

ROTOX ZSA CUTTING CENTRE

263 F + DFS

Technical specification:

- Painting: RAL 7016 (Anthracite)
/ RAL 7035 (Grey)
- Data transmission connection: ROTO Creator
- Processing specification: none
- Layout setup: approved
- Transport direction: from right
to left
- Label printer: Godex EZ2250i
(to be supplied by Abakus)

Processed Profiles:

1. Salamander proEvolution 72
 - L Frames: 720003, 720004
 - Renovation frames:
 - T Mullions: 722005, 722006, 722000
 - Z Sashes: 721001, 721008
 - T Sashes: 721009
 - Movable mullion: 726003, 726004
2. Salamander bluEvolution 82
 - L Frames: HO8020, HO9020
 - Renovation frames: HO9110
 - T Mullions: HO8320, HO9320
 - Z Sashes: HO8520
 - T Sashes:
 - Movable mullion: HO9800
3. Salamander bluEvolution NL
 - NL Frames: 820801, 820802
 - NL Renovation frames: 820805
 - NL Mullion: 822801, 822802
 - NL Mullion, renovation:
 - Z Mullion:
 - Reversed profile: 826801
 - Frame + rev. profile: 820801+826801
4. Salamander bluEvolution USA
 - USA Frame: HO8020+NP0600

5. Rehau Synego

- L Frames: 1537605, 1537625
- Renovation frames:
- T Mullions: 1537405, 1537415, 1537505, 1537515, 1537435, 1537425
- Z Sashes: 1537525,
- T Sashes:
- Movable mullion: 1537455

6. Rehau Synego NL

- NL Frames: 1539025,
- NL Renovation frames: 1539055, 1539045
- NL Mullion: 1539075, 1539135
- NL Mullion, renovation: 1539080
- Z Mullion: 1539105
- Reversed profile: 1539125
- Frame + rev. profile: 1539025+1539125
- Mullion + rev. profile: 1539075+1539125

7. Rehau Artevo

- L Frames: 1555625
- Renovation frames: 1555695
- T Mullions: 1555565, 1555425
- Z Sashes: 1555225, 1555235, 1555245
- T Sashes: 1555265
- Movable mullion: 1555455

Restrictions and reservations:

USA Frame: HO8020+NP0600: - restricted, possible problems during transport and cutting

Reversed profile 826801 - restricted, possible damage during clamping

Movable mullions: 726003 - restricted

Movable mullions: 726004 - restricted

Movable mullions: HO9800 - restricted

Movable mullions: 1537455 - restricted

Movable mullions: 1535455 - restricted

Frame + rev. profile: 820801+826801 - restricted
(cutting accuracy)

Frame + rev. profile: 1539025+1539125 -
restricted (cutting accuracy)

Mullion + rev. profile: 1539075+1539125 -
restricted (cutting accuracy)

**Restricted
profiles are included
in the specification of processed profiles, however their processing may
not be optimal, and in extreme cases may be impossible**

Feeding magazine - ZBZ 10 profile bars
max. length 6500 mm - 1 pc.

**2.0 ROTOX ZSA 263 F profile cutting
automatic machine**
for single cutting
of PVC profiles, with
1 NC axis for

feeding and positioning
of profiles, bar
minimum length:
700 mm (or 550 mm depending on equipment), maximum bar length: 6500
mm, 2 cutting units arranged in a V-shape,
cutting blades Ø 500 mm,
motorized and NC-controlled feed of cutting units, NC axis for
receiving cut profile bars, pneumatic
profile clamping, PC computer with visualization and two network cards, without tools,

together with safety
fence. Profile height: min.: 30
mm, max.: 180 mm - depending on

geometry, profile width: min.: 30
mm, max.: 130 mm - depending on profile
positioning, cutting length at 90°: min.: 290
mm, cutting
length at 45°: depending on profile (290
mm + profile width,
for T sash + 30 mm), maximum capacity up to 350
window units per 8 hours - 1 pc.

**3.0 Straight-cutting unit for ROTOX
ZSA 263** mounted on
the main stand opposite the
PVC profile cutting unit,

1 electric motor,
pneumatic feed of the cutting blade
together with vertical and horizontal

profile clamping,
cutting blade diameter Ø 400 mm, without tools - 1 pc.

4.0 Chip extraction unit with motor blower
and chip bag, 3 KW motor, (together with electrical control, option
recommended for more reliable machine operation) - 1 pc.

5.0 Pipe
Ø 200 mm, length 1000 mm - 2 pcs.

6.0 Pipe
clamp Ø 200 mm -
2 pcs.

7.0
Sleeve Ø 200 mm -
1 pc.

8.0 Special equipment positioning of the
machine control cabinet behind the receiving table - 1 pc.

**9.0 Conveyor belt for waste removal from
the machine**
for automatic cutting machines (option recommended for more reliable machine operation) - 1
pc.

10.0 Inclined waste conveyor to a height of 2,200 mm for
a waste container height of
approx. 1,800 mm - 1 pc.

11.0
Clamping device
for the rebate gasket of sashes - 1 pc.**

12.0
Program and cutting test of one profile - ZSA 263 F - 51 pcs.

13.0
Program and cutting test of one special profile e.g. extremely narrow profiles

monoblock mullion - ZSA 263 F - 3 pcs.

14.0
Blade Ø 400 x 3.8 x 30 Z96 - 1 pc.**

14.5

Blade Ø 500 mm - 2

pcs. (2 pcs. required)

15.0 Program connection for a label printer with network card or USB input, the equipment (label printer) must be supplied

to the machine manufacturer's premises - 1
pc.

16.0

Optimizing program with offcut measurement in approx. 15
switching sections, together with
offcut

processing, without offcut management system -
1 pc.

17.0

Cross-feed indexing conveyor for bar length max. 3500 mm, indexing transversely to
the length of the profile bar,
used for mounting
DFS and transporting profiles to DFS - 1 pc.

17.5

Buffer integrated with the indexing conveyor - 1 pc.

18.0

Rotox DFS 263 gasket milling station 263

for milling
the inner and outer gasket area with 1
milling unit
with electric motor,
PLC control and 3-axis CNC, pneumatic
profile clamping, maximum profile height: 156
mm, maximum profile
width: 155 mm (for one ZBZ
2 x DFS must be used) - 1 pc.

19.0

Transfer of the zero edge of the profile bar from DFS 1 milling station
to DFS 2 milling station using a system of driven rollers - 1 pc.

20.0

Rotox DFS 263 gasket milling station for milling the inner and
outer gasket area with 1 milling unit with electric motor,
PLC control and 3-axis CNC, pneumatic profile clamping, maximum profile height: 156
mm, maximum profile width: 155 mm (for one ZBZ
2 x DFS must be used) - 1 pc.

20.2

Cutter

HM Ø63x14/Ø22/Z12 for gasket [DFS 488] - 2 pcs.

20.4

Program with milling test of one standard profile - DFS milling station - 32 pcs.

20.6

Program with milling test of one special profile - DFS milling station - 3 pcs.

21.0

Receiving table

maximum bar length: 3500
mm, indexing transversely to
the length of the profile bar,
used for

further transport from DFS to the next station or for
receiving profiles - wide shelf for receiving profiles

- 1 pc.

24.0

ROTOX-Web-Control connection

Remote machine diagnostics via
internet for 1 to 2 machines - 1 pc.