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。

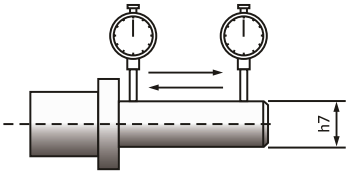

图 fig. 1

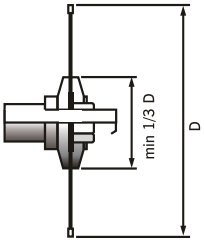

图 fig. 2

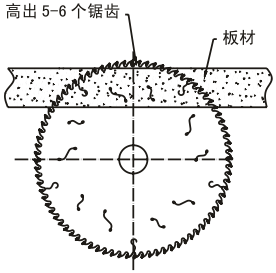

图 fig. 3

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）。

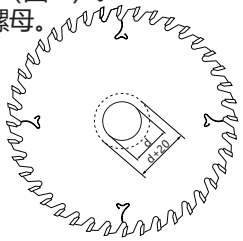

图 fig. 4

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。

图 fig. 5

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）。

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 dring 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

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