GRINDING TOOLS FOR THE WOOD INDUSTRY

Wood is one of the most popular materials used in the world. Its popularity is constantly growing and a multitude of applications means that woodworking machine users are looking for better and better solutions in terms of sharpening tools they use. Thanks to many years of experience, ANDRE can offer wide range of abrasive tools for sharpening applications. Our advantages are high quality, user safety and affordable price.

GRINDING OPERATIONS WITH ANDRE ABRASIVE TOOLS

BAND SAW BLADE SHARPENING

- Grinding the rake surface of the tooth
- Grinding the side surface of the tooth
- Grinding of the saw welds

GANG SAW BLADE SHARPENING

- Grinding the rake surface of the tooth

CHAINSAW BLADE SHARPENING

- Grinding the chain blades

CIRCULAR SAW BLADE SHARPENING

- Grinding the tooth rake face of HSS saws
- Grinding the tooth rake face of carbide saws
- Grinding the tooth top of carbide saws
- Grinding the side surface of the tooth of carbide saws

WOODWORKING TOOLS SHARPENING

- Veneer knive sharpening
- Other woodworking tools (planer knives, drills, cutters)

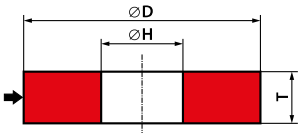
ANDRE®
abrasive articles

BAND SAW BLADE SHARPENING

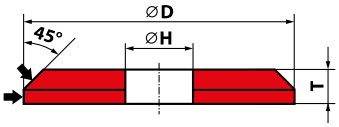
In this grinding operation the saw blade is shaped to achieve the required properties and long life. The correct grinding process ensures that the cutting surface is smooth and little heat is generated during the use of the saw. ANDRE company offers a proven range of grinding wheels for band saw sharpening, both for the rake and side surface grinding.

• GRINDING THE RAKE SURFACE OF THE TOOTH

| TYPE 1 | TYPE 1C



1 - D × T × H

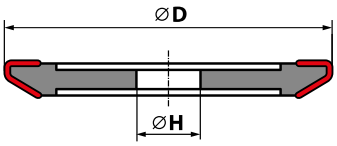


1C - D × T × H

Examples of implemented abrasive tools in industry [*]				
Type	Dimensions [mm]	Technical characteristics	Speed [m/s]	Wersja
1	127 × 6,0 × 12,7	99A60RB89	50	FORMULA “2”
1	150 × 6,0 × 32	99A60SB88	50	FORMULA “3”
1C	150 × 8,0 × 20	95A60N/O8B643	50	–

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

| SUPERHARD GRINDING WHEELS | PROFILE CBN WHEEL



Profile CBN electroplated grinding wheel D × T × H; profile

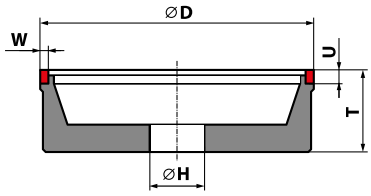
Examples of implemented abrasive tools in industry [*]			
Type	Dimensions [mm]	Specification	Profile
PROFILE GRINDING WHEEL	127 × 22,23 E9,5; R15,24; H12,7	B126GA1	10/30
PROFILE GRINDING WHEEL	203,2 × 22,23 E9,5; H32	B126GA1	9/29

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

GRINDING THE SIDE SURFACE OF THE TOOTH

In this operation side surface of the band saw is ground. The grinding wheels work in pairs.

| TYPE 6A9



6A9 - D × T × X × U × H

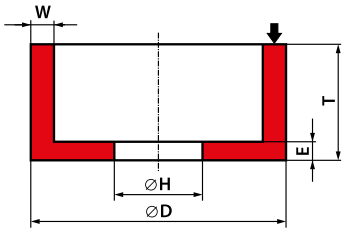
Examples of implemented abrasive tools in industry [*]		
Type	Dimensions [mm]	Technical characteristics
6A9	100 × 30 × 3 × 10 × 20	B151V180LBL2

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

GRINDING OF THE SAW WELDS

The operation is performed to align the weld. ANDRE offers a proven range of grinding wheels for this operation. Only properly selected grinding wheels will ensure quick and burn-free material removal.

| TYPE 6



6 - D × T × H - W...E...

