



**Title:** **KASTOvertical – the little money-spinner**  
**Topic:** Vertical Bandsaw in use.....  
Press text 46-2006-E / October 2006  
Author Eberhard Betsch Sales Manager Team 3

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**Sub-Title:** Modern manufacturing of tools starts with accurate saw cuts

**Text:**

The company Marks GmbH from Eisenberg in Thuringia, founded in 1992, supplies everything for today's modern tool manufacturing. Within 24 hours after the order is received the approximately 1.400 customers from all over Germany are supplied with saw cuts according to a parts list in all current tool steel qualities and special metals. Standard parts and accessories as well as first level processing and the complete machining of tools with modern milling and deep-hole-boring machines complete the product range.

General Manager Lothar Marks notes that this on-time-delivery can only be guaranteed by utilizing modern processing machines and saws. When selecting the saws, the company Marks trusted the recommendations of the market leader KASTO without any compromises and - considering the constantly growing demand – the machinery was expanded by three new KASTO-bandsaws.

Different saws were purchased in several steps according to the actual demands.

A longitudinally cutting KASTObloc U5 with a cutting length of 4.100 mm and CNC-control is used to cut large parts in different material qualities.

An automatic bandsaw KASTOssb A 2 is used for mass production and individual cuts in the cutting range up to 260 x 260 mm.

Since the company Marks also produces remnants in a considerable amount, the newly developed compact longitudinally cutting KASTOvertical ensures an economic, fast and cost-effective sawing of these remnants. With this machine design, KASTO paid attention to easy, economic and ergonomic material handling. This new machine concept allowed the company Marks to reduce the set-up times to a minimum, especially when cutting small dimensions or remnants. The KASTOvertical is a perfect "little money-spinner" when small blocks and plates need to be cut precisely and efficiently contour-close with little stock allowance. Each tenth of a millimeter unnecessary stock left costs only money, according to Mr. Marks.

Contrary to "moving the saw head while the table is stationary" – mainly used when cutting larger work pieces, the KASTOvertical moves the material support table. This technical characteristic allows the operator outside of the work range of the machine to position, adjust and fixate the material safely and quickly onto the material support table with an ergonomic support height of 1.150 mm.

The cast iron saw table with machined support surfaces and T-grooves is designed for fast and safe clamping of the work pieces. The material support table is guided by linear guides with play-free adjusted carts. When dimensioning these guides, the daily rough operation was taken into consideration. The support tables are moved and positioned via a ball lead screw with servo drive.



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The machine bed with the fixed, distortion-free and vibration optimized saw frame in C-construction – the same proven feature as with the block bandsaws KASTObloc – guarantees quiet running even when processing difficult to cut materials.

The KASTOvertical can process cutting heights up to 600 mm, cutting lengths up to 1.260 mm with a cutting depth of 680 mm and a work piece weight of max. 2.000 kg without any problems.

The KASTOvertical is equipped with a frequency-controlled, large dimensioned saw blade drive as well as a hydraulically controlled saw band clamping.

The KASTOvertical cuts all common material qualities, even difficult to cut ones, economically and with the good cutting qualities, for which KASTO is well known.

High reliability, low downtimes, stability and the necessary cutting precision, the good service net and therefore the high availability of the KASTO-machines make it easy for the company Mark to consider KASTO again in 2007 again when new investments will be made.



Picture 1  
Shows the three Production Bandsaws at Marks: from left KASTObloc U 5, KASTOvertical, KASTOssb 260



Picture 2  
Shows the company building of Marks in Eisenberg



Picture 3  
Shows the KASTOvertical with moving support table: Programming of orders is done easily and ergonomically by the KASTO-CompactControl



Picture 4  
Shows the work range of the KASTOvertical. A material block is positioned on the movable support table ready to be cut