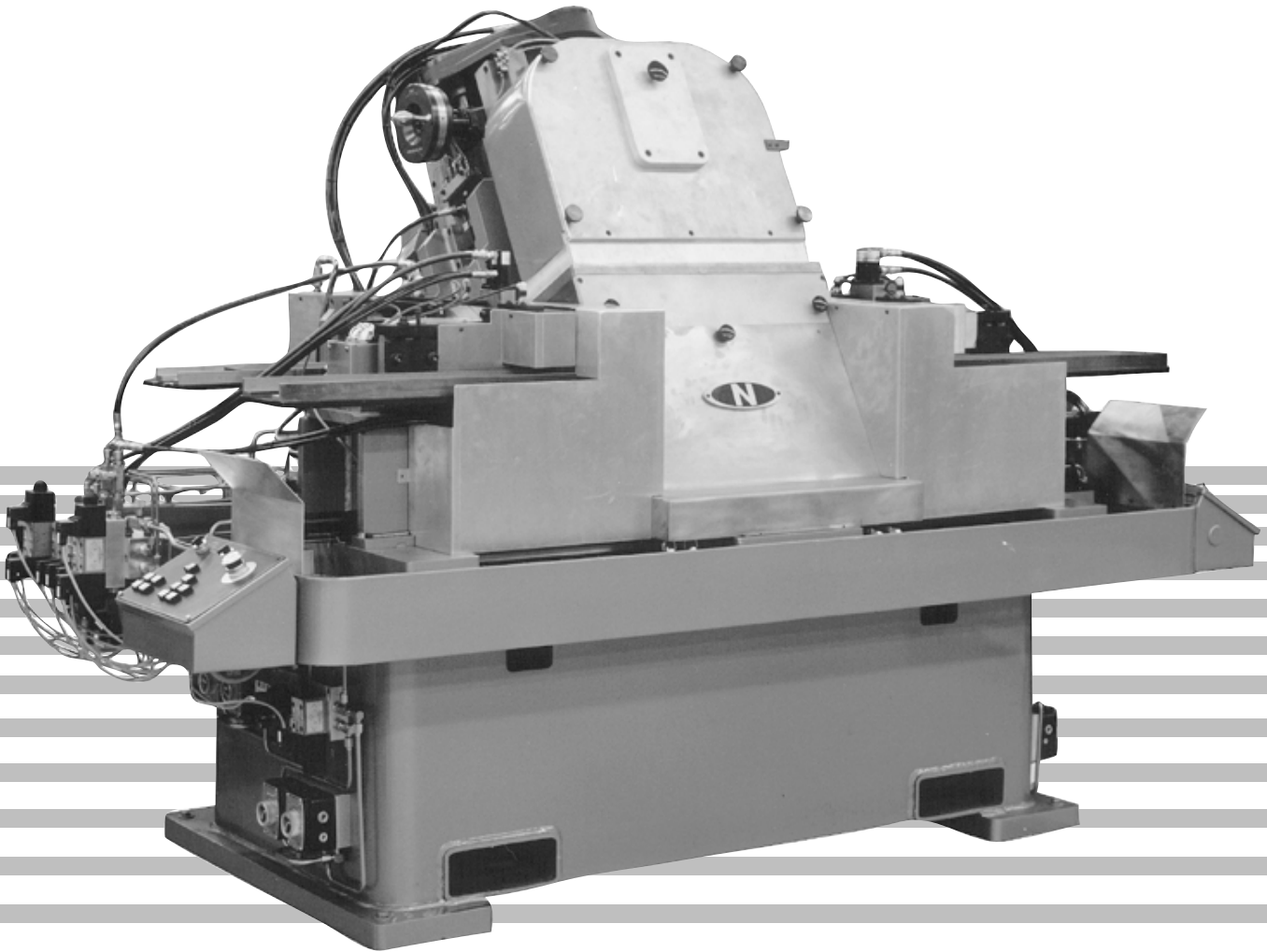


# JS06

## AUTOMATIC JIG SAW GRINDING MACHINE



MADE IN USA



NORMAC / Precision Grinding Machines

# Exclusive Features

Dual automatic load and unload mechanisms.

