

# iseli AS-2

## Heavy Duty automatic sharpening machine for circular saw blades

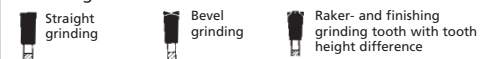


**Tooth by tooth  
for a fine faced tooth  
giving burr free finish.**



### Specification

- Electric Supply  
Voltage: 400 V 3 Ph. N  
Connected load: approx. 2 kW  
Grinding motor: 0,75 kW  
Drive motor: 0,25 kW
- Compressed air supply: 6 bar
- Machine for dry grinding:  
Circular saws 250 to 1000 mm dia
- Machine for dry grinding with baseframe:  
Circular saws 250 to 1600 mm dia
- Machine for wet grinding with fully closed protection hood:  
Circular saws: 250 to 1200 mm dia
- Bore dia: 22 to 210 mm
- Tooth pitch: 15 to 100 mm
- Tooth height: max. 40 mm
- Tooth shape: pointed tooth, hypoid tooth, rake tooth
- Grinding methods:



#### Standard machine

- Front face rake angle 10° to 30°
- Clearance angle tooth back 10° to 20°
- Bevel grinding tooth face 0° to 15°
- Bevel grinding tooth back 0° to 8°

#### Universal machine

- Front face rake angle 10° to 30°
- Clearance angle tooth back 10° to 20°
- Tooth face straight grinding only 0° to 15°
- Bevel grinding tooth back 0° to 15°
- Raker- and finishing tooth infinitely variable height adjustment 0,1 to 0,6 mm
- Chamfering 0° to 45°

#### Special features

- Powerful water cooling
- Infinitely variable feed speed
- Grinding wheel diameter 175 to 250 mm
- Grinding wheel bore 25 mm + 32 mm
- Packing:  
Dimension: 230/150x180 cm  
Weight: net 800 kg  
gross 1'100 kg

Subject to modification in design!

**SGS Zertifikat ISO 9001**



Control unit

**iseli**

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## Heavy duty automatic sharpening machine for circular saw blades

- A machine of extremely robust design, embodying state of the art technology, suitable for sharpening standard-type CV circular saw blades or special types such as stellite-tipped and carbide circular saw blades.
- The application of corundum grinding wheels allows sharpening of the complete tooth shape.
- When borazon grinding wheels are used on stellite-tipped saw blades, or diamond grinding wheels on carbide saw blades, only tooth face and back are ground. Grinding is carried out in one run for straight- and bevel-toothed circular saws.

### Standard machine

- Straight grinding tooth face and back.
- Straight grinding tooth face, bevel grinding tooth back.
- Bevel grinding tooth face and back.

### Universal machine

- The tooth face receives straight grinding only. (no bevel grinding).
- Straight grinding tooth face and back.
- Straight grinding tooth face, bevel grinding tooth back. Grinding of saw blades with raking- and finishing teeth can be adjusted by tooth height difference. Chamfering up to 45°.

### Special features

- Robust steel design.
- Mechanism and grinding head guides with tempered shafts and ball bush bearings (minimum maintenance, no greasing points).
- Feed speed regulator with frequency converter, 4 speeds can be programmed selectively for the complete tooth shape.
- Modern, selective programme control for neatly arranged; easily operated elements.
- Pneumatically operated two-pressure blade clamping facility, high pressure for tooth face grinding, low pressure for tooth back grinding in order to facilitate broaching cutter run.

- Pneumatic bevel grinding, special alternating bevel grinding, grinding head adjustment for chamfering to 45°
- Option: Automatic grinding wheel feed down including totalizer for the number of teeth sharpened and automatic stop.
- Machine available with dry grinding or with powerful water cooling system.
- When CBN- or diamond grinding wheels are used, the water cooling with fully closed protection hood is compulsory.

Rely on ISELI for precision-made quality machines from Switzerland!

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