

# Sterco

## Band Saw Butt Welder

### MODEL-MB





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## MODEL-MB BAND SAW BUTT WELDER

**STERCO** Band Saw Welder is the result of many years of experience, research and development. It is the most modern method of joining Band Saw Blades giving a joint strength 25% higher than that of the base metal strength. It eliminates the old process of overlapped brazing. Resistance welding is quick and automatic, thus eliminating human error and giving a perfect and strong joint.

### WELDING PROCESS

The Band Saw Blade ends are cut straight exactly at right angles and free of burrs. Welding current, upsetting pressure and upsetting way are set according to the blade width the blade ends being rigidly clamped by special quick acting jaws. By depressing the welding lever the automatic welding cycle starts. The two ends are heated up to forging temperature in a few seconds, then automatically forged (upset) and current switches off.

### ANNEALING ATTACHMENT

The upsetting pressure is now turned to annealing and job again clamped properly with extended jaws distance which comes in automatically flipping the lever to annealing position. By turning the annealing switch on which the heat position are provided the job is annealed in order to normalize the brittleness in the welded zone. Depending upon the type of material, the annealing process must be repeated several times if needed.

### SHEARING ATTACHMENT

Special shearing attachment is provided on the machine itself for cutting the piece at right angles, except for model MB-3 + 4.

### GRINDING ATTACHMENT

The attachment is provided for removing the burrs from the welded zone. This unit is mounted on the machine,

TECHNICAL DATA				
MODEL	JOB	WELDING CAPACITY	KVA RATING	MAX. PRIMARY CURRENT
MB-1	Band Saw Blades	3 mm to 25 mm	3 KVA	13 Amps
MB-2	" "	10 mm to 35 mm	5 KVA	22 Amps
MB-3	" "	15 mm to 50 mm	8 KVA	20 Amps
MB-4	" "	25 mm to 60 mm	15 KVA	37 Amps

### CUSTOMER TO PROVIDE

#### POWER SUPPLY

220 Volts, 50 Cycles, Single phase, AC for Model MB-1 & MB-2 and 415 Volts, Single phase, 50 cycle for Model MB-3 & MB-4.

We reserve the right to change design and modify specifications at the discretion of our department.



Manufactured by :

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Grams.: TEWELDING