

SW BA 80N



Electro-mechanical controlled sharpening machine for CV- and bi-metal band saw blades with consistant tooth pitch



- + Deep in-feed grinding by use of CBN grinding wheel
- + Integrated water cooling system
- + Band saw blades from 10 – 80 mm in width

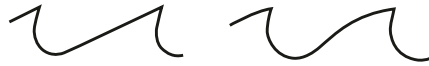
The SW BA 80N is an electro-mechanical machine that creates tooth shapes by following a cam. The machine benefits from the addition of a water cooling system and a CBN grinding wheel for deep in-feed grinding.

Operation

The cam-controlled horizontal reciprocating motion of the grinding head is in cooperation with the saw blade advance the preselected tooth shape. The band saw blade is fed through a feed pawl right on the ramp. In order to bridge damaged teeth a double feed pawl is available. The adjustment of the rake or face angle is made directly in relation to a scale by simply swinging the band saw blade holder. The feed speed is infinitely adjustable through a frequency converter.

Standard tooth shapes

The tooth profile desired (straight back or round back teeth) is simply selected by a lever mechanism.



Straight back tooth Round back tooth
or pointed tooth

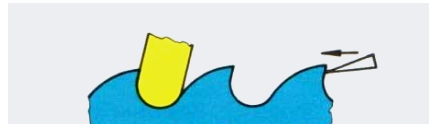
Special Features

- + Simple operation
- + Double feed pawl for missing / broken teeth
- + Dial gauge for adjusting blade thickness
- + Quick and easy face angle adjustment

The Grinding Process



1. The grinding wheel moves into the tooth and contacts lightly the tooth face.



2. As soon as the grinding wheel has reached the tooth gullet, the saw blade is pushed forward by means of the feed finger and the round part of the bottom is being ground.



3. The blade continues being fed forward whereas the wheel retracts to grind the tooth back.



4. After the tooth back has been completed, the feed finger slides back to engage the next tooth.

Technical data

Working range	
Tooth Pitch	3 – 30 mm
Tooth height	up to 12 mm (Straight back tooth) or 8 mm (Curved back tooth)
Band saw width	10–60 mm or 55–80 mm
Face angle	0–25 Degree
Grinding wheels	
CBN	Ø 200 x 32 mm
Grinding speed	24–50 teeth/min
Cooling	
Coolant type	Water emulsion
Electrical installation	
Machine input power	1.1 kVA
Weight	
Machine	approx. 230 kg
Dimensions (W x D x H)	
2300 x 920 x 2250 mm	

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