Seam cutter operations

ID

Verify/Hazards

Verify Tooling:

- Seam Cutter
- Orbital cutter
- ISCAR indexable slotting cutter
- Pocket Laser Tach 200
- Spanner Wrench & Spindle key
- Kant Twist
- 5mm wrench

Verify Hardware:

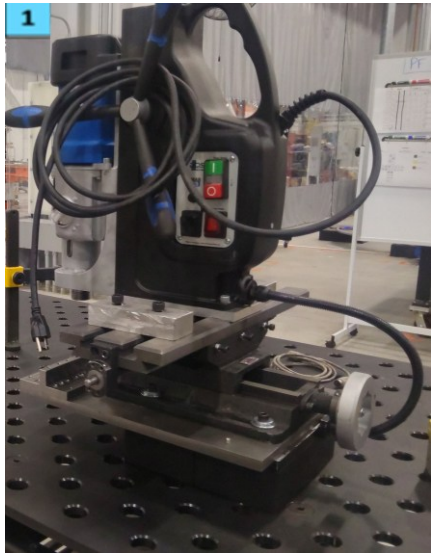
- M6 X 16 Cap Screw
- M6 X 20 Cap Screw

PPE:

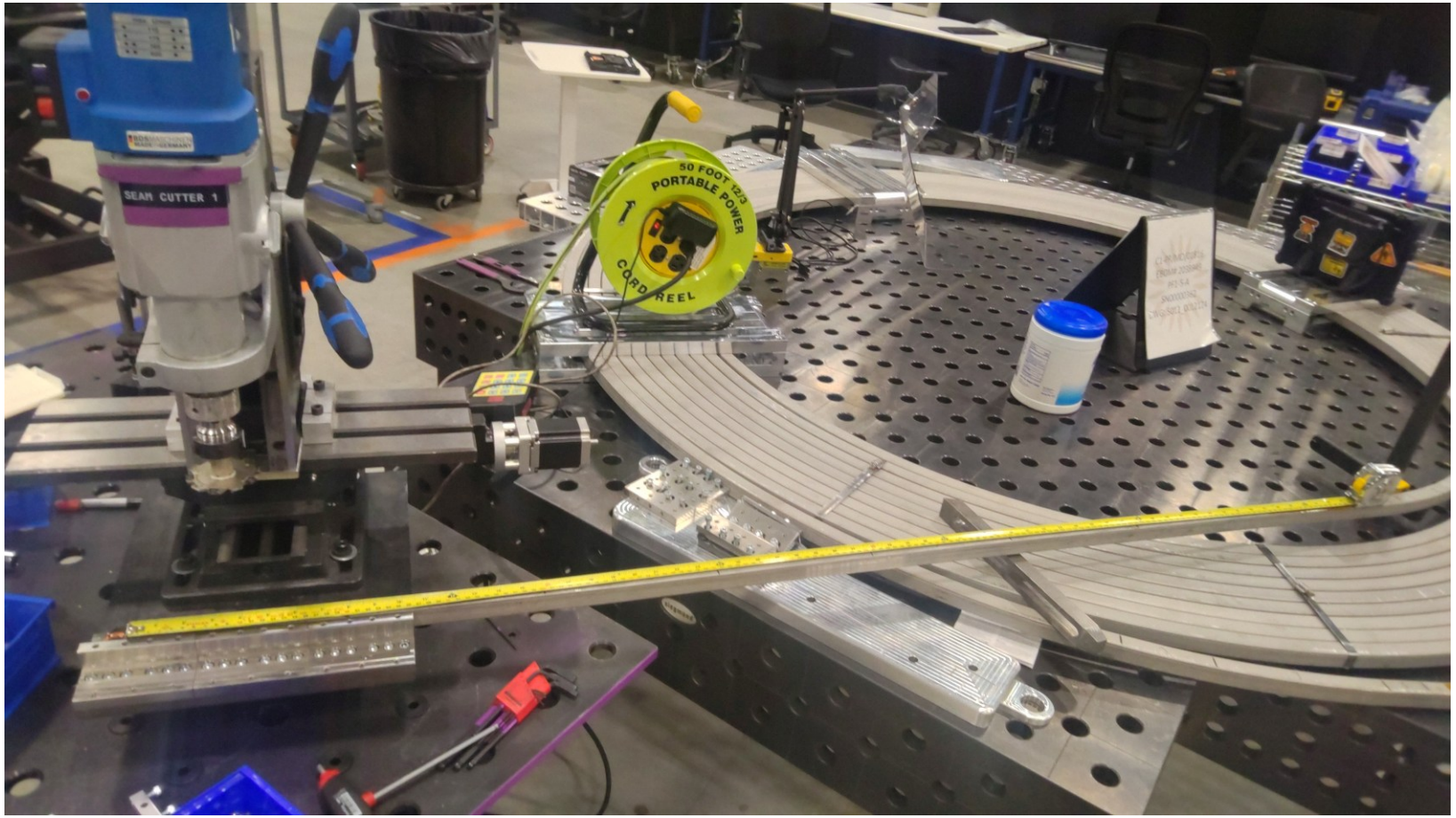
- Safety Glasses
- Lexan Guards

Hazards:

