



ARTI Bileme

GRINDING & WELDING MACHINERY

OTOMAT-NC

NC AUTOMATIC T.C.T. CIRCULAR SAW GRINDER



www.artibileme.com.tr e-mail: info@artibileme.com.tr

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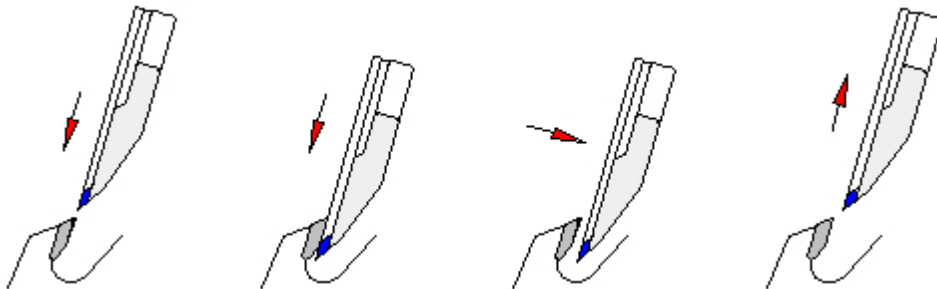
OTOMAT-NC

The OTOMAT-NC is a fast, NC controlled automatic face and top grinding machine that is capable of grinding all standard tooth shapes on T.C.T. circular saws up to Ø550mm in one cycle.

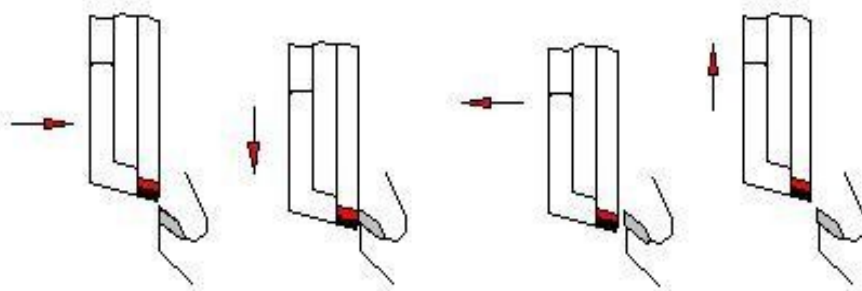
OTOMAT-NC is designed to grind T.C.T. circular saw blades, generally used for cutting timber, pressboard, PVC and aluminum. Its aim is to provide a clean and undamaged cutting edge for the materials used.

There are two different grinding processes that can be performed with this machine:

Face Grinding:



Top Grinding:



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General features at a glance:

- 3 axes hydraulic, 2 axes Step motor controlled.
- Microprocessor controlled.
- Operating screen in any language (please state the required language in purchase order)
- Possibility of selecting the grinding program from the control panel.
- Grinding all common tooth types in one cycle.
- ATB and combo face grinding in one cycle.
- Max. outside diameter Ø550mm.
- Hydraulic saw blade clamp providing rigid support during grinding.
- Automatic blade thickness adjustment to self center bevels.
- Central lubrication system.
- TFT screen control panel.
- Totally enclosed cabin for operator safety.
- Simple controls for ease of use.
- Rigid base.
- Variable grinding speed.
- Ergonomic cabin for ease of loading and unloading..
- Independently adjustable grinding and indexing speeds.
- Production conformed with CE standards.

Capacity: Top/face grinding up to 45 T.C.T. circular saws per day.

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Technical Specifications:

Circular saw outside diameter	Ø100-550mm
Bore diameter	Ø6-90mm
Blade thickness	Max. 6.0mm
Tooth pitch	7-100mm
Grinding stroke	50mm.
Cutting angle	(-10°) - (+30°)
Radial angle	±45°
Max. Tangential angle	30°
Grinding wheel outside diameter	Ø125mm
Grinding wheel bore diameter	Ø32mm
Grinding motor	1HP
Coolant container capacity	~50 lt.
Coolant motor capacity	35 lt/min.
Motor quantity	6
Connected load	~3kW
Voltage	380V, 3Ph, 60Hz
Net/gross weight	950/975kg
Dimensions	110*150*210cm.

Hydraulic power unit:

Hydraulic Pump Capacity	3,2 lt /min.
Working pressure	20 Bar
Container Capacity	18 lt
Oil type	Tellus 37
Number of valves in use	3 units

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Motors on the machine:

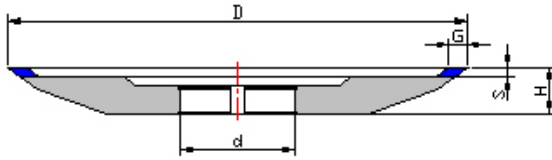
- i. Grinding wheel motor (Y axis) – [0,75kW 2800 r.p.m.]
- ii. Back clearance & hook angle adjustment motor (B axis) – [0,37kW 1400 r.p.m.]
- iii. Hydraulic motor – [0,75 kW 1400 r.p.m.]
- iv. Coolant motor – [0,09 kW 2800 r.p.m.]
- v. Beveling motor (A axis Step motor) – [8,5 Nm]
- vi. Infeed motor (X axis Step motor) – [8,5 Nm]

Saw blade holders provided with the machine:

Ø20 – 22 – 25 – 30 – 32 – 35 – 40 – 45 – 50 – 55mm

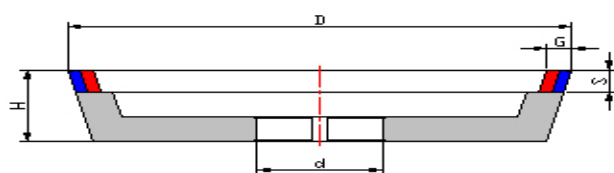
Grinding Wheels:

