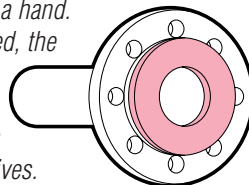




The Circular Slitting Saw Equipment from Klinger

With a Klinger circular slitting saw you are equipped for any emergency. You can manufacture rings, collars, hoops and bands from 80 mm to 1250 mm diameter in all gauges – at the turn of a hand. And if required, the equipment can be supplied with motorised drives.





Making the equipment operational

First adjust the centring bolt **1** to the size of the required circular slitter. For this purpose, employ the incorporated tape line, by attaching it to the centring bolt. The set radius can be read off the slitter position.

Insert the slitter substrate on the centring bolt and set the slitting depth on the small hand wheel **2** so that the slitter just cuts into the substrate but does not touch the counter roller in the rail. This setting should then be secured with the counter nut.

Thereafter, turn the slitter height back to the initial position.

Slitting routines

You can now commence the circular slitting operations. A centring boring has already been tapped into the small plate with the punch supplied.

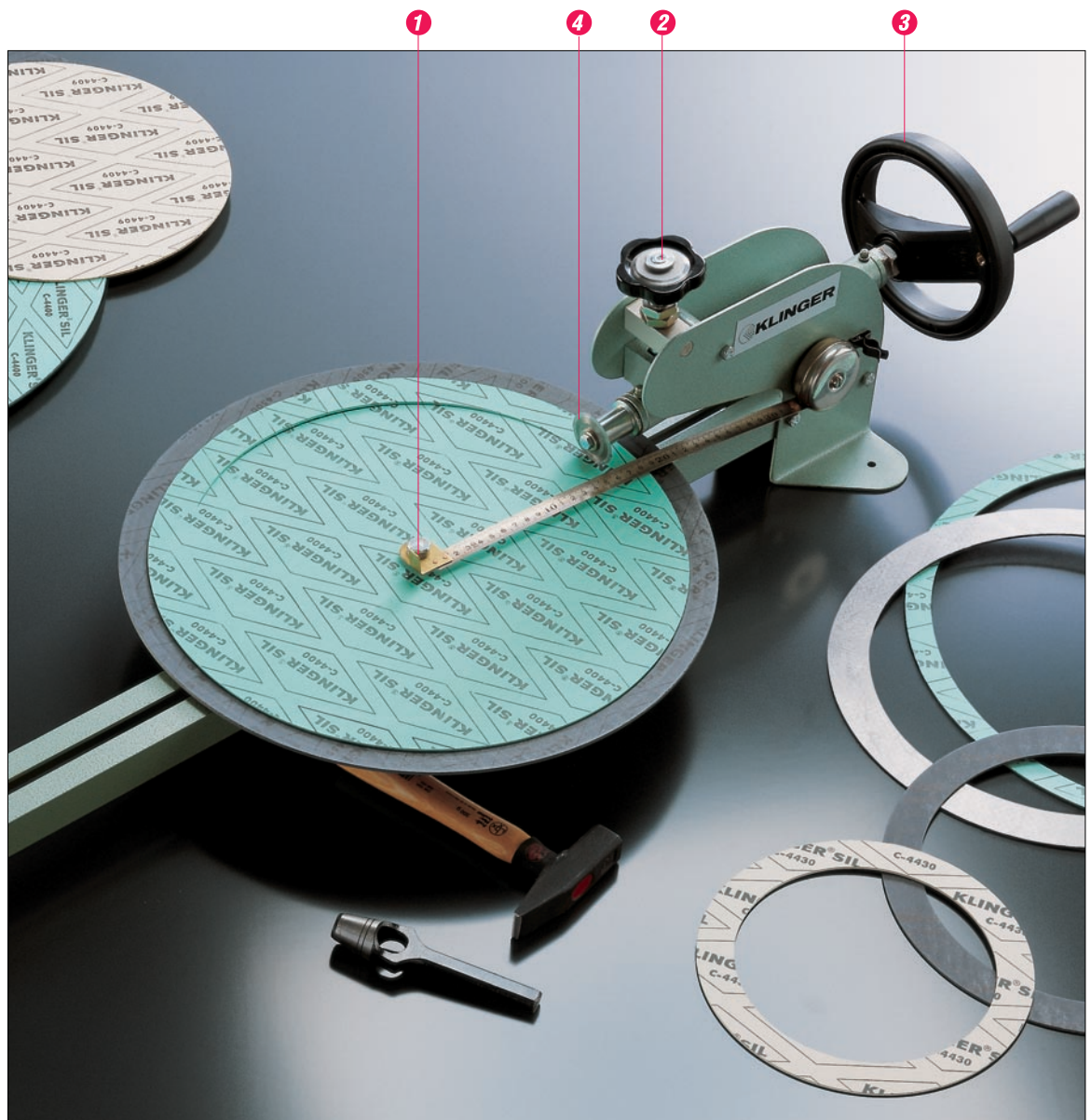
By turning the large hand wheel **3**, the circular slitter **4** can then be moved together with the small plate. The depth the slitter can be engaged stage by stage by means of the small hand wheel per turn of the workpiece depends on the gauge and the hardness of the plate presented. The ideal gauge is between 0.5 and 2.0 mm.

