

## CNBS81 ECO for Sharpening of the Frame Saw Blades

The CNBS81 ECO is the ideal machine for sharpening of CV, bimetal, carbide-tipped and stellite-tipped saw blades and band saw blades. Machine operates with CBN or with diamond grinding stones by using the water cooling. The blades width is in range of 8 - 80 mm.

With the introduction of our CNC Grinder, we can now offer our customers a significantly improved alternative to the original mechanical Grinder for the sharpening of their frame saw blades. Until now, the only option for grinding saw blades was with a mechanical system. Although this system has worked, it was subject to many variables and this could significantly affect the consistency of the sharpened blade.

With the new CNC Grinder, the grinding cycle is controlled via CNC servo motors; with the result that the saw tooth dynamics remain consistent. The grinder incorporates a coolant reservoir and spray system which helps to keep the saw blades cool during grinding.

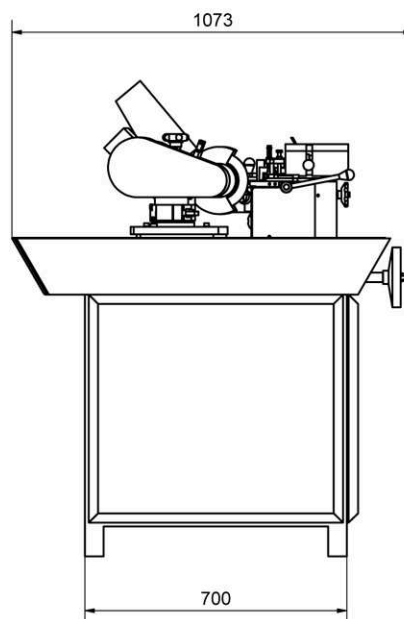
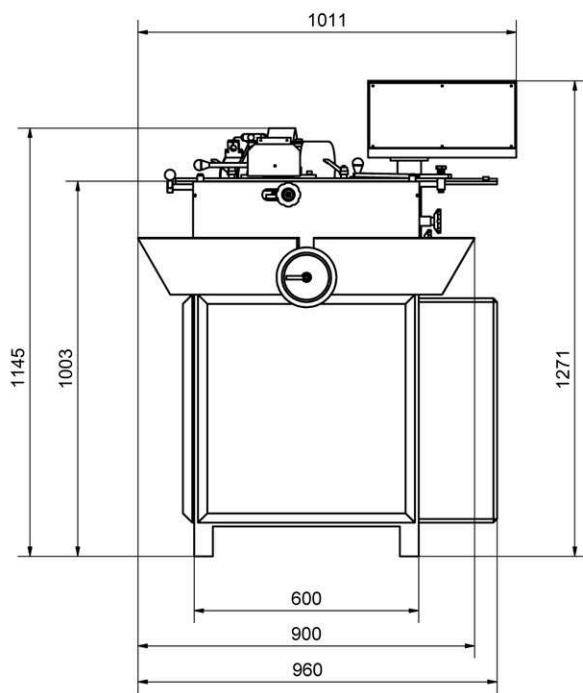
### Other advantages include:

- More saw blade re-grinds are achieved on the CNC grinder because of its accuracy and consistency.
- A better finish on the wood is achieved because each tooth is ground more accurately.
- The re-grinds will be consistent from one machine operator to another.
- Electronic Hand Wheel for even faster and easier adjusting and starting sharpening cycle.
- Increased productivity of sharpening due to new patented feeding system.
- Mechanical parts and motors perfectly protected against cooling liquid.
- Improved tolerance of the wood parts being cut.
- Easy setup and operation.



## Main Advantages of CNC Sharpening of Saw Blades

1. **One Tooth** is ground by **More Cycles**, depending on blunting of tooth edge, the proper transference is chosen for each cycle
2. **Constant Speed** of grinding tool head motion, the geometry of tooth is set by program
3. The grinding stone **grinds the Back of Tooth**, no peak is created
4. The grinding **Stone Angle is set** and the stone does not have to be shaped during the grinding operation
5. Grinding of **Band Saw Blades**



### Technical specification

Length of the saw blades	200 – 1000 mm
Thickness of the saw blades	0.5 – 3.0 mm
Tooth gap	3 – 75 mm
Tooth depth	max. 15 mm
Angles of the front	0° – 25°
Angles of the top side	0° – 20°
Speed of the operation	max. 50 teeth/min.
Rotations of the driving shaft of grinding wheel	3800 rpm
Diameter of the grinding wheel	150 mm
Diameter of the driving shaft of grinding wheel	32 mm
Breadth of the grinding wheel	3 – 6 mm

### Engine performance

Motor of the grinding wheel	0,5 kW
Motors of the driving device	0,8 kW
Motor of the pumping device	0,155 kW

### Machine dimensions

Width	1011 mm
Length	1073 mm
Height	1271 mm
Weight	350 kg