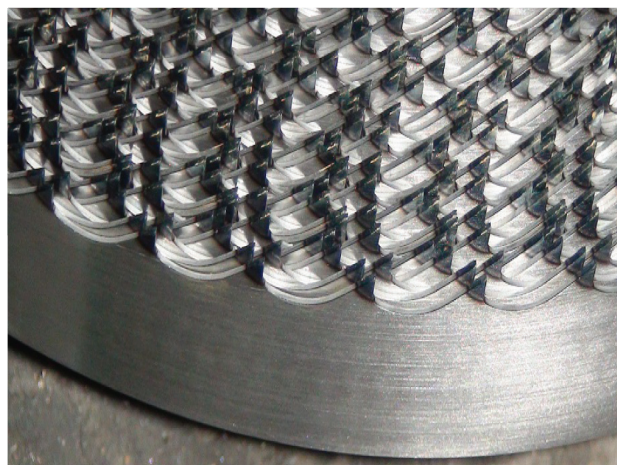
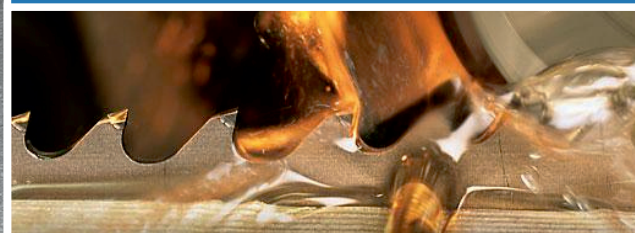


CATALOG



EQUIPMENT AND TOOLS FOR WOOD INDUSTRY



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BAND SAW - HAMMER

Specification:

- Material: natural wood
- Utilization: cutting of natural wood
- Machine: band sawmill for logs
- Profile: 10/30



HAMMER bandsaw is made of high quality German steel which allows us to give the saw blade strength and flexibility simultaneously. Unlike others band saw HAMMER can withstand twice the load.

Under the right conditions bandsaw HAMMER shows the result of cutting wood of 60 cbm (cubic meters). It is possible to deliver band saw blades toothed, set, sharpened, hardened. Band saw blades are delivered in coils as well as in length welded loops on order for a particular type of the machine, material hardness 45-47 HRC (hardness of hardened teeth 57 HRC).

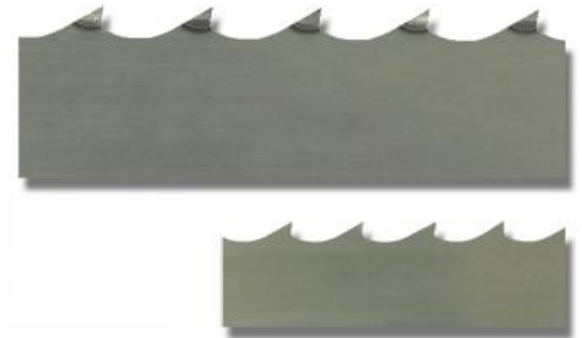
Type of band saw:	H x S [mm]:
Band saws METALDRAFT Hammer	35x1,07
Band saws METALDRAFT Hammer	35x1,10
Band saws METALDRAFT Hammer	38x1,07
Band saws METALDRAFT Hammer	38x1,10
Band saws METALDRAFT Hammer	50x1,07
Band saws METALDRAFT Hammer	50x1,10



BAND SAW - METALDRAFT PR

Specification:

- Material: natural wood
- Utilization: cutting of natural wood
- Machine: band sawmill for logs
- Profile: 10/30



METALDRAFT PR is made of high quality German steel which allows us to give the saw blade strength and flexibility simultaneously. Unlike others band saw METALDRAFT PR can withstand twice the load.

Under the right conditions bandsaw METALDRAFT PR shows the result of cutting wood of 45 cbm (cubic meters). It is possible to deliver band saw blades toothed, set, sharpened, hardened. Band saw blades are delivered in coils as well as in length welded loops on order for a particular type of the machine, material hardness 42-45 HRC (hardness of hardened teeth 52 HRC).

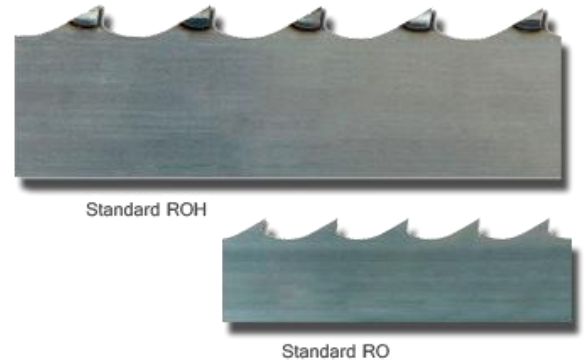
Type of band saw:	H x S [mm]:
Band saws METALDRAFT Pr	35x0,9
Band saws METALDRAFT Pr	35x1,0
Band saws METALDRAFT Pr	35x1,1
Band saws METALDRAFT Pr	38x1,15
Band saws METALDRAFT Pr	40x1,0
Band saws METALDRAFT Pr	40x1,1
Band saws METALDRAFT Pr	50x1,0



BAND SAW - METALDRAFT ST

Specification:

- Material: natural wood
- Utilization: cutting of natural wood
- Machine: band sawmill for logs
- Profile: 10/30



METALDRAFT ST is made of high quality German steel which allows us to give the saw blade strength and flexibility simultaneously. Unlike others band saw **METALDRAFT PR** can withstand twice the load.

It is possible to deliver band saw blades toothed, set, sharpened, hardened. Band saw blades are delivered in coils as well as in length welded loops on order for a particular type of the machine, material - 75 Ch1 steel with hardness of 42-45 HRC (hardness of hardened teeth 52 HRC).

Type of band saw:	H x S [mm]:
Band saws METALDRAFT St	35x0,9
Band saws METALDRAFT St	35x1,0
Band saws METALDRAFT St	35x1,1
Band saws METALDRAFT St	38x1,15
Band saws METALDRAFT St	40x1,0
Band saws METALDRAFT St	40x1,1
Band saws METALDRAFT St	50x1,0



BAND SAW - JOINER

Specification:

- Material: natural wood
- Utilization: cutting in the joinery workshops
- Machine: carpenters band saws



Joiner

JOINER is the narrow band saw (fretsaw) which made of high quality German steel which allows us to give the saw blade strength and flexibility simultaneously. Unlike others band saw JOINER can withstand twice the load.

It is possible to deliver band saw blades toothed, set, sharpened, hardened. Band saw blades are delivered in coils as well as in length welded loops on order for a particular type of the machine, material hardness 41-46 HRC (hardness of hardened teeth 62-65 HRC).

Type of band saw (fretsaw):	H x S [mm]:
Narrow band saw JOINER METALDRAFT	10 x 0,6 x 6,3
Narrow band saw JOINER METALDRAFT	15 x 0,7 x 6,3

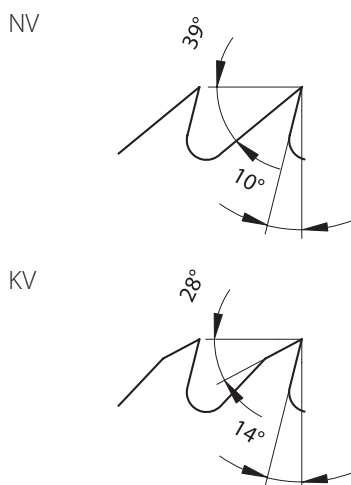
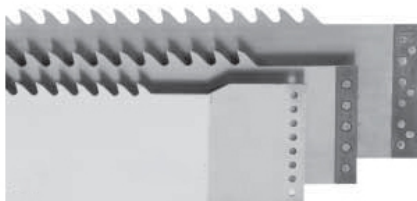


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FRAME SAWS FOR WOODWORKING MACHINES

Machine Gang Saw Blades for Rip Cutting



Machine Gang Saw Blades Tempered



5360.1 (KV) – Wolf Type of Teeth 5360.01 (NV) – Triangular Type of Teeth

Usage: For cutting soft and hard woods.

