

QUOTATION

SERIE



Machine
:
42 series 1350 WRB
Date
:
02-11-2023

1 TECHNICAL SECTION

CUSTOMER APPLICATION REQUIREMENTS

Description material	☐ Steel* ☐ Stainless steel ☒ Aluminium ☒ Foiled parts ☐ Zincor parts ☐ Protrusion (parts with formings)					
Material processing	☒ Laser cutting ☐ Plasma cutting ☐ Oxyfuel cutting ☐ Water jet cutting ☒ Punching ☐ Guillotine shearing ☐ Milling ☐ Sawing					
Application	☒ Edge rounding ☒ Finishing ☐ Precision grinding ☐ Laser oxide removal					
Product dimensions (mm) to be advised by customer	Length		Width		Thickness	
Min. **	50	mm	50	mm	1	mm
Max.	∞	mm	1350	mm	100	mm
Hours per day	8					
Remarks	* Processing high-alloy and hard (tough) steels on Timesavers machines only after extensive testing in our machine application center. Hard steels give a white intense spark shower.					
	** Plate without holes. Smaller parts can be processed after getting experienced with the machine (like Ø 30 x 2 mm).					

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GENERAL MACHINE DESCRIPTION

Based on the analysis above, we have selected the following machine for you:

42 series 1350 WRB

The 42 RB series offers the solution for manufacturers who supply premium quality products. This top quality is achieved through a multi-rotating brush head with eight abrasive flap brushes that deburr uniformly and round the edges of the metal perfectly. Multi-directional rotary abrasive brush (RB) machine, for uniform deburring and finishing of flat sheet metal parts.

Executed with one (or more) abrasive belt head(s) (W) for pregrinding to remove the burr and for finishing.

- ✓ One rotary brush head processes the entire working width, with a total of eight brushes.
- ✓ An even wear of the abrasive flap brushes, regardless of where the machine operator places the parts.
- ✓ Quick release to change brushes and grinding belts in seconds to retool the machine.
- ✓ Standard vacuum table with automatic vacuum control to hold small parts (up to 50 x 50 mm) and aluminium parts during processing.
- ✓ Automatic cleaning cycle on the vacuum table at every machine stop and maximum after 4 hours production, which lasts 60 seconds. These 60 seconds can be optimally used to retool the machine for machining other materials.
- ✓ Window doors and lighting of the interior, together with the placement of the Siemens control panel on the side to monitor the process.
- ✓ Different thicknesses can be machined simultaneously.
- ✓ Suitable for different materials such as stainless steel, mild steel, aluminium, Zincor etc,
- ✓ Perfect edge rounding (radius of up to 2 mm).
- ✓ Straight finishing without oscillation marks.

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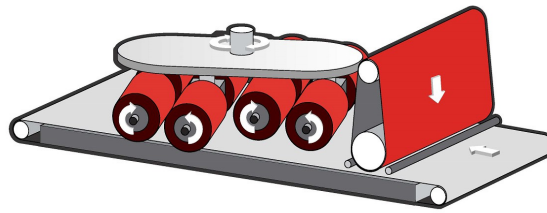
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[Youtube video](#)

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MACHINE CONFIGURATION



Wide abrasive belt contact roller head (W)

For deburring and finishing

- **Contact roller:** made of special "High Flexible" vulcanised oil and heat resistant rubber with special profiled grooves for pre-grinding, removing the upstanding burr and finishing.
- **Fine adjustment in height** of head with a precision of 0,01 mm to change pressure or for abrasive belt thickness. The displacement can be read out on the dial indicator.
- **Frequency-controlled motor** to determine the speed of the sanding belt.
- **Outboard support:** quick release M20 bolt that locks and unlocks for quick change of abrasive belts and provides rigid support of the grinding head.
- **Abrasive belt tension:** air operated and activated by thumb switch. Air tensioning automatically compensates for belt stretch. Machine cannot be started unless belt is tensioned.
- **Abrasive belt tracking:** an electronic system automatically keeps the fast revolving abrasive belt on the head. Due to this life time of belts improves.
- **Jog function transport:** used for adjusting the grinding belt pressure.
- **Jog function grinding belt:** used for checking the grinding belt tracking.
- **Belt trim lever:** used for correcting mis tracking of abrasive belt.
- **Brake:** to stop grinding head when limit switch is tripped or emergency stop is activated.
- **Pneumatic rise and fall of the grinding head:** the grinding head will lower after it has reached his full speed and will rise when you have an emergency stop when put on automatic mode. The grinding head can be put in the up position when you do not want to use it.

