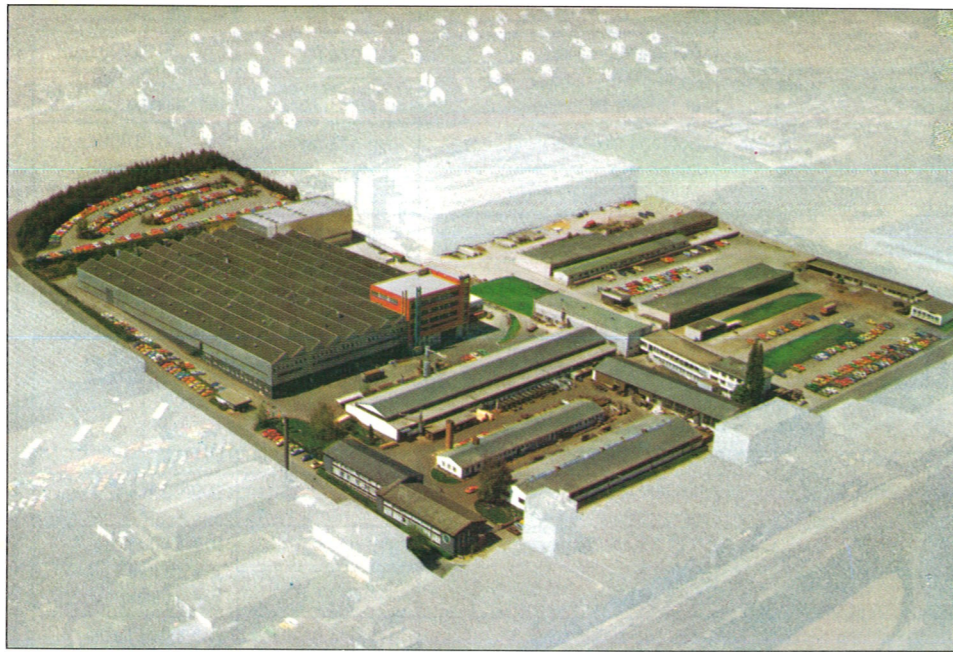




MICHAEL WEINIG

AKTIENGESELLSCHAFT

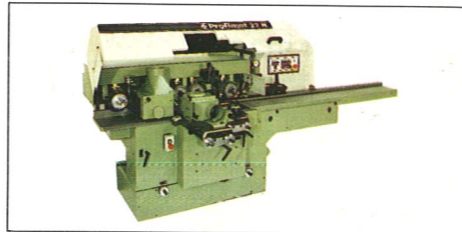
Weinigstrasse 2/4
Postfach 1440
D-6972 Tauberbischofsheim
Telephone (0) 93 41/86-0
Telefax (0) 93 41/70 80
Telex 6 89 511
West Germany



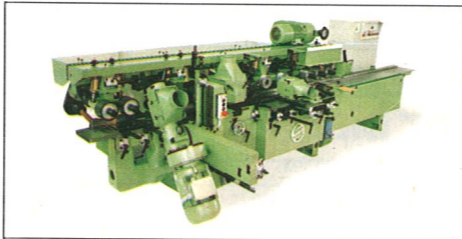
Aerial photograph of our factory in Tauberbischofsheim
(publication approved by Reg. Präs., No. 9/54 571)



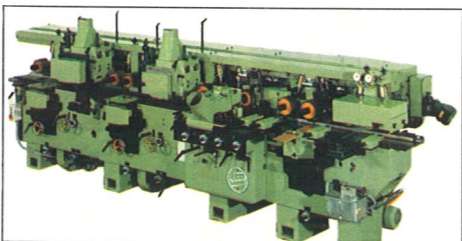
Large-batch production on a production line



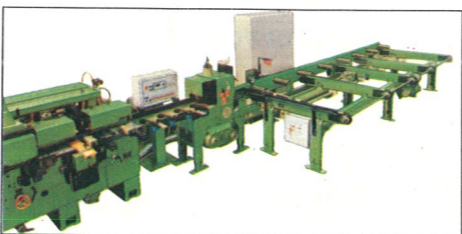
Profimat



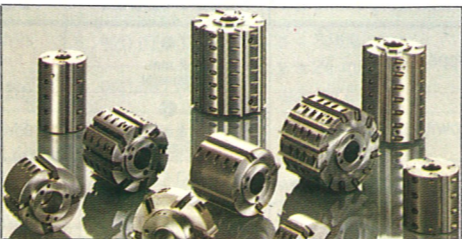
Unimat



Hydromat



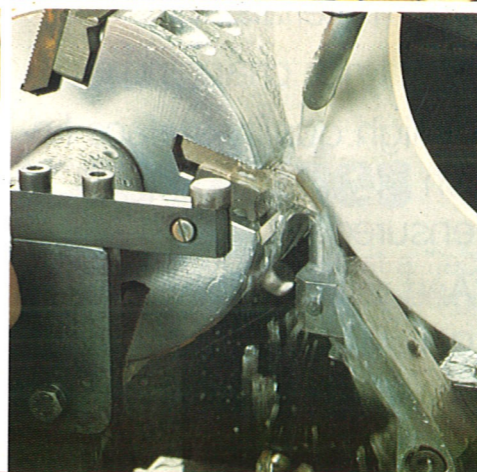
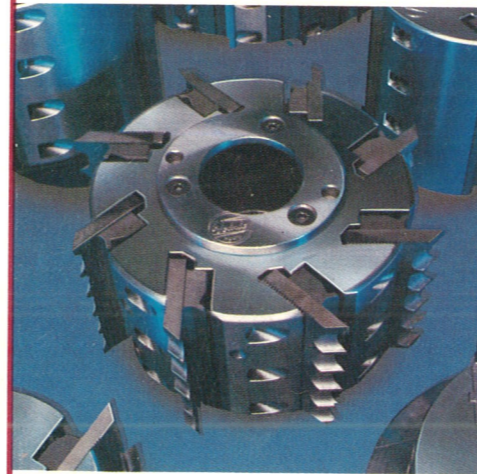
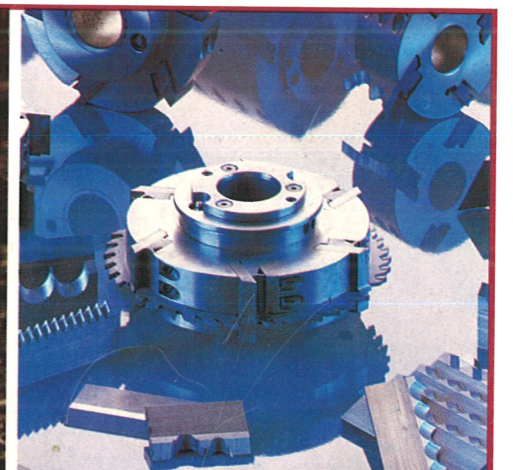
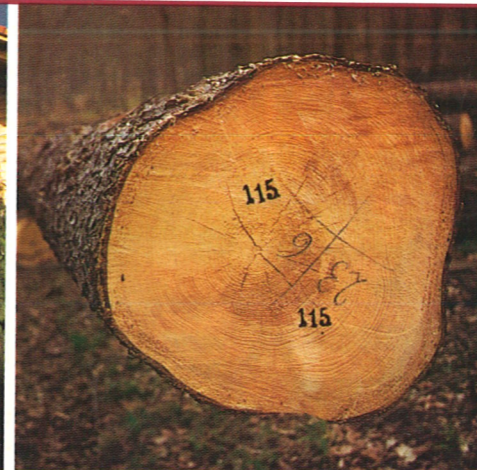
Material handling equipment



