



HORIZONTAL BANDSAWS PRODUCT CATALOG

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HORIZONTAL BANDSAWS

A Complete Line of Precision General Purpose Horizontal Bandsaws

- Manual Bandsaws
- Semi-Automatic Bandsaws
- Fully-Automatic Bandsaws



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Since 1911.

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CLAUSING KALAMAZOO 8" (200 mm) WET CUTTING BANDSAW

Features

- 1 HP (.75 kW) drive motor, heavy-duty reducer and variable step drive assembly
- 4 speed step pulley with worm gear speed reducer, worm shaft is hardened and ground
- Heavy-duty hydraulic cylinder with precision ground hinge support
- Pan shaped base with built-in coolant & hydraulic system
- Carbide blade guides with roller bearings
- Two additional bearings to support blade from the top
- Integral coolant system
- Blade brush
- Down feed rate and cutting pressure via hydraulic down feed valve
- Simplified control switches mounted on saw head
- Cast iron 0°– 45° quick set up vise
- Anti-slip hand wheel
- Easy blade change with front access at waist level
- bi-metal saw blade
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	KC812W
Type	Horizontal wet cut
Drive Motor	1 HP (.75 kW) 110 V or 220 V, 1 Ph*
Band Wheel Diameter	11.5" (292 mm) Flanged, Cast Iron
Blade Size	1" x .035" x 107" (25 x .9 x 2,718 mm)
Bed Height	24.8" (630 mm)
Blade Speeds (4)	59, 96, 155, 260 fpm (18, 29, 47, 79 m/min)
90° Cutting Capacity	
Round	8" (203 mm)
Square	7" (178 mm)
Rectangular (H x W)	7" x 14" (178 x 356 mm)
45° Cutting Capacity	
Round	7.5" (191 mm)
Square	6" (152 mm)
Rectangular (H x W)	6" x 9" (152 x 229 mm)
Width	59" (1,499 mm)
Depth	24.6" (625 mm)
Height (head-up)	63" (1,600 mm)
Height (head-down)	45" (1,143 mm)
Net Weight	515 lbs. (234 kg)
Shipping Weight	640 lbs. (290 kg)
Shipping Dim. (LxWxH)	58" x 30" x 48" (1,473 x 762 x 1,219 mm)

All specifications subject to change without notice or obligation.

Accessories

- BT01-Bandsaw Blade Tension Gauge
- P10-Stock Stand Assembly 21"– 30"
- SA8-Roller Table Assembly 15"x 10'
- SA9-Roller Table Assembly 15" x 5'
- SA12-Roller Table 18"x10'
- SA13-Roller Table 18" x 5'
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons



CLAUSING KALAMAZOO 9" AND 10" WET CUTTING SWIVEL BANDSAWS

Features

- 1.5 HP drive motor, heavy duty reducer and step pulley drive MS9S3 and MS9V1
- 1.5 HP drive motor, heavy duty reducer and variable Speed drive MS9V3
- Swivel angle 0–60 degree left MS9S3 and MS9V1
- Double swivel for adjustable left or right angles MS9V3
- Feed down cylinder
- Motor with worm gear driven gear box with hardened and ground worm shaft MS9S3 and MS9V1
- 2-Speed motor with worm gear driven gear box with hardened and ground worm shaft MS9V3
- Bi-Metal saw blade
- Blade tension gauge system
- Coolant system
- Machine stand with door
- Operation and parts manual
- Two year limited warranty
- Voltages are 220v/1ph for MS9V1
- Voltages are 230v/3 phase for MS9S3 and MS9V3 all other voltages may require a transformer or special order

Specifications

Model	MS9S3	MS9V1	MS9V3
Type	Horizontal Miter	Horizontal Miter	Horizontal Double Miter
Motor	1.5 HP 3 phase	1.5 HP 1 phase	2 Speed 1.5 HP 3 Phase
Step Speed Drive	2	Single Pulley	—
Variable Speed	—	—	Yes
Blade Size	1" x .035" x 96.5"	1" x .035" x 96.5"	1" x .035" x 120.3"
Blade Speeds Step	132 and 264 FPM	10–264 FPM	10–264 FPM
Blade Speeds Variable	—	—	—
90° Cutting Capacity			
Round	8.9" (226 mm)	8.9" (226 mm)	10.2" (259 mm)
Rectangular (H x W)	9.45" x 6" (240 x 152 mm)	9.45" x 6" (240 x 152 mm)	13.8" x 7.9" (351 x 201 mm)
45° Cutting Capacity			
+ Round	5.75" (146 mm)	5.75" (146 mm)	7.9" (201 mm)
Rectangular (H x W)	5.75" x 8.27" (146 x 210 mm)	5.75" x 8.27" (146 x 210 mm)	8.7" x 7.9" (221 x 201 mm)
45° Cutting Capacity			
- Round			7.9" (201 mm)
Rectangular (H x W)			9.1" x 7.9" (231 x 201 mm)
60° Cutting Capacity			
+ Round	3.5" (89 mm)	3.5" (89 mm)	5.5" (140 mm)
Rectangular (H x W)	3.5" x 7" (89 x 178 mm)	3.5" x 7" (89 x 178 mm)	5.5" x 5.5" (140 x 140 mm)
Bed Height from Floor	39.5"	39.5"	39.5"
Width	53" (1,346 mm)	53" (1,346 mm)	63.4" (1,610 mm)
Depth	28" (711 mm)	28" (711 mm)	39.4" (1,001 mm)
Height (head down)	52.2" (1,326 mm)	52.2" (1,326 mm)	64.5" (1,638 mm)
Net Weight	550 lbs. (249 kg)	550 lbs. (249 kg)	792 lbs. (359 kg)
Shipping Weight	620 lbs. (281 kg)	620 lbs. (281 kg)	900 lbs. (408 kg)
Shipping Dim. (L x W x H)	60" x 35" x 60"	60" x 35" x 60"	70" x 45" x 71"

All specifications subject to change without notice or obligation.

Accessories

- P10-Stock Stand Assembly 21"–30"
- SA10-Roller Table Assembly 18" x 10'
- SA11-Roller Table Assembly 18" x 5'
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons

Speed control and speed chart on variable speed model KC1016VS



CLAUSING KALAMAZOO 10" (250 mm) WET CUTTING BANDSAW

Features

- 1.5 HP (1.1 kW) drive motor on 110 V & 220 V, 1 Ph models
- 2 HP (1.5 kW) drive motor on 230 V & 460 V, 3 Ph models
- Magnetic starter with overload protection
- 4 speed step pulley with worm gear speed reducer, worm shaft is hardened and ground (model KC1016W)
- Infinity Variable Speed drive (model KC1016VS)
- Totally enclosed transmission
- Heavy-duty hydraulic cylinder with precision ground hinge support
- Pan shaped base with built-in coolant and hydraulic system (5.25 gallon capacity)
- Cast iron bed
- Cast iron quick acting 0°–45° vise with manual lead-screw clamping system
- Two additional bearings to support blade from the top
- Recirculating coolant system with application through both guides
- Blade brush
- Valve controlled hydraulic cylinder controls feed and can be adjusted for different types and sizes of material
- Adjustable stock stop
- Simplified control switches mounted on saw head
- Anti-slip hand wheel
- Easy blade change with front access at waist level
- 1" wide saw blade
- Tools
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	KC1016W/KC1016VS
Type	Horizontal wet cut
Motor KC1016W 4 Speed Drive	1.5 HP (1.1 kW) 110 V or 220 V, 1 Ph* 2 HP (1.5 kW) 230 V or 460 V, 3 Ph*
Motor KC1016VS Variable Speed Drive	1.5 HP (1.1 kW) 110 V or 220 V, 1 Ph* 2 HP (1.5 kW) 230 V or 460 V, 3 Ph*
Band Wheel Diameter	15" (381 mm) Flanged, Cast Iron
Blade Size	1" x .035" x 11' (25 x .9 x 279 mm)
Bed Height	25" (635 mm)
Blade Speeds Step	(4) 75, 121, 190, 305 fpm (23, 37, 58, 93 m/min)
Blade Speeds VS	50–295 fpm (15–90 m/min)
90° Cutting Capacity Round	10" (254 mm)
Rectangular (H x W)	9" x 14.5" (229 x 368 mm)
45° Cutting Capacity Round	9" (229 mm)
Rectangular (H x W)	9" x 9" (229 x 229 mm)
Length	66" (1,676 mm)
Depth	28" (711 mm)
Height (head-up)	69" (1,753 mm)
Height (head-down)	41" (1,041 mm)
Net Weight	720 lbs. (327 kg)
Shipping Weight	885 lbs. (401 kg)
Shipping Dim. (LxWxH)	68" x 30" x 45" (1,727 x 762 x 1,143 mm)

All specifications subject to change without notice or obligation.

Accessories

- P10–Stock Stand Assembly 21"–30"
- BT01–Bandsaw Blade Tension Gauge
- SA8–Roller Table Assembly 15" x 10'
- SA9–Roller Table Assembly 15" x 5'
- SA12–Roller Table Assembly 18" x 10'
- SA13–Roller Table Assembly 18" x 5'
- CSR1–SAWZIT 1 Gallon
- CSR5–SAWZIT 5 Gallons

Speed control and speed chart on variable speed model KT1018VS



CLAUSING/KALAMAZOO 10" (254 mm) WET CUTTING BANDSAW

Features

- 2 HP (1.5kw) drive motor with magnetic starter and overload protection
- 4 step blade speeds (KT1018W)
- Infinity variable blade speeds (KT1018VS)
- Quick positioning 45° vise
- Cast iron bed
- Totally enclosed transmission
- Quick and simple speed change
- 1" (25.4 mm) wide blade
- Blade cleaning brush
- Solid carbide blade guides with rollers
- Recirculating coolant system with application through both guides
- Stock stop
- Easily adjusted head feed
- Head control is hydraulic cylinder operated by needle valve
- Two (2) year limited warranty

Accessories

- P10-Stock Stand Assembly 21"-30"
- BT01-Bandsaw Blade Tension Gauge
- SA12-Roller Table Assembly 18" x 10'
- SA13-Roller Table Assembly 18" x 5'
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons

