High Production Band Saws

Sold and Supported by Pat Mooney Saws
DANOBAT’s Zone Cutting System brings CNC control to the cutting operation. This system will increase the number of parts you can produce per shift and enhance blade life. This system also allows you to standardize your cutting process, and achieve the maximum productivity and blade life, while analyzing the accuracy of each cut.

- Automatic blade break-in
- Interactive cutting deflection system
- Automatic selection of speed and feed based on material

Zone Cutting Advantages
- Minimum costs, maximum production
- Longer blade life
- High accuracy and high cutting quality
- Compatible with any blade brands
The DS 3A Horizontal Fully Automatic Band Saw Machine is designed for production sawing and providing precise, accurate cut to length parts. The machine’s heavy duty construction ensures maximum productivity, extended blade life, and faster cut times.

Other features include a fixed arm integrated into the saw head, and a movable arm by means of a linear guide. The movable arm is automatically adjusted to the width of the material and is positioned in the optimum position in relation to the moving vice. This ensures that the bandsaw blade is supported as near as possible to the material on both sides of the cut. The main round column and the secondary prismatic column are designed to accept high blade tensions. The material is clamped on both sides of the blade to reduce burrs on the cut component.

**Blade Guide System**

The DANOBAT Blade Guide Design allows for faster sawing with a higher degree of accuracy. The Large Carbide Plates and bearings are locked into position on the guide arm. Vertical guiding of the back of the saw blade is via two bearings.

There are two guide arms on the machine. One guide arm is permanently mounted to the saw head. The other guide arm will be positioned to the size of the part being cut automatically.

**Incremental Feeding Vice**

The feeding of the material by the moving vice is incremental thereby eliminating the need for the feeding vice to continuously move to the pre-set feed position. This gives faster cycle times and helps reduce wear on the machine slides.

<table>
<thead>
<tr>
<th>Model</th>
<th>Cutting Capacity Round</th>
<th>Cutting Capacity Square</th>
<th>Cutting Capacity Bundles</th>
<th>Blade Dimensions</th>
<th>Saw Motor Power</th>
<th>Blade Speed</th>
<th>Machine Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>DS 3A</td>
<td>13”</td>
<td>13” x 13”</td>
<td>13” x 8.3”</td>
<td>16’ 3” x 1-1/4” (34 mm) x .042”</td>
<td>4 HP</td>
<td>46-295 fpm</td>
<td>3792 lbs</td>
</tr>
</tbody>
</table>
Enclosed for Safe Operation

A n enclosed machine means safe operating conditions, reduced noise levels and an ergonomically positioned control panel.

iDS 4A AND iDS 5A BAND SAWS

We have conceived and designed the DANOBAT iDS band saw machine to help your business achieve higher performance in productivity, accuracy and blade life.

The iDS band saw has a very heavy duty construction that allows you to maximize the latest and future developments in band saw blade technology.

The base of the machine and the saw head are manufactured in one piece with electrowelded and stabilized steel which together with a double column design traveling on linear guides helps eliminate vibration and contributes to extremely smooth downfeed. The twin columns are also filled with polymer concrete which again help absorb vibration thereby enhancing cutting performance and blade life.

The iDS helps you in achieving and exceeding your customer’s highest expectations.

Enclosed for Safe Operation

An enclosed machine means safe operating conditions, reduced noise levels and an ergonomically positioned control panel.
Highly Accurate and Rigid Guiding Arm
Blade guidance is carried out with a combination of bearings and carbide pads. When the machine is cutting the moving guide arm is locked in position with multiple hydraulic cylinders to ensure maximum rigidity.

Incremental Feeding Vice
The feeding of the material by the moving vice is incremental thereby eliminating the need for the feeding vice to continuously move to the pre-set feed position. Results include reduced cycle time, higher productivity and longer part life.

New Fastening Clamps
Reduce scrap by 50%.

