

**KELION<sup>®</sup>**



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**KELION**  
**Automation**

**Professional manufacturer  
of TCT saw blade  
equipment**

**DANYANG QILIANG MACHINERY CO., LTD**

Enlightenment of wisdom, Enlighten the future

<https://kelion-automation.com>

Cooperative brand



Kelion has provided service for more than 1200 manufacturers of saw blades in China and has established cooperative relations with overseas cutting tool manufacturers, including Kanefusa, Leitz, Bosch and Black&Decker. We provide customers with one-stop welding solution and support customized brazing and grinding equipment. After years of development, we have obtained 25 national patents, including the ISO9001 management system certification. Our equipment standard parts are from Omron, Freud, Keyence, Schneider and other well-known manufacture to ensure the efficiency and stability of the machine.

We treat our customers as partners in business, work closely with them to address their marketing problems in their own markets, by conducting in-depth market analysis to recommend suitable products and optimal pricing strategies. As we expected and endeavored, our business partners, customers, and agents of our own brands have continued to gain still larger shares of their respective markets.

**KELION**  
Automation





With the same philosophy, our wills unite like a fortress, achievement centennial enterprise.

Every company that has a century of dreams. But that need employees who have the same heart and soul. And every corner is infiltrated with the essence of corporate culture. In Kelion, we have a good vision and strive for it. In Kelion, we have integrity based business philosophy and put it into practice. In Kelion, we have the technological concept of innovation as the standard, and introduce it into every project research and development. In Kelion, we have a sophisticated and rigorous production concept, and throughout the production of each machine, assembly and testing;

In Kelion, we have an efficient business philosophy, a harmonious team spirit, and penetrate into every business activity.

Vision: leading industry bench marking, achievement hundred years enterprise

Philosophy: integrity, innovation, rigour, efficiency and harmony.

Mission: Based on research and development and innovation, to provide energy-efficient equipment.

Target: Technology leader in brazing equipment industry worldwide.





**KELION**Automation  
**CNC Machining workshop**



# **AUTOMATIC BRAZING MACHINE SERIES**

**HSC750E    HSC400E**  
**HSC790E    HSC400A**  
**HSC300A    HSC750I**  
**HSC790A    HSC1200**  
**MW-800K**

**KELION**Automation  
**Production workshop**





# HSC750E

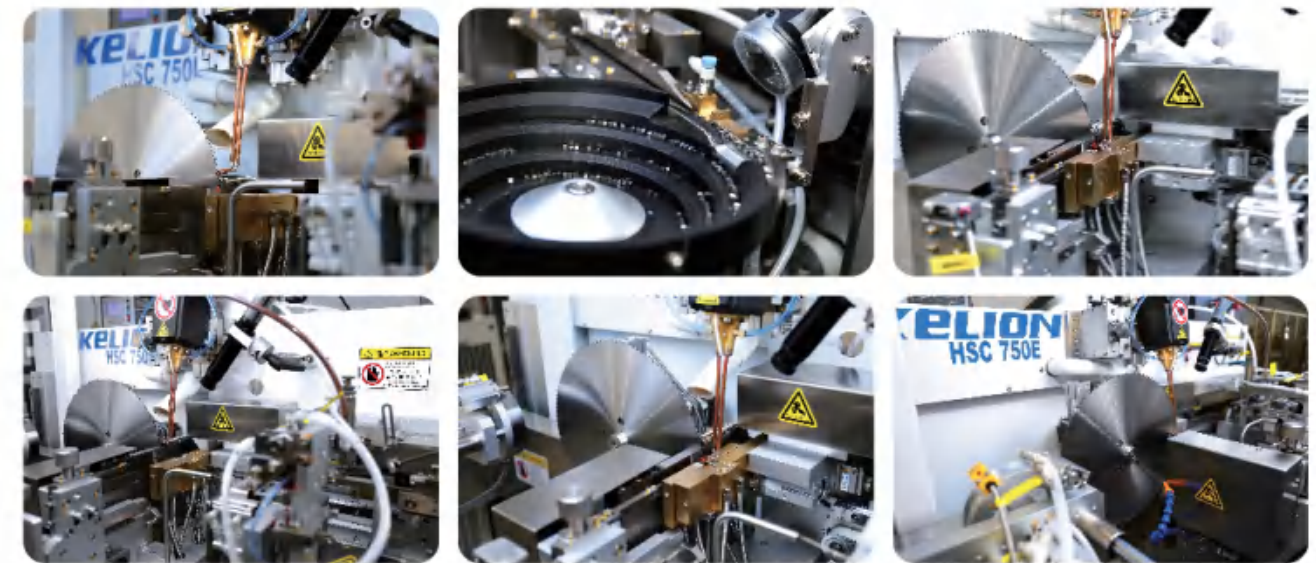
CNC AUTOMATIC BRAZING MACHINE WITH STRAP SOLDER FOR CERMET  
TIPPED METAL CUTTING SAW BLADE (WITH ROBOT)



## TECHNICAL DATA

TECHNICAL DATA	HSC750E
Diameter of saw blades	180mm~500mm
Rake angle	-10°~+20°
Tip width	1.5mm~7mm
Brazing accuracy	≤0.04mm
Thickness of saw blades	1.2mm~5.0mm
Speed of brazing	7~13s/per tooth
The width of silver solder foil	1.5mm~5mm

TECHNICAL DATA	HSC750E
Length of tooth	4.0mm~10mm
General power	6.0kw
Water pressure	≥3KG
Air pressure	≥5.5KG
Electricity	220V(single phase) 50Hz(wire bigger than 6mm <sup>2</sup> )
Gross Weight	800KG
Dimension	1600mm*1200mm*1700mm



### Equipment features:

The high frequency induction heating system controls the temperature automatically. The accuracy of controlled temperature, to ensure welding strength and heating stability, suitable for brazing metal cold saw blade, ironwork saw blade, stainless steel saw blade and aluminum alloy saw blade.

Industrial PC with 10inch touch screen system with both language and logo for parameter setting, easy set-up and operation.

Automatic tooth selection, feeding, dosing, silver solder foil cutting and folding just through one-stage processing.

High precision dosing valve to ensure the accuracy.

Welding the saw tip onto the circular saw blade by control the temperature so that the temperature controlled brazing and annealing cycle allows brazing joints perfectly.

