



CHP 840 and CHP 1300

/////// CIRCULAR SAW ///

Universal sharpening machine for carbide-tipped circular saw blades up to diameter 840 or 1300 mm



THE FUTURE IS NOW: CHP 840 and CHP 1300

THE VERSATILITY OF A NEW GENERATION

FOUR CNC-CONTROLLED AXES FOR ACCURATE GRINDING OF NEARLY ALL TOOTH GEOMETRIES IN ONE CYCLE. INGENUOUSLY SIMPLE OPERATION WITH INNOVATIVE MULTIFUNCTION HANDWHEEL AND A GROUND-BREAKING MACHINE CONCEPT WITH PROGRAMS USED IN THE WOOD, ALUMINIUM, PLASTIC AND **A WIDE RANGE OF METAL APPLICATIONS.**

THE RESULT: THE PERFECT COMBINATION OF PRECISION AND PRODUCTIVITY WITH MAXIMUM FLEXIBILITY.

FOR THE UNIVERSAL MACHINING OF CARBIDE-TIPPED CIRCULAR SAW BLADES WITH A DIAMETER OF 80 MM TO 840 OR 1300 MM

CHP 840 and CHP 1300 ONE FOR ALL. ALL IN ONE.



Machine available for two different diameter ranges: 80–840 mm or 80–1300 mm

- 1 COMPACT DESIGN**
Space-saving design and optimal accessibility for operators
- 4 FULL ENCLOSURE AS STANDARD**
For effective safety at work, noise and emission protection, as well as a characteristic appearance

- 2 INNOVATIVE CONTROL PANEL**
With 10-inch LCD colour display and multifunction handwheel for fast and safe operation
- 5 SOLID DESIGN**
Robust machine construction for vibration-free operation and high-quality sharpening result

- 3 LARGE VIEWING WINDOW**
Internal, two-part operational door for a perfect view of the grinding process



/// THE MACHINE CONCEPT

The CHP series is ideally equipped for sharpening carbide-tipped circular saw blades. Offering versatility that leaves nothing to be desired, yet with numerous options.

/// Four CNC-controlled axes for the complete machining of all commonly used tooth geometries in just one cycle – even for saws with axial angle and group toothing

/// Oscillation grinding as standard – for high material removal rates in just one cycle, e.g. when machining teeth for repair

/// Motor-driven hook and clearance angle adjustment for rapid switchover from face to top grinding

/// Optimum movement coordination for short grinding times and reduced non-productive times

/// Consistently hydraulic-free – extremely low-maintenance

/// Automatic central lubrication included in the basic equipment for reduced maintenance effort

/// APPLICATION

Saws for the saw mill industry, solid wood processing and furniture manufacture

The name VOLLMER guarantees process reliability and stability. Thanks to the diagonally integrated feed pawl with pneumatic lift, even chipper segments present no problem – even if these are screwed with or without a reinforcing ring onto the mounting devices manufactured specially for the purpose, often also with filler pieces in order to fill up the gaps in the body.

/// Wide-opening blade clamping mechanism for saws with collar or reinforcing ring

/// Optional second feed pawl for machining tooth pitches up to 180 mm

/// Optional hollow face grinding device for machining hollow face saws

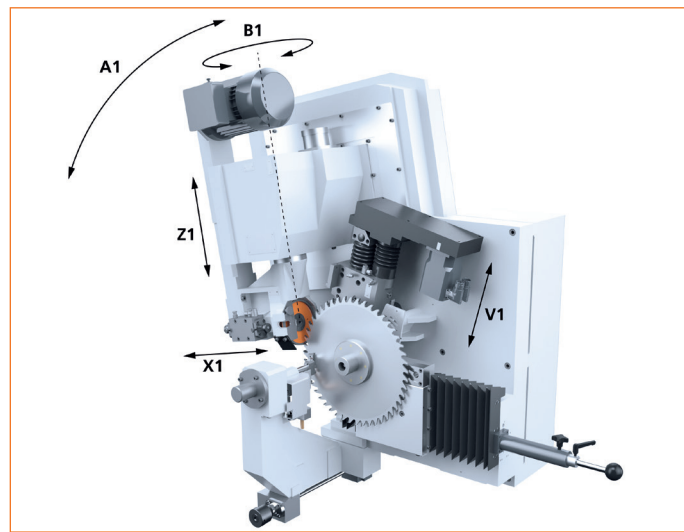
Saws for metal machining

Particular requirements apply in metal machining, which is also true for sharpening. The CHP 840 and CHP 1300 are ideally designed for efficiently grinding even complex tooth geometries and group toothings.

