Economical repair of TK-saw blades

Loroch sharp solutions!

Carbide or cermet-tipped thin kerf saw blades with a chip guiding notch

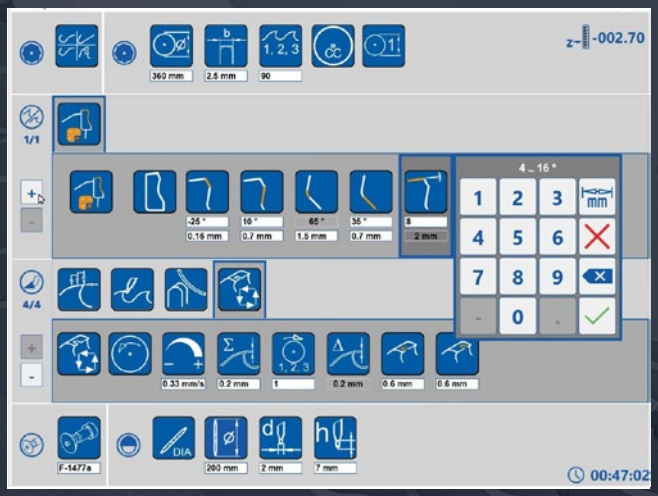
Complete machining in one clamping operation:

Contour, chamfer and chip breaker grinding

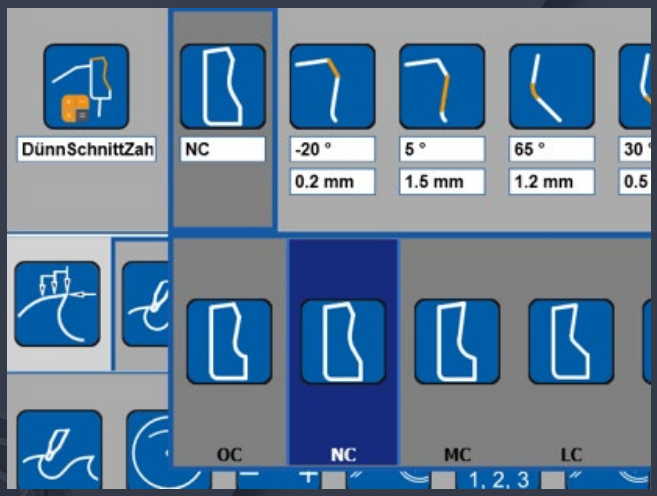
KSC 560-B

KSC 710-T

With the Loroch KSC machine concept, TK-saw blades can be resharpened economically. The advantages of touch control and contour move are noticeable in the shorter process time compared to other technologies.



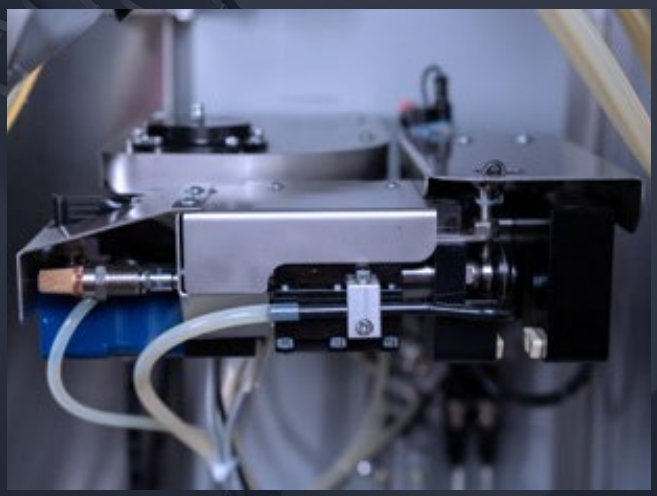
The operator enters all the data required for the process on the clear input screen.



The Loroch geometries for TK-saw blades cover almost all tooth shapes available on the market.

The starting point for processing is determined reliably and precisely with the aid of a structure-borne sound sensor.

A measuring probe is not necessary. If required, the pitch difference between the individual cutting edges can be determined.



The automatic chip breaker device ensures cost-effective complete machining in a single clamping operation, rounding off the automated process.

1. Determine wear mark

The thin-cutting saw was designed for mass cutting systems and is also designed for harsh operating conditions. Nevertheless, it is important to determine the wear mark of the saw before repairing it in order to achieve a maximum economical sharpening process.

With the Loroch TC 720 measuring device, the individual teeth of a TK-saw blade can be measured and examined. →

2. Select grinding wheel

Choosing the right grinding wheel ensures process reliability. The Loroch TurboGrind grinding wheel impresses with its dimensional stability. The radius is precisely determined with the Loroch TC 720 and entered in the User Interface.

← TurboGrind diamond grinding wheel 200 x 2.0 x 32 mm. Control of the grinding wheel radius with the Loroch TC 720 measuring device.

3. Post-treatment

The right choice of post-treatment is important for the effectiveness of the re-sharpened cutting edge. Different methods of cutting edge rounding in combination with a suitable wear protection coating can achieve economical service life times in the sawing process.

TK-saw blade sharpened, rounded and coated. →

It is also possible to process TK-saw blades with following Loroch machines:

solution K850-T

TWIN 860

Machine overview – Technical data

		solution K850-T		KSC 560-B		KSC 710-T		TWIN 860	
		850	920	Manual	Magazine	Manual	Magazine	Metal	Wood
Saw blade data	Recutting / sharpening Ø mm	(40)130 – 850	(40)130 – 920	130 – 560		(40)130 – 710	(75)130 – 540(560)	(60)130 – 860	(145)200 – 700
	Chamfering Ø mm	(105)145 – 850	(105)145 – 920	145 – 560		(105)145 – 710	(105)145 – 540(560)	(75)145 – 860	(145)200 – 700
	Chip breaker manual Ø mm	(115) 180 – 710		—		—		—	
	Chip breaker semi auto Ø mm	—		—		—		(115)130 – 860	
	Chip breaker auto motor. Ø mm	—		200 – 560		200 – 540 (560)		—	
	Thickness mm	max. 8		max. 8		max. 8		max. 8	max. 5
	Tooth pitch mm	1 – 55		1 – 55		1 – 55		1 – 55	6 – 60
	Number of teeth	2 – 998		2 – 998		2 – 998		2 – 998	2 – 998
	Tooth height mm	max. 17		max. 17		max. 17		max. 17	max. 10
Tooth shapes metal	Curved back tooth	✓		✓		✓		✓	—
	Straight back tooth	✓		✓		✓		✓	—
	Vario tooth	✓		✓		✓		✓	—
	SkipTooth	○		—		○		○	—
	TK	○		✓		○		○	—
	TK Material	HM / CER		HM / CER		HM / CER		HM / CER	—
	TK Ø mm	200 – 500		200 – 560		200 – 560		200 – 700	—
	Pocket seat	○		—		○		○	—
	Micro toothing	—		—		—		○	—
	Circular knifes	—		—		—		○	—

✓ Standard ○ Optional

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VIDEO

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