DoALL

SAWING PRODUCTS

SAWING MACHINES

FOR ALL YOUR SAWING NEEDS!

BAND SAW BLADES | CIRCULAR SAW BLADES | BAND SAWING MACHINES | CIRCULAR SAWING MACHINES | CUTTING FLUIDS

Model		C-3028NC	C-4033NC	APEX-420NC	C-420NC	C-5650NC	C-560NC	C-6260NC
Max round	mm	Ø280	Ø330	Ø420	Ø420	Ø500	Ø560	Ø600
Min round	mm	Ø10	Ø10	Ø10	Ø10	Ø10	Ø10	Ø10
Max rectangular	mm	300 x 280H	400 x 330H	420 x 420H	420 x 420H	560 x 500H	610 x 560H	620 x 600H
Max bundles	mm	260 x 100H	310 x 160H	310 x 210H	310 x 210H	450 x 260H	490 x 225H	460 x 310H
Min bundles	mm	170 x 30H	170 x 40H	170 x 90H	170 x 90H	240 x 80H	245 x 160H	240 x 190H
Blade	mm	34 x 1,1 x 3.820	34 x 1,1 x 4.242	41 x 1,3 x 4.880	41 x 1,3 x 4.880	41 x 1,3 x 5.450	54 x 1,6 x 6.600	41 x 1,3 x 6.560
Band speed	m/min	16 - 85 25 - 135	16 - 85 25 - 135	16 - 85	16 - 85 25 - 135	16 - 85 25 - 135	16 - 85 25 - 135	16 - 85 25 - 135
Band drive motor	kW	3,7	3,7	7,5	5,5 / 7,5*	5,5	7,5	5,5
Index length Single Multi	 mm mm	 400 3.600	 500 4.500	 390 3.600	 500 4.500	 500 4.500	 400 3.600	 400 3.600
Material pass line	mm	700	700	690	720	750	850	800
Dimensions	mm mm mm	1.990 L 2.100 W 1.300 H	2.250 L 2.195 W 1.400 H	3.100 L 2.200 W 2.250 H	2.235 L 2.450 W 1.665 H	2.260 L 2.630 W 1.820 H	2.125 L 3.210 W 2.160 H	2.130 L 3.180 W 2.030 H
Weight	kg	1.750	2.000	3.900	2.450	3.100	4.500	4.800

C-4033NC

C-8070NC

Band sawing machines - NC series

The DoALL NC series is a line of machines designed and built for general purpose sawing operations both in manual and automatic mode. For ease of use these machines are already equipped with a chip conveyor, variable vice pressure control, double retracting index vice, worklight and toolbox.

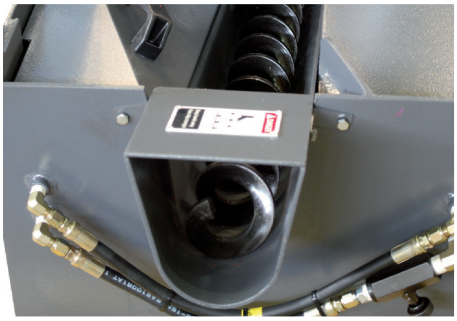
C-420NC

Standard equipment

- PLC control for all electric and hydraulic functions
  Color touch screen control panel with alarm messages
- Infinitely variable band speed controlled by inverter
- Idler wheel motion detector with blade stall device
  and band break switch
- Shuttle type automatic feed and sliding work table with roller
- Hydraulic band tension
- Split front vice*
- Double retracting index vice
- Workheight sensor and rapid approach
- Carbide inserts with roller bearings or carbide backups
- Nesting fixture* and vertical rollers for bundle cutting
- Length setting: magnetic scale
- Variable vice pressure control
- 20 jobs presetting
- Automatic chip conveyor
- Power driven band brush
- Flushing hose for machine cleaning
- Worklight
- One roller conveyor of 2 meters

** Not **all** models*

C-8056NC	C-8070NC	C-1080NC
Ø560	**Ø700**	**Ø800**
Ø10	Ø100	Ø200
800 x 560H	800 x 700H	1.000 x 800H
54 x 1,6 x 6.800	67 x 1,6 x 8.250	67 x 1,6 x 8.800
16 - 85	16 - 85	16 - 85
7,5	11	11
400 3.600	400 3.600	400 6.000
850	800	920
2.135 L 3.410 W 2.160 H	2.240 L 3.910 W 2.300 H	2.160 L 4.320 W 2.726 H
4.850	7.100	11.500