Examples of implemented abrasive tools in industry [*]			
Type	Dimensions [mm]	Technical characteristics	Speed [m/s]
6	100 × 50 × 20 - W8 E12	99A70M7VE02B	35
6	100 × 50 × 20 - W12E12	99A70N7VTE10	35
6	150 × 51 × 32 - W20 E20	95A60N/O7VTE10	30

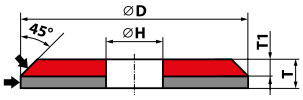
[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

GANG SAW BLADE SHARPENING

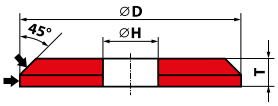
In this grinding operation the saw blade is shaped to achieve the required properties and long life. The correct grinding process ensures that the cutting surface is smooth and little heat is generated during the use of the saw. ANDRE company offers a proven range of grinding wheels for gang saw sharpening.

- **GRINDING THE RAKE SURFACE OF THE TOOTH**

  | TYPE 1YC | TYPE 1C



1YC - D × T/T1 × H



1C - D × T × H

Examples of implemented abrasive tools in industry [*]			
Type	Dimensions [mm]	Technical characteristics	Speed [m/s]
1YC	200 × 10/7 × 32	99A60N7/CRA60O7VTE10	40
1C	250 × 10 × 32	95A60N/O8B643	50

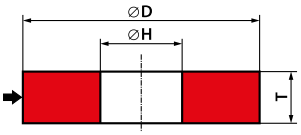
[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

CHAINSAW BLADE SHARPENING

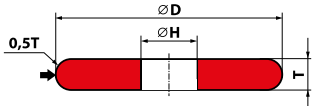
In this grinding operation the chain saw blade is shaped to achieve the required properties and long life. The correct grinding process ensures that the cutting surface is smooth and little heat is generated during the use of the saw. ANDRE company offers a proven range of grinding wheels for chainsaw blade sharpening.

- **GRINDING THE CHAIN BLADES**

  | TYPE 1 | TYPE 1F



1 - D × T × H



1F - D × T × H

Examples of implemented abrasive tools in industry [*]			
Type	Dimensions [mm]	Technical characteristics	Speed [m/s]
1	105 × 4,7 × 22,23	CRA60K7VE01	35
1	140 × 3,2 × 12	CRA60L7VE01	25
1F	145 × 4,7 × 22,23	CRA60K7VE01	35

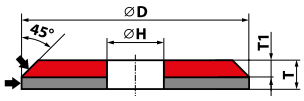
[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

CIRCULAR SAW BLADE SHARPENING

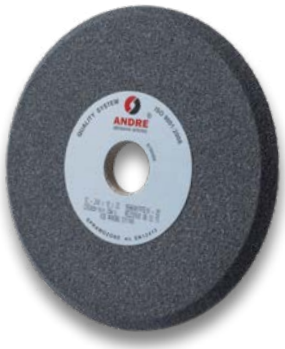
In this grinding operation the saw blades are shaped to achieve required properties. ANDRE offers a proven range of conventional and super hard wheels for both HSS or carbide blades. Only properly selected grinding wheels for specific tasks guarantee the required sharpness and long life of circular saw blades.

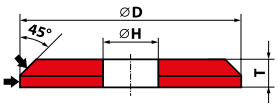
• GRINDING THE TOOTH RAKE FACE OF HSS SAWS

| TYPE 1YC | TYPE 1C | TYPE 12

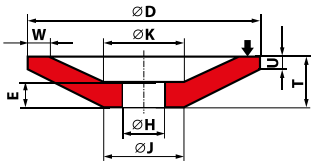


1YC - D × T/T1 × H





1C - D × T × H

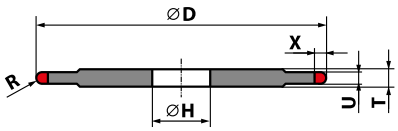


12 - D/J × T/U × H - W...E...K...

