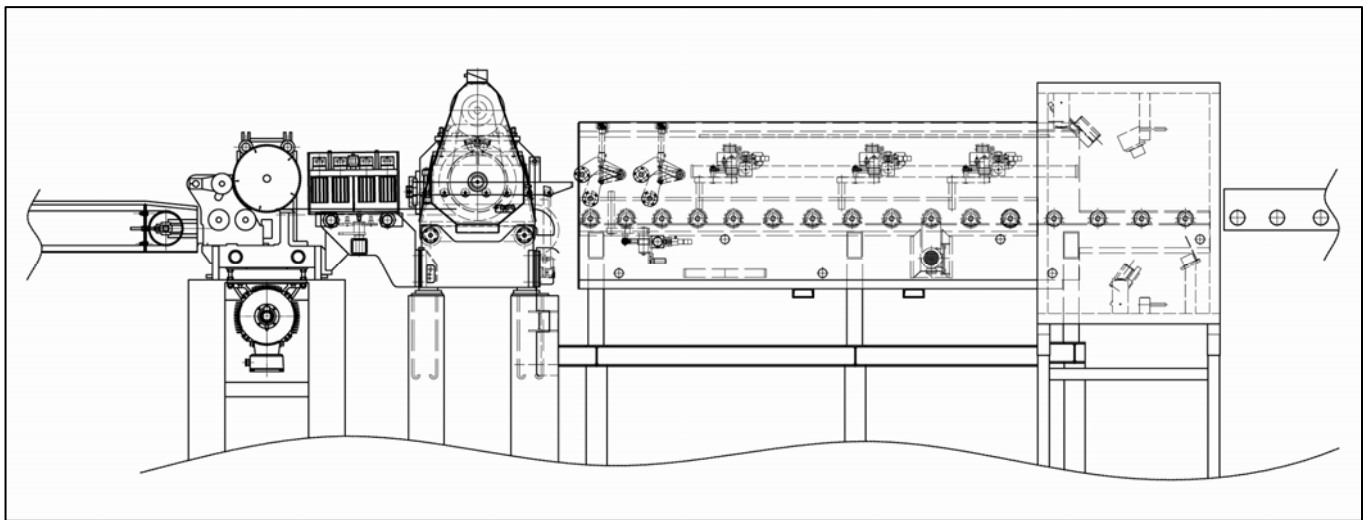
This means very flexible cutting and optimum cutting yield.

The BCO 800-series will cut the centre yield at variable measurement and the side boards in the same run.

This machinery can also be equipped with various feeding equipment and 1D or 3D measuring:

By using a mid-centred infeed combined with 1D-scanning optimization, according to top diameter, is achieved.

By using an in-feed, combined with 3D-measuring type Microtec DiShape, the cant is aligned by skewing according to measured data, and optimum cutting yield is achieved.



Optimized centre yield after chipper canter and saw

If your requirements to cutting height cannot be met by 180 mm provided by the BCO 800-series, the Brødbæk & Co. circular saw family can offer as follows:

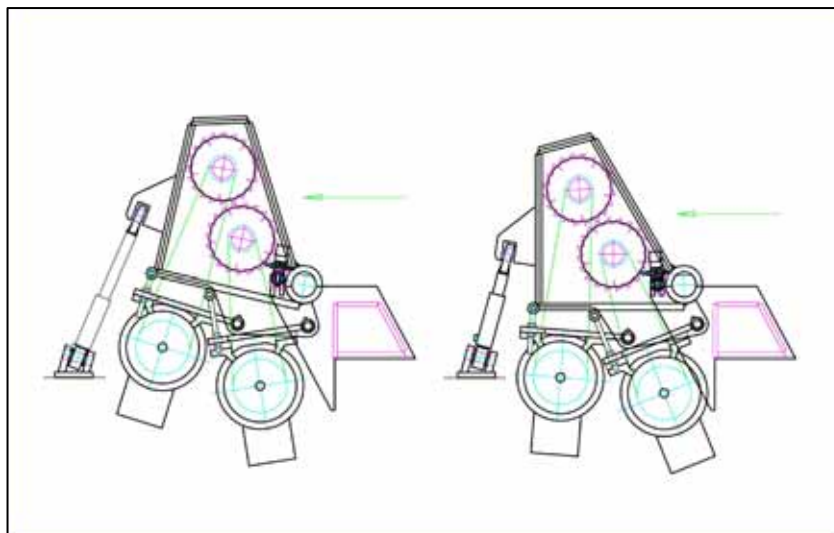
By combining the chipper canter BCO 500 or 600 with the 4 arbor saw BCO 400 or 500 series cutting heights of 275 and 375 mm respectively are obtainable.



BCO 3-400 and BCO 4-500
4 arbor multi-rip saws

The saws can be used as:

- Log taking saw
- Cant taking saw
- Multi-ripping saw



The vertical movement of the saw positions the saw blades correctly according to required cutting height. Upper and lower saw blades cut at the same depth. The saw changes vertical position to follow log taper

Technical data:		Model BCO 3-400	Model BCO 4-500
Min. log diameter	mm	100	120
Max. log diameter with cutters Ø/H	mm	350/400	500/550
Depth of cut min.	mm	60	60
Depth of cut max.	mm	275	375
Cant length min.	m	1,8	2,0
Passage width max.	mm	1000	1000
Cutting width min.	mm	18 (12)	18 (12)
Cutting width max.	mm	600	600
Saw blade diameter	mm	540	640
Saw arbor RPM	1/min	3000	2600
Drive power per saw arbor up to	kW	160	200
Feeding speed up to	m/min	100	100
Weight approx. with main motors	kg	20,000	22,000

The Brødbæk & Co. family of circular saws also includes:

BCO 1000-150/180/250 Double arbor

This saw can be used as:

- Multi-rip saw
- Cant saw



The new BCO 800/60 at work, producing up to 50 boards/min.

Detail of BCO 800/60 with the cover up



The 4 arbor saw BCO 3-400

*Brødbæk & Co. will provide a **solution** meeting your requirements!*

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