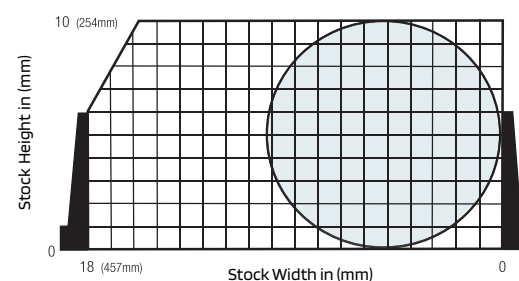
Specifications

Model	KT1018W/KT1018VS
Type	Horizontal wet cut
Drive Motor	2 HP (1.5 kW) 110 V or 220 V, 1 Ph* 230v or 460 V, 3 Ph*
Band Wheel Diameter	15.4" (391 mm) Flanged, Cast Iron
Blade Size	1" x .035" x 11'-4.5" (25 x .9 x 3,467 mm)
Bed Height	21.8" (554 mm)
Blade Speeds W Model	60, 125, 200, 300 fpm (18, 38, 61, 92 mpm)
Blade Speeds VS Model	69-321 fpm (21-98 mpm)
90° Cutting Capacity	
Round	10" (254 mm)
Rectangular (H x W)	18" x 6" or 10" x 16" (457 x 152 or 254 x 406 mm)
45° Cutting Capacity	
Round	8" (203 mm)
Rectangular (H x W)	8" x 6" or 4" x 9" or 3" x 10" (203 x 152 or 102 x 229 or 76 x 254 mm)
Floor Space	61" x 51" (1,549 x 1,295 mm)
Machine Dim. LxWxH	74.8" x 29.1" x 39.4" (1,900 x 739 x 1,001 mm)
Height (head-up)	60.4" (1,535 mm)
Height (head-down)	39.4" (1,001 mm)
Net Weight	VS-780 lbs. (354 kg) W-685 lbs. (311 kg)
Shipping Weight	VS-850 lbs. (386 kg) W-888 lbs. (403 kg)
Shipping Dim. LxWxH	80.3" x 35.4" x 45.3" (2,040 x 899 x 1,151 mm)

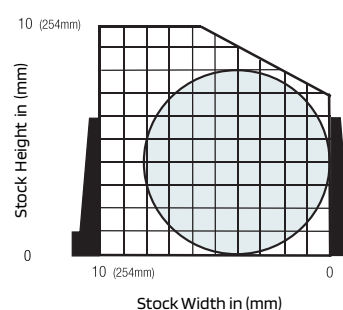
All specifications subject to change without notice or obligation.

Cutting Capacities

Capacity at 90°



Capacity at 45°





Specifications

Model	MS1218VS
Drive Motor	2 HP (1.5 kW) 230/460 V, 3 ph*
Hydraulic Motor	0.25 HP (19 kW)
Coolant Pump	0.125 HP (1 kW)
Band Wheel Diameter	15.4" (391 mm)
Blade Size	1" x .035" x 11'-4.5" (25 x .9 x 3,467 mm)
Bed Height	21.75" (552 mm)
Vise Opening	18" (457 mm)
Blade Speeds	80-360 fpm (24-110 m/min)
90° Cutting Capacity	
Round	12" (305 mm)
Square	10" x 10" (254 x 254 mm)
Rectangular (H x W)	10" x 16" (254 x 406 mm)
45° Cutting Capacity	
Round	8" (203 mm)
Square	8" x 8" (203 x 203 mm)
Rectangular (H x W)	8" x 12" (203 x 305 mm)
Width	75" (1,905 mm)
Depth/with stock stop	34"/49.5" (864/1,257 mm)
Height (head-up)	64" (1,626 mm)
Height (head-down)	41" (1,041 mm)
Net Weight	926 lbs. (420 kg)
Shipping Weight	1,129 lbs. (512 kg)
Shipping Dim. (LxWxH)	78" x 36" x 46" (1,981 x 914 x 1,168 mm)

All specifications subject to change without notice or obligation.

CLAUSING 12" (305 mm) WET CUTTING SEMI-AUTOMATIC MITER BANDSAW

Features

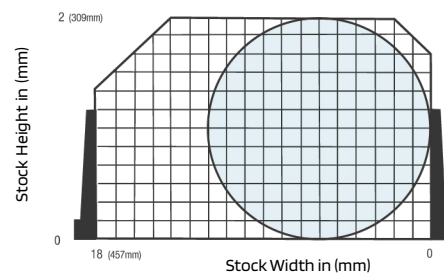
- 0°-45° Miter cutting, make angle cuts without swinging material to be cut
- 2 HP (1.5 kW) main drive motor with magnetic starter and overload protection
- Variable speed drive
- 230/460 V 60 cycle 3 phase electrics
- Recirculating coolant system with application through both guides
- Solid carbide blade guides with rollers
- Quick action vise
- Automatic shut-off at end of cut
- Totally enclosed transmission
- Blade cleaning brush
- Cast iron bed
- 1" (25 mm) wide blade
- Stock stop
- Easily adjusted head feed with hydraulic power head lift
- Two (2) year limited warranty

Accessories

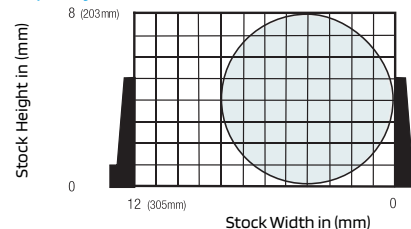
- P10-Stock Stand Assembly 21"-30"
- BT01-Bandsaw Blade Tension Gauge
- SA12-Roller Table Assembly 18" x 10'
- SA13-Roller Table Assembly 18" x 5'
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons

Cutting Capacities

Capacity at 90°



Capacity at 45°



Speed control and speed chart
on variable speed model KC12SA



CLAUSING 12" (305 mm) SEMI-AUTOMATIC BANDSAW

Designed for rugged production use, the Clausing KC12SA bandsaw offers high production output and heavy duty performance in semi-automatic operation.

Features

- 5 HP 230/460 V, 3 ph* drive motor
- Semi-automatic operation
- Infinitely variable blade speeds
- LED blade speed readout
- Vise clamps workpiece both sides of blade
- Powered hydraulic down feed
- Automatic height setting feature
- Auto shutoff at end of cuts
- Blade breakage/stoppage switch
- Hydraulic Blade Tension System
- 110 V control circuit
- Overload protection
- Recirculating coolant system
- (1) general purpose bi-metal blade
- (1) gallon coolant
- Stock stop assembly
- Tool Kit
- Flushing hose for cleanup
- Operator's manual
- Two (2) year limited warranty

Specifications

Model	KC12SA
Motor	5 HP (3.75 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	1 HP (.75 kW)
Hydraulic Oil Capacity	6.5 gallons (25 liters)
Band Wheel Diameter	16" (406 mm)
Blade Speeds (Variable Speed)	85–445 fpm (26–136 m/min)
Blade Size	1.25" x .042" x 150.4" (32 x 1 x 3,820 mm)
Coolant	Recirculating
Coolant Capacity	10 gallons (39 liters)
90° Cutting Capacity	
Round	12.75" (324 mm)
Rectangular (H x W)	12.75" x 12.6" (324 x 320 mm) 7.9" x 14.2" (201 x 361 mm)
**Bundle Cutting Width	6.5" to 10" (165 to 254 mm)
**Bundle Cutting Height	2" to 8" (51 to 203 mm)
Length	47" (1,194 mm)
Width	75" (1,905 mm)
Height (head-down)	61" (1,549 mm)
Height (head-up)	73" (1,854 mm)
Bed Height	29.5" (749 mm)
Net Weight	2,039 lbs. (925 kg)
Shipping Weight	2,260 lbs. (1,025 kg)

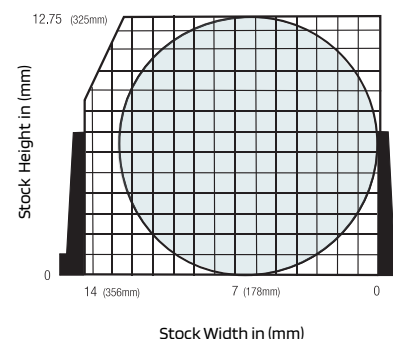
*Other voltages optional. **When machine is equipped with optional hydraulic bundle cutting attachment. All specifications subject to change without notice or obligation.

Accessories

- PT1-Stock Stand Assembly 29-1/2"–39-1/2"
- VP12SA-Variable Vise Pressure System 1 Vise
- KC12-SSTP- Extra Stock Stop Assembly
- CM1201-Chip Conveyor
- CM1202-Hydraulic Bundle Clamps
- SA20-Heavy-duty Roller Table 15" x 10'
- SA21-Heavy-duty Roller Table 15" x 5'
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons

Cutting Capacities

Capacity at 90°





Shown with optional Hydraulic Bundle Clamp and Variable Vise Pressure System

Specifications

Model	KC12AX
Motor	5 HP (3.75 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	1 HP (75 kW)
Hydraulic Oil Capacity	6.5 gallons (25 liters)
Band Wheel Diameter	16" (406 mm)
Blade Speeds (Variable Speed)	95–395 fpm (30–120 m/min)
Blade Size	1.25 x .042" x 150.4" (32 x 1 x 3,820 mm)
Coolant	Recirculating
Coolant Capacity	10 gallons (39 liters)
90° Cutting Capacity	
Round	12.75" (324 mm)
Rectangular (H x W)	12.75" x 12.6" (324 x 320 mm) 7.9" x 14.2" (201 x 361 mm)
Feed Accuracy	±.004"–.008" (±0.1–0.2 mm)
Length of Remnant Manual	.79" (20 mm)
Length of Remnant Automatic	1.97" (50 mm)
Minimum Cut Thickness	.354" (9 mm)
**Bundle Cutting Width	6.5" to 10" (165 to 254 mm)
**Bundle Cutting Height	2" to 8" (51 to 203 mm)
Feed Length/Index	15.75" (400 mm)
Max. Feed (9 times)	141.75" (3,600 mm)
Length	76.5" (1,943 mm)
Width	76.5" (1,943 mm)
Height (head-down)	57" (1,448 mm)
Height (head-up)	73" (1,854 mm)
Bed Height	26" (660 mm)
Net Weight	2,795 lbs. (1,268 kg)
Shipping Weight	2,945 lbs. (1,336 kg)
Shipping Dim. (LxWxH)	84" x 86" x 60" (2,134 mm x 2,184 mm x 1,524 mm)

*Other voltages optional. **When machine is equipped with optional hydraulic bundle cutting attachment. All specifications subject to change without notice or obligation.

CLAUSING 12" (305 mm) AUTOMATIC BANDSAW

Designed for rugged production use, the Clausing KC12AX bandsaw offers high production output and heavy duty performance in both semi-automatic and fully automatic operation. A powerful drive motor provides the power, and the optional hydraulic bundling attachment makes multiple cuts easy. The hydraulic shuttle feed system offers up to nine indexes.