Examples of implemented abrasive tools in industry [*]			
Type	Dimensions [mm]	Technical characteristics	Speed [m/s]
1YC	126 × 6/4 × 12,7	99A80N7/CRA100O7VE01	40
1C	200 × 8 × 32	CRA60K7VE01	40
12	125/61 × 13/3,2 × 32 - W6E7K61	99A60K5VTE10	40

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

| TYPE 14F1



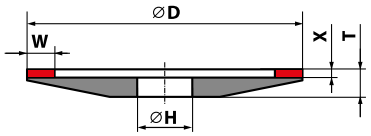
14F1 - D × U × X × T × H

Examples of implemented abrasive tools in industry [*]		
Type	Dimensions [mm]	Technical characteristics
14F1	200 × 2 × 8 × 8 × 32	B126V240OBN5
14F1	200 × 4 × 8 × 8 × 32	B126V240NBN5
14F1	200 × 6 × 8 × 8 × 32	B126V240NBN5

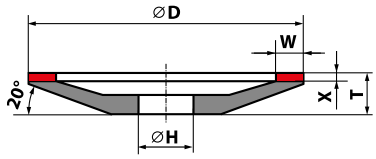
[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

• GRINDING THE TOOTH RAKE FACE OF CARBIDE SAWS

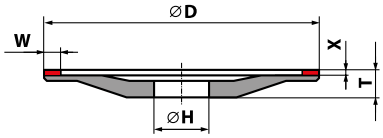
| TYPE 4A2 | TYPE 12A2-20 | TYPE 12V9-20 | TYPE 12A2PA | TYPE VBA-8



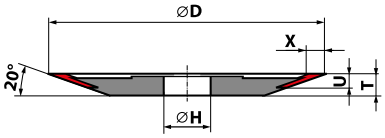
4A2 - D × T-X × W × X × H



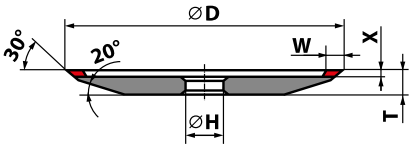
12A2–20 - D × T-X × W × X × H



12A2PA - D × T-X × W × X × H



12V9-20 - D × T × X × U × H

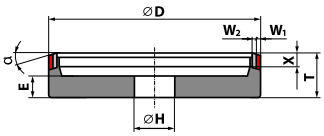


VBA-8 - D × T × W × X × H

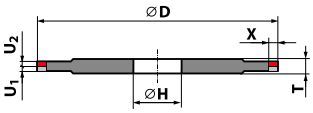
Examples of implemented abrasive tools in industry [*]		
Type	Dimensions [mm]	Technical characteristics
4A2	125 × 7 × 6 × 2 × 20	D126C50LBL2
4A2	150 × 9 × 10 × 2 × 20	D126C75LBL2
12A2-20	125 × 14 × 6 × 2 × 20	D126C75LBL2
12A2-20	150 × 16 × 6 × 2 × 32	D126C75LBL2
12A2PA	100 × 8 × 6 × 2 × 32	D76C100LBL2
12V9-20	125 × 13 × 3,5 × 4 × 32	D64C125NBN3
VBA-8	100 × 10 × 4 × 2 × 20	D76C125TBL5
VBA-8	125 × 13 × 4 × 2 × 32	D76C100LBL2

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

• GRINDING THE TOOTH TOP OF CARBIDE SAWS | TYPE VDA-14 | TYPE 14AA1



VDA-14 - D × T × W_1/W_2 × X × H

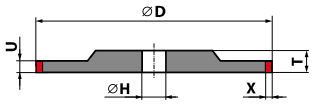


14AA1 - D × U_1/U_2 × X × T × H

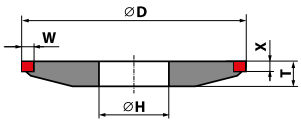
Examples of implemented abrasive tools in industry [*]		
Type	Dimensions [mm]	Technical characteristics
VDA-14	125 × 18 × 3/2 × 6 × 32	D126/46C100/75LBL2
14AA1	150 × 2,5/2,5 × 8 × 10 × 32	D126/46C125/100O/PBL2