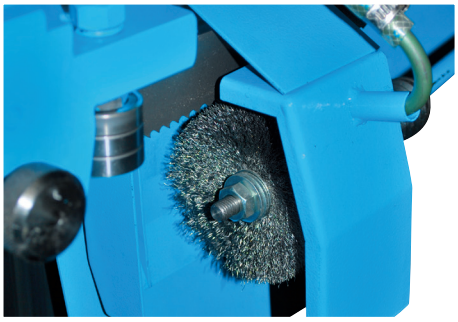


Automatic chip conveyor

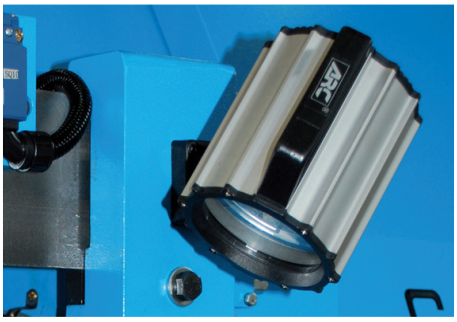
Hydraulic band tension

Color touch screen control panel and manual buttons *NC-models*

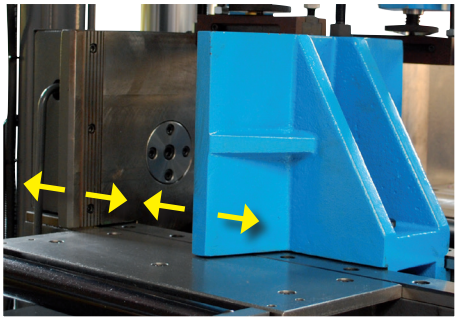
Roller conveyor



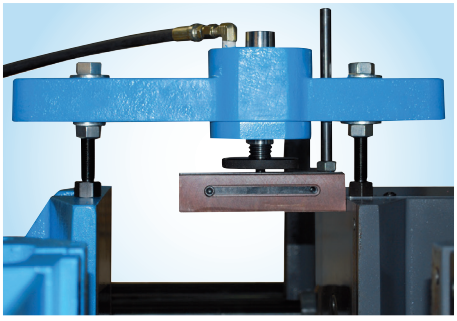
Power driven band brush



Work light



Double retracting index vice
NC-models



Nesting fixture
** Not **all** models*

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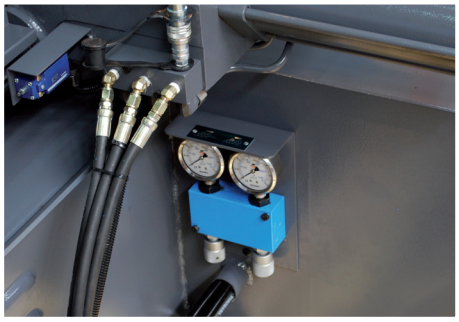
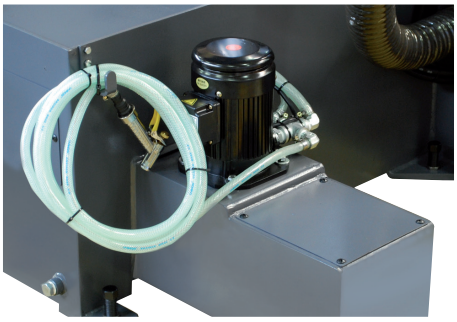
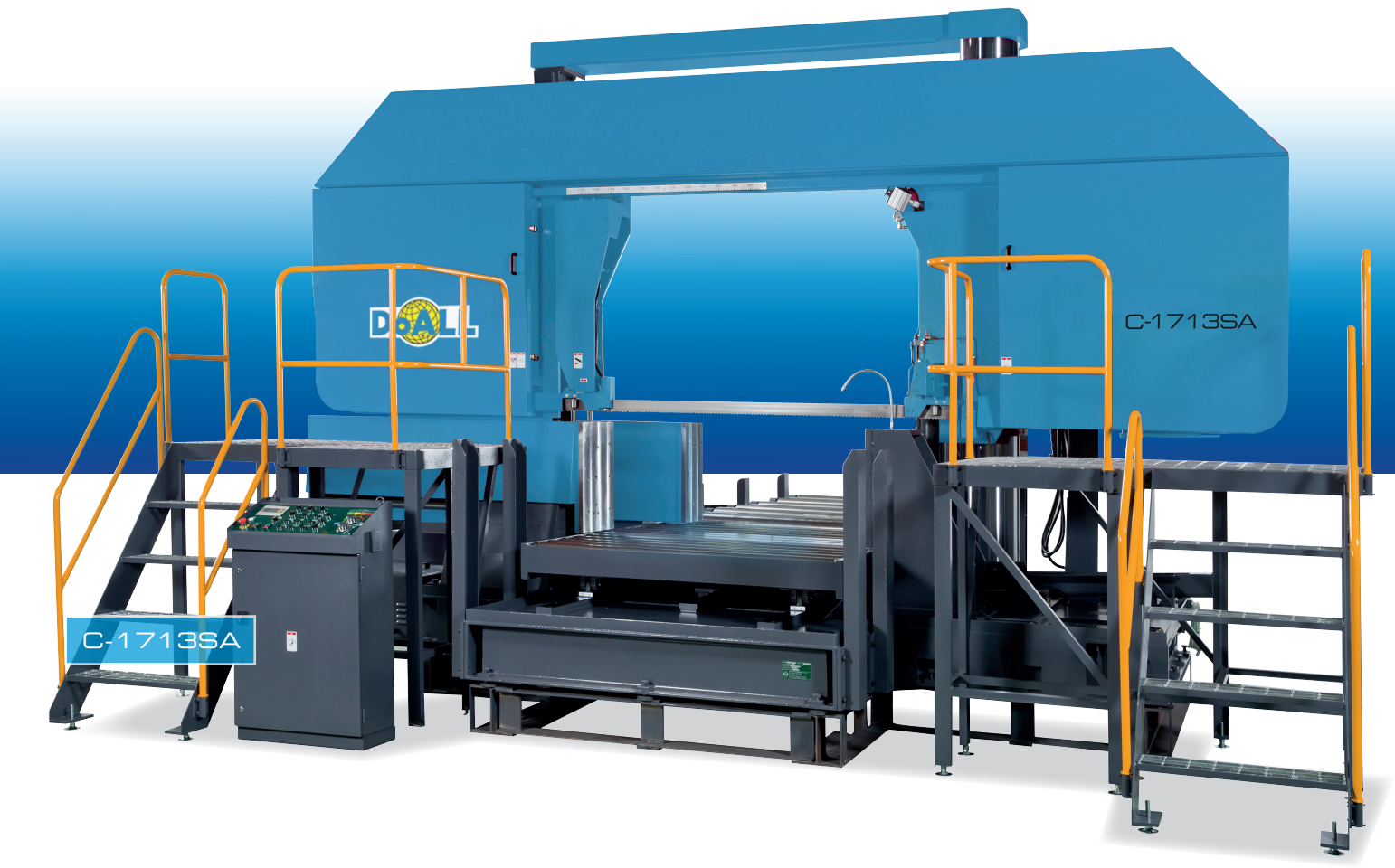