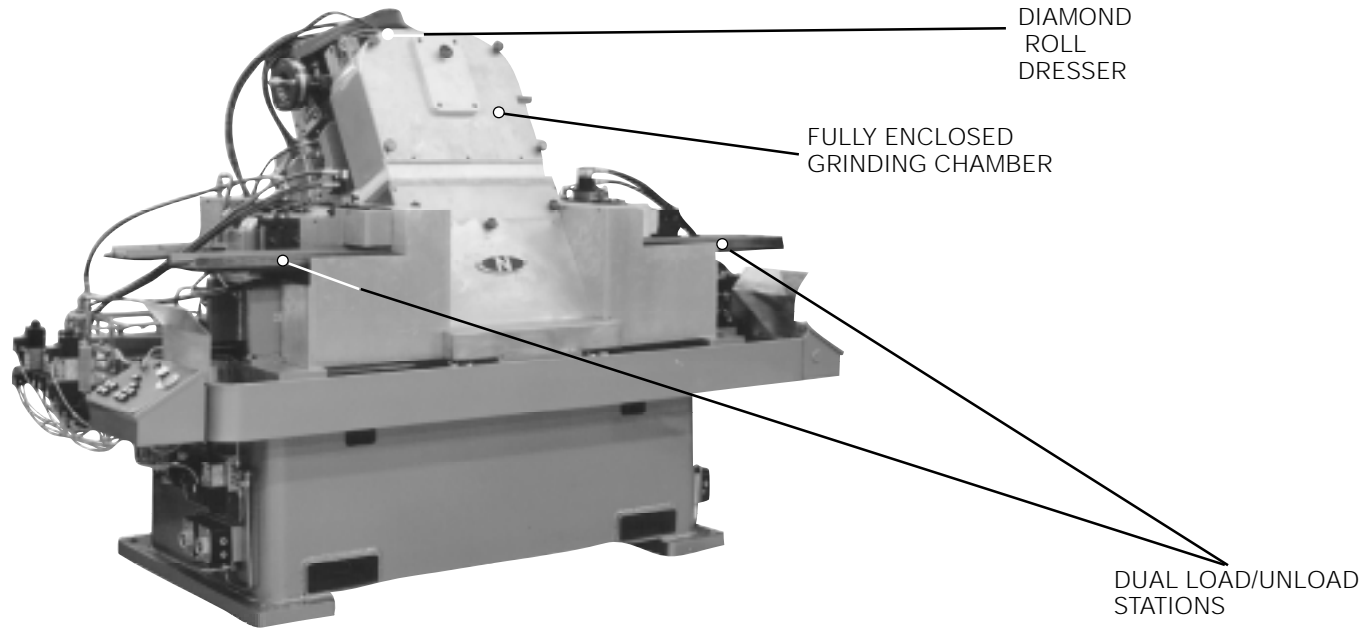
Swiveling grind vises for grinding bevel angles.

Grinds sharp, uniform teeth with little or no burr.

Wheel and Dresser Slides are Heavy Cast Iron, Hardened and Ground, and Automatically Lubricated for Greatest Durability.

Fully Automatic, Self-compensating Rotary Diamond Roll Dressing System.

Enclosed grinding chamber for a cleaner, quieter work environment.



## JS06 Automatic Jig Saw Reciprocating Saw Blade Grinding Machine

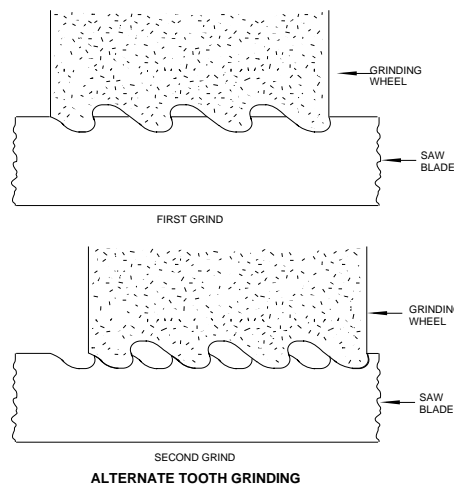
### General Description

The JS06 Fully Automatic Jig Saw Blade Grinding Machine provides a new, fast and efficient method for grinding jig saw and reciprocating saw blades. The JS06 features dual automatic load and unload mechanisms and dual grinding vises to provide maximum output from the machine. The swiveling vise mechanisms allow grinding bevel angles up to 30° and the angled grinding wheel head allows grinding up to 20° positive rake angles.

