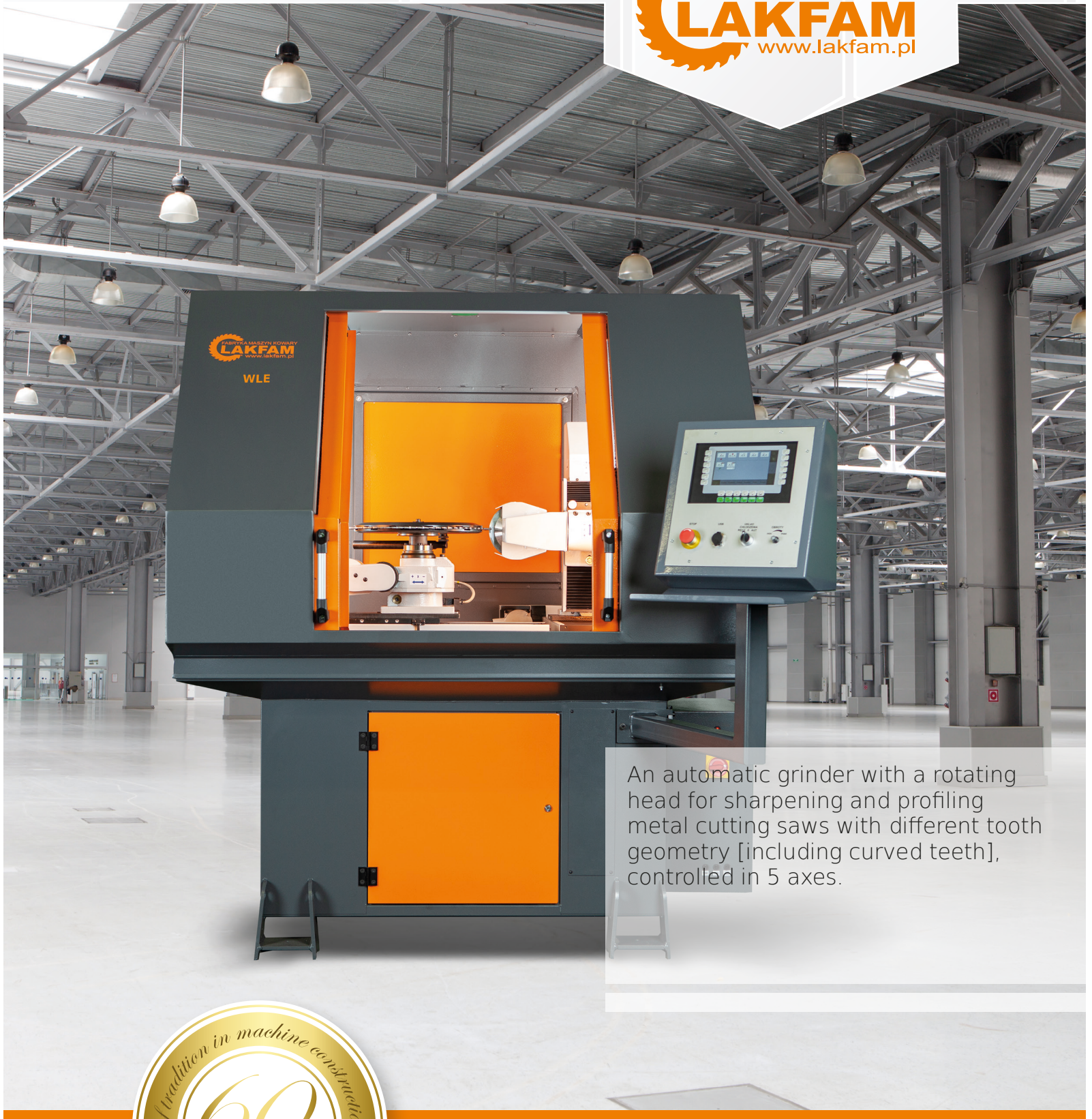


# ASP-631 WL(E)



An automatic grinder with a rotating head for sharpening and profiling metal cutting saws with different tooth geometry [including curved teeth], controlled in 5 axes.



# ASP-631 WL (E)

## Features of the ASP-631 WL (E)

- Five numerically controlled axes
- Grinding of the top and face of most currently available tooth geometries in one cycle, without having to change the tool position and the wheelhead manually
- An intuitive and clear control system with a graphical user interface
- Minimum machine operating costs
- Robust and well thought-out design
- Electronically controlled tooth pitch
- High precision, maintenance-free dividing head.

