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CUT SAWS
SP720

RANDEK™

BUILDING THE FUTURE

SAWS WITH ANGLED AND INCLINED CUTS

Randek's SP720 series provides reliable cut saws for roof truss, wall, floor and house producers around the world.

The SP720 series is reliable, flexible and easy to use. It has been on the market for decades and is continuously improved in close cooperation with our customers. The blade swivels and tilts, so the saw makes both angled and inclined cuts. The large Ø700 mm blade also cuts up to three stacked board layers in one pass.



Timber picker with additional modular handling system

- Angled cuts 0° to 360° and inclined cuts 90° to 28° (SPL728)
- Stack height up to 250 mm: cut up to three board layers per cycle
- Computer-controlled length stops for fast, automatic setup
- Timber is fixed close to the blade for consistently accurate cuts

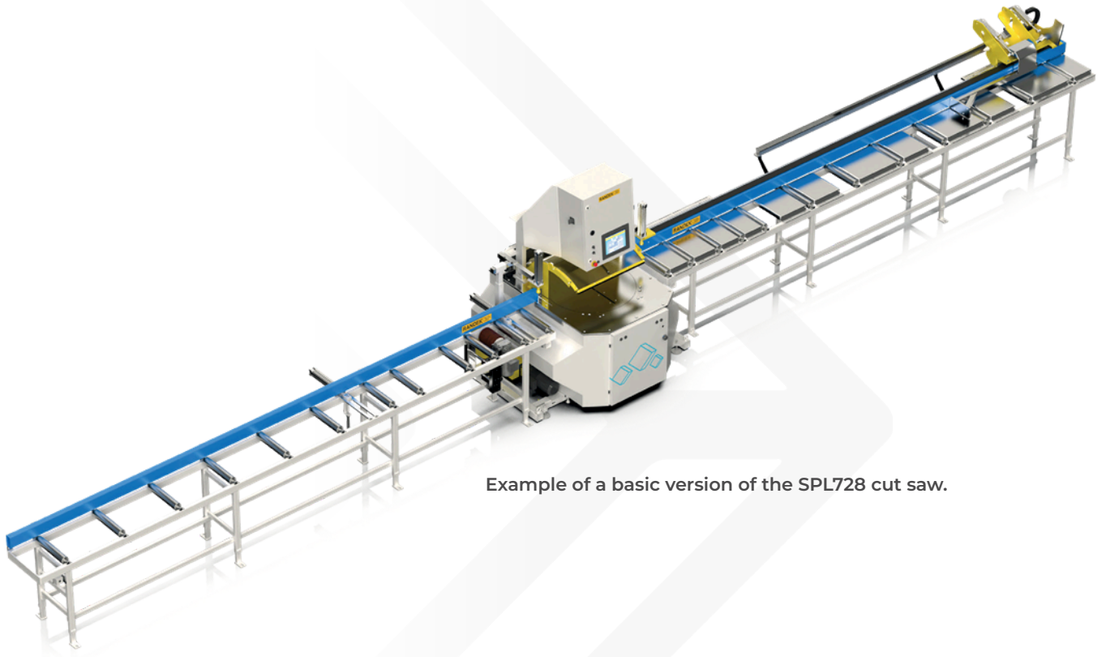


Stacker placing a layer onto the lift table.

SPL728 with outfeed bench and lift table

CUSTOMIZE THE SAW TO YOUR NEEDS

The SP720 connects to an extensive range of peripheral equipment, such as timber pickers, stackers and splicing presses, so the saw line can be configured to your particular needs.



Example of a basic version of the SPL728 cut saw.

- Available in left to right or right to left feeding direction
- Available with or without inclined cuts (SPL728 or SP722)
- Infeed benches from 4 to 11 metres
- Outfeed benches from 6 to 13 metres
- Outfeed stackers and pushers
- Timber picker
- Label printer, milling machine, splicing press
- Customized modular handling system



INFEED BENCH

The SP720 infeed benches come in different lengths with standard equipment: non-driven rollers 400 mm long, a separate timber feeder, retracting devices and plungers.

The retracting devices fix and press the timber against the back fence and straighten it to secure a precise cut. The retracting device works automatically and is activated with each cut.

The plunger holds the timber down on the saw table. Like the retracting device, it is activated automatically with each cut.

