

Technical manufacturing

Tips of processing

Semi-finished products can be processed using timber and metal processing machinery without any difficulties. The sharpness of the tools used and good removal of the chips is important.

Grinding or polishing semi-finished products is not recommended as a greasing effect occurs due to overheating.

Our technicians are available for any further questions.

PE500/1000	SAW	PLANE	TO BORE	TO MILL	TURNING ON A LATHE
TOOLS	-Circular saws -Saw sheets with hard metal -Ribbon saws: HSS	HSS or HM	Spiral shaped bit HSS or HM	HSS or HM	HSS or HM
CUTTING SPEED	Circular saw: 3.000-4.000 m/min Ribbon saw: 1.000-2.000 m/min	3.000M/MIN	15-10 m/min	1.000-2.000m/min	100-600 m/min
FEED	0,1-0,2 mm, per tooth	0,1-0,2 MM, per rotation	0,1-0,3 mm	Ca. 0,5 mm	0,2 -0,5 mm
EFFECTIVE CUTTING ANGLE	-circular saw: 5°-8° -ribbon saw: 3°-6°	20°	15°-25°	5°-15°	15°-25°
RELIEF ANGLE	-circular saw: 10°-15°	20°	Angle of twist : α_2 :ca. 15° apical angle: α_1 : ca. 130°	5°-15°	5°-15°

WELDING

Stump welding procedure: the areas to be welded are heated at the heating mirror at 200 to 220 °C using low pressure level until a layer of ca. 4 mm has become elastic. The surfaces are pressed at a pressure level of 10 to 20 kp/cm².