Modern tip sorting system with laser camera and intelligent learning function

### Options:

- Camera inspection system
- Silver wire feeding unit
- Ceia induction heating system



# HSC 400E

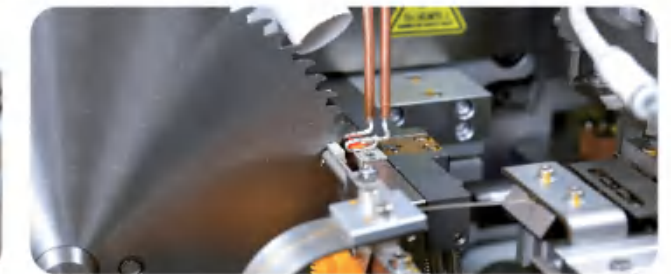
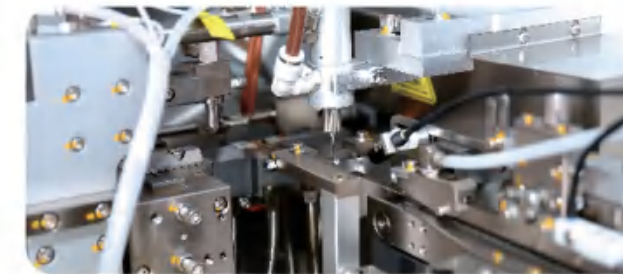
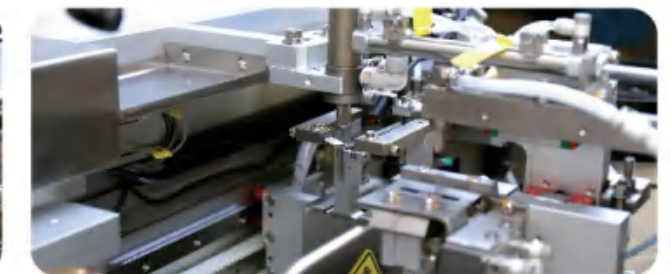
CNC AUTOMATIC BRAZING MACHINE WITH WIRE&STRAP  
SOLDER(WITH ROBOT)



## TECHNICAL DATA

TECHNICAL DATA	HSC400E
Diameter of saw blades	100mm~400mm
Rake angle	-5°~+25°
Tip width	1.5mm-11.5mm
Brazing accuracy	≤0.05mm
Thickness of saw blades	1.0mm~5.0mm
Speed of brazing	4.5~12s/per tooth
The width of silver solder foil	1.5mm~5mm
Time of change blades	8~15s/pcs

TECHNICAL DATA	HSC400E
Length of tooth	4.0mm~10mm
General power	6.0kw
Water pressure	≥3KG
Air pressure	≥5KG
Electricity	220V(single phase) 50Hz(wire bigger than 6mm <sup>2</sup> )
Gross Weight	700KG
Dimension	1600mm*1200mm*1700mm



### Equipment features:

Stable structure with high brazing speed(about 6-12 seconds needed per tooth)

The electronic control system automatically takes, changes, installs and welds saw blades, the whole process takes 10-15 seconds.

Changeover mainly by inputting data into the machine control.

Automatic tooth selection, feeding, dosing, silver solder foil cutting and folding just through one-stage processing.

Suitable for mass production, one person can control 12 equipment at the same time.

### Options:

Camera inspection system  
Ceia induction heating system



# HSC 790E

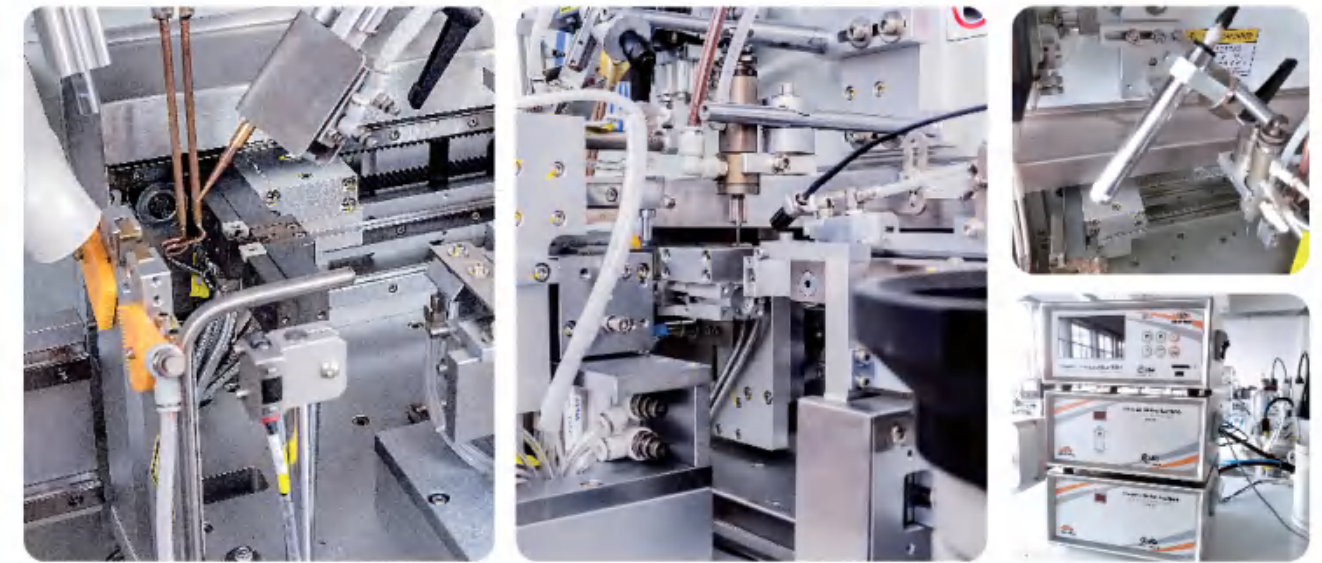
CNC AUTOMATIC BRAZING MACHINE WITH WIRE&STRAP  
SOLDER (WITH ROBOT)



## TECHNICAL DATA

TECHNICAL DATA	HSC790E
Diameter of saw blades	120mm~500mm
Rake angle	-5°~+25°
Tip width	1.5mm~6mm
Brazing accuracy	≤0.05mm
Thickness of saw blades	1.0mm~5.0mm
Speed of brazing	6~13s/per tooth
The width of silver solder foil	1.5mm~6mm
Time of change blades	15~20s/pcs

TECHNICAL DATA	HSC79E
Length of tooth	4.0mm~10mm
General power	6.0kw
Water pressure	≥3KG
Air pressure	≥5.5KG
Electricity	220V(single phase) 50Hz(wire bigger than 6mm <sup>2</sup> )
Gross Weight	800KG
Dimension	1600mm*1200mm*1700mm
Diameter of silver	0.5mm



### Equipment features:

The function of automatically install and unload of blades, suitable for precision cutting board saw, electronic cutting saw, aluminum alloy saw blade, multi-blade saw and other series of saw blades. One person can operate more than 10 machines at the same time, greatly save labor cost.

