



SHARPTEC

Resin-bonded grinding tools for saw grinding

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The new SHARPTEC assortment for grinding band and circular saws redefines performance and quality. Thanks to state-of-the-art manufacturing technologies, innovative grit technology and a newly developed resinoid bond, the tools guarantee a grinding process that is both particularly gentle on the material and highly efficient. The comprehensive assortment offers solutions for all performance requirements.

The customer benefits are clear: exceptionally long lifetimes, no material damage during the grinding process and maximum efficiency in daily use. The innovative SHARPTEC line stands for precise results and maximum efficiency: SHARPTEC CA offers balanced cutting ability and stability – CA+ impresses with high profile retention combined with reduced grinding forces.

+ Cool grinding:

The combination of innovative grit quality and an adapted bond system reduces grinding forces and thus burr formation as well as thermal input.

+ Adapted specification assortment:

SHARPTEC grinding tools can be customised to meet individual customer requirements – this is facilitated by the flexible combination of grit qualities and bonds.



Application:
Creation of saw teeth on a HSS blade



+ Optimised cost-effectiveness:

Long dressing intervals and the attractive grinding wheel price reduce unit costs considerably.



SHARPTEC CA B82



SHARPTEC CA+ B100



SHARPTEC CA B22



SHARPTEC CA+ B408

Application example

Tooth form grinding

Workpiece: Stellite tipped bandsaw, number of teeth: 360, tooth width: 5.2 mm
Grinding wheel: Shape 1, 400 x 10 x 127, SHARPTEC CA+, NF-A80 O7 B100
Machine: ISELI BNP 210, emulsion coolant 4%
Parameters: $v_s = 40$ m/s, face $v_f = 8$ mm/s, radius $v_r = 6$ mm/s, back $v_b = 4$ mm/s, act. dressing cycle = 20

Dressing cycle [no. of teeth]

SHARPTEC CA+ 25

COMPETITION 20

Dressing stock [mm]

SHARPTEC CA+ 0,2

COMPETITION 0,5

Conclusion: The new SharpTec CA+ specification is significantly more durable as well as more free cutting than competitor products which leads to a cool grinding behavior. It is recommended for profiling new teeth with high stock materials and can also be used for resharpening. The dressing stock is half of the competitors value and the dressing cycle can be significantly increased without affecting the quality of the saw blade – no geometrical deviation or burning marks. The customer was specifically impressed by the perfect run-out conditions of the grinding wheel.

Specification	Application	Performance
CA B22	Resharpening	+
CA B82	Resharpening and profiling	++
CA+ B408	Resharpening and profiling	+++
CA+ B100	Profiling and high material removal	++++