

# HEM<sup>®</sup> SAW H220HA-DC-CTS

—The saw that cuts straight.—



\*Shown w/ Optional Top Clamps

## Dual Column, Heavy-Duty, Metal-Cutting Production Band Saw

Capacity: 22" W x 22" H • Blade: 2" x 21'0" x .063"

Motor: 10 HP • Hydraulics: 10 HP • Bar-Feed: 0-24" Stroke Hydraulic Cylinder (Multiple Index)

### Swing-Away Control Console

The Control Console is located on the front of the saw, in a swing-away console, for operator convenience.



\*Shown w/ Optional Features



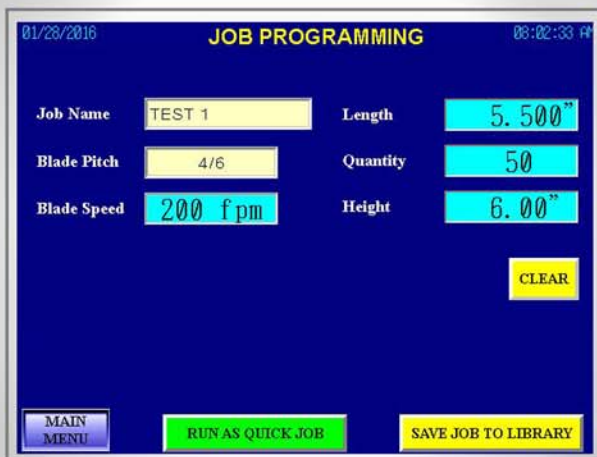


## Touch Screen Controls

The Touch Screen display provides easy-to-use menu navigation for programming and recalling automatic saved jobs, running a series of jobs, as well as manual functions and programming information required for each job. Other functions include memory storage for a job library, system information, diagnostics and saw operation parameters.

## Auto Run

The Auto Run screen controls the Computer Controlled Feed system which makes programming and running a job in automatic easy. Any pre-saved job can be entered into the Auto Run, or the operator can program a job. The quantity, length, height, width, and blade speed are then entered and transferred to the Auto Run. The information can then be saved as a job, and can be operated on the saw at any time.



## Program a Job

Jobs can be programmed into the touch screen then saved with a job number to run at any time. Up to 999 jobs can be saved. The part length, height, width, and quantity are entered for the cut, and then transferred to run automatically. Blade speed, blade type, and cutting options are also set before transferring to run automatically.



## Program a Series

A series of cuts for certain parts can be programmed, to be cut from the same bar stock, by entering up to 12 jobs that will be run in a sequence. The sequence can be run up to 99 times by placing an amount into the "Reps" section. Up to 100 program series can be created and saved in the menu.

01/28/2016 **SERIES OVERVIEW** 07:44:24 AM

	First Job												Last Job		
STEP#	1	2	3	4	5	6	7	8	9	10	11	12	Reps		
Pg Up	0	2	3	1	0	1	0	0	0	0	0	0	0	5	
	1	3	2	1	0	0	0	0	0	0	0	0	0	10	
	2	0	0	0	0	0	0	0	0	0	0	0	0	0	
	3	0	0	0	0	0	0	0	0	0	0	0	0	0	
PROGRAM#	4	0	0	0	0	0	0	0	0	0	0	0	0	0	
	5	0	0	0	0	0	0	0	0	0	0	0	0	0	
	6	0	0	0	0	0	0	0	0	0	0	0	0	0	
Pg Dwn	7	0	0	0	0	0	0	0	0	0	0	0	0	0	
	8	0	0	0	0	0	0	0	0	0	0	0	0	0	
	9	0	0	0	0	0	0	0	0	0	0	0	0	0	

MAIN MENU RUN PROGRAM DELETE PROGRAM PROGRAM SERIES BACK

01/28/2016 **MANUAL / SEMI AUTO CUT** 08:00:44 AM

FEED POSITION  
5.000"  
GO TO

ARM HEIGHT  
10.00"  
GO TO HEIGHT ENT

CUT TIME  
0: 0: 0  
Hrs : Min : Sec  
LAST

BLADE SPEED  
200  
FEET / MIN

SAW VISE OPEN

FEED VISE OPEN

SAW VISE CLOSE

FEED VISE CLOSE

CUTTING OPTIONS

SEMI-AUTO CUT

SENSITIVITY CUTWATCHER 5

MAIN MENU

PAUSE

STOP

ACCESSORY OPTIONS

## Manual Run

In Manual Run mode, the saw operator can make a single, semi-automatic cut without creating a program. The blade and various options can be controlled from this screen, or the console.

