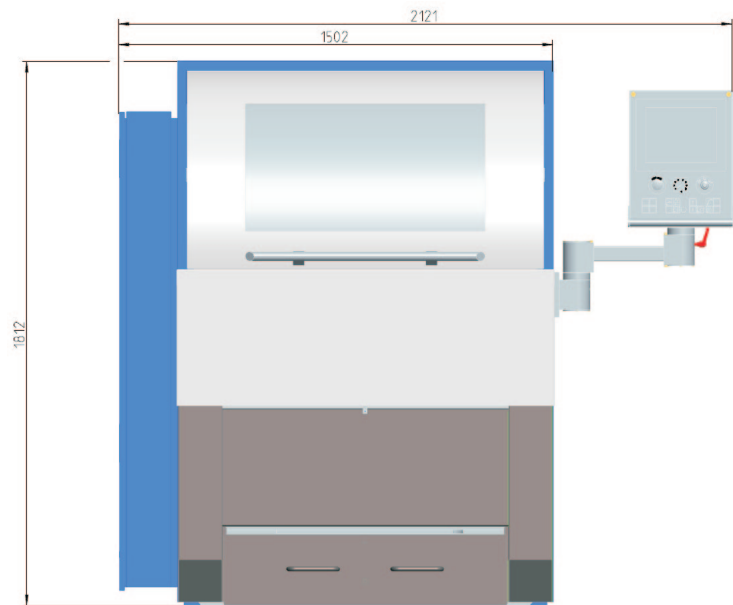


# em 300



Neat grouping of compact elements.

Conception and design of the machine are very operator friendly.

## Specifications

Tooth pitch 15 - 100 (4 ``)  
Flank clearance angle Tooth face 0-7 °  
Flank clearance angle Tooth back 0-7 °

Tooth shapes selectively  
Tooth face angle 0° - 35 °  
Tooth back angle 0° - 25 °

Feed speed 10 Z/min  
Cup grinding wheel Ø 100 or 125 mm  
Bore Ø 20 mm  
Peripheral speed of grinding-wheel by frequency 30 - 60 m/sec

### Band saw blades

Blade widths standard 70 - 350 mm  
Blade widths optional 25 - 350 mm

### Circular saw blades

Blade diameter 180 - 800 mm

### Frame saw blades

Toothed length bis 1500 mm  
Blade width 75 - 180 mm

Standard voltage 400 V, 3Ph, N

Connected load of feeder 10 A  
Grinding motors (2) 1.5 kW  
Cooling agent pump 0.65 kW  
Feed motors (3) 4.00 NM  
Advance motors (2) 0.90 NM

Weight of machine 1600 kg  
Packing seaworthy 240/160x190 cm  
Gross-weight 1850 kg

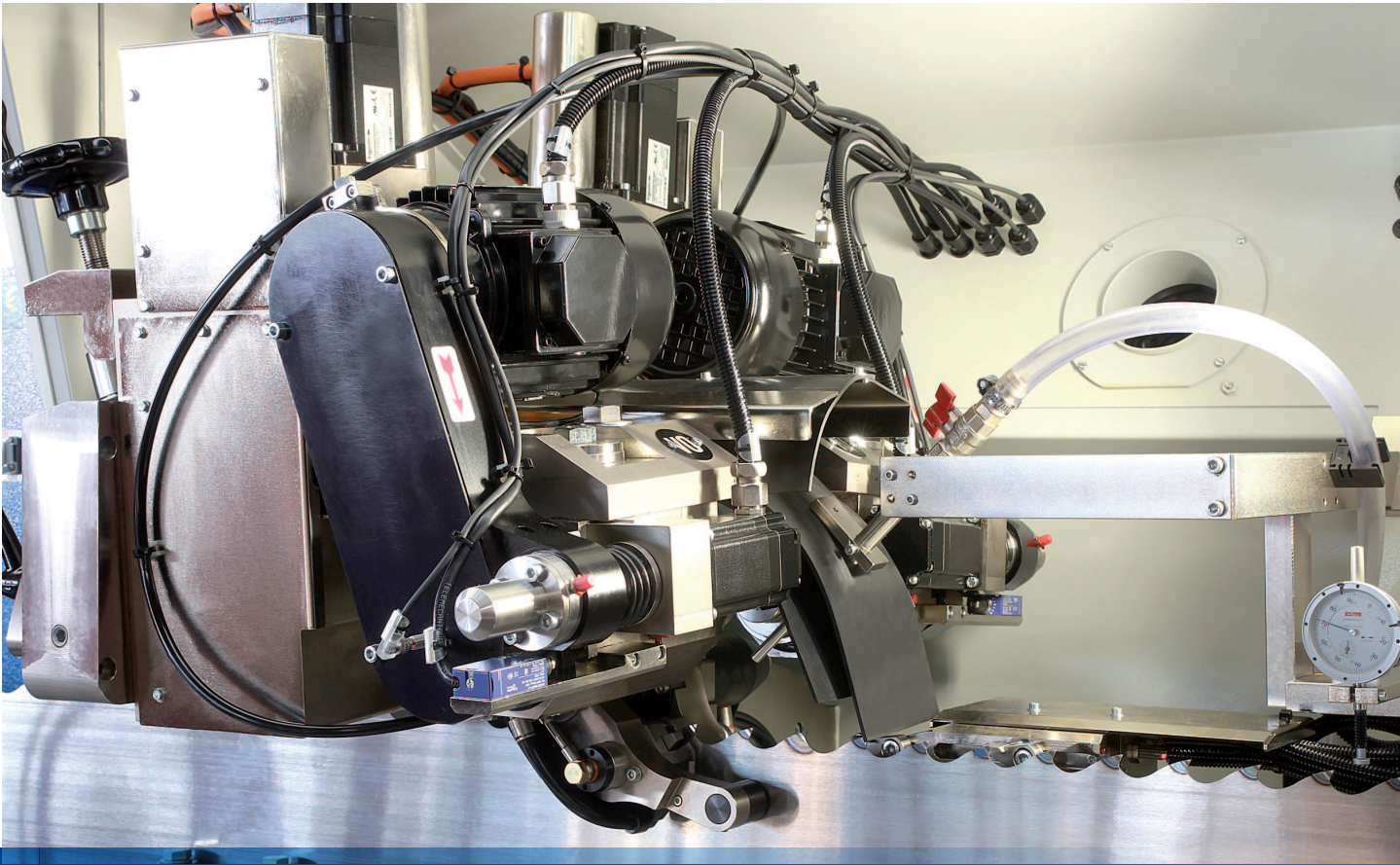
Subject to alteration in design for technical advancement.