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

• GRINDING THE SIDE SURFACE OF THE TOOTH OF CARBIDE SAWS | TYPE 3A1 | TYPE 4A9



3A1 - D × T × U × X × H



4A9 - D × T × W × X × H

Examples of implemented abrasive tools in industry [*]		
Type	Dimensions [mm]	Technical characteristics
3A1	100 × 2,5 × 6 × 14 × 32	D46C75NBL3
4A9	100 × 10 × 6 × 4 × 32	D46C75NBL3

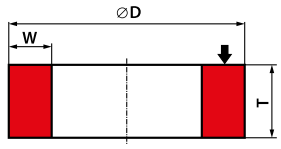
[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

WOODWORKING TOOLS SHARPENING

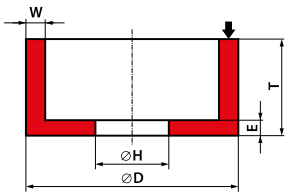
VENEER KNIVE SHARPENING

In this operation veneer knives are ground to achieve required properties. ANDRE offers a proven range of grinding tools intended for this operation. Only properly selected grinding tools for specific tasks guarantee the required sharpness and long life of veneer knives.

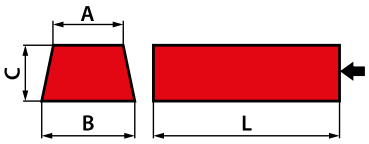
| TYPE 2 | TYPE 3109 | TYPE 6



2 - D × T-W



6 - D × T × H - W...E...



3109 - B/A × C × L

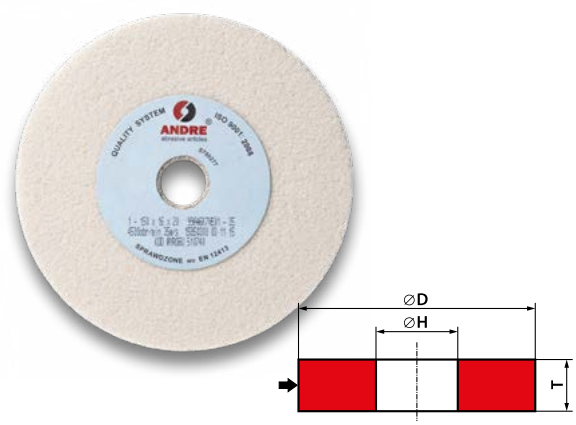
Examples of implemented abrasive tools in industry [*]			
Type	Dimensions [mm]	Technical characteristics	Speed [m/s]
2	200 × 90 - W20	59A60G12VTE10P	20
3109	49/44 × 22 × 80	59A46G12VTE10P	–
6	175 × 90 × 110 - W20 E15	99A36JB	35

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

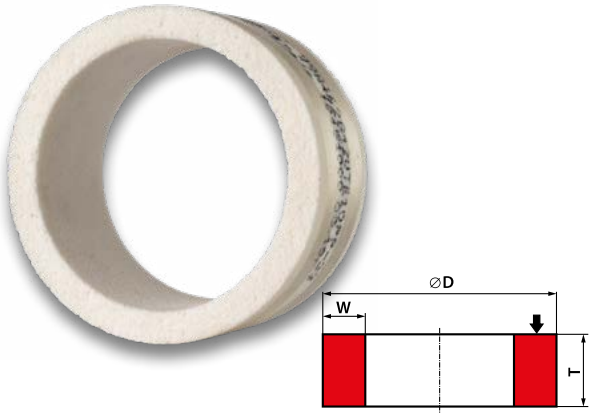
OTHER WOODWORKING TOOLS (PLANER KNIVES, DRILLS, CUTTERS)

Tools for wood are not only circular, band or chain saws - drills, milling cutters and planer knives are also commonly used in this industry. Each of these tools must be sharp to do its job. ANDRE offers a proven range of grinding wheels for sharpening these tools. Only properly selected grinding wheels will ensure correct operational properties and long life of these tools.

