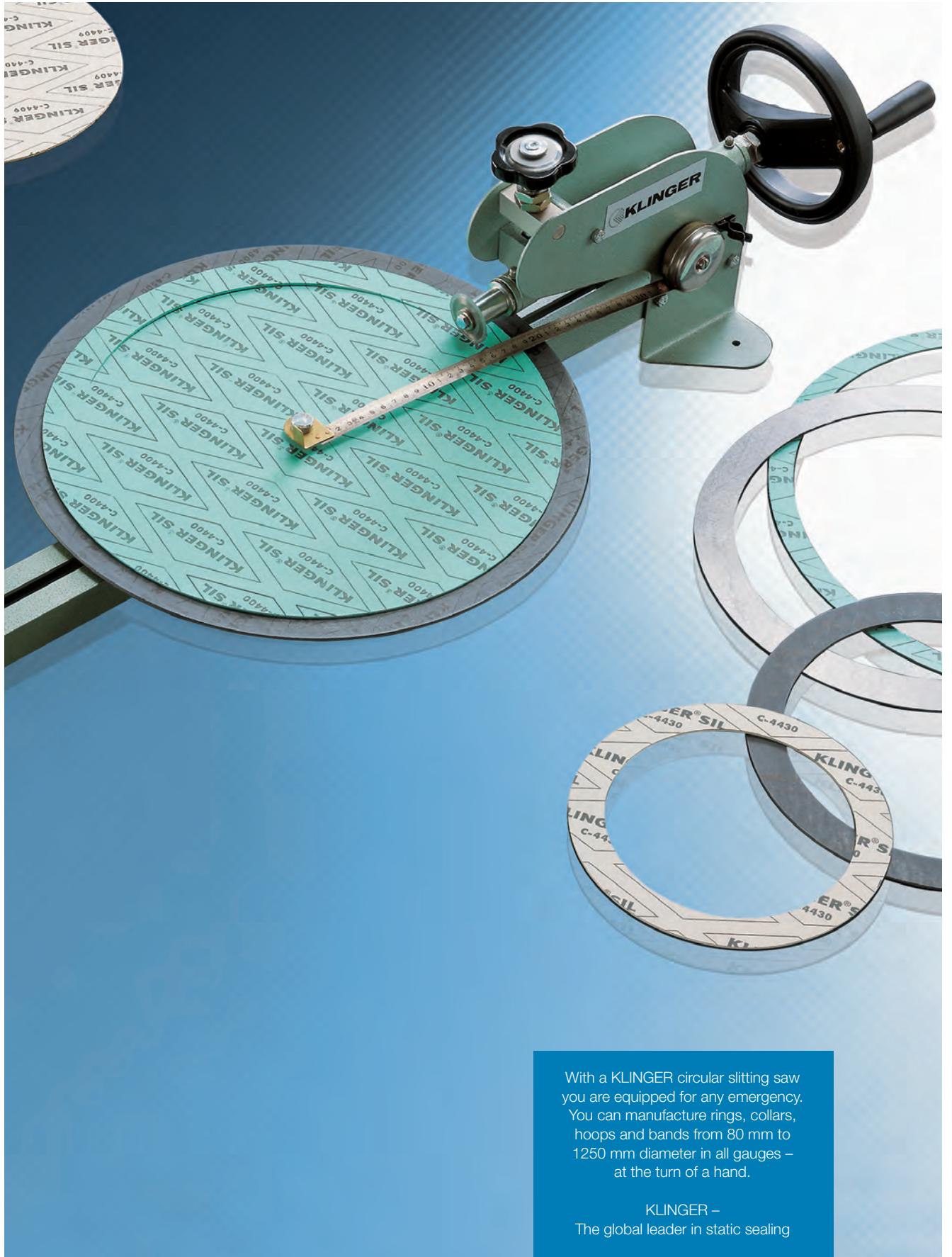


KLINGER® Circular Slitting Saw

Cut rings “quickly yourself”



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.

KLINGER –
The global leader in static sealing

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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 to 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.

