

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:

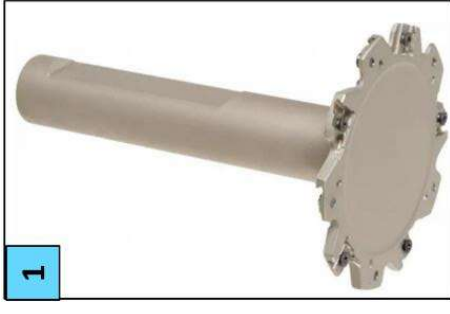
- M6 X 16 Cap Screw
- M6 X 20 Cap Screw

PPE:

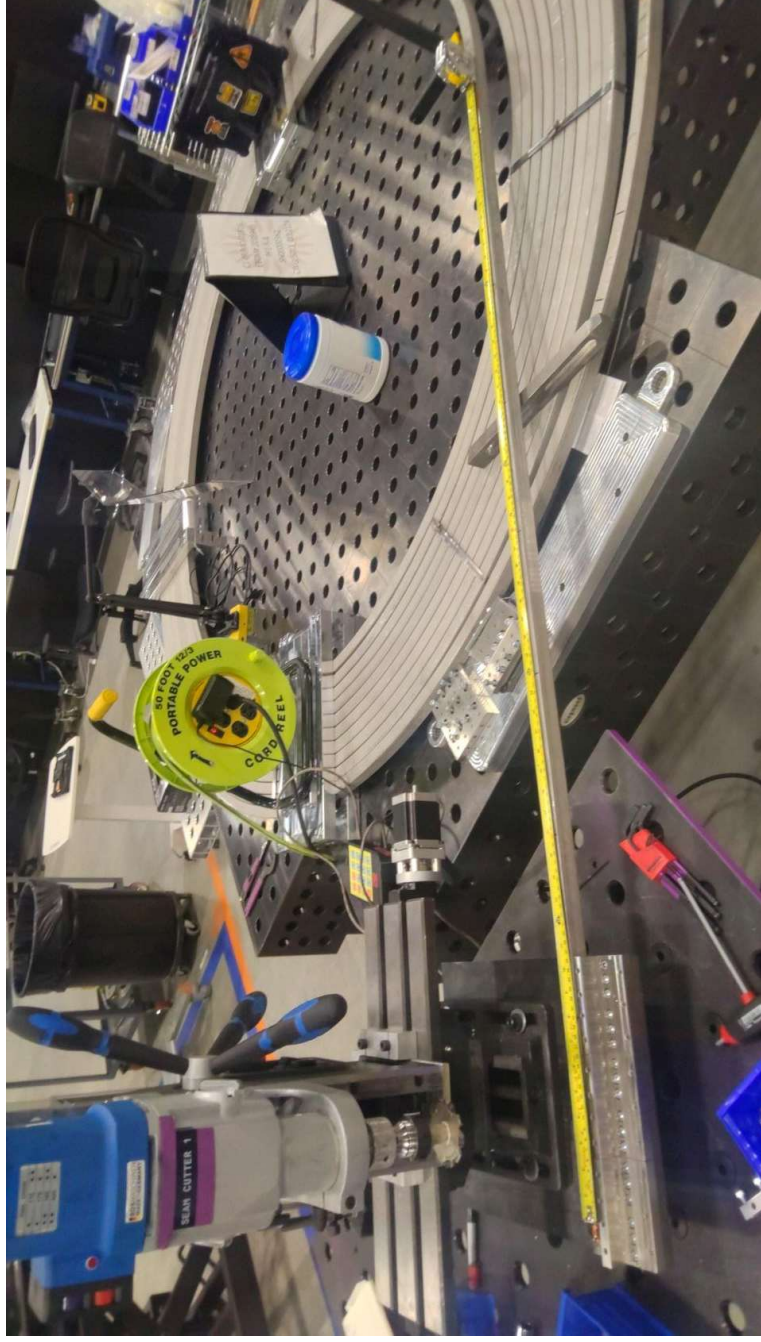
- Safety Glasses
- Lexan Guards

Hazards:

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



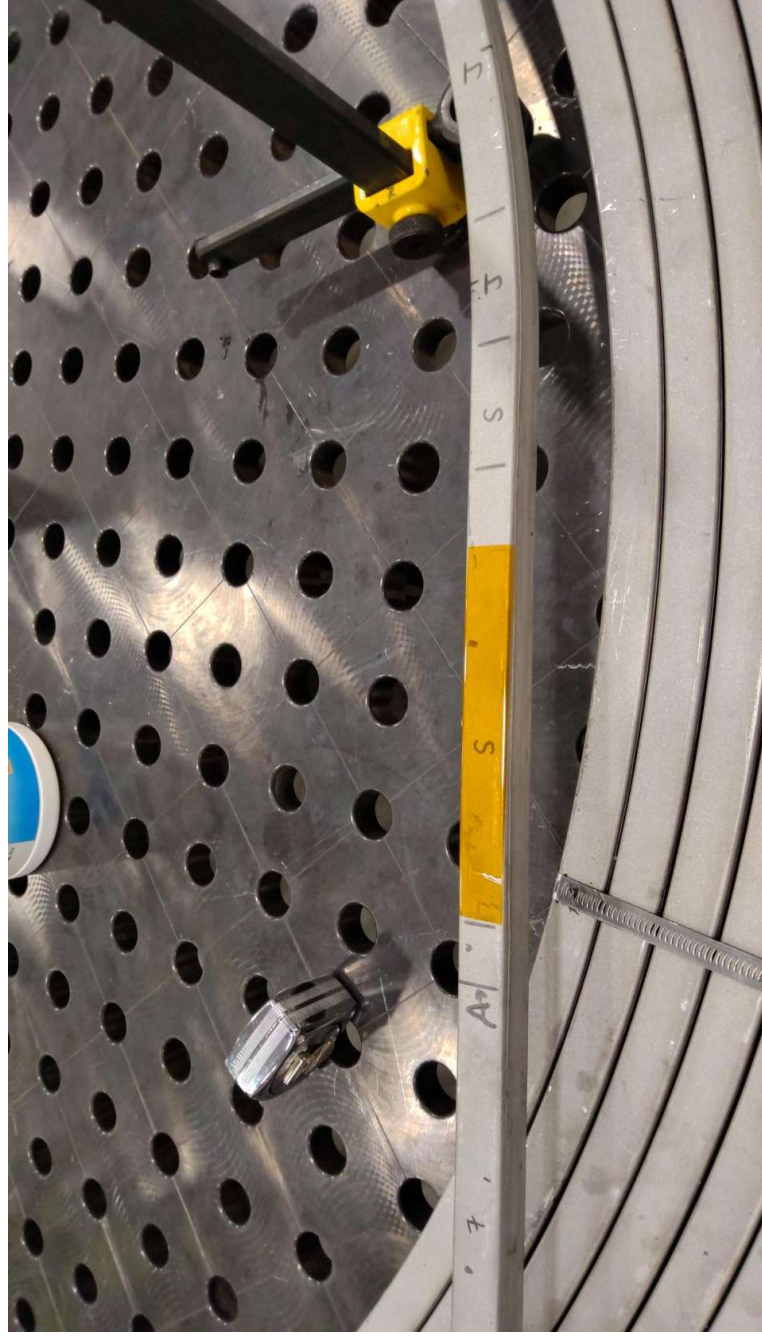
Record Length from Jacket End to Datum,
Enter length into data collection



