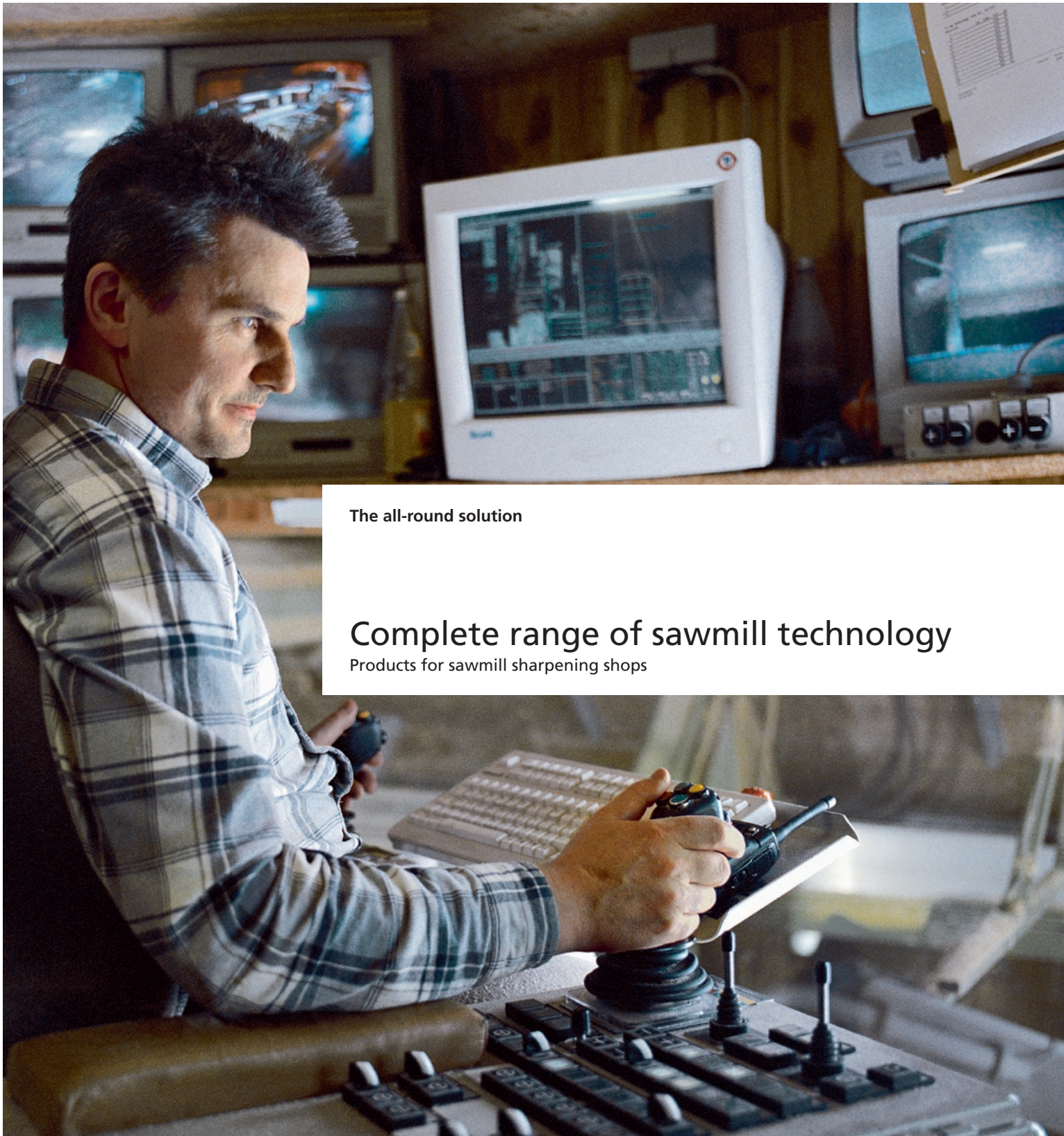


TOP PRODUCTS FOR TOP PERFORMANCE



The all-round solution

Complete range of sawmill technology

Products for sawmill sharpening shops

INNOVATIVE SOLUTIONS – THE KEY TO YOUR SUCCESS



The full program for your sharpening shop

It is in the sharpening shop that the productivity and economic efficiency of your business are determined. Only with precision-ground tools can you guarantee a long service life and maximum machining availability for your equipment. With its comprehensive know-how, high-performance machines and services, VOLLMER offers the ideal ingredients for top-quality tools. With innovative technologies for machining band and circular saw blades or for one-stop planning and equipping of your sharpening shop, we are the professional partner for sawmills world-wide.

