AMADA MACHINE TOOLS AMERICA, INC.

AHB TOOLING & MACHINERY

**COMPLETE METALWORKING SOLUTIONS**

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THE VISION OF PRECISION

# HFA Series

AMADA®

# Contents

# Amada Machine Tools America


With more than 70 years of industry experience, Amada Machine Tools America is committed to helping our customers deliver dependable service and top-quality work with exceptional sawing solutions.

Whatever your sawing needs, we have the right solution for your specific application.

Market-Leading Quality—We believe quality work begins with quality tools designed and built from the ground up to deliver outstanding performance, time after time.

Customer-Driven Innovation—Every feature, function, and configuration we offer has been developed to address the needs of our customers.

Proven Accuracy—We help you take your work to the next level and exceed your customers' expectations.

Reliable Productivity—We understand productivity is the heart of your business, and we can help you optimize it in multiple ways.

## A History of Cutting-Edge Manufacturing

Amada Machine Tools was founded on the manufacturing of saws back in 1946. Since that time, our goals have always been to provide our customers with increased productivity and reliability.

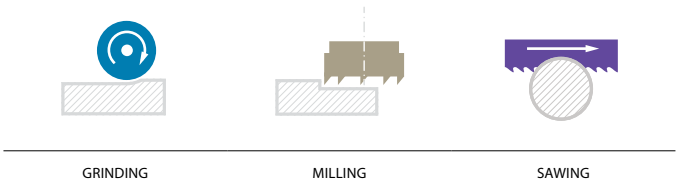
And, as technology has evolved, we've embraced CNC automation as a core strength, improving throughput and helping new operators become productive more quickly.

Today, we are uniquely positioned to help you expand your capabilities and grow your business.

## Solutions Designed Around Customer Needs

No two customers' needs are exactly alike. Finding the right solution means thoroughly understanding your objectives and configuring a solution to match them precisely. Our engineers bring decades of industry experience to help you achieve your specified goals with a process that fits—and enhances—your workflow.

TECHNOLOGIES OF AMADA



# Amada Sawing Technology

## A Perfect Match with Amada Blades

Amada also offers another unique advantage in that we manufacture our own bandsaw blades. This allows you to precisely match the characteristics of the blade to the machine to achieve optimum cutting performance, no matter what material you're working with.

Because we manufacture our own blades, we're able to ensure we've got the right blades—in stock—when you need them. And we have expert engineers with years of industry experience on staff to answer any questions you might have.

## Finding the Right Solution

No matter what kind of sawing capabilities you need, these machines deliver the proven quality and accuracy that have made Amada the trusted choice for productivity and reliability.

| Series | Description |
|---|---|
| CTB | CNC-controlled horizontal bandsaws designed for carbide-tipped blades |
| DYNASAW | Dynamic, high-performance bandsaw machines |
| H | Highly rigid horizontal bandsaws for a wide range of cutting tasks |
| HA | Semi-automatic horizontal bandsaws |
| HFA | Fully automatic horizontal bandsaws |
| HK | Miter-cutting bandsaws for structural steel sections |
| HKB | NC bandsaws for bundled tubes, solids, and structural materials |
| PCSAW | Horizontal bandsaws with Amada's revolutionary pulse cutting technology |
| VM | Vertical bandsaws for cutting blocks and plates |
| CMB | Circular saws with exceptional surface finishing |
| SCP | Automated chip compactor |

SAWING TECHNOLOGY

# Saws

Throughout the steel processing world, the Amada name is known for quality and dependability. Our lineup of industry-leading saws brings a host of innovations designed to improve your productivity. From operator-friendly controls and intuitive CNC software to our patented pulse-cutting technology that offers dramatically improved cutting times while improving blade life, you can count on Amada

SAWING TECHNOLOGY

# HFA Series

The HFA Series of fully automatic bandsaws was created to deliver extraordinary precision with highly accurate material indexing controlled by NC positioning. The squareness of each cut is monitored by a unique Amada-designed blade deviation monitor. A wide range of cutting capacities is available to match your application requirements.