Silver solder bending unit is continuously variably programmable in all dimensions.

Three groups of rails are adopted for the transmission of tungsten carbide tooth, which improves the running accuracy and service life of rails.

Industrial PC with 10inch touch screen system with both language and logo for parameter setting, easy set-up and operation.

Automatic tooth selection, feeding, dosing, silver solder foil cutting and folding just through one-stage processing.

Welding the tip onto the circular saw blade by control the temperature so that the temperature controlled brazing and annealing cycle allows brazing joints perfectly.

Automatically pick up of the brazed circular saw blade and placing it onto the upper pin of the loading magazine in ergonomic control position for the operator.

### Options:

- Camera inspection system
- Ceia induction heating system



# HSC 400A

CNC AUTOMATIC BRAZING MACHINE WITH WIRE SOLDER(WITH ROBOT)



## TECHNICAL DATA

TECHNICAL DATA	HSC400A
Diameter of saw blades	100mm~400mm
Rake angle	-5°~+25°
Tip width	1.5mm~11.5mm
Brazing accuracy	≤0.05mm
Thickness of saw blades	1.0mm~5.0mm
Speed of brazing	4.5~12s/per tooth
Diameter of silver	0.5mm
Time of change blades	8~15s/pcs

TECHNICAL DATA	HSC400A
Length of tooth	4.0mm~10mm
High frequency power	6.0kw
Water pressure	≥3KG
Air pressure	≥5KG
Electricity	220V(single phase) 50Hz(wire bigger than 6mm <sup>2</sup> )
Gross Weight	650KG
Dimension	1600mm*1200mm*1700mm



### Equipment features:

Stable structure with high brazing speed(about 4.5-8 seconds needed per tooth)

The electronic control system automatically from takes , changes, installs and welds, and the whole process takes 10-15 seconds.

Both sides cylinders automatically fixed saw blades to improve precision.

The high frequency induction heating system control the temperature automatically. The accuracy of controlled temperature, to ensure welding strength and heating stability.

Automatic tooth selection, feeding, dosing, silver solder foil cutting and folding just through one-stage processing.

Suitable for mass production, one person can control 12 equipment at the same time.

### Options:

Camera inspection system  
Ceia induction heating system



# HSC 300A

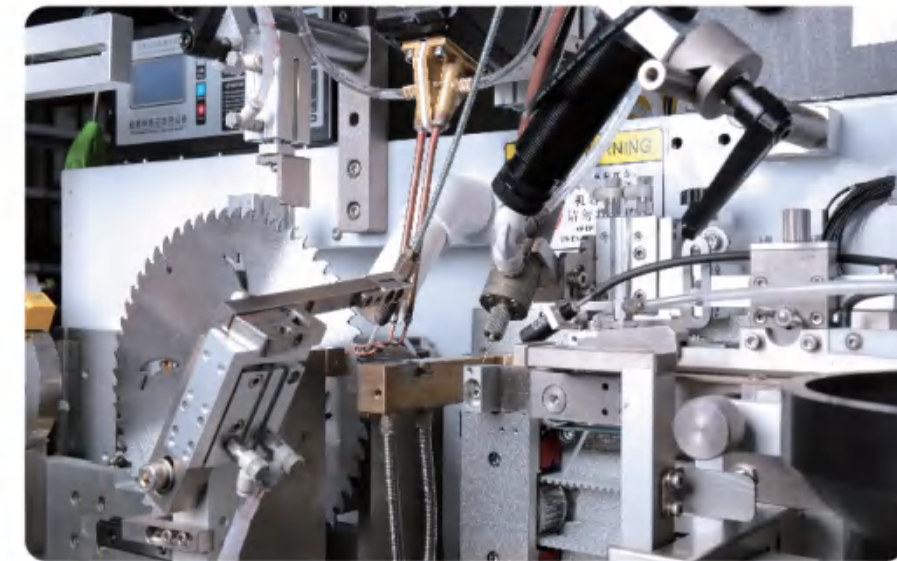
CNC AUTOMATIC BRAZING MACHINE WITH WIRE SOLDER(WITH ROBOT)



## TECHNICAL DATA

TECHNICAL DATA	HSC300A
Diameter of saw blades	100mm~300mm
Rake angle	-5°~+25°
Tip width	1.7mm~6.5mm
Brazing accuracy	≤0.05mm
Thickness of saw blades	1.0mm~5.0mm
Speed of brazing	3.8~6s/per tooth
Diameter of silver	0.5mm
Time of change blades	8~15s/pcs

TECHNICAL DATA	HSC300A
Length of tooth	4.0mm~10mm
High frequency power	6.0kw
Water pressure	≥0.3Mpa
Air pressure	≥5KG
Electricity	220V(single phase) 50Hz(wire bigger than 6mm <sup>2</sup> )
Gross Weight	350KG
Dimension	1100mm*1100mm*1600mm



### Equipment features:

Stable structure with high brazing speed(about 3.8-6 seconds needed per tooth),high brazing efficiency with 4800-7500 tips per 8 hours.

The electronic control system automatically from takes , changes, installs and welds, and the whole process takes 10-15 seconds.

Standard parts using well-known brands: OMRON, KEYENCE, Schneider, Airtac, Taiwan HIWIN and other parts to ensure the high efficiency and stability of the machine.

Automatic tooth selection, feeding, dosing, silver solder foil cutting and folding just through one-stage processing.

High precision dosing valve to ensure the accuracy.

Automatic centering system, advanced high frequency heating controller, infrared temperature measuring device, to ensure welding strength and stability.



