

Automatic Grinding Machine

USK 230 B - HV 208



KNECHT.

Automatic Grinding Machine USK 230 B - HV 208



Product profile

Sharpness, grinding angle, shape and profile of a cutter knife greatly influence the quality of the sausages produced.

High cutting speeds (130 m / s and higher) and lateral pressures place great mechanical stress on the cutter knives. Grinding thus also has a direct effect on the security against fracture of a cutter knife.

A grinding machine must therefore fulfil the following requirements:

- exact, precisely angled grinding,
- preservation of the prescribed cutting edge profile,
- preservation of the original knife shape

And this must be reproducible for the whole life of the cutter knives.



Sickle-shaped cutter blade



Cutter blade with straight cutting edges

The **USK 230 B - HV 208** automatically grinds up to 100 cutter knives (500 l) per shift. The average grinding time per knife is 1.5 to 4 minutes, depending on knife size. With each regrinding the complete cutting edge profile is processed.

Approx. 1.5 g material is removed from the knife per grinding process. A 500 litre cutter knife can be reground up to 100 times. Cutting tools up to 450 mm in size are possible.

Copy clamping plate SP 110:

This is the key to automatic grinding. It contains all information needed about the shape and size of the knife. Every knife is assigned a tailor-made copy grinding plate. There is no need for inconvenient and time consuming programming and adjusting. This ensures maximum grinding precision and easy handling. It takes less than one minute to retool the machine to a different knife shape.



Polishing and deburring: The cutting edge manually is given its final fine trim on the finned brush. Exactly appropriate peripheral speed and optimally adjusted brush resistance protect the cutting edge and level out handling errors.

The **cutting edge profile** is programmed and saved via the PLC-control on the control panel. The operator has a choice of 3 different programs which can be programmed individually and called up via a program selection switch.



Copy clamping plate SP 110



Changing the copy plate



Grinding angle adjustment

Waterproof wet grinding belts are used as abrasive. Up to 80 cutter knives (500 - 750 l) can be ground with 1 belt.

A **coolant device** protects the cutting tools from overheating - the most important condition for durable cutting edges.

Parameter	Function	Setting Range	Standard Setting
231	Start	1-10	3
232	1. Position	1-10	1
233	2. Position	1-10	1
234	3. Position	1-10	1
235	4. Position	1-10	1
236	5. Position	1-10	1
237	6. Position	1-10	1
238	7. Position	1-10	1
239	8. Position	1-10	1
244	Number of Blade Positions	0-9	7



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Grinding principle: The knife profile is divided into small, overlapping grinding zones. Each of these grinding zones can be ground 1-10 times, after which the machine changes to the next zone. Each individual grinding zone is programmed and saved. In this way the knife is given a cutting edge profile which matches the product exactly. The same applies to each regrinding for the whole life of the knife.

Technical data

Automatic grinding machine

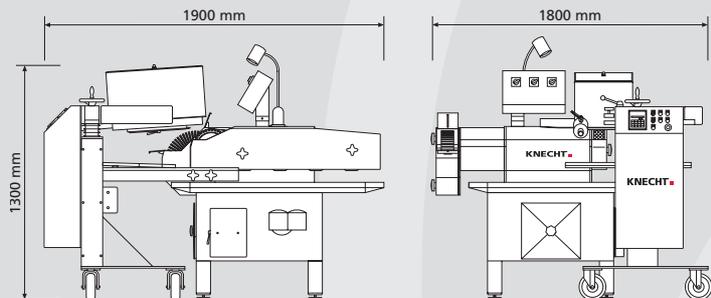
USK 230 B - HV 208

Depth 1900 mm
 Width 1800 mm
 Height 1300 mm
 Weight 330 kg
 Connected load 2.8 kW

Compressed air connection 6 bar
 Air consumption 50 l / min.

The machine meets the **EU health and safety requirements** and features the **CE-sign**.

Technical modifications reserved.



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