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Multi Rotary Brush Head (RB)

For deburring, edge rounding and non-directional finishing

- **The multi-directional rotary brush head** is suitable for eight brushes, four brushes rotate clockwise and four brushes rotate counter-clockwise.
- **Frequency controlled variable main motor** to control the speed of the brushes, with digital read-out.
- **Motorised height adjustment** to adjust the height of the brush carousel and compensate for brush wear. The height of this carousel is readable on the HMI screen and can be calibrated to 0.
- **Quick release pins** for easy change of the brushes.

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MACHINE FEATURES

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Operation

- Siemens user friendly control touch panel.
- Service screen with alarm list.
- Hour meter to record time of operation and for maintenance purposes.
- Digital display for main parameters.
- Press buttons to start/stop the heads with light indicator.
- Go-To positioning material thickness.
- Single joy stick operation to start and stop the conveyor belt.
- Load meters to indicate the percentage of motor load.
- LED lighting infeed and outfeed side with machine status.
- Operation on the left side of machine.

Conveyor table

- A robust box construction of tempered steel, mounted on four synchronised spindles.
- Vacuum table, with high friction vacuum conveyor belt, optimised for processing small parts of approx. 50 x 50 x 1 mm (light cubic shaped products are difficult to process).
- Frequency controlled vacuum pump for constant vacuum level no matter if the table is full with products or empty.
- Frequency controlled feed speed.
- Motorised table height adjustment for product thickness settings.
- Automatic cleaning cycle of the inner vacuum table via timer and at each machine stop.
- Conveyor belt running direction is from right to left seen from the belt changing side.

Different thicknesses in one pass

- With the RB unit, different thicknesses can be laid side by side on the conveyor belt:
here you see parts of various thickness that are perfectly rounded off together in one pass. The RB brushes do not scratch the parts, which is important for the food industry and machine construction.

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Pressure rollers for accurate guiding of parts

- Pressure rollers to ensure safe product infeed and operational safety. The rollers are covered with thick and flexible rubber.
- Over-thickness protection with safety switch on the infeed roller to prevent oversized parts entering the machine.

Construction and build-up

- Main frame, fabricated of heavy steel, properly ribbed, to minimize vibration and deflection.
- Dynamic balancing of all high-speed rollers to prevent hammering-out of vital parts and preserve machine life.
- Window doors on both sides of the machine for ease of maintenance and quick change of consumables.
- Interior light on the RB head for process observation.
- Dust extraction funnel to ensure a cleaner process.

CE and safety

- Protective guards at all pinch points.
- Finger protection, if the hinged guard is triggered, the conveyor belt will stop.
- Door safety switch, if a door is opened during operation, the machine will stop.
- Emergency push buttons at infeed- and outfeed side of the machine.
- Machine is CE approved; CE declaration enclosed in the manual.
- Electrical power supply: **460V, 60Hz**



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TECHNICAL SPECIFICATIONS HEADS

W Head		
Diameter contact roller	180	mm
Hardness rubber	55	shore
Abrasive belt speed	5 - 15	m/sec
Abrasive belt dimensions (W x L)	1380 X 1900	mm
Main motor	11	kW
Total power W head	11	kW

RB Head		
Brush dimensions (L x W)	530 X 350	mm
Brush speed frequency controlled	6 - 18	m/sec
Motor brush head total	6	kW
Main motor carousel	1,5	kW
Motor height adjustment brush head	0,5	kW
Total power RB head	8	kW