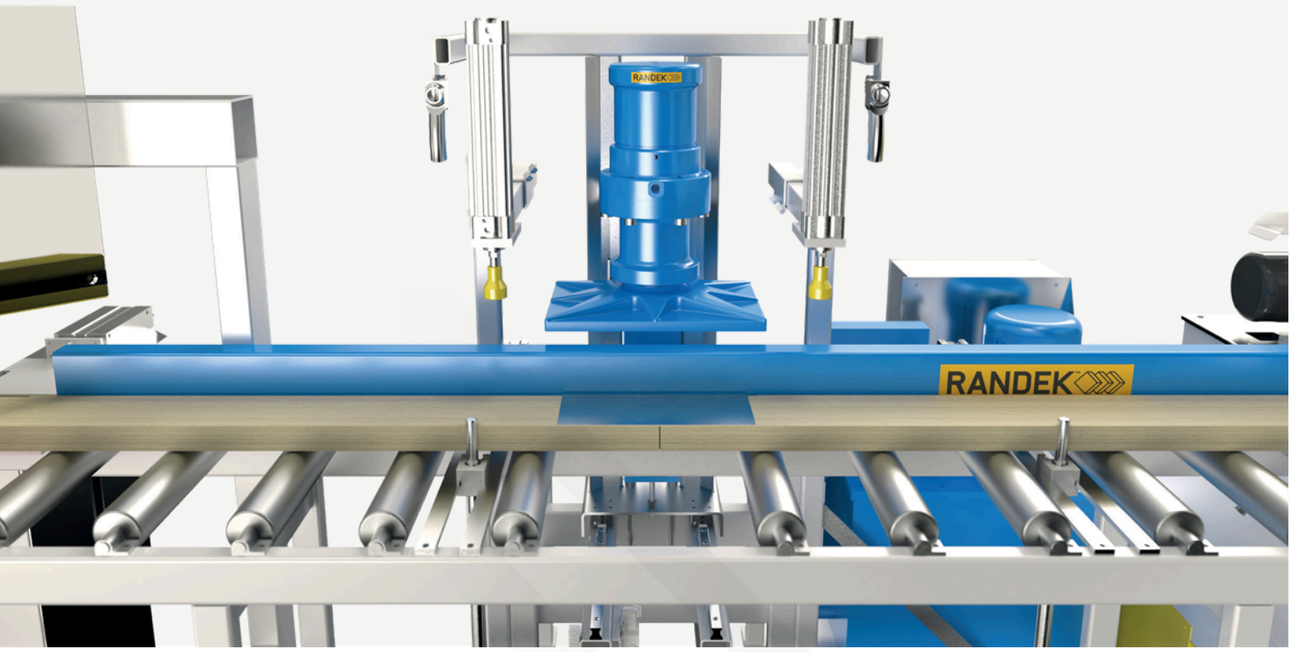
The plunger and retracting device are designed to fix the timber close to the cutting line, as close as possible to the blade, for consistently high accuracy.

The timber feeder transports the timber along the infeed and outfeed benches to its position for each cut. It is operated manually with a push button.



Technical Description

Roller diameter	76 mm
Roller length	400 mm
Timber feeder roller diameter	155 mm
Timber feeder speed	44 m/min
Air and electrical supply from the saw.	

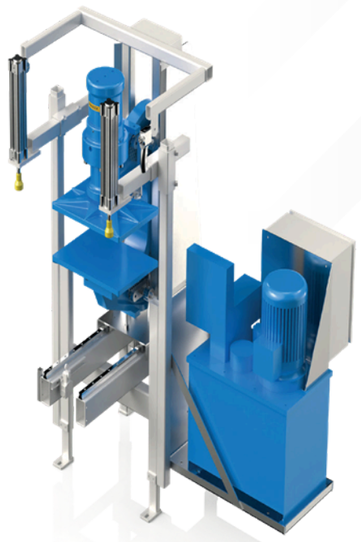


INFEED BENCH
WITH SPLICING PRESS

The splicing press joins timber with nail plates directly on the infeed bench of the saw. Boards can be spliced to any length before cutting, with minimal waste.

The press force is 35 tonnes, and plungers and retracting devices keep the timber aligned during splicing.

The press is operated manually with two-hand pistol-grip activation.