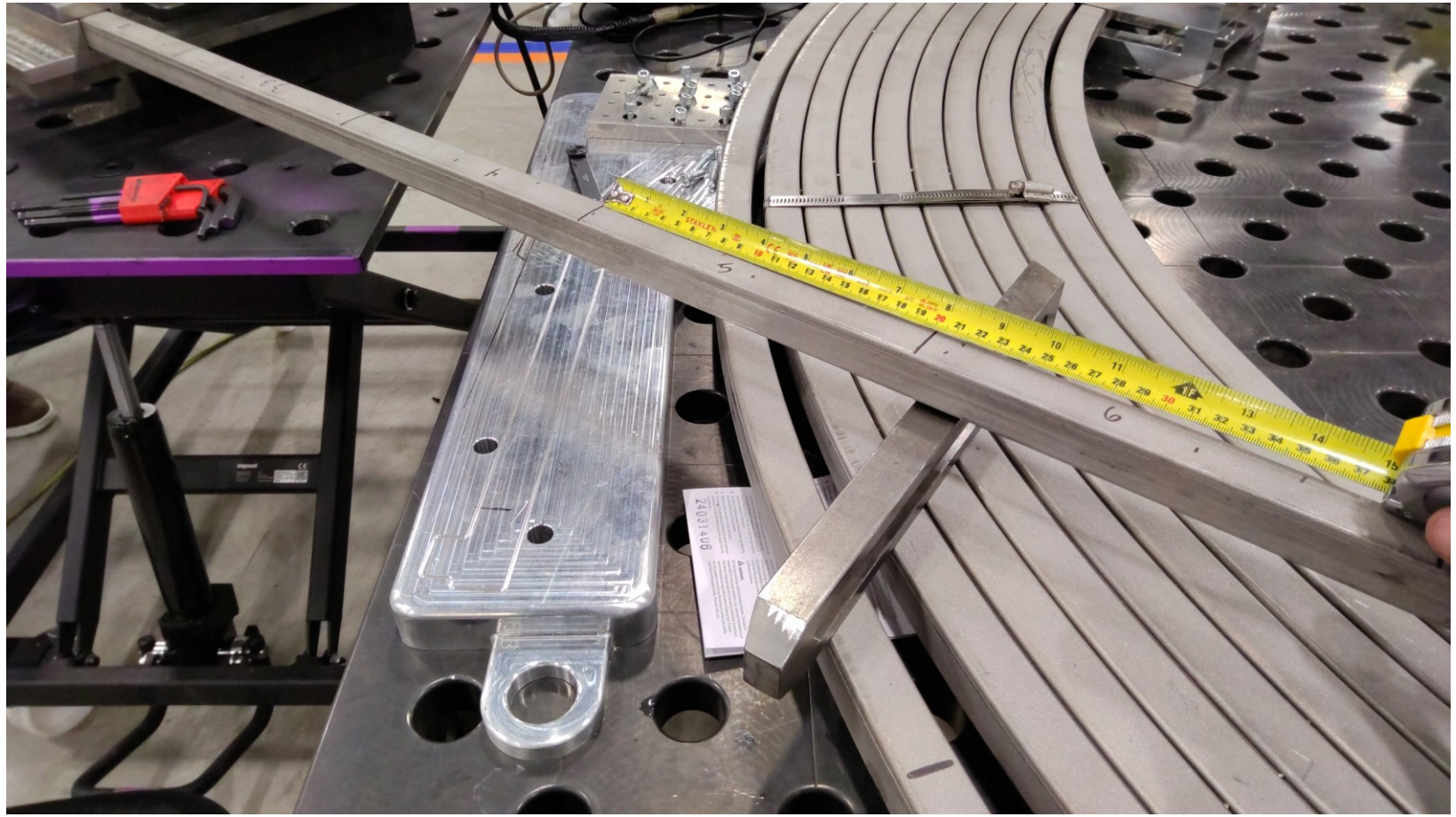
- GLOVES, JEWELRY, and LOOSE articles of clothing are a Hazard while operating rotating machinery
- Metal Chips