# HFA250W, HFA400W and HFA500W

| MODEL | ROUND (DIAMETER) | RECTANGLE (W X H) | WORK LOAD CAPACITY |
|---|---|---|---|
| HFA250W | 1.18"~10"<br>(30 mm–250 mm) | 10.6" x 10"<br>(270 mm x 250 mm) | 3307 lbs<br>(1500 kg) |
| HFA400W | 1.18"~16.54"<br>(30 mm–420 mm) | 16" x 16"<br>(400 mm x 400 mm) | 5511 lb<br>(2500 kg) |
| HFA500W | 1.18"~20"<br>(30 mm–500 mm) | 20" x 20"<br>(500 mm x 500 mm) | 6615 lb<br>(3500 kg) |
| HFA700CII | 11.4"~28"<br>(290 mm~700 mm) | 32" x 28"<br>(800 mm x 700 mm) | 17,637 lb<br>(8000 kg) |
| HFA1000CII | 15.7"~40"<br>(400 mm~1000 mm) | 15.7" x 3.9"~43" x 40"<br>(400 mm x 100 mm~<br>1100 mm x 1000 mm) | 33,069 lb<br>(15,000 kg) |

## Features

Saw Head Frame—The rigid "C" section frame carries the mountings for the two band wheels, the heavy-duty worm gear drive reducer, the band drive motor, and the saw guide arm mounting supports.

Drive Wheel Transmission—The drive wheel transmission is designed and built by Amada to provide high-efficiency speed reduction (without requiring external cooling) to deliver more power to the large-diameter drive shaft (drive hub on the HFA500W). This ensures that the torque developed is transferred to the blade with no strobing, enabling the machine to efficiently cut high alloys as well as free-machining materials.

Pressure/Flow Feed Control—The independent pressure and flow controls ensure the optimum cutting rate can be obtained regardless of section or alloy being cut. The pressure control determines the cutting force applied to the blade and the flow control sets the maximum fall rate of the head. For example, for difficult-to-machine materials, the pressure is set higher than free-machining alloys and the flow is set lower, as shown on the escutcheons above the control knobs.

Idler Wheel Motion Detector—The wheel motion detector will turn off the blade drive in the event of a blade breaking or jamming in a workpiece. This feature also prevents premature wear on the drive wheel from a stalled blade.

Automatic Powered Chip Conveyor—The powered chip conveyor auger automatically removes the saw chips while draining cutting fluid back into the fluid reservoir. This greatly reduces cleanup time and enables the machine to run longer without operator cleanup.

Split Front Vise (HFA250W)—The work-holding vise is split so that it clamps the workpiece on both sides of the cutting plane. This additional support in front of the cutting plane minimizes the burr on the cut pieces.

Full-Stroke Vises—The work-handling and index vise cylinders are both full-stroke, which eliminates the need to manually set the clamping jaw for the work-width.

User-Friendly Controls—All cutting

Blade Deviation Monitor

NC Control Panel

Wheel Cover Interlock

## NC Funtions

- Auto trim cut
- Hour meter
- Blade deviation monitor
- 99 cut-off lengths from the same bar
- Number of pieces required
- Number of pieces cut
- Does not have blade life
- Does not have blade history

| STANDARD FEATURES | HFA250W | HFA400W | HFA500W |
|---|---|---|---|
| 2-way opening vise | | | • |
| Auto trim cut | • | • | • |
| Blade deviation monitor | • | • | • |
| Chip conveyor | • | • | • |
| Full-stroke vise | • | • | • |
| Motion detector | • | • | • |
| Piece counter | • | • | • |
| Pressure flow valve | • | • | • |
| Programmable cut length | • | • | • |
| Self-diagnostics | • | • | • |
| Split vise | • | | |
| Variable blade speed | • | • | • |
| Wheel cover limit switch | • | • | • |

| OPTIONAL ACCESSORIES | HFA250W | HFA400W | HFA500W |
|---|---|---|---|
| Return conveyor | | | |
| Roller table 6.5" (2 m) | • | • | • |
| Roller table 10" (3 m) | • | • | |
| Vertical clamps | • | • | • |
| Vise pressure control | • | • | • |