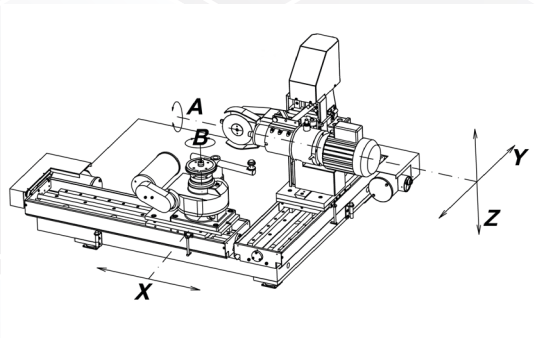
## Outcome

- The perfect combination of precision and performance
- The highest price/quality ratio.

# Design Assumptions

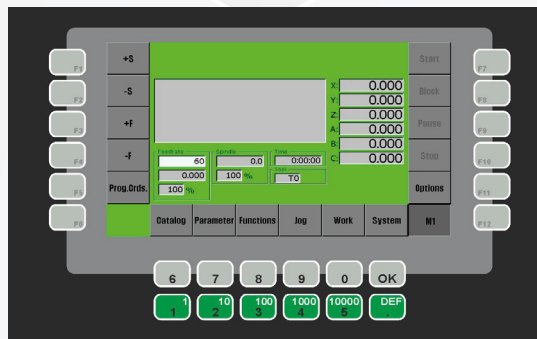
The grinder is designed for automatic sharpening and profiling circular saws (HSS) with diameters from 100 mm to 630 mm.

- The rotary wheelhead enables the sharpening of tooth types A, Aw, B, Bw, BR, and C
- Five numerically controlled axes enable the complete grinding of all available teeth shapes used in metal industry, plastic processing industry, and many others
- Robust and compact design
- Adjusting the rake and clearance angles from the controller
- No hydraulic systems
- Using highest quality components
- Manufactured in Poland
- Electronically controlled tooth pitch
- No need to retool the dividing head manually, i.e. changing the pusher or other mechanical parts



