

NORMAC SS 25

Automatic straight saw grinding machine



EXCLUSIVE FEATURES SS25 AUTOMATIC STRAIGHT SAW GRINDING MACHINE

- Automatic grinding cycle.
- Fully enclosed grinding chamber.
- Automatic self-compensating dressing system.
- Solid state programmable control system.
- 20 horsepower spindle drive.
- Easy load and unload.
- Fast size changes.
- Small floor space requirement.
- Grinds conventional and fast-cut tooth profiles.

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NORMAC, Inc. / Precision Grinding Machines



MACHINE DESCRIPTION

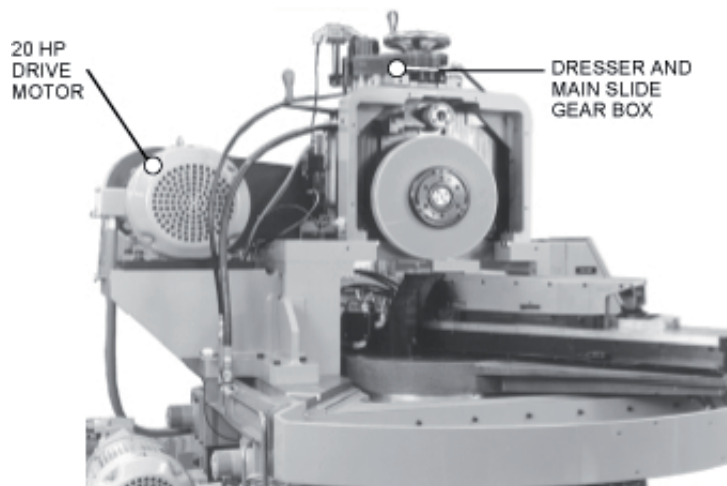
The SS25 uses a 45 mm (1-3/4") wide grinding wheel and a plunge grinding method.

The grinding wheel is dressed with the tooth form, with every second tooth left out.

The grinding wheel plunges down, grinding alternate teeth in the first 50 mm (2") of the blade, and then returns up and clear of the blade. The worktable then advances 50 mm (2") and the grinding stroke is repeated. This process is repeated the number of times required for the saw blade length. After the entire length has been ground, the table is shifted one pitch and the entire table swivels to the opposite bevel angle.

The grinding then begins again with the table moving in 50 mm (2") increments toward the front end of the blade. The SS25 worktable assembly incorporates the blade clamping fixture and mechanism, the blade advance (indexing mechanism, the pitch shift mechanism, and a rotary table mechanism for moving the blade to the desired bevel angles. The blade advance and pitch shift motions are controlled by a single axis closed loop servo drive and linear encoder feedback with 1 micron resolution.

The SS25 employs a unique blade positioning and clamping system. For loading, a blade is pushed forward to a stop. When the clamping push-button is depressed, the blade is automatically positioned and clamped. For unloading a finished blade, the clamping mechanism opens and the blade is pushed up and back for easy removal.



TECHNICAL SPECIFICATION:

Size Range Any pitch:	Straight, 15°, 25° or 34°
Bevel angles;	380 mm, 508 mm, 610 mm, 660 mm (15", 20", 24" or 26") long blades.
Space Requirements (W x D x H):	2 m (80") x 1,8 m (72") x 1,9 m (76") high.
Shipping Weight:	3600 kg (7,000 lbs).
Electrical Requirements:	Total connected electrical load is 19.5 KW
Coolant Requirements:	A coolant system is required but not furnished. 115 l/min (30 gal) at 100 PSI (7.0 atmospheres). Straight oil coolant is recommended
Estimated Production Rates:	380 mm blade (15") - 60 pieces per hr. 610 mm blade (24") - 40 pieces per hr. 660 mm blade (26") - 35 pieces per hr.