While cutting with wolf teeth geometry you can reach more precise geometrical accuracy of cutting material.

While cutting with triangular tooth geometry you can reach better surface quality – suitable for small diameter of logs.

Modification: Machine gang saw blades are delivered in straightened and tensioned stage.

Termination: Standard gang saw blades are delivered with hardened guide gibs of 35, 30, 25 mm width, with straight punching (Esterer hanges) and also blades without guide gibs.

Dimensions (mm)	Tooth pitch
140 x 1,8	22, 25, 26, 30
140 x 2,0	
140 x 2,2	
160 x 2,0	
160 x 2,2	
180 x 2,2	
180 x 2,4	

Gang saw blades are manufactured from material 75Cr1 (DIN 1.2003) with hardness 48 +/- 2Hrc. We can also produce gang saws coated with hard-chrome (surface of 10, 15 and 20microns). Hardchrome surface improves the resistance against tool wear and does not tend to slow down when in contact with steel. It is also resistant against high temperatures and protects against rust.

We are able to manufacture also other types of toothing (tooth pitch, shape) together with other types of guide gibs and pinholes on the request of our customers.

5362.1 (KV) – Wolf Type of Teeth

Usage:

For cutting hard and soft woods.

Tampered gang saw is more efficient then the one with set teeth.

Its advantage is a better stability of the tool, possibility to increase the feed speed and removing half size of chip when comparing with tooth set gang saw.

Modification: Machine gang saw blades are delivered in straightened and tensioned stage.

Termination: Standard gang saw blades are delivered with hardened guide gibs of 35, 30, 25 mm width, with straight punching (Esterer hanges) and also blades without guide gibs.

Dimensions (mm)	Tooth pitch
140 x 2,2	22, 25, 26, 30
160 x 2,2	
180 x 2,2	

Gang saw blades are manufactured from material 75Cr1 (DIN 1.2003) with hardness 42 +/- 2Hrc. We are able to manufacture also other types of toothing (tooth pitch, shape) together with other types of guide gibs and pinholes on the request of our customers.

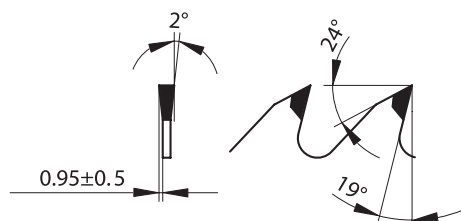
Machine Gang Saw Blades Stellite Tipped

5366.1 (KV) – Wolf Type of Teeth

Usage: Hard and soft woods. It is needed to know while ordering.

Modification: Gang saw blades are delivered straightened and tensioned.

Termination: Standard gang saw blades are delivered with hardened guide gibs of 35, 30, 25 mm width, with straight punching (Esterer hanges) and also blades without guide gibs.



Dimensions (mm)	Tooth pitch
140 x 1,8	22, 25, 26, 30
140 x 2,0	
140 x 2,2	
160 x 2,0	
160 x 2,2	
180 x 2,2	
180 x 2,4	

Gang saw blades are manufactured from material 75Cr1 (DIN 1.2003) with hardness 48 +/- 2Hrc. Welding and stellite grinding is performed on Vollmer machines.

Main advantages of stellite-tipped gang saws:

1. Long life – time of tips (5 – 10 x more than normal version).
2. Lower energy intensiveness while cutting.
3. Lower tendency to tip damage due to dirt (compared TCT tools).
4. Higher surface quality of cutting material.
5. Higher dimensional and formal accuracy of cutting material.
6. Possibility to adjust tip geometry to particular cutting conditions (machine type, type of cutting material, cutting conditions etc.).
7. Due to higher cutting power enable lower thermal cutting stress of tip.
8. Possibility to re-tip the tool after grinding off the whole layer of previous welding (after 15 – 20 sharpening).
9. Minimizing the stand-time when changing the dull tools in machines.
10. Increasing the cutting performance by faster feed speed when tampered gang saws are replaced with stellite – tipped.

Gang saw blades are manufactured with tooth number and side finish according to our general types or to customer's requirements.

We are able to manufacture also other types of toothing (tooth pitch, shape) together with other types of guide gibs and pinholes on the request of our customers.

We can provide service of all gang saw blades with tooth pitch 26 and 30 mm.



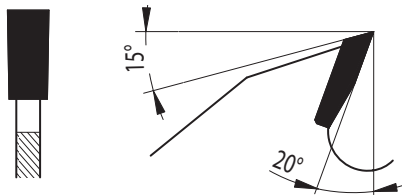
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CIRCULAR SAWS FOR WOODWORKING MACHINES

TCT Circular Saw Blades for Multi-rip Machines

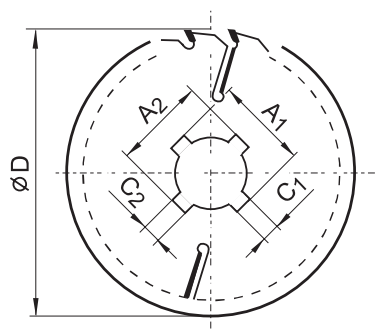
Material:	natural solid – longitudinal cuts of soft and hard wood
Usage:	multi-rip sawing of massive natural woods
Machine:	multi-rip saw, for single shaft, double shaft and splitting machine



5394 FZ

Characteristics:

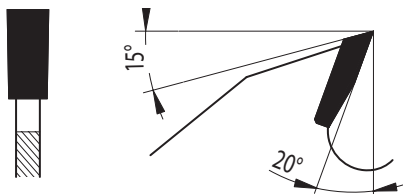
- » universal rip saw blades for longitudinal cutting of all types of wood, dry and wet, with a standard quality of the cutting edge and a lower height of the cut
- » usage: for multi-rip machines for primary processing of wood and pallet production



D	B	b	d	z	C ₁ x A ₁	C ₂ x A ₂	h _{max}	d _{p max}
250	3,6	2,5	70	16+2	13x80	20x83	50	130
250	3,6	2,5	80	16+2	14x90	22x93	50	130
300	4,0	2,8	70	18+2	13x80	20x83	70	130
300	4,0	2,8	80	18+2	14x90	22x93	70	130
315	4,0	2,8	80	18+2	14x90	22x93	80	130
350	4,0	2,8	70	20+2	13x80	20x83	100	135
350	4,0	2,8	75	20+2	13x80	20x83	100	135
350	4,0	2,8	80	20+2	14x90	22x93	100	135
400	4,0	2,8	70	24+2	13x80	20x83	110	185
400	4,0	2,8	80	24+2	14x90	22x93	110	185

D – blade diameter [mm], S – tooth width [mm], s – body thickness [mm], d – bore [mm], z – number of teeth, Hmax – maximum cut height [mm], dp max – max. bore diameter [mm]