Features

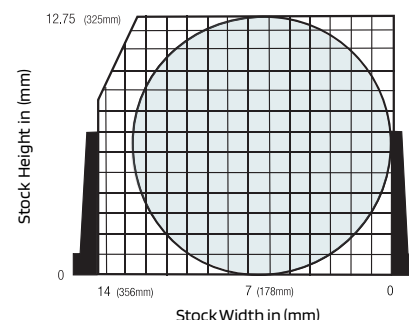
- Full or semi-automatic operation
- Infinitely variable blade speeds
- LED blade speed readout
- Vise clamps workpiece both sides of blade
- Hydraulic down feed
- Automatic height setting feature
- Auto shutoff at end of material or after preset number of cuts
- Front-mounted digital length gauge
- Blade breakage/stoppage switch
- 110 V control circuit
- Overload protection
- Recirculating coolant system
- Shuttle vise
- (1) General purpose bi-metal blade
- Operator's manual and Flushing hose for cleanup
- 1 Gallon coolant and tool Kit
- Two (2) year limited warranty

Accessories

- CM1201-Chip Conveyor
- CM1202-Hydraulic Bundle Clamps
- VP12- Variable Vise Pressure System
- SA20-Heavy-duty Roller Table 15"x 10'
- SA21-Heavy-duty Roller Table 15"x 5'
- P10-Stock Stand Assembly 21"–30"
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons

Cutting Capacities

Capacity at 90°





CLAUSING KALAMAZOO 12" (305 mm) AUTOMATIC NC BANDSAW

Features

- Oversized hydraulic cylinder
- Hydraulic shuttle vise assembly
- Inverter controlled infinitely variable speed
- Carbide blade guides with roller bearings
- Two additional guides to support the blade from the top
- Automatic hydraulic blade tensioning
- Power driven blade brushes
- Integral coolant system
- Smart NC-100 technology programmable up to 100 different jobs
- Easy recall and execution of stored parts
- Automatic shutoff after preset number of cuts or when out of stock
- 5.7" HMI touch screen incorporating readout on blade speed, blade life, feed vise position and error code display for self-diagnostics
- Automatic kerf loss compensation & computer controlled multiple indexing
- Precision feed pressure & feed rate
- Bundle/single cutting mode switch
- Automatic height setting feature
- Hydraulic front and rear vises
- Cast iron vises with replaceable hardened wear plates
- Discharge table with built-in coolant return
- Blade slippage or breakage detection
- Adjustable cut-off stock fence
- Additional flushing hose
- Bi-metal saw blade
- Built in work light
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	KC12NC
Motor	5 HP (3.75 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	1 HP (.75 kW)
Hydraulic Oil Capacity	6.6 gallons (25 liters)
Blade Speeds (Variable Speed)	66-330 fpm (20-101 m/min)
Blade Size	1.25" x .042" x 150.4" (32 x 1 x 3,820 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	11.9 gallons (45 liters)
90° Cutting Capacity	
Round	11.81" (300 mm)
Square	11.81" (300 mm)
Rectangular (H x W)	13.4" x 11.81" (340 x 300 mm)
Feed Accuracy	±.004" - .008" (±0.1-0.2 mm)
Length of Remnant Manual	.79" (20 mm)
Length of Remnant Automatic	1.97" (50 mm)
Minimum Cut Thickness	.354" (9 mm)
**Bundle Cutting Width	748" to 11.81" (190 to 300 mm)
**Bundle Cutting Height	2.75" to 5.51" (70 to 140 mm)
Feed Length/Index	15.86" (403 mm)
Max. Feed	650" (16,510 mm)
Length	84" (2,134 mm)
Width	86" (2,184 mm)
Height (head-up)	76.7" (1,948 mm)
Height (head-down)	60" (1,524 mm)
Bed Height	26" (660 mm)
Net Weight	2,977 lbs. (1,350 kg)
Shipping Weight	3,164 lbs. (1,435 kg)

*Other voltages optional. **When machine is equipped with optional hydraulic bundle cutting attachment. All specifications subject to change without notice or obligation.

Accessories

- CM1201N-Chip Conveyor
- CM1202N-Hydraulic Bundle Clamps
- VP12-Vise Press Regulator (factory installed)
- SA20-Heavy-duty Roller Table 15" x 10"
- SA21-Heavy-duty Roller Table 15"x 5"
- P10-Stock Stand Assembly 21"-30"
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons



CLAUSING 13" (330 mm) SEMI-AUTOMATIC SWIVEL HEAD MITER BANDSAW

Features

- Advanced hydraulic system provides dependable power for powered clamping and raising the saw head at end of cut
- Full stroke machine vise for tight clamping of any material from operator's panel
- Swivel saw head allows the operator to accurately pivot head for angle cuts from 0°, for a 90° cut, to 60°
- Carbide blade guides provide excellent stability for the saw blade
- Variable blade speed
- Power chip brush removes chips from the blade extending blade life
- Integrated coolant system
- Cast iron movable guide arms provide rigidity and stability for an accurate cut
- Flushing hose
- Adjustable work stop
- Tool box with tools
- Manual & parts list
- Two (2) year limited warranty

Specifications

Model	MS1318SA
Drive Motor	Drive Motor 3 HP (2.2 kw)
Hydraulic Motor	0.5 HP (.37 kW)
Hydraulic Oil Capacity	2.1 gallons (8 liters)
Coolant Motor	.125 HP (.09 kW)
Coolant Capacity	7.8 gallons (30 liters)
Blade Speeds (Inf. Variable)	98–328 fpm (30–100 m/min)
Blade Size	1" x .035" x 136" (25 x .9 x 3,454 mm)
Swivel Angle Range	0° to 60°
Cutting Capacity	
Round @ 90°	13" (330 mm)
Round @ 45°	11.8" (300 mm)
Round @ 60°	8.6" (218 mm)
Square @ 90°	11" (279 mm)
Square @ 45°	9.4" (239 mm)
Square @ 60°	8.6" (218 mm)
Rectangular @ 90°	11" x 17.3" (279 x 439 mm)
Rectangular @ 45°	11" x 9.4" (279 x 239 mm)
Rectangular @ 60°	11" x 8.6" (279 x 218 mm)
Bed Height	32.3" (820 mm)
Length	87.44" (2,221 mm)
Width	43.38" (1,102 mm)
Height	57.8" (1,468 mm)
Net Weight	1,782 lbs. (808 kg)
Shipping Weight	1,886 lbs. (855 kg)
Shipping Dim. (LxWxH)	86" x 47" x 64" (2,184 x 1,194 x 1,626 mm)

*Available in 3-phase 230v/460v only. All specifications subject to change without notice or obligation.

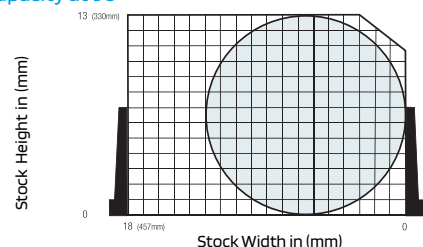
Available in Manual and Automatic Models

Accessories

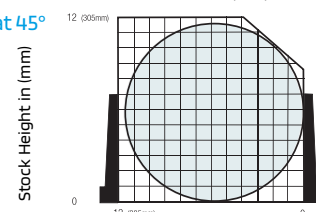
- P11-Stock Stand Assembly 29.5"–39.5"
- BT01-Bandsaw Blade Tension Gauge
- VP13SA-Variable Vise Pressure Regulator
- SA10-Roller Table Assembly 18" x 10'
- SA11-Roller Table Assembly 18" x 5'
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons

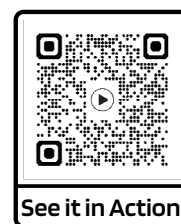
Cutting Capacities

Capacity at 90°



Capacity at 45°





CLAUSING KALAMAZOO 12.6" (320 mm) AUTOMATIC NC TWIN COLUMN BANDSAW

Features

- Oversized hydraulic cylinder
- Twin column design ensures rigid support during cutting cycle
- Hydraulic shuttle vise assembly
- Inverter controlled infinitely variable speed
- Carbide blade guides with roller bearings
- Two additional guides to support the blade from the top
- Automatic hydraulic blade tensioning
- Power driven blade brushes
- Integral coolant system
- Smart NC-100 technology programmable up to 100 different jobs
- Easy recall and execution of stored parts
- Automatic shutoff after preset number of cuts or when out of stock
- 5.7" HMI touch screen incorporating readout on blade speed, blade life, feed vise position and error code display for self-diagnostics
- Automatic kerf loss compensation & computer controlled multiple indexing
- Precision feed pressure & feed rate
- Bundle/single cutting mode switch
- Automatic height setting feature
- Hydraulic front and rear vises
- Cast iron vises with replaceable hardened wear plates
- Discharge table with built-in coolant return
- Blade slippage or breakage detection
- Adjustable cut-off stock fence
- Additional flushing hose
- Bi-metal saw blade
- Built in work light
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	H1315NC
Motor	5 HP (3.75 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	1 HP (.75 kW)
Hydraulic Oil Capacity	6.6 gallons (25 liters)
Blade Speeds (Variable Speed)	49–262 fpm (15–80 m/min)
Blade Size	1.25" x .042" x 166.9" (32 x 1 x 4,239 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	11.9 gallons (45 liters)
90° Cutting Capacity	
Round	12.6" (320 mm)
Square	12.6" (320 mm)
Rectangular (H x W)	15" x 12.6" (381 x 320 mm)
Feed Accuracy	±.004"–.008" (±0.1–0.2 mm)
Length of Remnant Manual	.59" (15 mm)
Length of Remnant Automatic	1.97" (50 mm)
Minimum Cut Thickness	.197" (5 mm)
**Bundle Cutting Width	7.48" to 11.81" (190 to 300 mm)
**Bundle Cutting Height	2.75" to 5.51" (70 to 140 mm)
Feed Length/Index	15.86" (403 mm)
Max. Feed	255.9" (6,500 mm)
Length	79.13" (2,010 mm)
Width	78.75" (2,000 mm)
Height	70.3" (1,786 mm)
Bed Height	31.1" (790 mm)
Net Weight	3,509 lbs. (1,592 kg)
Shipping Weight	3,766 lbs. (1,708 kg)

*Other voltages optional. **When machine is equipped with optional hydraulic bundle cutting attachment. All specifications subject to change without notice or obligation.

