



MILLING TYPE ORBITAL COLD SAW CUT-OFF

By SRET Equipment



SRET Equipment

Milling Type Orbital Cold Saw Cut Off

China's industrial pioneer and leadership, well-proven by hundreds of success installations worldwide

SRET Equipment has developed a state of the art solution for milling type orbital cold saw cut off that is able to cut heavy section tube, either round or shaped, in various grade of steel, by quick and effective cold saw process. Two tungsten carbide-tipped (TCT) blades are applied to ensure a clean cutting of the end without the need for any end facing even in a hollow section. The orbital trajectory is obtained by combining two independent axes for each blade, like in CNC milling machine, which is simple and reliable. The cutting process can be either in rectangular coordinate or in polar coordinate. The machine is totally numerically controlled and very user friendly. Once programmed it can operate without requiring the constant presences of operator at the control station.

SRET Equipment is the first company in China who developed the milling type orbital cold saw cut off, has the widest success reference installations, and now is the most trusted supplier of it in China.



Why Chose SRET Equipment?

	In-Depth Experience		Service Commitment
	Latest Technology		Cost Effectiveness
	Production Quality		Full Compliance

All SRET milling type orbital cut-off machines offer the following benefits:

Benefit Highlights	Descriptions
Lower the user's initial investment risk, while reducing the operating cost in a long run	Technology maturity ensures high stability and reliability. Thru continuous improvement in hundred of practical production processes, SRET has become the biggest supplier in China for milling type cut off, with over 70% of China's market and extensive applications for thick wall and large diameter tube. Low energy consumption, and extended saw blade lifespan up to 7 m ² /piece, guaranteeing a big saving on the saw blade cost
Suitable for various shapes and sizes of tube with minimum machine adjustment	Sophistical design and calculation of cutting parameter and trajectory accurately based on various material shape and size. One set of clamping fixtures for all sizes of square/rectangular tube, and no need to change the clamping fixtures when the product size changes, ensuring a constant top performance through the time
Easy maintenance, keep a maximum uptime and smooth production	The main commercial components have great versatility for easy spare part replacement. HMI provides real time status of operation, equipped with a remote monitoring function that enables the on-site operation status to be assessed by SRET technician from remote locations for timely troubleshooting service
Easy of use, the operating system is simple and easy to learn for operators	User friendly interface where the settings can be quickly entered and adjusted to match the change of tube specifications. full automation, expert database management to all product specifications, and automatic generating of cutting parameter, minimizing the time and risk caused by repeated operation. Communication with forming/sizing and welding sections helps realize a optimized cutting

It's All About Results – SRET Equipment understands what it takes to be successful in the tube making industry, and we're delivering proven solutions to help you drive performance.

Depending on the need of use, tube sizes, material type, material steel grade, performances required, our large selection satisfies every necessity.

Categories	Applications	Features / Customer Values	Specifications
219 Specialty Series	Square/rectangular and round tube of $\leq \Phi 219\text{mm}$; Wall thickness from 3mm-14mm; Material grade: General carbon steel, High strength steel, API, etc	Price affordability, performance reliability / Lower initial investment cost	Compact design, and economical optimum configuration, without compromising the machines performance
		Excellent speed up to 45m/min / High production throughput	Sophisticated design of traveling system
		Small diameter saw blade with high rigidity / Longer service life, reduced saw blade cost	Thanks to specially designed saw gearbox reducer with SRET's intellectual property, able to cut the same size tube with smaller diameter saw blade
		Suitable for cutting thin walled tube / No deformation with bur-free cutting surface	Small diameter and ultra-thin saw blade specially designed and produced for SRET allows for beautiful cutting of thin walled tube
Rectangular Coordinate	$\square 200\text{mm}-\square 600\text{mm}$ rectangular tube, $\Phi 165\text{mm}-\Phi 710\text{mm}$ round pipe, and open profile; Wall thickness from 3mm-20mm; Material grade: General carbon steel, High strength steel, API, etc	Excellent suitability for cutting mid- to large-sized rectangular tube / Great quality of cutting face and cutting accuracy for rectangular shape	Special design of mechanical structure combined with unique profiling cutting path calculation, requires a lowered cutting force to fillet, making it easier to cut rectangular tube
		Works on all types of forming pass lines without needs for machine adjustment: bottom line based & center line based & float-type / Super practicability, and reduced maintenance points	The profiling curves of two saw blades are generated in rectangular coordinates of X and Y movements, eliminating the requirements for mechanical adjustment
		Longer lasting blade, up to 7 m ² /piece for $\square 400$ tube cutting / Significant cost saving on saw blades	Scientific design of shorter spacing between clamping fixtures on both sides of blade makes the cutting process more stable
		Humanized design of working space / Increased convenience of operation and maintenance	Automatic shifting and resetting mechanism applied to many devices like guide rollers, clamping fixtures, etc.
Polar Coordinate	$\square 200\text{mm}-\square 600\text{mm}$ rectangular tube, $\Phi 165\text{mm}-\Phi 710\text{mm}$ round pipe; Wall thickness from 5mm-25mm; Material grade: General carbon steel, High strength steel, API, etc	Excellent suitability for cutting thick walled tube made through center line based forming / Minimum downtime, running at its full capacity	Polar coordinates of the orbital curve are determined in Φ and r dimensions providing an optimized cutting to center line based forming tube
		Simplified electric control system / Reduced failure points of control system	Circumferential feeding of double saw blades supported on one rotating disk
		Faster speed, faster by 2-3m/min on the same tube of 6m length than rectangular coordinate / High productivity	Precision gears driven by servo motor to realize blade circumferential feeding, benefitting faster and more agile speed
		Low energy consumption, low noise < 90db / Environment-friendly	Thanks to scientific structure design, lightweight traveling carriage requires lowered driving power. Great sound insulation due to enclosed-type cutting

219 Specialty Series



Rectangular Coordinate



Polar Coordinate





Technical Data Sheet

Model No.	Tube Size (mm)	Thickness (mm)	Length (m)	Tolerance (mm)	Speed (m/min)
XFJ130	Ø 60 - 130 □ 47 - 102	2.5 - 8.0	5.0 - 18.0	≤ ±2	Max. 45
XFJ165	Ø 89 - 165 □ 70 - 130	2.5 - 10.0	5.0 - 18.0	≤ ±2	Max. 45
XFJ219	Ø 114 - 219 □ 90 - 170	3.5 - 12.0	5.0 - 18.0	≤ ±2	Max. 40
XFJ273	Ø 165 - 273 □ 130 - 215	4.0 - 12.7	5.0 - 18.0	≤ ±2	Max. 38
XFJ325	Ø 165 - 325 □ 130 - 255	5.0 - 14.0	5.0 - 18.0	≤ ±2	Max. 35
XFJ406	Ø 219 - 406 □ 170 - 319	6.0 - 16.0	5.0 - 18.0	≤ ±2	Max. 35
XFJ508	Ø 219 - 508 □ 170 - 400	6.0 - 18.0	5.0 - 18.0	≤ ±2	Max. 30
XFJ630	Ø 219 - 630 □ 170 - 495	6.0 - 20.0	5.0 - 18.0	≤ ±2	Max. 30
XFJ660	Ø 325 - 660 □ 255 - 520	6.0 - 22.0	5.0 - 18.0	≤ ±2	Max. 30
XFJ711	Ø 325 - 711 □ 255 - 560	8.0 - 22.0	5.0 - 18.0	≤ ±2	Max. 25
XFJ762	Ø 325 - 762 □ 255 - 600	8.0 - 25.0	5.0 - 18.0	≤ ±2	Max. 25

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