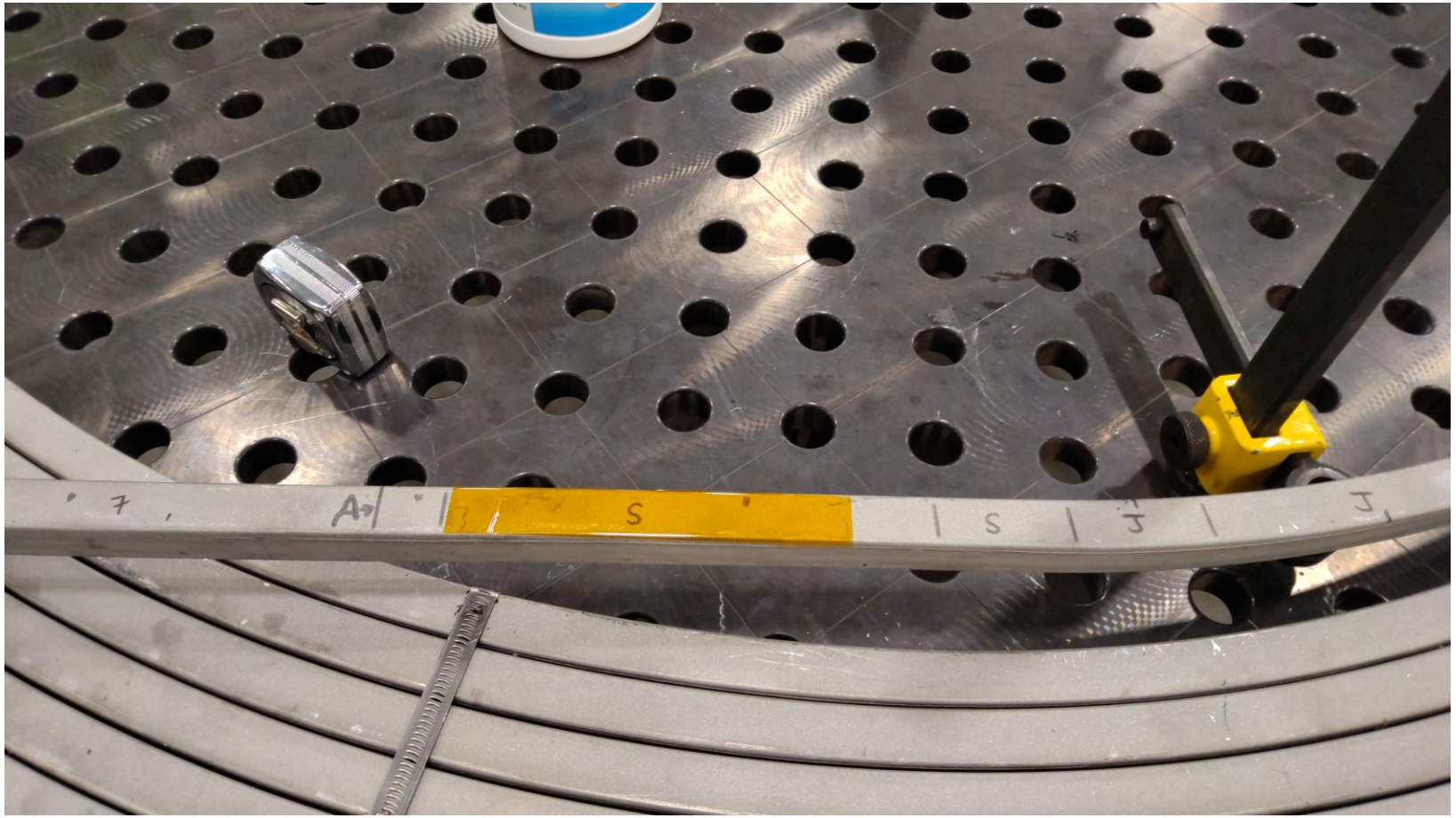
Record Length from Jacket End to Datum, Enter length into data collection



From Jacket End to Datum Measure 200mm sections