/// More powerful grinding motor with variable grinding speed, for a high level of grinding efficiency and the possibility of optimising process and machining parameters

/// Adjustable grinding barrel for chip breaker machining for more flexibility

/// Software for negative tooth face geometries and chip breaker machining as standard



/// MAXIMUM FLEXIBILITY thanks to four CNC-controlled axes (B1, Z1, X1, V1)



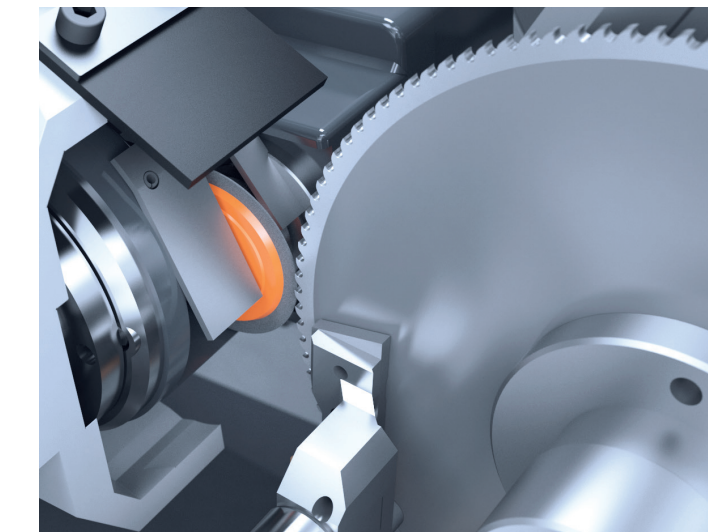
/// TOOTH FACE MACHINING



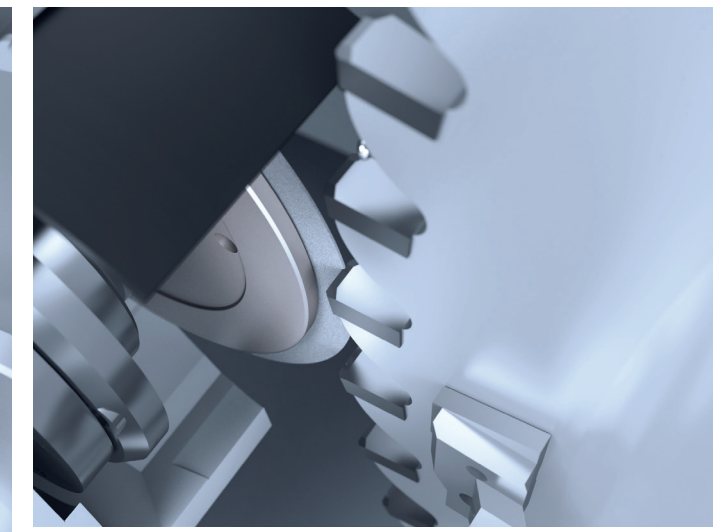
/// TOOTH TOP MACHINING on chipper segment from the saw mill industry



/// HOLLOW FACE MACHINING for excellent results in furniture manufacture



/// CHIP BREAKER MACHINING ON HSS SAWS with 50 mm grinding wheel



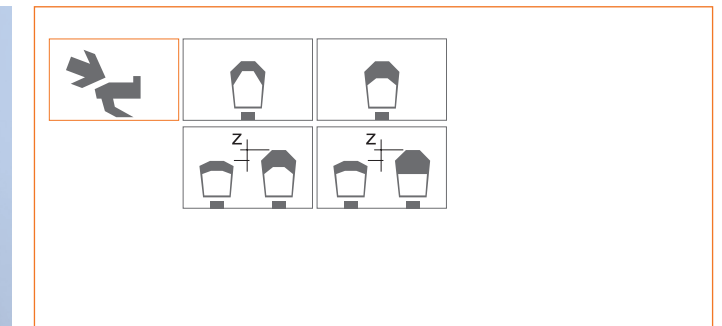
/// CHIP BREAKER MACHINING with 125 mm grinding wheel