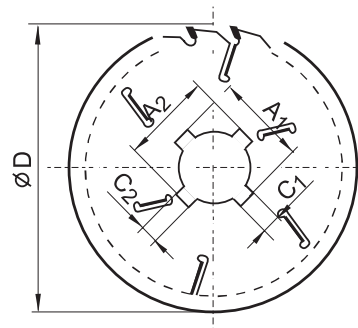
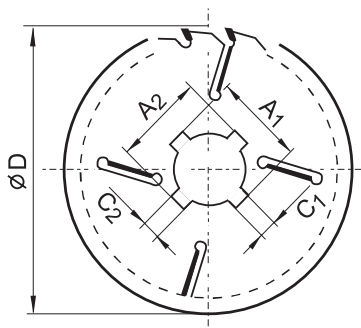
TCT Circular Saw Blades for Multi-rip Machines



5394.1 FZ

Characteristics:

- » universal rip saw blades for longitudinal cutting of all types of wood, dry and wet, with a standard quality of the cutting edge
- » usage: for multirip machines for primary processing of wood and pallet production



D	B	b	d	z	C ₁ x A ₁	C ₂ x A ₂	h _{max}	d _{pmax}
250	3,2	2,2	70	16+4	13 x 80	20 x 83	60	110
250	3,2	2,2	80	16+4	14 x 90	22 x 93	60	110
300	3,2	2,2	70	18+4	13 x 80	20 x 83	75	125
300	3,2	2,2	80	18+4	14 x 90	22 x 93	75	125
315	3,2	2,2	70	18+4	13 x 80	20 x 83	80	130
315	3,2	2,2	80	18+4	14 x 90	22 x 93	80	130
350	3,6	2,5	70	20+4	13 x 80	20 x 83	100	125
350	3,6	2,5	75	20+4	13 x 80	20 x 83	100	125
350	3,6	2,5	80	20+4	14 x 90	22 x 93	100	125
315	4,0	2,8	80	18+4	14 x 90	22 x 93	80	130
350	4,0	2,8	70	20+4	13 x 80	20 x 83	100	125
350	4,0	2,8	75	20+4	13 x 80	20 x 83	100	125
350	4,0	2,8	80	20+4	14 x 90	22 x 93	100	125
400	4,0	2,8	30	18+4			120	155
400	4,0	2,8	70	24+4	13 x 80	20 x 83	120	155
400	4,0	2,8	80	24+4	14 x 90	22 x 93	120	155
400	4,2	3,0	30	20+4			155	120
450	4,4	3,2	30	20+4			140	170
450	4,4	3,2	70	28+4	13 x 80	20 x 83	140	170
450	4,4	3,2	80	28+4	14 x 90	22 x 93	140	170
450	5,0	3,5	30	20+4			170	140
500	4,4	3,2	30	22+4			150	195
500	4,4	3,2	70	28+4	13 x 80	20 x 83	150	195
500	5,0	3,5	30	22+6			125	160
300	3,2	2,2	30	24+4			75	120
350	3,6	2,5	30	24+4			80	140
400	4,2	2,8	80	24+6	14 x 90	22 x 93	120	125
450	4,4	3,2	30	20+6			140	130
450	4,4	3,2	80	28+6	14 x 90	22 x 93	140	130
500	4,4	3,2	30	22+6			150	125
500	4,4	3,2	80	28+6	14 x 90	22 x 93	150	125
550	5,0	3,5	30	24+6			160	175
550	5,0	3,5	30	32+6			160	175
550	5,5	3,5	30	24+6			175	160
600	5,0	3,5	30	26+6			180	195
600	5,0	3,5	30	34+6			180	195

D – blade diameter [mm], S – tooth width [mm], s – body thickness [mm], d – bore [mm], z – number of teeth,
Hmax – maximum cut height [mm], dp max – max. bore diameter [mm]



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CIRCULAR SAWS FOR WOODWORKING MACHINES

TCT Circular Saw Blades for Multi-rip Machines



5394.2 LFZ

Characteristics:

- » longitudinal cuts of soft and hard woods
- » trimming saw, multi – rip, joining saw
- » saw blade geometry includes a chip thickness limiter

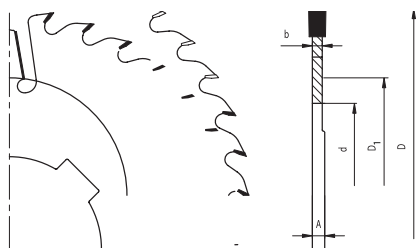
D	B	b	d	z	h _{max}	d _{p max}
250	3,2	2,2	30	18+3	60	115
300	3,2	2,2	30	18+3	75	130
350	3,6	2,5	30	20+4	100	105
400	4,0	2,8	30	24+4	120	120



5394.3 FZ

Installed on the one side multirip saw blades.

Multirip saw blades with reinforced hull in the flange area can be manufactured on order.



D – blade diameter [mm], S – tooth width [mm], s – body thickness [mm], d – bore [mm], z – number of teeth,
Hmax – maximum cut height [mm], dp max – max. bore diameter [mm]



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CIRCULAR SAWS FOR WOODWORKING MACHINES

TCT Saw Blades HANIBAL

Material:	massive natural wood
Usage:	cutting woods of massive dimension
Machine:	machine feed

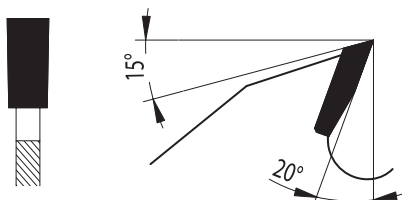
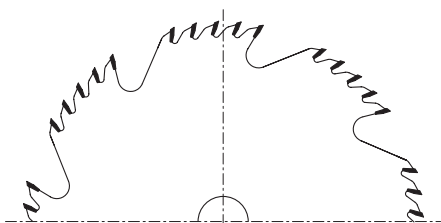


5333.1 FZ

Characteristics:

- » longitudinal cuts of massive wood dimensions
- » machine feed

D	B	b	d	z
600	5,5	3,5	30	40
700	5,5	3,5	35	40
800	6,5	4,5	35	40



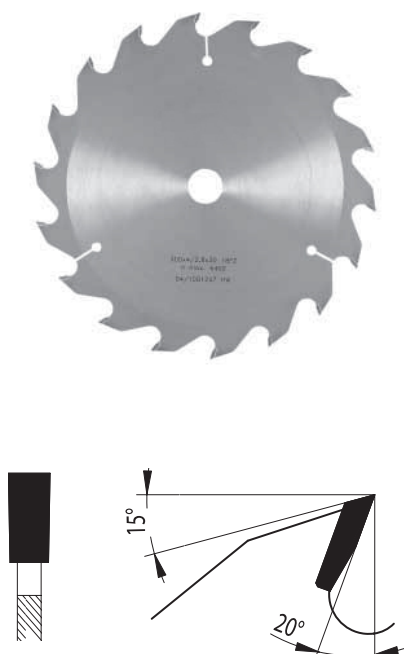
TCT Saw Blades for Wood Cutting

Material:	natural woods–soft, hard, wet
Usage:	cutting along and across the grain of natural massive wood

5380–50 FZ

Characteristic:

- » cutting along the grain of natural massive wood
- » suitable for prismatic beam saws