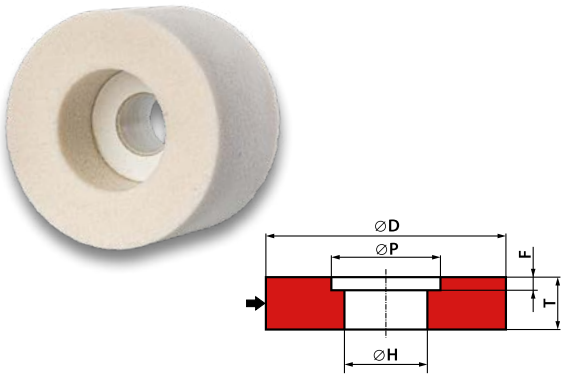
| TYPE 1 | TYPE 2 | TYPE 5 | TYPE 6 | TYPE 11



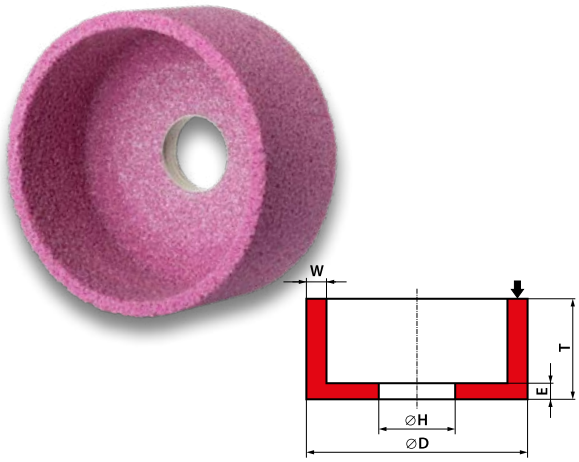
1 - D × T × H



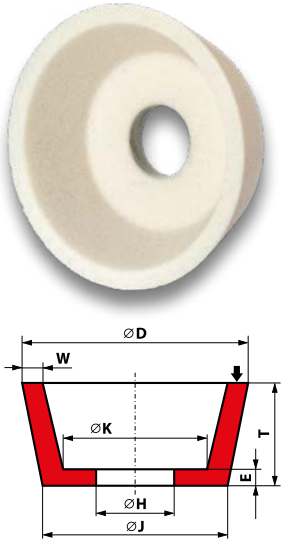
2 - D × T - W



5 - D × T × H - P...F...



6 - D × T × H - W...E...

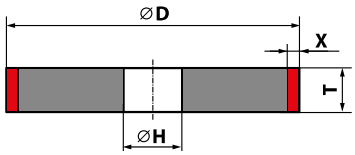


11 - D/J × T × H - W...E...K...

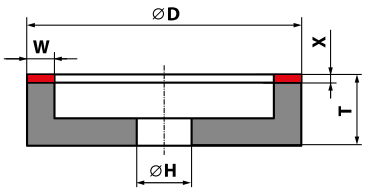
Examples of implemented abrasive tools in industry [*]			
Type	Dimensions [mm]	Technical characteristics	Speed [m/s]
1	150 × 20 × 20	CRA80K7VE01	35
2	200 × 100 - W20	99A462G8VE01Z	40
2	300 × 120 - W25	99A36K6B	40
5	150 × 40 × 12,7 - P80 F20	99A100J7VE01	35
6	150 × 80 × 32 - W13 E16	99A46K7VE01	35
11	150/114 × 50 × 32 - W10 E13K96	99A60K7VE01	33

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.