## Well thought-out design

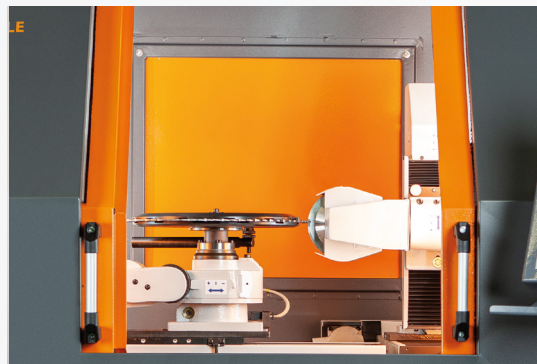
Five numerically controlled axes



## An intuitive control system with a touch panel



## Sharpening the clearance surface and bevelling



## Compact and robust design



## High-end components

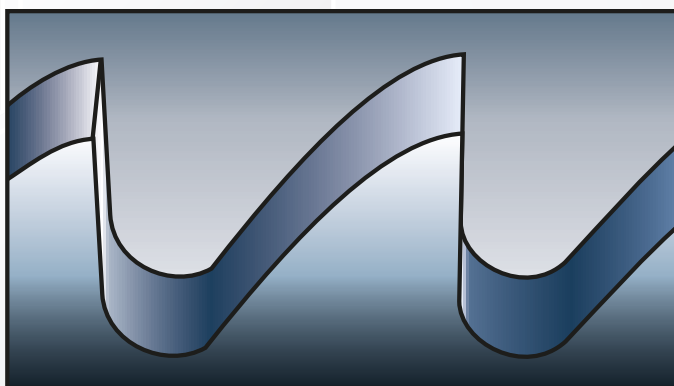
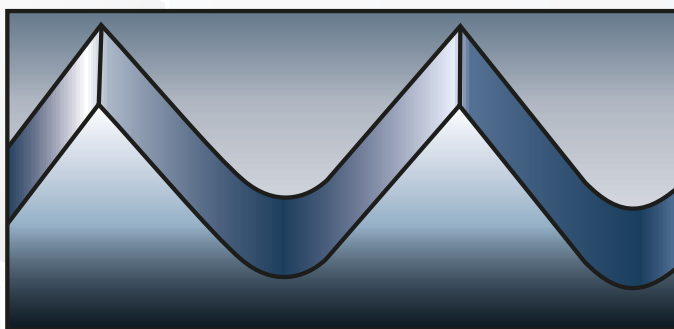
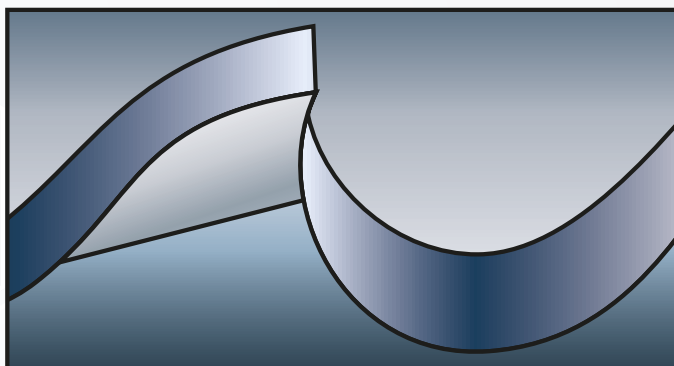
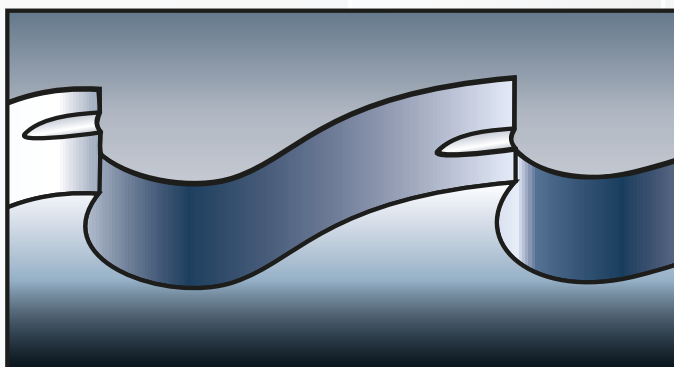


## Sharpening of the face and tooth profiling

# Description and application

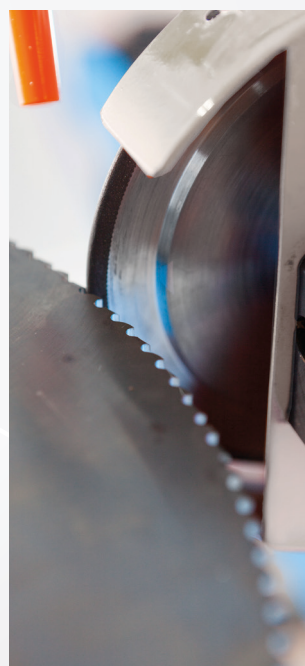
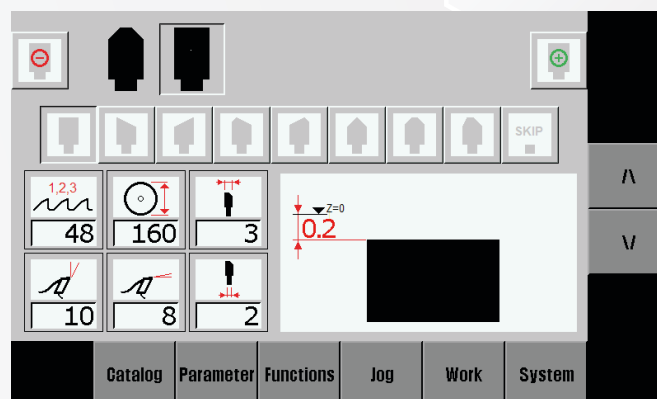
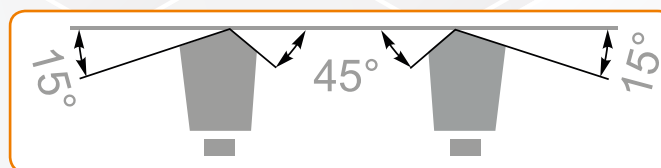
Polish engineering solutions combined with the work of our design engineers, resulted in the creation of the technologically advanced ASP-631 WL (E) grinder for sharpening tools like saws and metal slitting saws with curved teeth, used for cutting of steel, rubber, or plastic.

The use of 5 numerically controlled axes enables the automatic positioning of the wheelhead against the tool axis, and sharpening and profiling of teeth. The machine also makes it possible to remove old teeth and then make new teeth, according to pre-set parameters.



