

**Performance just got a
new name.**

B240M

Bandsaw blade milling machine

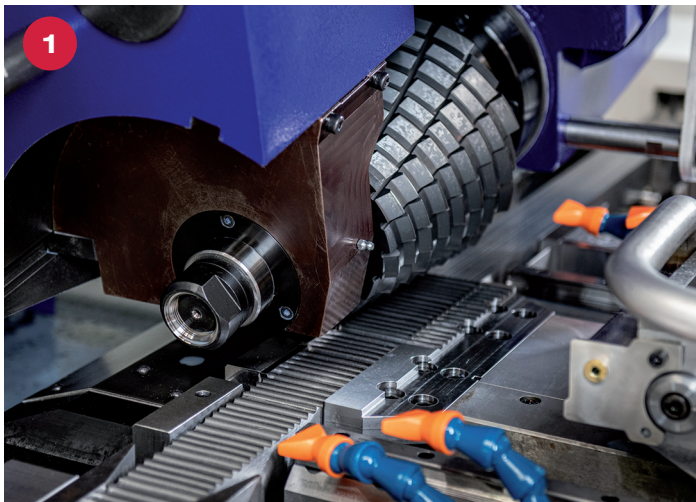


- Bandsaw blade production
- > Steering rack production
- > Rack production
- > Clamping tools

B240M

Performance is power. The B240M, the first in the new B Series of machines from Kesel, not only builds upon the global success of the FS 2500, but truly redefines the performance level of bandsaw blade milling machines. A completely new machine from Kesel, the B240M has been designed and engineered for pure productivity. The hybrid core, consisting of a steel and mineral-composite machine bed and column, delivers increased machine stiffness and dampening which transfers through to ensure the smoothest, highest quality milling ever achieved.

Optimised for the milling of carbon, bi-metal and carbide-tipped backing material, the B240M is capable of using 240 mm wide milling cutters as standard, ensuring maximum output. Bandwidths up to 125 mm, and the full spectrum of tooth profiles, from 32 – 0.5 TPI, can be milled on the B240M. With focus on productivity, speed of use and reduction of material wastage, the B240M employs the latest technology to ensure your manufacturing effectiveness remains at the forefront of industry capability.



Milling

The newly developed hybrid machine bed and milling column, combined with zero backlash drive units on our F350 milling head deliver the smoothest milling process of all time. The stiff, highly dampened machine design ensures both productivity performance and optimised tool life.

With a standard milling cutter width of 240 mm and band packet thicknesses up to 60 mm, milling of the entire spectrum of band-sizes and tooth profiles is possible with unbeatable output.



Band feeding and transportation

The band feed system of the B240M has been updated significantly to increase speed of use and dramatically reduce material wastage. Re-designed roller guides and a pneumatic band-packet holder ensure band changeovers are completed quickly and effectively.

The zero-loss feed system, a standard feature of the B240M, ensures that milling begins from the very first millimetre of band material. For organisations conscious of their carbon footprint, the B240M goes a long way to supporting more responsible manufacturing.



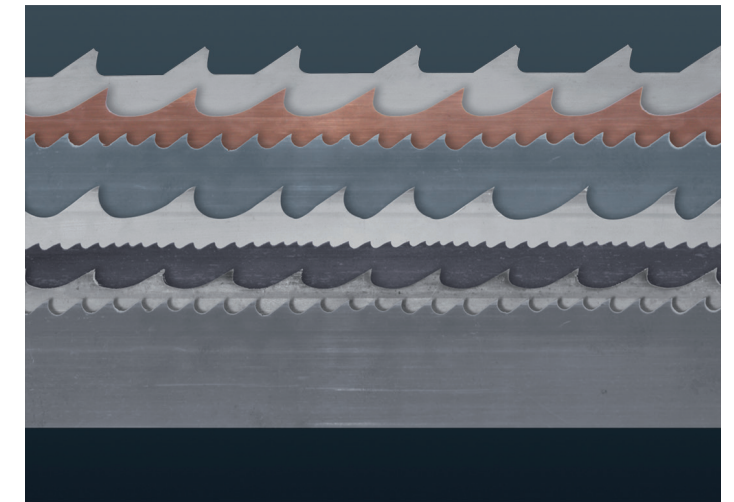
Control

The new high performing Siemens SINUMERIK ONE platform ensures ultimate performance and precision. The flexible architecture and automatic workflows make NC-programming simple and quick and with newly integrated hydraulic controls via the operator panel, machine operation has never been easier.