Variable vice pressure control



Flushing hose / coolant system

Model		C-4033SA	C-5650SA	C-8056SA	C-1080SA	C-1100SA	C-1300SA	C-1713SA
Max round	mm	Ø330	Ø500	Ø560	Ø800	Ø1.100	Ø1.300	Ø1.300
Min round	mm	Ø10	Ø10	Ø10	Ø560	Ø300	Ø320	Ø695
Max rectangular	mm	400 x 330H	560 x 500H	800 x 560H	1.000 x 800H	1.100 x 1.100H	1.300 x 1.300 H	1.700 x 1.300H
Min rectangular	mm	10 x 10H	10 x 10H	10 x 10H	560 x 25H	300 x 25H	320 x 25H	695 x 25H
Blade	mm	34 x 1,1 x 4.242	41 x 1,3 x 5.450	54 x 1,6 x 6.800	67 x 1,6 x 8.800	67 x 1,6 x 10.000	80 x 1.6 x 12.300	80 x 1,6 x 13.000
Band speed	m/min	20,35,50,65,80	20,35,50,65,80	16 - 85	16 - 85	16 - 85	12 - 75	12 - 75
Band drive motor	kW	3,7	5,5	7,5	11	11	15	15
Material pass line	mm	700	750	850	720	720	720	680
Dimensions	mm mm mm	1.210 L 2.260 W 1.520 H	1.450 L 3.000 W 1.800 H	1.950 L 3.390 W 2.160 H	4.350 L 2.160 W 2.650 H	4.600 L 2.400 W 3.250 H	2.800 L 5.700 W 3.800 H	2.800 L 6.200 W 3.800 H
Weight	kg	1.650	2.600	3.800	11.000	14.000	18.000	21.000



Band sawing machines - SA series

The DoALL SA series is a line of machines designed and built for general purpose sawing operations.
Ideal for jobs in manual (semi-automatic) mode.
For ease of use these machines are already equipped with a standard variable vice pressure control*, worklight and toolbox.

Standard equipment

- PLC control for all electric and hydraulic functions
- Inverter drive *(except C-4033SA, C-5650SA)*
- Idler wheel motion detector and band break switch
- Hydraulic band tension
- Rapid saw head approach by pushbutton
- Carbide inserts with roller bearings
- Manual length setting with hydraulic lift roller
- Variable vice pressure control*
- Automatic chip conveyor
- Power driven band brush
- Flushing hose for machine cleaning
- Worklight
- One set of tools in tool box
- One roller conveyor
- Adjustable work height setting

* *(Except C-1713SA)*

Model		2013-V2 *2 speed range* *AC inverter* *Fixed table*	2013-V3 *2 speed range* *AC inverter* *Fixed table*	3613-V3 *2 speed range* *AC inverter* *Fixed table*
Max work height	mm	**330**	**330**	**330**
Max width to column	mm	**508**	**508**	**915**
Blade dimensions	mm	3 - 27 x 3.910	3 - 27 x 3.910	3 - 27 x 5.055
Speed range Low	m/min	10 - 100	10 - 100	10 - 100
Speed range High	m/min	170 - 1.675	170 - 1.675	170 - 1.675
Table	mm	660 x 660	660 x 660	660 x 660
Table tilt		45°R - 10°L	45°R - 10°L	45°R - 10°L
Table height	mm	995	995	995
Band drive motor	kW	1,5	2,2	2,2
Dimensions	mm mm mm	895 L 1.399 W 2.065 H	895 L 1.399 W 2.065 H	1.092 L 1.880 W 2.065 H
Weight	kg	570	570	635

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For all your sawing needs!

Vertical contour saws

The most versatile machine tool available!

Vertical contour saws for cutting aluminium, brass, copper, mild steels, tough tool steels, stainless steels and sheet metal as well as cut plastics and fibrous materials.

Plus, they are available with a wide variety of attachments that permit contour cutting, disc cutting and more.

