

BNP 200 G2

Fully automatic profile sharpening machine for band saw blades controlled with 4 CNC axes



The ISELI BNP 200 line combines technology that can be precision grinded and finish grinded against the cutting edge.

Optionally, the tool zero point can be set automatically by means of an acoustic sensor or the tooth profile can be scanned via the Tooth Tracing System.

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)
 - by means of CNC axes "W" & "Y" (grinding of the positioned and clamped saw tooth)
- ✓ **Top/Face-grinding of Stellite- and Carbide-tipped band saw blades**
 - by means of CNC axes "W" & "Y" (grinding of the positioned and clamped saw tooth)
- ✓ **Automatic set up of the saw**
 - Positioning the saw to the workpiece grinding position (automatic)
 - Positioning the saw to the workpiece change position (automatic)
 - Automatic recognition of the tooth group and measurement of the tooth pitch
- ✓ CNC controlled cutting angle Adjustment ("S" axis)
- ✓ Automatic probing of the grinding wheel at the saw tooth
- ✓ Automatic tooth shape tracing "Tooth Tracing System - TTS"

Application programmes



Grinding of standard tooth forms
Grinding of variable tooth forms



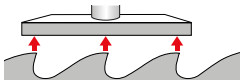
Alternating grinding on the
tooth face and back



Grinding the winter tooth



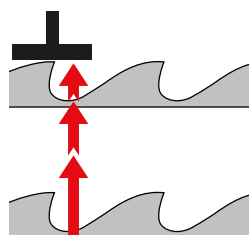
Automatic probing of the tool zero point
with acoustic sensor



Automatic setup of the saws

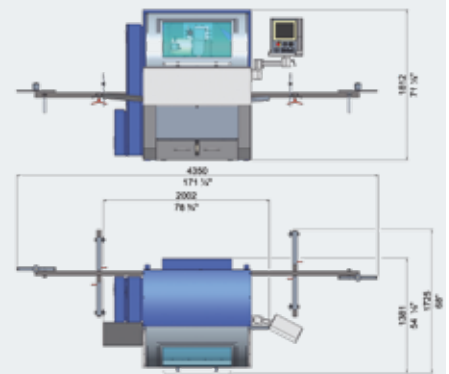


Automatic tooth shape tracing
"Tooth Tracing System"



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)	70 – 360 mm
Saw blade width (optional)	30 – 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:

Electrical connection	400V 3Ph N
Compr. air supply	6 bar
Connected load	3.6 kVA
Grinding wheel motor	2.2 kW
Weight	approx. 1'700 kg
Coolant tank	approx. 170 l