With experience the operator will increasingly obtain a feeling for the correct engagement.

A few tips from practice

When slitting circular features in excess of 750 mm exterior diameter, the edges of the plate cut should be removed, so that the workpiece can be turned without hinderance.

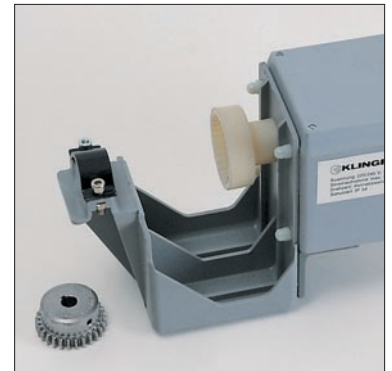
In cases of circular features over 3 mm gauge, it is advisable to turn the workpiece after slitting through half of the thickness and recommence and complete the work from the opposite side.



Cut Rings – manufactured in house – in one quick cut, with or without a motorised drive

Replacement slitters and servicing

The circular slitter is disposable. You can grind it back into condition or merely dispose and replace it. The slitter supplied is found on the small hand wheel and is attached by a central screw. The slitter drive shaft should preferably be greased at regular intervals. There are two nipples available for greasing routines.



Simple and rapid installation of the electric drive facility

The following service routines apply both to initial installation of the circular slitter with the electric drive facility or when re-equipping the motor.

First, remove the crank on the large hand wheel. This enables the subsequent installation procedure for the connection of the motor drive facility.

Thereafter, the toothed pinion supplied should be fixed to the free shaft end of the large hand wheel*. The stud screw should be screwed into the boring on the shaft.

The electric drive motor is then to be attached by means of sliding the internally toothed plastic coupling onto the toothed pinion, so that the holder arm grips around the shaft drive of the circular slitter saw from below.

After closing and securing the clamp, a firm fixture is obtained between the equipment and the electric drive motor and the installation is complete. The lower illustration shows the operational status of the equipment.

When conducting motorised slitting operations, care should be taken to ensure that the equipment is off-

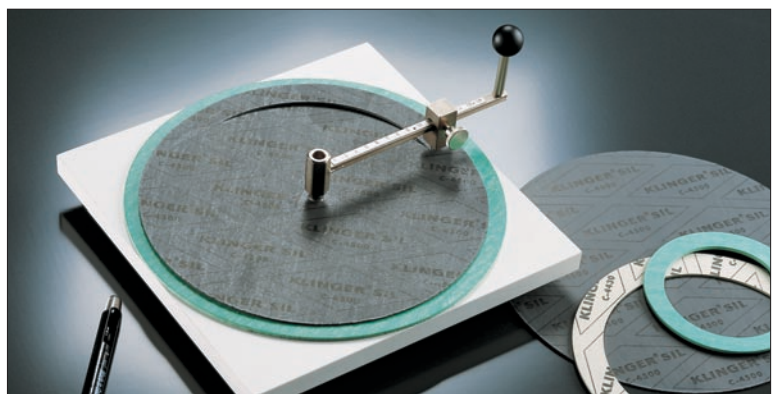
red up to the work slowly, otherwise the electric drive motor can stall.

Ensure that the transparent protective cap covers the circular slitter under motorised work conditions. Otherwise there is a hazard of bodily injury, e.g. when slipping off the small hand wheel.

* The circular slitter shaft in the older models of the equipment will have to be replaced.

Our "tiny one" for rapid servicing work on customer workshops

The "tiny one" is ideal for mobile workshops. It is easy to transport, quick to install and simple to handle and comes equipped with slitting work face, centering bolt, slitter and slitter callipers. The equipment can be employed to process all work from 300 mm outside diameters to 25 mm inner diameters.



The slitting substrate supplied is of 3 mm gauge and has a diameter of 400 mm. Diameters available are 400 mm, 700 mm and 1270 mm.

New:
Circular slitters
of specially hardened steel

Dimensions and weights

Equipment	without drive	with drive
Length max.	1,100 mm	1,200 mm
Height max.	250 mm	250 mm
Width max.	170 mm	170 mm
Weight	6.5 kg	9.3 kg

Drive facility

Voltage	220/240V 50 cycles
Power rating	50 W, 0.23 A
Drive shaft revolutions	53 rpm
MCB protection	IP 54
Overloading MCB, automatic	thermal triggering
Slitting speed, dependent on workpiece and gauge	5.5 – 6.5 m/min

Working application

Min. circular feature diameter, dependent on gauge	approx. 80 mm
Max. circular feature diameter	1,250 mm
Circular feature width, dependent on type of workpiece	up to 1 mm
Circular feature width max.	160 mm
Slitting depth, dependent on type of workpiece	up to 9 mm

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DIN EN ISO 9000:2000.**

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