## Control Panel

The control panel allows for quick I.O. and system operation to calibrate the encoders and help diagnose a possible problem with operation of the saw.

01/28/2016 **CONTROL PANEL** 07:35:07 AM

ARM CAL / BALANCE  
Height Encoder  
24.0"  
Scaled Height Position  
QUICK CAL HEIGHT

BLADE LIFE  
(Meter hours in "cut" since last blade change)  
RESET 0: 0  
Hours : Min

TOTAL MOTOR HOURS  
0: 0  
Hours:Min

TOTAL PUMP HOURS  
0:28  
Hours:Min

HOURS TILL NEXT SERVICE  
2000  
Hours

FEED CAL  
Feed Encoder  
0.000"  
Scaled Feed Position  
Check Table Capacity Calibrate Feed Slow Speed  
Quick Cal Feed

Broken Blade  
Test  
Normal  
Disable

Out Of Stock  
Test  
Normal  
Disable

Input Status

Comms Status

BACK

ACCESSORY OPTIONS

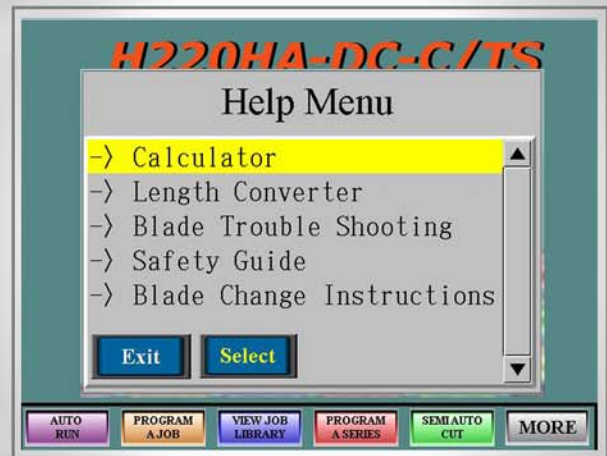


## Cut Watcher System

The patented Cut Watcher system monitors the cut for squareness to a pre-set deviation value. The system shuts down the saw when the pre-set value is exceeded. This is a must for production cutting.

## Help Files

Help files are available to assist in operating the saw. These include: a blade symptom chart, length converter, basic calculator, saw safety section, and blade change instructions.



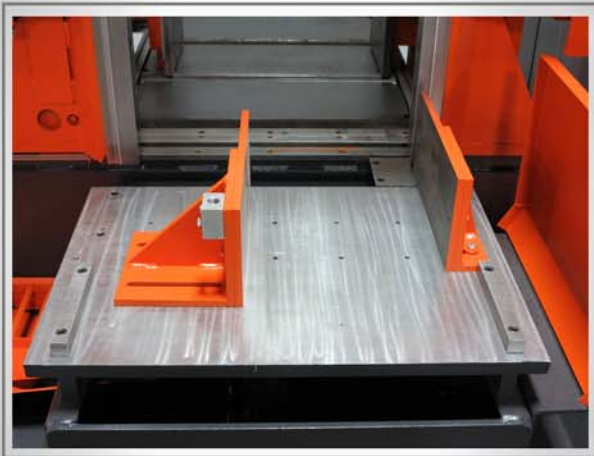
## Adjustable Feed Rate & Cut Pressure

The saw arm Feed Rate can be adjusted from zero to 3 inches per second. Cutting pressure can be adjusted for effective metal removal rates.




## Full-Stroking Main & Feed Vise

Full-Stroking Main & Feed Vise clamps material at the turn of a switch and holds the material in place to ensure accurate cuts. In automatic mode the vises open and close automatically. The clamping pressure is easily adjusted to clamp various materials. *\*Shown w/ Optional Top Clamp & Outboard Vise*



## 24" Solid Discharge Table

A standard Solid Discharge Table provides easier handling after the cut. The table is 24" in length and is fully coolant panned. 