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TECHNICAL SPECIFICATIONS OTHER MACHINE PARTS

Max. working width	1350	mm
Machine opening	0,8-100	mm
Feed speed frequency controlled, variable speed	0,2-8	m/min
Electrical other		
Vacuum pump, frequency controlled	15	kW
Conveyor motor, frequency controlled	2,6	kW
Motor height adjustment table	0,37	kW
Electrical connection	460	V
Main frequency	60	Hz
Control voltage	24	V
Total power	37	kW
Compressed air		
Air pressure required	6	bar
Total air consumption	25	l/min
Dust extraction		
Extraction capacity required at 100 mm WC	5.500	m ³ /h
Weight		
Weight of the machine unpacked	Approx. 6.200	kg

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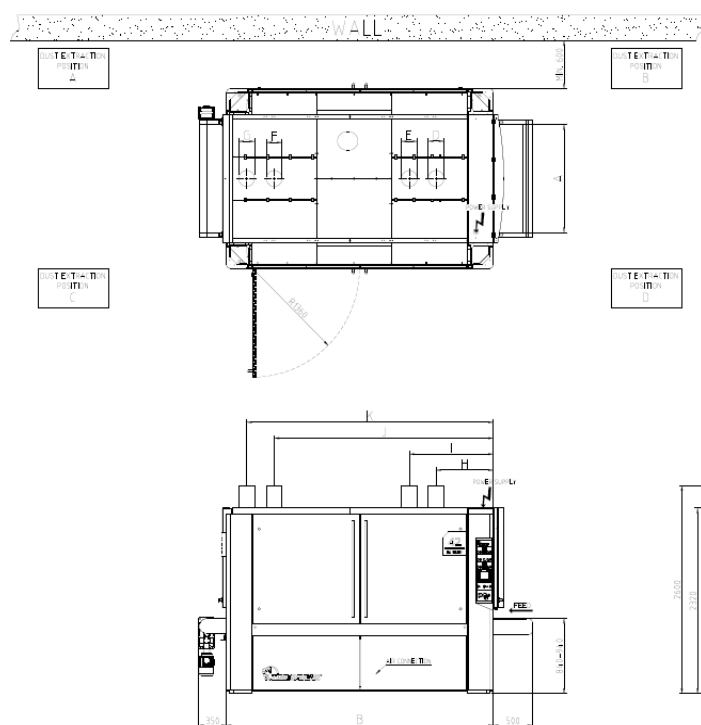
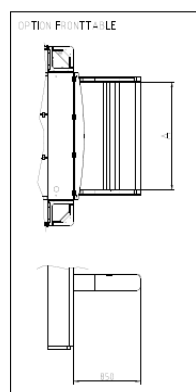
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DIMENSIONS

[illegible]

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OFFERED OPTIONS

Rotating conveyor cleaning brush under conveyor belt <i>(counter rotating) Driven by its own motor with cleaning hatch.</i>	
Magnetic track for small parts <i>300 mm wide, positioned left from the center</i>	
Extended rear table <i>With 2 rollers and steel plate (approx. 400 mm extra length)</i>	
Camera on the outfeed side of the machine with sepearte screen on the front. <i>Seperate screen on the infeed side of the machine to keep the HMI of the machine on operation mode.</i>	

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Starterset abrasive belts 1350

Content: 384F (grain 120, 180) 784F (grain 80, 120) 461F (grain 180) Scotch Brite (VFN) (H execution only 784F; grain 36, 60, 80)



Frequency controller on carousel RB head

Variable speed of the carousel. 5 - 9 rot/min.



Steel wire brushes (adjustable)

Adjustable brush to be used in combination with abrasive flap brushes for laser oxide skin removal in combination with rounding edges.



Aluminium Oxide brush, #180 - 3&5 mm

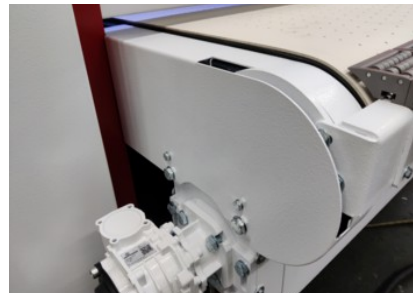
Medium edge rounding and surface finishing of steel, aluminium and stainless steel.



