

# GNP 100

Fully automatic profile sharpening machine for gang saw blades controlled with 2 CNC axes



## Highlights

- ✓ Profile-grinding of standard and Stellite-tipped band saw blades by means of CNC axes "W" & "Y" (grinding of the positioned and clamped saw tooth)
- ✓ Pneumatic saw blade clamping all over the whole saw blade length
- ✓ Precision spindle height adjustment for saw width
- ✓ Full-space cover with intensive water cooling
- ✓ "LINUX Debian 10" control unit with multicore processor
- ✓ Drive by means of servo motors
- ✓ Use of linear roller guides for all CNC axes (stiffer engineering and maximized lifetime)
- ✓ Extensive grinding programmes
- ✓ Automatic probing of the grinding wheel at the saw tooth
- ✓ Tooth profiles retrievable via control unit (standard memory for 99'999 tooth profiles)

## Application programmes



Grinding of standard tooth forms  
Grinding of variable tooth forms



Alternating grinding on the tooth face and back



Grinding the winter tooth



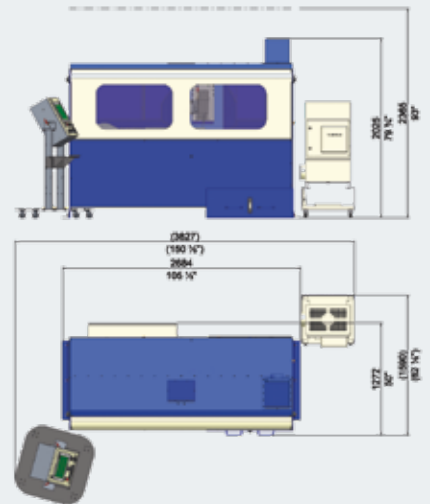
Automatic probing of the tool zero point with acoustic sensor

The space-saving GNP 100 sets new standards in the grinding of gang saw blades.

By means of the acoustic sensor and the W-axis, the zero points can be measured automatically.

The saw neck can be programmed and can be machined automatically.

## Technical Data



### GENERAL INFORMATION:

Tooth pitch	5 – 60 mm
Tooth height	up to 30 mm
Rake angle	0 – 25°
Tooth shape	programmable

### GANG SAWS::

Blade width	80 – 180 mm
Blade length (Tooth length)	up to 1'500 mm

### GRINDING WHEEL:

Bakelite grinding wheel	Ø 350 mm
Bore	Ø 32 mm
Peripheral speed	adjustable
Grinding wheel motor	2.2 kW

### PROPERTIES:

Electrical connection	400V 3Ph N
Connected load	2.4 kVA
Compr. air supply	6 bar
Coolant tank	approx. 170 l