ACT-09240 is a robotic cell for casting gate cutoff with a band saw. The cell is equipped with a 50 kg payload articulated robotic arm, automatic tool changer, tool magazine, part load nests, re-grip indexer station, scrap bins, and a 5 HP cutoff wheel.

Specifications:
- 50 kg robot arm
- 5 HP cutoff wheel
- 5 HP belt grinding station
- Part tray magazine
- Tool magazine
- Automatic tool change
- Part scanner
- Enclosure
- Dust collection system
- HMI
- Common base

Options:
- Pin bump grinding w/ small belts
- Sand blasting booth and tooling
- Scrap sorter
- Automatic cutoff wheel change
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**GATE CUTOFF OPERATION**

Parts transferred into the machine from baker’s style load rack are scanned with robot mounted vision and picked up from plastic molded trays. Robot positions the parts at the cutoff station and performs root and tip gate cuts.

Trimmed gate pieces slide to scrap bin(s) below cutoff wheel. Optional automatic scrap sorter is available to divert scrap pieces to one of 3 bins based on material type.

**GATE GRINDING**

After cutoff operation, robot measures gates at laser scanner station and grinds them to witness lines on 5 HP abrasive belt head.

This head is equipped with linear compliance slide, programmable force, precision contact wheel, and fully extended sensor.

**PIN BUMP GRINDING**

This option is made of two smaller belt stations integrated in the cell with adjustable depth of grind attachment (ACT Microgrinder head).

Pin bumps on both sides of airfoil can be grindes without gouging parent blade material.

**SAND BLASTING OPTION**

Sand blasting booth is integrated with the robot allowing part to be articulated inside it to perform sand blasting operation.

Part programming aids/tools are included. Sand reclaiming/recirculating system is also included.

**AUTOMATIC WHEEL CHANGE OPTION**

Cutoff or other wheels are mounted on arbors and loaded into docking nests in tool storage magazine. Used wheel is released from wheel spindle via pneumatically operated collet and extracted by the robot using special gripper tool.

The wheel is dropped off in an empty docking nest and new one is loaded into the spindle. Old wheel is marked as used in operator interface and new one is measured to adjust its outer diameter/wear dimension.

**AUTOMATIC SCRAP SORTER OPTION**

With this option, cutoff scrap pieces are automatically diverted to 1 of 3 bins.

Sorter positioning mechanism is fully programmable.