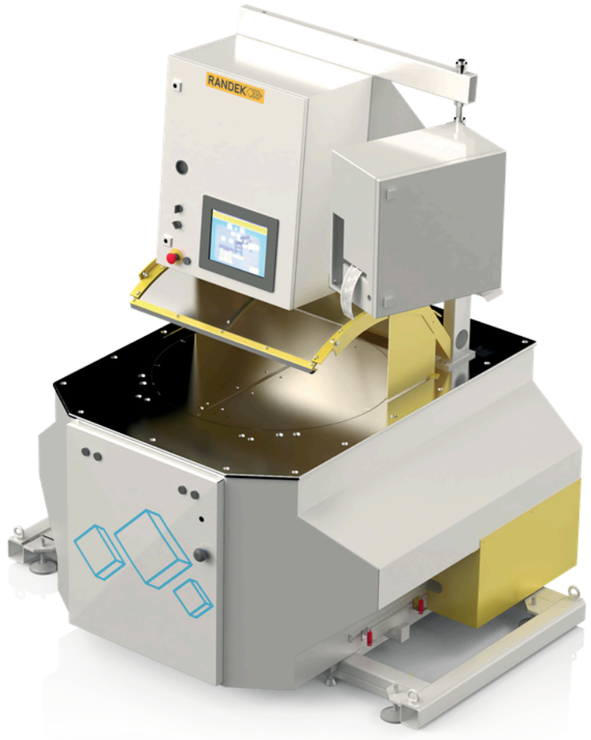
Technical Description	Minimum	Maximum
Roller diameter	76 mm	
Roller length	400 mm	
Timber feeder roller diameter	155 mm	
Timber feeder speed	44 m/min	
Nail plate length	-	420 mm
Nail plate width	-	300 mm
Timber thickness	45 mm*	130 mm
Hydraulic pressure	227 bar (35 tonnes)	
Electricity requirements	Configured to the destination market Contact Randek for consultation	

* Minimum timber thickness can be reduced with a spacer plate. Air supply from the saw.

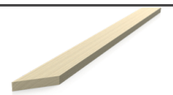
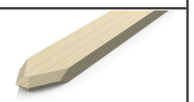
SAW UNIT

The saw units are delivered in two main models: SP722 and SPL728. The main difference is the possible cut types. The SP722 swivels the blade between 0° and 180°, while the SPL728 swivels it 0° to 360° and tilts it between 90° and 28°.

The saws have a protective blade cover that is lowered automatically when the operator makes a cut. The touch screen sits in front of the operator, who can view and change the work process at a glance.



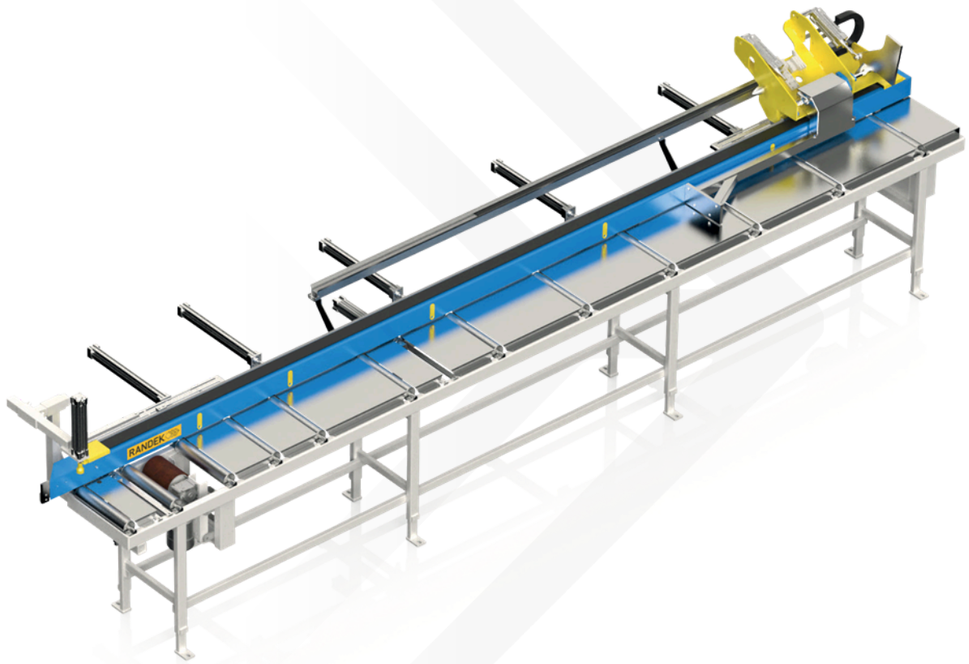
Technical Description	SP722	SPL728
Angular cuts	0° – 180°	0° – 360°
Inclined cuts	–	90° – 28°
Center line adjustment	0 – 250 mm	0 – 250 mm
Saw blade	Ø700 mm	Ø700 mm
Saw motor	5.5 kW	7.5 kW
Electricity requirements	Configured to the destination market Contact Randek for consultation	
Must be connected to an external dust extraction, air speed	4 × Ø125 mm, 30 m/s	