The JS06 grinds using an alternate tooth (or "skip tooth") method that ensures grinding sharp, uniform teeth with little or no burr.

In the automatic cycle, one grinding vise moves to its unload/load station where a finished blade is unloaded from the vise, and

a new blade blank is loaded. While this is happening, the other grinding vise rotates to the preset bevel angle and travels under the grinding wheel, grinding half the teeth. After the blade has traveled past the grinding wheel, the vise rotates to the opposite bevel angle and shifts one pitch length. The vise then travels under the grinding wheel in the opposite direction to finish grinding the teeth, and then travels to its unload/load station.



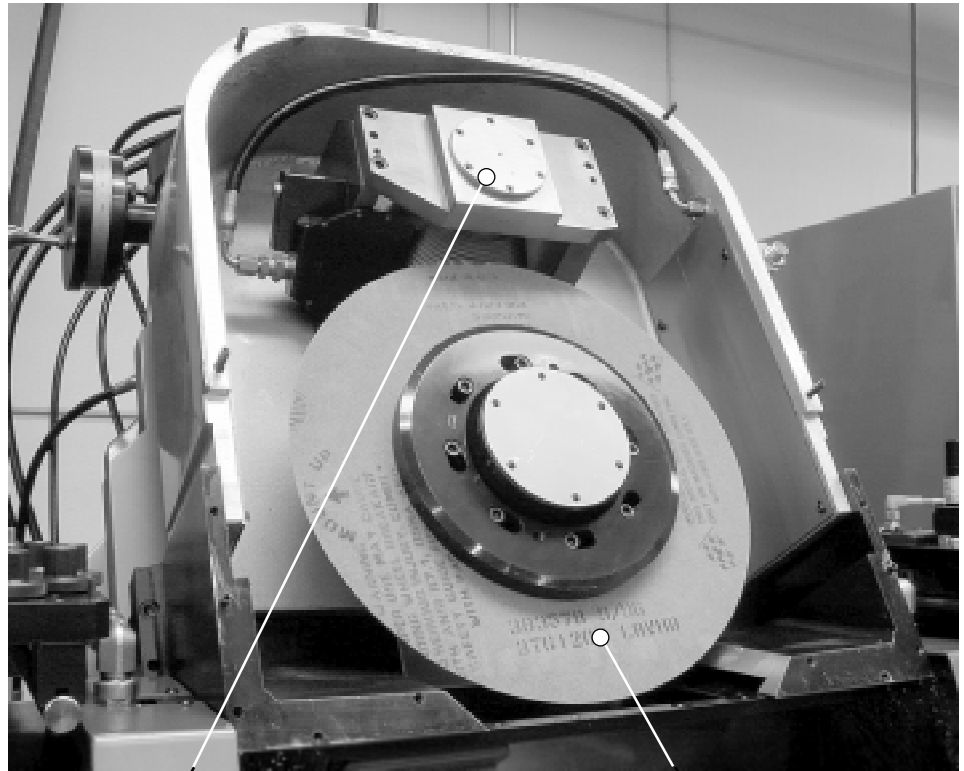
Style of blade produced by the JS06.

# Wheelhead and Dresser Assembly

The JS06 wheelhead assembly incorporates hardened and ground precision wheel and dresser slides that are automatically lubricated for reliability and ease of maintenance. The dresser and grinding wheel slides are geared together so reestablishing tooth depth is unnecessary when making a wheel change.

The wheel dressing frequency is determined by the type of blade material being ground and is preset by using a counter on the control panel. Dressing depth is infinitely variable.

The dressing system on the JS06 consists of a 2 H.P. precision motorized spindle with outboard support for greater rigidity, and a reverse plated diamond dresser roll to dress the grinding wheel. This roll is designed with a 28° face angle capable of producing up to a 20° positive rake angle on the finished tooth form.