Standard equipment

- One set of high-speed, insert type guide-blocks for bands 3 through 13 mm
- One set of steel guide inserts for bands 6, 10, and 13 mm
- Band speed indicator
- Removable chip pan
- Band tension indicator
- Chip blower (requires plant air)
- Post elevating hand wheel
- Variable speed AC Drive (controls speeds, soft start and dynamic brake functions)
- Band door interlocks
- Dual range transmission

Model		TC-75NC	TC-100NC	TC-155NC
Capacity round	mm	8 - 75	10 - 102	55 - 155
Capacity rectangular	mm	8 - 60	10 - 80	55 - 120
Blade	mm	Ø285 x 2,0(T) x 1,7(t)	Ø360 x 2,6(T) x 2,25(t)	Ø460 x 2,7(T) x 2,25(t)
T= Kerf / t= thickness		32; 4 x 11 at 63 mm	40; 4 x 11 at 90 mm	50; 4 x 13 at 90 mm
Blade rotation speed	rpm	30 - 150	30 - 150	30 - 150
Blade drive motor	kW	11	11	18,5
Hydraulic pump motor	kW	1,5	2,2	2,2
Blade feed system		Servo motor and ball screw		
Material feed system		Servo motor and ball screw		
Loading table dimensions	mm	1.200 x 5.200	1.200 x 5.200	1.200 x 5.200
Single Automatic index	mm	6 - 600	6 - 600	6 - 600
Multiple Index length	mm	up to 6.000	up to 6.000	up to 6.000
Dimensions	mm mm mm	6.755 L 2.765 W 2.090 H	6.890 L 2.850 W 2.090 H	7.230 L 3.120 W 2.090 H
Weight	kg	2.800	3.600	4.200

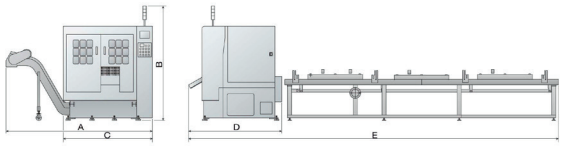
TC-75NC

Highlights

- High production
- High accuracy
- Superb finish
- Complete
- Easy to use

Circular sawing machines - TC series

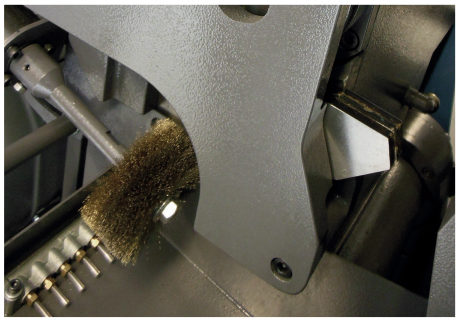
The TC series are designed for high production rates with low cost of ownership. Machines are suited for materials from engineering steels, non ferrous to stainless steels, using carbide tipped DoALL circular blades. With ergonomic design and extremely easy to use interface, machines are ready for production in a matter of moments.



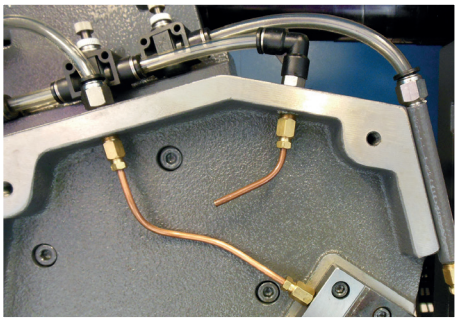
Standard equipment

- Operator friendly PLC control with touch screen
- Hydraulic clamped hortizontal and vertical vices
- Floating shuttle device
- Automatic loading table for round bars only
- Out of stock detector
- Air compressed oil mist lubrication system*
- Oil mist filter
- Hydraulic operated sorting chute
- Powered chip brush
- Inverter drive
- Automatic chip conveyor
- One set of tools in toolbox
- Work light

** Machines require plant air*

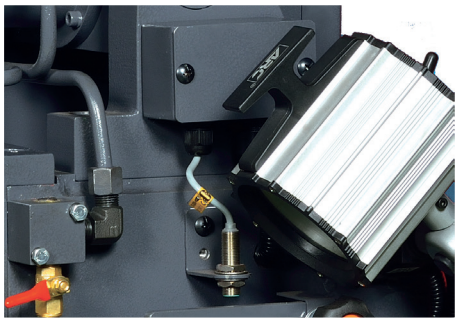


Power driven chip brush *actively cleans chips from the saw blade.This extends blade life and maintains cutting efficiency.*

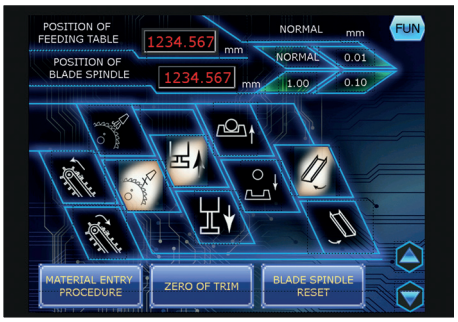


Direct oil mist application *for improved lubrication of saw blade and machine parts.*

