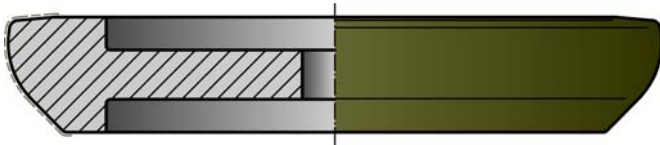


CBN GRINDING WHEELS for SAW BANDS

Basic characteristics:

Wheels are indicated for grinding of saw bands for cutting of solid natural timber. Wheels are produced in three basic diameters 127, 150 and 200 mm. Because of the fact that the shape of the grinding layer is the same with shape of tooth gap of saw band, the selection of the wheels is the same.



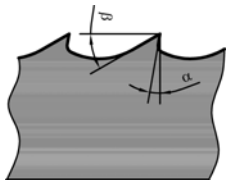
CBN grinding wheel for saw band

Curve of the tooth is constructed in the way to correspond with cutting angles (geometry of the tooth) and to create enough space for removing of the wood splinter. It is indicated by number e.g. 03 0381, which is marked on the wheel together with the mark of the geometry of tooth. Further there is serial number, grain size and company logo on the wheel.

The wheels divide by:

- Diameter:
 - \varnothing 127 mm
 - \varnothing 150 mm
 - \varnothing 200 mm
- Pitch:
 - 22 mm (standard)
 - 25 mm
- Geometry of tooth depends on the sort of wood for standard pitch 22 mm:

| Mark | Sort of wood | For ordinary use | α [°] | β [°] |
|------------|----------------|------------------|--------------|-------------|
| 8,5 / 24,5 | VERY HARD | ○ | 8,5 | 24,5 |
| 9 / 29 | HARD or FROZEN | ● | 9 | 29 |
| 10 / 30 | SOFT | ● | 10 | 30 |
| 13 / 29 | SOFT | ○ | 13 | 29 |
| 14 / 22 | SOFT | ○ | 14 | 22 |



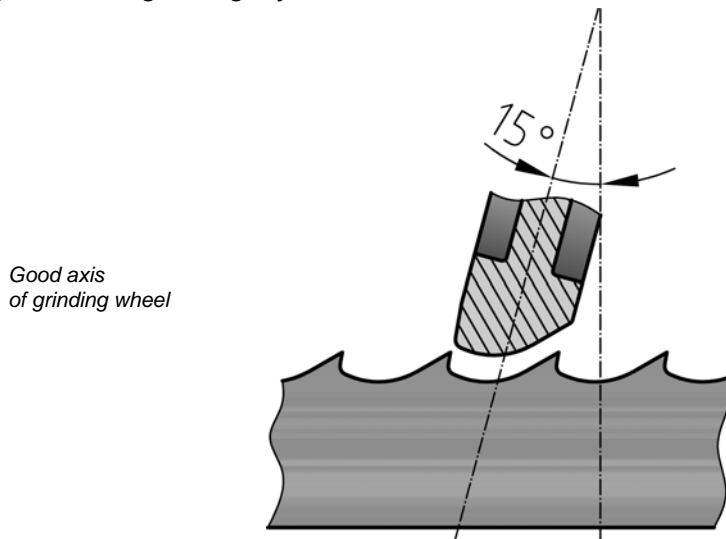
Basic angles geometry of the tooth

- Grain size:

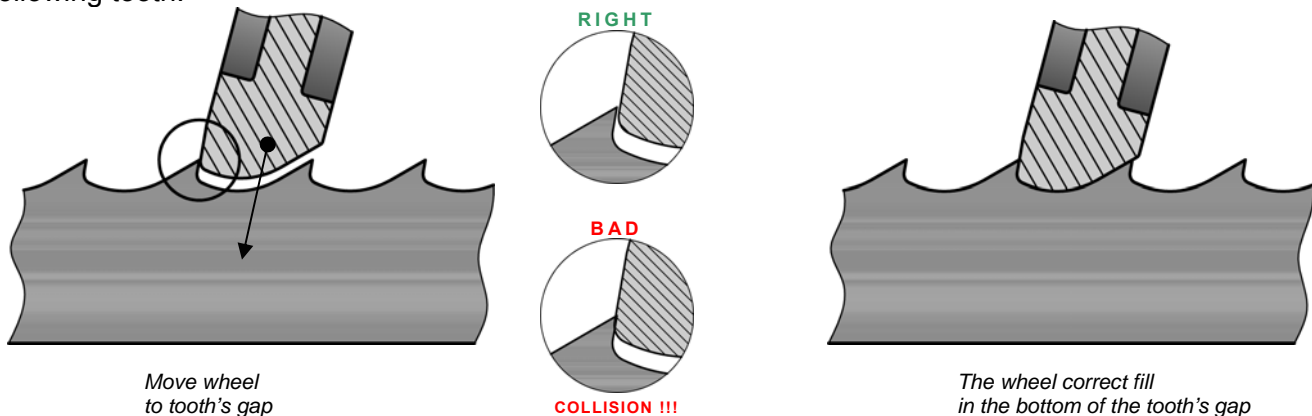
On the basis of practice test, the grain size is set to B126. Sometime it can be used coarse grains (B151) or fine grains (B107) in the specific case.

Grinding conditions:

Axis of the grinding wheel has to lean of 15 degrees towards the axis of saw band. Some single-purpose machines have it set by the producer. Work place should be sufficiently cooled. Dry grinding dramatically reduces working life of the grinding layer.



It is very important to pay attention to right setting of the wheel in catch. The wheel has to fill in the bottom of the tooth's gap without touching cutting face. Like this it grinds equally cutting face and ridge of the following tooth.



Renovation of the grinding layer:

There in good setting of the wheel in catch once you see that cutting facets are equally glazed in whole profile. Such wheel can be sent to the producer for repairing – to remove old layer and fix new one.

In case that wheel is unevenly used, it usually causes the damage of its shape. It is not economics to repair such a tool.

CONTACT



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