SP722 SPL728	SP722 SPL728	SPL728	SPL728	SPL728
				

OUTFEED BENCH

SP720 outfeed benches have the Randek LX-01 length stop, which positions itself for each piece of timber. It cuts pieces from 50 mm up to the full length of the outfeed bench + 400 mm.

Like the infeed bench, the outfeed bench has retracting devices and plungers for accurate cutting.



Length	Timber feeder
5800 mm	No
7000 mm	No
8200 mm	No
9400 mm	No
10600 mm	No
11800 mm	No
13000 mm	No

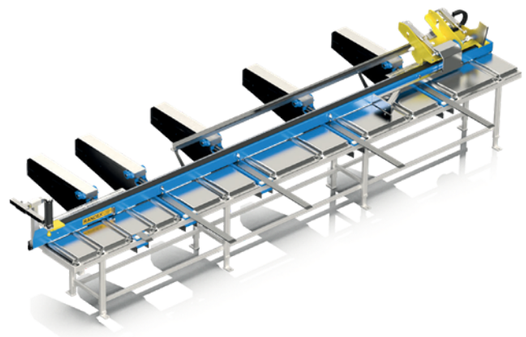
Technical Description	
Roller diameter	76 mm
Roller length	400 mm
Max timber length	Bench length + 400 mm
Air and electrical supply from the saw.	



OUTFEED BENCH WITH STACKER

The stacking unit is an outfeed bench that stacks timber automatically on a hydraulically levelled table. When the timber is cut, a timber feeder moves it forward until its back end reaches a sensor. Then the timber is pushed off the outfeed bench onto supporting arms.

The pusher pushes the timber onto the supporting arms until one complete layer is filled. The supporting arms then retract and drop the layer onto the stack. The lift table lowers itself one layer, so that another layer can be piled. Cassettes with pushers and supporting arms are mounted on the back of the bench. The complete working cycle is automated. The feeding device is fitted with a brake and reversible movement for straight-ended packs.



Outfeed bench equipped with	Length	Timber feeder
Timber stacker with lift table	5800 mm	Yes
Timber stacker with lift table	7000 mm	Yes
Timber stacker with lift table	8200 mm	Yes
Timber stacker with lift table	9400 mm	Yes
Timber stacker with lift table	10600 mm	Yes
Timber stacker with lift table	11800 mm	Yes
Timber stacker with lift table	13000 mm	Yes

