



QF 270

Unit for machining the tooth sides of PCD-tipped circular saw blades by rotary electro-erosion



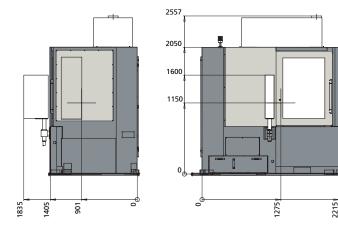
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Technical data at a glance:

 Circular saw blades 	
Outer diameter	from 100 to 840 mm
with robot ND2	100 to 630 mm
with robot ND3	200 to 840 mm
Bore diameter	from 10 mm
with robot	up to 180 mm
Blade thickness	up to 14 mm
with robot	up to 5 mm
Cutting width of saw	up to 16 mm
Tooth pitch	from 6 to 120 mm
Erosion path length	up to 12 mm
Hook angle	from -15° to +25°
Tangential clearance angle	up to +6°
Radial clearance angle	from -10° to +6°

- Rotary electrode
 Outer diameter
 Outer diameter (worn)
 Bore diameter
 Height
 max. 127 mm
 min. 67 mm
 32 mm
 Ho mm
- Rotary electrode drive
 Rotational speed during erosion
 Rotational speed during dressing
 Dielectric pump delivery rate
 Dielectric tank capacity
 Connected load
 Dimensions
 2295 mm x 1405 mm x 2050 mm
 Weight
 80 to 700 rpm
 300 to 1600 rpm
 60 l/min
 approx. 140 l
 4.0 KW/5.0 kVA
 Dimensions
 3295 mm x 1405 mm x 2050 mm
 Weight
 approx. 3.300 kg

Dimensions



VOLLMER technology

This rotary erosion machine can be used for machining

- circular saw blades,
- cutting tools and
- special-purpose tools.
- The machine features the
- VOLLMER PMC system with multiprocessor control
- CNC-controlled axes

1x for hook angle adjustment (A-axis)

1x for rotary electrode infeed (X1-axis)

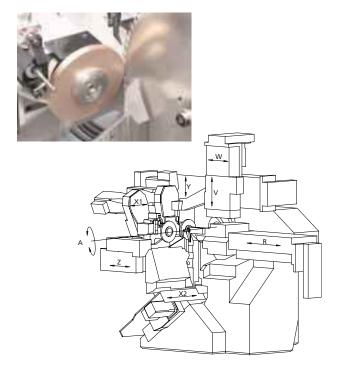
1x for rotary electrode infeed (X2-axis)

1x for erosion path (Z-axis)

2x for tooth feed (V and W-axes)

1x for tangential angle adjustment (Y-axis)

1x for saw blade positioning slide (R-axis)



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