Swarf management

The swarf management system is optimised for use with either emulsion or oil coolant. The high delivery volume ensures the milling face is optimally cooled and rinsed at all times. The magnetic filter system can be optionally extended to include a fleece micro-filtering system to support enhanced surface finish.



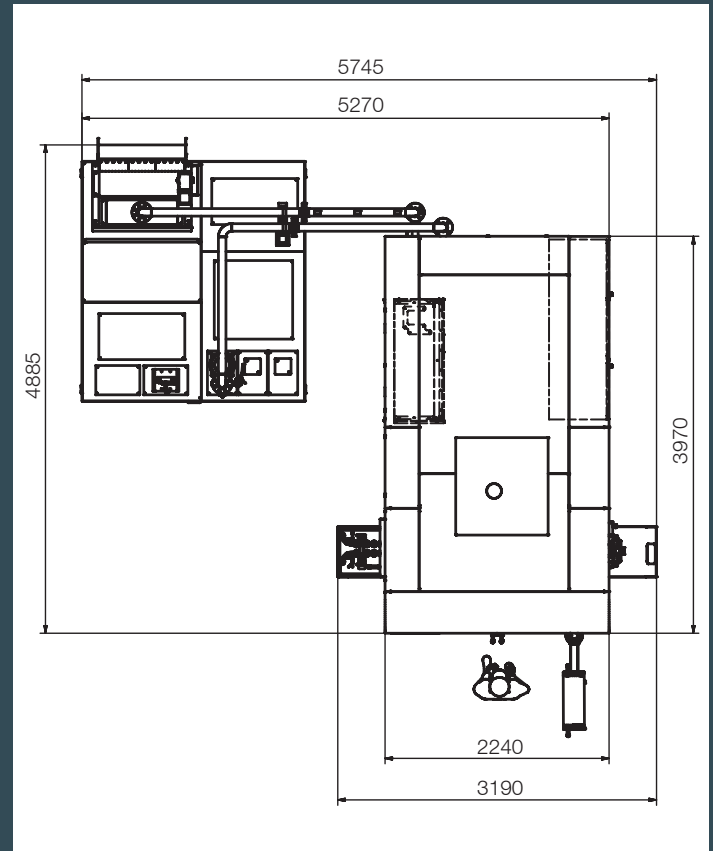
Bandsaw blades

Kesel machines are used around the world every day for the production of first-class bandsaw blades. The B240M extends the current performance and productivity possibilities ensuring almost any band type and tooth profile can be produced.

By no means limited to bi-metal band materials, the B240M can also mill carbon and carbide-tipped backing material. Whatever the application, our technical team is ready to work alongside you to design a system and tooling that ensures success.

Specification B240M

Milling head	
Type	F350, transmission with high power drive
Power	45 kW S6 40%
RPM	max. 450 U/min, infinitely variable
Milling arbor	SK 50
Min. diameter of milling cutter	165 mm + 2 x milling depth + 5 mm safety + resharpening (acc. to cutter manufacturer)
Max. diameter of milling cutter	310 mm (depending on cutter cone angle/rake angle saw)
Max. tool width	240 mm depending on cutter cone angle/rake angle saw (on request we provide technical assistance in the mill design)
Rotational axis	Cutting angle swivel range +2° up to -20°
Control	
Siemens SINUMERIK ONE	
Clamping System	
New clamping system with 40% reduced lifting on clamping jaw.	
Clamping width	max. 60 mm
Possible band height	up to 125 mm
Band guide and burr plate	
Zero-loss automatic band feed included Adjustable in vertical and horizontal direction Electrically operated burr plate drive	
Coolant and swarf removal	
Cooling lubricant	Emulsion or oil
Filling capacity	3,300 litres
Magnetic filter roller for fine filtration	
Electrical connection	
Voltage	3 x 400 V
Amperage	60 A
Dimensions and weight	
Space consumption	Lenght 5,745 x depth 4,885 x height 2,545 mm
Machine weight	Approx. 16,000 kg (machine incl. Control cabinet)
Options	
- Coiling systems	
- Cutter changing unit	
- Cutter pressure rinser	
- Tooth tip height monitoring	
- Fine filtration system	
- User interface with template incl. information regarding milling parameters	
- Additional milling accessories	
- Additional clamping equipment	



approx. dimensions of the B240M

Additional accessories available upon request / Subject to modifications arising from technical advances