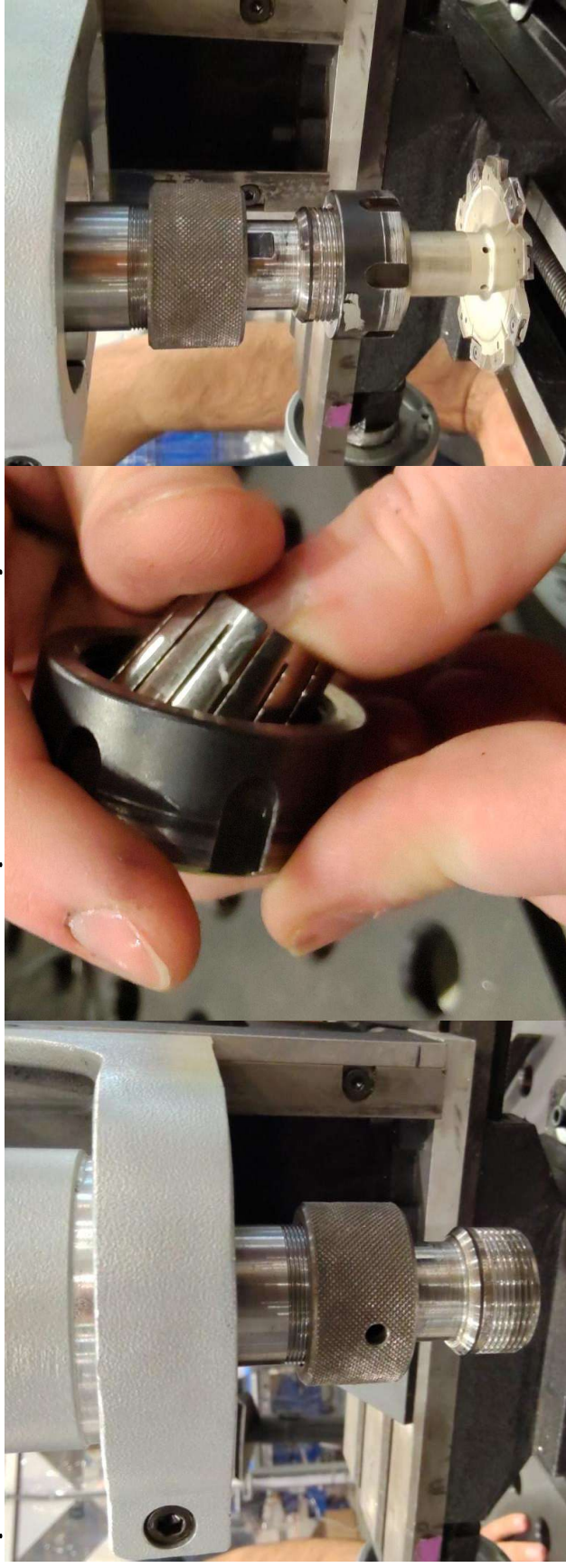
From Jacket End to Datum Measure 200mm
sections