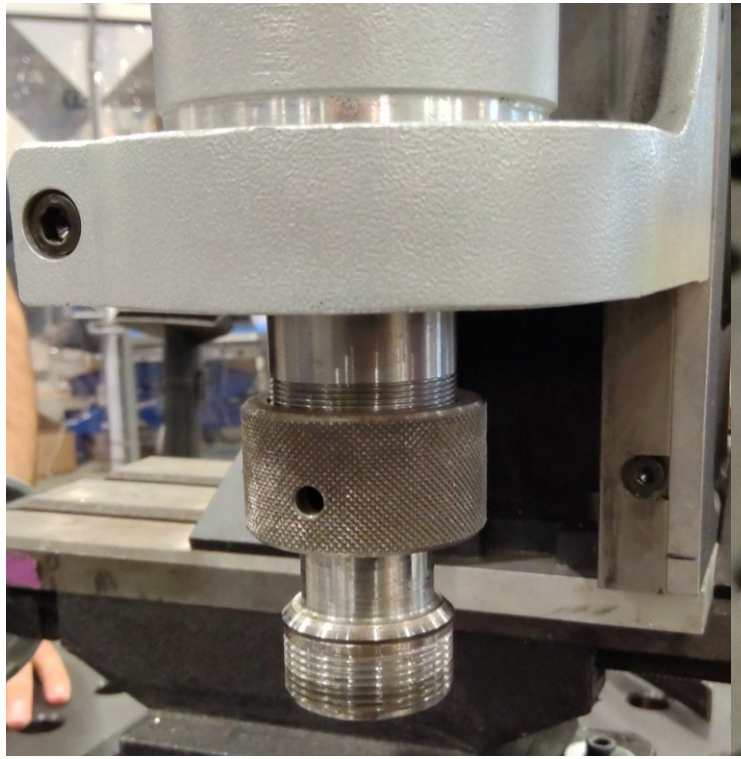
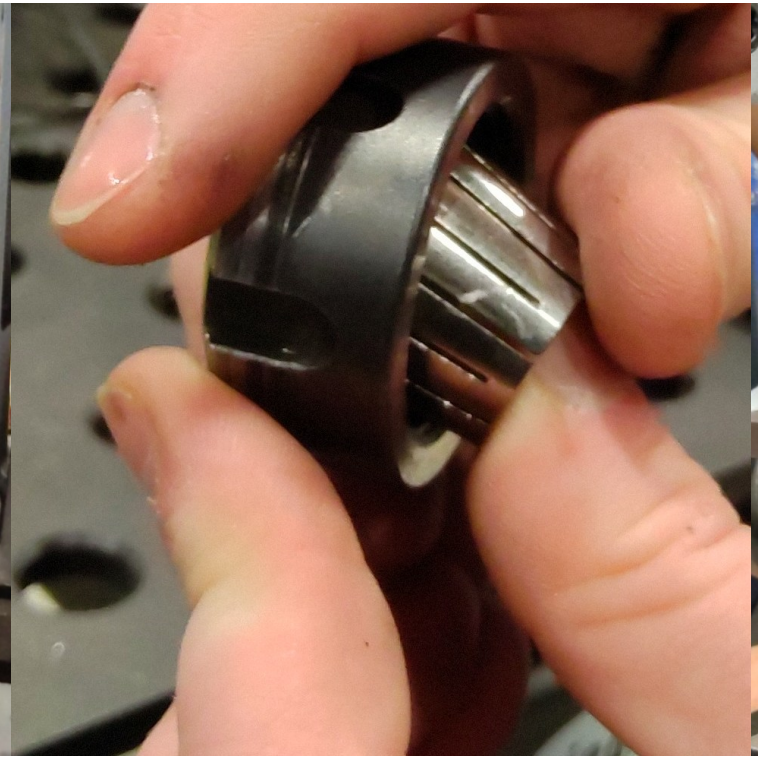
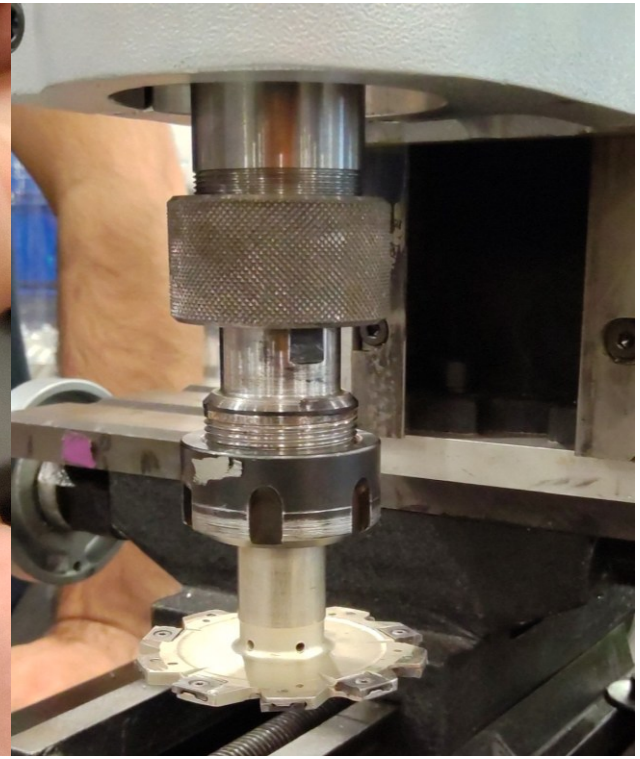