Oil mist filter *with high capacity improves working environment.*

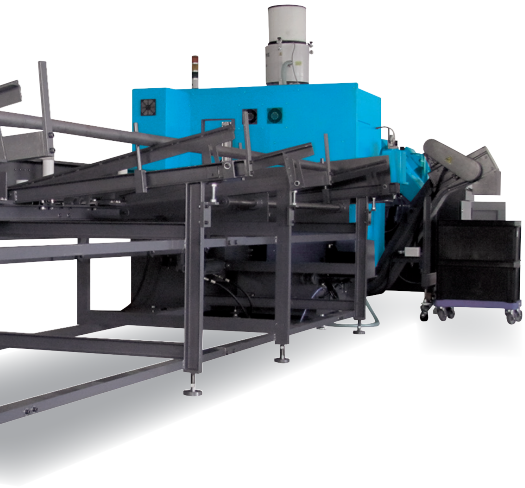


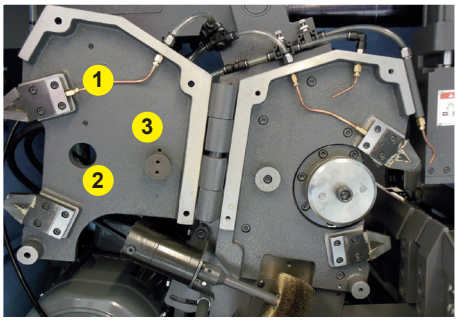
Halogen work light



Touch screen *and control panel allow easy operation.The information for problem solving & trouble shooting is shown on the screen and historical data is recorded for reference.*

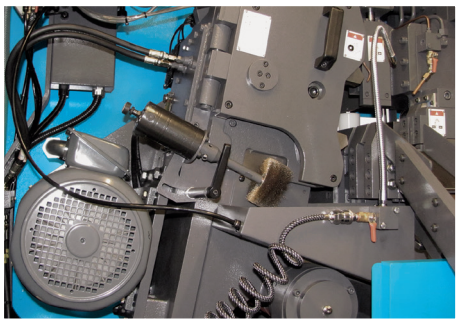
Automatic chip conveyor *transports chips to a height of approx 1 meter and drops them into a customer supplied bin.*



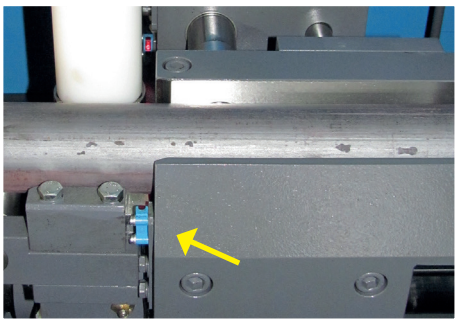


Carbide guide blocks *increase stability during cut and blade life.*

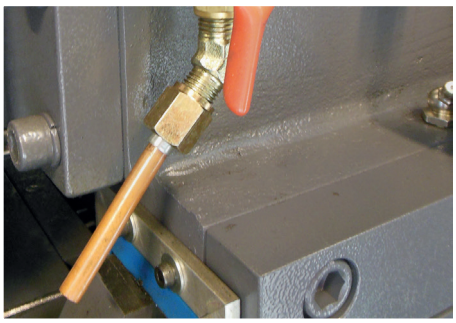
Automatic loading table *efficiently moves round material only from the loading area to the infeed area.*



Blade drive motor



Optical sensor *for increased reliability.*



Cleaning nozzle *to extend blade life.*

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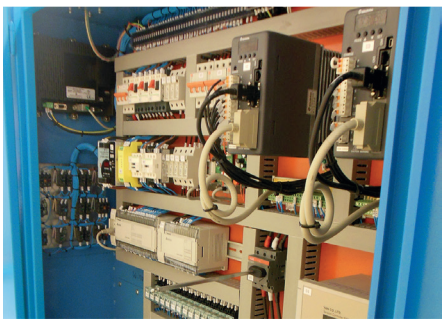
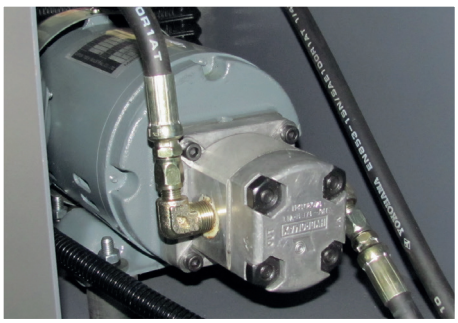


Split door of TC-155NC *for easy acces to different parts of the machine to improve maintenance control.*



External cooling system gearbox *for improved temperature control and reliability.*

DS-330SA

- ○ 330 mm
- ▭ 420 x 330 mm
- ∠ 45°R / 60°R / 45°L
- Ergonomic saw control.
- Inverter drive.
- Saw guides, solid carbide inserts for accurate cuts.
- Hydraulic head feed control
- Driven blade brush.
- Saw blade guard for operator safety.

S-260NC

- ○ 260 mm
- ▭ 295 x 230 mm
- ∠ 45°R / 60°R
- Automatic; single mitre machine.
- Ball screw and servo drive index vice; max stroke 500 mm.
- Hydraulic control of saw head and vices.
- Inverter drive.
- Band tension: manual with gauge.
- Fast approach.
- Color touch screen.

DS-260SA

- ○ 260 mm
- ▭ 295 x 230 mm
- ∠ 45°R / 60°R / 45°L
- Semi-automatic; double mitre machine.
- Rotating bearing supported machine bed with easy stops.
- Hydraulic control of sawhead and vice.
- Inverter drive
- Band tension: manual with gauge.
- Fast approach.

S-220HD

- ○ 220 mm
- ▭ 230 x 185 mm
- ∠ 45°R / 60°R
- Manual/Gravity down feed; single mitre machine.
- Carbide faced blade guidance.
- Quick clamping vice.
- Two speed band speed.
- Band tension: manual with gauge.
- Coolant system.