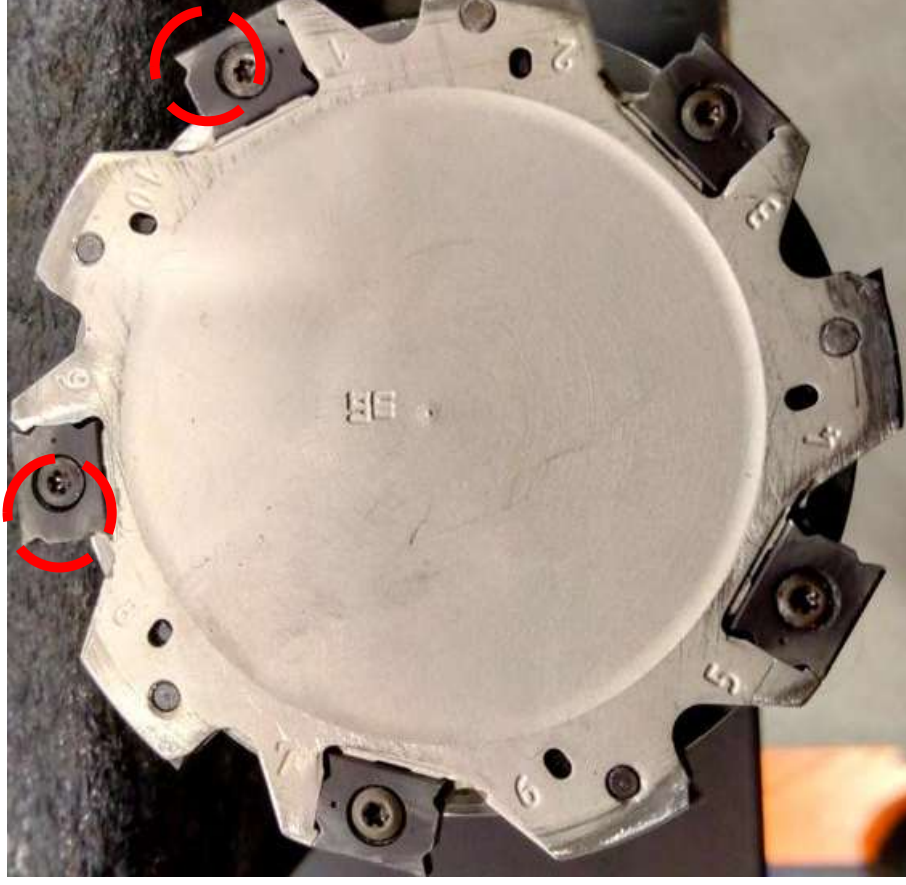
Tape off Joint Region, Indicating non-cutting area for current operations.



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



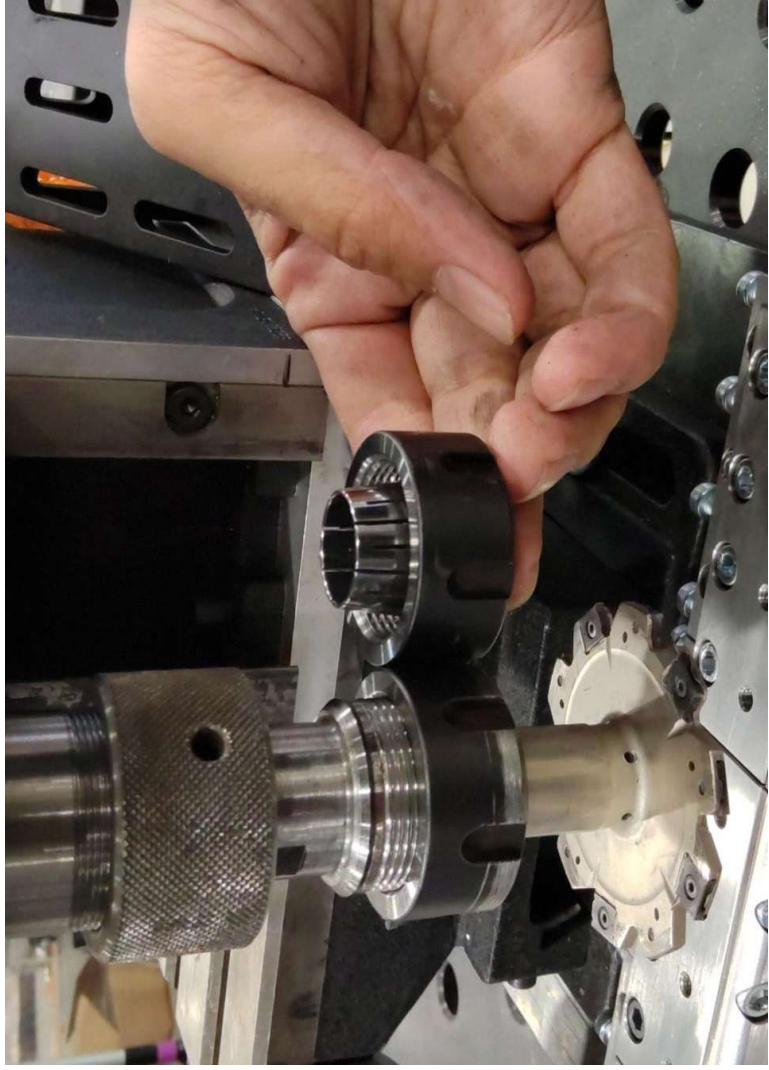
Inspect Indexing cutter for worn blades, rotate or flip if necessary to a new blade location.