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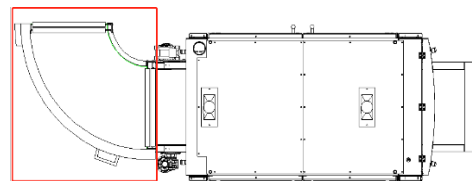
Preparation outfeed table (with conveyor cleaning brush)

*Machine preparation outfeed table
(with conveyor cleaning brush)*



Outfeed table 90 °for pick up parts

Outfeed table 90° mm, with driven.



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DUST EXTRACTOR

Wet separators of the Serie B have been specially designed for the separation of materials, which during processing produce flying sparks, are flammable or even explosive (ATEX). The Serie B has a revolutionary flow technology with a 50% higher suction power and maximum separation efficiency with low energy and water consumption. This system can be controlled via the machines' HMI. The interior of the system is easily accessible via four inspection openings and saves valuable time in cleaning and maintenance. The innovative technology is also reflected in the design and is unique in the industry.

UNIT COMPONENTS

Filter

- Cleanable stainless-steel metal mesh
- Multiple filter stages for maximum degree of separation
- Robust quality filters
- Long filter service lifetime

Options & configurations

- ATEX-/fire protection execution needed when processing aluminium
- HEPA H14 filter for fine, toxic and hazardous dust particles
- Pinch valve
- Versatile noise protection by means of galvanized silencer
- Ducting between extractor and machine

Options for discharge

- Discharge hose
- Containers in different sizes depending on type of extraction unit



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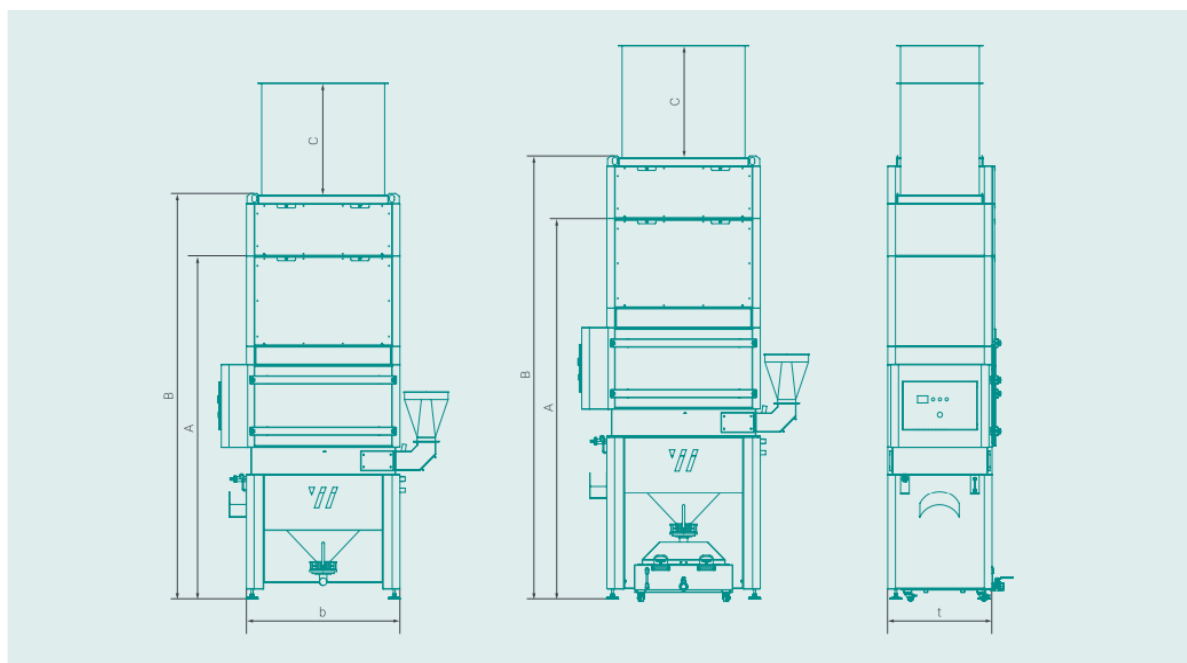
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DUST EXTRACTOR