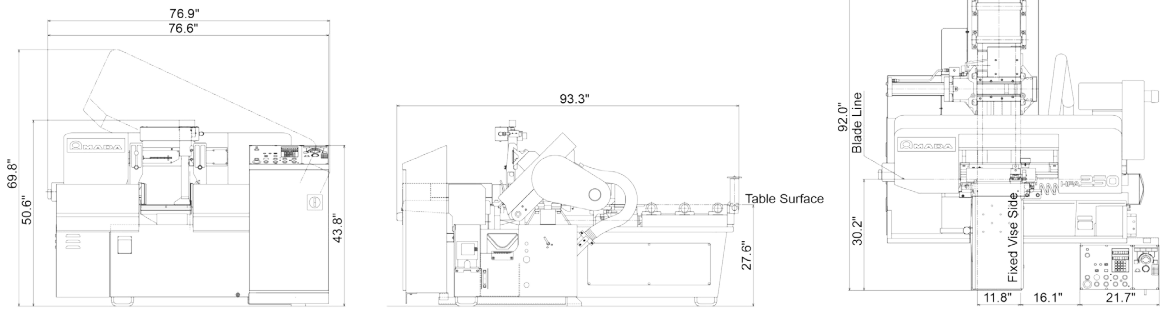
# HFA250W, HFA400W and HFA500W


# HFA250W

## HFA250W Machine Specifications

| | | | | |
|---|---|---|---|---|
| CAPACITY | Cutting capacity | Round (diameter) | 1.18"~10" | 30~250 mm |
| | | Rectangle (W x H) | 10.6" x 10" | 270 x 250 mm |
| | Work load capacity | | 3307 lb | 1500 kg |
| BLADE AND VISE OPERATION | Saw blade | Dimensions (L x T x W) | 11'6" x 0.042" x 1.25" | 3505 x 1.1 x 34 mm |
| | | Blade speed | 89~295 ft/min, 60 Hz stepless | 27~90 m/min, 60 Hz stepless |
| | | Tension control | Hydraulic | |
| | Blade control | Top limit setting | Automatic setting with quick approach feeler | |
| | | Cutting control | Hydraulic pressure and flow control valve | |
| | Vise operation | Type | Front split vise and rear vise | |
| | | Control | Hydraulic full-stroke cylinder | |
| MOTORS | Saw blade motor | 5 HP | 3.7 kW | |
| | Hydraulic pump motor | 1 HP | 0.75 kW | |
| | Cutting fluid pump motor | 1/4 HP | 0.18 kW | |
| POWER REQUIREMENTS | Power supply voltage | AC220 ± 10%, 3 PH, 60 Hz (or AC440V, 3 PH, 60 Hz) | | |
| | Power requirement | 8 kVA | | |
| CUTTING FLUID AND HYDRAULIC | Cutting fluid | Tank capacity | 22.4 gal | 85 liters |
| | | Pump type | Electric | |
| | Hydraulic | Tank capacity | 7.9 gal | 30 liters |
| | | Pressure setting | 384 psi | 2.7 MPa (27 kgf/cm$^2$) |
| CHIP DISPOSAL | Chip conveyor | | | |
| MATERIAL INDEX | Index mechanism | | Shuttle vise | |
| | Stroke | | 15.75" | 400 mm |
| | Length | | 0.39"~393.70" | 10~9999.9 mm |
| | Number of input stations | | 1~99 | |
| | Number of cut-off pieces | | 1~9999 | |
| | Remnant length | | 2.24" plus length of parts | 57 mm plus length of part |
| DIMENSIONS AND WEIGHT | Machine dimensions (W x L x H) | Head up position | 76.9" x 93.1" x 69.8" | 1945 x 2366 x 1772 mm |
| | | Head down position | 76.9" x 93.1" x 50.6" | 1945 x 2366 x 1285 mm |
| | Table height (above floor) | | 27.6" | 700 mm |
| | Machine weight | | 3307 lb | 1500 kg |

## Floor Layout




* Specifications may change without notice at the sole discretion of Amada's Engineering Department.