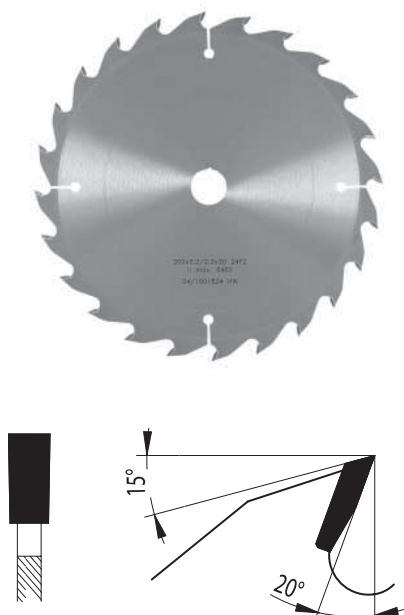


D	B	b	d	z
300	4,0	2,8	30	18
350	4,0	2,8	30	20
400	4,4	3,2	30	24
450	4,4	3,2	30	28
500	5,2	3,5	30	30
550	5,5	3,5	30	32
600	5,5	3,5	30	36

5380–40 FZ

Characteristics:

- » cutting along the grain of natural massive wood



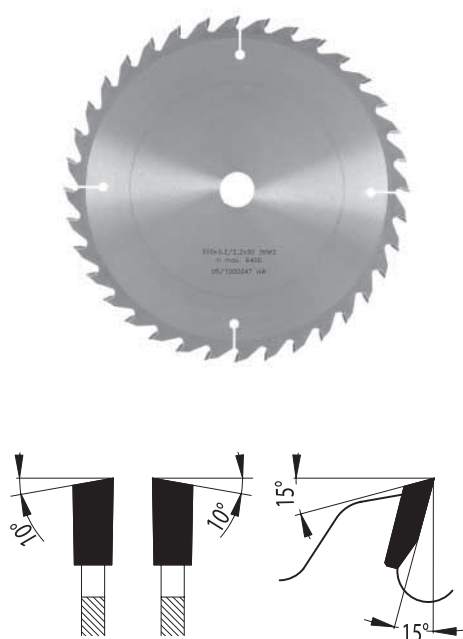
D	B	b	d	z
200	2,5	1,6	20	16
250	3,2	2,2	30	20
300	3,2	2,2	30	24
350	3,6	2,5	30	28
400	3,6	2,5	30	32
450	4,0	2,8	30	36
500	4,0	2,8	30	40
600	5,5	3,5	30	48
700	5,5	3,5	35	56

TCT Saw Blades for Wood Cutting

5381-26 WZ

Usage:

- » cutting along and across the grain of natural massive wood
- » cutting plywood, chip-board, wood – base panels

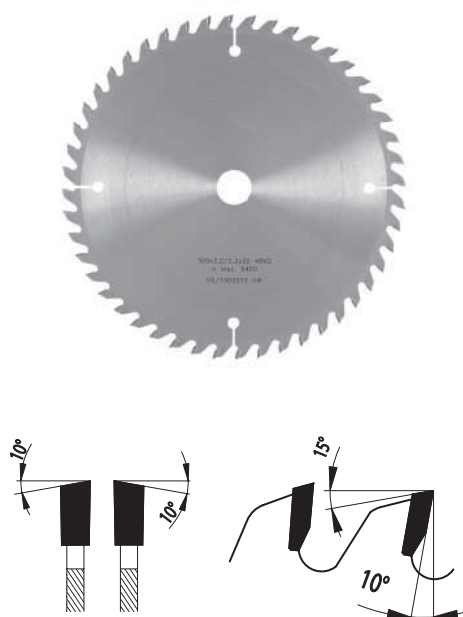


D	B	b	d	z
160	2,5	1,6	20	16
180	2,5	1,6	20	20
200	2,5	1,6	20	24
250	3,2	2,2	30	32
300	3,2	2,2	30	36
350	3,6	2,2	30	40
400	3,6	2,2	30	48
450	4,0	2,8	30	56
500	4,0	2,8	30	64

5381-20 WZ

Usage:

- » cutting across the grain of natural massive wood
- » cutting of laminated paper and laminated textiles, thermoplastics



D	B	b	d	z
160	2,5	1,6	20	24
180	2,5	1,6	20	28
200	2,5	1,6	20	32
250	3,2	2,2	30	40
300	3,2	2,2	30	48
315	3,2	2,2	30	48
350	3,6	2,5	30	54
400	3,6	2,5	30	64
450	4,0	2,8	30	72
500	4,0	2,8	30	84
600	5,2	3,5	30	90



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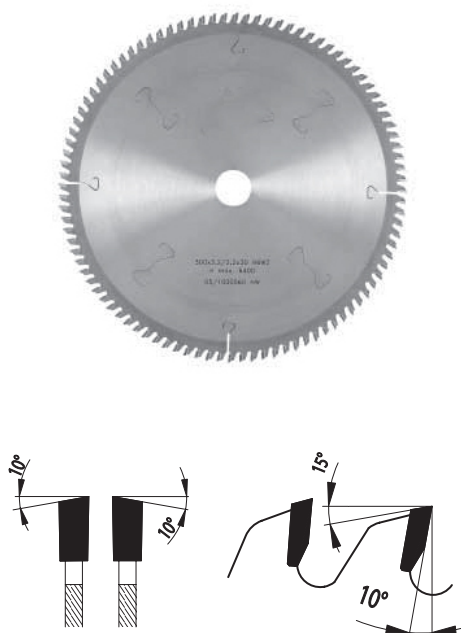
CIRCULAR SAWS FOR WOODWORKING MACHINES

TCT Saw Blades for Wood Cutting

5381-16 WZ

Usage:

» cutting across the grain of natural wood

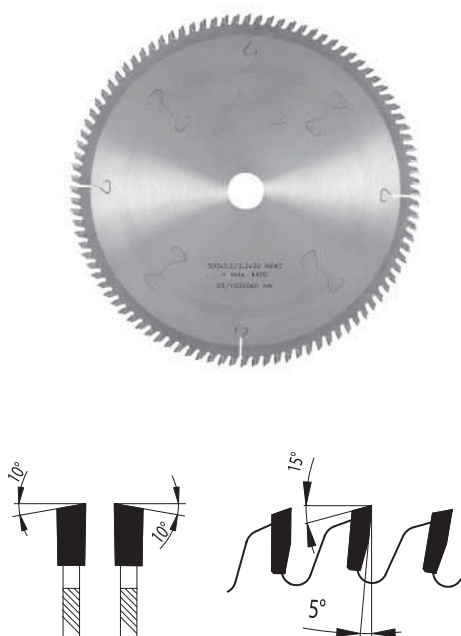


D	B	b	d	z
180	2,5	1,6	20	36
200	2,5	1,6	20	40
250	3,2	2,2	30	48
300	3,2	2,2	30	64
350	3,6	2,5	30	72
400	3,6	2,5	30	84

5381-13 WZ

Usage:

» cutting across the grain of natural wood



D	B	b	d	z
160	2,5	1,6	20	36
200	2,5	1,6	20	48
250	3,2	2,2	30	60
250	3,2	2,2	30	64
260	2,6	1,8	30	60
300	3,2	2,2	30	72
350	3,6	2,5	30	84
400	3,6	2,5	30	96

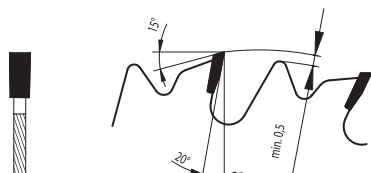
D – диаметр диска [мм], B – ширина зуба [мм], b – толщина корпуса [мм], d – диаметр крепёжного отверстия [мм], z – количество зубьев