Original Weinig Tooling

Rondamat

Tool grinders for the woodworking industry

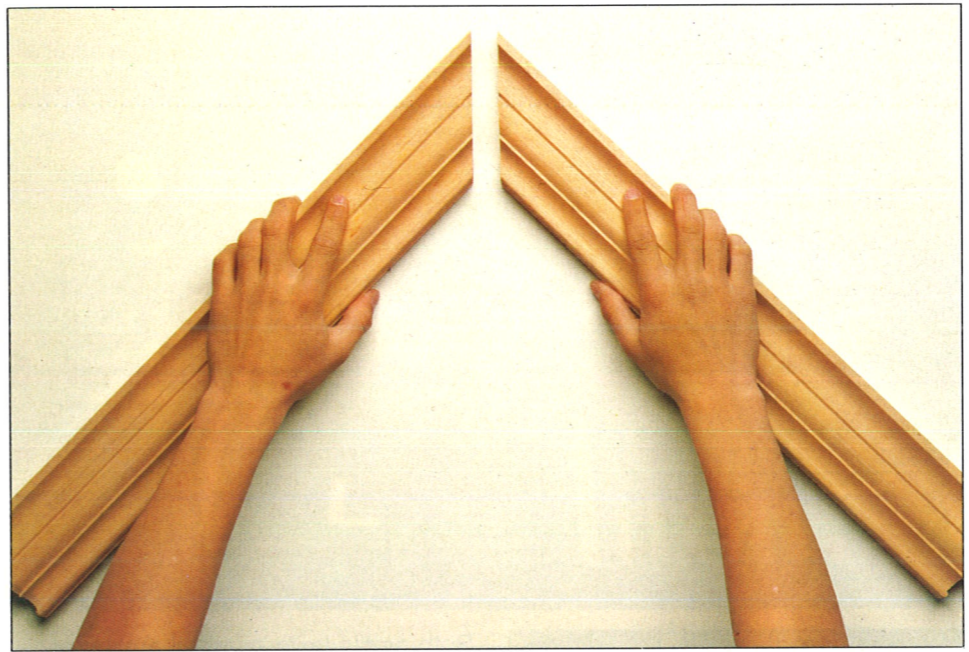
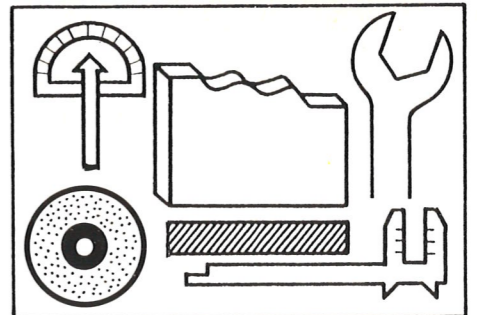


The low-cost model: Rondamat 929



This is the most inexpensive way to produce your own profile knife. In your own factory, in a matter of minutes. From a straight blank. Any employee can do it. No special qualifications are required.

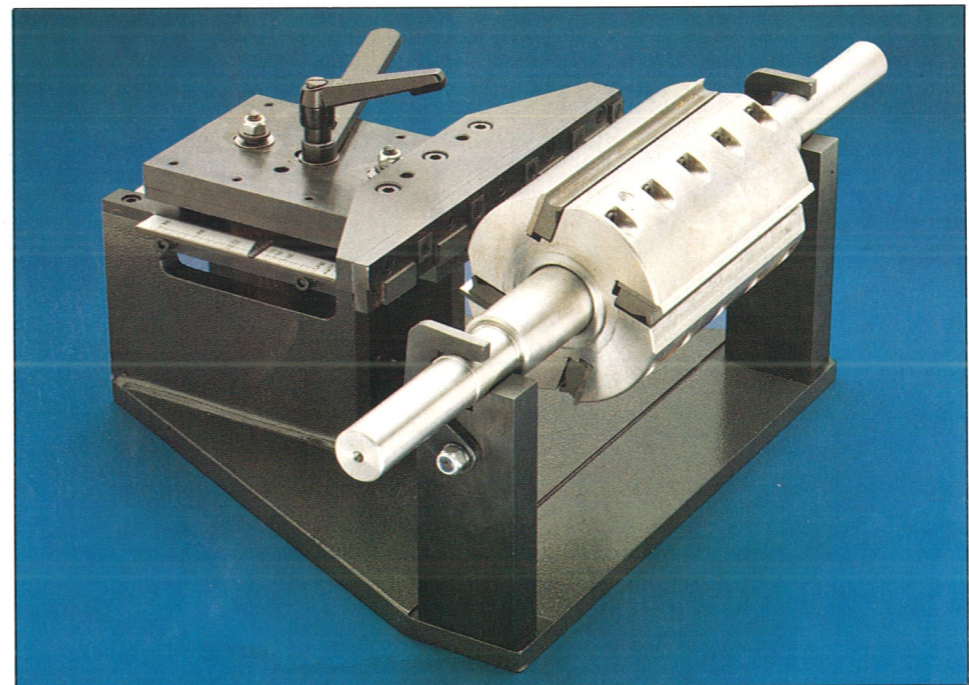
Thanks to the template. It guarantees true-to-profile grinding and resharpening. Over and over again with absolute accuracy.



Fitting accuracy is not accidental. Grinding on the Rondamat.

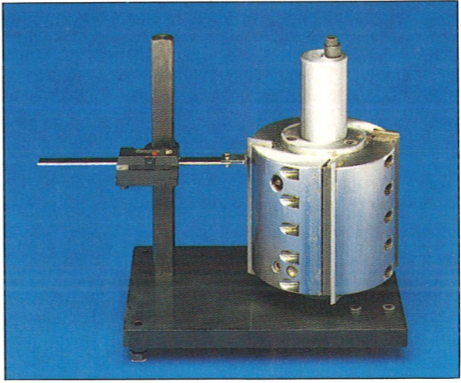


The standard setting stand for planer heads. Low priced, reliable, accurate.