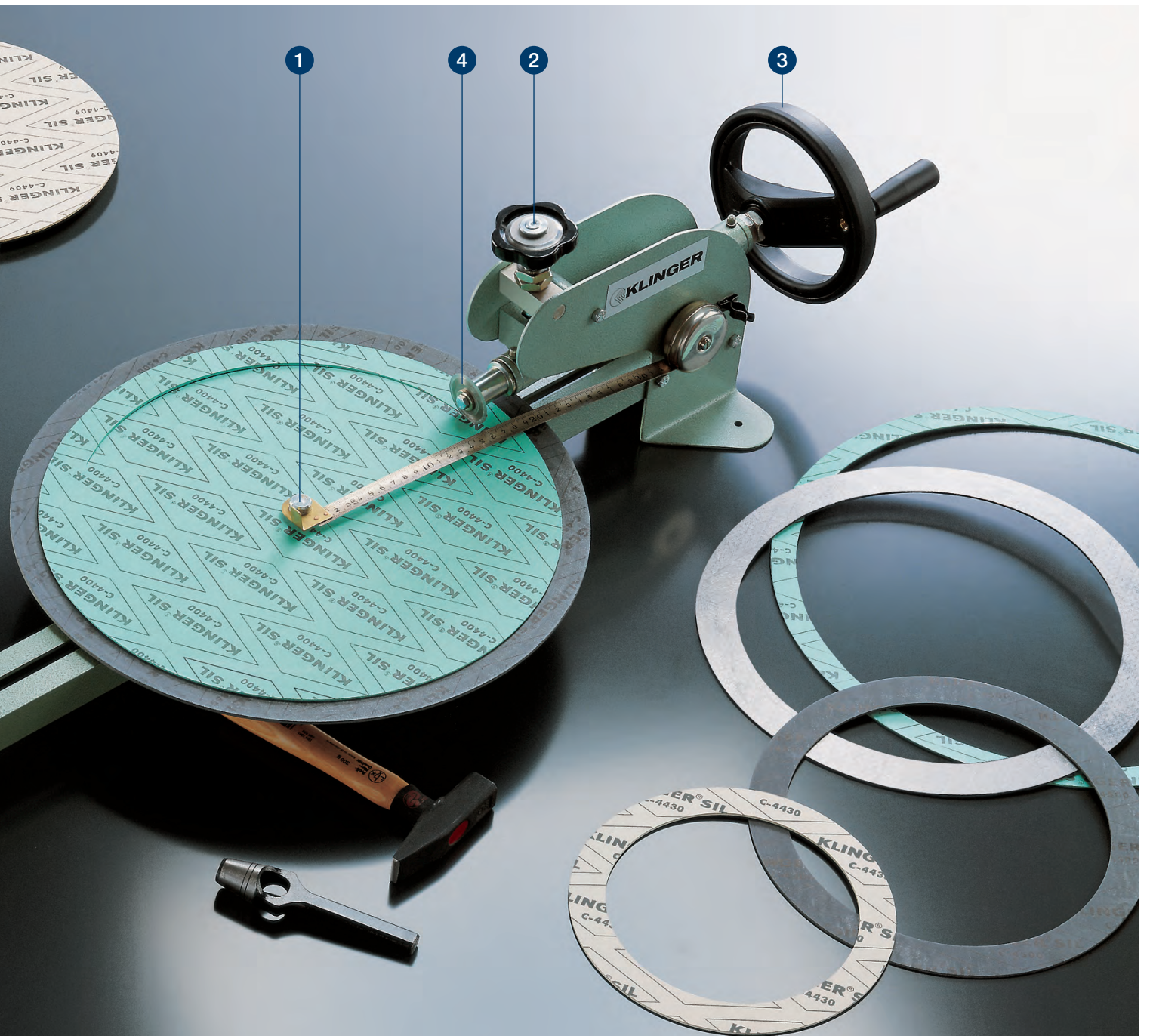
A few tips from practice

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.



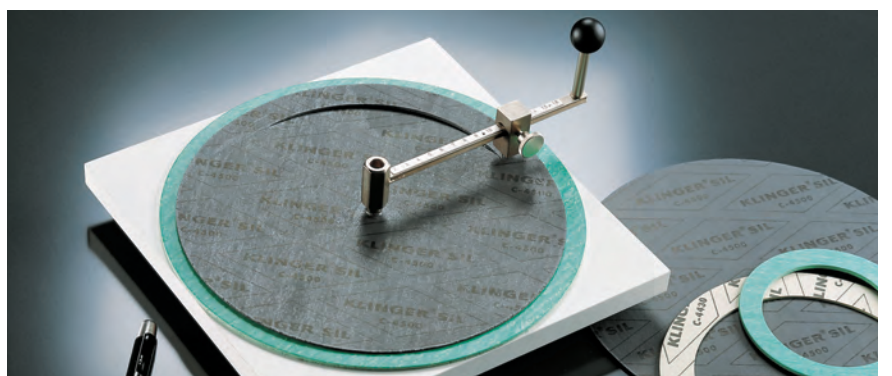
Replacement slitters and servicing

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.



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.



KLINGER® Circular Slitting Saw

Technical specifications at a glance

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

The ring cutting machine was originally developed for cutting gasket sheets without a metallic insert, such as KLINGERSIL® or KLINGER®topchem products.

In principle, it is also possible to cut gasket sheets with a spit sheet insert, such as KLINGER®graphite laminate and KLINGER®milam.

However, increased wear of the cutting wheel must be expected.

The cutting result is also influenced by the skill of the respective user.

Practical tip:

In general, it is important not to press the cutting blade with the setting wheel by the material to be cut when starting to cut. First, let the blade make a slight cutting groove in the surface. This creates a certain amount of guidance. Then you can set the cutting blade a little deeper and a further turn of the plate leads to penetrating a little deeper into the material. Proceed in this way step by step and cut deeper and deeper into the material- but always cut around after each feed!

This procedure ensures that the guide hole in the center of the plate is not widened, which would result

Dimensions and weights	
Length max.	1100 mm
Height max.	250 mm
Width max.	170 mm
Weight	6,5 kg
Working application	
Min. circular feature diameter, dependent on gauge	approx. 80 mm
Max. circular feature diameter	1250 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



in an incorrect cutting radius. This is particularly important with sensitive materials such as graphite sheets.

When cutting gasket sheets with a spit plate insert and for gasket sheets with a thickness of more than 3 mm, it is very advisable to turn the cut to after about half of the material thickness (not to cut all the way through) and to continue and finish the work on the reverse side.

In any case, care must be taken to ensure that the cutting wheel does not hit the ball support.

If necessary, this must be secured by adjusting the counteracted stop nut on the adjusting spindle of the cutting wheel.

**Certified according to
 DIN EN ISO 9001:2015**

Subject to technical
 alterations.
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