Tape off Joint Region, Indicating non-cutting area for current operations.

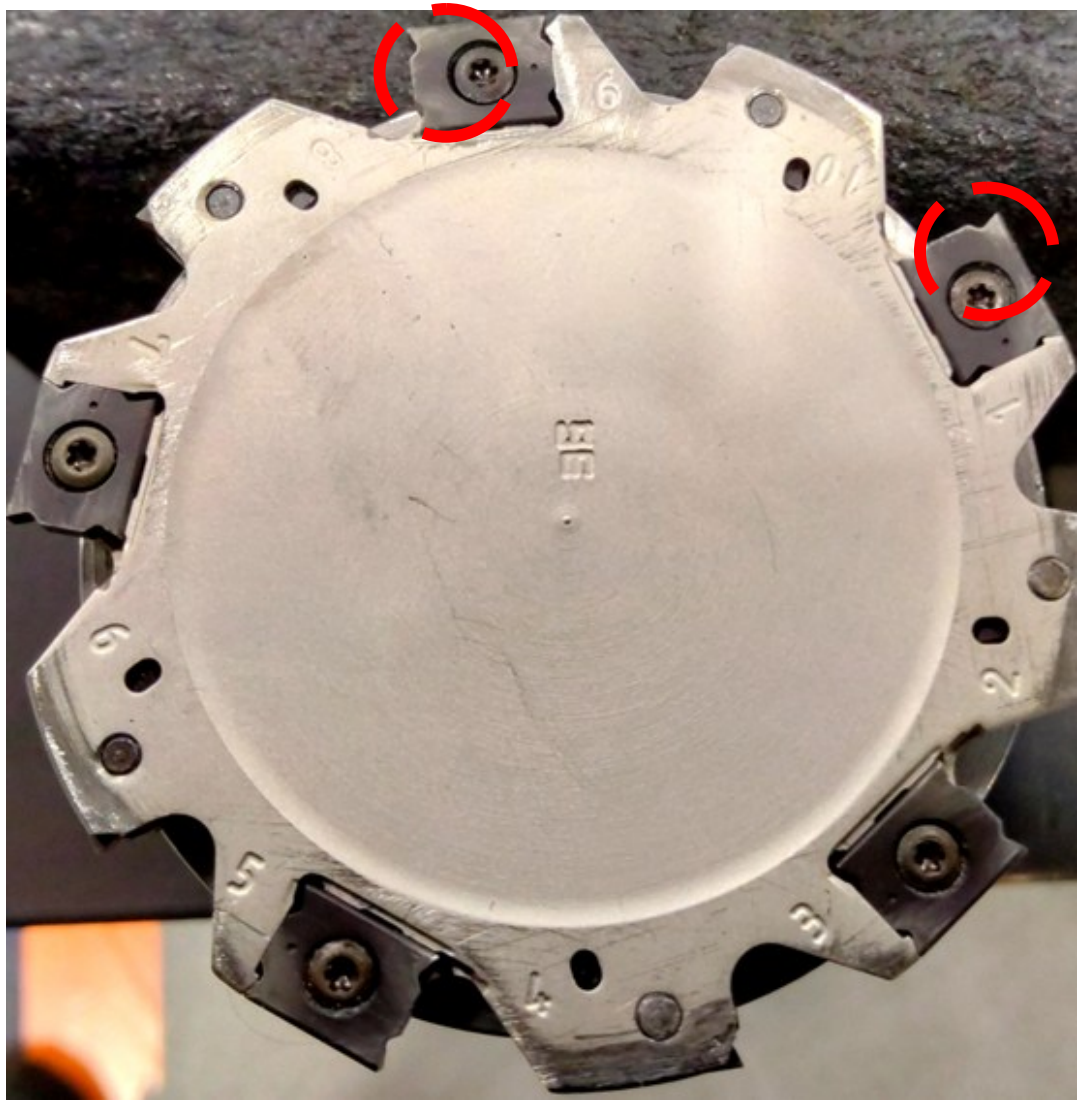


Configure seam cutter

Replace and adjust the collet chuck and cutting tools as needed. Make sure they are tight using spanner wrench and spindle key

