



鋸片 研磨機

SAWBLADE
GRINDERS

四軸數控全自動鋸片研磨機

4 AXIS CNC Control Full Automatic Circular Sawblade Grinders



研磨齒型 Grinding Teeth Profile



標準附件 Standard Accessories

- 工具箱 x1組
- 切削油 x1桶 (4公升)
- 自動給油系統 x1組
- 工作燈 x1支
- 全罩式護罩 x1組
- 油霧回收器 x1組
- 鑽石砂輪 x2片
- 鋸片夾緊盤(ø130,ø210,ø260,ø310) x4組
- 高壓冷卻液x1組
- 電熱箱熱交換器x1組
- Tool box x 1 set
- Coolant oil x 1 pail (4L)
- Auto lubrication system x 1 set
- Working lamp x 1 pcs
- Fully enclosed splash guard x 1 set
- Oil mist recycle device x 1 set
- Diamond grinding wheel x 2 pcs
- Saw blade clamp (ø130,ø210,ø260,ø310) x 4 sets
- High pressure coolant system x 1 set
- Heat exchanger for electrical cabinet x 1 set

特殊附件 Optional Accessories

- 鋸片夾緊盤
- 鑽石砂輪
- Saw blade clamp
- Diamond grinding wheel

四軸CNC全伺服控制 4 Axis CNC control Full Automatic saw blade Grinding Machine

SVC-500 是一部四軸伺服控制CNC鋸片研磨機，外徑、齒數、研磨量、切削角、背隙角倒角全部自動化
SVC-500 is a saw blade grinding machine with 4 axis CNC servo control. Diameter, tooth number, grinding amount, cutting angle, and back rack angle by full automatically.

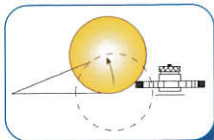
- **更簡易的人機介面**
親和性的人機操作介面設計，讓專業的研磨技術不再令人心生畏懼。
- **對話式輸入顯示**
簡單的輸入鍵盤設計，齒數、齒深、切削角、背隙角、倒角、進給速度全部以數據輸入，完全沒有繁瑣的人工調整過程。
- **自我偵測及模組化控制系統**
電腦與電控系統採取模組化方式設計，具有自我偵測系統，將錯誤訊息顯示於螢幕，使故障排除更為簡便。
- **齒型研磨+倒角研磨一次完成**
一次設定完成從齒型到倒角全自動研磨，不須停機做任何調整。
- **砂輪軸轉速可設定**
依據不同砂輪的研磨特性，可設定不同的砂輪轉速。
- **切削角自動定位**
切削角角度輸入完成後，砂輪軸自動偏移定位，無需手動調整。
- **自動倒角功能**
全自動倒角，鋸片研磨完成後，自動上下倒角，無需手動調整。
- **新鋸片重覆研磨功能**
直徑相同且齒數亦相同的新鋸片研磨新齒，只需第一片做接觸定位。第二片之後只按重覆研磨鍵，即可自動研磨，符合量產化的經濟效率。
- **Simple of man-machine interface**
Easy operation with friendliness and simple input data to accomplish full automatic grinding.
- **Digital Parameter Input**
With dedicated keypad design ,teeth number, teeth depth, cutting angle, back rack angle, chamfering and feeding speed can be input by digital data. No complicated procedures from manual adjusting.
- **Self-Detection & Modular control system**
Computer programming and control system is designed by modular technology. Self-detection system displays error on screen for easy trouble shooting.
- **Tooth Grinding+ Chamfer Grinding accomplish at one go**
From tooth to chamfer completely grind automatically at a time. Stop machine for adjustment is unessential.
- **Grinding wheel speed set at random**
According to characteristics of wheels, it can set different speeds.
- **Cutting angle automatic position**
After inputting a cutting angle, wheel spindle will offset automatically it done hands-free always.
- **Auto Chamfering function**
Completely automatic chamfering it done hand-free always.
- **New saw blade Duplication Grinding**
When grinding new saw blade with same diameter and same tooth number, you only need to touch rim with initial saw blade. After that you just press the "new" button, when another new one is installed. The fully meets the requirement of economical efficiency in mass production system.