S-185HD

- ○ 185 mm
- ▭ 200 x 150 mm
- ∠ 45°R / 60°R
- Manual/Gravity down feed; single mitre machine.
- Bearings for blade guidance.
- Quick clamping vice.
- Two speed band speed.
- Band tension: manual with gauge.
- Coolant system.

S-170M

- ○ 170 mm
- ▭ 170 x 170 mm
- ∠ 45°R / 60°R
- Manual pull down feed; single mitre machine.
- Bearings for blade guidance.
- Manual clamping vice.
- Single phase AC-motor drive.
- Spring loaded band tension.
- Coolant system.

PS-150M

- ○ 150 mm
- ▭ 150 x 140 mm
- ∠ 45°R / 60°R
- Manual pull down feed; single mitre portable machine.
- Bearings for blade guidance.
- Manual clamping vice.
- Single phase AC-motor drive.
- Motor overload safety.

PS-125M

- ○ 125 mm
- ▭ 130 x 125 mm
- ∠ 45°R / 60°R
- Manual pull down feed; single mitre portable machine.
- Bearings for blade guidance.
- Manual clamping vice.
- Single phase AC-motor drive.
- Motor overload safety.

Model		DS-330SA	DS-260SA	S-260NC	S-220HD
Max 0° ○	mm	**330**	**260**	**260**	**220**
Max 0° ●	mm	200	100	100	80
Max 0° ▭	mm	420 x 330	295 x 230	295 x 230	230 x 185
Max 45°R ○	mm	**310**	**240**	**240**	**150**
Max 45°R ●	mm	125	80	80	60
Max 45°R ▭	mm	335 x 200	225 x 215	225 x 215	210 x 150
Max 60°R ○	mm	**235**	**160**	**160**	**90**
Max 60°R ●	mm	80	50	50	40
Max 60°R ▭	mm	235 x 235	160 x 130	160 x 130	100 x 90
Max 45°L ○	mm	**280**	**190**		
Max 45°L ●	mm	125	80		
Max 45°L ▭	mm	260 x 220	190 x 190		
Band saw blade	mm	3.820 x 34 x 1,1	2.965 x 27 x 0,9	2.965 x 27 x 0,9	2.455 x 27 x 0,9
Band speed	m/min	25 - 85	25 - 85	25 - 85	35 / 70
Band motor	kW	1,7	1,3	1,3	1,0
Band tension		Manual with gauge	Manual with gauge	Manual with gauge	Manual with gauge
Feed control		Hydraulic	Hydraulic	Hydraulic	Manual, gravity
Vice		Manual, hydraulic	Manual, hydraulic	Manual, hydraulic	Manual
Dimensions	mm mm mm	2.220 L 1.185 W 2.190 H	1.550 800 1.480	2.800 1.800 1.800	1.350 715 1.480
Weight	kg	800	310	580	250

The DoALL General Purpose Line band sawing machines are designed for use in workshops with a variety of materials in all kinds of shapes and sizes.

Model		S-185HD	S-170M	PS-150M	PS-125M
Max 0° ○	mm	**185**	**170**	**150**	**125**
Max 0° ●	mm	70			
Max 0° ▭	mm	200 x 150	170 x 170	150 x 140	130 x 125
Max 45°R ○	mm	**110**	**130**	**100**	**80**
Max 45°R ●	mm	50			
Max 45°R ▭	mm	110 x 90	130 x 150	100 x 100	80 x 80
Max 60°R ○	mm	**70**	**75**	**70**	**50**
Max 60°R ●	mm	30			
Max 60°R ▭	mm	70 x 70	75 x 75	65 x 70	50 x 50
Max 45°L ○	mm				
Max 45°L ●	mm				
Max 45°L ▭	mm				
Band saw blade	mm	2.085 x 20 x 0,9	2.030 x 20 x 0,9	1.735 x 13 x 0,9	1.440 x 13 x 0,65
Band speed	m/min	35 / 70	30 - 80	30 - 80	30 - 80
Band motor	kW	0,75	1,6 (single fase)	1,5 (single fase)	1,0 (single fase)
Band tension		Manual with gauge	Springloaded, handwheel	Springloaded, handwheel	Springloaded, handwheel
Feed control		Manual, gravity	Manual	Manual	Manual
Vice		Manual	Manual	Manual	Manual
Dimensions	mm mm mm	1.280 550 1.480	1.120 430 1.480	1.000 430 495	650 310 450
Weight	kg	190	150	30	19

* Machine + options

GENERAL PURPOSE

General Purpose Verticals

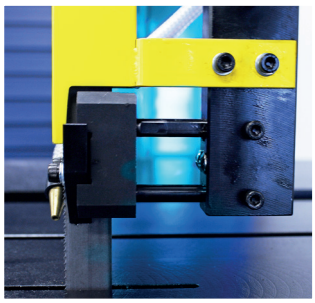
Specifications		V500	V660	V900
Throat, band to column	mm	508	658	915
Max work height	mm	330	355	330
Band width capacity	mm	3-27 mm		
Band length	mm	4.035	4.680	5.020
Table size primary table Secondary table*	mm mm	600 x 700	600 x 700	600 x 700 450 x 700*
Table tilt in degrees R&L	°	12/12	12/12	12/12
Table height	mm	1.000	1.000	1.015
Inverter drive, band speed	m/min	15 - 130 / 175 - 1.500		
	kW	2,2		
Standard electrics		400V, 50Hz, 3 Phase		
Wheels, diameter	mm	515 Rubber tires	665 Rubber tires	515 (2x) 368 (1x) Rubber tires
Upper wheel adjustment	mm	50	50	50
Floor area	mm	1.090 x 810	1.295 x 810	1.760 x 810
Height	mm	2.030	2.140	2.060
Weight	kg	590	665	800