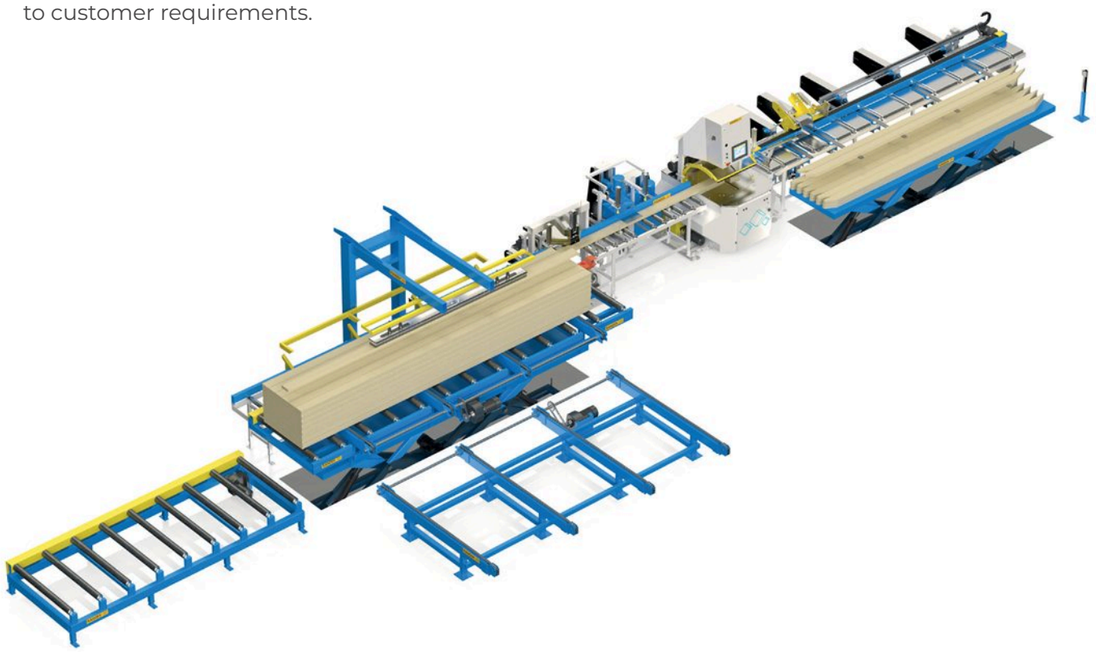
Technical Description	Minimum	Maximum
Roller diameter		76 mm
Roller length		400 mm
Timber feeder roller diameter		155 mm
Timber feeder speed		44 m/min
Stack width	-	800 mm
Stack height	-	900 mm*
Timber length	50 mm**	Bench length + 400 mm
Electricity requirements		Configured to the destination market Contact Randek for consultation

* When the lift table is submerged in the concrete floor
** Minimum length for stacking function = 1200 mm
Air supply from the saw.

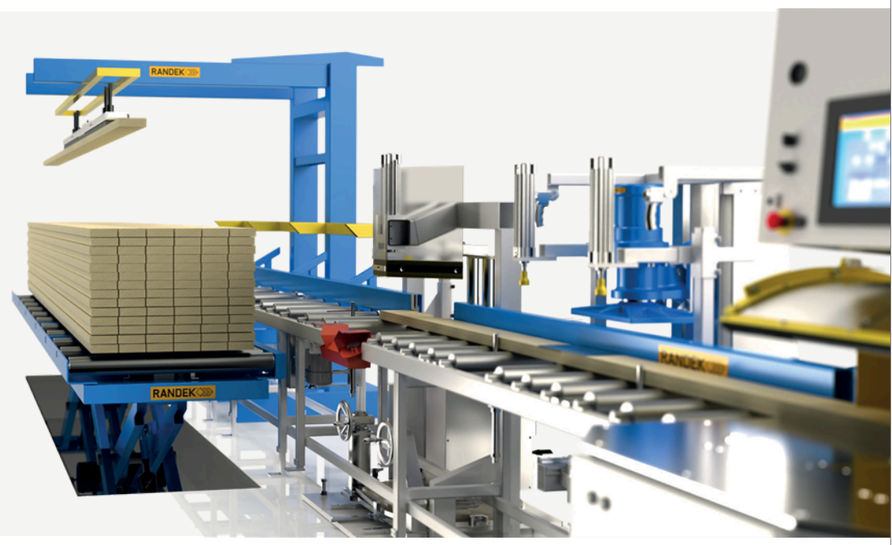
MODULAR HANDLING SYSTEM



• For handling and feeding of entire piles of timber, the saw and timber picker can be equipped with a modular handling system. The system can be configured according to customer requirements.



TIMBER PICKER



The timber picker lifts boards from the timber pile with two vacuum pads and places them on the infeed bench. Sensors on the picker position the pads, and each board is placed on an elevator and lowered to the infeed bench. The operator can flip the board or slide it down onto the rollers, so roof truss producers can align each board's natural curve with the truss.