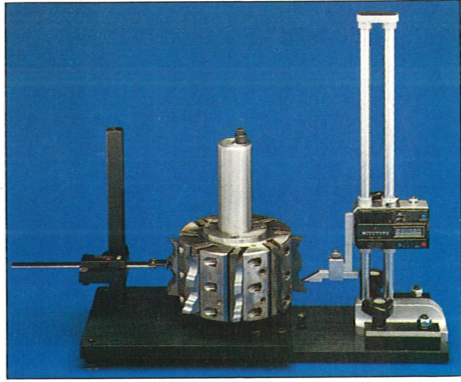


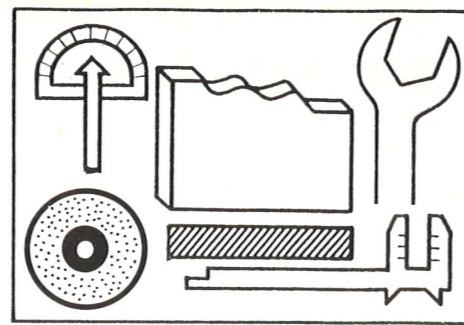
Precision setting device for planing knives. It couldn't be more accurate.

This version determines radius and profile height. ▶



The ATS system takes the tool radius into account. The radius measuring device.





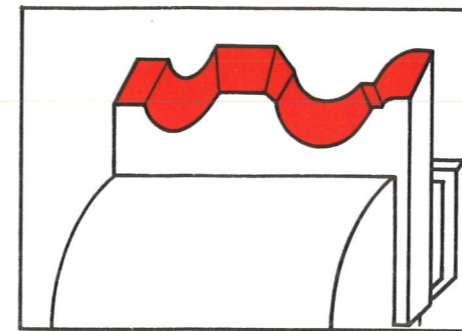
... you need a Rondamat

Use and application of diamond grinding wheels for carbide-tipped profile knives

Machine	designation	shape of grinding wheel	use and application	clamping flange	approx. value
				tracing pin	
R 931	930 062 002 grit size D 151 bonding K + 1313 RY		TCT profile knives (entire profile) rough grinding	920 074 05	n = 3.000 r.p.m. v = 32 m/s wet grinding
				930 042 002	
R 931	930 062 003 grit size D 46 bonding K + 888 RY		TCT profile knives (sheer angles, edges and corners) finish grinding	920 074 05	n = 3.000 r.p.m. v = 32 m/s wet grinding
				930 042 002	
R 931	930 062 004 grit size D 46 bonding K + 888 RY		TCT profile knives (sheer angles, sheer angles with radius) finish grinding	920 074 12	n = 3.000 r.p.m. v = 32 m/s wet grinding
				930 042 012	
R 931	930 062 005 grit size D 46 bonding K + 888 RY		TCT profile knives (v-shaped patterns, small radii) finish grinding	920 074 05	n = 3.000 r.p.m. v = 32 m/s wet grinding
				930 042 003	
R 931	930 062 006 grit size D 25 bonding K + 888 RY		TCT profile knives (entire profile) (TCT jointing) finish grinding	920 074 05	n = 3.000 r.p.m. v = 32 m/s wet grinding
				930 042 002	
R 931	920 072 001 grit size D 151 bonding K + 920 A		TCT profile knives (entire profile) rough grinding (Z 10 to Z 20)	920 074 01	n = 3.000 r.p.m. v = 24 m/s wet grinding
				930 042 002	
R 931	920 072 002 grit size D 46 bonding K + 888 RA		TCT profile knives (entire profile) finish grinding (Z 10 to Z 20)	920 074 01	n = 3.000 r.p.m. v = 24 m/s wet grinding
				930 042 002	
R 931	920 072 004 grit size D 46 bonding K + 888 RA		TCT profile knives (v-shaped patterns, small radii) finish grinding (Z 10 to Z 20)	920 074 01	n = 3.000 r.p.m. v = 24 m/s wet grinding
				930 042 003	

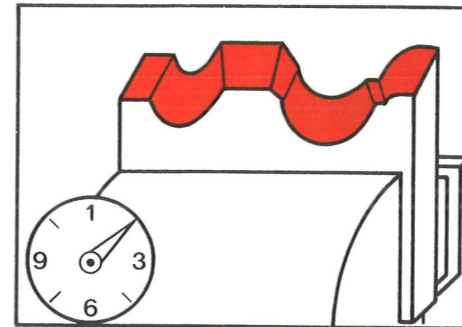
Use and application of borazon grinding wheels for HSS/stellite profile knives

Machine	designation	shape of grinding wheel	use and application	clamping flange	approx. value
				tracing pin	
R 931	930 062 007 grit size B 151 bonding KSS RY		HSS and stellite profile knives (entire profile) rough grinding	920 074 05	n = 3.000 r.p.m. v = 32 m/s wet grinding
				930 042 002	
R 931	930 062 008 grit size B 91 bonding KSS RY		HSS and stellite profile knives (sheer angles, corners and edges) finish grinding	920 074 05	n = 3.000 r.p.m. v = 32 m/s wet grinding
				930 042 002	
R 931	930 062 009 grit size B 91 bonding KSS RY		HSS and stellite profile knives (v-shaped patterns, small radii) finish grinding	920 074 05	n = 3.000 r.p.m. v = 32 m/s wet grinding
				930 042 003	
R 931	920 072 007 grit size B 64 bonding KSS 10 NA		HSS and stellite profile knives (entire profile) finish grinding (Z 10 to Z 20)	920 074 01	n = 3.000 r.p.m. v = 24 m/s wet grinding
				930 042 002	
R 931	920 072 014 grit size B 64 bonding KSS 10 NA		HSS and stellite profile knives (sheer angles, corners and edges) finish grinding (Z 10 to Z 20)	920 074 01	n = 3.000 r.p.m. v = 24 m/s wet grinding
				930 042 002	
R 931	920 072 009 grit size B 64 bonding KSS 10 NA		HSS and stellite profile knives (v-shaped patterns, small radii) finish grinding (Z 10 to Z 20)	920 074 01	n = 3.000 r.p.m. v = 24 m/s wet grinding
				930 042 003	



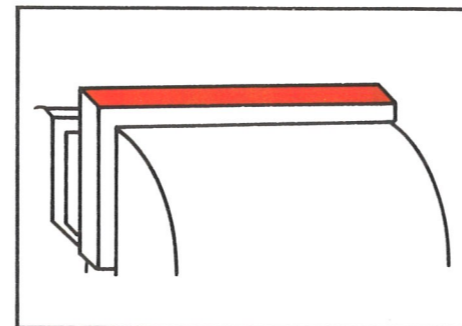
Rondamat 929

A **knife grinder** on which you can produce and regrind **profile knives**. On page 4.