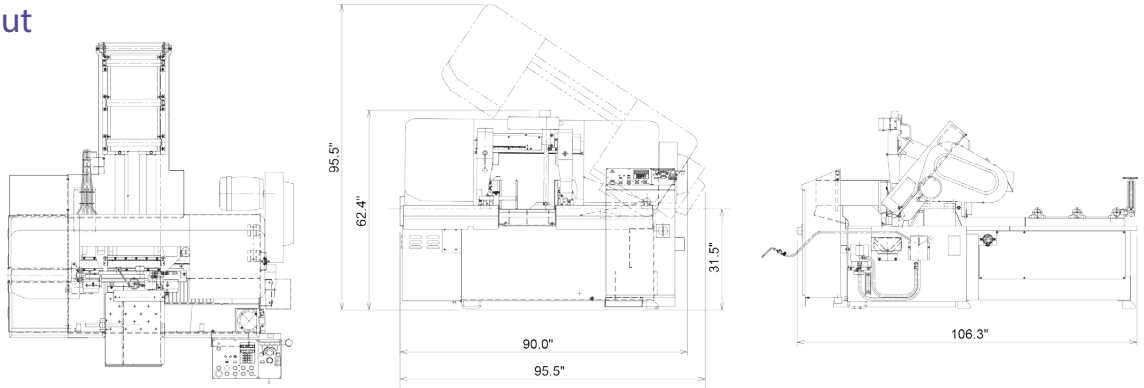
# HFA250W, HFA400W and HFA500W


# HFA400W

## HFA400W Machine Specifications

| | | | | |
|---|---|---|---|---|
| CAPACITY | Cutting capacity | Round (diameter) | 1.18"~16.54" | 30~420 mm |
| | | Rectangle (W x H) | 16" x 16" | 400 x 400 mm |
| | Work load capacity | | 5511 lb | 2500 kg |
| BLADE AND VISE OPERATION | Saw blade | Dimensions (L x T x W) | 15' x 0.050" x 1.5" | 4570 x 1.3 x 41 mm |
| | | Blade speed | 56~295 ft/min, 60 Hz stepless | 17~90 m/min, 60 Hz stepless |
| | | Tension control | Hydraulic | |
| | Blade control | Top limit setting | Automatic setting with quick approach feeler | |
| | | Cutting control | Hydraulic pressure flow control valve | |
| | Vise operation | Type | Front and rear vise | |
| | | Control | Hydraulic full-stroke cylinder | |
| MOTORS | Saw blade motor | 7.5 HP | 5.5 kW | |
| | Hydraulic pump motor | 2 HP | 1.5 kW | |
| | Cutting fluid pump motor | 1/4 HP | 0.18 kW | |
| POWER REQUIREMENTS | Power supply voltage | AC220 ± 10%, 3 PH, 60 Hz (or AC440V, 3 PH, 60 Hz) | | |
| | Power requirement | 11 kVA | | |
| CUTTING FLUID AND HYDRAULIC | Cutting fluid | Tank capacity | 31.5 gal | 120 liters |
| | | Pump type | Electric | |
| | Hydraulic | Tank capacity | 10.5 gal | 40 liters |
| | | Pressure setting | 498 psi | 3.5 MPa (35 kgf/cm$^2$) |
| CHIP DISPOSAL | Chip conveyor | | | |
| MATERIAL INDEX | Index mechanism | | Shuttle type | |
| | Stroke | | 19.6" | 500 mm |
| | Length | | 0.39"~393.70" | 10~9999.9 mm |
| | Number of input stations | | 1~99 | |
| | Number of cut-off pieces | | 1~999 | |
| | Remnant length | | 3" plus length of parts | 76 mm plus length of parts |
| DIMENSIONS AND WEIGHT | Machine dimensions (W x L x H) | Head up position | 89.5" x 106.2" x 95.5" | 2274 x 2697 x 2425 mm |
| | | Head down position | 89.5" x 106.2" x 62.0" | 2274 x 2697 x 1575 mm |
| | Table height (above floor) | | 31.5" | 800 mm |
| | Machine weight | | 4850 lb | 2200 kg |