Dimensions



WEI SEPARATOR SERIES			B 1000	B 2000	B 2000	B 2000	B 3000	B 3000	B 3000	B 4000	B 4000	B 4000	B 4000
Supply voltage	V												
Frequency	Hz												
Current type	Ph												
Engine power	kW	1.1	2.2	3	4	4	5.5	7.5	11	15	18.5	22	
Back-up fuse	A	16	16	16	20	20	25	32	50	50	50	60	
Fan performance max.	m ³ /h	2,350	3,400	4,200	6,200	6,200	6,900	11,000	14,800	18,000	21,000	22,000	
Negative pressure max.	Pa	1,950	2,500	3,100	3,800	3,800	4,000	4,000	4,400	5,100	5,500	6,500	
Connection diameter	mm	125	200	224	250	250	315	355	400	450	500	560	
Width (b)	mm	550	850	850	850	1,250	1,250	1,250	1,250	1,250	1,250	1,250	
Depth (t)	mm	650	850	850	850	850	850	850	1,500	1,500	1,500	1,500	
Height A (Cone)	mm	900	2,700	2,800	2,800	2,920	3,020	3,120	3,520	3,520	3,620	3,620	
Height B (Cone + H14)	mm	2,390	2,915	3,015	3,015	3,135	3,235	3,235	3,635	3,635	3,735	3,735	
Height A (Cone with elevation)	mm	-	3,000	3,100	3,100	3,220	3,320	3,420	3,820	3,820	3,920	3,920	
Height B (Cone with elevation + H14)	mm	-	3,215	3,315	3,315	3,535	3,535	3,535	3,935	3,935	4,035	4,035	
Height C (Splitter silencer)	mm	(+800)	(+1,000)	(+1,000)	(+1,000)	(+1,000)	(+1,000)	(+1,000)	(+1,000)	(+1,000)	(+1,000)	(+1,000)	
Opening radius door (R)	mm	450	750	750	750	1,200	1,200	1,200	1,200	1,200	1,200	1,200	
Weight empty (approx.)	kg	300	400	420	450	600	650	700	950	1,000	1,050	1,150	
Weight with water (approx.)	kg	650	750	770	800	950	1,000	1,050	1,300	1,350	1,400	1,500	
Sound level (approx.)	dB(A)	75	75	75	75	75	75	75	78	79	79	79	
Permissible ambient temperature	°C												
Permissible humidity	%												

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2 COMMERCIAL SECTION

PRICE SUMMARY

Description	Total
Machine	€ 260.899
Accessories	€ 6.565
Tables	€ 37.789
Operation	€ 1.622
General	€ 4.449
Dust Extractor	€ 24.083
General (Dust Extractor)	€ 12.123
Spare parts	€ 19.263
Packing and FOB Rotterdam harbor	€ 3.379
Installation and training	€ 4.828
Total list price	€ 375.000

PRICE SPECIFICATION

Machine

Description	Price	Quantity	Total Price
42 series 1350 WRB	€ 260.899	1	€ 260.899
Subtotal			€ 260.899

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Accessories

Description	Price	Quantity	Total Price
Starterset abrasive belts 1350	€ 389	1	€ 389
Frequency controller on carousel RB head		0	
Steel wire brushes (adjustable)		0	
Aluminium Oxide brush, #180 - 3&5 mm	€ 772	8	€ 6.176
Subtotal			€ 6.565

Tables

Description	Price	Quantity	Total Price
Rotating conveyor cleaning brush under conveyor belt	€ 3.524	1	€ 3.524
Magnetic track for small parts		0	
Extended rear table		0	
Preparation outfeed table (with conveyor cleaning brush)	€ 1.439	1	€ 1.439
Outfeed table 90°for pick up parts	€ 32.826	1	€ 32.826
Subtotal			€ 37.789