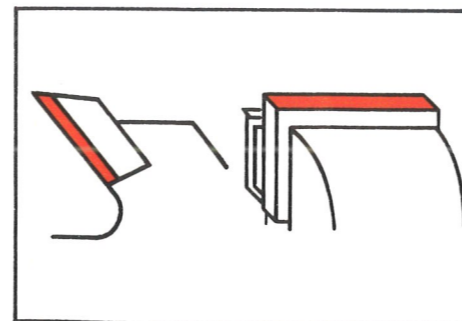
Rondamat 931

A **high-precision knife grinder** on which you can produce and regrind **profile knives**. On page 6.



Rondamat 909

A **high-precision tool grinder** for fully automatic grinding of **planing knives** in the planer head. On page 8.

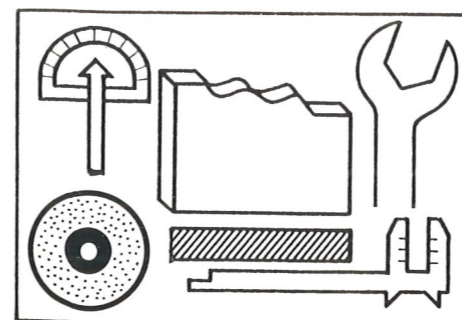


Rondamat 912

A **high-precision automatic grinder** for fully automatic grinding of **planer heads and solid cutters**. On page 10.

Accessories

These make your Rondamat a "jack of all trades". Tailored to your very specific requirements where grinding is concerned. See pages 13-17.



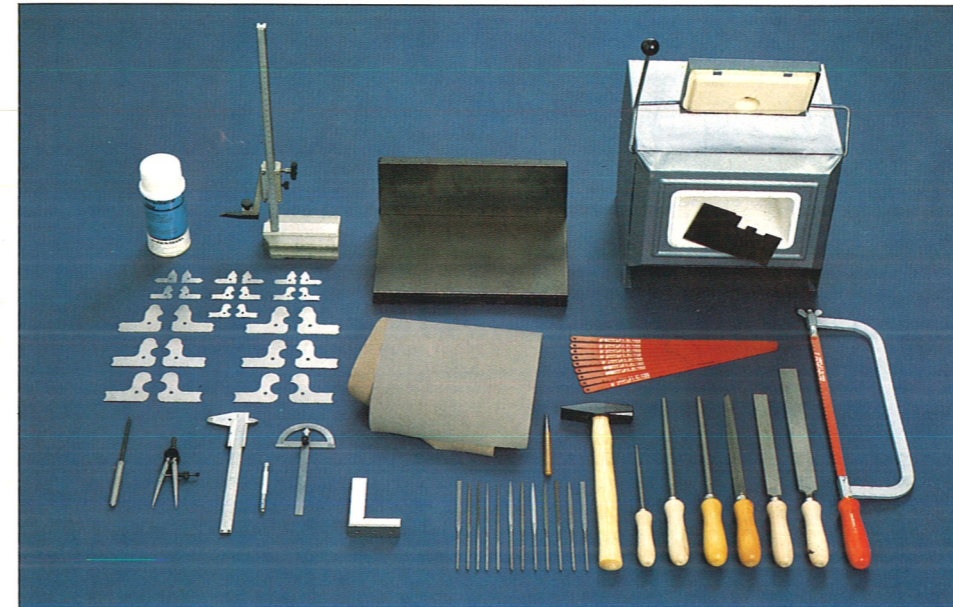
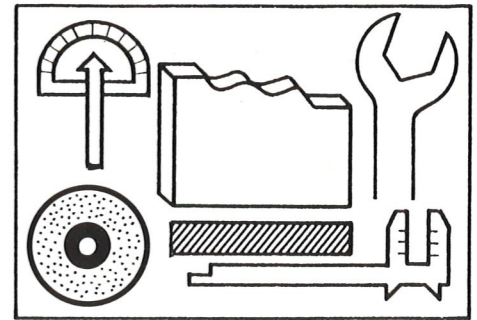
The low-cost model: Rondamat 929



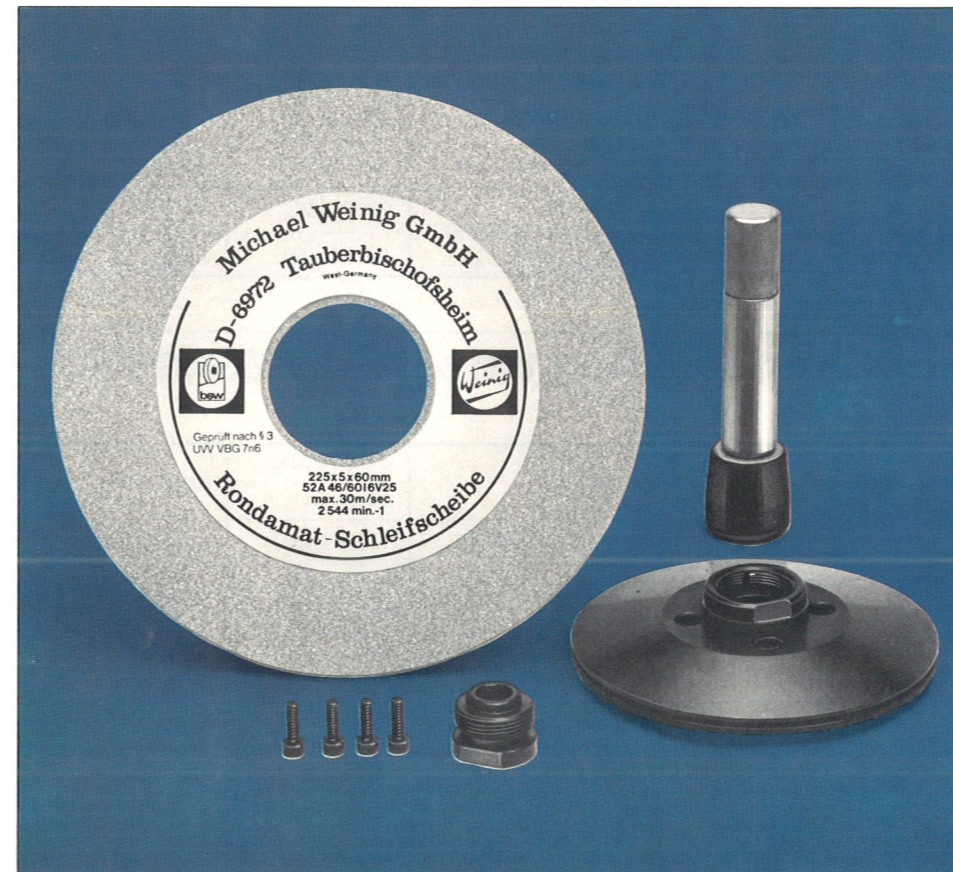
This is the most inexpensive way to produce your own profile knife. In your own factory, in a matter of minutes. From a straight blank. Any employee can do it. No special qualifications are required.