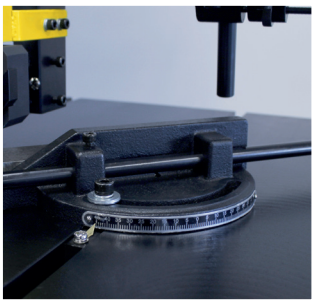
Astro Vertical Sawing Machines

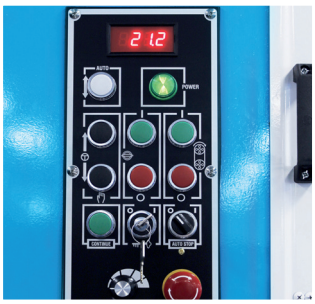
This range of upright metal cutting tools are perfect for numerous cutting jobs. From educational use in schools to cutting steel in mould shops. From cutting floor panels in maintenance facilities for airplanes to contouring aluminium parts at yacht builders. These machines are useful for many different vertical cutting applications in a variety of materials, such as steel, aluminium, brass, stainless steel.

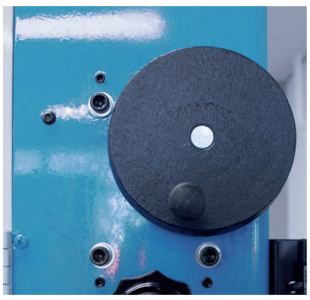
Machines are already equipped with many different accessories to make the cutting job more easy.

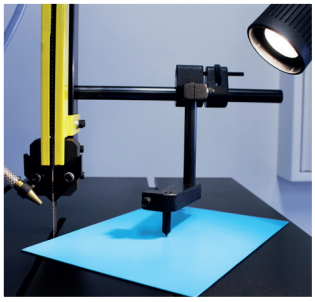
STANDARD EQUIPMENT

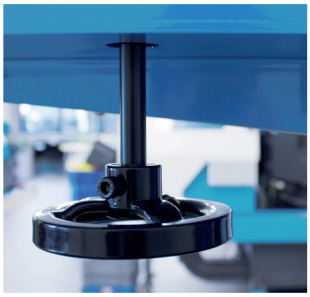

Guideblocks and inserts


Mitring attachment

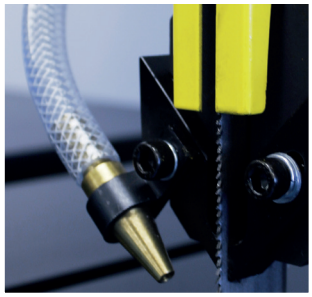

Band speed indicator


Post elevating handwheel


Disk cutting attachment

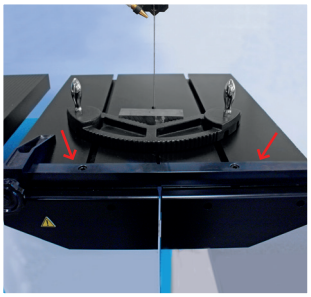

Band tension

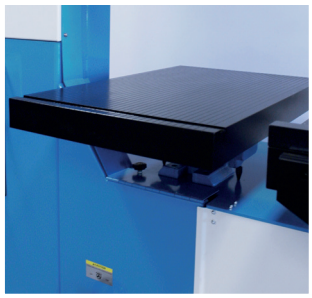

Work light


Chip blower (plant air)


Dust spout

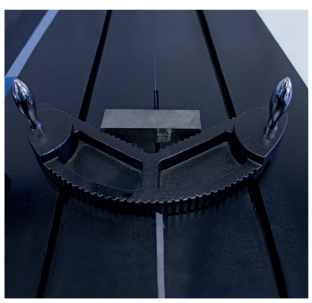

Band door safety interlocks

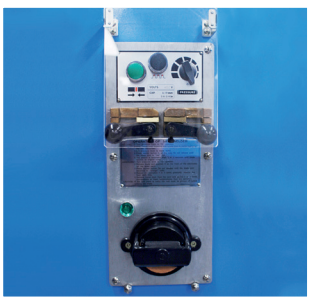

Rip fence


Secondary table*
* Standard on V900 only

OPTIONAL ACCESSORIES

- **Electric driven tables**
- **Mist lubrication system**
- **Work jaw handle**
- **Blade welder**


Work jaw handle


Blade welder

CUTTING FLUIDS

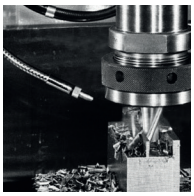
We offer an extensive range of cutting fluids

General purpose

These coolants offer excellent protection for operator and environment. The demands on water-miscible metal working coolants are changing continuously because of production, environmental and operator safety requirements.
DoALL's semi-synthetic fluids optimize the benefits of synthetics and soluble oils in one fluid. These fluids contain mineral oil and performance enhancing chemical additives.