TCT Saw Blades for Wood Cutting

5383-55 LFZ

Usage:

- » longitudinal cutting of natural massive wood
- » single blade machines without machine feed
- » saw blade geometry includes a chip thickness limiter

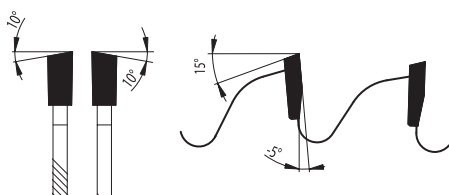


D	B	b	d	z
300	3,6	2,5	30	18
350	4,0	2,8	30	20
400	4,0	2,8	30	24
600	4,2	2,8	30	36
700	4,4	3,2	30	44

5381 WZ N

Usage:

- » trimming
- » swinging cross-cut saw, radial saw with manual feed
- » negative hook angle enables fluent cutting start



D	B	b	d	z
210	2,8	1,8	30	48
210	2,8	1,8	30	60
216	2,8	1,8	30	48
216	2,8	1,8	30	60
216	2,8	1,8	30	80
250	2,8	1,8	30	48
250	2,8	1,8	30	60
250	2,8	1,8	30	80



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CIRCULAR SAWS FOR WOODWORKING MACHINES

Panel Sizing TCT Saw Blades

Material:	exotic woods, hard woods, laminated chip-boards
Usage:	laminated boards
Machine	panel sizing machines

5397-11 TFZ L

Usage:

- » cutting of laminated boards
- » quality cut is reached when used in combination with split scorer

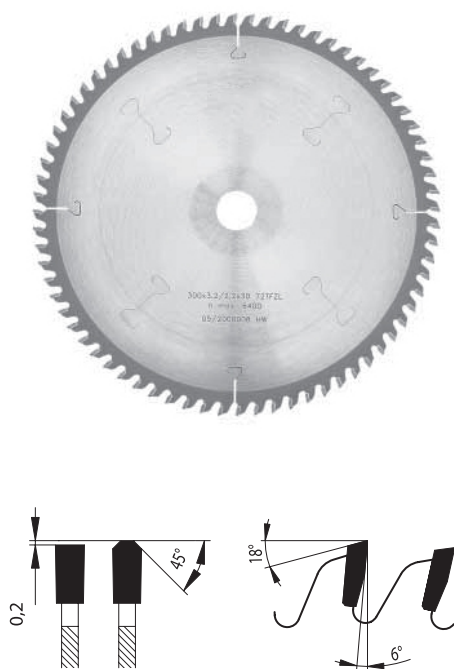


D	B	b	d	z
200	3,2	2,2	30	64
250	3,2	2,2	30	80
300	3,2	2,2	30	96
350	3,6	2,5	30	108

5397-13 TFZ L

Usage:

- » cutting of laminated chip-boards



D	B	b	d	z
250	3,2	2,2	30	60
300	3,2	2,2	30	72

Grooving TCT Saw Blades

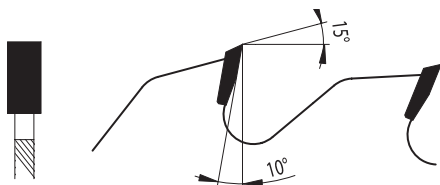
Material: natural wood, chip-boards, plastics

Usage: grooving

5392 FZ

Usage:

» grooving all types of natural wood, furniture materials, plastics



D	B	b	d	z
150	3,5	2,5	30	12
150	4,0	2,5	30	12
150	5,0	3,5	30	12
150	6,0	3,5	30	12
180	4,0	2,5	30	16
180	5,0	3,5	30	16
180	6,0	3,5	30	16
200	4,0	2,5	30	32
200	5,0	3,5	30	32

5396 WZ

Usage:

» grooving of various widths in wood
» saw blades for wobble saws

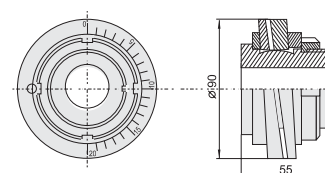
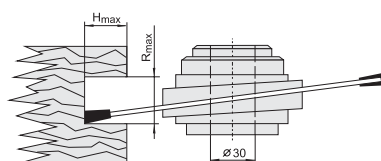


D	B	b	R _{max}	H _{max}	d	z
200	3,2	2,2	15	50	50	32
250	3,6	2,5	20	70	50	40
300	3,6	2,5	22	100	50	48

5748 Clamping bushes

Characteristics:

» clamping bush is made of steel, size of required cutting width is possible to adjust fluently with skew symmetric plates and matrix





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CIRCULAR SAWS FOR WOODWORKING MACHINES

Heat Treatment TCT Saw Blades and Segments



Usage: for cutting of materials under extreme load

Machine: primarily for the longitudinal cutting machines

Usage:

- » thermal treatment of saw blades made on special customer request
- » prevents the occurrence of cracks and tears in the body of the saw blade due to extreme loads during cutting operation
- » increases the lifespan of the saw blade

Surface Treatment TCT Saw Blades and Segments



Usage: for cutting materials with a high content of tar and other contaminants

Machine: dividing machine, trimming machine

Characteristics:

- » increases the saw blade lifespan by 20% compared to untreated TCT saw blade
- » treatment of saw blades made on special customer request
- » a thin chemical layer of black colour on the saw blade surface



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KNIVES FOR RING FLAKERS

Materials: high alloy steel and special resistant flaker steel for knives and parts

Use: starting operation for two-stage or single-stage manufacture of chips for particleboard production

Machine: ring flakers of brands Pallmann, Maier, Klöckner, Pessa, Goos, Bezner etc.

Characteristics:

» hardness usually 54–57 HRC or according to customers request and type of processed wood

» heat treatment proceeded in a computer-controlled furnaces

» angle of cutting edge 35°–44°



knife holder plate



flaker knife



flaker knife



wear shoe



wear shoe



pressure bar



counter knife holder



protection plate



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KNIVES FOR RING FLAKERS HOMBAK / PESSA



flaker knife



flaker knife

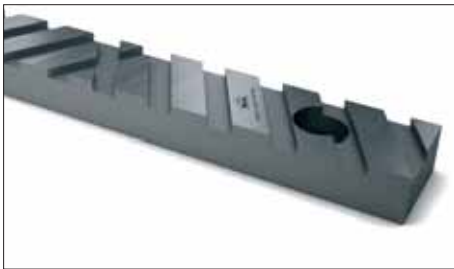
Material for knives: high alloy steel and special resistant flaker steel for knives and parts

Refining and Hammer Mills

Materials: high alloy hardened steel for stator segments in refining mills, Hardox steel for hammers

