



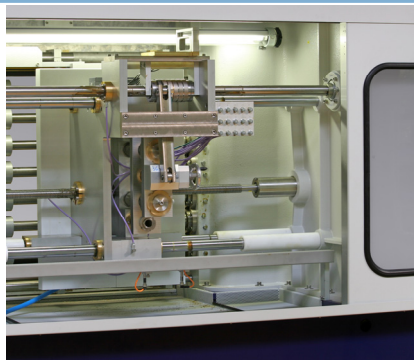
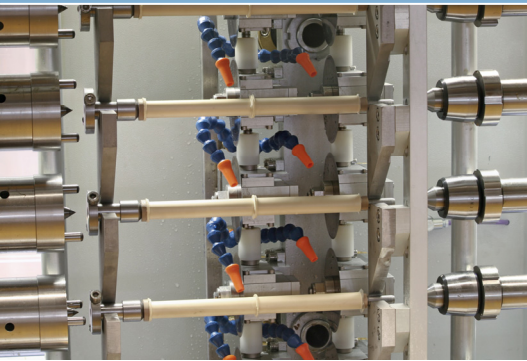
Metzner Mandrel Cutting Machines

Precision machines for cutting off rings and slices

Metzner Mandrel Cutting Machines

Cutting off on mandrels and without mandrels

Metzner



Metzner mandrel cutting machines of the SR and WA series are precision machines for cutting off rings and slices from die-cast hoses and bars made of rubber, Vulkollan and similar materials.

Cutting off on mandrel

The hoses are clamped on mandrels for machining. Flaring and deflaring is quick and easy, thanks to the special mandrel set-up. Afterwards, the mandrels are automatically clamped between the rotating tips. A cutter slide moves along the mandrels and cuts the rings off with plug-in or circular knives. This cutting method convincingly accommodates

the requirements for maximum cutting quality and high production output at the same time.

SR machines come over as being even more versatile with the use of highly modern servo technology: Cut-in and feed movements are freely programmable for the optimised cutting of materials with different material properties.

The SR series ranges from 2 to 7 string machines. Thus, Metzner offers the most efficient respective solution for various capacity requirements.

Cutting off without mandrels

If the inner diameter of a material is so small that flaring isn't possible, this material is machined with rotating rollers. In the case of the Metzner WA series, the material rotates between chequered steel rollers and is cut off by plug-in knives. Here, clamping rings prevent the hoses from wandering. The drive acts on all rollers and has "softdrive" characteristics.

Cutting surfaces of the highest quality are also generated with this cutting method. The free adjustment of the cut-in and feed movement also guarantee optimum machining results here for various material properties.

Performance	Cutting off on mandrels		Cutting off without mandrels	
	SR 85	SR 200 Century	WA 5E / 12-35	WA 3E / 35-60
Material diameter max.	170mm (6.69")	200mm (7.87")	12mm – 35mm (0.47" – 1.38")	35mm – 60mm (1.38" – 2.36")
Numbers of tubes	4 – 7	2	5	3
Tube length max.	620mm (24.41")	635mm (25.0")	500mm (19.68")	500mm (19.68")
Cutting cycle cuts / minute ¹⁾ max.	7x 100 cuts	2x 140 cuts	5x 140 cuts	3x 140 cuts
Cutting length	0,3 – 100mm (0.012" – 3.94")	0,3 – 100mm (0.012" – 3.94")	0,3 – 100mm (0.012" – 3.94")	0,3 – 100mm (0.012" – 3.94")
Length resolution	0,01mm (0.004")	0,01mm (0.004")	0,01mm (0.004")	0,01mm (0.004")
Rotation speed tube (mandrel)	600 – 3500 rpm, infinitely adjustable	600 – 3500 rpm, infinitely adjustable	—	—
Technical Data				
Dimensions (W x D x H)	2800 x 1320 x 1900mm 110.23" x 51.97" x 74.80"	2600 x 600 x 1700mm 102.36" x 23.62" x 66.93"	2600 x 600 x 1700mm 102.36" x 23.62" x 66.93"	2600 x 600 x 1700mm 102.36" x 23.62" x 66.93"
Electrical connection	3~400 V, 50/60 Hz, 25 A	3~400 V, 50/60 Hz, 25 A	3~400 V, 50/60 Hz, 25 A	3~400 V, 50/60 Hz, 25 A
Weight	2300 kg (5070 lbs)	1300 kg (2866 lbs)	1400 kg (3086 lbs)	1400 kg (3086 lbs)

¹⁾ At cutting length 2mm (0.08") | Specifications are subject to change without notice.

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