## 0-24" Stroke Hydraulic Cylinder Bar-Feed (Multiple Index)

The Bar-Feed on the saw is comprised of an automatic floating (self-adjusting) shuttle vise feed system with a 0-24" feed stroke with multiple indexing for longer parts. This efficient system prevents binding of imperfect material. The Material Jogging feature allows the operator to inch the material forward. *\*Shown w/ Optional Top Clamp*



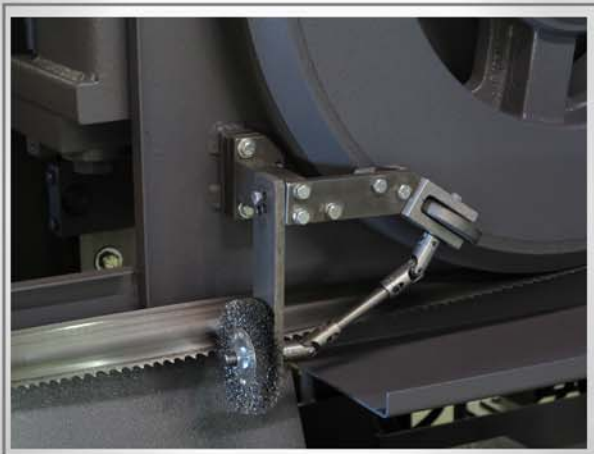
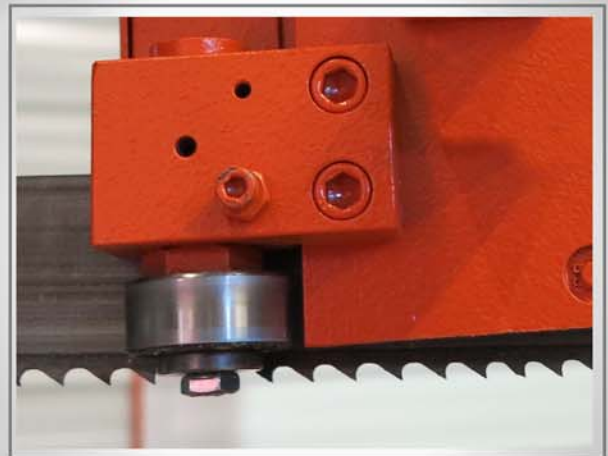


## Carbide Blade Guides

The Blade Guide System incorporates side and back blade guides that utilize carbide inserts for long wear, stability and maximum blade support.

## Lead In/Lead Out Roller Guides

In addition to precision-ground flat carbides, roller guides are also used which reduce vibration when cutting hard materials.



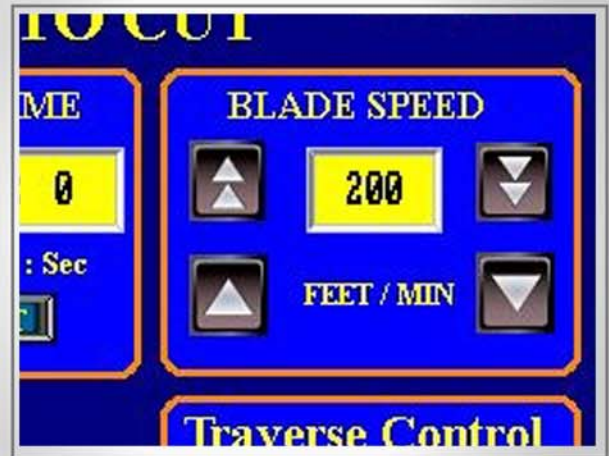
## Blade Brush

A shaft-driven Blade Brush is standard for positive removal of metal chips that lodge in the blade gullets. This system ensures a cleaner blade, more accurate cuts, and prolonged blade life.



## Adjustable Blade Speed

Blade speed can be adjusted with an infinitely variable speed drive, which allows the user to adjust blade speed's surface feet per minute which is set and adjusted from the Touch Screen.



## Powered Guide Arm

The Powered Guide Arm provides optimum blade support as material size changes. The guide arm works in conjunction with the main vise to adjust automatically while holding the blade securely, providing straighter cuts and longer blade life.

## Powered Blade Tension

The Powered Blade Tensioner maintains proper blade tension at all times during the cut, compensating for blade stretch. Changing blades on the saw is done in minutes, with the use of the Powered Blade Tensioner.





## Emergency Stop

The saw is equipped with a safety Emergency Stop cut-off switch. This allows the operator to closely monitor the cutting process and quickly stop it if needed.

## Other Safety Features

The Safety Lockout Key is used to disable saw operation during maintenance.

The saw will automatically shut off if the blade breaks or is out of stock, shown by the Broken Blade or Out-of-Stock Indicators.

The Panic Stop halts all automatic functions.



## Built-In Flood Coolant System

The saw has a totally built-in coolant system with sealed coolant pump, with coolant that is dispensed through the guides on each side of the cut.



