



Powerful with a modular design

## CUT-OFF MACHINES SERIES IB®

# IB®1B / IB®1



## IB®1B cut-off machine

Easy to operate and ideal for small quantities and single cuts the IB®1B manual cut-off machine is the perfect solution for your requirements. With its manual clamping device, it enables precise cuts and gives you full control over the process. The basic model of the IB®1B offers a manual cut-off wheel feed, which is particularly suitable for single cuts and the cutting off of broken tools. Thanks to its reliability and user-friendliness this cut-off machine is an indispensable addition for your working environment.

### Feed rate

The operator manually controls the feed speed.

### Clamping

Two independently adjustable manual machine table clamps hold the workpiece securely in the prism.

### Length adjustment

The basic machine is supplied without length stop. We offer different variants as options.



## IB®1 cut-off machine

The IB®1 is the solution for precise cuts in small quantities and single cuts. With its user-friendly design, it is easy to operate and offers professional results at the same time.

The IB®1 has a manual cut-off wheel feed and a pneumatic clamping system, which is particularly ideal for single cuts and smaller series.

This cut-off machine offers you the flexibility and efficiency you need to optimize your work processes.

### Feed rate

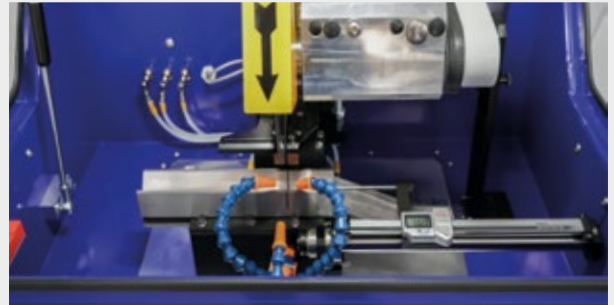
The operator manually controls the feed speed.

### Clamping

Two independently adjustable adjustable pneumatic clamping arms hold the workpiece securely in the prism.

### Length adjustment

The basic machine is supplied without length stop. We offer different variants as options.



## IB<sup>®</sup>2 cut-off machine

The IB<sup>®</sup>2 is the solution for precise separating cuts with minimal effort. With its automatic disc feed it carries out the cut-off cut independently which makes it ideal for use as a side cutting machine. The encapsulated machine guarantees a safe work process and offers you precise results within tight tolerances.

### Feed rate

The semi-automated machine is equipped with a hydropneumatic feed unit, the feed speed of which is controlled via a rotary knob.

### Clamping

Two independently adjustable pneumatic clamping arms hold the workpiece securely in the prism.

### Length adjustment

Various models of length stops guarantee high repeat accuracy of the cut-off cuts.



## IB®2plus cut-off machine

The IB®2plus redefines precision and user-friendliness-new. With its modern, fully encapsulated design and the wheel feed, which is controlled by an electric cylinder, it sets new standards in the industry.

Thanks to this technology, the part to be cut can be approached precisely in fast speed, which saves time and increases efficiency.

The touch display allows you to adjust the cutting speed and the wheel feed rate simply and precisely to have maximum control over the cutting process. Many cutting parameters can be permanently programmed in the system, which minimizes changeover times.

The IB®2plus cutting machine helps you to optimize your work processes.

### Feed rate

Thanks to the machine's electric cylinder, the feed speed can be precisely defined and adjusted. In addition, the feed rate can be automatically reduced shortly before the cut-off wheel comes out of the material to effectively prevent chipping.

### Clamping

Two independently adjustable pneumatic clamping arms hold the workpiece securely in the prism.

### Length adjustment

There are various options available here, ranging from a simple length stop with vernier to a digital solution.



## IB®3plus cut-off machine

The IB®3plus redefines precision and efficiency. With automatic cut-off wheel and workpiece feed it is the ideal machine for machining small series in special tool production.

The cut-off wheel feed is controlled by an electric cylinder, while the workpiece feed is controlled by a high-precision feed unit with integrated glass scale. Single cuts are also possible.