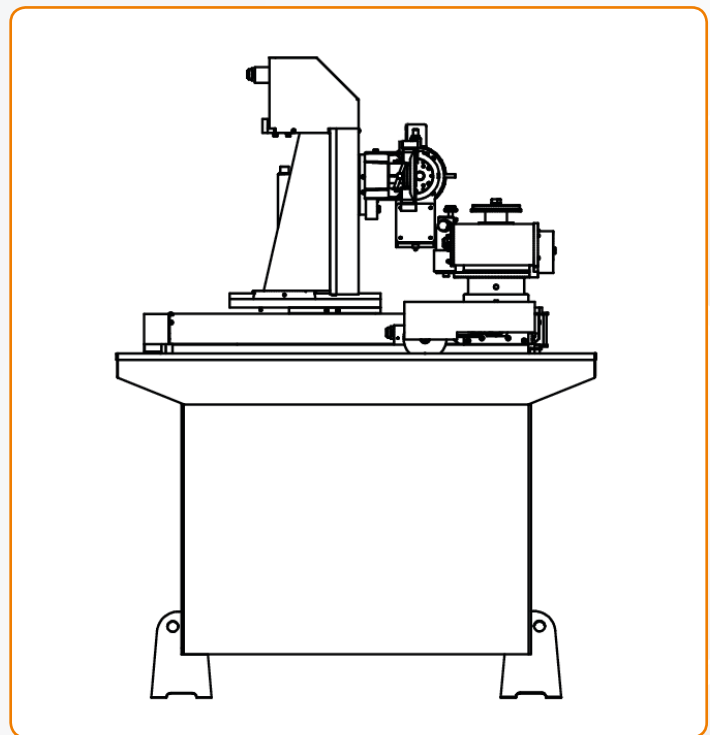
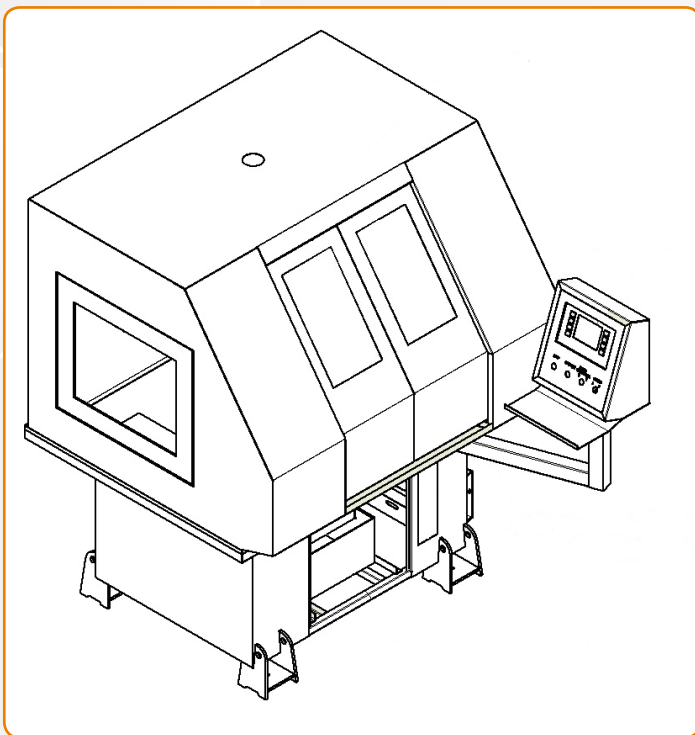
## Advantages

- 5 numerically controlled axes
- Electronically controlled tooth pitch
- Robust and compact design
- Programmable variable sharpening speeds
- Internal memory for saving saw parameters
- Sharpening and profiling metal cutting saws
- An intuitive control system for programming the necessary tool and operating parameters
- Programmable tooth combinations
- Using of support and pressure disks to stabilise the saw
- A self-aligning head for sharpening the top of the tooth in a single sharpening pass
- Using highest quality components
- Two-grinding-wheel system operation
- Fully enclosed design
- Chip breaker cutting
- Removal and cutting new teeth



## TECHNICAL DATA

External diameter of the sharpened saw	100 - 630 mm
The number of sharpened teeth	2 - 999
Incremental feed rate during sharpening	0,01 - 0,99 mm
The number of programmable sharpening passes	0 - 99
The speed of grinding	0,1 - 2 m/min
Rake angle	-10° do +30°
Clearance angle	+5° do +45°
Grinding wheel diameter	150 mm
Diameter of the fixing hole	40 mm
Installed power	2 kW
Coolant tank capacity	Approx. 40 litres
Weight	Approx. 550 kg
Dimensions	1540x1700x1800 mm



### Standard Components

- A stand with a booth
- Cooling system
- A set of reduction rings
- Supporting disks
- A set of wrenches
- A starting package (grinding wheel and coolant)

# Technologia ostrzenia



# Grinding Technology



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