

BNP 300

Fully automatic 5-axis-control profile sharpening machine for band saw blades in wet grinding execution



The BNP 300 meets all requirements for machining stellite and carbide tipped band saws. In convincing quality, with a long service life.

Triplechip with tooth height difference and 45° chamfering can be ground in one pass.

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)
- ✓ **Chamfering and bevel grinding of the tooth back**
 - by switching in the CNC axis "U" (for triplechip with tooth height difference and 45° chamfering)
- ✓ **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

Application programmes



Grinding of standard tooth forms
Grinding of variable tooth forms



Alternating grinding on the tooth face and back



Grinding the winter tooth



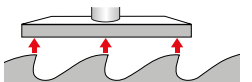
Automatic probing of the tool zero point with acoustic sensor



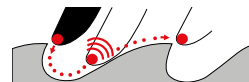
Flat tooth



Roof tooth

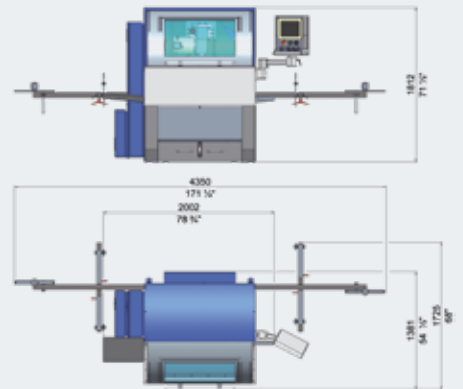


Automatic setup of the saws



Automatic tooth shape tracing
"Tooth Tracing System"

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)	30 – 360 mm
Saw blade length (standard)	from 6'000 mm
Saw blade length (optional)	from 4'300 mm
Blade thickness	0.6 – 0.3 mm

GRINDING WHEEL:

Grinding wheel	Ø 200 / 250 mm
Bore	Ø 32 mm
Grinding wheel motor	2.2 kW

PROPERTIES:

Electrical connection	400V 3Ph N
Connected load	3.9 kVA
Compr. air supply	6 bar
Coolant tank	approx. 170 l