## Floor Layout

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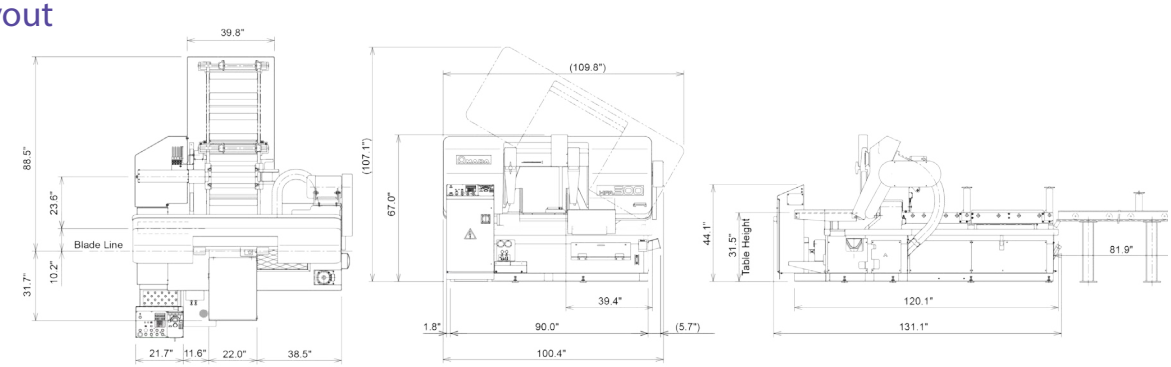
# HFA250W, HFA400W and HFA500W


# HFA500W

## HFA500W Machine Specifications

| | | | | |
|---|---|---|---|---|
| CAPACITY | Cutting capacity | Round (diameter) | 1.18"~20" | 30~500 mm |
| | | Rectangle (W x H) | 20" x 20" | 500 x 500 mm |
| | Work load capacity | | 6615 lb | 3500 kg |
| BLADE AND VISE OPERATION | Saw blade | Dimensions (L x T x W) | 17'5" x 0.050" x 1.5" | 5300 x 1.3 x 41 mm |
| | | Blade speed | 50~393 ft/min, 60 Hz stepless | 15~120 m/min, 50/60 Hz stepless |
| | | Tension control | Hydraulic | |
| | Blade control | Top limit setting | Automatic setting with quick approach feeler | |
| | | Cutting control | Hydraulic pressure and flow control valve | |
| | Vise operation | Type | Front and rear vise | |
| | | Control | Hydraulic full-stroke cylinder | |
| MOTORS | Saw blade motor | 7.5 HP | 5.5 kW | |
| | Hydraulic pump motor | 2 HP | 1.5 kW | |
| | Cutting fluid pump motor | 1/4 HP | 0.18 kW | |
| POWER REQUIREMENTS | Power supply voltage | AC220 ± 10%, 3 PH, 60 Hz (transformer required for other voltages) | | |
| | Power requirement | 21 kVA | | |
| CUTTING FLUID AND HYDRAULIC | Cutting fluid | Tank capacity | 18.5 gal | 70 liters |
| | | Pump type | Electric | |
| | Hydraulic | Tank capacity | 18.5 gal | 70 liters |
| | | Pressure setting | 498 psi | 3.5 MPa (35 kgf/cm$^2$) |
| CHIP DISPOSAL | Chip conveyor | | | |
| MATERIAL INDEX | Index mechanism | | Hydraulic shuttle type | |
| | Stroke | | 23.6" | 600 mm |
| | Length | | 0.39"~393.70" | 10~9999.9 mm |
| | Number of input stations | | 1~99 | |
| | Number of cut-off pieces | | 1~999 | |
| | Remnant length | | 4.9" plus length of parts | 125 mm plus length of parts |
| DIMENSIONS AND WEIGHT | Machine dimensions (W x L x H) | Head up position | 100.4" x 131.1" x 107.1" | 2550 x 3330 x 2720 mm |
| | | Head down position | 100.4" x 131.1" x 67" | 2550 x 3330 x 1700 mm |
| | Table height (above floor) | | 31.5" | 800 mm |
| | Machine weight | | 7940 lb | 3600 kg |

## Floor Layout

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# HFA700CII and HFA1000CII

The HFA700CII and HFA1000CII were purpose-built for maximum accuracy and durability when cutting large materials.