Accessories

- CM1301N–Chip Conveyor
- CM1302N–Hydraulic Bundle Clamps
- VP13NC–Vise Press Regulator
- H13-BDD– Blade Deviation Detector
- SA20–Heavy-duty Roller Table 15" x 10'
- SA21–Heavy-duty Roller Table 15" x 5'
- PT1–Stock Stand Assembly 29.5"–39.5"
- CSR1 SAWZIT 1 Gallon
- CSR5 SAWZIT 5 Gallons



CLAUSING KALAMAZOO 13" (330 mm) AUTOMATIC NC SWIVEL HEAD MITER BANDSAW

Features

- The swivel saw head allows cutting at any angle between 90° (straight cut) and 45° (miter cut)
- Precision pivot system facilitates easy and accurate adjustment for angle cuts
- Inverter controlled infinitely variable speed
- Carbide blade guides with roller bearings
- Two additional guides to support the blade from the top
- Automatic hydraulic blade tensioning
- Power driven blade brushes
- Integral coolant system
- Smart NC-100 technology programmable up to 100 different jobs
- Easy recall and execution of stored parts
- Automatic shutoff after preset number of cuts or when out of stock
- 5.7" HMI touch screen incorporating readout on blade speed, blade life, feed vise position and error code display for self-diagnostics
- Automatic kerf loss compensation & computer controlled multiple indexing
- Precision feed pressure & feed rate
- Automatic height setting feature
- Hydraulic front and rear vises
- Cast iron vises with replaceable hardened wear plates
- Computer controlled multiple indexing
- Discharge table with built-in coolant return
- Blade slippage or breakage detection
- Additional flushing hose
- Bi-metal saw blade
- Built in work light
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Model	MS1319NC
Motor	5 HP (3.75 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	1 HP (.75 kW)
Hydraulic Oil Capacity	10.4 gallons (40 liters)
Blade Speeds (Variable Speed)	66–330 fpm (20–101 m/min)
Blade Size	1.25" x .042" x 193" (32 x 1 x 4,902 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	14.3 gallons (55 liters)
90° Cutting Capacity	
Round	13" (330 mm)
Rectangular (H x W)	11" x 19.68" (279 x 500 mm)
45° Cutting Capacity	
Round	11.5" (292 mm)
Rectangular (H x W)	10.43" x 10.43" (265 x 265 mm)
Feed Accuracy	±.004"–.008" (±0.1–0.2 mm)
Length of Remnant Manual	2.75" (70 mm)
Length of Remnant Automatic	9.84" (250 mm)
Minimum Cut Thickness	.126" (3.2 mm)
Feed Length/Index	23.9" (607 mm)
Max. Feed	255.9" (6,500 mm)
Length	114" (2,896 mm)
Width	102" (2,591 mm)
Height	86.6" (2,200 mm)
Bed Height	30.8" (783 mm)
Net Weight	3,300 lbs. (1,497 kg)
Shipping Weight	3,745 lbs. (1,699 kg)

*Other voltages optional. All specifications subject to change without notice or obligation.

Accessories

- CM1301M–Chip Conveyor
- CM1302M–Hydraulic Bundle Clamps
- VP13NCS–Vise Press Regulator (Factory Installed)
- SA22–Heavy-duty Roller Table 19" x 10'
- SA23–Heavy-duty Roller Table 19" x 5'
- P11–Stock Stand Assembly 29.5"–39.5"
- CSR1–SAWZIT 1 Gallon
- CSR5–SAWZIT 5 Gallons



CLAUSING KALAMAZOO 16.5" (420 mm) AUTOMATIC NC TWIN COLUMN BANDSAW

Features

- Oversized hydraulic cylinder
- Twin column design ensures rigid support during cutting cycle
- Hydraulic shuttle vise assembly
- Inverter controlled infinitely variable speed
- Carbide blade guides with roller bearings
- Two additional guides to support the blade from the top
- Automatic hydraulic blade tensioning
- Power driven blade brushes
- Integral coolant system
- Smart NC-100 technology programmable up to 100 different jobs
- Easy recall and execution of stored parts
- Automatic shutoff after preset number of cuts or when out of stock
- 5.7" HMI touch screen incorporating readout on blade speed, blade life, feed vise position and error code display for self-diagnostics
- Automatic kerf loss compensation & computer controlled multiple indexing
- Precision feed pressure & feed rate
- Bundle/single cutting mode switch
- Automatic height setting feature
- Hydraulic front and rear vises
- Cast iron vises with replaceable hardened wear plates
- Discharge table with built-in coolant return
- Blade slippage or breakage detection
- Adjustable cut-off stock fence
- Additional flushing hose
- Bi-metal saw blade
- Built in work light
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	H1616NC
Motor	7.5 HP (5.6 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	2 HP (1.5 kW)
Hydraulic Oil Capacity	10.5 gallons (40 liters)
Blade Speeds (Variable Speed)	57–378 fpm (17–115 m/min)
Blade Size	1.5" x .05" x 1878" (38 x 1.3 x 4,770 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	22.5 gallons (85 liters)
90° Cutting Capacity	
Round	16.5" (419 mm)
Square	16.5" (419 mm)
Rectangular (H x W)	16.5" x 16.5" (419 x 419 mm)
Feed Accuracy	±.004"–.008" (±0.1–0.2 mm)
Length of Remnant Manual	.79" (20 mm)
Length of Remnant Automatic	2.55" (65 mm)
Minimum Cut Thickness	.197" (5 mm)
**Bundle Cutting Width	748" to 14.17" (190 to 360 mm)
**Bundle Cutting Height	3.94" to 7.08" (100 to 180 mm)
Feed Length/Index	19.8" (503 mm)
Max. Feed	255.9" (6,500 mm)
Length	110.4" (2,804 mm)
Width	100.8" (2,560 mm)
Height	74.4" (1,890 mm)
Bed Height	28.5" (724 mm)
Net Weight	4,673 lbs. (2,120 kg)
Shipping Weight	4,901 lbs. (2,223 kg)

*Other voltages optional. **When machine is equipped with optional hydraulic bundle cutting attachment. All specifications subject to change without notice or obligation.

Accessories

- CM1601NC-Chip Conveyor
- CM1602NC-Hydraulic Bundle Clamps
- VP16NC-Vise Press Regulator
- SA22-Heavy-duty Roller Table 19" x 10'
- SA23-Heavy-duty Roller Table 19" x 5'
- P10-Stock Stand Assembly 21"–30"
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons



CLAUSING KALAMAZOO 16" (420 mm) SEMI-AUTOMATIC BANDSAW

Features

- Twin column design ensures rigid support during cutting cycle by keeping the blade parallel and square to the workpiece
- Infinitely variable speed
- Blade deviation detection
- Digital blade speed indicator
- Carbide blade guides with roller bearings
- Two additional guides to support the blade from the top
- Automatic hydraulic blade tensioning
- Power driven blade brushes
- Integral coolant system
- LCD digital blade speed monitor
- Precision feed pressure & feed rate
- Cast iron vises with replaceable hardened wear plates
- Discharge table with built-in coolant return
- Blade slippage or breakage detection
- Additional flushing hose
- Bi-metal saw blade
- Built in work light
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	H1621SA
Motor	Motor 7.5 HP (5.5 kw), 230/460 V, 3 ph*
Hydraulic Pump Motor	2 HP (1.5 kw)
Hydraulic Oil Capacity	10 gal (40 liters)
Blade Speeds (Variable Speed)	66–328 fpm (20–100 m/min)
Blade Size	1.5" x .050" x 208.7" (38 x 1.3 x 5,301 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	21.25 gal (85 liters)
90° Cutting Capacity	
Round	16.5" (419 mm)
Square	16.5" (419 mm)
Rectangular (H x W)	16.5" x 21.6" (419 x 549 mm)
Length	109.7" (2,786 mm)
Width	43.7" (1,110 mm)
Height	72.6" (1,844 mm)
Bed Height	27.5" (699 mm)
Net Weight	4,188 lbs. (1,900 kg)
Shipping Weight	4,629 lbs. (2,100 kg)

*Other voltages optional. All specifications subject to change without notice or obligation.

Accessories

- CM1601H–Chip Conveyor
- CM1602H–Hydraulic Bundle Clamp
- VP16SA–Vise Pressure Regulator Single Vise
- SA24–Heavy-duty Roller Table 21" x 10'
- SA25–Heavy-duty Roller Table 21" x 5'
- P10–Stock Stand Assembly 21"–30"
- CSR1–SAWZIT 1 Gallon
- CSR5–SAWZIT 5 Gallons



CLAUSING KALAMAZOO 16.5" (420 mm) SEMI-AUTOMATIC HYDRAULIC SWIVEL HEAD MITER BANDSAW

Features

- Swivel saw head mitering from 90° to 60°
- Rigid and heavy-duty pivot and trunnion
- Sturdy cast work table
- 24.5" solid discharge table with coolant return
- Variable speeds from 66 thru 330 fpm
- Carbide blade guides with roller bearings
- Two additional bearings to support blade from the top
- Cast iron guide arm supported by heavy-duty cast iron dovetail
- Automatic hydraulic blade tensioning
- Integral coolant system
- Synchronized blade brush
- Precision feed pressure & feed rate dual valve system
- Conveniently designed control station
- Electrical components located inside the control box with main lockout disconnect
- Work height selector
- Industrial rated hydraulic components
- 36" infeed roller table
- Full stroke machine vises
- Breakage detector
- Built-in adjustable material stop
- Adjustable work light
- Additional flushing hose
- Bi-metal saw blade
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	MS1625SA
Motor	5 HP (3.75 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	1 HP (.75 kW)
Hydraulic Oil Capacity	11.7 gallons (45 liters)
Blade Speeds (Variable Speed)	66–328 fpm (20–100 m/min)
Blade Size	1.25" x .042" x 209" (32 x 1 x 5,309 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	15.6 gallons (60 liters)
90° Cutting Capacity	
Round	16.5" (419 mm)
Rectangular (H x W)	15" x 26.6" (381 x 676 mm)
45° Cutting Capacity	
Round	16" (406 mm)
Rectangular (H x W)	16" x 16" (406 x 406 mm)
60° Cutting Capacity	
Round	10" (254 mm)
Rectangular (H x W)	16" x 10" (406 x 254 mm)
Length	90.6" (2,301 mm)
Width	114" (2,896 mm)
Height	98.4" (2,499 mm)
Bed Height	29.5" (749 mm)
Net Weight	3,300 lbs (1,497 kg)
Shipping Weight	3,960 lbs. (1,796 kg)

*Other voltages optional. All specifications subject to change without notice or obligation.

