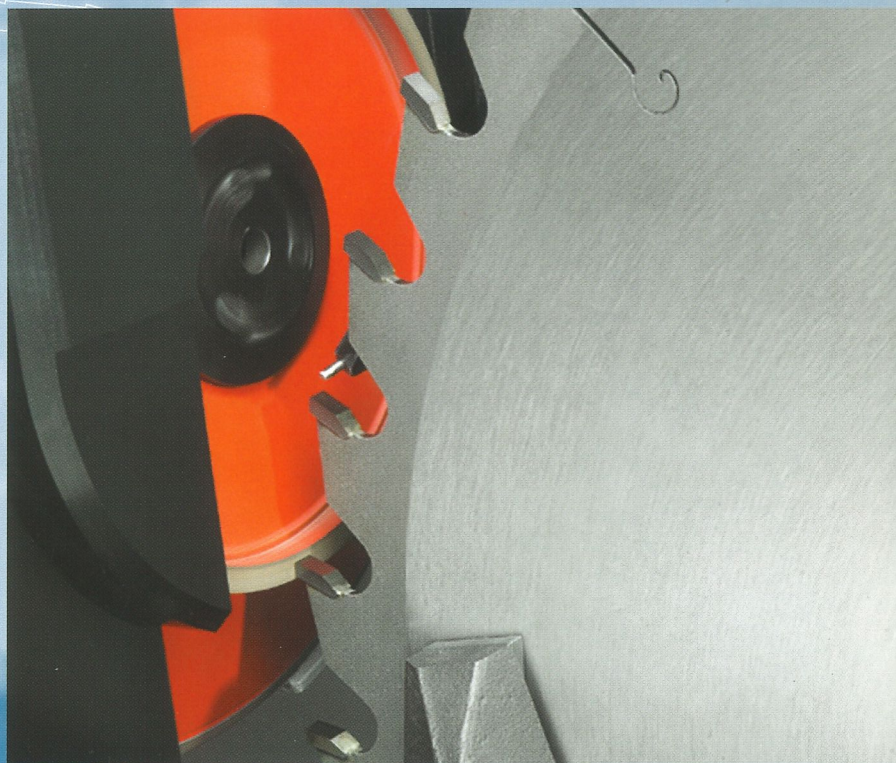
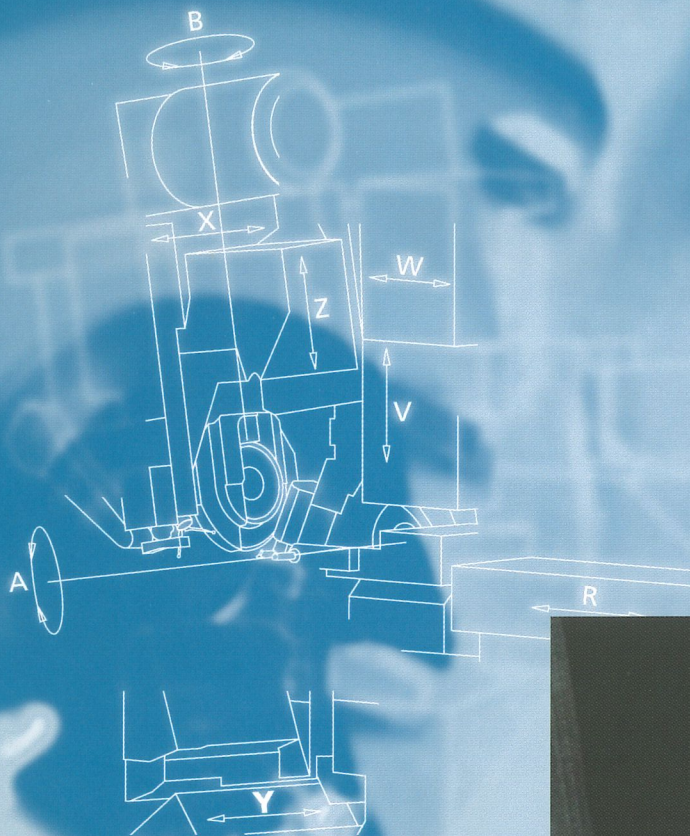


