

CA200/300 CAL200/300

**High-tech machining technology for
your resawing and log band saw blades.**

CNC ||| controlled



Sharpening technology for limitless grinding programs. Competence as the basis for perfection.

Limitless CNC-controlled grinding programs. No cams.
Automatic sequencing.
Outstanding grinding quality.

Pin-point precision at the cutting edges of band saw blade teeth is an essential requirement for economical sawing. The CA 200 and CA 300 automatic profile grinding machines comply perfectly with these stringent demands; developed for use in modern sawmills and for manufacturers who require the very highest quality standards on the saw blades they produce.

With this new machine concept, the grinding stroke and tooth feed are controlled by two CNC axes, which interact to allow a limitless range of tooth shapes to be programmed and accessed from the control panel. Tooth shape cams are a thing of the past.

Using this CNC technology, it is also possible to achieve precision profile grinding of variable pitch saw blades. Programs are also provided for winter tooth shapes and for fast bypass of the tooth gullet in newly stellite-tipped saw blades. On completion of program selection, and after pressing start, the machine runs automatically, leaving operating staff to attend to other work.

The hard-wearing, stable design of this automatic grinding machine allows saw blades up to 270 mm (CA 200) and 420 mm (CA 300) in width to be machined quickly with an outstanding grinding finish.

The machines use the wet grinding method; essential for high output and a long tool life. The user can choose between corundum or

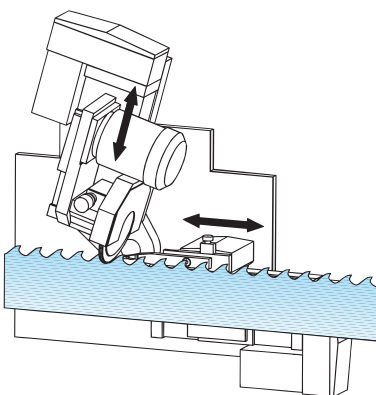
boron nitride grinding wheels with a large diameter of 300 mm (CA 300) or 250 mm (CA 200). Outstanding grinding results are guaranteed every time

We also place rigorous demands on safety and workplace conditions. The attractive full enclosure completely isolates the work area and gives optimum protection for operating staff against noise, dust and water vapour emissions. As another important safety feature, the machine comes to a complete stop if the enclosure is opened.

The machine concept conforms to the very highest technical standards. Its flexible design provides the ideal foundation for future tooth geometries and grinding requirements.

The CA 200 and CA 300 models are configured with tooth feed towards the grinding wheel from the right, the CAL 200 and CAL 300 models with tooth feed from the left towards the grinding wheel. A variety of support systems are available to accommodate different saw blade widths and lengths, either with or without auxiliary feed. In conjunction with the CBF 300 side grinder, saw blades can be completely and simultaneously machined in-line on the face, top and both sides.

CNC-controlled



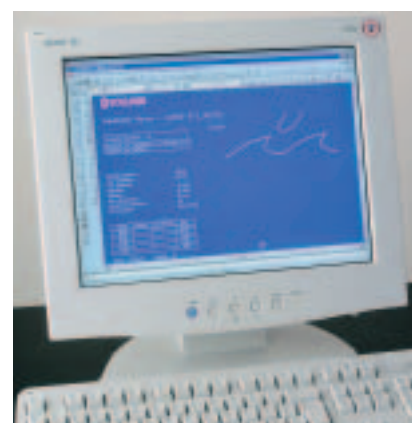
Two CNC axes for limitless grinding programs.



CA 200 profile grinding machine with mounting bracket and central clamping fixture.

Simple, convenient operation.

We paid particular attention to ensuring simple, convenient operation. All the important parameters are entered and the grinding programs accessed from the control panel. Important information is available to the user on an LCD display with operator guidance in plain language. Should a fault occur, operators are notified of the possible cause on this display.



Option tooth shape management

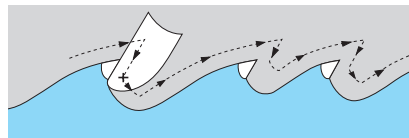


CA 300 profile grinding machine with mounting bracket and centrally powered height adjustment of the saw support pedestals.

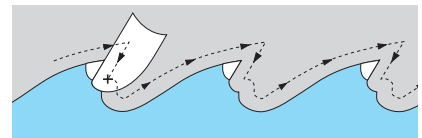
For limitless grinding programs.

The use of CNC technology allows limitless tooth shapes to be ground. These are simply accessed from the control panel. The "Tooth shape management" CAD/CAM system allows customer-specific tooth shapes to be created. These are then loaded into the machine using a memory card and are then available for machining. Tooth shape cams are no longer required.