Rotary Dresser

Grinding Wheel

# Loading and Unloading System

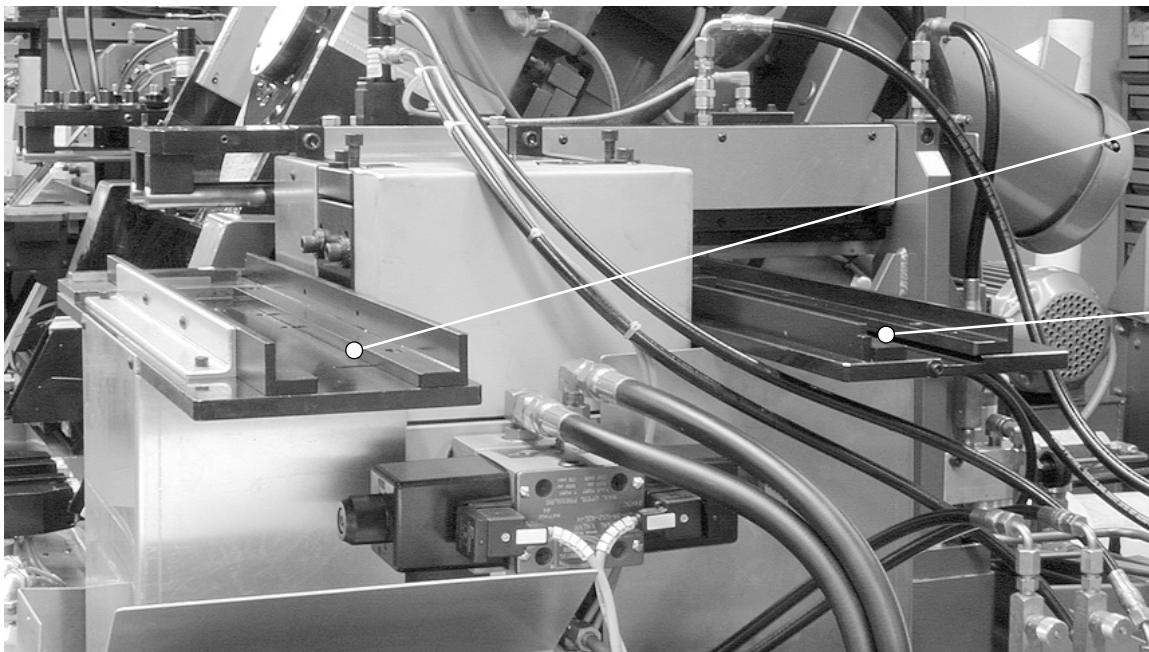
The JS06 features dual load and unload stations; one load/unload station at each side of the machine. Each load/unload station consists of a loading and unloading tray. The load tray, holds jig saw blade blanks and the other, the unload tray, holds the finished ground blades.

In the automatic cycle, the blades move forward in the load tray and when they reach

a prescribed position a loader blade picks up a new blade and places it in the grind vise. While this is taking place an unload finger comes down on the unload station and moves a finished blade from the grind vise toward the unload tray. When the finished blade is in position at the opening of the unload tray, a metal finger rises and pushes the finished blade into the tray and stacks it with the other

finished blades.

Since loading /unloading takes place during grinding there is no delay waiting for the machine to reload a blank. There is no wasted loading time when you grind jig saw blades on Normac's JS06.



Unload Station

Load Station

# Specifications

## Blade Size

1-3 mm thick, 3/16"-1/2" (4,7 mm-12.7 mm) high, 6" (152.4 mm long), 5" (127 mm) tooth length.

## Rake Angle

20° maximum positive rake angle.

## Bevel Angle

30° maximum bevel angle.

## Grinding Wheel Size

20" (500 mm) O.D. x 8" (203,2 mm) I.D. x 2.5" (63.5) minimum to 4.5" (114,3 mm) maximum wide., 28° face angle. Vitrified bonded type.

## Control

Programmable Logic Control

## Coolant Requirement

30 gallons per minute (115 LPM) at 100 PSI (7.0 atmospheres). Straight oil coolant is recommended.