Certificate ISO 9001:2002

# iseli em 300

Fully automatic CNC controlled side-grinding machine for band-, circular- and frame saw blades



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



ISELI & Co. AG  
Luzernerstraße 31  
CH-6247 Schötz

MASCHINENFABRIK  
Telefon 041 984 00 60  
Telefax 041 984 00 66

SWITZERLAND  
office@iseli-swiss.com  
www.iseli-swiss.com



## Our strength: Productive solutions with highest accuracy

For more than half a century the ISELI brand has stood for quality Swiss precision and excellent service to customers.

Tool grinding lies at the heart of the economic viability of modern grinding shops and sawmills. Today's sawmills, grinding shops and saw blade manufacturers expect reliability and the highest quality when undertaking saw blade maintenance.

ISELI machines are at the forefront of design technology with ease of maintenance and operation built in. We provide an outstanding range of solutions and accessories designed using our unique experience and know-how of mechanical engineering and software development. We can supply individual constructions and custom-tailored solutions.

We at ISELI offer an excellent after-sale service to support our customers and can supply 95% of original spare-parts from stock.

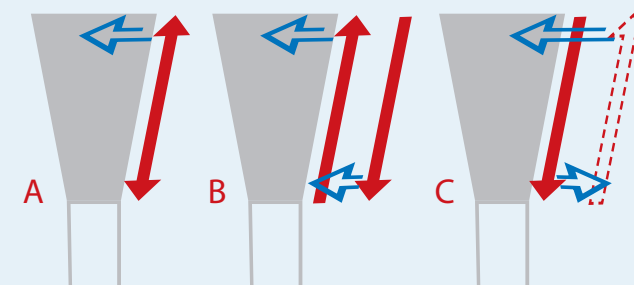
## The most important features

- Fulfilling the highest requirements of side-grinding accuracy.
- We offer a CNC technology allowing unlimited possibilities for sharpening the flanks of the saw tooth, dual side-grinding
- Operation of the machine by use of a touch screen monitor
- Conception and design of the machine are very operator friendly
- The machine is equipped with 6-axis control unit
- Variable tooth heights and tooth pitches can be ground by means of special programmes (options)
- Auxiliary pneumatic saw blade clamping for stabilization of thin teeth during grinding, resulting in higher dimensional accuracy
- The application of CBN grinding-wheels for stellite-tipped circular saw blades or Diamond grinding-wheels for carbide-tipped circular saw blades results in an absolutely smooth surface
- Minimum wear of grinding wheels and much reduced grinding times
- Very short adjusting operations because the tooth positions remains the same for all types of saw blades
- Powerful water cooling with fully closed protection hood
- Built-in adjustment by electric motor
- The grinding-wheel peripheral speed can be adjusted by frequency converter
- The latest CE-regulations are completely observed. The electrical equipment corresponds with IEC-204-1 standards



## Sharpening programmes

The positioned saw tooth can be ground to the required tolerance measurement by means of several feeds of the grinding wheel.



- A** Grinding-wheel feed is at the top. This process can be repeated several times
- B** Grinding-wheel feed is at the top and at the bottom what results in 2, 4 or 6 feeds
- C** Grinding-wheel feed is at the top. At the bottom, the grinding-wheel is moved back. The grinding head goes quickly upwards and the feed is again activated. This process can be repeated several times.
- The grinding depth and grinding speed can be programmed individually.