# HSC 750I

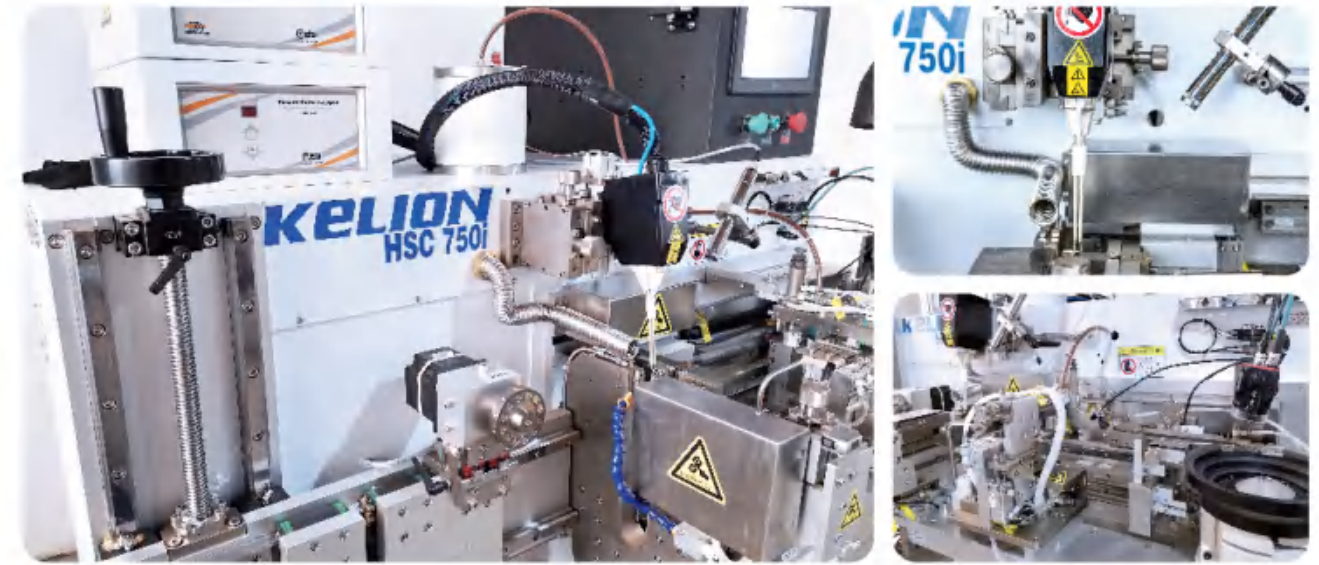
CNC AUTOMATIC BRAZING MACHINE WITH STRAP SOLDER FOR CERMET  
TIPPED METAL CUTTING SAWBLADE



## TECHNICAL DATA

TECHNICAL DATA	HSC750I
Diameter of saw blades	180mm~600mm
Rake angle	-10°~+20°
Tip width	1.5mm~7mm
Brazing accuracy	≤0.04mm
Thickness of saw blades	1.2mm~5.0mm
Speed of brazing	7~13s/per tooth
The width of silver solder foil	1.5mm~5.0mm

TECHNICAL DATA	HSC750I
Length of tooth	4.0mm-10mm
High frequency power	6.0kw
Water pressure	≥3KG
Air pressure	≥5.5KG
Electricity	220V(single phase) 50Hz(wire bigger than 6mm <sup>2</sup> )
Gross Weight	750KG
Dimension	1600mm*1200mm*1700mm



### Equipment features:

The high frequency induction heating system control the temperature automatically. The accuracy of controlled temperature, to ensure welding strength and heating stability, suitable for brazing metal cold saw blade, ironwork saw blade, stainless steel saw blade and aluminum alloy saw blade.

Industrial PC with 10inch touch screen system with both language and logo for parameter setting, easy set-up and operation.

Automatic tooth selection, feeding, dosing, silver solder foil cutting and folding just through one-stage processing.

High precision dosing valve to ensure the accuracy.

Brazing the carbide tips onto the circular saw blade by control the temperature so that the temperature controlled brazing and annealing cycle allows brazing joints perfectly.

Modern carbide tips sorting system with laser camera and intelligent learning function.

### Options:

- Camera inspection system
- Silver wire feeding unit
- Ceia induction heating system



# HSC 790A

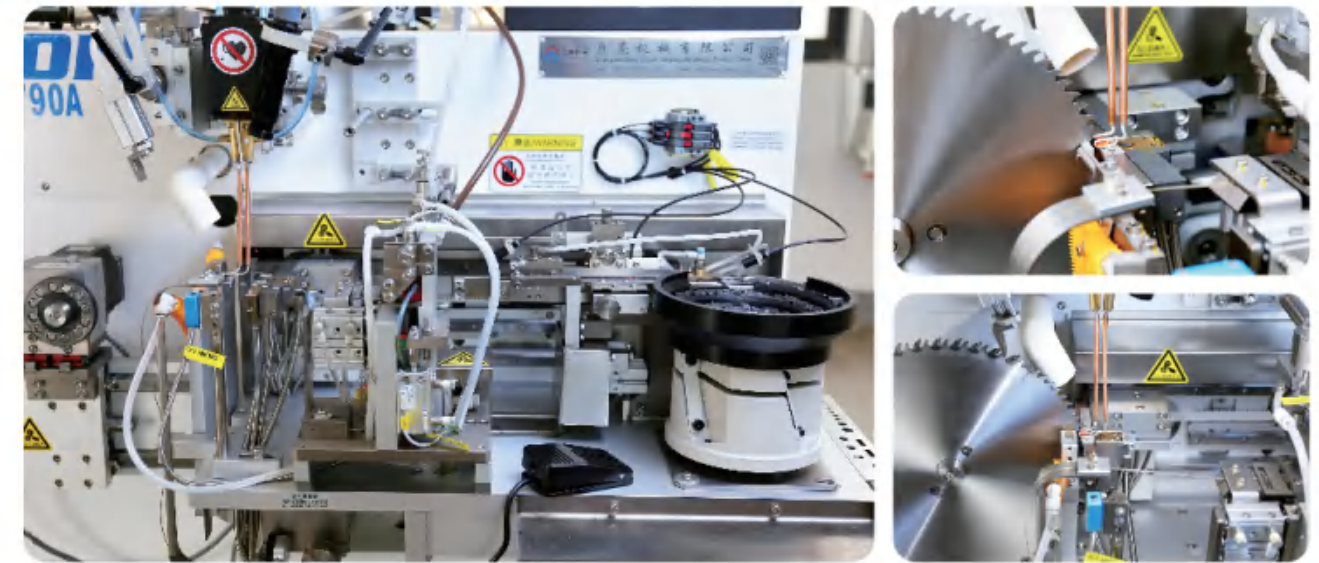
CNC AUTOMATIC BRAZING MACHINE WITH WIRE&STRAP SOLDER



## TECHNICAL DATA

TECHNICAL DATA	HSC790A
Diameter of saw blades	120mm~790mm
Rake angle	-5°~+25°
Tip width	1.5mm~10mm
Brazing accuracy	≤0.05mm
Thickness of saw blades	1.0mm~9.0mm
Speed of brazing	6~12s/per tooth
The width of silver solder foil	1.5mm~6.0mm