/// TOOTH TOP MACHINING



/// NEGATIVE HOOK ANGLE MACHINING



/// NEGATIVE HOOK ANGLE // TOOTH SHAPE EXAMPLES

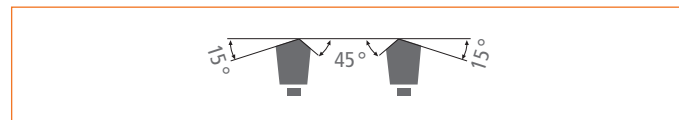


/// OPTIONAL CHIP GUIDING NOTCH Machining of saws with chip guiding notch



/// APPLICATION

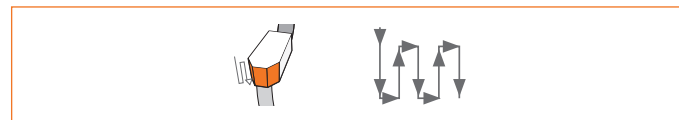
Its high level of variability and functionality makes the CHP series the first choice in each case for the workshop-oriented sharpening of circular saw blades in wood, aluminium, plastic and metal processing, and it can therefore be universally used in sawmills, sharpening services and the production of small-batch runs.



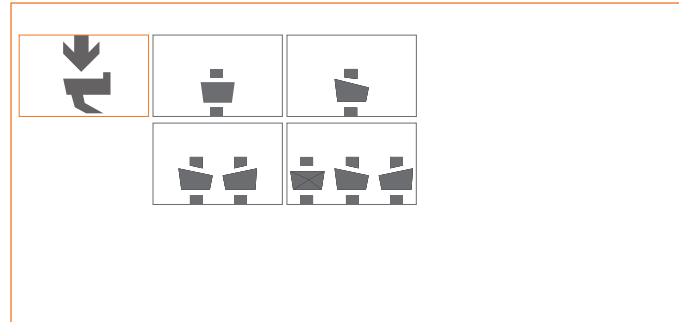
/// BEVEL GRINDING ANGLE can be individually chosen



/// GRINDING SPEED can be steplessly adjusted according to different surfaces



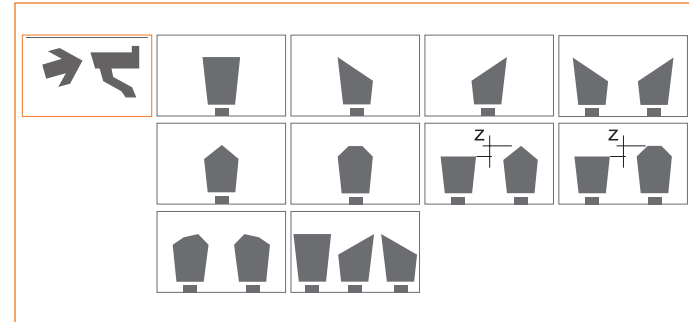
/// OSCILLATION GRINDING PROCESS achieves outstanding surface finish quality even when high rates of metal are removed



/// TOOTH FACE // TOOTH SHAPE EXAMPLES



/// GROUP TOOTHING can be machined



/// TOOTH TOP // TOOTH SHAPE EXAMPLES



/// MULTIPLE SURFACE PROGRAM optional

/// THE OPERATING CONCEPT

The modern operation concept with the multifunction handwheel makes work significantly easier and faster. The axes are selected and controlled by only one module, which is very helpful in avoiding the possibility of incorrect operation. The handwheel is also used as a potentiometer in order to be able to carry out speed adjustments in automatic mode.

/// Optimised machining times and surface finish quality through variable input of the grinding speeds for various different surfaces

/// No tooth pitch input required thanks to the feed pawl sensor system

/// Automatic adjustment of the hook angle and clearance angle through digital detection avoids adjustment errors

VOLLMER OPERATION PHILOSOPHY – ensures maximum convenience of use



/// 1 CONCISE VOLLMER SYMBOLS facilitate intuitive programming

/// 2 STORAGE of up to 4000 programs possible

/// 3 WINDOWS-BASED INTERFACE with 10-inch LCD colour display and graphical user guidance