## Features

### High Accuracy for Large Materials

- HFA700CII: Up to 32" x 28" (800 mm x 700 mm)
- HFA1000CII: From 15.7" x 3.9" to 43" x 40" (400 mm x 100 mm to 1100 mm x 1000 mm)

Automatically Positioned Guide Arm—The automatic setting of the guide arm eliminates the potential of operator error in the initial setup. The guide arm will always be as close as possible to the pieces being cut.

Automatic Adjusting Double Wire Brushes—The new automatically adjusted double wire brush design keeps the blade clean for maximum blade life (and brush life) with all types of cutting.

Blade Deviation Monitor—The NC controller constantly monitors the cutting and blade conditions, including the twist of the saw blade. When any conditions exceed preset parameters, the machine will cease cutting and indicate the reason for the stoppage.

Front and Rear Vises—The vise configuration allows a minimum remnant length.

Hydraulic Blade Tensioning—A specially designed hydraulic cylinder produces the wide range of band tension required when utilizing both bi-metal and carbide-tipped blades. A direct-reading pressure gauge enables quick and accurate tension setting to accommodate all cutting applications.

Auto Trim Positioning

User-Friendly Operator Console—By simplifying the required input data, the cutting rate controller ("CNC-Lite") ensures the maximum cutting rate, accuracy, and blade life.

# HFA700CII and HFA1000CII

## NC Funtions

- Automatic kerf compensation
- Hour meter
- Blade runout monitor
- History
- 99 cut-off lengths from the same bar
- Number of pieces required
- Number of pieces cut
- Blade life

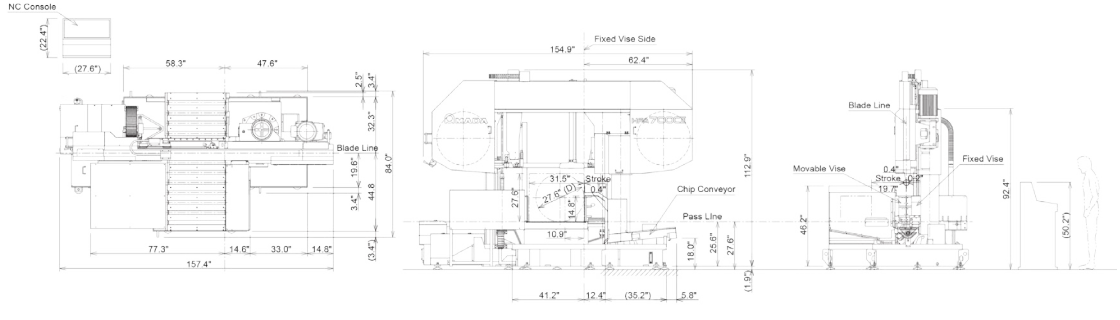
| STANDARD FEATURES | HFA700CII | HFA1000CII |
|---|---|---|
| Automatically positioned guide arm | ● | ● |
| Blade deviation monitor | ● | ● |
| Blade speed controlled by inverter | ● | ● |
| Chip conveyor | ● | ● |
| CNC-controlled down feed | ● | ● |
| Drive: helical gear (no torque loss) | ● | ● |
| Full-stroke vises | ● | ● |
| Hydraulic blade tensioning | ● | ● |
| Motion detector | ● | ● |
| Piece counter | ● | ● |
| Outboard vise | ● | ● |
| Vibration dampening rollers | ● | ● |
| Wheel cover limit switch | ● | ● |

| OPTIONAL ACCESSORIES | HFA700CII | HFA1000CII |
|---|---|---|
| Beacon | ● | ● |
| Free roller table | ● | ● |
| Vertical clamp (must be factory ordered) | ● | |
| Vise pressure control valve | ● | |