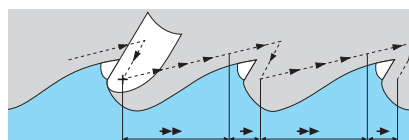
Some examples of possible tooth shapes:



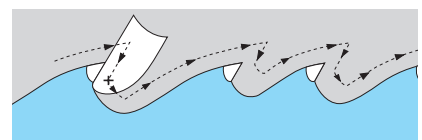
Basic shape



With program for winter tooth shape



With program for fast bypass of the tooth ground for newly stellite-tipped saw blades



With program for precision profile grinding of variable pitch saw blades

Meticulously engineered down to the last detail.

The quality and economy of a machine are determined to a large extent by the way in which it is able to address detail problems. Just a selection of innovative details are featured here:



The saw blade support with automatic height adjustment guarantees a precisely horizontal position of the saw blade (Fig. CA 300)



Precise positioning of the saw blade



Automatic dressing of the corundum grinding wheel as an optional feature (Fig. CA 200)



Bracket to simplify the insertion of saw blades (Fig. CA 300)



An optional synchronously driven auxiliary feed supports the forward movement of the saw blade



For effective purification of the coolant, we recommend using the N 170 cleaning plant



This optional filtration system extracts the coolant mist

Convincing solutions.

The major benefits for you at a glance:

CNC-controlled profile grinding machine for band saw blades up to 270 mm (CA 200) or 420 mm (CA 300) blade thickness.

Two CNC axes control tooth feed and the grinding stroke, eliminating the need for cams.

Limitless grinding programs and their variants such as variable pitch toothing, winter tooth, bypassing the tooth gullet in newly stellite-tipped saw blades.

Simple setting and tooth shape changeover from the control panel.

Wet grinding with full enclosure and extraction system to answer ever more rigorous demands on safety. Noise and emission protection, helping to create safer, more pleasant working conditions.

Outstanding grinding finish using either CBN or corundum grinding wheels.

Automatic dressing of corundum grinding wheels ensures precision profile grinding.

Only two grinding passes required for newly stellite-tipped saw blades; only one pass for regrinding.

Simpler insertion of the saw blade with the aid of a specially designed bracket.

Facility for in-line combination with the CBF 300 side grinder for even shorter overall grinding times.

The main specifications at a glance:

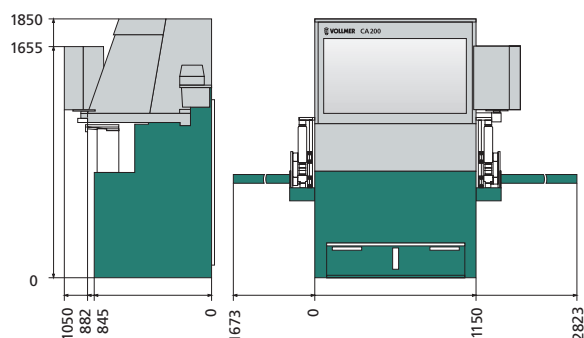
The machine is designed for sharpening band saw blades

Blade width	CA 200	70 to 270 mm
	CA 300	180 to 420 mm
Blade length	CA 200	from 5,5 m
	CA 300	from 8,5 m
Blade thickness		to 2,8 mm
Tooth pitch	20	to 120 mm
Tooth height		to 40 mm
Hook angle		to 40°
Grinding wheels		
Diameter	CA 200	250 mm
	CA 300	300 mm
Peripheral speed		
Corundum grinding wheels		35, 45 m/s constant
CBN grinding wheels		63 m/s constant
Working speed		5 to 30 teeth/min
Connected load	CA 200	appr. 4,8 KVA/4 KW
	CA 300	appr. 5 KVA/4 KW
Weight	CA 200	appr. 1025 kg
	CA 300	appr. 1300 kg

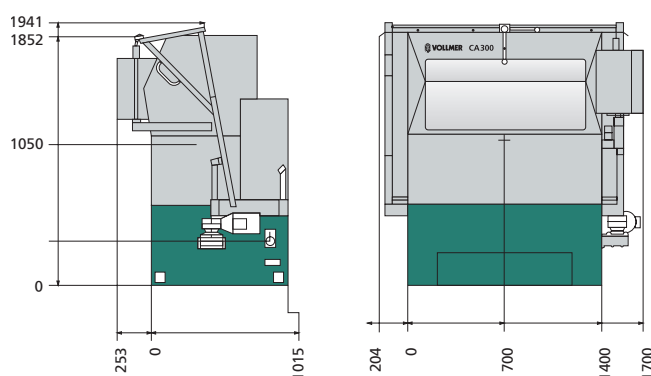
Stellite® is a registered trade mark of Stoodly Deloro Stellite.
Alterations of constructions due to technical development reserved. Patents applied.

Dimensions

CA 200



CA 300



VOLLMER WERKE
Maschinenfabrik GmbH
P.O. Box 1760
D-88396 Biberach/Riss
Phone +49 7351/571-0
Telefax +49 7351/571-130
info-vobi@vollmer.de
www.vollmer.de