Thanks to the template. It guarantees true-to-profile grinding and resharpening. Over and over again with absolute accuracy.

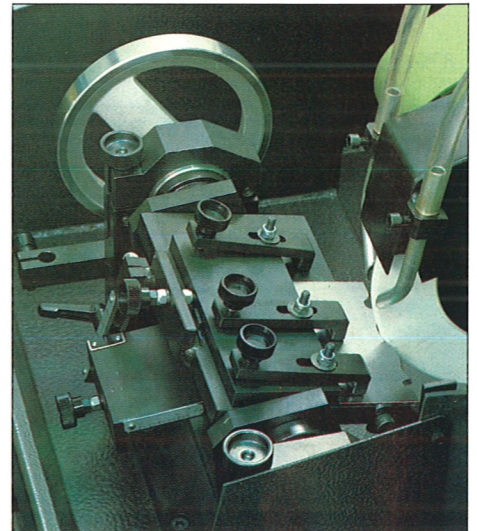
**Your tailor-made Rondamat.
Through
Rondamat accessories.**



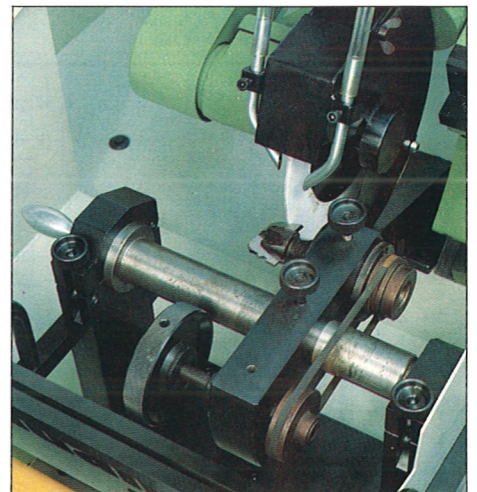
If your templates have to be precise and ready to hand, they must be produced with technically perfect tools. The Rondamat template tool kit includes everything, even the hardening oven. (Rondamat 929, Rondamat 931)



Grinding wheels (special fused alumina, diamond, borazon, etc.), flanges, grinding arbours. Important components for the tool production and maintenance.



You can even grind profile knives outside the cutterhead with this grinding attachment (Rondamat 929, Rondamat 931)



This attachment has been developed for grinding router bits on the Rondamat 931.

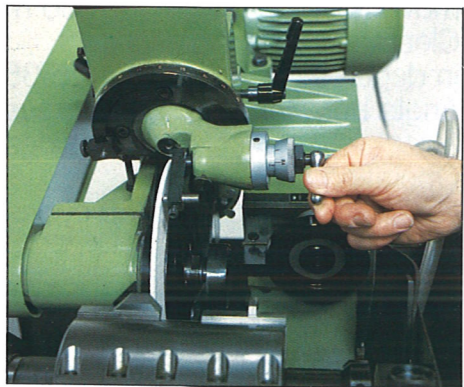
WEINIG OFFER MORE



It couldn't be easier. Control panel of the Rondamat 929.



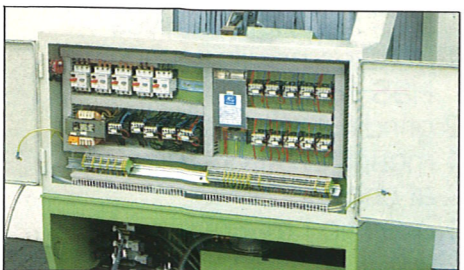
Re-set in a matter of minutes. The Rondamat 909.



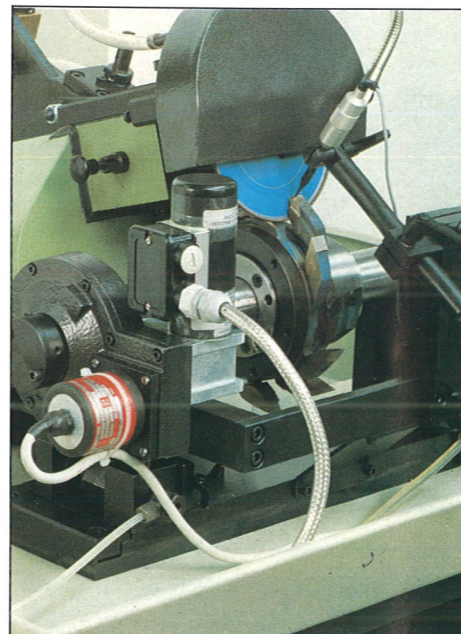
The dressing diamond ensures a precise grinding wheel. The Rondamat 931.



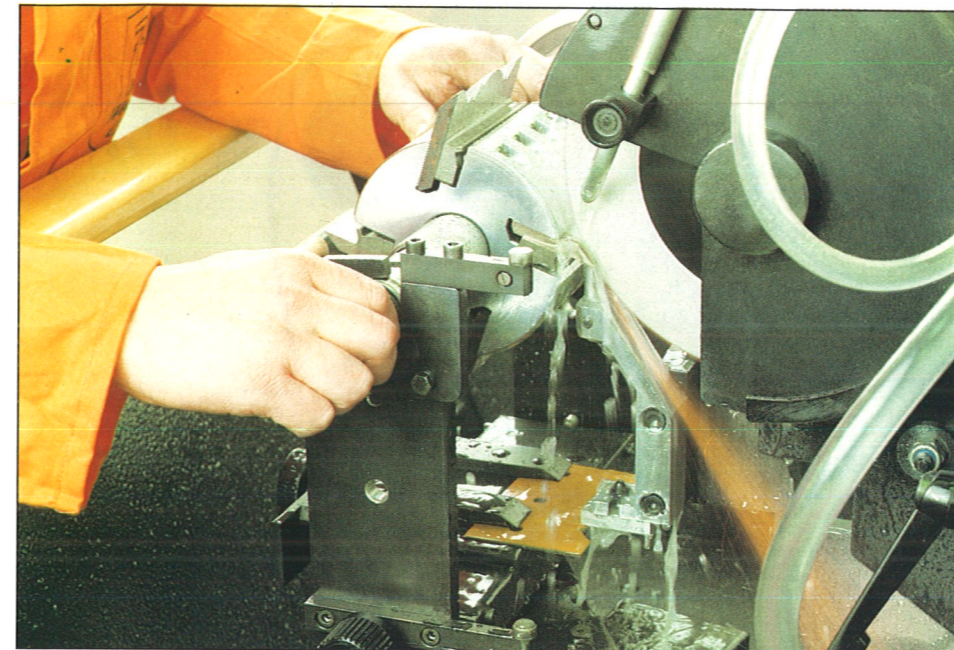
Infinitely variable grinding wheel speed. Standard feature on the Rondamat 931.