VOLLMER machines are noted for their top precision, user-friendliness and long life. From manually operated machines for simple tasks to fully automatic solutions with sharpening centres run on a multi-shift basis. Take advantage of our full range of machining equipment for all types of sawmills!

VOLLMER service and customer care

Our experts are at your disposal when it comes to consultation, reorganisation of work sequences, optimised service concepts or individual financing models. As a partner with international experience in successful projects, we help you make your sharpening shop the key to the economic efficiency of your sawmill.

Our approach is geared to maximising the efficiency of your VOLLMER machines: start-up management by VOLLMER specialists, staff instruction plus preliminary and final acceptance inspections, telephone support, on-site service, spare part express, preventive inspection and maintenance work and tailor-made service and maintenance contracts during and after the warranty period.



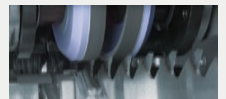


Sharpening of band saw blades

The tool life of your saw blades is crucial to the economic performance of your sawmill. The sharpening process contributes greatly to this by preventing cracks from forming in the tooth gullet. Exact side grinding plays a major role in maintaining the accuracy of the saw kerf in order to maximise yield and so improve economic efficiency.



Side grinding



Blade machining: levelling – tensioning – straightening

Tension, levelness and back straightness are key factors in keeping the band saw blades running smoothly on the roll. The aim of tool maintenance, should therefore be to produce a well levelled, tensioned and straightened saw blade. The blade trueness, tool life and cutting accuracy are a direct result of the overall care of the tool.



Measuring



Levelling

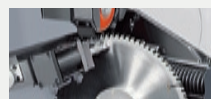


Straightening



Sharpening of circular saw blades

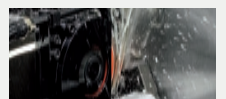
Precise tooth geometries with a perfect face and top grinding finish ensure high cutting rates and productivity for your circular saw blades. Exactly ground tooth sides guarantee top surface quality. The carbide grinding technology used by VOLLMER has enjoyed a world-wide reputation for precision and outstanding results over decades, and contributes substantially to the performance of your sawmill.



Face grinding



Top grinding



Flank grinding

PRODUCT OVERVIEW

Band saw blade machining

Profile grinding

CA 350

Profile grinding machine with 4 CNC-controlled axes. With freely programmable tooth shape.



Blade width: 120 to 360 mm
 Blade length: from 6 m
 Blade thickness: up to 2,8 mm
 Tooth pitch: 20 to 80 mm
 Tooth height: to 40 mm
 Working speed: 5 to 30 t/min

CA 300

Profile grinding machine with 2 CNC-controlled axes. For band saw blades up to 420 mm width. With 30 standard tooth shapes.



Blade width: 100 to 420 mm
 Blade length: from 8,5 m
 Blade thickness: up to 2,8 mm
 Tooth pitch: 20 to 120 mm
 Tooth height: up to 40 mm
 Working speed: 5 to 30 t/min

CA 200

Profile sharpening machine with 2 CNC-controlled axes. For band saw blades up to 270 mm width. With 30 standard tooth shapes.



Blade width: 70 to 270 mm
 Blade length: from 5,5 m
 Blade thickness: up to 2,8 mm
 Tooth pitch: 6 to 120 mm
 Tooth height: up to 40 mm
 Working speed: 5 to 30 t/min

CA 100

Profile sharpening machine with cam control system, available in dry and wet grinding versions. Extremely robust and simple to operate. Compact design.



