

CB 400
CBF 400

Sharpening machines for carbide- tipped band saw blades.



Production line for sharpening carbide-tipped band saw blades. Highest precision all-in-one machining.

The use of carbide-tipped band saw blades is growing rapidly in the metal cutting industry. This calls for extremely accurate tooth geometry. As a market leader for carbide-tipped saw blade sharpening machines, Vollmer has now developed a new range of machines for the precision sharpening of carbide-tipped band saw blades with widths up to 150 mm consisting of the following machines:

- CB 400 CNC-controlled sharpening machine for tool top grinding and face grinding
- CBF 400 CNC-controlled sharpening machine for double-sided tooth side grinding

These machines are usually linked together in a production line with the stock being fed from a coil.

Outstanding product advantages:

- Ultra-stable machine construction – a prerequisite for high precision
- All functions CNC-controlled
- Vollmer PMC multiprocessor control
- Higher flexibility thanks to integrated measuring probe
- simple operator prompts on LCD colour display with graphic support
- CB 400 with automatic hollow face machining or chip breaker machining as option
- Bevel grinding as option
- Excellent sharpening results using oil as coolant

Tool face grinding



Tooth side grinding (CBF 400)



Hollow face grinding (Option)



Chip breaker grinding (Option)



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Technical data at a glance

Band saw blades	
Blade width	13 to 150 mm
Blade thickness	up to 2.0 mm
Tooth pitch	4.3 to 200 mm
Hook angle	-25° to 25°
Hook angle for side grinding	-10° to 25°
Clearance angle	up to 25°
Bevel angle at tooth flank	up to 60°
Bevel angle at tooth face (option)	up to 30°
Tangential clearance angle	up to 6°
Radial clearance angle	-10° to 12°

Grinding speed	up to 20 mm/s
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Grinding wheels

Tool top

Outer diameter	150 mm
Bore diameter	32 mm
Peripheral speed	20 to 41 m/s

Tool face

Outer diameter	200 mm
Bore diameter	32 mm
Peripheral speed	20 to 41 m/s

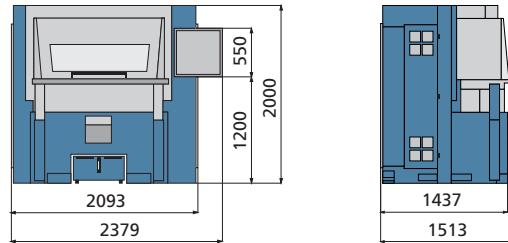
Tooth flank

Outer diameter	70 to 100 mm
Bore diameter	32 mm
Peripheral speed	20 to 40 m/s

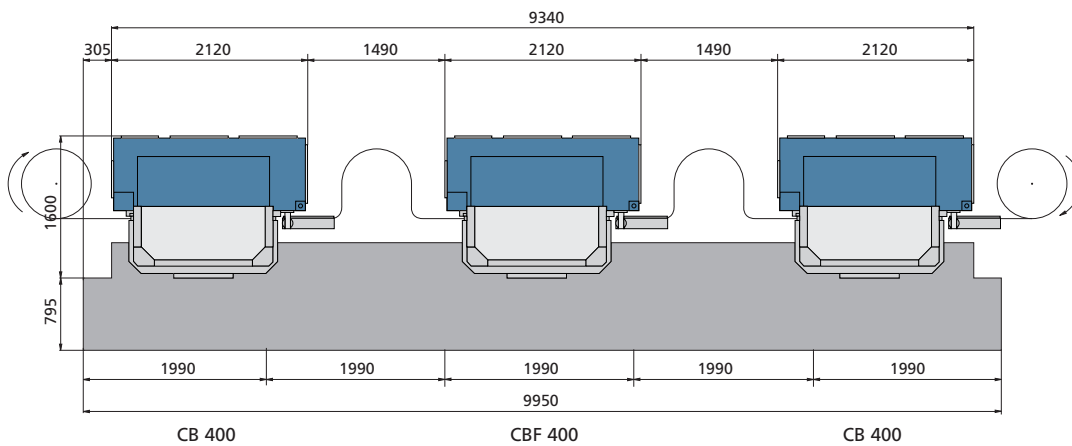
Connected load	approx. 4.3 kVA/3.5 kW
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Weight	approx. 2800 kg
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Dimensions



Example of machine configuration



We reserve the right to make design modifications in the interests of technical advancement. Patents pending.



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