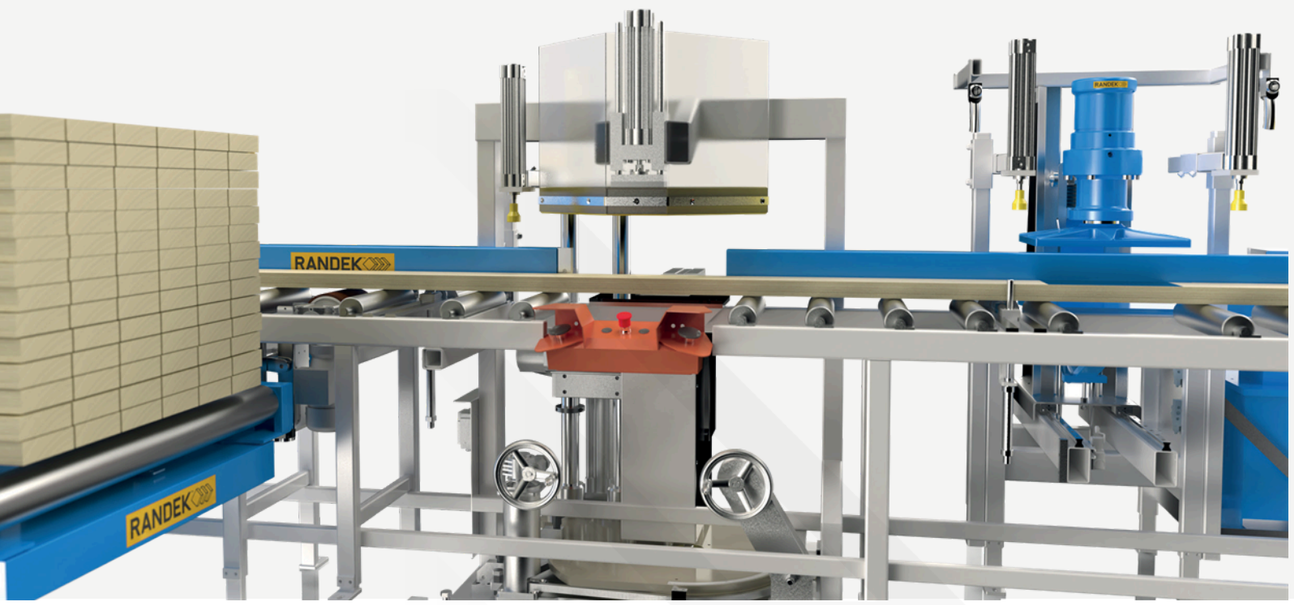
When the picker drops a board on the elevator, it immediately picks the next one, for a capacity of about 5 pieces per minute. The picker accepts different sizes and lengths in the pile, as long as the thickness is the same within each layer.

- Higher capacity in the saw line
- Fewer heavy lifts for the operator

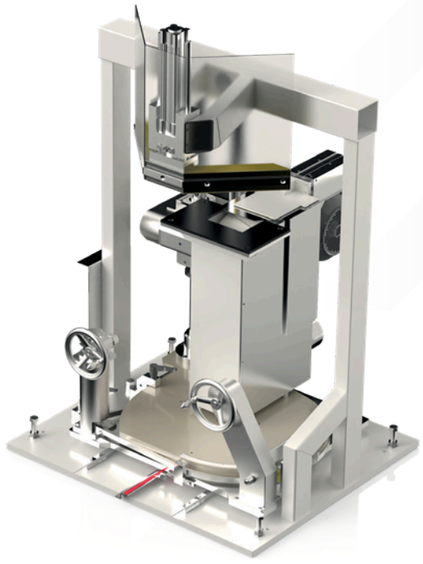
Technical Description	Minimum	Maximum
Timber length	2700 mm	6400 mm
Timber width	70 mm*	300 mm
Pile height	-	1900 mm
Timber pile weight	-	4000 kg**
Capacity	5 pieces/min.	
Electricity requirements	Configured to the destination market Contact Randek for consultation	
Air supply	7 bar - 200 NL/min	

* The minimum timber width can be reduced to 45 mm with smaller vacuum pads
** Lift table capacity