Use: fine milling of wooden chips for upper and bottom layer in particleboard

Machine: usually Pallmann PSKM, hammer mill



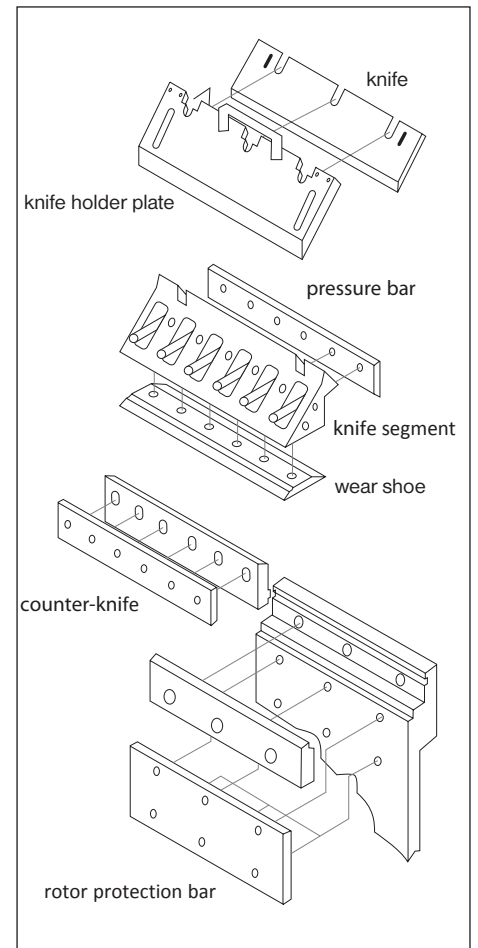
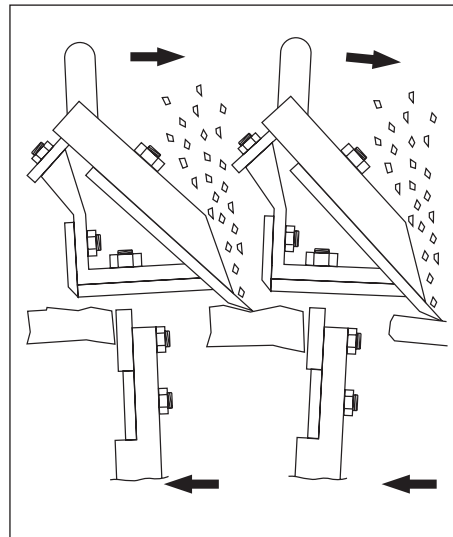
milling segment



milling plate



hammer





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KNIVES FOR OSB STRANDERS

Materials: high alloy steel for knives and parts

Usage: primary process of OSB production – specific sized wooden chips being cutted from debarked logs

Machine: ring and drum stranders of brands Pallmann, CAE

Characteristics:

- » hardness usually 55–58 HRC or according to customers request and type of processed wood
- » winter and summer version, passivated upper layer for better wear resistance
- » heat treatment proceeded in a computer-controlled furnaces
- » angle of cutting edge 28°–31°



flaker knife



flaker knife



counter knife

Chipper knives and counter knives for manufacturing of chips, wood dusts and chip-boards

Material: high alloy steel specially developed for chipper knives

Use: primary process of MDF and Particleboard production, wooden logs or waste are being cutted into small chips in drum or disk chippers of brands Pallmann, Brucks-Klößner, Maier, Ferrari, Kone-Wood, Pessa, Rudnick, æcoplan etc.

Characteristics:

- » hardness usually 52–57 HRC or according to customers request and type of processed wood
- » heat treatment proceeded in a computer-controlled furnaces
- » angle of cutting edge 25°–32°, eventually counter-edge » knife thickness usually 20 or 25 mm



chipper knife



chipper knife



counter knife of chipper knife



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GRINDING WHEELS

GRINDING ABRASIVE WHEELS

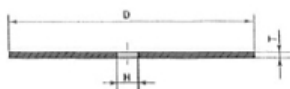


Unreinforced grinding wheels are used for all types of metal grinding; weld cleaning, for cleaning of surfaces after casting and rolling, burrs cleaning, cutting of grooves and for treatment of half-closed surfaces.

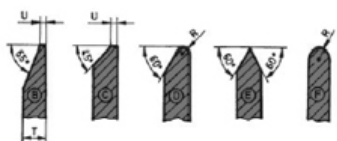
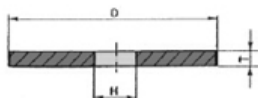
They are used with angle grinders and cutting machines. The circles are made of electrocorundum. Working speed is up to 80 m/sec.

Dimensions [m]:	Description:
100x50x20	UNREINFORCED GRINDING WHEELS ARE MADE OF SYNTHETIC ABRASIVES WITH BINDER OF SYNTHETIC RESIN
125x6x12,7	
150X6X32	
175x6x32	
200x6/3/3x32	
250x10x32	
250x10x35	

Type 1 T



Type 1



U = T/4 U = T/4 R = 0,3 T R = 0,5 T



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GRINDING WHEELS

FOR SHARPENING OF BAND SAWS

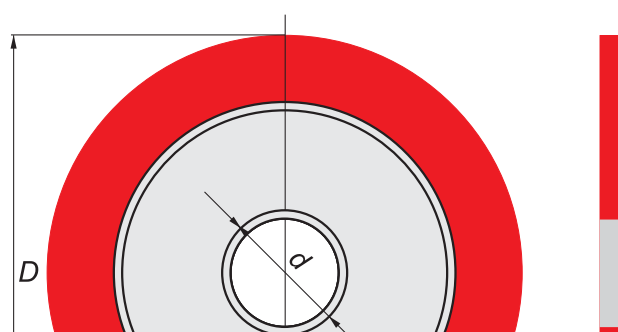
product's name	D x d x s (mm)
abrasive disk ANDRE	127 x 12.7 x 6
abrasive disk ANDRE	150 x 20 x 6
abrasive disk ANDRE	150 x 32 x 6
abrasive disk Ro-Ma	127 x 12.7 x 5
abrasive disk Ro-Ma	150 x 20 x 5
abrasive disk Ro-Ma	150 x 32 x 5

FOR SHARPENING OF GANG SAWS

product's name	D x d x s (mm)
abrasive disk ANDRE	200 x 32 x 8
abrasive disk ANDRE	200 x 32 x 10
abrasive disk ANDRE	250 x 32 x 10

FOR SHARPENING OF BAND SAWS

product's name	D x d (mm)
BORAZONE abrasive disk	127 x 12.7
BORAZONE abrasive disk	203 x 32





Horizontal band sawmill HBS-3

Horizontal band sawmill HBS-3 is designed for longitudinal sawing of logs on the edged and unedged timber. Band sawmill HBS-3 model allows to conduct longitudinal sawing of logs with a diameter up to 1000mm and length up to 6200mm.

It is possible to provide by sawmill of any cutting length on order. It is also possible to carry out sawing of unedged boards on the squared beam or the edged board.

Depending on the hardness of wood and its type HBS-3 provides performance of up to one cubic meter per hour.

Feeding of the sawing unit along the site of sawn log is executed manually. Lowering and rising of the sawing unit to set the thickness of the board is executed by screw with electric drive.

Thickness of the board is controlled visually by a special line. The log is mounted on a table by the stops and clamping.

The tension force of the saw is controlled by the manometer. The HBS-3 must be protected from direct precipitation and installed indoors or outdoors under cover.



Technical specification (HBS-3):

Specification:	Property:
Max. log diameter , mm	1100
Max. kerf width, mm	800
Max. board thickness, mm	300
Feeding speed, m/min	2 - 20
Sawing precision, mm	1/1 000
Kerf thickness, mm	2 – 3
Sawing speed, mm/sec	30
Saw drive power, kW	11(15)
Log length (any on order), m	0,9 – 7,2

Horizontal band sawmill HBS-2

Horizontal band sawmill HBS-2 is designed for longitudinal sawing of logs on the edged and unedged timber.

Band sawmill HBS-2 model allows to conduct longitudinal sawing of logs with a diameter up to 900mm and length up to 6200mm.

It is possible to provide by sawmill of any cutting length on order.

It is also possible to carry out sawing of unedged boards on the squared beam or the edged board.

