



Product information

QF 270

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

QF 270

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	max. 127 mm
Outer diameter (worn)	min. 67 mm
Bore diameter	32 mm
Height	10 mm
• Rotary electrode drive	
Rotational speed during erosion	80 to 700 rpm
Rotational speed during dressing	300 to 1600 rpm
Dielectric pump delivery rate	60 l/min
Dielectric tank capacity	approx. 140 l
Connected load	4.0 KW/5.0 kVA
Dimensions	2295 mm x 1405 mm x 2050 mm
Weight	approx. 3.300 kg

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)



Dimensions

