

BNP 110

Fully automatic profile sharpening machine for band saw blades controlled with 2 CNC axes



The BNP 110 combines the technology of the BNP 100 with the design of the BNP 200.

The ergonomic machine housing allows electrically controlled saw blade height adjustment.

Highlights

- ✓ Profile-grinding of standard and Stellite-tipped band saw blades by means of CNC axes "X" & "Y" (several complete cycles of the band saw blade)
- ✓ Use of linear roller guides for all CNC axes (stiffer engineering and maximized lifetime)
- ✓ "LINUX Debian 10" control unit with multicore processor
- ✓ Pneumatic saw blade clamping, with force relief during feed
- ✓ Tooth profiles retrievable via control unit (standard memory for 99'999 tooth profiles)
- ✓ Re-treated machine parts for longer service life and corrosion protection
- ✓ Drive by means of servo motors with state-of-the-art safety control system
- ✓ Large grinding wheel diameter of 350 mm

Application programmes



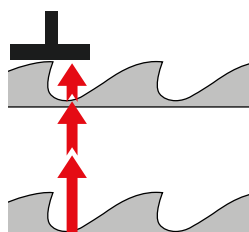
Grinding of standard tooth forms



Grinding of constant and / or variable tooth pitches and shapes

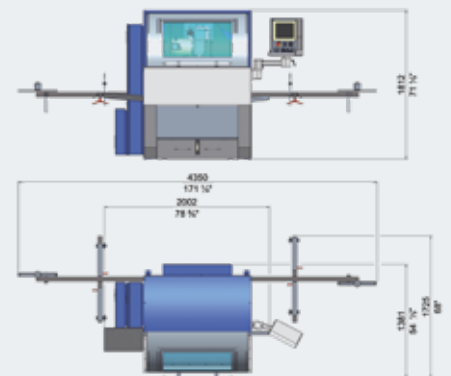


Grinding the winter tooth



Variable height measurement with Analogue sensor

Technical Data



GENERAL INFORMATION:

Tooth pitch	10 – 100 mm
Tooth height	up to 30 mm
Rake angle	0 – 35°
Tooth shapes	programmable

BAND SAWS:

Saw blade width (standard)	75 – 360 mm
Saw blade width (optional)	25 – 360 mm
Saw blade length (standard)	from 6'000 mm
Saw blade length (optional)	from 4'300 mm

GRINDING WHEEL:

Bakelite grinding wheel	Ø 350 mm
Grinding wheel CBN	Ø 300 / 350 mm
Bore	Ø 32 mm
Peripheral speed	adjustable

PROPERTIES:

Grinding wheel motor	2.2 kW
Electrical connection	400V 3Ph N
Connected load	4.2 kVA
Compr. air supply	6 bar
Weight	approx. 1'250 kg
Coolant tank	approx. 150 l