Depending on the hardness of wood and its type HBS-2 provides performance of up to one cubic meter per hour.

Feeding of the sawing unit along the site of sawn log is executed manually.

Lowering and rising of the sawing unit to set the thickness of the board is executed by screw with electric drive.

Thickness of the board is controlled visually by a special line. The log is mounted on a table by the stops and clamping.

The tension force of the saw is controlled by the manometer.

The HBS-2 must be protected from direct precipitation and installed indoors or outdoors under cover.



Technical specification (HBS-2):

Specification:	Property:
Max. log diameter , mm	900 (1000)
Max. kerf width, mm	700 (800)
Max. board thickness, mm	300
Min. board thickness, mm	3
Feeding speed, m/min	2 - 20
Sawing precision, mm	1/1000
Kerf thickness, mm	2 – 3
Sawing speed, mm/sec	25
Saw drive power, kW	7,5 (11)



Horizontal band sawmill HBS-1

Horizontal band sawmill HBS-1 is designed for longitudinal sawing of logs on the edged and unedged timber.

Simple design, small size and low power consumption allows you to use it in the farms, carpentry shops or directly at the construction sites.

It is used in individual farms and sawmills of small and medium power.

Sawing is performed by band saw which is rotated through the two pulleys.

The log is based on the track of the machine between the limits and pressed by the screw clamps.



Technical specification (HBS-1):

Specification:	Property:
Max. log diameter , mm	700
Max. kerf width, mm	540
Max. board thickness, mm	250
Feeding speed, m/min	2 - 20
Sawing precision, mm	1/1 000
Kerf thickness, mm	2 – 3
Sawing speed, mm/sec	22
Saw drive power, kW	4
Log length (any on order), m	0,9 – 5,2

Longitudinal trimming machine (LTM-1)

Longitudinal trimming machine LTM1 is designed for the cutting of board on the squared beam or edging board with thickness up to 80mm.

The standard model of the machine has a stroke up to 4.6m

At the customers' request the machines are made of any length.

Principle of operation of the machine is based on the cutting of stationary set board on a table by a moving carriage.



Clamping of the board at the time of cutting is executed by adjustable pressure rollers.

Width of the sawing workpiece is controlled by rulers or by dimensional limiters.

Longitudinal feed of carriage is performed manually or can be equipped with automatic feed, thus increasing of labor productivity.

The laser simulator of cutting can be mounted on the machine.



Technical specification (LTM-1):

Specification:	Property:
Max. sawing board width, mm	700
Max. cut-off board width, mm	240
Cutting thickness, mm	10 – 80
Sawing length (any on order), mm	4600
Saw diameter, mm	300
Seat (inner) saw diameter, mm	32 or 50
Saw rotating speed, rpm	2880
Saw drive power, kW	5,5
Sawing precision, mm	1/500

Machine miter MSM-1

Machine miter MSM-1 is designed for the crosscut sawing of board and squared beam with thickness up to 85mm and a width up to 450mm.

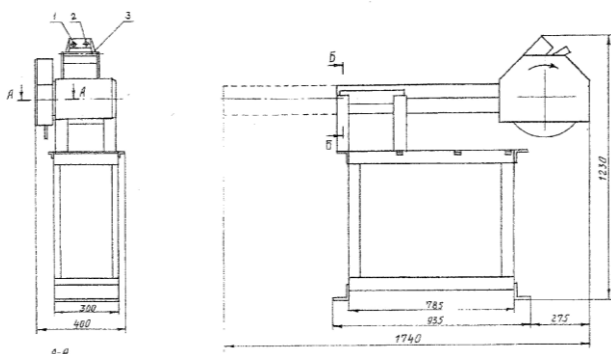
The saw with electro motor is mounted on the carriage, which provides moving of saw parallel over the plane of the table.

Feeding of the saw unit is carried out manually. The 3kW engine provides high performance of the machine.

The special saw for cross cutting with diameter of 400mm provides sufficient purity of cutting surface.

At the customer's request the machine is equipped with table and rollers.

It is recommended for furniture and joinery industries of any complexity.



Technical specification (MSM-1 (MSM-2)):

Specification:	Property:
Max. board thickness, mm	85
Cutting length (max. board width), mm	450
Saw rotating speed, rpm	2880
Saw drive power, kW	3
Saw diameter, mm	400
Seat (inner) saw diameter, mm	32 or 50

Machine miter with a pneumatic drive MSM-4

The machine miter with a pneumatic drive MSM-4 is designed for the crosscut sawing of board and squared beam in a semi-automatic mode.

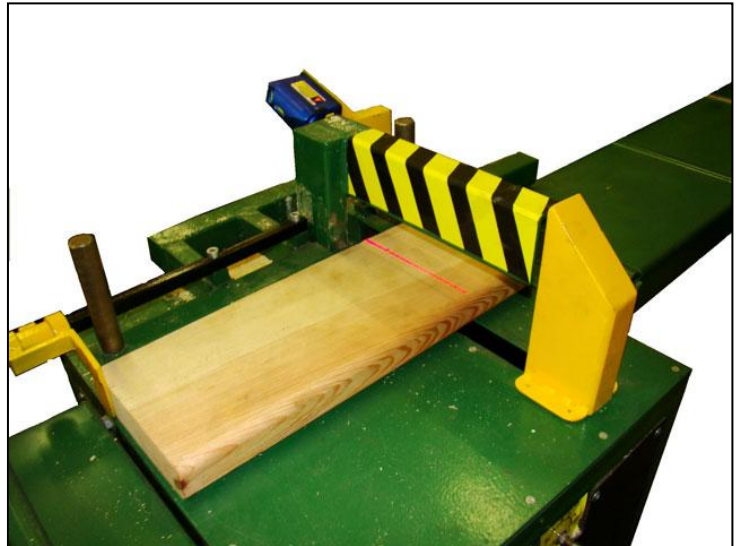
Clamping and cutting of a workpiece is carried out simultaneously in automatic mode.

The machine design allows it to saw a squared beam up to 100mm thick, without any additional adjustment of thickness.

Feeding of saw is pneumatically operated.

The machine can be provided by the laser cutting simulator.

At the customer's request the machine can be equipped with rollers of any length.



Technical specification (MSM-4):

Specification:	Property:
Max. board profile, mm	100x100 or 250x50
Saw rotating speed, rpm	2880
Saw drive power, kW	2,2
Air pressure, MPa	0.4 – 0.6
Saw diameter, mm	400
Seat (inner) saw diameter, mm	32 or 50

Machine miter with a pneumatic drive MSM-5

The machine miter with a pneumatic drive MSM-5 is designed for the crosscut sawing of board and squared beam in a semi-automatic mode.

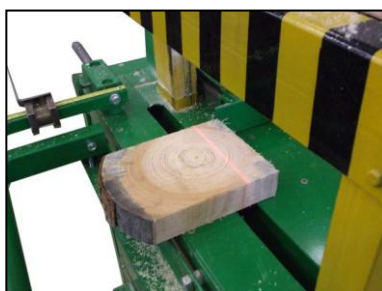
Clamping and cutting of a workpiece is carried out simultaneously in automatic mode.

The machine design allows it to saw a squared beam up to 100mm thick, without any additional adjustment of thickness.

Feeding of saw is pneumatically operated.

The machine can be provided by the laser cutting simulator.

At the customer's request the machine can be equipped with rollers of any length.



