



KSC 710 Basic

CNC-controlled sharpening machine for CBN-abrasive grinding

- ✎ Fully automatic sharpening, re-toothing and chamfering of metal circular saw blades
 - ✎ Automatic operation possible
 - ✎ Magazine with loading system can be connected at any time later on
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KSC 710 Basic

High-Tech-Solution for re-sharpening, re-toothing and chamfering of HSS metal cutting circular saw blades.

The KSC 710 – BASIC is the ideal machine for the full automatic complete processing of metal circular saw blades. Besides the high degree of automation the machine inspires through the outstanding grinding quality as well as low grinding and secondary times. For the first time this new machine is equipped with a powerful direct drive to the grinding wheel in order to prevent power loss and unwanted vibrations.

Besides HSS- and segmental circular saw blades, solid carbide blades can be ground also.

The saw blade data are entered into the CNC-control. The computer calculates tooth pitch, tooth height and for tooth shape C the tooth height difference according to DIN immediately. At the same time it is checked whether the grinding wheel thickness can be used or if the grinding wheel has to be changed.

After the input of face angle, back clearance angle and the chosen infeed the control determines the working speed as well as the necessary number of revolutions.

After pushing the start button the programmed saw blade diameter and the number of teeth are checked. If the entries are correct the machine automatically searches for the proper starting point of the grinding wheel and then starts grinding. If requested automatic chamfering follows after grinding or re-cutting.

An additional hydraulic saw blade clamping at the grinding point guarantees absolute symmetrical chamfering even with a possible facing difference of the saw blade.

For the first time the “System thought” has been consequently realized

Not only a new machine has been developed, but in co-operation with the respective producers also new grinding wheels and coolant which are coordinated in an optimized way.

Standard accessories integrated in basic machine:

- ✎ Automatic saw blade diameter adjustment
- ✎ Automatic clamping device for a hydraulic clamping of the saw blade by means of pedal switch
- ✎ Automatic grinding wheel insertion
- ✎ Additional hydraulic clamping of the saw blade at the grinding point
- ✎ Fully automatic chamfering
- ✎ Direct drive to the grinding spindle
- ✎ Swivel input station with big LCD monitor and windows operating system attached to the machine
- ✎ Effective coolant system with coolant pump of 10 bar and integrated 400 liter coolant tank with rough filtering system



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Optional Accessories:

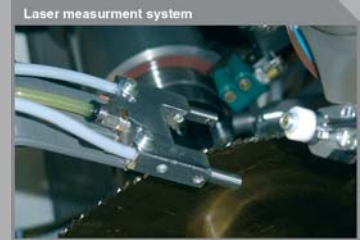
- ✎ Integrated clamping flange handling
- ✎ Integrated modem for remote-diagnosis and maintenance as well as online-support and saving of the customers data on our server and automatic measurement
- ✎ Laser based automatic measurement system to determine the saw blade diameter, the number of the teeth and thickness of the saw blades
- ✎ CAD-program for the construction of special tooth shapes
- ✎ Vario-pitch-grinding
- ✎ Control gear for grinding several saw blades to the same outside diameter

Advantages at a glance

- ✎ Absolute pitch accuracy
- ✎ Optimum surface quality due to CBN-abrasive grinding, direct drive of the grinding spindle and effective cooling of the grinding point
- ✎ Machine available for water emulsion or oil
- ✎ By the use of the automatic path offset, different pitches can be machined using the same grinding wheel thickness
- ✎ Additional hydraulic clamping of the saw blades from 130 – 760 mm with only one clamping flange
- ✎ Clear menus with windows surface
- ✎ Full automatic re-sharpening, re-toothing and chamfering

Technical Data

Working range	
Saw blade diameter	Ø 40 – 760 mm
autom. chamfering	Ø 160 – 760 mm (optionally from 100 mm possible)
Tooth pitch	1 – 55 mm
Number of teeth	2 – 998
Sawblade thickness	up to 8 mm
Grinding wheel	
CBN-grinding wheel	Ø 200 mm
Centre hole	Ø 32 mm
Cooling	
Coolant pressure	10 bar
Coolant type	Water emulsion or oil
Coolant quantity	400 l
Electrical installation	
Power input Grinding motor	3 kW
Power input Machine	appr. 7,5 kW
Weight	
appr. 2000 kg, netto	
Dimensions (L x W x H)	
without electro static air extractor	2565 x 1616 x 2200 mm
with electro static air extractor	2565 x 1616 x 2750 mm



Contact

Loroch GmbH
Josef-Loroch-Str. 1
69509 Mörlenbach, Germany

phone: +49 (0)6209 7159-50
+49 (0)700 56762433
+49 (0)700 lorochde

fax: +49 (0)6209 7159-38
e-mail: info@loroch.com
web: www.loroch.com