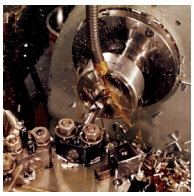
Grinding

These fluids offer the highest level of cooling, best workplace visibility, and are formulated to minimize operator sensitivity. These fluids are low foaming which is ideal in high-pressure coolant systems and also offer good detergent properties for maintaining free cutting grinding wheels. These synthetic fluids offer a long sump life, are very easy to maintain and have the lowest disposal cost.



MQL

Applications were flood coolants are prohibited or not desired. These oils are used with a pneumatic applicator unit and produce "dry" chips because the oil is consumed totally in the cutting operation. These oils are ideal for most cutting, sawing, turning, tapping, drilling and milling operations when applied directly on the tip of the cutting tool. These oils can be used on almost all steels, including stainless steel, titanium, and non-ferrous metals. These oils are a blend of natural raw materials keeping the environment in mind.



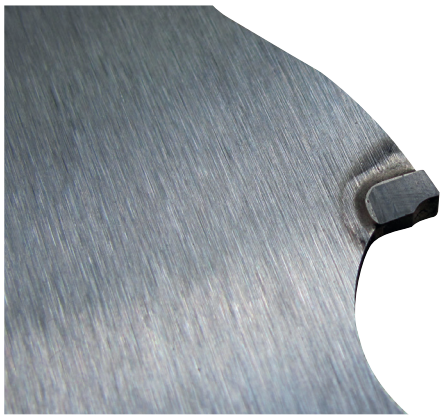
Cutting oil

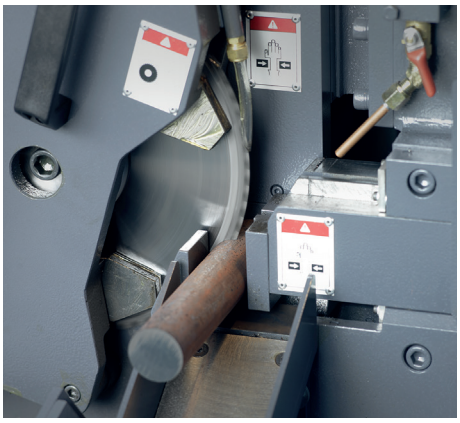
Cutting oils are blends of premium base oils and provide the highest degree of lubrication, longest tool life, and best surface finish of all metal working fluids. These oils provide long fluid life and have no rust issues associated with their use. Plus, these oils do not require dilution, have low to mild odour, and have the least amount of operator sensitivity. In addition, cutting oils are low misting and non-foaming.

COMPLEMENTARY PRODUCTS

Circular saw blades | Disposable

Autocut circular saw blades are designed for use in high performance circular sawing machines, with high demands on productivity, accuracy and surface finish. These saw blades have a special tooth geometry for single use, resulting in a smaller kerf and therefore lower energy consumption and less material loss.The program consists of Cermet tooth tip material for general purpose cutting of a wide range of materials. The tungsten carbide tooth tip with coating is a typical tooth tip material dedicated for cutting stainless steel.





FEATURES

- Cermet tooth tips and tungsten carbide tooth tips with coating available
- Small kerf tooth tips
- Tight tolerances on body flatness

BENEFITS

- Wide range of sawing applications
- High cutting rates, low energy consumption, low material losses
- Less vibration, low noise level, extended blade life, superb surface finish

APPLICATIONS

- Carbon steel
- Alloy steel
- Stainless steel
- Bearing steel
- Tool steel

Band saw blades for example: Bi-Metal | Penetrator

Penetrator

- M42 HSS tooth
- Designed for production sawing
- Moderate to difficult alloys

Penetrator Prime

- Powder metal tooth with hardness of 70 HRc
- Most wear-resistant Bi-Metal tooth
- Moderate to difficult alloys, extended blade life

TiN Penetrator

- M42 with TiN coating
- Use these blades to saw any material recommended for Penetrator blades
- For large volume cutting jobs

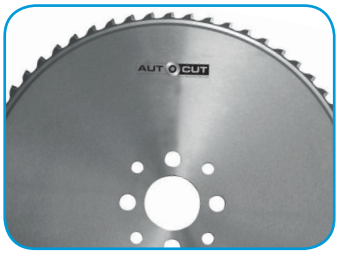
Welcome to DoALL

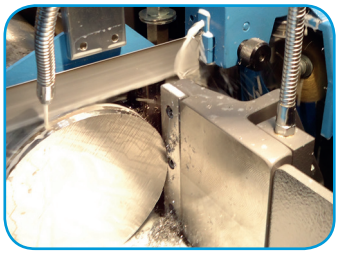
It started with the metal cutting band saw, invented by our founder Mr. Leighton A. Wilkie in 1933. He was the first to produce all three vital elements for band sawing: sawing machines, band saw blades and cutting fluids.
DoALL invented the Bi-Metal band saw blade and released many improvements over the years. Today we are still the trendsetter in band saw blade technology. We have production facilities in the USA; Canada as well as in Europe.

At your service!

The European Distribution Center is located strategically in Dordrecht, The Netherlands. Our sawing products are distributed throughout Europe including the Russian Federation and the Middle East.
Our factory trained local distributors operate their own welding centers to provide fast and local welding service and offer technical support.

Your distributor:





Scan to visit our website!

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