BNF 100

Fully automatic 4-axis-CNC side grinding machine for band saw blades in wet grinding execution

The BNF 100 is suitable for all band saw blades - including thin-cutting saws.

The two stable grinding units with a grinding wheel diameter of 75, 100 or 125 millimetres ensure optimum cutting performance with high precision and grinding quality.

Highlights

- ✓ Side-grinding of standard, Stellite- & Carbided-tipped band saw bladesmittels - by means of CHC axes "X", "Y" & "Z" (grinding of the positioned and clamped saw tooth)
- ✓ Automatic electrically controlled saw blade height adjustment
- ✓ Saw blade height stop for precise saw blade positioning
- ✓ Additional auxiliary pneumatic clamping at the saw tooth (for stabilizing thin saw teeth)
- ✓ "LINUX Debian 10" control unit with multicore processor
- ✓ Pneumatic saw blade clamping, with force relief during feed
- ✓ Automatic probing of the grinding wheels on the saw tooth
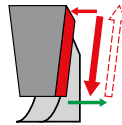- ✓ Precision angle adjustment (nonius)

Grinding programs
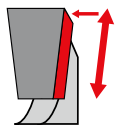
Grinding-wheel feed is at the top. This process can be repeated several times
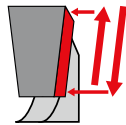
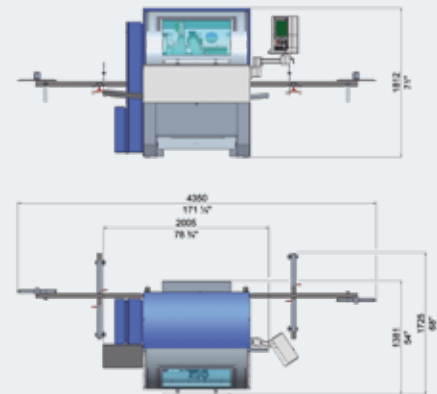Grinding-wheel feed is at the top and at the bottom what results in 2, 4 or 6 feeds

Grinding-wheel feed is at the top. At the bottom, the grinding-wheel is moved back. The grinding head goes quickly upwards and the feed is again activated. This process can be repeated several times.

Technical Data

GENERAL INFORMATION:

Tooth pitch	13 – 100 mm
Clearance angle (face)	0° – 7°
Clearance angle (back)	0° – 7°
Tooth face angle	0° – 35°
Grinding length	programmable
Working speed	approx. 10 Zähne / min

BAND SAW BLADES:

Blade width (Standard)	70 – 360 mm
Blade width (Option)	30 – 360 mm
Blade length (Standard)	from 5'300 mm
Blade length (Optional)	from 4'300 mm

GRINDING WHEELS:

Cup grinding wheel (Var 1)	Ø 75 – 100 mm
Cup grinding wheel (Var 2)	Ø 100 – 125 mm
Bore	Ø 20 mm
Peripheral speed	adjustable
Grinding motors (2)	1.5 kW

PROPERTIES:

Electrical connection	400V 3Ph N
Anschlusswert	2.1 kVA
Compr. air supply	6 bar
Weight	approx. 1'600 kg
Coolant tank	approx. 170 l