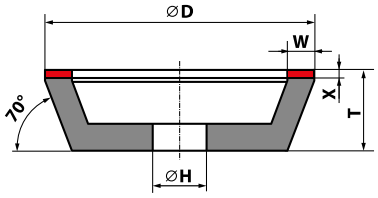
| TYPE 1A1 | TYPE 6A2 | TYPE 11A2



1A1 - D × T × X × H



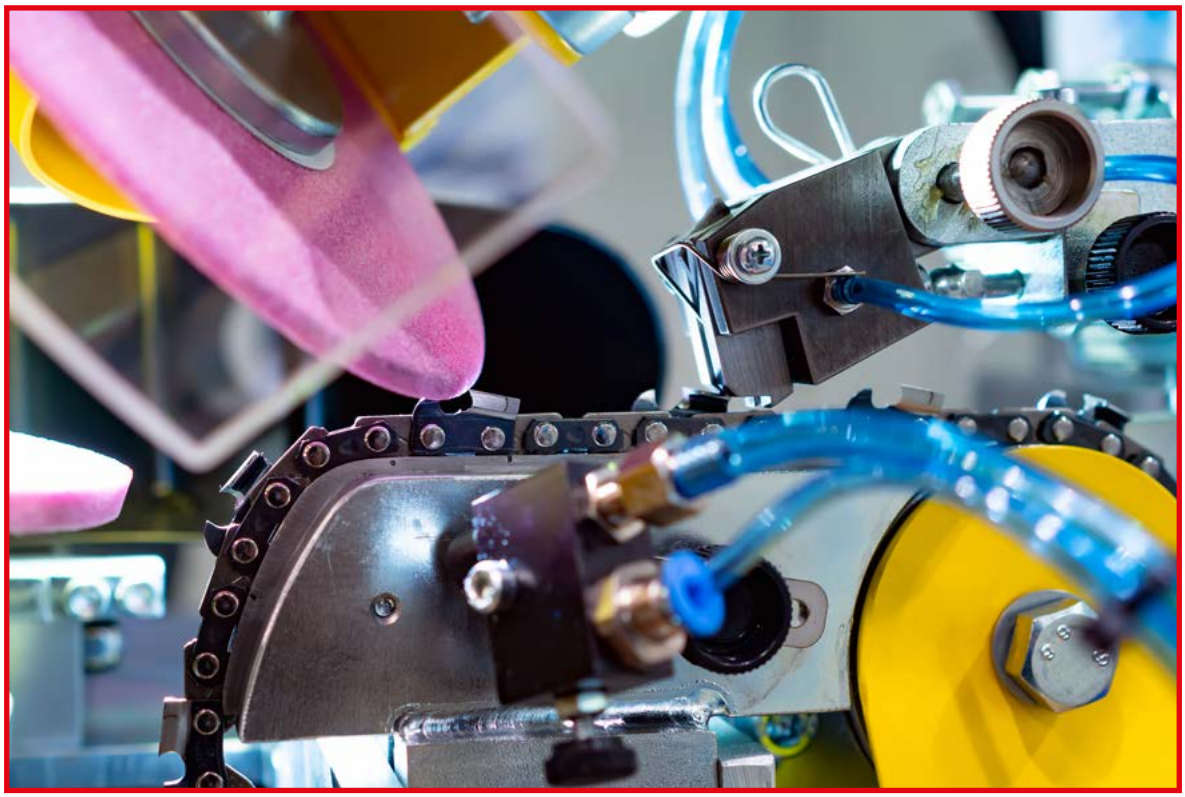
6A2 - D × T-X × W × X × H



11A2 - D × T-X × W × X × H

Examples of implemented abrasive tools in industry [*]		
Type	Dimensions [mm]	Technical characteristics
1A1	150 × 20 × 4 × 32	D126C75LBG2
1A1	150 × 15 × 4 × 20	B126V180LBG2
6A2	100 × 23 × 6 × 4 × 20	D126C75LBL2
6A2	125 × 23 × 10 × 4 × 20	B126V180LBL2
11A2	100 × 40 × 6 × 4 × 20	D107C75LBL2

[*] For the full range of dimensions and available technical characteristics ask the Sales Department.



ANDRE®
abrasive articles

A GOOD SAW ... IT IS A WELL SHARPENED SAW

ANDRE ABRASIVE ARTICLES
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