Take collet piece
and insert collar
inside as shown



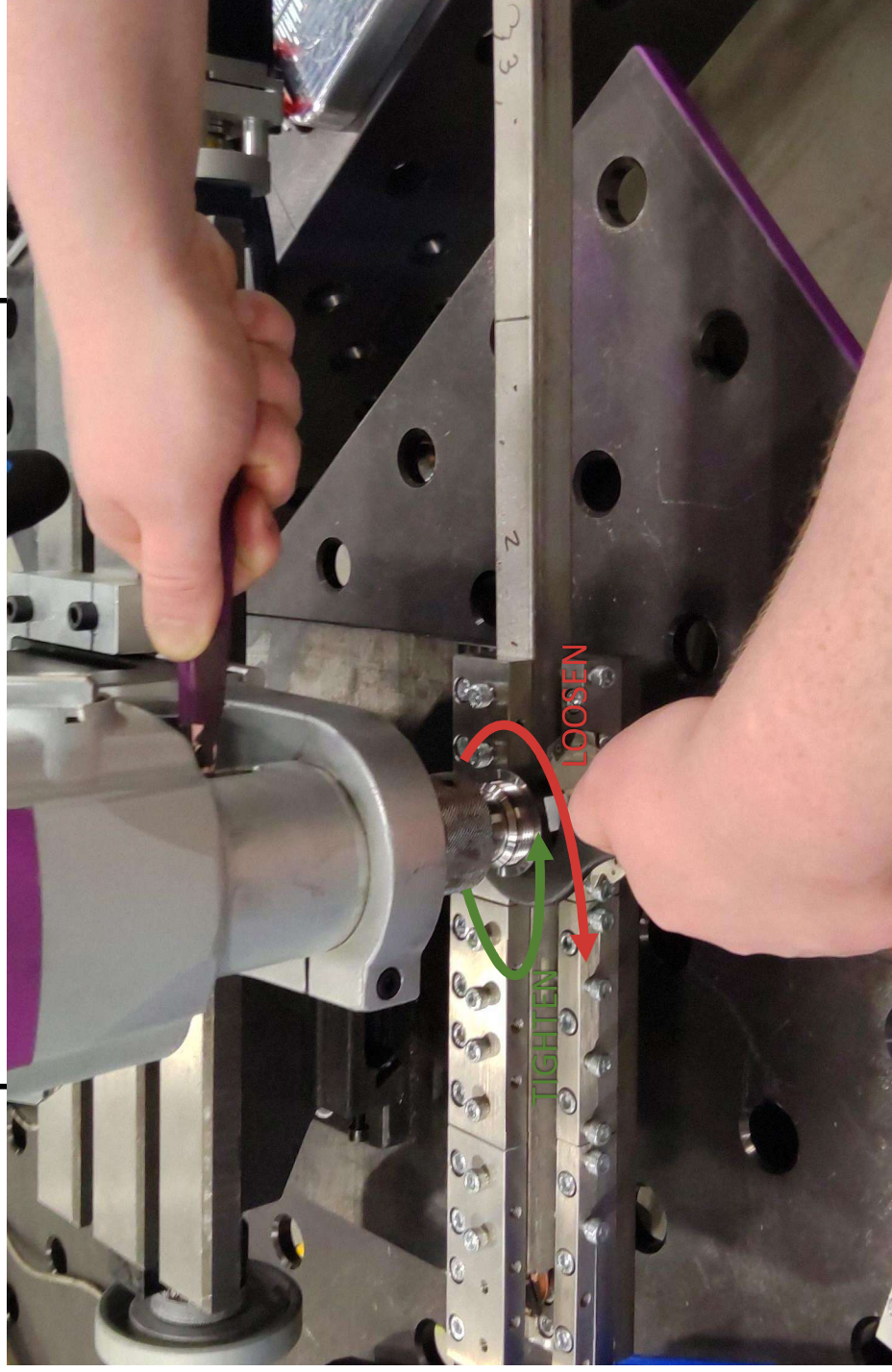
Insert collet with the silver collar facing towards the seam cutter chuck, begin the first few threads

