

NORMAC BS 35 / BS 45

Automatic grinding machine for band saw blades



BS 35



BS 45

EXCLUSIVE FEATURES OF THE BS35 AND BS45AUTOMATIC
BAND SAW GRINDING MACHINES

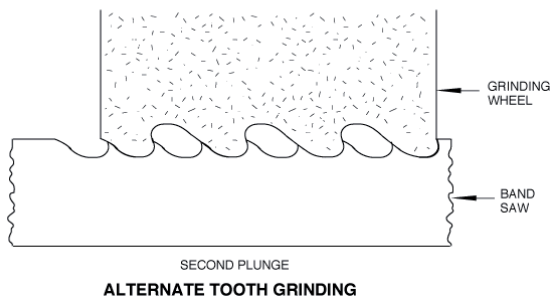
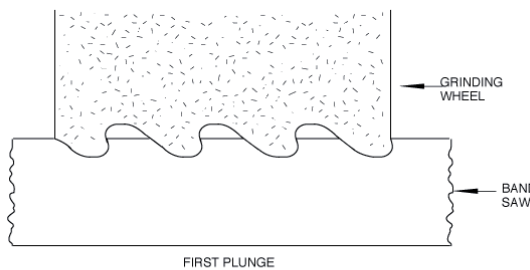
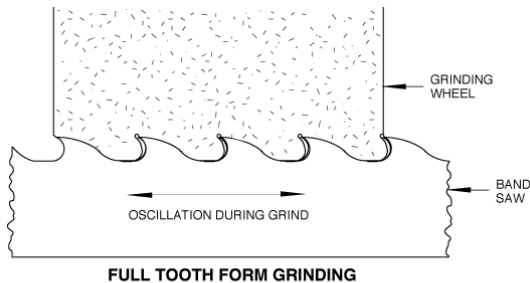
- FULLY AUTOMATIC OPERATION
- FULLY ENCLOSED GRINDING CHAMBER
- AUTOMATIC LUBRICATION
- HARDENED AND GROUND WHEEL AND DRESSER SLIDES
- PRECISION GRINDING SPINDLE
- HEAVY DUTY, COMPACT DESIGN



NORMAC, Inc. / Precision Grinding Machines

www.normac.com





NORMAC'S BAND SAW GRINDING MACHINES GREATLY IMPROVE THE QUALITY AND CONSISTENCY OF BAND SAW BLADE PRODUCTION

Both models can fully automatically grind straight or variable pitches from 1 to 32 TPI in one plunge with a band stock reciprocation, up to 10 degrees positive rake angle. Machines capable to grind band widths from 6 to 66 mm in a band stack up to 13 mm thickness.

The BS 35 model is equipped with an automatic diamond roll dressing system that is adjustable for depth of dress and for the number of grinding cycles between dressing operations. The machine also includes an automatic dress-in feature for automatically dressing tooth forms in new grinding wheels.

The BS45 is equipped with a 2 axis CNC dressing.

The Grind Vise Slides are mounted on extra precision Preloaded Linear Bearing Ways providing maximum rigidity and nearly frictionless motion on all Normac Band Saw Machines.

Precision Grinding Spindle Cartridge type, lubricated for life, driven by a 40 HP motor.

Fully Enclosed Grinding Chamber For a cleaner, quieter grinding environment.

Fully Automatic Lubrication Reduces parts wear and maintenance.

Automatic consumable burr plate system.

Production rate example:

- 3 tpi. band thickness 1.2 mm = 225 m / hr.
- 18 tpi. band thickness 0.9 mm = 225 m / hr.

TECHNICAL SPECIFICATION:

Band width:	6 - 66 mm	0,24 - 2,6"
Band stack thickness:	< 13 mm	< 0,51"
Pitch:	2 - 32 T.P.I.	
Vari. Pitch:	2 - 6 T.P.I. Up to 90 mm repeat patterns. 6 - 32 T.P.I. Up to 40 mm repeat patterns.	
Typical Cycle times:	3 T.P.I. - 18 sec. 10 T.P.I. - 24 sec.	
Materials:	Bi-metal or carbon steel, fully annealed or hardended.	
Accuracy:	Tooth height to within 0.002 mm in 100 mm band length.	
Weight:	4350 Kg	9,600 lbs
Electrical requirement:	230, 38, 415 & 60 or 575 V A.C. 50 or 60 Hz, 3 phase, 38 KW.	