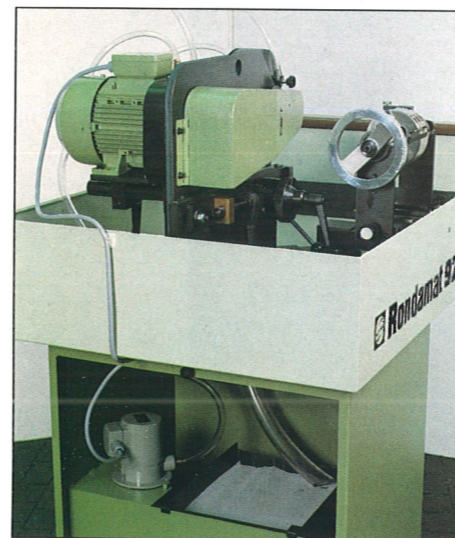
The heart of the Rondamat 912.



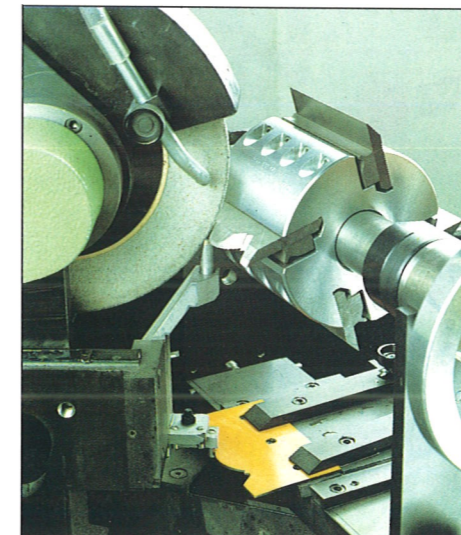
High precision limit switch for true concentric running when grinding solid cutters.



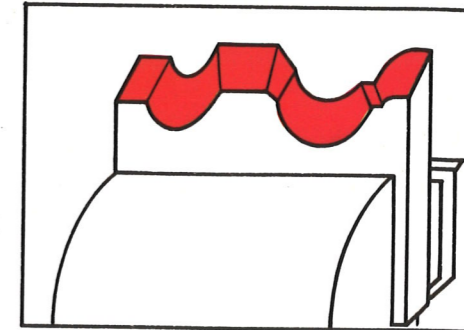
Easy to handle
Simple to operate



No overheating of the knives during grinding. The coolant system prevents this. The swarf is automatically filtered out and collected in the sediment tank.



The secret behind precision profile knives and their long service life in the moulder is the template with variable clearance angle and side relief adjustment.



Technical data:

(Subject to alterations)

Maximum grinding wheel diameter	225 mm
Grinding wheel width	5 mm
Grinding wheel bore	60 mm
Maximum tool diameter	300 mm
Minimum tool diameter	100 mm
Maximum tool width	230 mm
Grinding wheel drive	1.1 kW (1.5 HP)
Motor speed per minute	n = 1,410 r.p.m.
Grinding spindle speed	n = 1,700 r.p.m.
	n = 2,000 r.p.m.
	n = 2,250 r.p.m.
	n = 2,800 r.p.m.

Radial clearance angle in degrees	20-40
Motor for coolant pump	0,065 kW (0,088 HP)
Coolant tank capacity	approx. 90 litres
Total connected load	1.5 kW (2 HP)
Standard voltage	380 volts, 50 cycles

Machine dimensions:

Maximum height	1,300 mm
Maximum width	750 mm
Maximum depth	1,000 mm
Weight (without coolant)	approx. 250 kg

Accessories:

- 7 grinding wheels for pre-grinding
- 3 grinding wheels for finish grinding
- 2 grinding wheel adaptors
- 1 grinding arbour, diameter at choice
- Template material
- 1 operating manual
- Operating tools

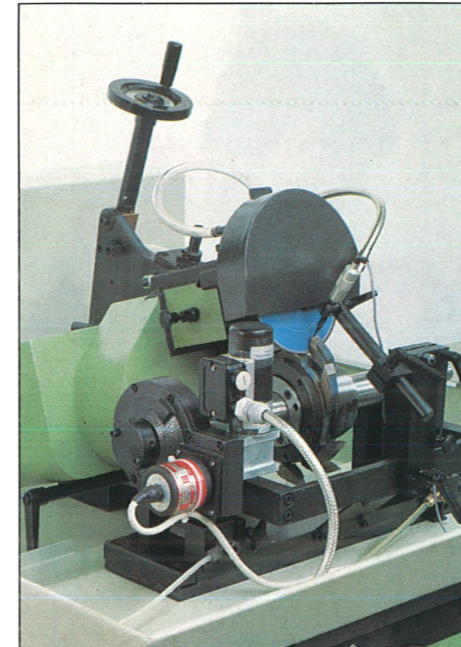
The bestseller: Rondamat 931



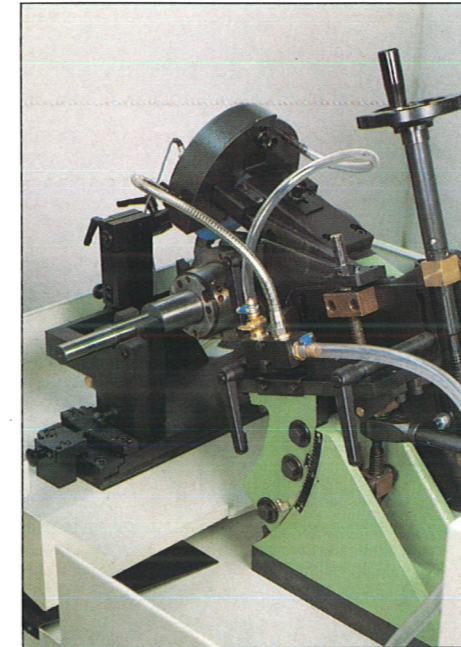
In a very short time this high precision model became the most popular knife grinding machine. Maximum tolerance in concentric running less than **5/1000 mm**. This makes it indispensable in any modern grinding shop.