TECHNICAL DATA	HSC790A
Length of tooth	4.0mm-10mm
High frequency power	6.0kw
Water pressure	≥3KG
Air pressure	≥5.5KG
Electricity	220V(single phase) 50Hz(wire bigger than 6mm <sup>2</sup> )
Gross Weight	800KG
Dimension	1600mm*1200mm*1700mm



### Equipment features:

Automatic tooth selection, feeding, dispensing, silver solder foil cutting and folding just through one-stage processing.

High precision dosing valve to ensure the accuracy.

The temperature controlled brazing and annealing cycle allows brazing joints perfectly.

One worker could operate 5 equipment at the same time, greatly improved production efficiency and saved cost.

Both sides of cylinders automatically fixed saw blades to improve precision.

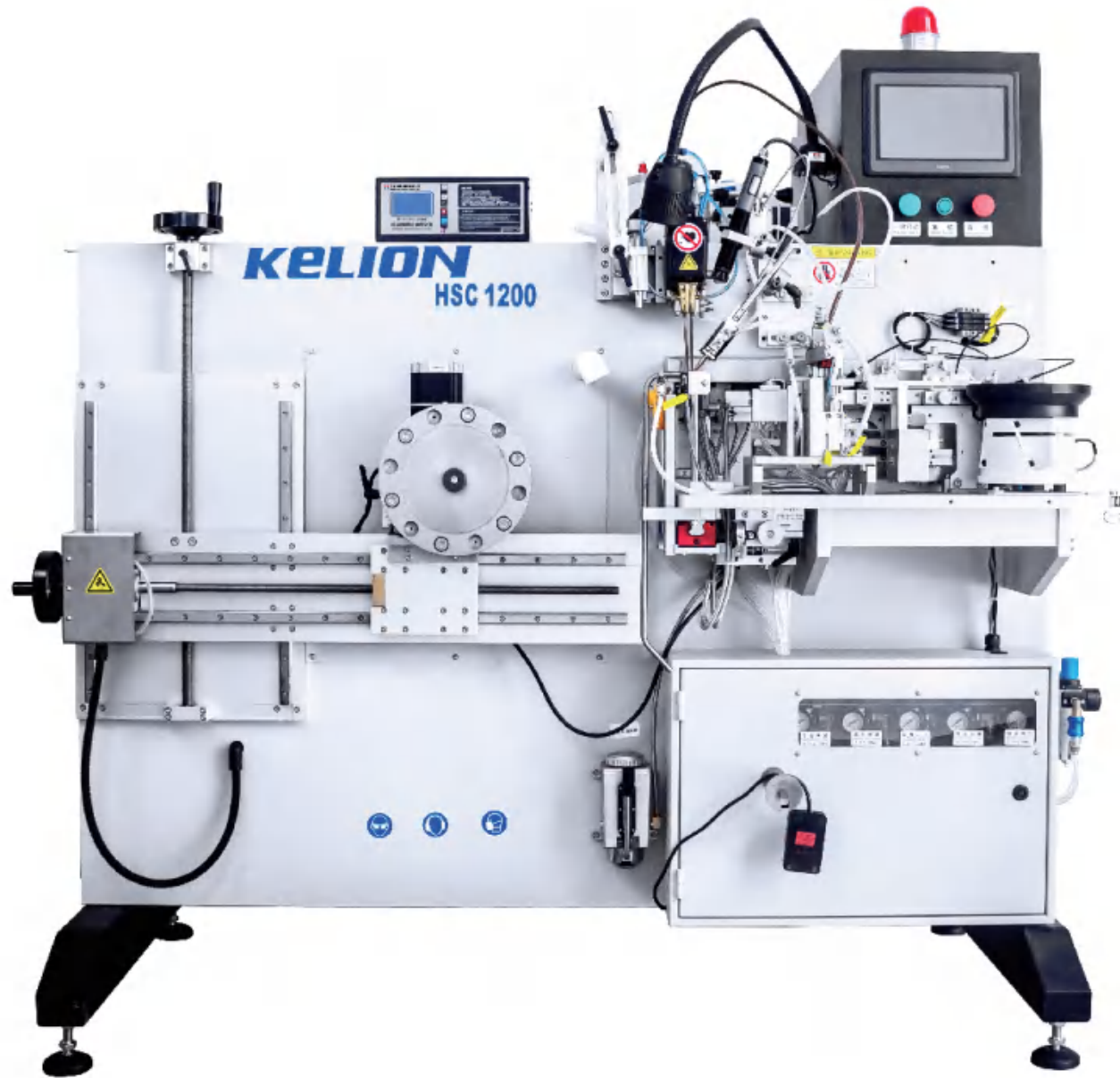
### Options:

- Camera inspection system
- Ceia induction heating system



# HSC 1200

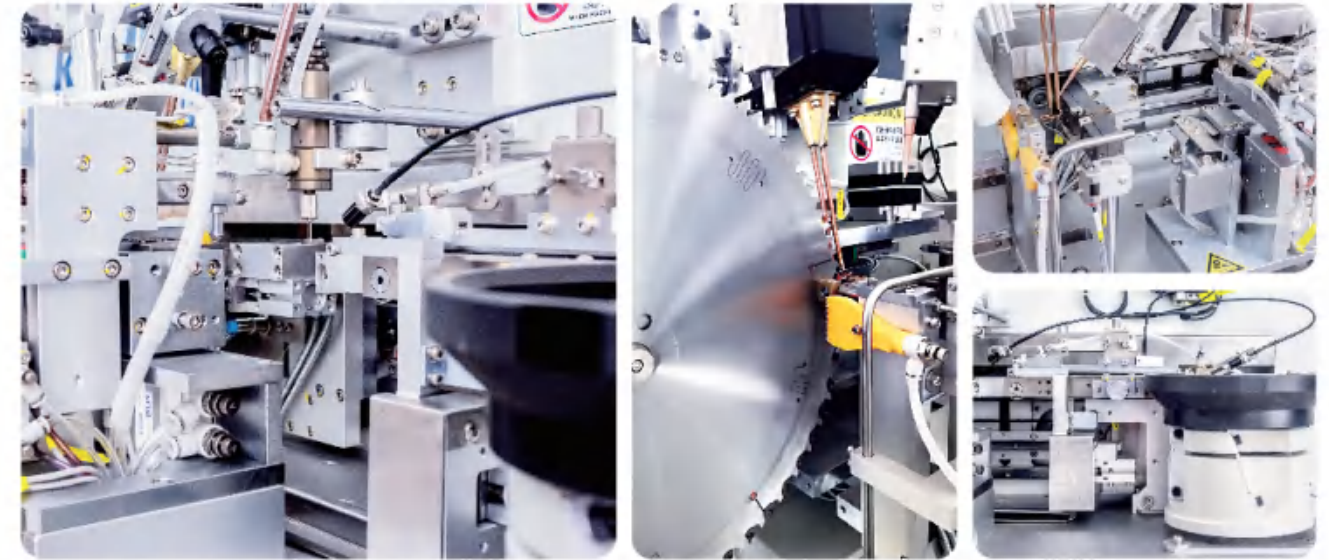
CNC AUTOMATIC BRAZING MACHINE WITH WIRE&STRAP SOLDER



## TECHNICAL DATA

TECHNICAL DATA	HSC1200
Diameter of saw blades	300mm~1200mm
Rake angle	-5°~+25°
Tip width	3mm~12mm
Brazing accuracy	≤0.05mm
Thickness of saw blades	3mm~8.0mm
Speed of brazing	7~15s/per tooth
The width of silver solder foil	2mm~9mm

TECHNICAL DATA	HSC1200
Length of tooth	4.0mm-10mm
High frequency power	8.0kw
Water pressure	≥3KG
Air pressure	≥5KG
Electricity	220V(single phase) 50Hz(wire bigger than 6mm <sup>2</sup> )
Gross Weight	850KG
Dimension	1800mm*1200mm*1800mm



### Equipment features:

Three groups of rails are adopted for the transmission of carbide saw tips, which improves the running accuracy and service life of rails.

The 8KW high frequency heating system allows brazing joints with repeatable quality to ensure brazing stability and welding strength.

Industrial PC with large touch screen system with both language and logo for parameter setting, easy set-up and operation.

Automatic tooth selection, feeding, dispensing, silver solder foil cutting and folding just through one-stage processing.

The temperature controlled brazing and annealing cycle allows brazing joints perfectly.

Both sides cylinders automatically fixed saw blades to improve precision.

### Options:

Camera inspection system  
Ceia induction heating system



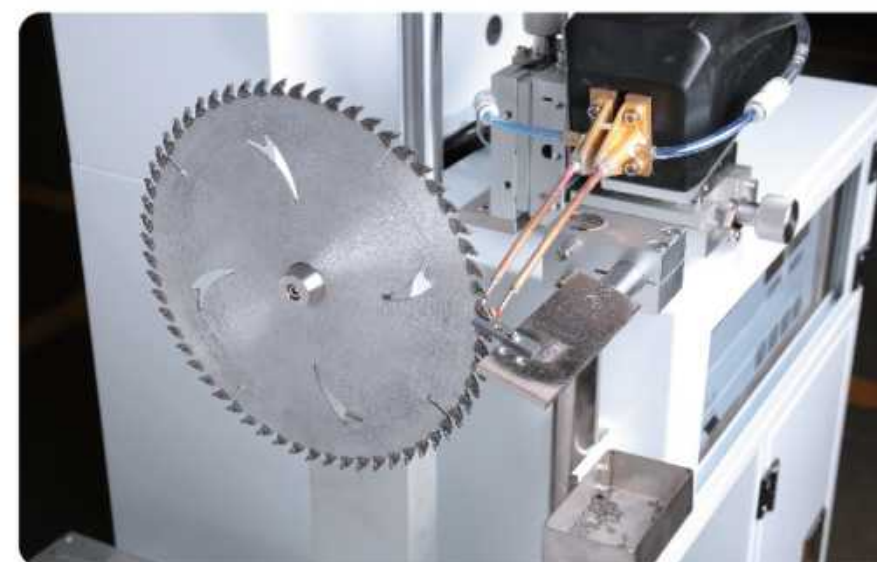
# MW-800K

## MANUAL HIGH FREQUENCY WELDING MACHINE



## TECHNICAL DATA

TECHNICAL DATA	MANUAL HIGH FREQUENCY WELDING MACHINE
Diameter of saw blades	100mm-800mm
Rake angle	-5°-+25°
General power	6.0kw
Water pressure	≥0.25Mpa
Electricity	220 V (single phase)
Dimension	760mm*500mm*1135mm



### Equipment features:

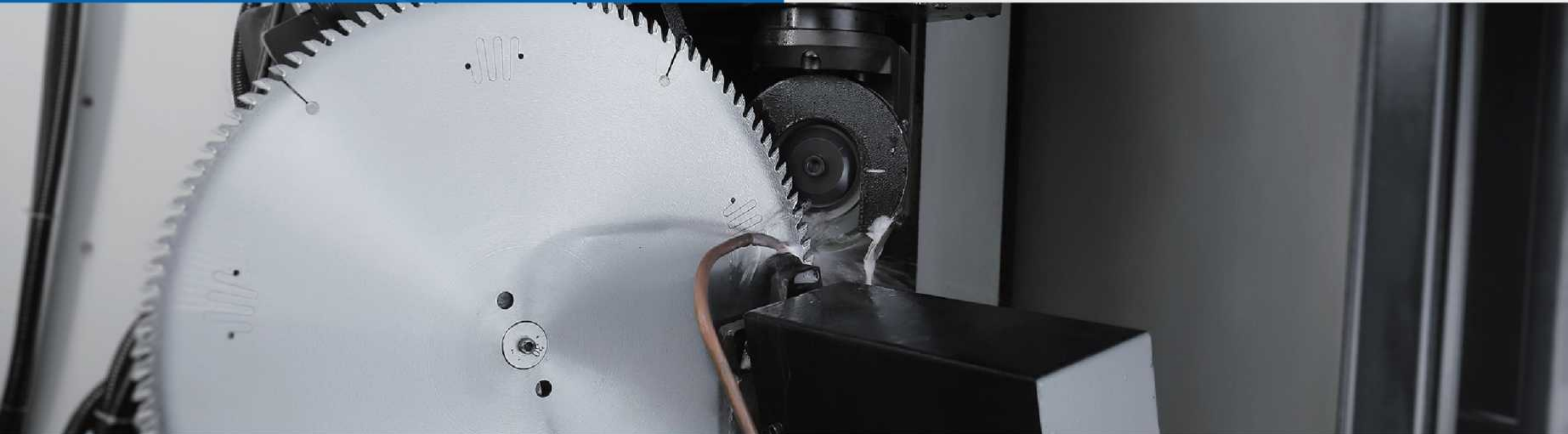
1. In order to facilitate operation, two heating modes for the manual welding machine: Mode 1 is to step on the foot for a long time to heat, loosen the heating will stop; Mode 2 is to set the temperature and time on the screen, and to heat the foot automatically.