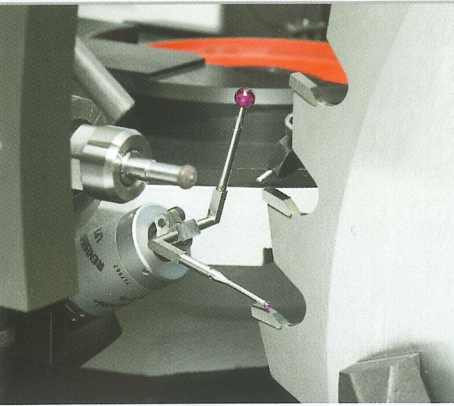


## CHD 270

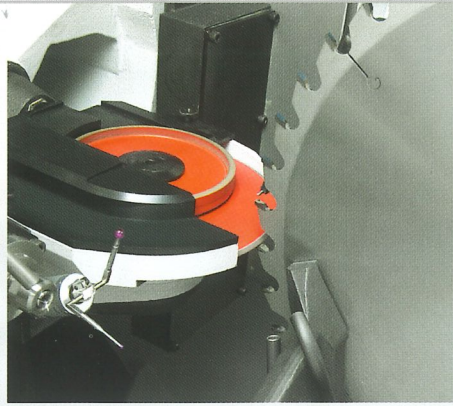
Sharpening with improved speed, flexibility and precision.



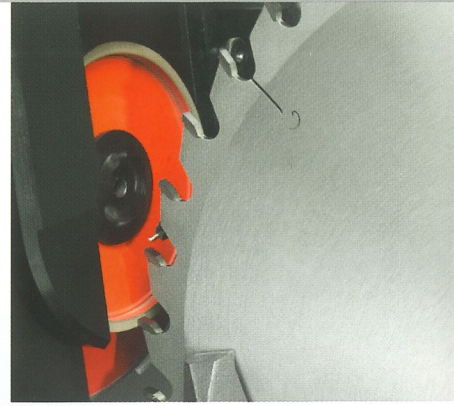
Measurement of complete tooth geometry



Sharpening of tooth face



Sharpening of tooth top



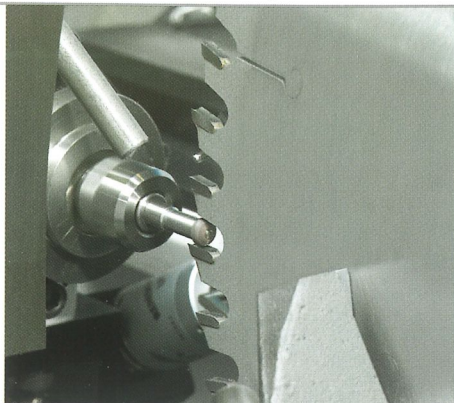
**Sharpening with improved speed, flexibility and precision with the new CHD 270 all-in-one face and top grinding machine.**

## CHD 270





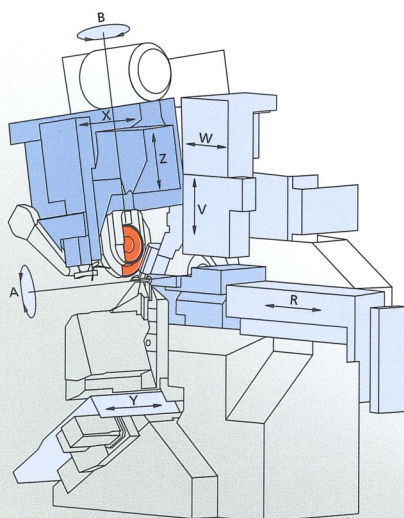
Sharpening of hollow face (option)



Sharpening of chip breaker (option)



Further improvements to this superior machine for high-precision sharpening of carbide-tipped circular saw blades include full CNC-control to both feed and hook/clearance angle adjustment along with an automatic measuring device. The CHD 270 can be used as a stand-alone machine with all the advantages of all-in-one machining, or combined with a robotic loading system as a fully automatic service centre to give flexible round-the-clock machining. The addition of a side-grinding machine enables fully automatic economic saw blade production to be achieved.