Operation

Description	Price	Quantity	Total Price
Camera on the outfeed side of the machine with separate screen on the front.	€ 1.622	1	€ 1.622
Frequency controlled carousel (included)	€ 0	1	€ 0
4 brushes at different speed		0	
Subtotal			€ 1.622

General

Description	Price	Quantity	Total Price
Wandress product cleaning brush		0	
Sisal brush for cleaning the parts in the rear	€ 3.524	1	€ 3.524
LED lighting on W-Head	€ 925	1	€ 925
Subtotal			€ 4.449

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Dust Extractor

Description	Price	Quantity	Total Price
Dust extractor Serie B 3000 - 5,5 kW	€ 24.083	1	€ 24.083
Subtotal			€ 24.083

General (Dust Extractor)

Description	Price	Quantity	Total Price
ATEX	€ 2.629	1	€ 2.629
Hepa filter	€ 2.675	1	€ 2.675
Sludge container L	€ 1.991	1	€ 1.991
Ducting between machine and dust collector	€ 4.827	1	€ 4.828
Subtotal			€ 12.123

Spare parts

Description	Price	Quantity	Total Price
Main machine parts			
Aluminium Oxide brush, #180 - 3&5 mm	€ 772	8	€ 6.176
Contact roller 55 degree	€ 4.443	1	€ 4.443
Oscillation cylinder	€ 338	1	€ 338
Electrical valve	€ 270	1	€ 270
Electrical eyes sender	€ 239	1	€ 239
Electrical eyes receiver	€ 249	1	€ 249
RB shaft completed (R)	€ 695	2	€ 1.390
RB shaft completed (L)	€ 695	2	€ 1.390
Tension roller bearing	€ 182	2	€ 364
Dust collector parts			
Stainless steel mash	€ 483	2	€ 966
H14 filter	€ 1.719	2	€ 3.438
Subtotal			€ 19.263

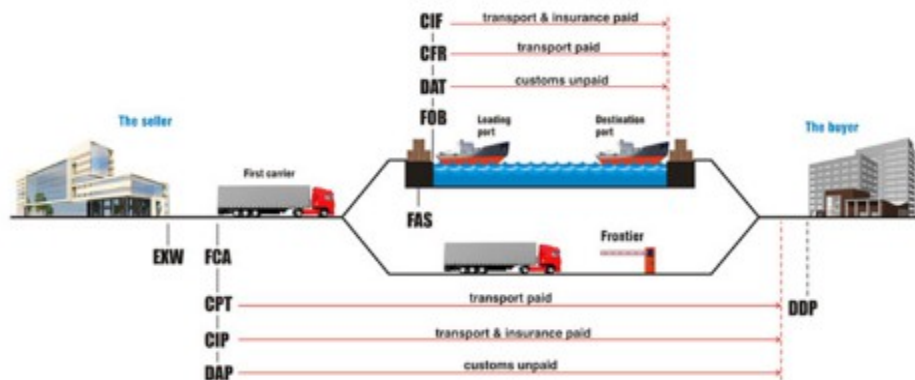
QUOTATION VALIDITY

Prices will remain fixed and firm until 02-12-2023

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PACKING AND DELIVERY

The machine is properly packed for transport. Delivery according to INCOTERMS® 2020 rule:
FOB ROTTERDAM



Task

Load:
Unload:
How to unload:
Unpacking:
From truck to site:

Responsible

Timesavers
Customer
Forklift or crane
Customer
Customer

TERMS AND CONDITIONS OF PAYMENT

Delivery to ORGALIME conditions: General conditions for delivery of mechanical, electrical and electronical related products, dated Brussels, March 2012, and General Conditions for Computer Software Supplement to ORGALIME S 2012. The ORGALIME conditions can be downloaded on our website: www.timesaversint.com

Payment conditions:

30% down payment,
70% before despatch

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WARRANTY

Timesavers warrants to the original purchaser that any part of our machine which, under normal operating and prescribed maintenance, proves defective in material or workmanship will be replaced free of charge, as follows:

Two (2) year or 4,000 hour warranty coverage: (whatever comes first)

Any Timesavers' manufactured parts, such as frames, brackets, castings, and weldments. All component parts not manufactured by Timesavers, such as electrical and pneumatic controls, speed reducers, and motors.