Accessories

- CM1601M–Chip Conveyor
- CM1602M–Hydraulic Bundle Clamp
- VP16SAS–Vise Pressure Regulator Single Vise
- SA26–Heavy-duty Roller Table 25" x 10'
- SA27–Heavy-duty Roller Table 25" x 5'
- P10–Stock Stand Assembly 21"–30"
- CSR1–SAWZIT 1 Gallon
- CSR5–SAWZIT 5 Gallons



CLAUSING KALAMAZOO 16" (420 mm) SEMI-AUTOMATIC BANDSAW

Features

- Twin column design ensures rigid support during cutting cycle by keeping the blade parallel and square to the work piece
- Infinitely variable speed
- Digital blade speed indicator
- Carbide blade guides with roller bearings
- Two additional guides to support the blade from the top
- Automatic hydraulic blade tensioning
- Power driven blade brushes
- Integral coolant system
- Automatic shut-off at end of material or after preset number of cuts
- Precision feed pressure & feed rate
- Cast iron vises with replaceable hardened wear plates
- Discharge table with built-in coolant return
- Blade slippage or breakage detection
- Additional flushing hose
- Bi-metal saw blade
- Built in work light
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	H1628SA
Motor	Motor 7.5 Hp (5.5 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	1 HP (.75 kW)
Hydraulic Oil Capacity	13 gallons (50 liters)
Blade Speeds (Variable Speed)	66–328 fpm (20–100 m/min)
Blade Size	1.5" x .05" x 215" (38 x 1.3 x 5,461 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	10.4 gallons (40 liters)
90° Cutting Capacity	
Round	16.5" (419 mm)
Square	13.8" (351 mm)
Rectangular (H x W)	13.8" x 27.5" (351 x 699 mm)
Length	47" (1,194 mm)
Width	108" (2,743 mm)
Height	84.2" (2,139 mm)
Bed Height	27.5" (699 mm)
Net Weight	4,440 lbs. (2,014 kg)
Shipping Weight	4,720 lbs. (2,141 kg)

*Other voltages optional. All specifications subject to change without notice or obligation.

Accessories

- CM1601HA-Chip Conveyor
- CM1602HA-Hydraulic Bundle Clamp
- VP16HA-Vise Pressure Regulator Single Vise
- SA26-Heavy-duty Roller Table 25"-10'
- SA27-Heavy-duty Roller Table 25"-5'
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons



CLAUSING KALAMAZOO 18" (460 mm) AUTOMATIC BANDSAW

Features

- Oversized hydraulic cylinder
- Hydraulic shuttle vise assembly
- Inverter controlled infinitely variable speed
- Carbide blade guides with roller bearings
- Two additional guides to support the blade from the top
- Automatic hydraulic blade tensioning
- Power driven blade brushes
- Integral coolant system
- Smart NCC-100 technology programmable up to 100 different jobs,
- easy recall and execution of stored parts
- Automatic shutoff after preset number of cuts or when out of stock
- 5.7" HMI touch screen incorporating readout on blade speed, blade life, feed vise position and error code display for self-diagnostics
- Automatic kerf loss compensations & computer controlled multiple indexing
- Precision feed pressure & feed rate
- Bundle/single cutting mode switch
- Automatic height setting feature
- Hydraulic front and rear vises
- Cast iron vises with replaceable hardened wear plates
- Discharge table with built-in coolant return
- Blade slippage or breakage detection
- Adjustable cut-off stock fence
- Additional flushing hose
- Bi-metal saw blade
- Built in work light
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	KC18NC
Motor	7.5 HP (5.6 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	2 HP (1.5 kW)
Hydraulic Oil Capacity	10.6 gallons (40 liters)
Blade Speeds (Variable Speed)	66–328 fpm (20–100 m/min)
Blade Size	1.5" x .05" x 184" (38 x 1.3 x 4,674 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	21 gallons (80 liters)
90° Cutting Capacity	
Round	18" (457 mm)
Square	18" (457 mm)
Rectangular (H x W)	18" x 18" (457 x 457 mm)
Feed Accuracy	±.004"–.008" (±0.1–0.2 mm)
Length of Remnant Manual	.79" (20 mm)
Length of Remnant Automatic	2.95" (75 mm)
Minimum Cut Thickness	.197" (5 mm)
Feed Length/Index	23.3" (592 mm)
Max. Feed	252.6" (6,416 mm)
Length	96.4" (2,449 mm)
Width	90.9" (2,309 mm)
Height (head-up)	90.9" (2,309 mm)
Bed Height	29.5" (749 mm)
Net Weight	6,380 lbs. (2,894 kg)
Shipping Weight	6,850 lbs. (3,107 kg)

*Other voltages optional. All specifications subject to change without notice or obligation.

Accessories

- P10-Stock Stand Assembly 21"–30"
- H18-BDD- Blade Deviation Detector (factory order)
- CM1801NC-Chip Conveyor
- CM1802NC-Hydraulic Bundle Clamps
- VP18NC-Vise Press Regulator
- SA22-Heavy-duty Roller Table 19" x 10'
- SA23-Heavy-duty Roller Table 19" x 15'
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons

CLAUSING KALAMAZOO 19" (483 mm) SEMI-AUTOMATIC HYDRAULIC DOUBLE MITER SWIVEL HEAD BANDSAW



Specifications

Model	MSD1928SA
Motor	75 HP (5.6 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	1 HP (.75 kW)
Hydraulic Oil Capacity	91 gallons (35 liters)
Blade Speeds (Variable Speed)	83–330 fpm (25–100 m/min)
Blade Size	1.5" x .050" x 257.5" (38 x 1.3 x 6,541 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	13 gallons (50 liters)
90° Cutting Capacity	
Round	19" (483 mm)
Rectangular (H x W)	16.5" x 28" (419 x 711 mm)
45° Cutting Capacity	
Round	16.5" (419 mm)
Rectangular (H x W)	16.5" x 17.7" (419 x 450 mm)
60° Cutting Capacity	
Round	11.8" (300 mm)
Rectangular (H x W)	16.5" x 11.8" (419 x 300 mm)
Length	130.3" (3,310 mm)
Width	135.8" (3,449 mm)
Height	88.6" (2,250 mm)
Bed Height	25.8" (655 mm)
Net Weight	6,100 lbs (2,767 kg)
Shipping Weight	6,380 lbs. (2,894 kg)

*Other voltages optional. All specifications subject to change without notice or obligation.

Features

- Voltage 230 Volt 3 phase (all other voltage will require special order or a transformer)
- 5.7" HMI touch screen controller
- Double swivel saw head mitering from 90° to +/- 45° to +/- 60°
- Rigid, oversize linear guides precision ground to ensure smooth hydraulically driven consistent feed rate of the cutting head
- Guide Arm travels along one linear guide and moves in sync with the full stroke hydraulic vise to always be at the best location possible when cutting
- 10 degree blade cant for longer blade life
- Fast accurate mitering via automatic angle positioning through the HMI touch screen with 0.1° accuracy
- Hydraulic angle lock-down device
- Specially designed gearbox for smooth and powerful cutting
- Heavy duty inverter blade drive system with variable blade speed control
- Carbide blade guides
- Two additional guide bearings for extra support of the blade
- Automatic hydraulic blade tensioning device
- Integral coolant system
- Synchronized power driven blade brush
- Precision feed pressure & feed rate dual valve system
- Proximity switch for sensing blade slippage or breakage
- Electrical and hydraulic safety interlock
- Conduits protection measure
- "Alert Orange" safety measure
- Blade "clip" device for easy blade change
- Bi-metal saw blade
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Accessories

- CM1901MD-Hydraulic Chip Conveyor
- CM1902MD-Hydraulic Bundling Clamps
- VP1901NC-Vise Pressure Regulator Single Vise (Factory Install)
- MS19-AMP- Motor Load Meter (Factory Install)
- MS19-SHD- Stock Height Detector (Factory Install)
- MS19-BDD- Blade Deviation Detector (Factory Install)
- MS19-AWR- Automatic Wedging Resistance (Factory Install)
- SA26-Heavy-duty Roller Table 25" x 10'
- SA27-Heavy-duty Roller Table 25" x 5'
- P10-Stock Stand Assembly 21"-30"
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons



CLAUSING KALAMAZOO 20.5" (520 mm) AUTOMATIC NC TWIN COLUMN BANDSAW

Features

- Oversized hydraulic cylinder
- Hydraulic shuttle vise assembly
- Inverter controlled infinitely variable speed
- Carbide blade guides with roller bearings
- Two additional guides to support the blade from the top
- Automatic hydraulic blade tensioning
- Power driven blade brushes
- Integral coolant system
- Smart NC-100 technology programmable up to 100 different jobs
- Easy recall and execution of stored parts
- Automatic shutoff after preset number of cuts or when out of stock
- 5.7" HMI touch screen incorporating readout on blade speed, blade life, feed vise position and error code display for self-diagnostics
- Automatic kerf loss compensation & computer controlled multiple indexing
- Precision feed pressure & feed rate
- Bundle/single cutting mode switch
- Automatic height setting feature
- Hydraulic front and rear vises
- Cast iron vises with replaceable hardened wear plates
- Discharge table with built-in coolant return
- Blade slippage or breakage detection
- Adjustable cut-off stock fence
- Additional flushing hose
- Bi-metal saw blade
- Built in work light
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	H2022NC
Motor	7.5 HP (5.6 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	2 HP (1.5 kW)
Hydraulic Oil Capacity	10.5 gallons (40 liters)
Blade Speeds (Variable Speed)	66–328 fpm (20–100 m/min)
Blade Size	2" x .06" x 238" (51 x 1.5 x 6,045 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	22.5 gallons (85 liters)
90° Cutting Capacity	
Round	20.5" (521 mm)
Square	20.5" (521 mm)
Rectangular (H x W)	22" x 20.5" (559 mm x 521 mm)
Feed Accuracy	±.004"–.008" (±0.1–0.2 mm)
Length of Remnant Manual	.79" (20 mm)
Length of Remnant Automatic	3.93" (100 mm)
Minimum Cut Thickness	.394" (10 mm)
**Bundle Cutting Width	9.84" to 18.5" (250 to 470 mm)
**Bundle Cutting Height	5.9" to 12.4" (150 to 315 mm)
Feed Length/Index	19.8" (503 mm)
Max. Feed	198" (5,029 mm)
Length	125" (3,175 mm)
Width	89" (2,261 mm)
Height	89" (2,261 mm)
Bed Height	272" (691 mm)
Net Weight	6,930 lbs. (3,143 kg)
Shipping Weight	7,326 lbs. (3,323 kg)

*Other voltages optional. **When machine is equipped with optional hydraulic bundle cutting attachment. All specifications subject to change without notice or obligation.