#### Advantages for you:

- More rigid construction (monobloc design) improves tooth accuracy
- Measurement of complete tooth geometries ensures higher cutting edge precision
- Greater flexibility thanks to two-axis co-ordinate feed
- Prepared for automatic hollow face and chip breaker machining as standard
- Improved performance thanks to higher machining speed
- All functions CNC-controlled
- All-in-one machining for service and production applications in unmanned multi-shift operation, using the robotic loading system handling saw blades up to 840 mm in diameter
- For machining all tooth geometries of saw blades for either wood or metal cutting
- The external dimensions of the CHD 270 sharpening machine are comparable with the existing CHD 251

## Technical data at a glance

### Circular saw blades

|                 |         |               |
|-----------------|---------|---------------|
| Outer diameter  | CHD 270 | 80 to 840 mm  |
| with robot      |         | 100 to 630 mm |
| or              |         | 200 to 840 mm |
| Bore diameter   |         | from 10 mm    |
| with robot      |         | 10 to 180 mm  |
| Blade thickness |         | up to 14 mm   |
| with robot      |         | up to 5 mm    |
| Tooth pitch     |         | 6 to 120 mm   |

### Grinding paths (carbide lengths)

|                                             |       |
|---------------------------------------------|-------|
| Face machining with grinding wheel 200 mm Ø | 20 mm |
| Top machining with grinding wheel 125 mm Ø  | 15 mm |
| Relief grinding on tooth top                |       |
| 0° to 20° bevel grinding                    | 40 mm |
| 20° to 45° bevel grinding                   | 30 mm |
| Hollow grinding with pencil 6 mm Ø          | 15 mm |

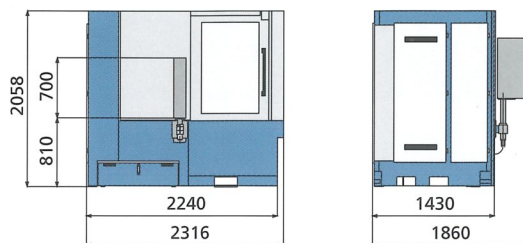
|                           |             |
|---------------------------|-------------|
| Hook angle                | -35° to 40° |
| Hook angle at hollow face | -10° to 25° |
| Clearance angle           | 5° to 45°   |
| Bevel grinding angle      |             |
| at tooth top              | up to 60°   |
| at tooth face             | up to 30°   |
| at negative tooth face    | up to 30°   |
| Tooth height difference   | any         |

### Grinding wheels

|                               |               |
|-------------------------------|---------------|
| Tooth face                    |               |
| Outer diameter                | 200 mm        |
| Bore diameter                 | 32 mm         |
| Peripheral speed (adjustable) | 45 m/s        |
| Tooth top                     |               |
| Outer diameter                | 125 mm        |
| Bore diameter                 | 32 mm         |
| Peripheral speed (adjustable) | 27 m/s        |
| Chip breaker, Oertli wheel    | up to 50 mm Ø |
| Grinding speed                | up to 20 mm/s |

|                          |                        |
|--------------------------|------------------------|
| Coolant pump output      | 80 l/min               |
| Capacity of coolant tank | approx. 180 l          |
| Total connected load     | approx. 5.8 kVA/4.4 kW |
| Weight of CHD 270        | approx. 3000 kg        |

### Dimensions



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



VOLLMER WERKE Maschinenfabrik GmbH  
P.O.BOX 17 60 · D-88396 Biberach/Riss  
Tel. + 49 (0) 7351/571-0 · Fax + 49 (0) 7351/571-130  
www.vollmer.de · info-vobi@vollmer.de