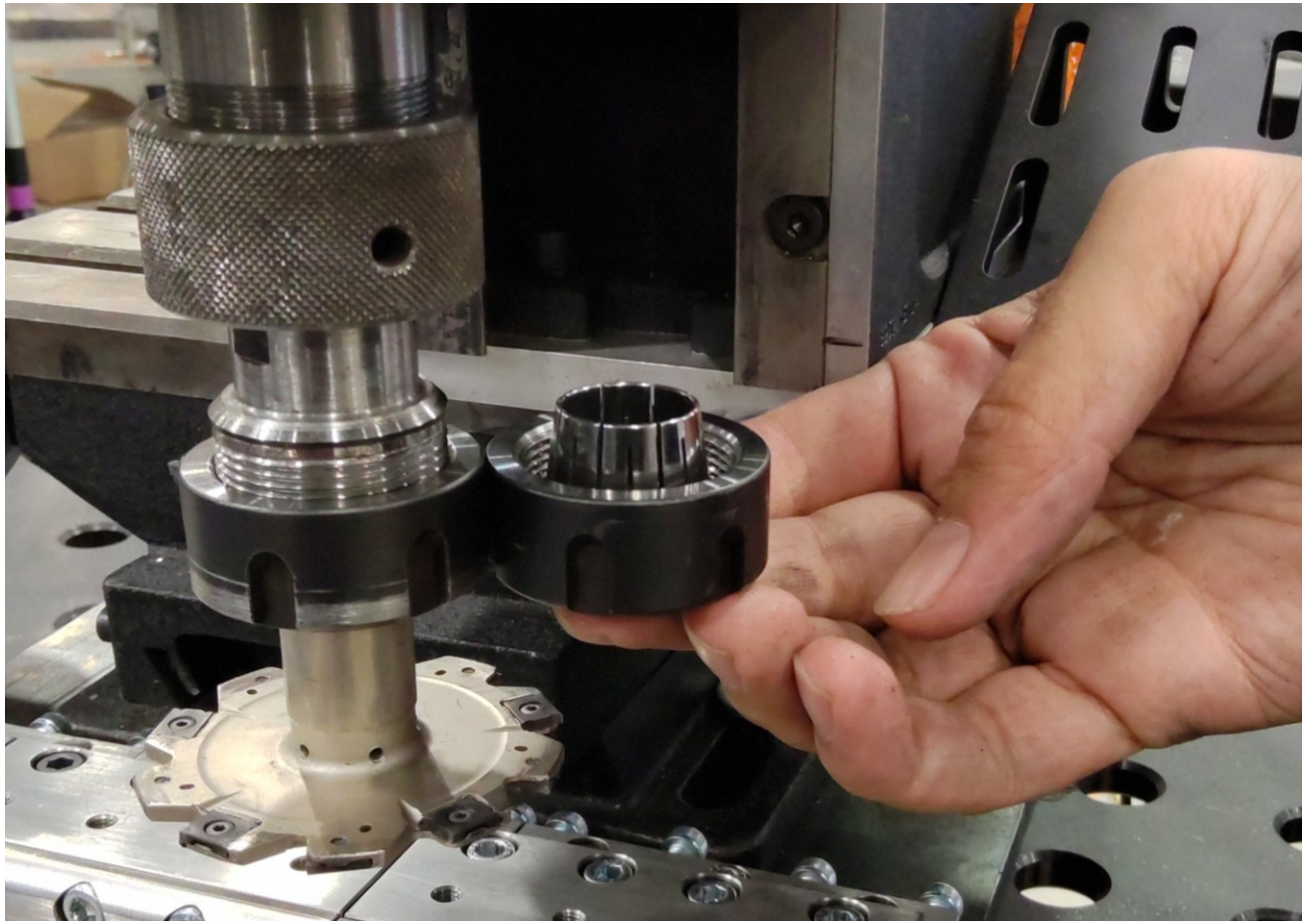




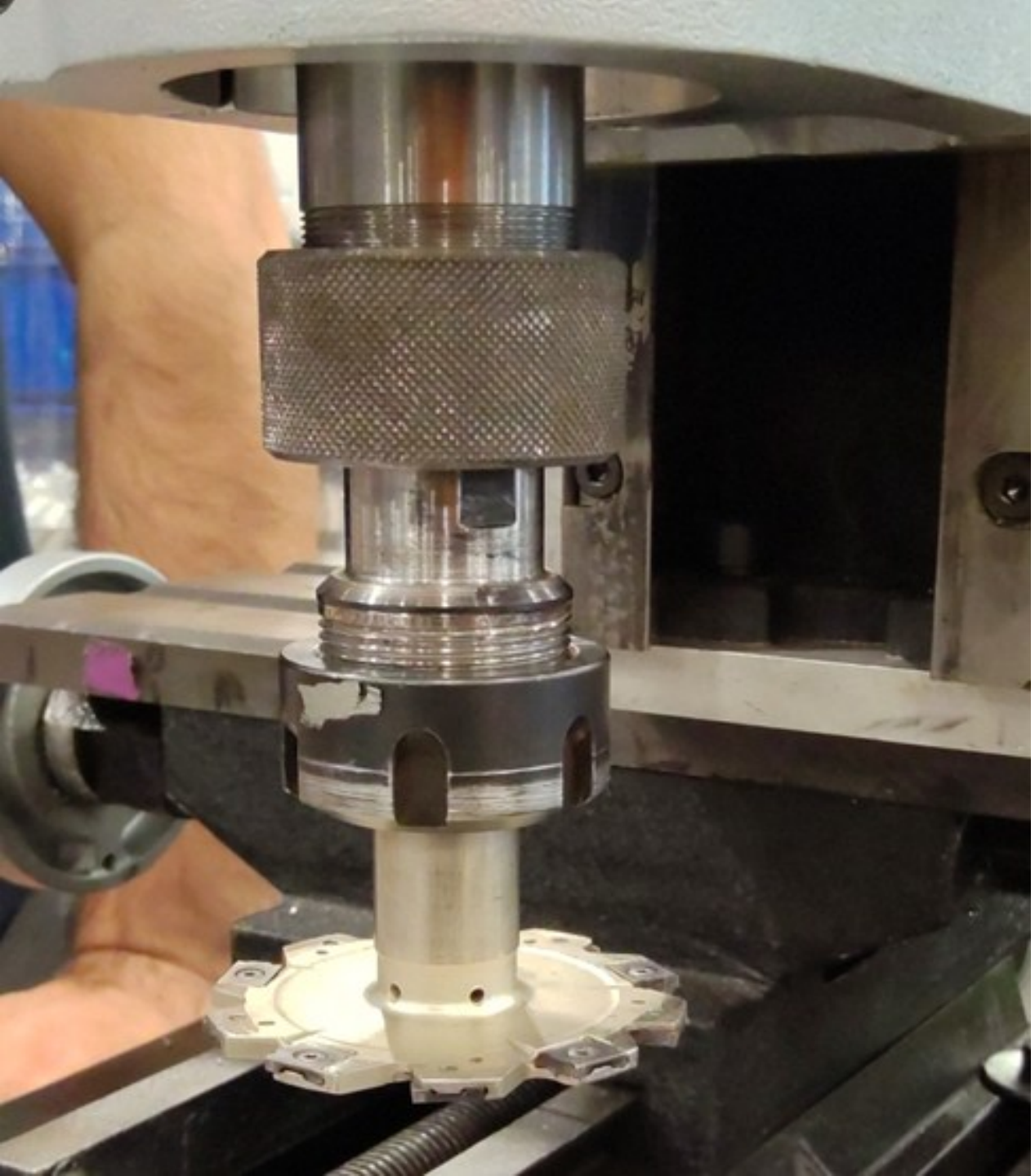
Inspect Indexing cutter for worn blades, rotate or flip if necessary to a new blade location.