Technical specification (MSM-5):

Specification:	Property:
Max. board profile, mm	45x150; 100x220; 50x350
Saw rotating speed, rpm	3900
Saw drive power, kW	4 (5.5)
Saw diameter, mm	450
Air pressure, MPa	0.4 - 0.6
Overall dimension (without rollers), mm	700x500x1100
Weight, kg	95
Operating personnel, person	1

Desktop machine miter MSM-3

Desktop machine miter MSM-3 is designed for the crosscut sawing of board and squared beam in a manual mode.

Feeding of the saw unit is carried out manually.

The machine is able to cut out a small profile board quickly and easily.

For example, it suits for furniture procurement, battens, floor boards, etc.

At the customer's request the machine can be equipped with a table and rollers.



Technical specification (MSM-3):

Specification:	Property:
Max. board profile, mm	60x150 or 25x250
Saw rotating speed, rpm	2880
Saw diameter, mm	350
Seat (inner) saw diameter, mm	32 or 50
Saw drive power, kW	1,1(1,5)
Feeding of saw unit	manual

Grinding machine GM-2

Grinding machine GM-2 is designed for the high-quality sharpening in the automatic mode of band saw blades with width 10 - 60mm, thickness 0.6 - 2mm.

For high-performance sharpening are used special CBN grinding wheels.

Design of the device allows sharpening the saws up to 60 mm wide with a very high quality and productivity.

Sharpening speed of band saw is around tooth per second, which provides the speed 4 times more than the usual universal sharpening devices.

Tooth profile is exactly the profile of grinding wheel.

Coolant is fed in the cutting zone while sharpening the saw.



Technical specification (GM-1):

Specification:	Property:
Voltage, V	3-phase - 380 (1-phase - 220)
Grinding wheel drive power, W	550
Grinding wheel dimension, mm	203x32x22
Width of sharpening saw, mm	27 – 60
Saw thickness, mm	0,8 – 1,4
Grinding speed, m/s	49

Grinding machine GM-1

Grinding machine GM-1 is designed for the sharpening in the automatic mode of band saw blades with width 10 - 60mm, thickness 0.6 -2mm.

Tooth profile is provided by a special former. To obtain a different profile you need to replace the former.

The formers at different profile and step of the band saw blades are manufactured on special order.



The standard version of the machine is equipped by a device for sharpening saws with the 22mm former of tooth pitch of the Wood-Mizers' profile.

GM-1 allows you to sharpen the band saw blade with 7mm to 25mm tooth pitch.

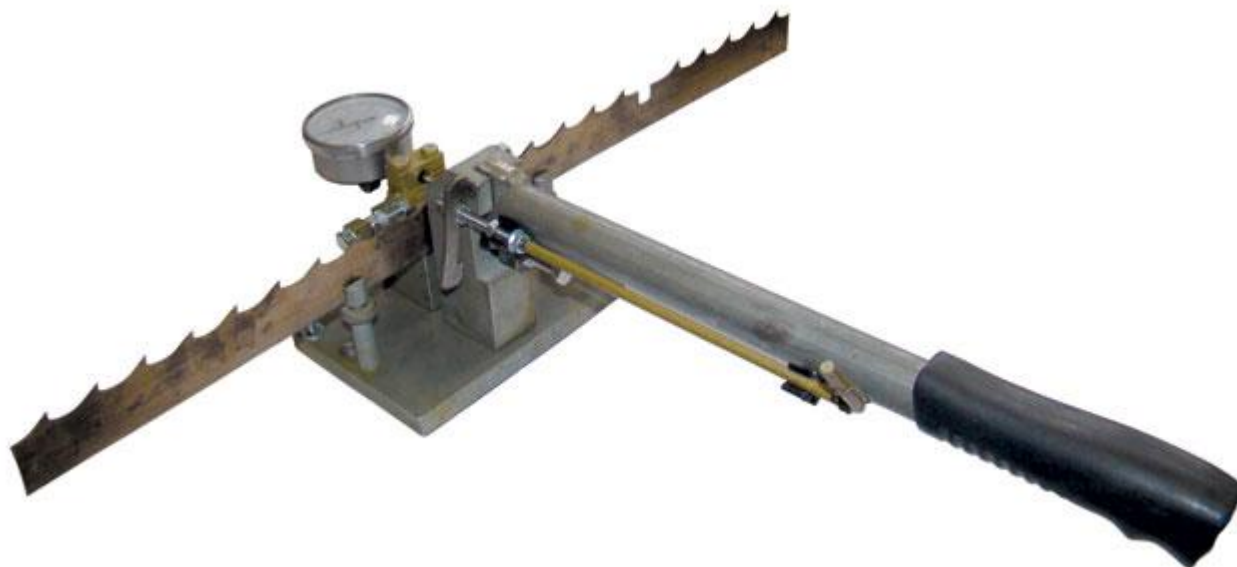
Time for sharpening of four-meter saw with 22mm pitch tooth is 25-40 minute.

Feeding of band saw is adjustable.

Technical specification (GM-1):

Specification:	Property:
Voltage, V	220
Grinding wheel drive power, kW	120
Grinding wheel dimension, mm	150x32x6
Saw width, mm	10 – 60
Saw width, mm	10 – 35
Saw thickness, mm	0,6 – 2
Grinding time, min	~ 10-60 (saw length- 4m, tooth pitch - 22mm)

Setting machine DWS-1



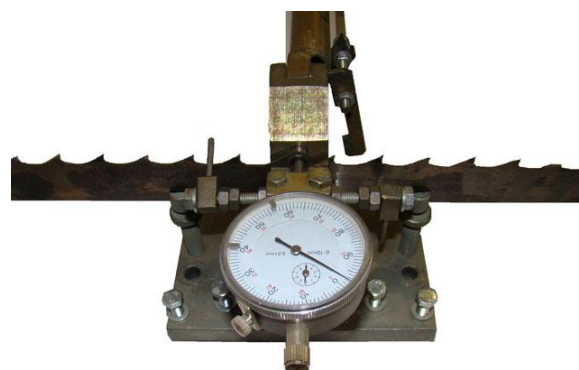
Setting machine DWS-1 is designed for manual setting and dimension control of band saws for woodworking machinery.

It is used for setting of band saw blades with width of 10 - 60mm and thickness of 0.6 – 2mm.

Time for setting of four-meter length saw blade with 22mm tooth pitch is up to 10 minutes.

The setting device is installed on a desktop or a special stand.

The value of setting is controlled by the dial gauge with an accuracy of 0.01mm.



Technical specification:

Specification:	Property:
Band saw blade width, mm	10 – 60
Band saw blade thickness, mm	0.6 – 2
Average setting time, min	10

Setting machine DWS-2



Setting machine DWS-2 is designed for manual setting and dimension control of band saws for woodworking machinery. It includes a counter and guides to support the band saw blade, as well as an indicator to indicate the setting parameters of the teeth.

The lever of the setting device is made as a handle, which serves for moving the saw within the tooth pitch and for the pressure on the saw blade to give the necessary tooth setting. Time for setting of four-meter length saw blade with 22mm tooth pitch is up to 5 minutes.

In order to make it easier for an operator to read of the instrument reading it is provided an opportunity of adjusting the tilt of the device for sharpening.

The lever of the machine is made in a form of the rotating handle with which the operator can easily operate. The machine provides precise setting of saw teeth. The delivery kit includes a counter and guides to support the band saw blade during the setting.

Technical specification:

Specification:	Property:
Band saw blade width, mm	10 – 60
Band saw blade thickness, mm	0.6 – 2
Average setting time, min	5