## HFA700CII Machine Specifications

| | | | | |
|---|---|---|---|---|
| CAPACITY | Cutting capacity | Round (diameter) | 11.4"~28" | 290~700 mm |
| | | Rectangle (W x H) | 32" x 28" | 800 x 700 mm |
| | Work load capacity | | 17,637 lb | 8000 kg |
| BLADE AND VISE OPERATION | Saw blade | Dimensions (L x T x W) | 27'3 x 0.063" x 2.625" | 8300 x 1.3 x 67 mm |
| | | Blade speed | 49~394 ft/min, by inverter | 15~120 m/min, by inverter |
| | | Tension control | Hydraulic | |
| | Blade control | Top limit setting | Automatic setting with quick approach feeler | |
| | | Cutting control | CNC-Lite, hydraulic flow control valve with stepping motor | |
| | Vise operation | Type | Front and rear vise | |
| | | Control | Hydraulic full-stroke cylinder | |
| MOTORS | Saw blade motor | 15 HP | 11 kW | |
| | Hydraulic pump motor | 5 HP | 3.7 kW | |
| | Cutting fluid pump motor | 1/2 HP | 0.36 kW | |
| POWER REQUIREMENTS | Power supply voltage | AC220 ± 10%, 3 PH, 60 Hz (all other voltages require a transformer) | | |
| | Power requirement | 26 kVA | | |
| CUTTING FLUID AND HYDRAULIC | Cutting fluid | Tank capacity | 26.4 gal | 100 liters |
| | | Pump type | Electric | |
| | Hydraulic | Tank capacity | 30.4 gal | 115 liters |
| | | Pressure setting | 784 psi | 5.5 MPa (55 kgf/cm$^2$) |
| CHIP DISPOSAL | Chip conveyor | | | |
| MATERIAL INDEX | Index mechanism | | Shuttle vise | |
| | Stroke | | 19.6" | 500 mm |
| | Length | | 0.39"~393.70" | 10~9999.9 mm |
| | Number of input stations | | 1~99 | |
| | Number of cut-off pieces | | 1~9999 | |
| | Remnant length (for clamp clearance of 0.79"/20 mm) | | 1.38" plus length of parts | 35 mm plus length of parts |
| DIMENSIONS AND WEIGHT | Machine dimensions (W x L x H) | Head up position | 157.4" x 84.0" x 112.9" | 3999 x 2133 x 2867 mm |
| | | Head down position | 157.4" x 84.0" x 112.9" | 3999 x 2133 x 2867 mm |
| | Table height (above floor) | | 27.6" | 700 mm |
| | Machine weight | | 15,435 lb | 7000 kg |

## Floor Layout

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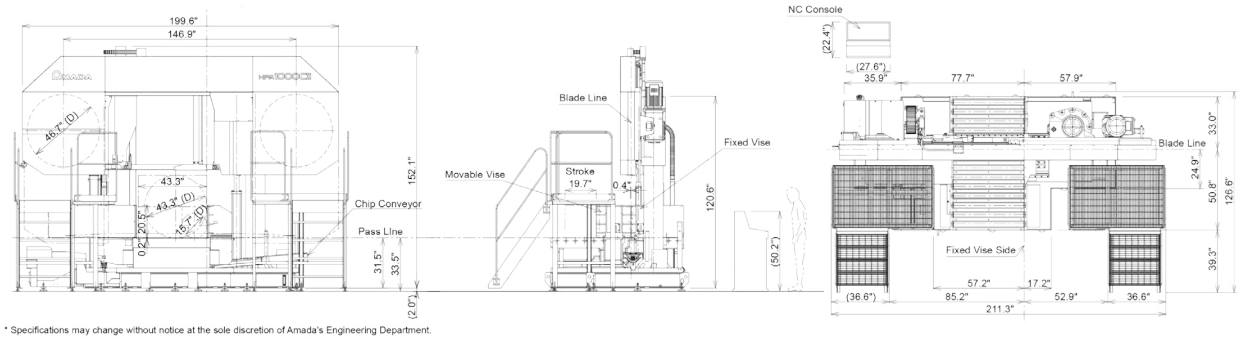
# HFA700CII and HFA1000CII