Take collet piece and insert collar inside as shown

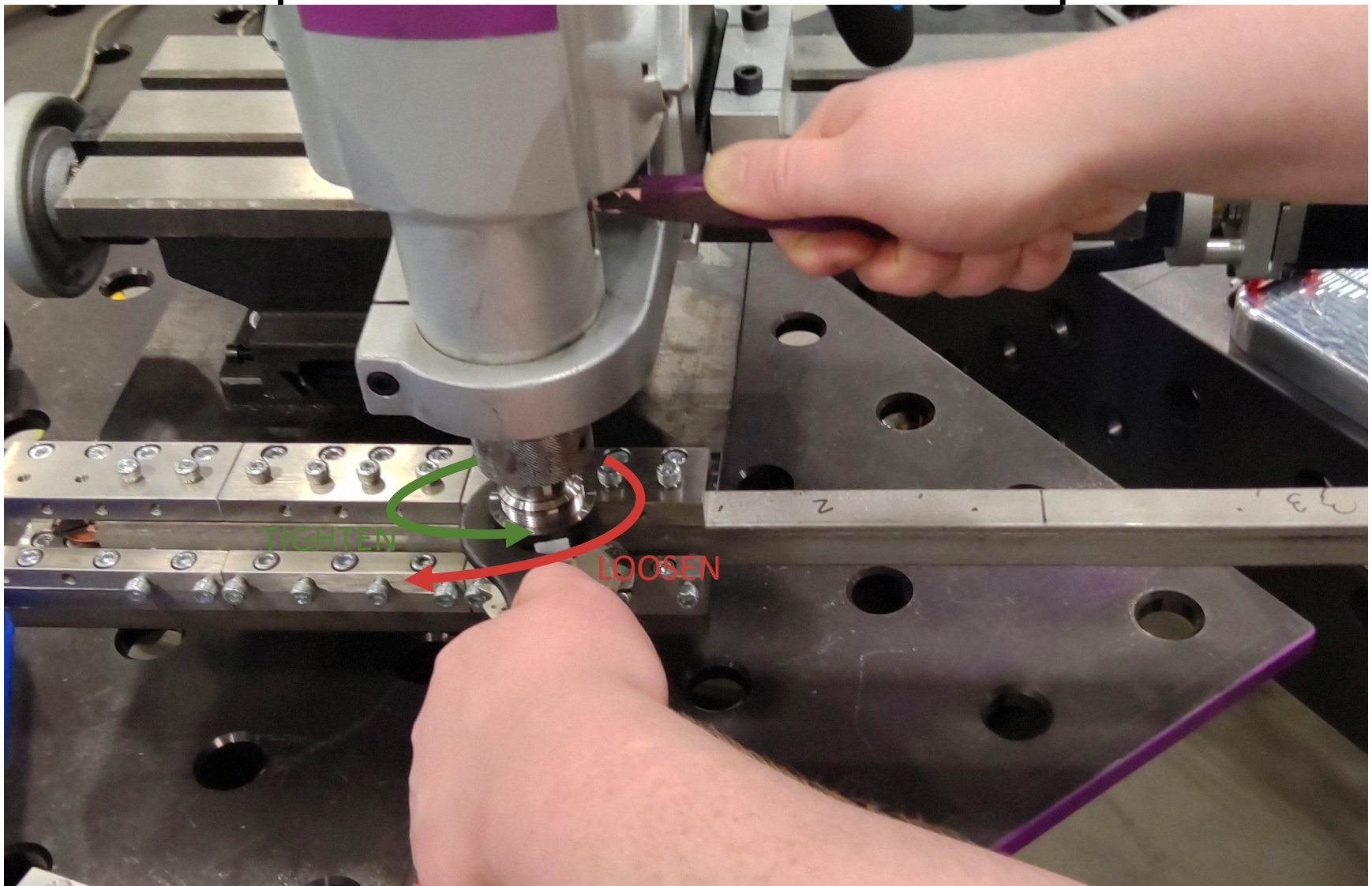
Insert collet with the silver collar facing towards the seam cutter chuck, begin the first few threads

