

solution K850-T



Sharpening, re-toothing and chamfering
of metal-cutting circular saw blades with CBN-abrasive grinding



- + Automatic grinding wheel insertion
- + Automatic chamfering of the saw blade
- + Attachment for cutting in chip breaker grooves
- + Separation of machine set-up and machine operation possible

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Complete machining in single set-up and superior grinding quality satisfy every sharpening professional.

State-of-the-art CNC-machine control facilitates the separation of machine set-up and machine operation. Within minutes, the machine programmer sets up all saws for sharpening. The machine operator only needs to load the saws and push the start button. The machine takes care of the rest.

Like the KSC series the K850-T utilizes direct drive grinding technology to provide maximum performance while eliminating vibrations.

The K850-T is also prepared to grind friction and solid carbide saws in addition to HSS saws and segmental saws.

The machine is also prepared for re-sharpening of thin kerf metal cutting saw blades with chip guiding notches (optional carbide-tipped and CERMET type TK saws – including grinding of the spoon face).

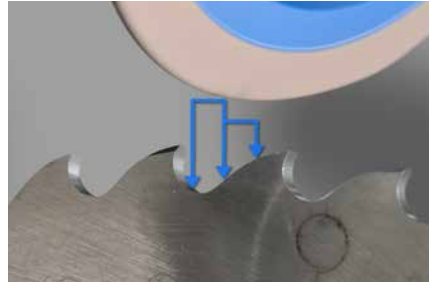
The machine can automatically grind the chamfers after re-sharpening or re-toothing of saws. An additional saw support device at the grinding point ensures completely symmetrical chamfering even on blades that are not perfectly straight.

The optional chip breaker grinding attachment can simply be mounted to the grinding head to cut in chip breaker grooves.

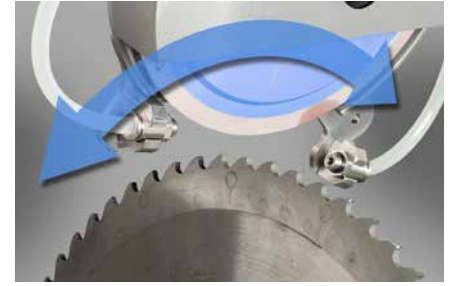
The following software upgrades are available:

- + Variable tooth-pitch
- + Special tooth forms
- + Program to grind multiple saw blades to the exact same blade diameter

Features and accessories



Auto positioning of the grinding wheel while detecting correct saw blade diameter and number of teeth **VIDEO 1**



Swivelling of grinding head for automatic chamfering



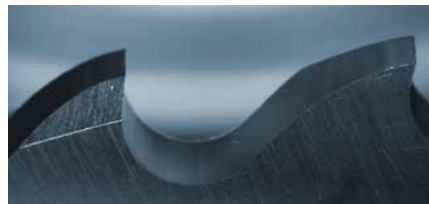
Attachment to grind in chip breaker grooves **VIDEO 2**



External HSS- and carbide filter with coolant chiller unit



Examples of tooth shapes



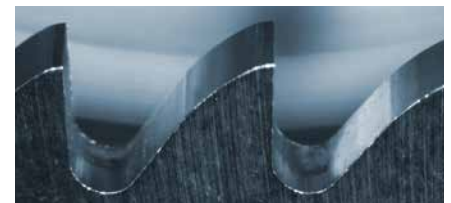
Curved back teeth with chamfers



Solid carbide teeth



Straight back teeth



Friction teeth



Carbide teeth of a thin kerf saw blade (TK-saw)



Curved back teeth with chip breaker grooves

The solution K 850-T is the ideal CNC controlled saw sharpening machine for fully automatic machining of metal-cutting circular saws – easily integrated in a multi-machine shop set-up.

Advantages of the solution K850-T

Fully automatic grinding

- + Including sharpening, cutting off existing teeth, re-toothing, chamfering
- + Cutting in chip breaker grooves with additional attachment
- + Additional tooth shapes and tooth geometries available
- + Vario-Tooth Shapes

Short non-productive and grinding times

- + Grinding programs can be entered in advance while machine is in operation.
- + Only one flange required for saw blades ranging from 130 – 850 (920) mm
- + Precision Grinding (ability to grind multiple saw blades to the exact same outside diameter)
- + Ideal machine for multi-machine shop set-up: load or enter saw blade data – set-up saw blade – push START!

High reliability and excellent grinding quality

- + Separation of machine set-up and machine operation possible

- + Automatic grinding wheel insertion with verification of the saw blade data
- + Rigid machine, low-vibration direct drive grinding spindle, CBN- abrasive grinding and effective cooling and coolant filtration
- + Hook and clearance angle freely adjustable
- + A saw support attachment ensures continued symmetrical chamfering, even with saw blades that are not perfectly plane.

- + Changing of grinding speed between diamond grinding wheels or CBN grinding wheels

Machine available for use with water-based emulsion or oil coolant

Low space requirement

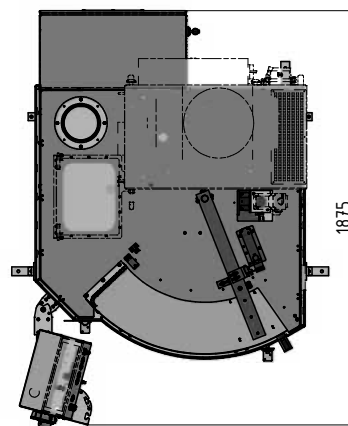
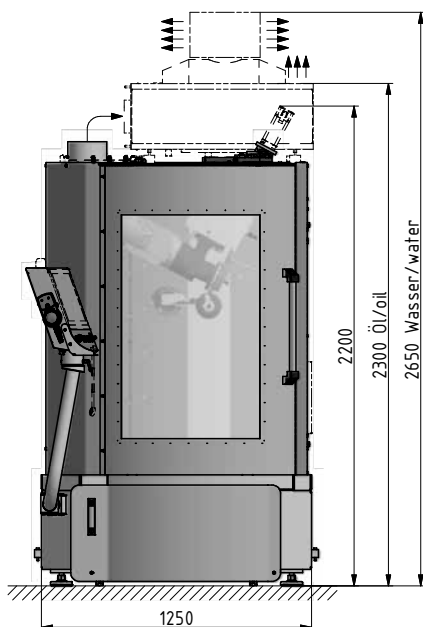
Advantageous price-performance ratio



5 controlled axes, including 2 simultaneous CNC controlled axes

Technical data

Working range	
Saw blade grinding	Ø (40) 130 – 850 (920) mm
Saw blade chamfering	Ø (105) 145 – 850 (920) mm
Cutting in chip breaker grooves	Ø (115) 180 – 710 (780) mm
Tooth pitch	1 – 40 mm
Number of teeth	2 – 998
Saw blade thickness	up to 8 mm
Grinding wheels	
CBN or DIA	Ø 200 mm (14F1)
Bore size	Ø 32 mm
Cooling	
Coolant pressure	approx. 6 bar
Coolant type	Water emulsion/Oil
Coolant quantity	300 l
Electrical installation	
Grinding motor power	3 kW
Machine input power	approx. 6,5 – 8,9 kVA
Weight	
net	approx. 1250 kg
Dimensions (W x D x H)	
Machine	1250 x 1875 x 2200 mm
Height with air extractor (oil)	approx. 2300 mm
Height with air extractor (water)	approx. 2650 mm
Required door opening size for transportation (H)	min. 2020 mm



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