



Special-purpose CNC grinder

Special-purpose grinder for strip-steel teeth grinding by throughfeed method

For the production of toothed cutting edges, ground on both sides, on continuous strip steel running from a reel.

Grinding by throughfeed method increases considerably the pitch accuracy and reduces the cycle times.

The toothed strip steel is the basic material for punching tools.





Characteristics:

Dressing of the profiled wheel with a diamond dressing roll during grinding – search cycle for plunging into the ground teeth (grinding of the second strip side) – grinding of both strip sides in a single operation cycle with two synchronized grinding heads - Integration of a measuring system to measure the tothing – control unit: Sinumerik 840 D

4 NC axes (Double-head 6 NC axes):

X-Axis grinding spindle head movement (double-head machines: x 2)

V-Axis (stroke motion of the workpiece for form adaptation of the tothing and compensation of wheel abrasion)

Z-Axis: strip drive via friction rollers

Y-Axis: dresser infeed (double-head machines: x 2)

2 NC spindles: dresser and workpiece feed (double-head machines: x 4):

Grinding spindle head (double-head machines: x 2)