

圆锯片使用说明书

1. 作业环境

- 机械要安装保护罩，防止因锯片破损、碎片飞散等造成伤害。
- 作业场所应远离易燃、易爆品。



2. 服装、防护用具

- 作业者必须佩戴保护眼睛，防止因锯片破损、碎片飞散等造成伤害。
- 作业者必须注意领带及袖口，不能戴手套，长发要置于工作帽内，防止被卷入机器，发生危险。

3. 使用前的准备

- 确保设备状态量好，主轴无变形、无振动，轴径公差为h7（图1）。
- 锯片上不能有任何附着物，刀尖的欠损及脱落的有无也需要确认。
- 锯片基体的裂缝，歪曲，异常磨损等的有无也需要确认。如果发现这些异常情况不可继续使用。
- 锯片必须在正确用途以内使用。

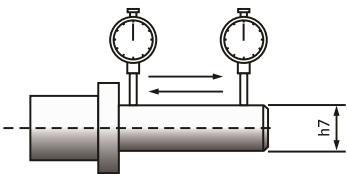


图 fig. 1

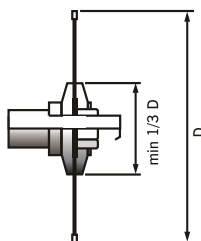


图 fig. 2

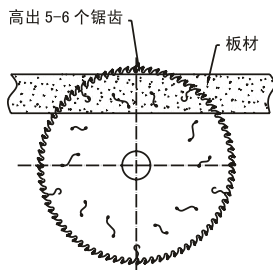


图 fig. 3

4. 安装

- 确保锯片回转方向与机器主轴回转方向一致。
- 选择内径与锯片内径一致、外径为锯片外径1/3略大（多片锯宜采用锯片外径1/2）的法兰盘，确认其无异常磨损、弯曲变形、表面洁净无异物附着（图2）。
- 保证锯片内径与机器轴径之间无大间隙，安装好法兰盘，拧紧螺母。
- 空转状态下产生异常噪音及异常振动，应立刻停止使用。
- 锯片的再加工（内径修正、定位孔加工等）必须由厂方进行。如果加工不良，会影响产品使用效果，并且可能发生危险。
- 安装时，一般锯片高出板材5-6个锯齿为宜（图3）。
- 锯片扩孔不能超过原内孔尺寸20mm（图4）。

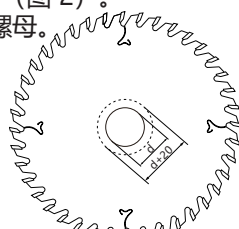


图 fig. 4

5. 使用中

- 旋转速度禁止超出锯片上标明的最高转速（N.max）。
- 切削材料需要充分固定，否则可能导致锯片破损、碎片飞散、夹刀，发生意外事故。
- 如果锯片在使用过程中产生异常噪音及异常振动，应立刻停止使用，否则可能发生意外事故。

6. 使用后

- 当锯片不锋利时必须及时研磨。否则可能损坏锯片和设备。
- 锯片研磨必须由可信赖的专业厂家进行，不能改变原角度，推荐使用全自动数控设备研磨（图5）。



图 fig. 5

Instruction Manual of Circular Saw Blade

1. Operating Conditions

- Machine cover is essential to minimize the injuries caused by broken blades.
- Flammables and explosives should be kept away from the workshop.

2. Safety Measures

- Wear glasses while working to prevent from injuries by broken blades.
- Watch out for your ties and sleeves. Long hair should be kept inside the cap, and no gloves are allowed during operation.

3. Before Use

- Ensure the machine are in good condition with no deformation and no spindle vibration, the spindle's running tolerance can be h7(fig. 1).
- Check if there is any material adhesion, edge chipping or defect on the blade.
- Cracking on body, distortion and abnormal wear must be checked as well. Never use the blade if those defects are found.
- Do not use the sawblade for improper purposes.

4. Installation

- Ensure sawblade turns in the same direction as the shaft of the machine does.
- The flange's outer diameter should be a little larger than 1/3 (for multi-rip sawblade is 1/2) of the sawblade. Ensure the flange is clean, not over worn, bent and distorted shape(fig. 2).
- Check the tolerance between the sawblade and the spindle. Install the flange and fasten the screw.
- Run the sawblade without work, if there is abnormal noise and vibration, shut down the machine immediately.
- Sawblade reprocessing such as reboring, should be finished by the factory. Poor reprocessing would lead to poor quality and may cause injuries.
- While installation, the sawblade should be 5-6 teeth higher than the workpiece surface(fig.3).
- Maximum reboring of the blade is 20mm of the original bore size. (Fig.4).

5. In Using

- RPM must be below the maximum RPM (N.max) shown on the sawblade.
- Clamp workpiece firmly. Inadequate clamping could cause the material chipping and flying out, and jamming for possible injury.
- In case of unusual noise or vibration while using, shut down the machine immediately, or it may cause injuries.

6. After Use

- Resharpener is necessary when the blade is no longer sharp, or the blade and machine could be damaged.
- Resharpener should be accomplished by the certified professional factories, the original angle degree is not allowed to change(fig. 5).