

KHF 300

Fully automatic side grinding CNC machine for complete machining of the side angles of carbide-tipped circular saw blades [with integrated measuring system and preparation for robotization]



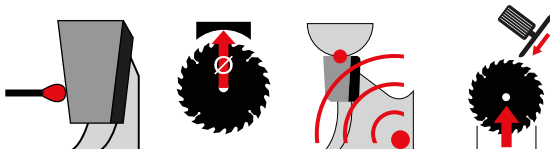
The tooth geometry is grinded in only one setting. Each saw blade is automatically positioned independently of the diameter when it moves into the grinding position. A measuring probe then measures the tooth geometries.

High precision is a prerequisite for later exact grinding results.

Highlights

- ✓ Conceived and designed for the fully automatic processing of carbide-tipped circular saws
- ✓ Blade feed from right to left, including radius tracking
- ✓ The space-saving machine design allows for high ergonomics and excellent usability
- ✓ Easy access for maintenance work to the electrical cabinet, coolant pump, pneumatics and extinguishing systems
- ✓ Unlimited storage for circular saw parameters
- ✓ Optimal, fast and safe programming and setup of circular saw parameters
- ✓ The positioned tooth can also be ground completely in several passes.
- ✓ Manual or automatic (using a probe) repairment tooth recognition
- ✓ Measurement protocol of the side clearance and centricity offset
- ✓ Ready for the integration of a fully automatic loading system (robot)

Application programmes



Modes

- Symmetrical grinding starting from the center of the blade body
- Grinding based on automatic setting of tool zero points
- Grinding based on manual setting of tool zero points

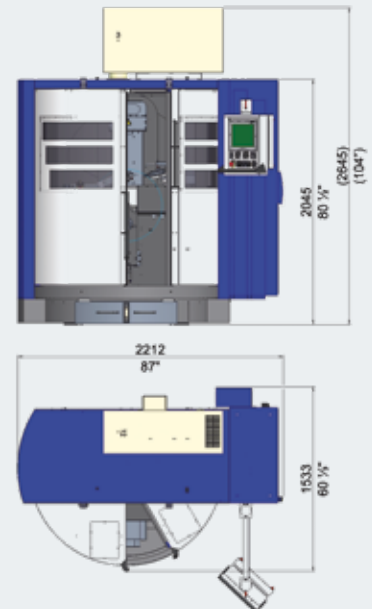
Measuring

- Blade body and cutting width
- Side clearance rear/front
- Centricity
- Diameter

Functions

- Automatic measurement
- Automatic diameter detection
- Automatic probing / tracing
- Automatic saw blade positioning

Technical Data



GENERAL INFORMATION:

Tooth geometry	programmable
Tooth pitch	10° - 120° mm
Blade thickness	up to 8 mm
Tooth face clearance angle	0 - 5°
Tooth back clearance angle	0 - 5°
Circular saw outer Ø	180 - 860 mm (without Robot) 200 - 820 mm (with Robot)
Circular saw bore Ø	22 - 200 mm optional from Ø 15 mm
Cup grinding wheel Ø:	100 mm
Grinding wheel bore Ø:	32 mm

PROPERTIES:

Electrical connection:	400V 3Ph 50Hz, 6 kVA
Compressed air connection:	6 bar