型號	Model	SVC-500
研磨外徑	Grinding dia.	65 ~ 500
齒距	Pitch range	最大 24mm
研磨齒數	Grinding teeth	10~998 齒
鋸片厚度	Thickness of sawblade	最厚 10 mm
切削角	Range of cutting angle	0~30 度
研磨速度	Grinding Speed	1~60 齒/分
砂輪外徑	Wheel diameter	ø200 mm
砂輪內徑	Wheel inner diameter	ø32 mm
砂輪厚度	Grinding Thickness	最厚 8 mm
砂輪馬達	Grinding motor	5HP 2P
砂輪轉速	Grinding speed	2500~7000RPM
X 軸馬達	X axis motor	AC伺服 1.3KW
Y 軸馬達	Y axis motor	AC伺服 1.3KW
Z 軸馬達	Z axis motor	AC伺服 1.3KW
A 軸馬達	A axis motor	AC伺服 400W
冷卻液馬達	Coolant motor	1.5 KW
油霧回收器	Oil mist recycle device	0.75KW
磁鐵過濾機	Magnetic filter	60公升(Litre)/min
使用總電力	Total electric power	10.275 KW
機器重量	Machine weight	1550 KGS
機械尺寸	Machine size (LxWxH)	2000 x 1750 x 1800mm

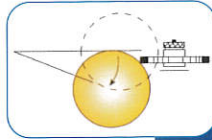
自動鋸片研磨機

Automatic Circular Sawblade Grinders

研磨倒角圖 Grinding Teeth Chamfer



砂輪頭上擺時，
可研磨上面倒角
Grinding head
swings up-wards,
grinding off the up-
ward chamfer



砂輪頭下擺時，
可研磨下面倒角
Grinding head
swings down-
wards, grinding
off the down-ward
chamfer



研磨齒型 Grinding Teeth Profile



特點 Features

- 全部的鑄件均採用球狀石墨鑄鐵(FCD-45)，確保精度及增加耐磨性。
- 直齒(A齒型)、曲背齒(B齒型)齒型切換容易。
不同的鋸片厚度，可經由量錶指示準確地調整。
- 進給速度使用無段變速調整，可隨齒距的變化，快速調整所需要的速度。
- C齒型的高齒、低齒同時研磨，並有指示錶做設定，確保準確的高低差值
- 倒角研磨不必更換砂輪，只須依照砂輪大小，對準指示牌即可。
- All cast-iron components are made from DUCTILE IRON(FCD-45), wear resisting to assure precision.
- Simply shift between Straight tooth(A type) and Curved tooth(B type). During saw blade install, the blade thickness setting is quick and accurate according an indicating meter.
- Driving speed change by a stepless adjusting device, regard to change speed for different blade pitch promptly.
- Alternate high/low teeth shall be accomplished by one pass. The teeth height difference is variable and read out from indicating meter, thus you got a perfect sharpening result.
- Teeth chamfering is easily made without need to replace grinding wheel, only swings upward or downward to aim the indication plate.

標準附件 Standard Accessories

- 砂輪 x10片 ● Grinding wheel x 10 pcs
- 分度盤 x2片 ● Index plate x 2 pcs
- 工作燈 x1支 ● Working lamp x 1pcs
- 工具 x1組 ● Tools x 1 set

特殊附件 Optional Accessories

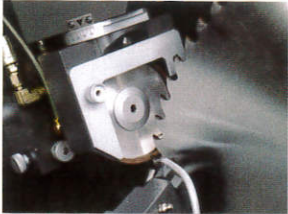
- 砂輪
- 分度盤
- 吸塵裝置
- 小徑鋸片座(鋸片最小直徑 ϕ 50mm)
- 大徑鋸片座&游動座(鋸片最大直徑 ϕ 650mm)
- Grinding wheel
- Index plate
- Dust suction equipment
- Small saw blade holder (available min ϕ 50mm)
- Enlarged saddle & hdder (available Max ϕ 650mm)