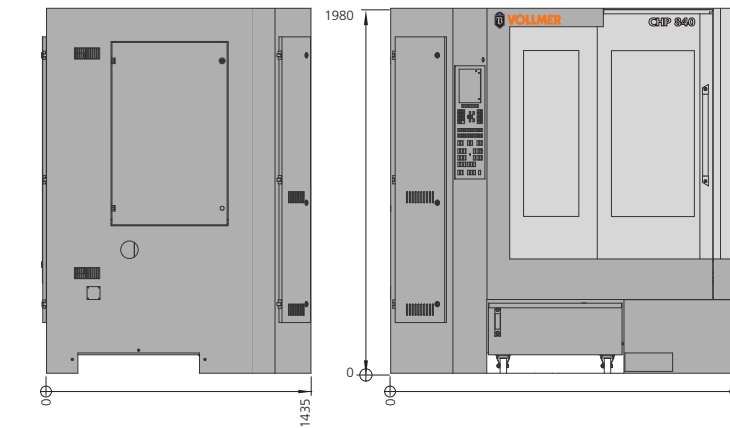
/// 4 EASY SET-UP thanks to innovative multifunctional handwheel

/// SPECIFICATIONS

Circular saws	CHP 840	CHP 1300	
Outside diameter	80–840	80–1300	mm
Bore diameter	from 10	from 10	mm
Blade thickness	≤ 8	≤ 8	mm
Tooth pitch	≤ 100 (≤ 180*)	≤ 100 (≤ 180*)	mm
Cutting width	to 12	to 12	mm
Workpiece weight	max. 30	max. 80	kg
Hook angle	-30 to +40	-30 to +40	°
Hollow face hook angle	-10 to +30*	-10 to +30*	°
Clearance angle	+5 to 45	+5 to 45	°
Bevel grinding			
on the tooth top	≤ 45	≤ 45	°
on the positive tooth face	≤ 15	≤ 15	°
on the negative tooth face	≤ 15	≤ 15	°

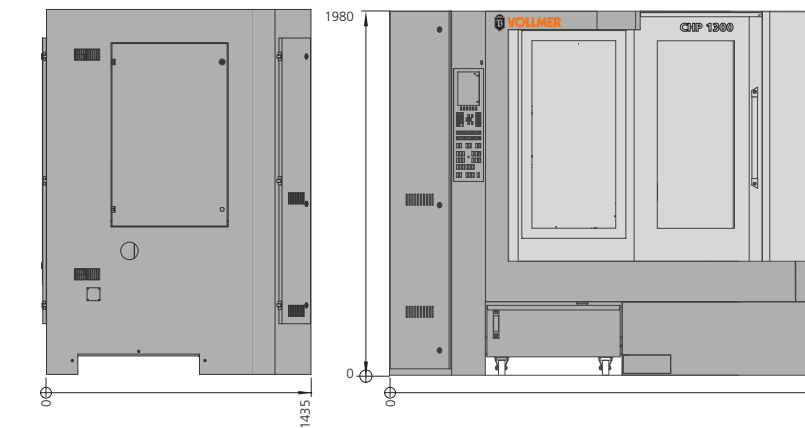
Grinding paths	CHP 840	CHP 1300	
Hook angle	≤ 20	≤ 20	mm
Clearance angle	≤ 24	≤ 24	mm
Hollow face	≤ 15	≤ 15	mm
Grinding shaft drive output	1,1	1,1	kW
Grinding wheels			
Outside diameter	125	125	mm
Bore diameter	32	32	mm
Peripheral speed	variable	variable	
Coolant tank capacity	approx. 125	approx. 125	l
Connected load (without auxiliary equipment)	approx. 2.2	approx. 2.2	kVA
Weight	approx. 1660	approx. 1850	kg

*optional



/// MACHINE DIMENSIONS

/// MACHINE FOR TWO DIAMETER RANGES: 80–840 mm or 80–1300 mm available



/// SERVICE THAT IS MADE TO MEASURE

With a comprehensive range of helpful and efficient services, VOLLMER is there to provide you with support. From competent advice and the best financing for you, through to an advantageous service contract that allows you to decide now which service costs you will have to pay in the future.

In short: We do everything so that you can concentrate on what's important: Your success.

/// Extensive advice and project planning

/// Financing and insurance

/// Training and start-up

/// Maintenance and service

/// Original spare parts

/// Upgrade and software

/// Purchase and sale of used machines



CHP 840 AND CHP 1300 – THE MAIN ADVANTAGES AT A GLANCE:

/// MORE PRODUCTIVITY

Optimised grinding times, maximum machining precision, exemplary operational convenience – for workshop-oriented working.

Your bonus in terms efficiency and precision.

/// INCREASED COST EFFICIENCY

A lot of performance at very reasonable conditions.

Manageable investment – high profitability

/// INCREASED FLEXIBILITY

Four CNC axes. Machine all tooth geometries in one cycle – even with metal applications.

That gives you even more opportunities.