It will grind HSS, stellite or carbide-tipped knives with maximum precision. The Rondamat forms an integral part of the Weing Hydro System.

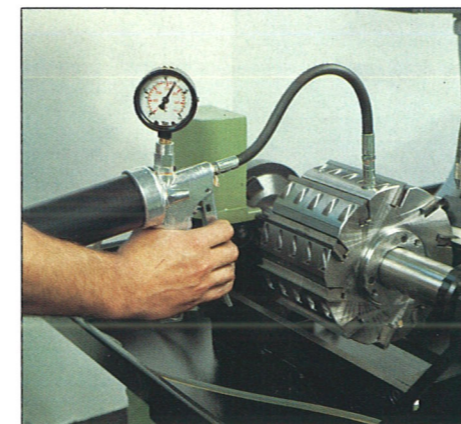
Hydro profile cutterheads should only be ground on this machine. It is the only way to ensure the degree of precision you need for jointing knives.



Maximum precision: grinding a Hydro cutter



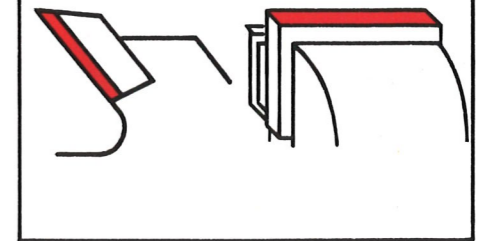
Extremely fast: re-setting the Rondamat 912 from planer head grinding to solid cutter grinding.



Clamping a Weing Hydro head on the automatic grinder. Grinding precision becomes cutting precision on the moulder.



Clear, distinct design: control desk with sheet-covered keyboard and digital display.



Technical data:

(Subject to alterations)

Maximum tool length	standard version	260 mm
	special version	430 mm
Maximum tool diameter		280 mm
Minimum tool diameter		80 mm
Grinding spindle speed		n = 4,600 r.p.m.
Grinding motor		1.1 kW (1.5 HP)
		n = 2,850 r.p.m.
Grinding wheel diameter for cutterheads		125 mm
Grinding wheel diameter for solid cutters		150 mm
Grinding wheel bore		20 mm
Hydraulic unit		0.37 kW
		Contents 8 litres
Coolant system		0.065 kW (0,088 HP)
		Contents 100 litres
Feed speed		infinitely variable
Maximum table movement		500 m
Clearance angle in degrees		15-35
Angle between axis		15 degrees on both sides
Operating voltage		380 volts, 50 cycles

Machine dimensions:

Height	approx.	1,460 mm
Width	approx.	1,400 mm
+ table movement		500 mm
Depth	approx.	1,400 mm
Weight (without coolant)		900 kg
Colour:		RAL 6011 green
		RAL 7032 grey

Accessories:

- 1 Borazon grinding wheel for HSS and stellite knives
- 1 Borazon grinding wheel for HSS cutters
- 2 grinding wheel adaptor
- 1 mounting arbour, diameter at choice
- 1 operating manual
- Operating tools

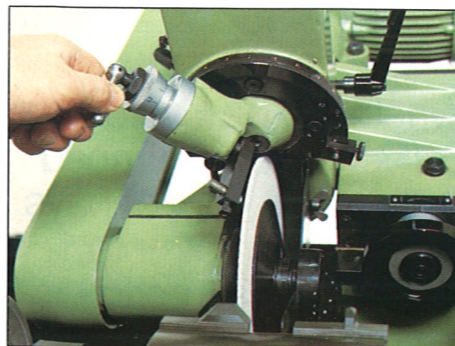
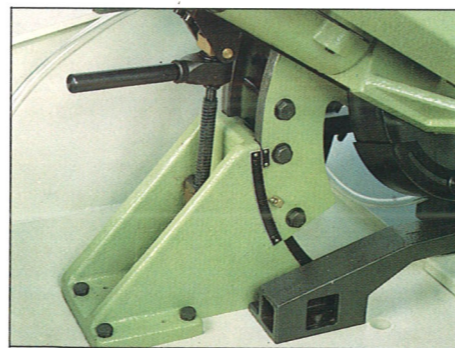
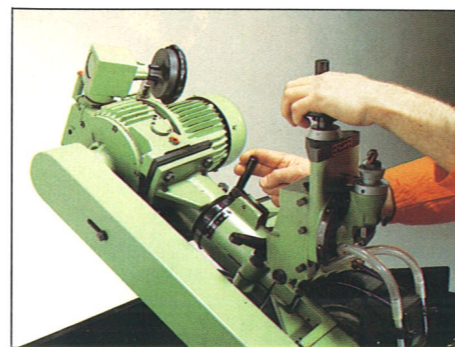
The grinding centre: Rondamat 912



This automatic grinder is a superlative among numerically controlled grinding machines. It is of particular advantage if you have to keep both planer heads and solid cutters sharp. Fully automatic grinding in the head for true concentric

running of planing knives and solid cutters. You need this highly sophisticated automatic grinder as an integral part of the Weinig Hydro System if you have to grind solid cutters as well.

It is electronically controlled and simple to operate with a keyboard, transparent sheet and digital read-out.

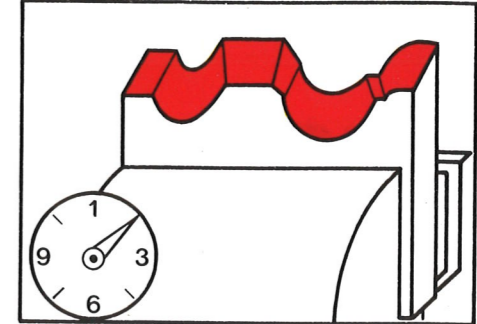


Effortless grinding. Absolute accuracy is guaranteed by the floating linear table.

Side relief is adjustable up to 20 degrees right and left. An important benefit being that re-dressing is not required between changing relief angles.

Flexibility: adjustments of between 10 and 30 degrees are available for back clearance.

Safety: the wheel is dressed well above the cutterhead, swarf, coolant and grinding wheel.