### Cutting Data

<table>
<thead>
<tr>
<th>Material Grade</th>
<th>Shape</th>
<th>Diameter</th>
<th>Wall Thickness</th>
<th>Cut Time</th>
<th>Square Inches/Minute</th>
</tr>
</thead>
<tbody>
<tr>
<td>Superduplex</td>
<td>Bar</td>
<td>11-1/8&quot;</td>
<td>N/A</td>
<td>13 min</td>
<td>36.23</td>
</tr>
<tr>
<td>Inconel</td>
<td>Bar</td>
<td>12&quot;</td>
<td>N/A</td>
<td>49 min</td>
<td>5.84</td>
</tr>
<tr>
<td>K55</td>
<td>Pipe</td>
<td>14&quot;</td>
<td>1&quot;</td>
<td>3 min, 12 sec</td>
<td>33.12</td>
</tr>
<tr>
<td>410 Stainless</td>
<td>Pipe</td>
<td>16&quot;</td>
<td>3-1/4&quot;</td>
<td>14 min, 30 sec</td>
<td>13.88</td>
</tr>
<tr>
<td>F115</td>
<td>Bar</td>
<td>36-1/4&quot;</td>
<td>N/A</td>
<td>100 min</td>
<td>26.17</td>
</tr>
</tbody>
</table>

### iDS Band Saw Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>Cutting Capacity Round</th>
<th>Cutting Capacity Square</th>
<th>Blade Dimensions</th>
<th>Saw Motor Power</th>
<th>Blade Speed</th>
<th>Machine Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>iDS 4A</td>
<td>16.5&quot;</td>
<td>16.5&quot; x 16.5&quot;</td>
<td>19' 5&quot; x 1-1/2&quot; (40 mm) x .050&quot;</td>
<td>7.5 HP</td>
<td>50-450 fpm</td>
<td>8900 lbs</td>
</tr>
<tr>
<td>iDS 5A</td>
<td>20.5&quot;</td>
<td>23.6&quot; x 20.5&quot;</td>
<td>25' 2&quot; x 2&quot; (54 mm) x .063&quot;</td>
<td>15 HP</td>
<td>60-492 fpm</td>
<td>12,125 lbs</td>
</tr>
</tbody>
</table>
The HDS Series Semi and Fully Automatic Large Capacity Band Saw Systems are robust and accurate. The HDS Series Saws are designed for high production sawing that requires precision saw cuts. The columns and saw head on the Danobat Saws are filled with polymer concrete to completely remove any vibration from the sawing cycle. This is especially important when sawing difficult to cut materials. The saw head is designed and manufactured in a unique manner. The pieces of the saw head are assembled and then placed on a machining center so all of the critical mounting are machined in a single setup; ensuring that all the mounting points for band wheels and band guides will be in exactly the same plane, and that the accuracy of the path of the saw blade is built into the construction of the saw head. The Danobat Saw Systems are designed to run either carbide or bimetal band saw blades. The saws come equipped with clamps on both sides of the saw blade and the guide arm is automatically adjusted to the material width. Once the guide arm is in position it is locked into place hydraulically during the cut.

Danobat has hundreds of installations throughout Europe and North America in Steel Service Centers, Large Steel Die Plants, and Forging Companies.

### HDS Automatic Band Saw Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>Cutting Capacity Round</th>
<th>Cutting Capacity Square</th>
<th>Band Length</th>
<th>Band Width</th>
<th>Band Thickness</th>
<th>Saw Motor Power</th>
<th>Hydraulic Power</th>
<th>Blade Speed</th>
<th>Index Stroke</th>
<th>Machine Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>HDS6</td>
<td>26'</td>
<td>26' x 26'</td>
<td>26' 3'</td>
<td>2-5/8'</td>
<td>0.063'</td>
<td>10 to 15 HP</td>
<td>2.5 HP</td>
<td>40-350 fpm</td>
<td>19-5/8'</td>
<td>16,100 lbs</td>
</tr>
<tr>
<td>HDS8</td>
<td>32'</td>
<td>32' x 32'</td>
<td>28' 6'</td>
<td>2-5/8'</td>
<td>0.063'</td>
<td>15 HP</td>
<td>2.5 HP</td>
<td>40-300 fpm</td>
<td>15-3/4'</td>
<td>23,700 lbs</td>
</tr>
<tr>
<td>HDS11</td>
<td>43-1/2'</td>
<td>43-1/2' x 43-1/2'</td>
<td>36' 5'</td>
<td>2-5/8'</td>
<td>0.063'</td>
<td>15 HP</td>
<td>4 HP</td>
<td>30-275 fpm</td>
<td>15-3/4'</td>
<td>31,100 lbs</td>
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</tbody>
</table>