Blade width: 120 to 360 mm
 Blade length: from 5,5 m
 Blade thickness: up to 2,8 mm
 Tooth pitch: 8 to 110 mm
 Tooth height: up to 40 mm
 Working speed: 10, 20, 30 t/min

CANA E

Universal profile sharpening machine for band, gang and circular saw blades. Compact, heavy design.



Band saw blade width: to 260 mm
 Tooth pitch: 10 to 100 mm
 Tooth height: up to 40 mm
 Gang saw blade width: up to 200 mm
 (optionally up to 220 mm)
 Circular saw blade diameter: 120 to 1.250 mm
 (optionally up to 2.000 mm)
 Working speed: 30 to 75 t/min

Liliput

Profile sharpening machine for narrow band saw blades, e.g. in joinery applications. Compact, space-saving machine.



Band saw blade width: 5 to 70 mm
 Circular saw blade diameter: 60 to 650 mm
 Tooth pitch: 3 to 35 mm
 (optionally up to 53 mm)
 up to 20 mm
 Tooth height: up to 20 mm
 Working speed: 48 to 80 t/min

Flank grinding

CBF 310

Flank sharpening machine with 4 CNC-controlled axes. Oscillation grinding as standard. Ideal for all band saw blades including thin-cutting saws.



Blade width: 60 to 420 mm
 Blade length: from 5,5 m
 Blade thickness: 0,6 to 3 mm
 Tooth pitch: 6 to 120 mm
 Working speed: up to 20 t/min

CBF 300

Robust, tried-and-tested flank sharpening machine for band, gang and circular saw blades. Simple operation and high grinding output.



Blade width: 60 to 420 mm
 Blade length: from 5,5 m
 Blade thickness: 0,9 to 3 mm
 Tooth pitch: 6 to 100 mm
 Working speed: up to 20 t/min

CAF 100

Flank sharpening machine available in dry and wet grinding versions. Extremely robust and simple to operate. Compact design.



Blade width: 120 to 360 mm
 Blade length: from 5,5 m
 Blade thickness: up to 2,8 mm
 Tooth pitch: 8 to 110 mm
 Working speed: up to 16 t/min

Stellting

GPA 200

Newly developed stellting machine based on plasma welding technique. With 2 CNC-controlled axes. Ideal for stellting band, gang and circular saw blades.



Band saw blade width: 120 to 360 mm
 Blade length: 6 to 18 m
 Tooth pitch: 10 to 100 mm
 Gang saw blade width: 80 to 200 mm
 Circular saw blade diameter: 220 to 900 mm
 Working speed: up to 10 t/min

Levelling, tensioning and straightening

GWM 10U

Stellting machine based on resistance welding technique for band, gang and circular saw blades.



Band saw blade width: 60 to 260 mm
 Blade length: from 5,5 m
 Tooth pitch: 25 to 65 mm
 Tooth height: 6 to 30 mm
 Gang saw blade width: 80 to 210 mm
 Circular saw blade diameter: 200 to 1.000 mm
 Working speed: approx. 4 to 5 t/min

RC 100

Dressing centre for fully automatic, all-in-one dressing of band saw blades. For measuring, levelling, tensioning and straightening in the same clamping fixture.



Blade width: 70 to 420 mm
 Blade length: from 18 m
 Blade thickness: 0,8 to 2,8 mm
 Working speed: 5 to 27 m/min

MAP 200/MAP 400

Levelling machine for band saw blades. For automatic double-sided measuring, correction and inspection of irregularities.

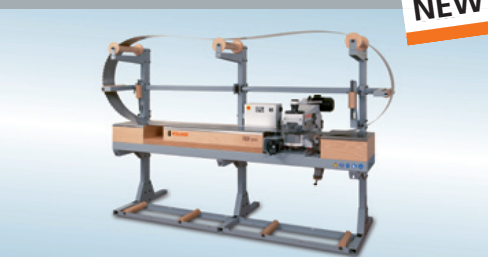


Fig. MAP 400

	MAP 200	MAP 400
Blade width:	to 206 mm	to 400 mm
Blade length:	7 to 10,5 m	8 to 19 m
Blade thickness:	0,8 to 1,47 mm	0,8 to 1,85 mm
Working speed:	app.15 m/min	app. 15 m/min

RB 200 and RW 200

Dressing bench and rolling machine for manual machining of band saw blades.