Accessories

- CM2001N-Chip Conveyor
- CM2002N-Bundle Cutting Attachment
- VP20NC-Vise Press Regulator
- SA26-Heavy-duty Roller Table 25"x10'
- SA27-Heavy-duty Roller Table 25"x5'
- H20-BDD- Blade Deviation Detector (Factory Install)
- P10-Stock Stand Assembly 21"–30"
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons



CLAUSING KALAMAZOO 20" (500 mm) SEMI- AUTOMATIC BANDSAW

Features

- Twin column design ensures rigid support during cutting cycle by keeping the blade parallel and square to the workpiece
- Infinitely variable speed
- Digital blade speed indicator
- Carbide blade guides with roller bearings
- Two additional guides to support the blade from the top
- Automatic hydraulic blade tensioning
- Power driven blade brushes
- Integral coolant system
- Last cut selector switch
- LCD digital blade speed monitor
- Precision feed pressure & feed rate
- Cast iron vises with replaceable hardened wear plates
- Discharge table with built-in coolant return
- Blade slippage or breakage detection
- Additional flushing hose
- Bi-metal saw blade
- Built in work light
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	H2030SA
Motor	7.5 HP (5.5 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	2 HP (.75 kW)
Hydraulic Oil Capacity	10 gallons (40 liters)
Blade Speeds (Variable Speed)	66-328 fpm (20-100 m/min)
Blade Size	2" x .063" x 238" (51 x 1.6 x 6,045 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	21.5 gallons (85 liters)
90° Cutting Capacity	
Round	20" (508 mm)
Square	20" (508 mm)
Rectangular (H x W)	20" x 29.5" (508 x 749.3 mm)
Length	122.9" (3,122 mm)
Width	42.2" (1,072 mm)
Height	82.1" (2,085 mm)
Bed Height	27.5" (699 mm)
Net Weight	5,016 lbs. (2,275 kg)
Shipping Weight	5,720 lbs. (2,595 kg)

*Other voltages optional. All specifications subject to change without notice or obligation.

Accessories

- CM2001H-Chip Conveyor
- CM2002H-Hydraulic Bundle Clamp
- VP20SA- Vise Pressure Regulator Single Vise
- SA26-Heavy-duty Roller Table 25"-10'
- SA27-Heavy-duty Roller Table 25"-5'
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons



CLAUSING KALAMAZOO 24" (610 mm) AUTOMATIC NC TWIN COLUMN BANDSAW

Features

- Oversized Precision ground, Large dual columns
- Cross link connecting two columns for enhanced structural strength
- Specially designed gearbox for high lateral pressure
- Heavy duty inverter blade drive system
- LED Speed Indicator
- Cam Lock Carbide blade guides with bearing guides
- Two additional guides to support the blade from the top
- Automatic hydraulic blade tensioning device
- Integral coolant system
- Synchronized power driven blade brush
- Smart NC-100 technology programmable up to 100 different jobs
- Ergonomically located independent control station
- Precision feed pressure & feed rate dual valve system
- "Last cut" or "keep on" selector
- Split vise Jaws
- Full stroke ductile cast iron vise
- NC Controlled multiple indexing for long cutting lengths up to 650"
- Ductile Cast Iron vises with replaceable hardened wear plates
- Proximity switch for sensing blade slippage or breakage
- Blade "clip" device for easy blade change
- Discharge roller work bed with built-in coolant return
- Additional flushing hose
- Bi-metal saw blade
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	H2430NC
Motor	10 HP (7.5 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	2 HP (1.5 kW)
Hydraulic Oil Capacity	10.5 gallons (40 liters)
Blade Speeds (Variable Speed)	66–328 fpm (20–100 m/min)
Blade Size	2" x .06" x 283" (51 x 1.5 x 7,188 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	22.5 gallons (85 liters)
90° Cutting Capacity	
Round	24.4" (620 mm)
Square	24.4" x 24.4" (620 x 620 mm)
Rectangular (H x W)	24.4" x 30" (620 x 762 mm)
Feed Accuracy	±.004"–.008" (±0.1–0.2 mm)
Length of Remnant Manual	.79" (20 mm)
Length of Remnant Automatic	6.49" (165 mm)
Minimum Cut Thickness	.551" (14 mm)
**Bundle Cutting Width	27.5" (699 mm) Max
**Bundle Cutting Height	15.3" (389 mm) Max
Feed Length/Index	19.7" (500 mm)
Max. Feed	999" (25,375 mm)
Length	160.5" (4,077 mm)
Width	82.4" (2,093 mm)
Height	94.1" (2,390 mm)
Bed Height	23.6" (599 mm)
Net Weight	10,582 lbs. (4,800 kg)
Shipping Weight	11,904 lbs. (5,400 kg)

*Other voltages optional. **When machine is equipped with optional hydraulic bundle cutting attachment. All specifications subject to change without notice or obligation.

Accessories

- CM2401NC-Chip Conveyor
- CM2402NC-Hydraulic Bundle Clamps
- VP24NC-Vise Press Regulator
- H24-AMP- Motor Lead Meter (factory installed)
- H24-SHD- Stock Height Detector (factory installed)
- H24-BDD- Blade Deviation Detector (factory installed)
- H24-AWR- Automatic Wedging Resistance (factory installed)
- SA26-Heavy-duty Roller Table 25" x 10'
- SA27-Heavy-duty Roller Table 25" x 5'
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons



CLAUSING KALAMAZOO 24" (620 mm) SEMI-AUTOMATIC BANDSAW

Features

- Oversized precision ground, large dual columns
- Cross link connecting two columns for enhanced structural strength
- Specially designed gearbox for high lateral pressure
- Heavy-duty inverter blade drive system
- LED speed indicator
- Cam lock carbide blade guides with bearing guides
- Two additional guides to support the blade from the top
- Automatic hydraulic blade tensioning device
- Integral coolant system
- Synchronized power driven blade brush
- PLC control
- Ergonomically located independent control station
- Precision feed pressure & feed rate dual valve system
- Work height selector & air gap eliminator
- "Last cut" or "keep on" selector
- Split vise jaws
- Full stroke ductile cast iron split vise
- Hydraulically powered in-feed lift roller for forward and backward feeding
- Ductile cast iron vises with replaceable hardened wear plates
- Proximity switch for sensing blade slippage or breakage
- Blade "clip" device for easy blade change
- Discharge roller work bed with built-in coolant return
- Additional flushing hose
- Bi-metal saw blade
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

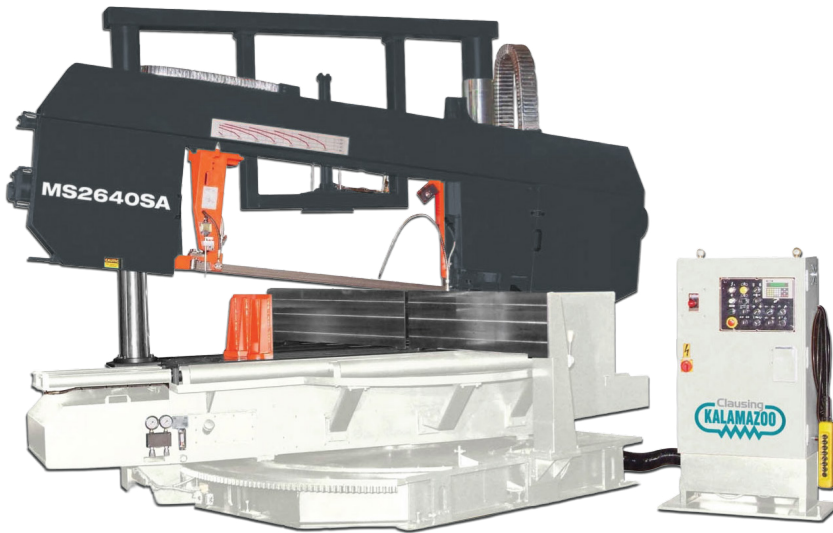
Specifications

Model	H2430SA
Motor	10 HP (7.3 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	2 HP (1.5 kW)
Hydraulic Oil Capacity	12.5 gallons (50 liters)
Blade Speeds (Variable Speed)	66-328 fpm (20-100 m/min)
Blade Size	2" x .063" x 283" (51 x 1.6 x 7,188 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	25 gallons (100 liters)
90° Cutting Capacity	
Round	24.4" (620 mm)
Square	24.4" (620 mm)
Rectangular (H x W)	24.4" x 30" (620 x 762 mm)
Length	47.2" (1,198 mm)
Width	140" (3,556 mm)
Height	93" (2,362 mm)
Bed Height	23.6" (600 mm)
Net Weight	7,700 lbs. (3,493 kg)
Shipping Weight	8,580 lbs. (3,892 kg)

*Other voltages optional. All specifications subject to change without notice or obligation.

Accessories

- VP24SA-Vise Pressure Regulator Single Vise
- CM2401H-Chip Conveyor
- CM2402H-Hydraulic Bundle Clamp
- SA26-Heavy-duty Roller Table 25"-10'
- SA27-Heavy-duty Roller Table 25"-5"
- CSRT-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons



CLAUSING KALAMAZOO 26" (660 mm) SEMI-AUTOMATIC HYDRAULIC SWIVEL HEAD MITER BANDSAW

Features

- Swivel saw head mitering from 90° to 60°
- Precision ground, oversized round column design
- 7.5 degree blade cant for longer blade life
- Heavy duty, rigid saw frame supported by two large bore hydraulic cylinders
- Cross link connecting the two columns for enhanced structural strength
- 45 degree forward & backward swivel with automatic angle lock-in
- Specially designed gearbox for smooth and powerful cutting
- Heavy-duty inverter blade drive system
- Easy-to-read LED speed indicator
- Hydraulically operated carbide blade guides
- Two additional guide bearings for extra support of the blade
- Automatic hydraulic blade tensioning device
- Hydraulically actuated guide arm
- Integral coolant system
- Synchronized power driven blade brush
- Independent control station
- Precision feed pressure & feed rate dual valve system
- "Shut off" or "keep on" selector switch
- Vise pressure detector
- Hydraulically powered material infeed lift roller
- Idle roller work table for material feeding
- Light projection for precise length measurement
- Two full stroke cylinder vises
- Proximity switch for sensing blade slippage or breakage
- Electrical and hydraulic safety interlock
- Conduits protection
- Bi-metal saw blade
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	MS2640SA
Motor	10 HP (7.5 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	3 HP (2.25 kW)
Hydraulic Oil Capacity	15.6 gallons (60 liters)
Blade Speeds (Variable Speed)	49–295 fpm (15–90 m/min)
Blade Size	2" x .063" x 326.8" (51 x 1.6 x 8,301 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	26 gallons (100 liters)
90° Cutting Capacity	
Round	26" (660 mm)
Rectangular (H x W)	20.5" x 40" (521 x 1,016 mm)
45° Cutting Capacity	
Round	23" (584 mm)
Rectangular (H x W)	20.5" x 24.4" (521 x 620 mm)
60° Cutting Capacity	
Round	15.7" (399 mm)
Rectangular (H x W)	21.3" x 15.7" (541 x 399 mm)
Length	148" (3,759 mm)
Width	154" (3,912 mm)
Height	109" (2,769 mm)
Bed Height	31.9" (810 mm)
Net Weight	9,460 lbs. (4,291 kg)
Shipping Weight	12,254 lbs. (5,558 kg)

*Other voltages optional. All specifications subject to change without notice or obligation.