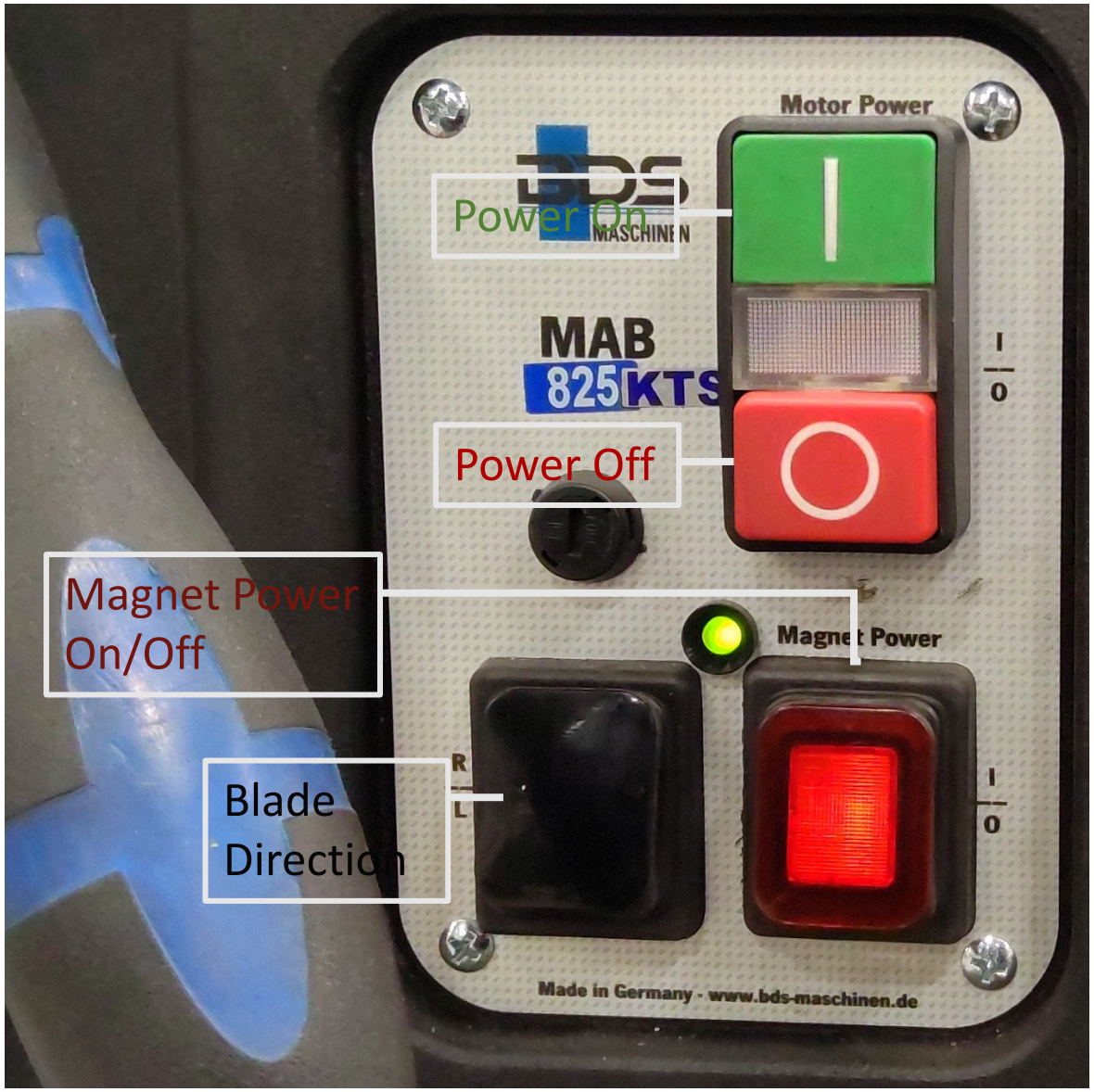




Insert Keyway Cutter until flush with the Seam cutter chuck.

Tighten Blade until completely hand tight with the spanner wrench and spindle key.




Motor Power
Power On
MAB
825KTS
Power Off
Magnet Power
On/Off
Magnet Power
Blade
Direction
R
L
I
O
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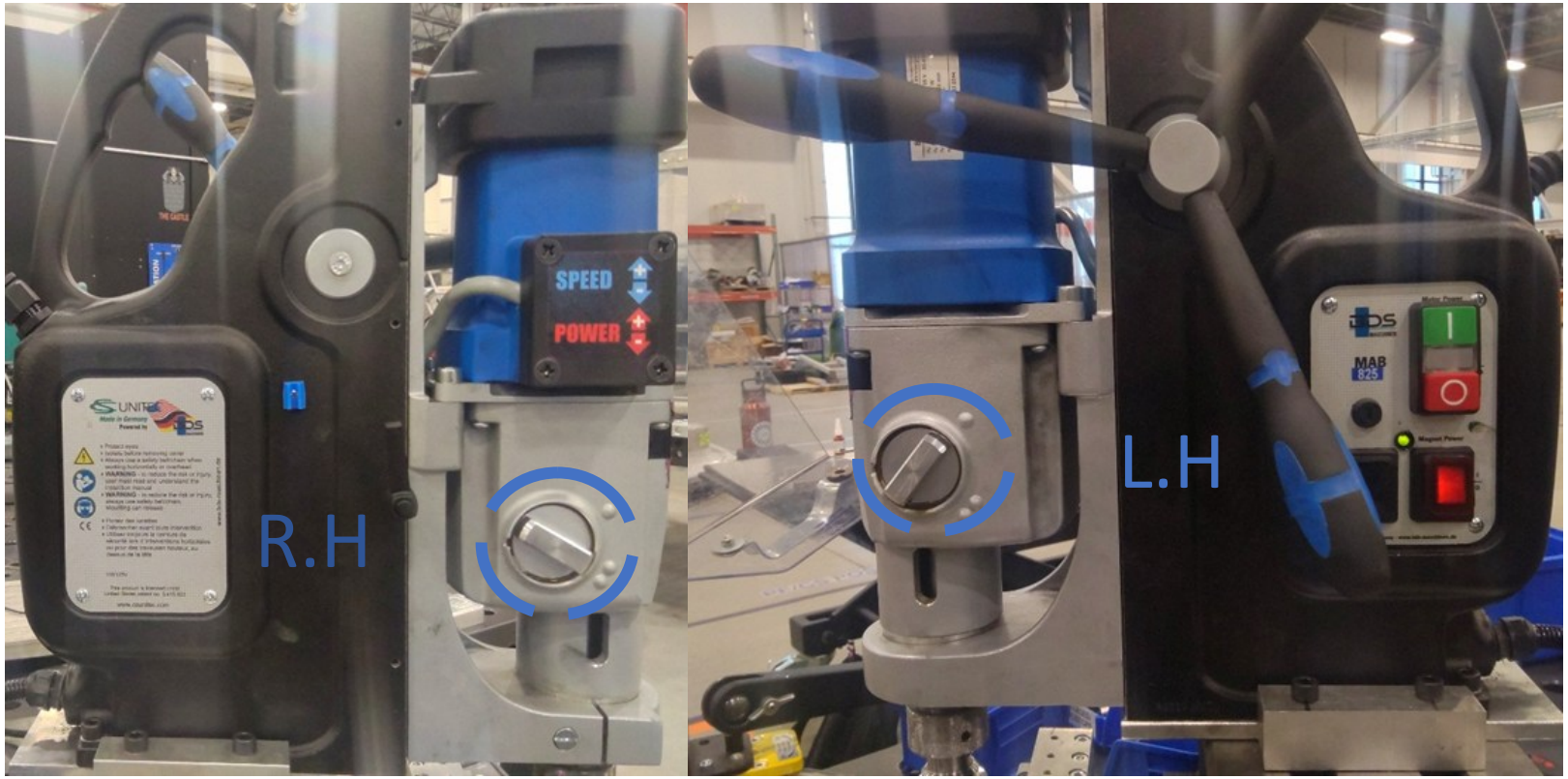
O
Made in Germany - www.bds-maschinen.de

Check Blade RPM using the tachometer adjust speed controls as needed until at of 500 RPM. (+/- 5 RPM)

Set Max Speed on Seam cutter to 600 U/min

While Spinning the Cutter housing adjust the Left-hand and Right-hand sides of the Seam Cutter