2. Suitable for saw blade tooth filling, tooth change, renovation.

3. Large power, fast speed, wide application range, can weld all kinds of saw blades.



# GRINDING MACHINE SERIES



DC650 DS650  
DF650

***KELION***  
Automation



# DC 650

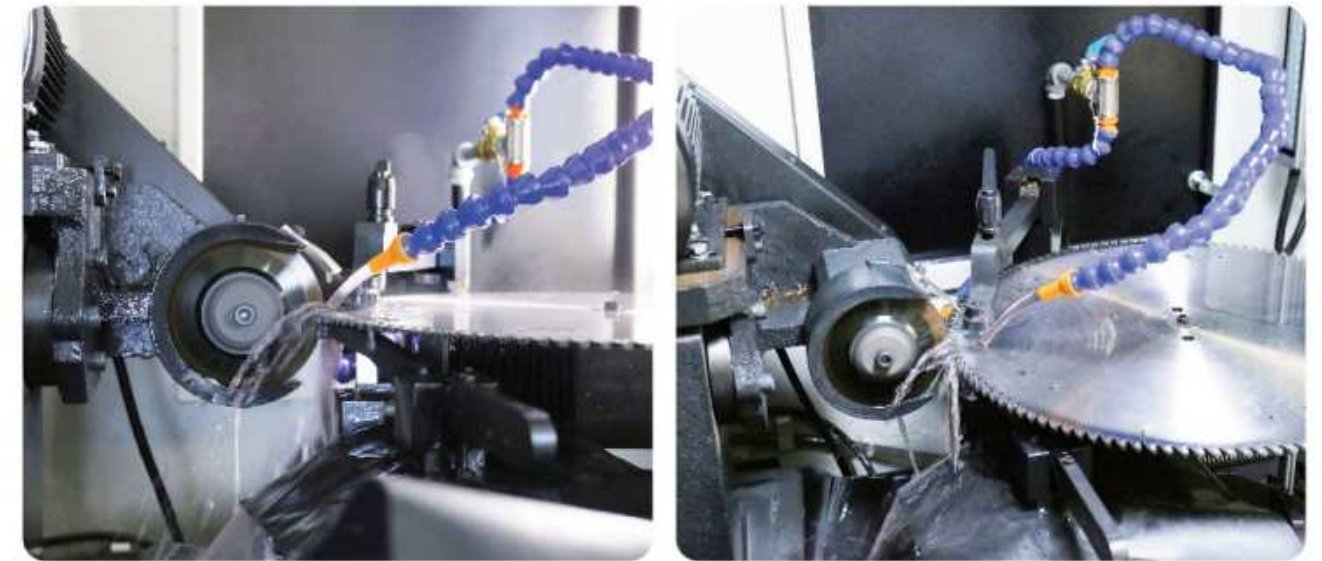
## CNC RAKE ANGLE SHARPENING MACHINE



## TECHNICAL DATA

TECHNICAL DATA	DC 650
Input voltage	AC380V/50 Hz
Power	3.2KW
Diameter of saw	120~650mm
Thickness of saw	1-6mm
Rake angel	-5~30°
Tip width	0.5~10mm

TECHNICAL DATA	DC 650
Tip length	3~20mm
Grinding speed	4~20S/tip
Diamond wheel	φ150* φ32*6mm
Dimensions(L*W*H)	1550mmX1300mmX1800mm
Weight	1200KG



### Equipment features:

At present, the rake angle grinding machine can choose the grinding method (swing type grinding and straight-line grinding) according to the size of the rake angle.

It can grind the tooth surface of various tooth shapes. The program comes with a conventional tooth shape. The user can edit the complex tooth shape by himself. Up to 15 groups of tooth shapes can be set, which has advantages for tooth grouping.

The grinding speed and feed rate can be set freely according to the alloy size and grinding amount, and the processing time is 5S to 25S/tooth.

The machining accuracy is high, and the error is less than 0.02mm. The flank face can be processed first and then the rake face without changing the radial runout of the saw blade.

Easy to operate, all machine parameters can be set on the operation panel, and one person can operate more than 10 devices.

With automatic compensation system, the compensation amount is set according to the grinding wheel, which can greatly improve the accuracy and processing efficiency.



# DS 650

## CNC SIDE SHARPENING MACHINE



## TECHNICAL DATA

TECHNICAL DATA	DS 650
Input voltage	AC380V/50 Hz
Power	3.2KW
Diameter of saw	120~650mm
Thickness of saw	1-6mm
Rake angel	-5~30°
Tip width	0.5~10mm

TECHNICAL DATA	DS 650
Tip length	3~20mm
Diamond wheel	φ 150* φ 32*6mm
Grinding speed	5-25s/tip
Dimensions(L*W*H)	1550mmX1300mmX1800mm
Weight	1200KG



### Equipment features:

High degree of automation, select the servo four-axis drive system, the backlash angle can be set directly, and the side clearance angle can be set directly from the operation panel.

It can grind positive and negative backlash angle saw blades (single scoring saw, etc.), and can grind group tooth (non-equidistant tooth profile), and the operation is extremely convenient.

Different feed rate and grinding speed can be selected according to the grinding wheel and alloy to achieve the required surface finish.

With automatic compensation system, according to the selected grinding wheel quality and grinding amount, the grinding wheel consumption compensation amount can be set by itself.

High efficiency, through the program to optimize the four-axis coordination, reduce the time of empty knife, and improve the effective operation rate of the equipment.