## HFA1000CII Machine Specifications

| | | | | |
|---|---|---|---|---|
| CAPACITY | Cutting capacity | Round (diameter) | 15.47"~40" | 400 x 1000 mm |
| | | Rectangle (W x H) | 15.7" x 3.9"~43" x 40" | 400 x 100 mm~1100 x 1000 mm |
| | Work load capacity | | 33,069 lb | 15,000 kg |
| BLADE AND VISE OPERATION | Saw blade | Dimensions (L x T x W) | 36'6" x 0.063"x 3" | 11,100 x 1.6 x 80 mm |
| | | Blade speed | 49~394 ft/min, by inverter | 15~120 m/min, by inverter |
| | | Tension control | Hydraulic | |
| | Blade control | Top limit setting | Automatic setting with quick approach feeler | |
| | | Cutting control | CNC-Lite, hydraulic flow control valve with stepping motor | |
| | Vise operation | Type | Front and rear vise | |
| | | Control | Hydraulic full-stroke cylinder | |
| MOTORS | Saw blade motor | 15 HP | 11 kW | |
| | Hydraulic pump motor | 5 HP | 3.7 kW | |
| | Cutting fluid pump motor | 1/2 HP | 0.36 kW | |
| POWER REQUIREMENTS | Power supply voltage | AC220 ± 10%, 3 PH, 60 Hz (all other voltages require a transformer) | | |
| | Power requirement | 26 kVA | | |
| CUTTING FLUID AND HYDRAULIC | Cutting fluid | Tank capacity | 66.1 gal | 250 liters |
| | | Pump type | Electric | |
| | Hydraulic | Tank capacity | 30.4 gal | 115 liters |
| | | Pressure setting | 784 psi | 5.5 MPa (55 kgf/cm$^2$) |
| CHIP DISPOSAL | Chip conveyor | | | |
| MATERIAL INDEX | Index mechanism | | Shuttle type | |
| | Stroke | | 19.6" | 500 mm |
| | Length | | 0.39"~393.70" | 10~9999.9 mm |
| | Number of input stations | | 1~99 | |
| | Number of cut-off pieces | | 1~9999 | |
| | Remnant length (for clamp clearance of 0.79"/20 mm) | | 13" plus length of parts | 330 mm plus length of parts |
| DIMENSIONS AND WEIGHT | Machine dimensions (W x L x H) | Head up position | 211.3" x 126.6" x 154.1" | 5420 x 3215 x 3924 mm |
| | | Head down position | 211.3" x 126.6" x 154.1" | 5420 x 3215 x 3924 mm |
| | Table height (above floor) | | 33.5" | 850 mm |
| | Machine weight | | 31,970 lb | 14,500 kg |

## Floor Layout

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# See Amada Saws at Work


The AMTA Technical Center was created to provide a unique atmosphere for visitors to experience the latest manufacturing technology in action. This stunning 40,000-square-foot facility houses the latest Amada technology in each product group. Much more than just
an exhibit, every machine, automation accessory, and software program in the facility is fully operational and ready to empower customers to solve their most challenging manufacturing applications.

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Specifications, appearance and dimensions are subject to change without notice at the sole discretion of Amada's Engineering Department.

There may be differences between the specifications described in this catalog and the Amada products actually shipped. Please ask our staff for more detail.

The products in the catalog may be subject to the provisions of foreign exchange and the Foreign Trade Law. When exporting cargo subject to such controls, permission pursuant to regulation is required. Please contact our business representative in advance when exporting products overseas.

When using our products, safety equipment is required depending on the operational task.

For safe and correct operation, ensure thorough reference to the Instruction Manual prior to operation.

The cutting performance data in this catalog may be affected by temperature, the cutting materials, tool materials, and cutting conditions, etc. Please note that such data are not guaranteed.

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