Accessories

- CM2601M-Chip Conveyor
- CM2602M-Hydraulic Bundle Clamp
- VP26SAS-Vise Pressure Regulator Single Vise
- P11-Stock Stand Assembly 29.5"–39.5"
- SA28- H.D. Roll Table 33" x 5' x (24"-32") 3" Ctr.
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons



CLAUSING KALAMAZOO 31.6" (800 mm) SEMI-AUTOMATIC BANDSAW

Features

- The extra heavy-duty saw frame is supported by two large bore hydraulic cylinders, providing unsurpassed rigidity, and the smoothest cutting possible
- Dual Column design with precision ground columns ensures smooth saw frame movement and consistent cutting force throughout the cutting cycle
- Large diameter cast iron band wheels
- Inverter drive with infinitely variable blade speeds with blade speed indicator
- Hydraulic controlled tungsten carbide blade guide
- Groove shaped designed blade guides
- Hydraulic controlled blade tension device
- Hydraulic driven guide arm
- Proximity switch for sensing blade slippage or breakage
- Independent wire brush drive system
- 'Auto shut off' function automatically stops the machine and shuts down the hydraulic system at the end of the last cut
- Two full stroke cylinder vises
- Discharge table with built-in coolant return
- Heavy-duty machine structure design for heavy cutting jobs
- Precise flow control valve to finely adjust the cutting speed
- Additional flushing hose
- Bi-metal saw blade
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	H3140SA
Motor	15 HP (11.2 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	3 HP (2.2 kW)
Hydraulic Oil Capacity	26 gallons (100 liters)
Blade Speeds (Variable Speed)	49-264 fpm (15-80 m/min)
Blade Size	2.5" x .063" x 346.5" (64 x 1.6 x 8,801 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	32 gallons (120 liters)
90° Cutting Capacity	
Round	31.5" (800 mm)
Square	31.5" (800 mm)
Rectangular (H x W)	31.5" x 39.4" (800 x 1,001 mm)
Length	90" (2,286 mm)
Width	169" (4,293 mm)
Height	105" (2,667 mm)
Bed Height	25.2" (640 mm)
Net Weight	22,000 lbs. (9,979 kg)
Shipping Weight	23,320 lbs. (10,578 kg)

*Other voltages optional. All specifications subject to change without notice or obligation.

Accessories

- CM3101H-Chip Conveyor
- CM3102H-Hydraulic Bundle Clamp
- VP31SA-Vise Pressure Regulator Single Vise
- SA28- H.D. Roll Table 33" x 5' x (24"-32") 3" Ctr.
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons

CLAUSING KALAMAZOO 43.3" (1,100 mm) SEMI-AUTOMATIC BANDSAW

Features

- The extra heavy-duty saw frame is supported by two large bore hydraulic cylinders, providing unsurpassed rigidity, and the smoothest cutting possible
- Dual Column design with precision ground columns ensures smooth saw frame movement and consistent cutting force throughout the cutting cycle
- Specially designed planetary gear reducer for optimum mechanical efficiency
- Inverter controlled infinitely variable blade speed with blade speed indicator
- Independent wire brush system
- Hydraulic Blade Tension System, with easy to read pressure gauge
- Carbide blade guides are activated hydraulically
- Additional blade guiding bearings for extra support
- Heavy cast iron movable Guide Arm is hydraulically powered from the control panel
- Auto shut off function
- Precision Feed Pressure control valve with micro-precision adjustment
- Saw Blade Height Selector
- Hydraulic driven work bed with rollers for moving large material safely
- Three sets of vises design. The front and middle vises hold the stock during cutting while the guide vise can be separately controlled to guide the material during feeding cycle
- Stock position cylinder pushes stock away from fixed vise for easy material handling
- Shadow light for material measurement
- Blade breakage and/or slippage detector
- Bi-metal saw blade
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	H4351SA
Motor	15 HP (11.2 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	3 HP (2.2 kW)
Hydraulic Oil Capacity	35 gallons (160 liters)
Blade Speeds (Variable Speed)	49–264 fpm (15–80 m/min)
Blade Size	3" x .063" x 433" (76 x 1.6 x 10,998 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	44 gallons (200 liters)
90° Cutting Capacity	
Round	43.3" (1,100 mm)
Square	43.3" (1,100 mm)
Rectangular (H x W)	43.3" x 51.2" (1,100 x 1,300 mm)
Length	86.6" (2,200 mm)
Width	193" (4,902 mm)
Height	137.8" (3,500 mm)
Bed Height	24.4" (620 mm)
Net Weight	30,140 lbs. (13,671 kg)
Shipping Weight	33,455 lbs. (15,175 kg)

*Other voltages optional. All specifications subject to change without notice or obligation.

Accessories

- CM4301H-Hydraulic Driven Chip Conveyor
- CM4302H-Hydraulic Bundle Clamp
- VP43SA-Vise Pressure Regulator Single Vise (Factory Order)
- H43-BDD- Blade Deviation Detector (Factory Order)
- H43-LL- Laser Light (Factory Order)
- H43-T18RT- 118" Manual Roller Table (Factory Order)
- H43- T18RTP- 118" Manual Roller Table (Factory Order)
- P10 Stock Stand Assembly 21"-30"
- CSR1-SAWZIT 1 Gallon
- CSR5-SAWZIT 5 Gallons



CLAUSING KALAMAZOO 51" (1,300 mm) SEMI-AUTOMATIC BANDSAW

Features

- The extra heavy-duty saw frame is supported by two large bore hydraulic cylinders, providing unsurpassed rigidity, and the smoothest cutting possible
- Dual Column design with precision ground columns ensures smooth saw frame movement and consistent cutting force throughout the cutting cycle
- Specially designed planetary gear reducer for optimum mechanical efficiency
- Inverter controlled infinitely variable blade speed with blade speed indicator
- Independent wire brush system
- Hydraulically powered guide arm is positioned from the control panel
- Hydraulic Blade Tension System, with easy to read pressure gauge
- Carbide blade guides are activated hydraulically
- Additional blade guiding bearings for extra support
- Heavy cast iron movable guide arm is hydraulically powered from the control panel
- Auto shut off function
- User-friendly control panel
- Precision Feed Pressure control valve with micro-precision adjustment
- Saw Blade Height Selector
- Hydraulic driven work bed with rollers for moving large material safely
- Three sets of vises design. The front and middle vises hold the stock during cutting while the guide vise can be separately controlled to guide the material during feeding cycle
- Stock position cylinder pushes stock away from fixed vise for easy material handling
- Shadow light for material measurement
- Blade breakage and/or slippage detector
- Bi-metal saw blade
- Tool box, leveling pads, and an additional wire brush
- Operation & parts manual
- Two (2) year limited warranty

Specifications

Model	H5167SA
Motor	20 HP (11.2 kW), 230/460 V, 3 ph*
Hydraulic Pump Motor	3 HP (2.2 kW)
Hydraulic Oil Capacity	35 gallons (160 liters)
Blade Speeds (Variable Speed)	49–264 fpm (15–80 m/min)
Blade Size	3" x .063" x 512" (76 x 1.6 x 13,005 mm)
Blade Tension	Hydraulic
Coolant	Recirculating
Coolant Capacity	44 gallons (200 liters)
90° Cutting Capacity	
Round	51" (1,295 mm)
Square	51" (1,295 mm)
Rectangular (H x W)	51" x 67" (1,295 x 1,702 mm)
Length	118" (2,998 mm)
Width	232" (5,893 mm)
Height	166.5" (4,229 mm)
Bed Height	24.4" (620 mm)
Net Weight	48,500 lbs. (22,000 kg)
Shipping Weight	51,410 lbs. (23,320 kg)

*Other voltages optional. All specifications subject to change without notice or obligation.

Accessories

- CM5101H–Chip Conveyor
- CM5102H–Hydraulic Bundle Clamp
- VP51SA– Vise Pressure Regulator Single Vase
- CSR1 SAWZIT 1 Gallon
- CSR5 SAWZIT 5 Gallons



Horizontal Bandsaw Reference

The Correct blade improves cut quality, blade life and productivity. Start with the material, then select the tooth pitch from the size and profile of the workplace.

Material or Application	Recommended Blade	Selection Guidance
Mild steel and carbon steel solids, shapes and general fabrication	M42 bi-metal Variable pitch	Best all-around choice for mixed shop work; Provides a durable cutting edge with good resistance to heat, wear and shock.
Alloy Steel and tool steel up to approximately 45 HRC	Heavy-duty M42 bi-metal positive rake, variable pitch	Improves penetration in tougher steels. Use controlled feed, proper coolant flow and a pitch matched to the section size.
Stainless steel	High-Performance M42 bi-metal positive rake	Use a lower blade speed than carbon steel and maintain a firm, steady feed to prevent work hardening. Flood Coolant is a strongly recommended.
Nickel-based alloys, titanium, hardened steel and large difficult solids	Carbide-tipped	Recommended when bi-metal blade life or productivity is inadequate. Best results require a rigid machine, correct tension and careful break in.
Aluminum, brass and copper	Coarse-Pitch bi-metal positive rake or Carbide for high production	Use generous tooth gullets to prevent chip packing. Select a coarse pitch than would normally be used on a hard material of the same size.
Cast iron	Bi-metal for general duty or Carbide / Carbide-Grit for abrasive grades	Surface scale and high-silicon castings can be abrasive. Reduce speed when needed and keep the blade brush operating comedy.
Thin-wall tube, pipe and structural shapes	Bi-metal variable pitch	Use a fine enough pitch to keep at least three teeth engaged. Variable pitch helps reduce vibration and tooth snagging.
Bundled or nested material	Bi-metal variable pitch selected for the total bundle	Choose pitch from the total selection being cut, not only the individual piece. Clamp the bundle securely so no piece can move.
Abrasive composites and special nonmetal applications	Carbide-grit or Specialty blade	Conventional teeth may wear rapidly. Confirm blade style, coolant requirements and operating limits with the blade supplier.