### HDS Semi Automatic Band Saw Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>Cutting Capacity Round</th>
<th>Cutting Capacity Square</th>
<th>Band Length</th>
<th>Band Width</th>
<th>Band Thickness</th>
<th>Saw Motor Power</th>
<th>Hydraulic Power</th>
<th>Blade Speed</th>
<th>Machine Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>HDS6</td>
<td>26'</td>
<td>26' x 26'</td>
<td>26' 3'</td>
<td>2-5/8'</td>
<td>0.063'</td>
<td>15 HP</td>
<td>2.5 HP</td>
<td>40-350 fpm</td>
<td>12,000 lbs</td>
</tr>
<tr>
<td>HDS8</td>
<td>32'</td>
<td>32' x 32'</td>
<td>30' 1'</td>
<td>2-5/8'</td>
<td>0.063'</td>
<td>15 HP</td>
<td>2.5 HP</td>
<td>40-300 fpm</td>
<td>17,000 lbs</td>
</tr>
<tr>
<td>HDS11</td>
<td>43-1/2'</td>
<td>47-1/4' x 43-1/2'</td>
<td>36' 5'</td>
<td>2-5/8'</td>
<td>0.063'</td>
<td>15 HP</td>
<td>4 HP</td>
<td>30-275 fpm</td>
<td>24,800 lbs</td>
</tr>
<tr>
<td>HDS13</td>
<td>51'</td>
<td>51-1/4' x 51-1/4'</td>
<td>41' 1'</td>
<td>3-1/8'</td>
<td>0.063'</td>
<td>20 HP</td>
<td>7.5 HP</td>
<td>30-275 fpm</td>
<td>28,900 lbs</td>
</tr>
</tbody>
</table>
**HDS SERIES BAND SAWS**

**Carbide Tipped Saw Blades**
The Danobat Saw Machines have the ability to run carbide tipped saw blades because of the machine’s robust design and ZONE CUT Technology. Running Carbide Tipped Saw Blades will increase your production when cutting hard materials.

**Blade Guide System**
This system allows for faster sawing and a higher degree of accuracy. The carbide guide plate and assembly are oversized to contact more of the blade, especially important when running carbide tipped band saw blades.

**Two Guide Arm Design**
One guide arm is permanently mounted to the saw frame. The guide arm automatically moves via hydraulics based on the size of the part to be cut. It moves on a box way and is hydraulically clamped during the cutting operation.

**Saw Head and Band Wheel**
The saw head houses the band wheels and guide arms. The saw head is completely assembled and then all match points are machined in a single set up. The band wheels are made of heavy steel and balanced for true running of the saw blade. Band tension is via hydraulics.

**Saw Motor + Gear Box = Exact Torque for Your Application**
Powerful saw drive motors and gear boxes provide the best torque and power for a wide range of materials. Custom designs available to meet your specific application.

**Heavy Duty Saw Frame**
Polymer concrete filled saw head columns and portico eliminate vibration. Saw head design includes twin prismatic column support, two hydraulic cylinders to control saw head movement and high precision linear bearings on the main column, and support-free bearings on the secondary column to eliminate friction between the saw head and columns.
Pat Mooney is the exclusive importer and sales/service agent for Danobat Saw Systems. A leader in the sawing industry in Europe, Danobat is recognized for large, heavy duty saws with unique cutting software systems. Expertly trained, our service specialists have the knowledge necessary to quickly respond to your Danobat service and support needs.

- Trained, Qualified Service Personnel
- A Large Inventory of Replacement Parts and Blades
- New Blades for Special Applications

Danobat GDS Gantry
Vertical Plate Saws
TDS Transfer Machines
GDS Gantry Machines