Band saw blade width: up to 400 mm
 Blade length: 8,5 to 11,5 m
 (optionally up to 18 m)
 Gang saw blade width: up to 200 mm
 Rolling speed: 5 to 16 m/min

Welding

MA 311

Welding machine for band saw blades. For automatic MIG welding and repair of cracks.



Blade width: 60 to 311 mm
 Blade thickness: 0,8 to 2,8 mm
 Welding speed: 120 to 540 mm/min

Circular saw blade machining

Face and top grinding

CHD 270 with ND robot system

Sharpening machine with 8 CNC-controlled axes and robot system with double gripper for fully automatic, round-the-clock machining and loading. With measuring device for measuring complete tooth geometry in order to ensure top cutting edge precision.



Circular saw blade diameter: 100 to 840 mm
 (according to model)
 Blade thickness: up to 5 mm
 Tooth pitch: 6 to 180 mm
 Working speed: up to 12 t/min

CHD 251 R2 with ND robot system

Sharpening machine with 5 CNC-controlled axes and robot system with double gripper. For fully automatic, round-the-clock machining and loading.



Circular saw blade diameter: 100 to 840 mm
 (according to model)
 Blade thickness: up to 5 mm
 Tooth pitch: 8 to 50 mm
 Working speed: up to 12 t/min

CX 100

Sharpening machine with 4 CNC-controlled axes. For face or top grinding of any tooth shape in a single cycle.



Circular saw blade diameter: 80 to 500 mm
 Blade thickness: up to 5 mm
 Tooth pitch: 7 to 100 mm
 Working speed: up to 18 t/min

CHP eco

Sharpening machine with 2 CNC-controlled axes. Bevel grinding angle individually selectable for machining all tooth geometries in a single cycle. Programs for grinding newly soldered teeth and bypassing individual missing teeth included as standard.



Circular saw blade diameter: 80 to 810 mm
 Blade thickness: up to 8 mm
 Tooth pitch: 6 to 120 mm
 Working speed: up to 20 t/min

CHC eco

Sharpening machine with automatic bevel grinding control. Versatile application, also for grinding cutter segments. Rotational direction of grinding wheel reversible for excellent grinding results.



Circular saw blade diameter: 80 to 810 mm
 Blade thickness: up to 5 mm
 Tooth pitch: 7 to 100 mm
 Working speed: up to 20 t/min

Flank grinding

CHF 270

Flank sharpening machine with 7 CNC-controlled axes and measuring device. For double-sided peripheral grinding. High grinding quality and dimensional accuracy thanks to vibration-resistant structure and optimal coolant supply.



Circular saw blade diameter: 80 to 840 mm
 Blade thickness: up to 14 mm
 Tooth pitch: 6 to 180 mm
 Working speed: up to 12 t/min

CHF eco

Flank sharpening machine with 3 CNC-controlled axes. For double-sided peripheral grinding. Five grinding programs included as standard.



Circular saw blade diameter: 80 to 840 mm
 Blade thickness: up to 8 mm
 Tooth pitch: 8 to 40 mm
 (optionally 6 to 120 mm)
 Working speed: up to 15 (12) t/min

Soldering, repairing

LG 21H

Device for manual soldering and desoldering of carbide teeth on circular saw blades with different diameters.



Circular saw blade diameter: 100 to 830 mm
 Tooth width: 2 to 6 mm

CHHF 21H

Machine for sharpening the flanks of newly soldered individual carbide teeth.



Circular saw blade diameter: 80 to 700 mm
 Tooth pitch: from 8 mm

Coolant purification

XB 600/XB 900

System for purifying coolants in sharpening machines for CV, stellite, HSS and TCT-tipped tools. Suitable for emulsion and oil.



Fig. XB 900

	XB 600	XB 900
No. of machining devices:	1 to 2	1 to 2
Filling volume:	max. 600 l	max. 900 l
Purification output:	up to 120 l/min	up to 120 l/min

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