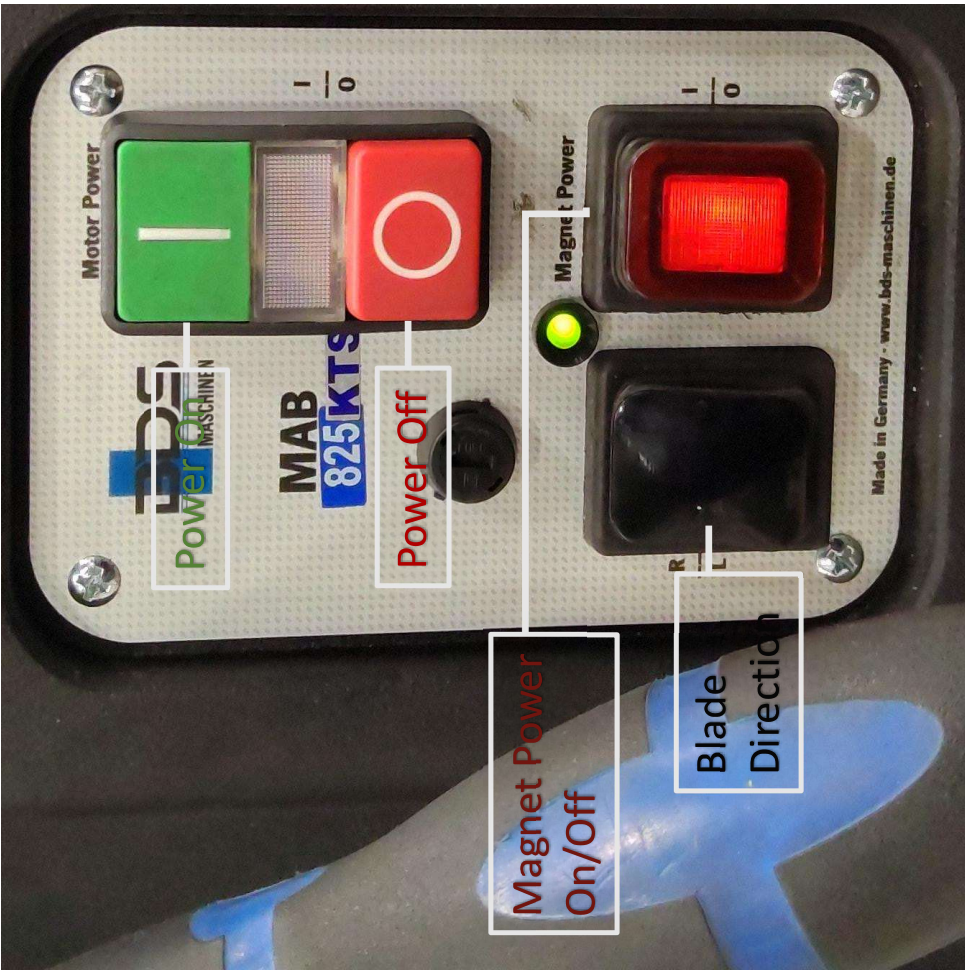


Insert Keyway
Cutter until flush
with the Seam
cutter chuck.



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





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