One (1) year or 2,000 hour warranty coverage: (whatever comes first)

Expendable parts such as v-belts, conveyor belts, rubber-covered rolls, and electronic tracking eyes, prorated based on a one-year life.

Warranty procedure:

Should you require warranty support, please contact Timesavers International B.V. +31113238950. We will promptly arrange for repair and/or replacement under the coverages set forth above. Warranty parts are shipped prepaid by Timesavers, using standard carrier. Timesavers may invoice the customer for all-applicable parts and labour. Credit will be issued upon the return and evaluation of the defective part, less any express shipping charges.

Other provisions:

This warranty does not cover consumable items and other normal wear items, or parts damaged due to accident or misuse. Timesavers is not responsible for, and will not pay for, work done, material furnished, or repairs made by others unless agreed to in writing prior to performing that work. This warranty starts on the date of machine installation. Maximum 6 months after shipping whatever occurs first. This warranty becomes void if the hour meter has been disconnected or tampered with. Parts repaired or replaced under warranty are covered for the balance of the original machine warranty, or the standard 12 months parts warranty, whichever is longer.

Except as stated above, there are no warranties, expressed or implied. The purchaser's sole and exclusive remedy against Timesavers shall be for the repair or replacement of defective parts as provided for herein. The warranty stated above is in lieu of any other warranty or remedy. In no event, be it due to a breach of any other warranty or any other cause arising from the performance or non-performance of the goods sold hereunder, shall Timesavers be obligated or liable for consequential or incidental damages, including, but not limited to, lost profits, plant downtime or suits by third parties.

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INSTALLATION AND START-UP

Installation and start-up of the machine(s) quoted herewith is not included. Extra price for the machine installation is mentioned as an option.

	Responsible	Remarks
General		
Installation equipment	Timesavers/Dealer	
Training	Timesavers/Dealer	
Tooling	Timesavers/Dealer	
Machine levelling	Timesavers/Dealer	
Connections to main power connection		
Electrics	Customer	
Compressed air	Customer	
Dust extraction	Customer	Controls via main cabinet Timesavers if extraction bought at Timesavers
Water for dust extraction	Customer	
Consumables	Customer	Delivered with machine
Civil work		
Foundation	Customer	200 mm flat concrete floor
Holes in wall and roof	Customer	Drawing provided by: Ducting or dust extraction company
Ducting from dust extractor to grinding machine	Customer	Drawing provided by: Ducting or dust extraction company

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DELIVERY TIME

Standard delivery time is approx. **25** working weeks after receiving the order and down payment.

Please contact me when you have any questions.

Kind regards,

Pascal Depondt
Area Manager
pdepondt@timesaversint.com
+31 6 3882 2314

Reservation for price increases/delay in delivery

Please be aware that both the price and the delivery time in this quotation is based on circumstances as they are today. These circumstances are very unstable, as everyone knows. As regards price, please be aware that we are facing cost increases every day, especially for the purchase of components and raw materials like steel. We therefore have to stipulate that this quotation is made under the explicit condition that we will be entitled to raise the price as specified in this quotation, taking cost increases which may occur as of today into account. You can certainly contact us before sending out your purchase order to learn what our price will be at that specific moment.

The same applies for the delivery time. Delivery of raw materials and components is uncertain and things are expected to be like that for the next coming months. We therefore have to stipulate that this quotation is made under the explicit condition that we will be entitled to suspend delivery, taking account of shortage of and delivery problems for raw materials and components. We cannot guarantee any specific date of delivery, unfortunately. We will certainly make every effort to stick to the delivery time as specified in this quotation.

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We can only accept your purchase order under these specific conditions for price increase and delay in delivery. We trust that you will understand our approach, given the unstable circumstances we are all facing.