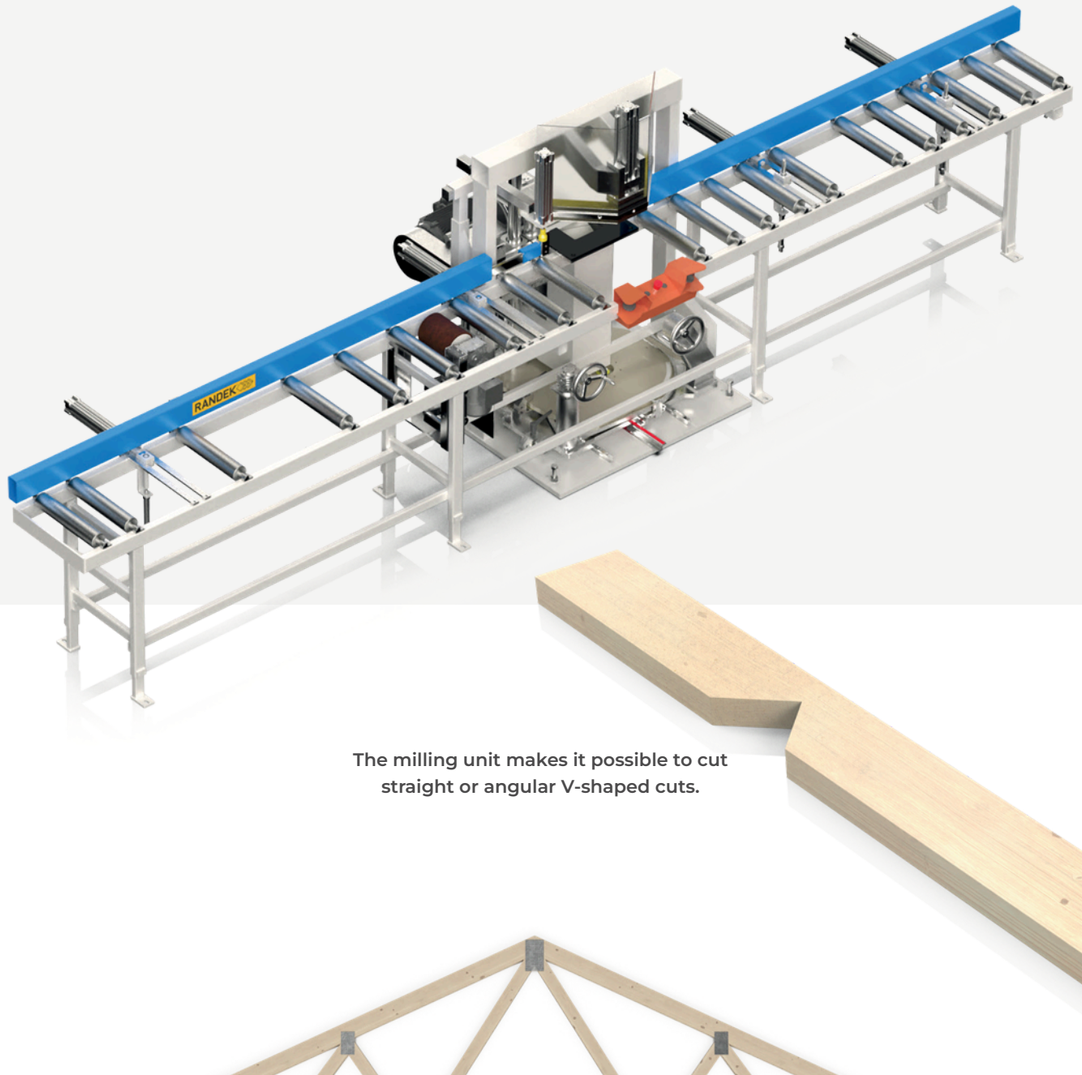
MILLING MACHINE



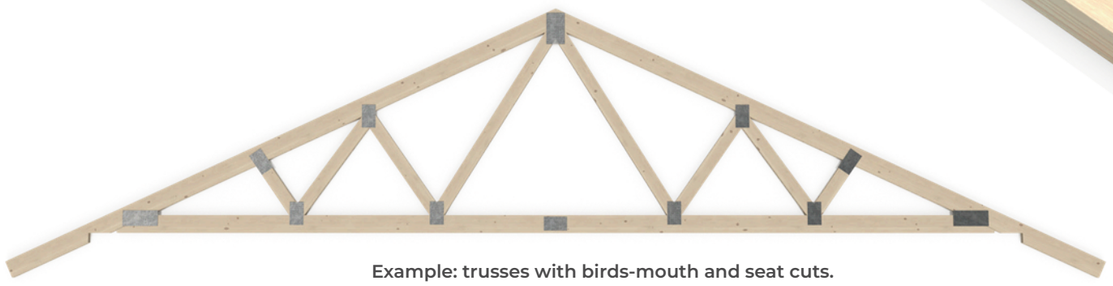
The milling machine (SPL-FVS375) works on its own or alongside the SPL728 and SP722 saws. It is manually adjustable between 0° and 45°, with a cut depth of up to 120 mm, also set manually.