Quick Troubleshooting

Problem	Common Causes	Check First
Crooked or Wavy cut	Feed too heavy, low tension, dull blade, guide arms too far apart, worn guides.	Reduce feed, verify tension and move guides closer to the work.
Teeth stripping	Pitch too coarse, workpiece movement, no break-in, heavy feed, entry on a sharp corner, blade tooth broken off in material	Confirm pitch, clamp securely and restart with a properly broken-in blade. Start a new cut.
Premature tooth wear	Blade speed too high, wrong blade type, poor coolant mix or hard surface scale	Reduce speed, verify coolant and confirm the blade is correct for the material.
Blade breakage	Incorrect tension, wheel or guide misalignment, excessive feed, blade rubbing wheel flange	Inspect tension, tracking, guides and wheel alignment before installing another blade.
Chips carried back into cut	Worn or missing chip brush, inadequate coolant, pitch too fine	Adjust or replace the brush and verify coolant flow.

Selecting the Correct Tooth Pitch

Tooth pitch is measured in teeth per inch, or TPI. Select a pitch that keeps approximately 3 to 10-14 teeth in the material throughout the cut.

Material Thickness	Suggested Variable Pitch	Typical Use
Up to 1/2 in. (13mm)	14-18 or 10-14 TPI	Thin sections, small solids and light-wall profiles
1/2 to 1 in. (13-25 mm)	10-14 or 8-12 TPI	Small bar stock and heavier-wall tube
1 to 2 in. (25-50 mm)	8-12 or 6-10 TPI	Small to medium solids
2 to 4 in. (50-100 mm)	5-8 or 4-6 TPI	medium to solids and compact bundles
4 to 6 in. (100-150 mm)	4-6 or 3-4 TPI	Large solids and structural bundles
6 to 10 in. (150-250 mm)	3-4 or 2-3 TPI	Large solid sections
Over 10 in. (250 mm)	2-3 or 1.4-2 TPI	Very large solids, subject to blade availability

Starting values only. Confirm that the selected pitch is available for the blade width and thickness required by the saw.

Simple Rule

Smaller or thinner sections need a finer pitch. Larger sections need a coarser pitch. Soft, gummy materials usually benefit from a coarser pitch, while hard materials often require a finer pitch so more teeth share the cutting load.

New Blade Break-In

1. Run the blade at the normal recommended blade speed.
2. For carbon steel and aluminum, use approximately 50% of the normal feed for the first 50-100 square inches of cutting.
3. Increase feed gradually. Do not jump directly to full production feed.
4. Increase feed gradually. Do not jump directly to full production feed.
5. Stop and correct vibration, chatter, chip packing or poor coolant flow before continuing.
6. For stainless, tool steel, hardened steel and nickel-based alloys, begin at approximately 75% of normal feed for the first 25-75 square inches.

SET UP THE SAW CORRECTLY

- Set the blade tension to the machine manufacturer's specification.
- Move the guide arms as close to the workpiece as practical.
- Clamp the material firmly and support long stock with roller tables or stands.
- Confirm the blade teeth point in the correct cutting direction.
- Keep the chip brush adjusted so chips are removed before the blade re-enters the cut.
- Direct coolant at both sides of the blade and maintain the correct coolant concentration.
- Use a steady feed. Excessive feed can cause crooked cuts, tooth loss and blade breakage.
- Reduce feed when the blade enters or exits interrupted sections.

MOST COMMON BLADE PROBLEMS

- Use the correct blade for the material and workpiece size.
- Verify the blade is installed correctly, with the teeth pointing in the cutting direction.
- Ensure the blade is tracking properly and is not contacting the wheel flanges.
- If a tooth strips or breaks, stop cutting immediately. Continuing the cut can damage the remaining teeth and ruin the blade.
- Always break in every new blade before full production cutting

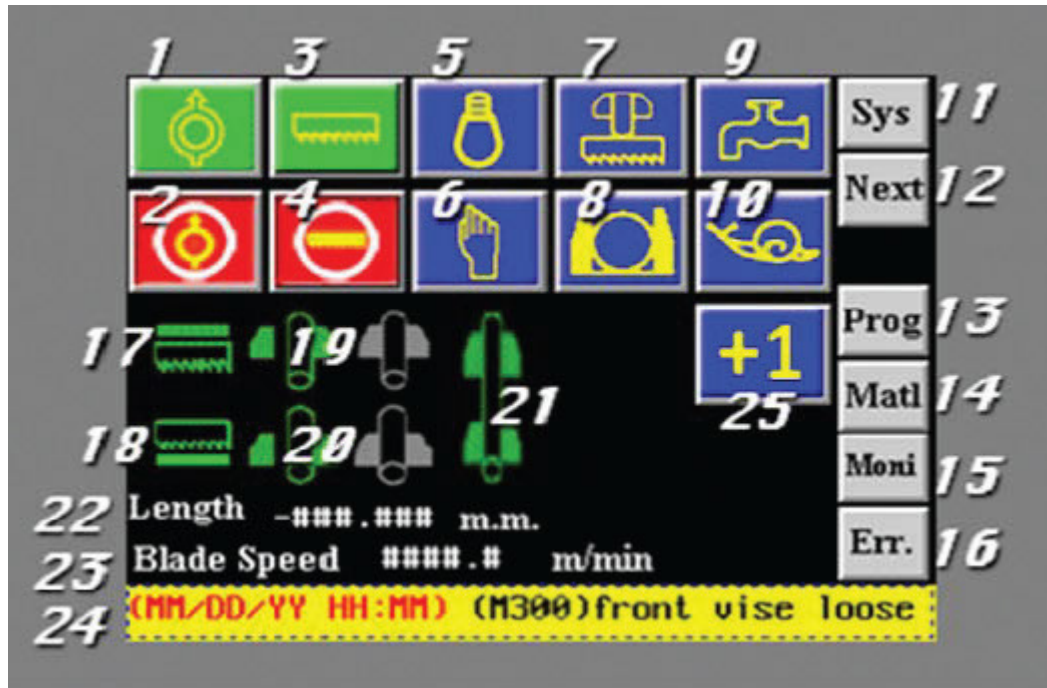
Quick Chip Check: Thin, silver chips generally indicate good cutting conditions. Blue or brown chips typically indicate excessive heat.

NEED HELP SELECTING A BLADE?

Send us the saw model, material grade, workpiece size and profile, desired cut quantity and current blade information available. These details help identify the correct blade construction, pitch and operating range.



269-345-7155
info@clausing-industrial.com
Clausing-industrial.com



SMART NC-100 CONTROL

Features

1. **Hydraulic System Start** — Starts the hydraulic motor.
2. **Hydraulic System Stop** — Stops the hydraulic motor.
3. **Saw Blade Start** — Press this button to start saw blade after workpiece is clamped.
4. **Saw Blade Stop** — Stops saw blade.
5. **Worklight ON/OFF** — turn worklight on or off each press.
6. **AUTO/Manual Mode Button** — This button switches between Auto and Manual mode.
7. **Material Retract 2mm ON/OFF** — When active the machine will retract the material 2mm after completing each cut.
8. **Single/Bundle Cutting Mode** — Used to switch between single or bundle cutting mode.
9. **Coolant ON/OFF** — Press this button to turn coolant on or off.
10. **Slow Material Feeding Mode** — Used only when in manual mode cutting.
11. **System Parameter Setting** — Press this button to set up system parameters.
12. **Cutting Parameter Setting** — Press this button to display cutting related information.
13. **Cutting Program Setting** — Press this button to directly enter the cutting job program set up page.
14. **Material Cutting Reference** — This 2 page reference chart lists out the required blade speed and cutting rate for each material.
15. **PLC Monitor** — Show current PLC signals.
16. **Error Report** — List a historical report of the errors.
17. **Saw Blade Up Indicator** — Indicates the saw blade is rising.
18. **Saw Blade Down Indicator** — Indicates that a cut is completed and the saw blade is at its lowest position.
19. **Rear Vise Status Indicator** — Indicates if the rear vises have clamped and secured the workpiece.
20. **Front Vise Status Indicator** — Indicates if the front vises have clamped and secured the workpiece.
21. **Feeding Movement Indicator** — When the feeding vise reaches the front limit, the vise set icon will turn solid white.
22. **Feeding Length Display** — Displays current feeding length while the material is being fed.
23. **Blade Speed Display** — Displays current blade speed.
24. **Error Display** — Displays error messages in the order of occurrence.
25. **Trim Cut ON/OFF** — This selection only works with the automatic cutting mode. When under auto mode and before proceeding with your automatic cutting jobs, select +0 if you wish the first cut to be "trim cut" (trims the edge of your material without the cut being counted into the finish cuts). Selecting +1 will not trim the edge and the first cut will be counted.

**BT-01 BLADE
TENSION GAUGE**



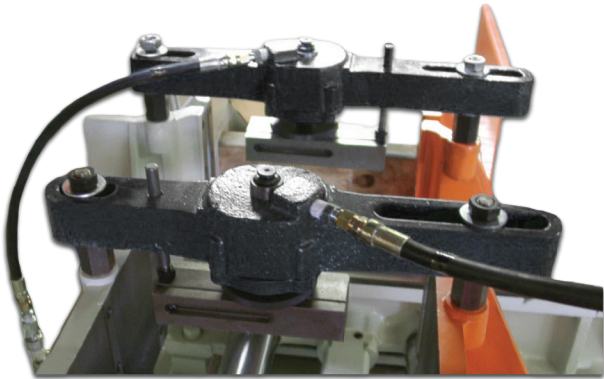
**P10 STOCK
STAND**



**SA10 ROLLER
TABLE**



BUNDLE CLAMPS



CHIP AUGER

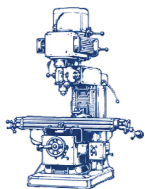


NOTES

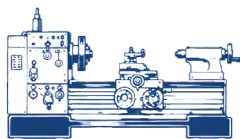
Clausing

— Committed to Excellence Since 1911 —

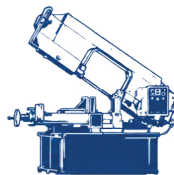
Delivering precision machine tools, dependable support, and trusted solutions for manufacturers for over a century.



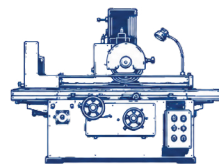
Mills



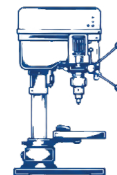
Lathes



Saws



Grinders



Drills

Need More Information?
CONTACT US



Scan to contact our team for product information, dealer support, and inquiries.

Clausing Industrial

📍 Clausing Industrial, LLC.
Kalamazoo, Michigan

📞 Phone: 269-345-7155

✉ Email: info@clausing-industrial.com

🌐 Website: www.clausing-industrial.com