FACE GRINDING WHEEL



D	Ø125mm
G	5 mm
S	3 mm
H	12 mm
d	Ø32 mm
Type	4A2P

TOP GRINDING WHEEL



D	Ø125mm
G	7 mm
S	4 mm
H	18 mm
d	Ø32mm
Type	6A9

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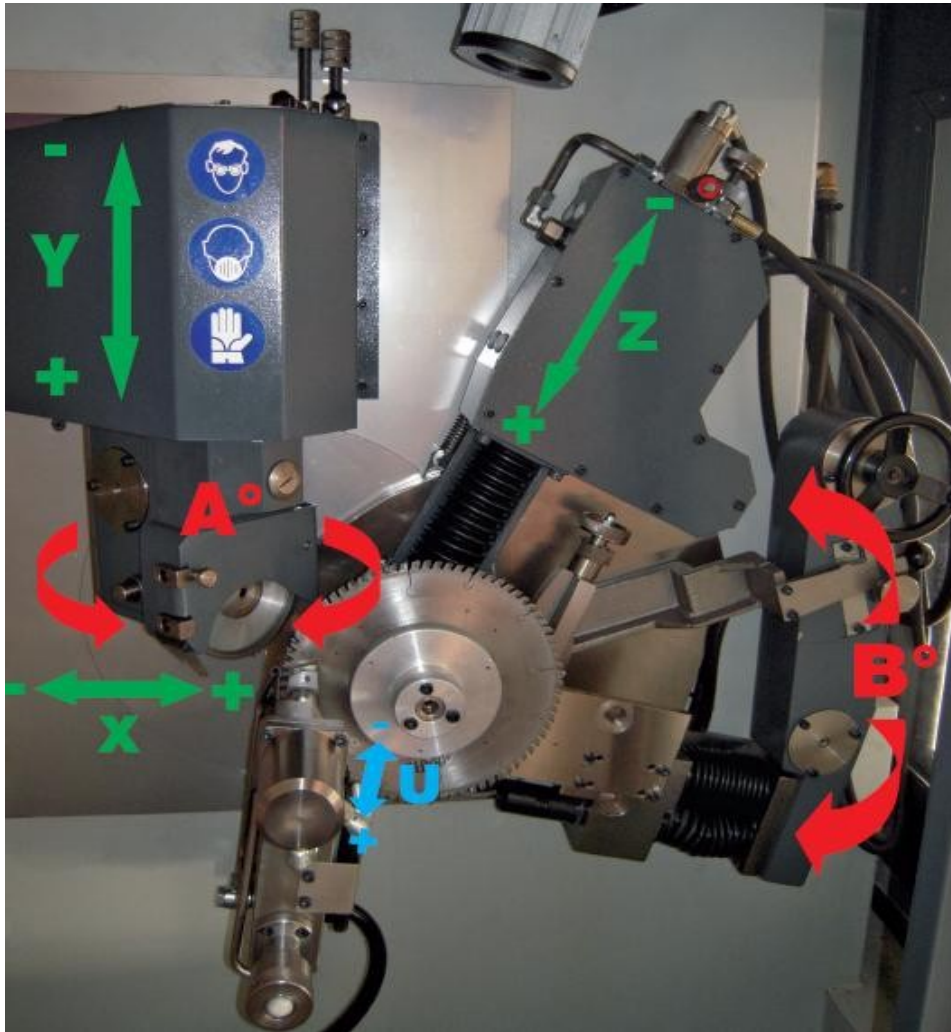


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Axes of the machine:



OTOMAT-NC Axes of the machine:

Infeed axis (X) – Step Motor

Grinding axis (Y) – Hydraulic

Indexing axis (Z) – Hydraulic

Beveling axis (A) – Step Motor

Back clearance – hook angle adjustment axis (B) – AC Motor

Clamping axis (U) – Hydraulic

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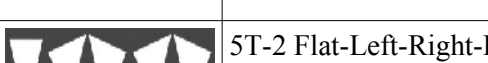




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Tooth Forms and Grinding Phases:

		Top	Face
	Triple and Flat tooth	1	1
	Chamfering of segmental and SS saw blades with CBN grinding wheels at the leader teeth	1	1
	Chamfering of saw blades at the leader and follower teeth with blades-identical chamfering angles at the tooth top	1	1
	Flat top	1	1
	All left bevels	1	1
	All right bevels	1	1
	Alternate top bevel (ATB)	1	1
	Pointed top	1	1
	Triple chip	1	1
	Triple-triple chip (Hi-low)	1	1
	Flat and pointed top	1	1
	5T-1 Flat-Right-Left-Right-Left	1	1
	5T-2 Flat-Left-Right-Left-Right	1	1
	5T-3 Flat-Right-Left-Right-Left-Flat-Left-Right-Left-Right	1	1
	SS45 – Raker Left Right	1	1
	Triple-Flat-Flat	1	1

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Warranty Period :

Mechanical Guarantee : 1 year against production faults.

Electronic Guarantee : 2 years against production faults.

(The guarantee does not cover the electrical motors and the supplied electrical materials)

Optional Supplements:

- Face grinding wheel.
- Top grinding wheel.
- Saw blade holders in various sizes.

(Saw holders up to Ø55mm are provided with the machine free of charge. Each holder for bigger diameters is optional)

- Air suction unit.
- Aluminum magnetic saw holder.
- Manual lubrication pump.
- Closed packing.

To be invoiced separately.