

Rodaj banda bimetal

Rodajul corect are o mare importanta in durata de exploatare a benzilor bimetal

Se procedeaza astfel :

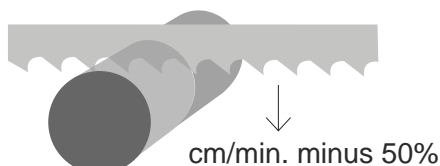
Pasul 1

Inainte de inceperea debitarii, alegeti viteza benzii Vc (m/min) si avansul de taiere Vz (cm/min) corespunzatoare materialului.

Pasul 2

Porniti ferastraul si reduceti viteza benzii cu cca. 1/3 si avansul cu 1/2. (ex.: daca in mod normal viteza benzii este de 60 atunci o reduceti la 40, iar daca avansul este de 40 atunci il reduceti la 20) Apasati START, ferastraul incepe sa debiteze.

→ m/min. minus 30%

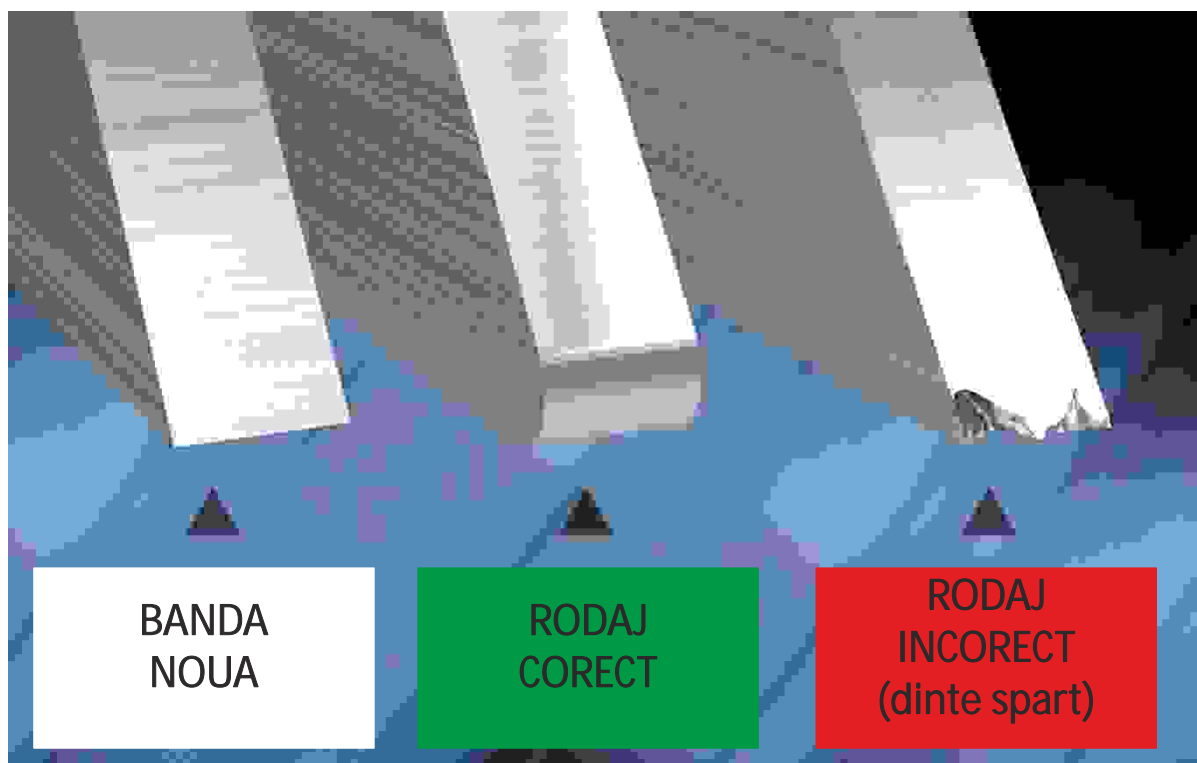


Pasul 3

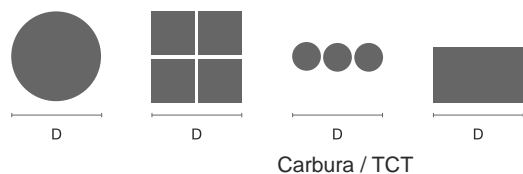
Daca apar vibratii in timpul debitarii, modificati cu atentie cele doua valori pina cand vibratiile dispar. Formarea continua si permanenta de span este importanta pe durata rodajului.

Pasul 4

Dupa cca. 400-600 cm² sau min. 15 min. de debitare efectiva a tuburilor/profilelor, puteti mari usor intai viteza benzii si apoi avansul pina cand ajungeti la valorile recomandate pentru materialul care se debiteaza.

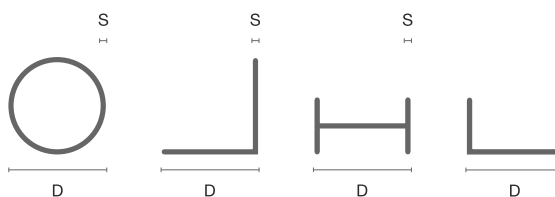


Material Plin Recomandare dintare



D	tpi	D	tpi	D	tpi
< 10 mm	14	< 25 mm	10/14	50 - 120 mm	3/4
10 - 30 mm	10	15 - 40 mm	8/12	100 - 250 mm	2/3
30 - 50 mm	8	25 - 50 mm	6/10	150 - 400 mm	1,5/2
50 - 80 mm	6	35 - 70 mm	5/8	350 - 600 mm	1,1/1,6
80 - 120 mm	4	40 - 90 mm	5/6	> 500 mm	0,85/1,15
120 - 200 mm	3	50 - 120 mm	4/6		
200 - 300 mm	2	80 - 150 mm	3/4		
300 - 700 mm	1,25	130 - 350 mm	2/3		
> 600 mm	0,75	150 - 450 mm	1,5/2		
		200 - 600 mm	1,1/1,6		
		> 500 mm	0,75/1,25		

Tuburi si Profile Recomandare dintare



Grosime perete S (mm)	Diametru exterior									
	20	40	60	80	100	120	150	200	300	500
2	14	10/14	10/14	10/14	10/14	8/11P	8/11P	8/11P	8/11P	5/7P
3	14	10/14	10/14	8/11P	8/11P	8/11P	8/11P	5/7P	5/7P	5/7P
4	10/14	10/14	8/11P	8/11P	8/11P	5/7P	5/7P	5/7P	5/7P	4/6P
5	10/14	10/14	8/11P	8/11P	5/7P	5/7P	5/7P	4/6P	4/6P	4/6P
6	10/14	8/11P	8/11P	5/7P	5/7P	5/7P	5/7P	4/6P	4/6P	4/6P
8	10/14	8/11P	8/11P	5/7P	5/7P	5/7P	4/6P	4/6P	4/6P	4/6P
10		8/11P	5/7P	5/7P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P
12		8/11P	5/7P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P
15		8/11P	5/7P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P
20			4/6P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P	3/4P
30				4/6P	4/6P	4/5P	4/6P	4/6P	4/6P	2/3P
50							4/6P	3/4P	2/3P	2/3P
80								3/4P	2/3P	2/3P
>100									2/3P	1,5/2