Technical Description	Minimum	Maximum
Milling angle	0°	45°
Milling depth	0 mm	120 mm
Milling cutter	Standard: 180 mm - Ø375 mm	
Motor	7.5 kW	
Dust extraction, air flow	30 m/s	
Electricity requirements	Configured to the destination market Contact Randek for consultation	
Compressed air is fed from the saw unit		



The milling unit makes it possible to cut straight or angular V-shaped cuts.



Example: trusses with birds-mouth and seat cuts.

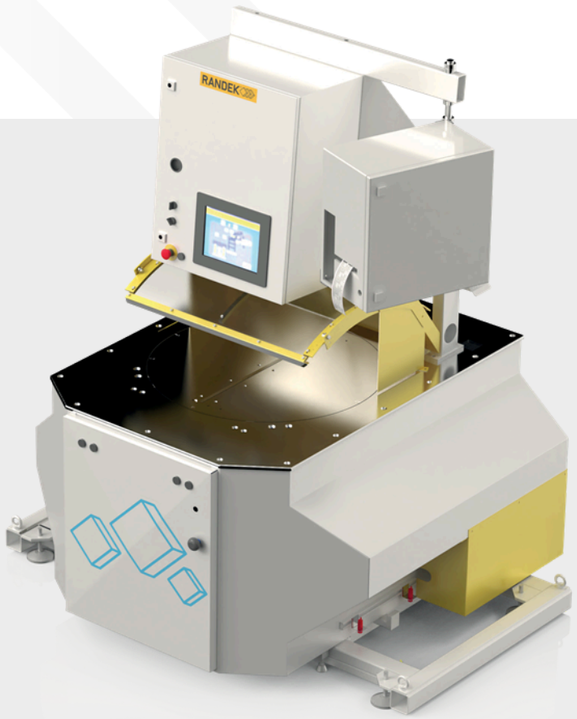
LABEL PRINTER

The label printer is connected to the saw's PLC and prints the company name, CAD file name, width, length and thickness. The printer sits in a cabinet for clean, dust-free operation, and the operator prints on demand with a button on the cabinet.

Print methods: thermal transfer or direct thermal.

Placement

Right
Left



THE SOFTWARE

The saw has an industrial PC with a touch screen showing automatic calculations and changes. The operator follows the process and always sees which cut on which piece is next.

Design boards on the machine, or import complete projects directly from market-leading house and truss design software. Then start sawing.

A LAN/Ethernet connection makes it easy to integrate the saw with your company network and transfer cutting lists for the projects ahead.



The operator can easily follow the work process on the screen.

SWEDISH QUALITY LASTS

Randek has developed automation for the prefabricated house manufacturing industry since 1943. Today Randek supplies high-performance machines, robotic solutions and complete production lines to house manufacturers in 40 countries on four continents.

PRODUCTS/SYSTEM



SP720 SERIES CUT SAWS

Sturdy, reliable cut saws for house and roof truss manufacturers, with computer-controlled length stops.



WALL, FLOOR AND ROOF LINES

Tailor-made systems for prefabricated walls, floors and roofs. From manual to fully automated.



ROBOTIC SYSTEMS

Randek Robotics develops the ZeroLabor Robotic System: robot cells for sheathing, sub-assembly and insulation.



ROOF TRUSS SYSTEMS

Randek Truss System NT for traditional truss production and the AutoEye System for automated pressing.



BUTTERFLY TABLES

Wall-turning tables, a Randek invention from 1963. From a single manual table to a full line.

RANDEK SERVICES



RANDEK PRE-STUDY



MAINTENANCE



GLOBAL SUPPORT



MYRANDEK

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