Suitable for processing products: high-end power tools, domestic professional saw blades.



# DF 650

CNC SURFACE AND TOP ANGLE SHARPENING MACHINE



## TECHNICAL DATA

TECHNICAL DATA	DF 650
Input voltage	AC380V/50 Hz
Power	3.2KW
Diameter of saw	120~650mm
Thickness of saw	1-6mm
Rake angel	-5~30°
Tip width	0.5~10mm

TECHNICAL DATA	DF 650
Tip length	3~20mm
Grinding speed	4~20S/tip
Diamond wheel	φ150* φ32*6mm
Dimensions(L*W*H)	1550mmX1300mmX1800mm
Weight	1200KG



### Equipment features:

It is driven by the French Schneider four-axis numerical control system, all angles are directly set, the operation is extremely convenient, and the grinding accuracy: no more than 0.02mm.

High-rigidity guide rail, low-vibration grinding head, select the appropriate grinding wheel size and feed rate, can grind the mirror effect.

All kinds of tooth saw blades can be ground, the grinding amount can be set freely, and the sliding gear mechanism improves the efficiency of the equipment.

Automatic compensation system, according to the selected grinding wheel quality and grinding amount, the grinding wheel compensation amount can be set freely.

Fully enclosed automatic operation, creating a clean working environment, one person can operate multiple machines.

Suitable for processing products: high-end power tools, panel saws, electronic cutting saws, aluminum alloy saw blades.





# ANCILLARY EQUIPMENT SERIES

**WST 1000K**    **QL-850**  
**RT-70**        **ST-70**  
**SD-70**

# WST 1000K

BRAZING BOND STRENGTH MEASURING UNIT



## TECHNICAL DATA

TECHNICAL DATA	WST 1000K
Diameter of saw blades	120mm~800mm
Rake angle	-5°~+25°
Max. pressure force	10kN
Accuracy	Better than 1%
Electricity	220V(single phase) 50Hz(wire bigger than 6mm <sup>2</sup> )
Power	1.2KW
Gross Weight	150KG
Dimension	500mm *800mm *1250mm



# QL-850

AUTOMATIC BRUSH MACHINE



# RT-70

RADIAL RUNOUT TESTING MACHINE



## TECHNICAL DATA

TECHNICAL DATA	QL-850
Diameter of saw blades	Φ165~Φ850 mm
Working air pressure	6 kg/cm <sup>2</sup>
Voltage	380 V(three-phase voltage)
Total Power	6 Kw/h
Ventilating ability	>5 m <sup>3</sup> /min
Antirust fluid	Water:1:10

### Equipment features:

QL 850 Automatic brush machine is a special equipment designed for welding spots on circular saw blades. It can be used to polish and cover welding spots by rotating grinding the welding position of saw blades through the installed steel wheel. Its high efficiency, good brush effect, clean and bright; The equipment is simple and easy to operate, PLC control processing data, high stability; Different from the traditional sandblasting process, the product is more beautiful, more environmental protection; It does not change the stress of the saw blade as easily as sandblasting.

## TECHNICAL DATA

TECHNICAL DATA	RT-70
Diameter of saw blades	100-700mm
Dimensions(L*W*H)	400*260*700mm
Weight	25kg
Accuracy	≤0.005mm

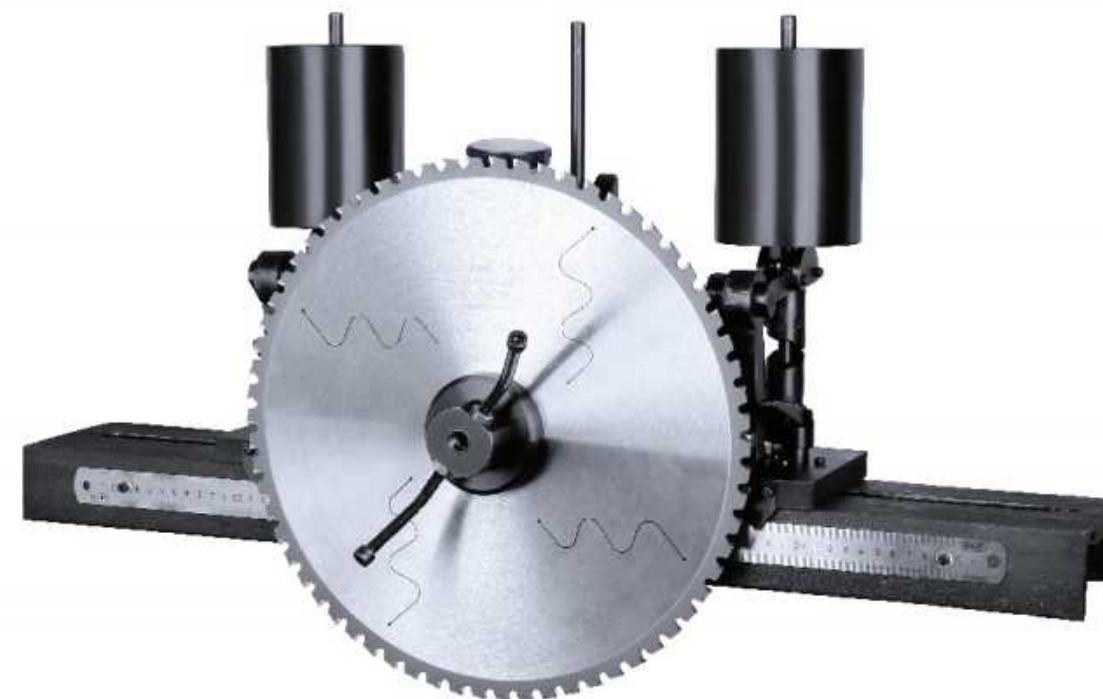


# ST-70

SIDE RUNOUT TESTING MACHINE

# SD-70

STRESS DETECTOR



## TECHNICAL DATA

TECHNICAL DATA	ST-70
Diameter of saw blades	100-600mm
Dimensions(L*W*H)	360*150*260mm
Weight	13kg
Flange face runout	<0.005mm
Flange	100mm
Flange centre bore	20/25.4/30/32/40/45/50/55/60/65/70/75/80/90

## TECHNICAL DATA

TECHNICAL DATA	SD-70
Diameter of saw blade:	MAX 800mm
Dimensions(L*W*H)	800*280*400mm
Weight	40kg
Accuracy	±1