型號	Model	C-450-2
圓鋸片外徑	Saw blade dia.	ϕ 50- ϕ 450
齒距	Pitch range	最大 Max. 25 mm
齒深	Depth of teeth	最深 Max. 8 mm
切削角	Range of cutting angle	-5° ~ 30°
進給速度	Feeding Speed	45~180 齒/分
鋸片厚度	Thickness of sawblade	最厚 Max. 8 mm
砂輪外徑	Grinding Wheel dia.	ϕ 75 ~ ϕ 150 mm
砂輪孔徑	Wheel inner dia.	ϕ 25 mm
砂輪轉速	Grinding wheel speed	4200 rpm
砂輪馬達	Grinding wheel motor	0.55 kw 2P
傳動馬達	Driving motor	0.37 kw 2p / 4p
吸塵器馬達	Dust suction motor	0.37kw 2p (選購配備Optional acc.)
淨重/毛重	N.W / G.W.	130 kgs / 180 kgs

全自動鎢鋼圓鋸片研磨機

Automatic Carbide Saw Grinder



研磨左右斜角並可於一次完成所有加工
Single step grinding of right and left angles.

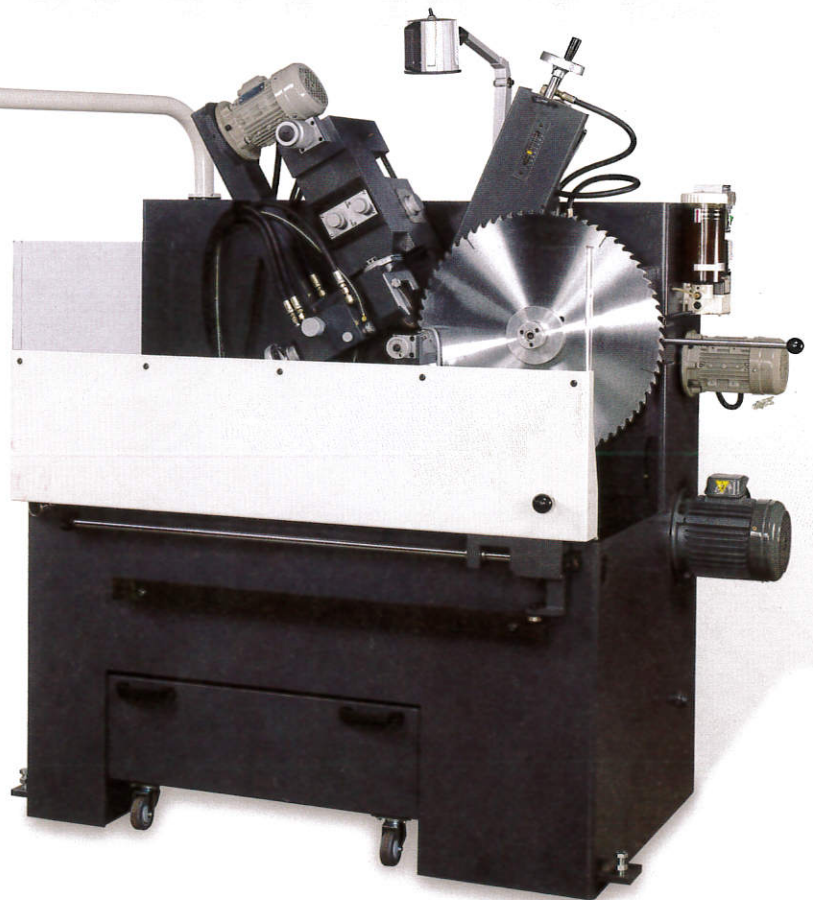
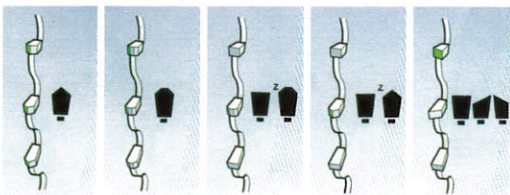