Technical data:

(Subject to alterations)

Maximum grinding wheel diameter	225 mm
Grinding wheel width	5 mm
Grinding wheel bore	60 mm
Maximum tool diameter	290 mm
Minimum tool diameter	90 mm
Maximum tool width	230 mm
Grinding wheel drive	1.1 kW (1.5 HP)
Motor speed per minute	n = 1,410 r.p.m.
Grinding spindle speed, infinitely variable	n = 500-3,000 r.p.m.
Radial clearance angle in degrees	10-30
Axial clearance angle in degrees	8-20
Coolant pump drive	0,065 kW (0.088 HP)
Coolant tank capacity	approx. 100 litres
Total connected load	1.5 kW (2 HP)
Standard voltage	380 volts, 50 cycles

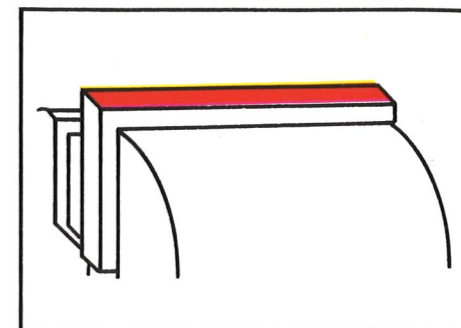
Machine dimensions:

Maximum height	1,650 mm
Maximum width	1,400 mm
Maximum depth	1,120 mm
Weight (without coolant)	approx. 440 kg

Accessories:

- 7 grinding wheels for pre-grinding
- 3 grinding wheels for finish grinding
- 2 grinding wheel adaptors
- 1 grinding arbour, diameter at choice
- Template material
- 1 operating manual
- Operating tools

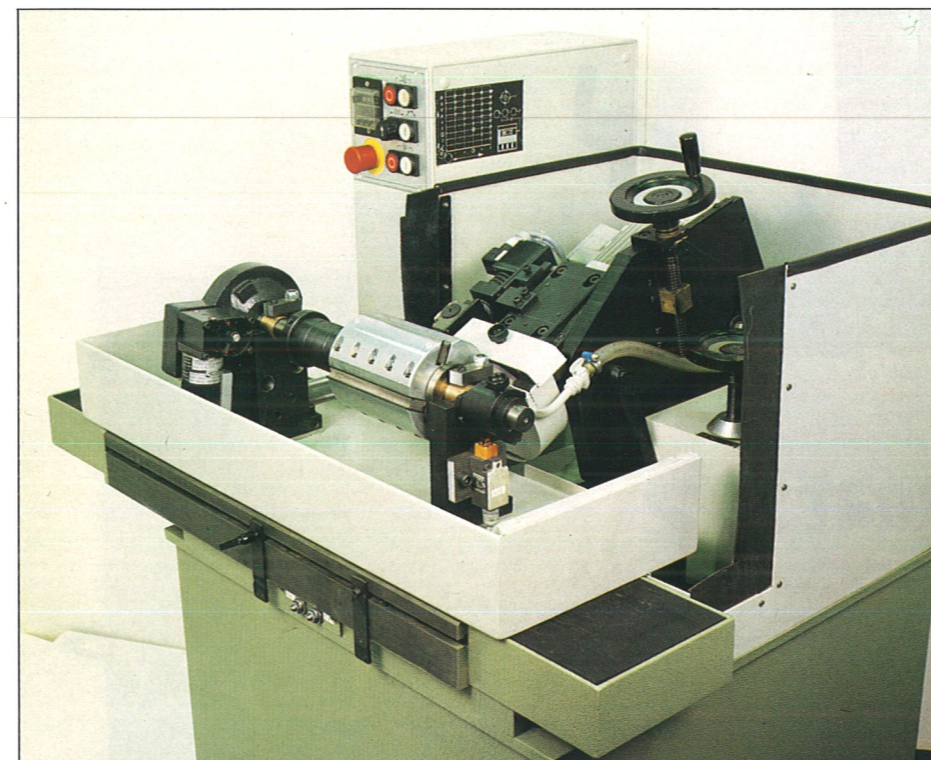
The super accurate: Rondamat 909



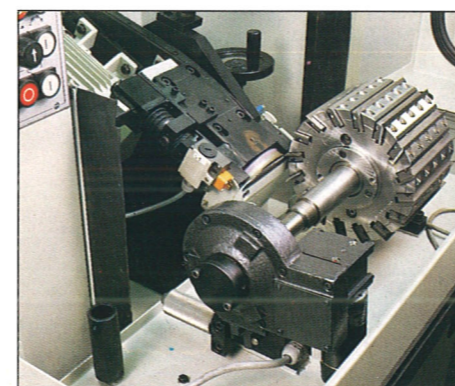
This automatic grinder grinds planing knives in the planer head. This guarantees maximum precision, top quality surface finish and long tool life. The Rondamat 909 is a fully automatic grinder and thus cuts personnel costs.

The maximum concentricity tolerance of **5/1000 mm** ensures frequent rejoining of the knives on high-speed machines.

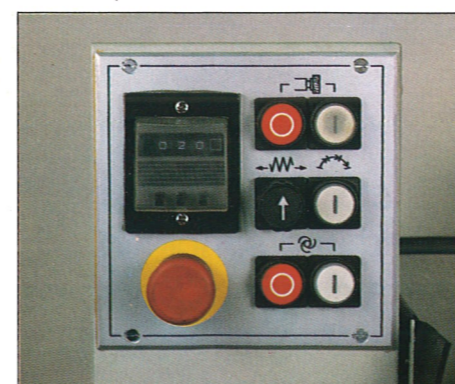
Whether it be Hydro or conventionally clamped tooling, this grinder pays its way with both precision and peak performance.



Fully automatic grinding of conventional planer head in a minimum of time.



Concentric grinding of a Hydro-Rota-plan cutterhead with 16 knives.



Clearly visible at the switch panel: this grinder is easy to handle.

Technical data:

(Subject to alterations)

Maximum length of tooling	330 mm
Maximum tool diameter	225 mm
Minimum tool diameter	85 mm
Radial clearance angle in degrees	15-35
Grinding spindle speed	n = 4,600 r.p.m.
Grinding wheel diameter	125 mm
Grinding wheel bore	20 mm
Motor rating, grinding wheel	1.1 kW (1.5 HP)
Motor rating, feed	0.053 kW (0.07 HP)
Motor rating, dividing attachment	0.033 kW (0.04 HP)
Coolant pump	0.065 kW (0.09 HP)
Coolant tank capacity	125 litres
Grinding speed	650 mm/min.
Freely selectable number of grinding passes per knife	1-5
Total connected load	1.5 kW (2.1 HP)
Operating voltage	380 volts, 50 cycles

Machine dimensions:

Height	1,200 mm
+ table movement	430 mm
Width	1,150 mm
Dept	820 mm
Weight (without coolant)	400 kg

Accessories:

- 1 Borazon grinding wheel for HSS and stellite knives
- 1 grinding wheel adaptor
- 1 mounting arbour, diameter at choice
- 1 operating manual
- Operating tools