### Optional workpiece magazine

As an additional option, we offer the possibility to equip the machine with an additional magazine for 20 round bars with maximum length of 450 mm. With this magazine, up to three different diameters, each in up to three different lengths can be cut precisely.

Increase your production output and maximize your versatility with this extended equipment option of the IB®3plus.

### Programming the workpiece lengths

The IB®3plus is equipped with an advanced Siemens control system with touch display, which enables user-friendly programming of the individual workpiece. Thanks to the possibility to save many cutting parameters in databases, changeover times can be reduced to a minimum. The machine is designed for bar lengths of up to 750 mm, which makes it a versatile solution for different applications.



## IB®4plus cutting-off machine

The IB®4plus is a fully automatic cut-off machine with automatic bar feed and loading magazine, perfectly suited for series production. Its large loading magazine enables unmanned operation and high productivity.

### Loading magazine

The large loading capacity enables efficient production with minimal manpower requirements. The front placement saves space and gives you optimum ergonomic accessibility when loading the magazine. The uncomplicated adjustment to different rod diameters by turning a rotary crank leads to minimal set-up times.

### Rod feed and cutting lengths

The feed unit with integrated glass scale ensures maximum accuracy. Any cutting length are freely programmable and the control unit automatically calculates the remaining piece length after length and number of pieces.

### Cutting wheel feed

The IB®4plus is equipped with an automatic cutting wheel feed by an electric cylinder. After entering the workpiece diameter in the control unit all traverse paths are automatically calculated and controlled. The feed speed can be programmed via the control unit.

### Clamping

Two independently operating pneumatic clamping arms hold the workpiece securely in the prism.

# Options

		IB®1B	IB®1	IB®2	IB®2 plus	IB®3 plus	IB®4 plus
<b>Length stop</b> Fixed stop without scaling		X	X	X	X		
<b>Length stop with micrometer screw</b> Accuracy in the hundredths range		X	X	X	X		
<b>Digital length stop</b> Coolant-protected, with digital display		X	X	X	X		
<b>Foot switch for length stop</b> For faster cutting in series			X				
<b>Coolant tank with pump</b> Space-saving in the machine base		X	X	X	X	X	X
<b>Connection to central cooling system</b> With control valve for customer's own system		X	X	X	X	X	X
<b>Pressureless switching for right clamping arm</b> For stepped blanks and tools			X	X	X		
<b>Pressure reducing valve</b> For clamping sensitive parts			X	X	X		
<b>Wide left clamping arm</b> For clamping of tools			X	X	X		
<b>Frequency converter</b> For setting the cutting speed		X	X	X	X	✓	✓

✓ = Included

# A concept establishes with success. The Ihle IB® cut-off machine series

Since 1998, G.u.K. Ihle e.K. has been developing and manufacturing high-performance cut-off machines for cutting carbide and other hard materials. The machines, designed according to the modular design concept, have been specially developed to meet the requirements of tool grinders and tool manufacturers. Simple operation, minimum set-up times and clean cuts guarantee high productivity at low costs.



## Technical data

depiction	IB®1B	IB®1	IB®2	IB®2 plus	IB®3 plus	IB®4 plus
Total height	1400 mm	1400 mm	1700 mm	1520 mm	1700 mm	1700 mm
Width	1000 mm	1000 mm	1000 mm	1060 mm	2550 mm	2700 mm
Depth	1500 mm	1500 mm	1100 mm	1100 mm	950 mm	1700 mm
Engine performance	1,5 / 3,0 kW	1,5 / 3,0 kW	3,0 kW	3,0 kW	3,0 kW	3,0 kW
Disc diameter	200 mm	200 mm	200 mm	200 mm	200 mm	200 mm
Separation area	3 - 40 mm	1,5 - 40 mm	1,5 - 40 mm	1,5 - 40 mm	2 - 40 mm	2 - 40 mm

If you would like to find out more about our cut-off machines, our carbides or our grinding technology please get in touch with us. We look forward to hear from you!