研磨鋸片之齒頂加工圖
Example of tooth top grinding



研磨鋸片之齒面加工圖
Example of tooth face grinding

研磨之齒形 Example of tooth shapes



標準附件 Standard Accessories

- 砂輪 1組
- 工具箱 1組
- 研消液1桶(4公升)
- Grinding wheel x 1set
- Tools x 1set
- Coolant oil 1 pail (4L)

特點 Features

- 全自動研磨，鋸片之齒面及齒頂。
- 可透過數值人機介面控制系統及LCD觸控式面板選擇適合的齒型及功能操作研磨。
- 操作者可選擇適合的齒型，並同時完成研磨。
- 研磨速度快，效率高，有效節省時間。
- 工作台採用高精度線性滑軌，精度高，壽命長。
- 鋸片設定簡易，研磨外徑100-810mm。
- Automatic grind for tooth faces and tops of saw blade.
- Select suitable tooth shape and function to operate with LCD touch display.
- Operator can select the appropriate tooth shape and complete processing simultaneously.
- Grinding speed is fast, high efficiency, effective to save time.
- Work table use linear guide of high precision, high precision, long life.
- Blade set-up is easy, grinding diameter is 100-810mm.

型號	Model	NC-810-3A
鋸片直徑	Saw outer dia.	ø100~ø810 mm
鋸片孔徑	Saw bore dia.	ø10~ø120 mm
鋸片厚度	Blade thickness	8 mm
齒距	Tooth Pitch	8~70 mm
頂端斜角	Top Bevel Angle	0° ~ 45°
齒面斜角	Face Bevel Angle	0° ~ 30°
研磨速度	Grinding Speed	20 teeth / min
鑽石砂輪外徑x孔徑	Diamond Wheel	ø125 x ø32
主電機功率	Connected load	2.2 KW
機械尺寸	Machine size	1650 x 1300 x 2000 mm
機械淨重	Machine weight	1050 kgs

自動鎢鋼圓鋸片研磨機

Automatic Tungsten Carbide Tip Circular Sawblade Grinders

C-700-2A

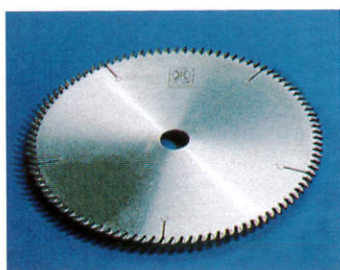


特點 Features

- 可研磨平齒，左斜齒，右斜齒及鋸尾。
- 可設定研磨齒數。
- 微電腦控制進刀時間。
- 操作簡單，只須調整角度及齒數齒距。
- 空油壓、驅動、研磨精度高。
- Can grind the flat tooth, left oblique tooth, right oblique tooth and hard iron tail.
- Can set up and grind the tooth to count.
- The microcomputer controls feed time.
- It is simple to operate, need only adjust the angle and tooth and count the tooth distance.
- Empty oil pressure, urging, grinding the precision high.

標準附件 Standard Accessories

- 鑽石砂輪 x 1組
- 研消液 x 1桶(4公升)
- 備用工具 x 1組
- Diamond grinding wheel x 1 set
- Coolant Oil x 1 pail (4L)
- Adjusting tool x 1 set



型號	Model	C-700-2A
研磨能力	Grinding capability (LxWxT)	ø178-ø700mm
鑽石砂輪尺寸	Grinding wheel size	ø150 x ø16 x16mm
砂輪迴轉速	Rev.speed of grinding wheel	6300 rpm
研磨動力	Grinding power	1HP
冷卻泵馬達	Coolant pump motor	1/8 HP
機械尺寸	Machine size	1100 x 1000 x 1440 mm
裝箱尺寸	Measurement	1200 x 1100 x 1540 mm
淨重/毛重	N.W / G.W.	350 kgs / 430 kgs