## Chip Auger System

The Chip Auger removes chips from the cutting area into an easy-to-empty container. Chips and coolant are automatically separated into two different containers.



## Optional Computer Controlled Traverse

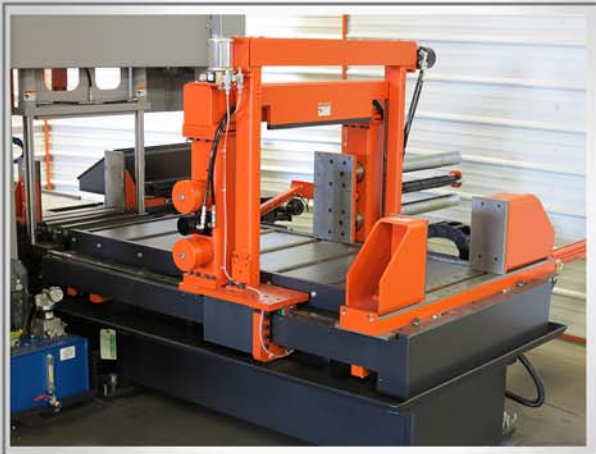
The Optional Computer Controlled Traverse, or CCT, controls the feed rate and cutting force to maintain the optimum cutting rate.

With the CCT option, a Material List is provided with the touch screen. The list includes the recommended blade speeds, cutting rates and blade pitch for the type and size of material. The data can then be transferred to a job and run automatically or manually.

## Optional 24" Roller Discharge Table

An Optional Roller Discharge Table provides easier handling after the cut. The table is 24" in length and is fully coolant panned. (In Lieu of Solid Discharge Table)





## **Optional 48" or 120" Stroke Servo Twin Ball-Screw Bar-Feed**

An Optional 0-48" or 0-120" Stroke Bar-Feed with Multiple Indexing is available.

*(Photo shown with Optional Top Clamps)*

## **Optional FC Top Clamps - Main or Feed Vise**

Full Capacity Top Clamps can be added to the Main or feed vise for vertical clamping of structural shapes and when entire "mill bundles" are to be cut. *\*Shown w/ Optional Outboard Vise & Top Clamp*



## **Optional FC Top Clamp - Outboard Vise**

A Full Capacity Top Clamp can be added to the outboard vise for vertical clamping of structural shapes and when entire "mill bundles" are to be cut. *\*Shown w/ Optional Outboard Vise*



## Optional Outboard Powered Vise

An Optional Outboard Vise on the Discharge helps with clamping of material.

*\*The Optional Roller Discharge Table comes w/ this option when ordered.*



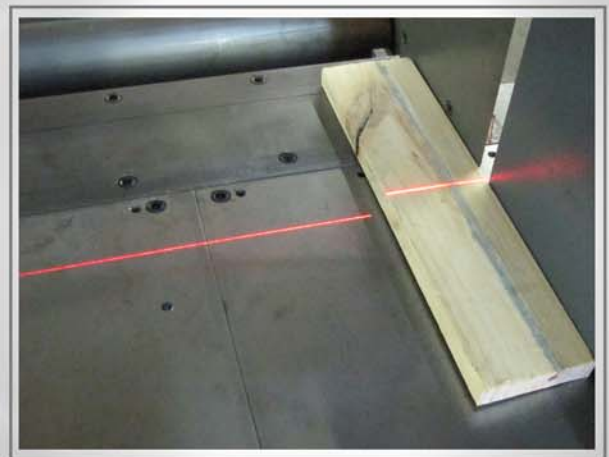
## Optional 3rd Holding Vise on Feed

An Optional 3rd Vise on the Feed helps with clamping of material.



## Optional Laser Light System

An Optional Laser Light indicates either above or below where the blade will enter the material for the cut.





## Optional Spray Mist Lubrication

The optional spray mist system lubricates the blade with a mist that is adjustable at a rate of 4 - 200 pulses per minute, pushing the mix of oil/air out of the delivery line to the nozzle.

## Optional 5' or 10' Idle Roller Stock Table

5' or 10' optional idle roller tables with 12" centers are available for material handling. The tables are non-coolant panned and height adjustable to be "trued-in" with the saw. They are designed to move even the large bars with ease and accuracy.



## Other Available Options:

Optional Consoles, Powered Roller Stock Tables





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*\*Shown w/ Optional Top Clamps & Outboard Vise*



**Band Saws • Material Handling • Metalworking Fluids  
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**Horizontal Miter**



**Vertical**



**Dual Column**



**Wide Flange**

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