Note: *Coolant system not furnished with the machine.*

## Electrical Requirement

230, 380, 415, 460 OR 575 V.A.C. 50 or 60 Hz, 3 phase, 17 Kw.

## Floor Space

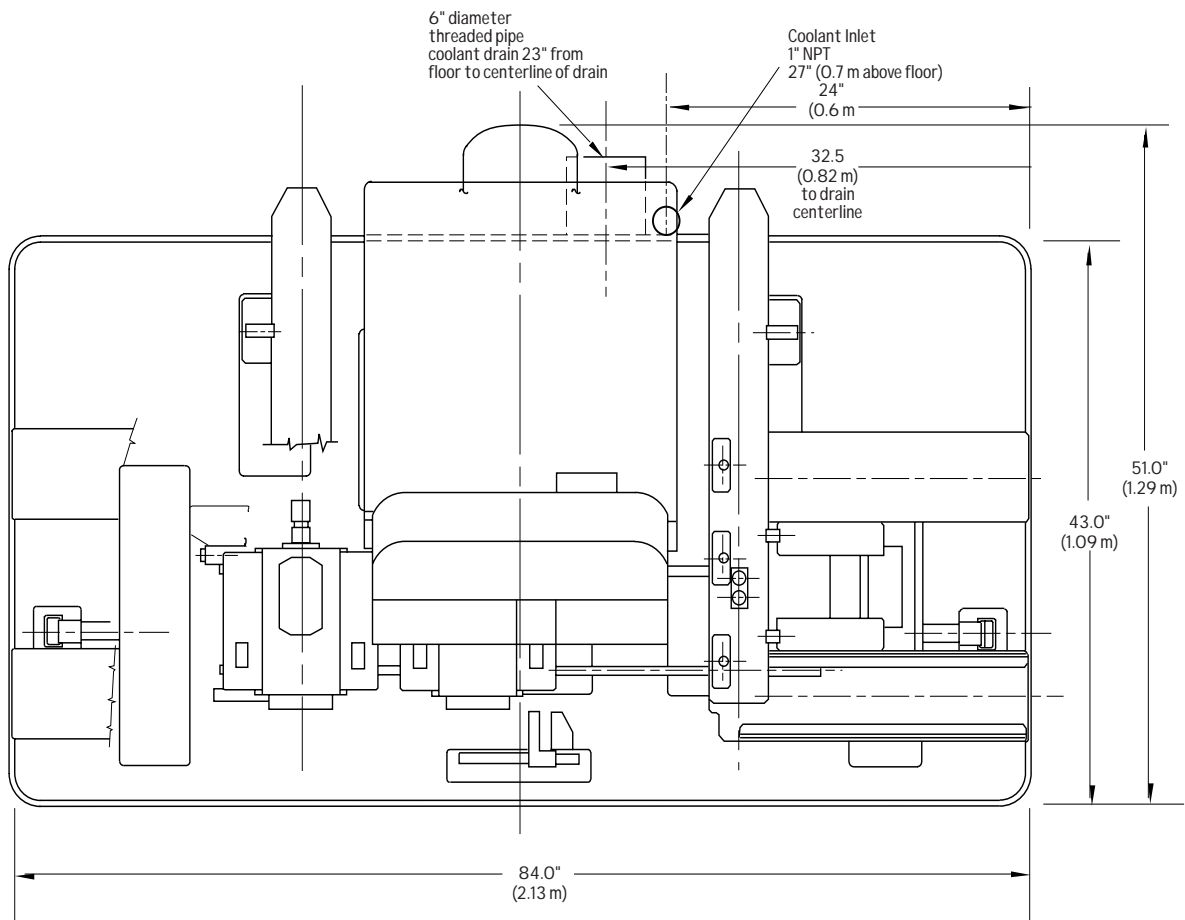
84" x 51" (2,1 m x 1,3 m).

## Shipping Weight

8,200 lbs. (3720 kg)

**Estimated Production Rates**  
Average 720 pcs/hr

Production rates shown are averages based on actual operation. Actual rates may vary depending on grinding wheel used, type of steel, coolant, etc.



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