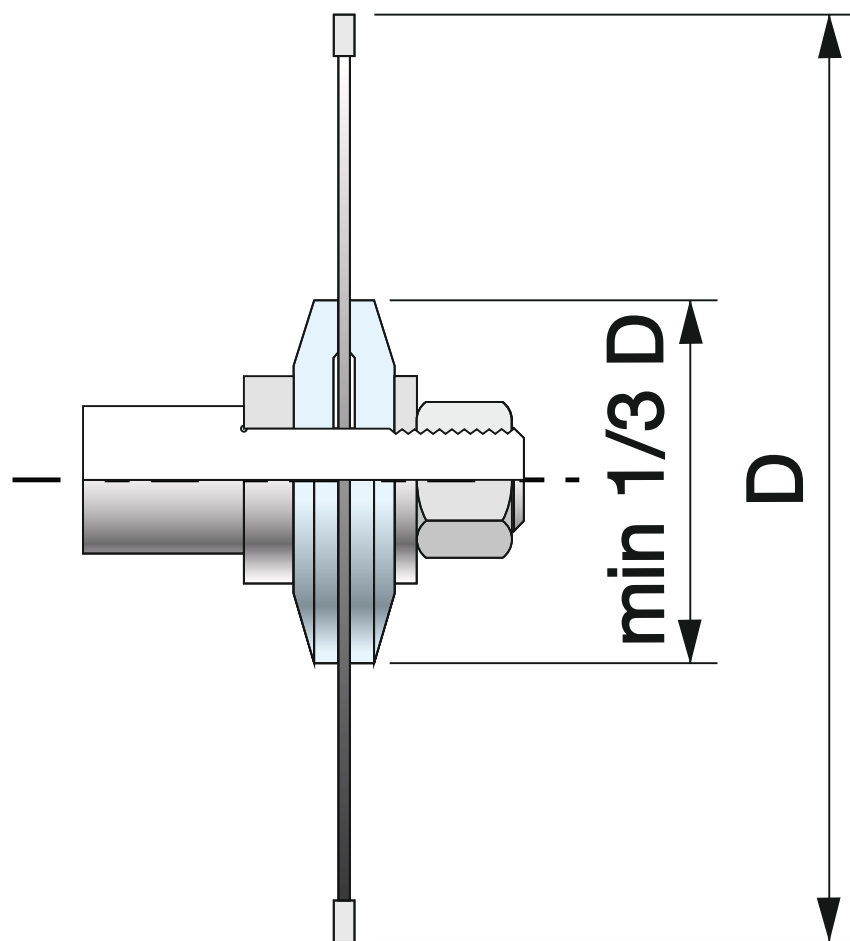
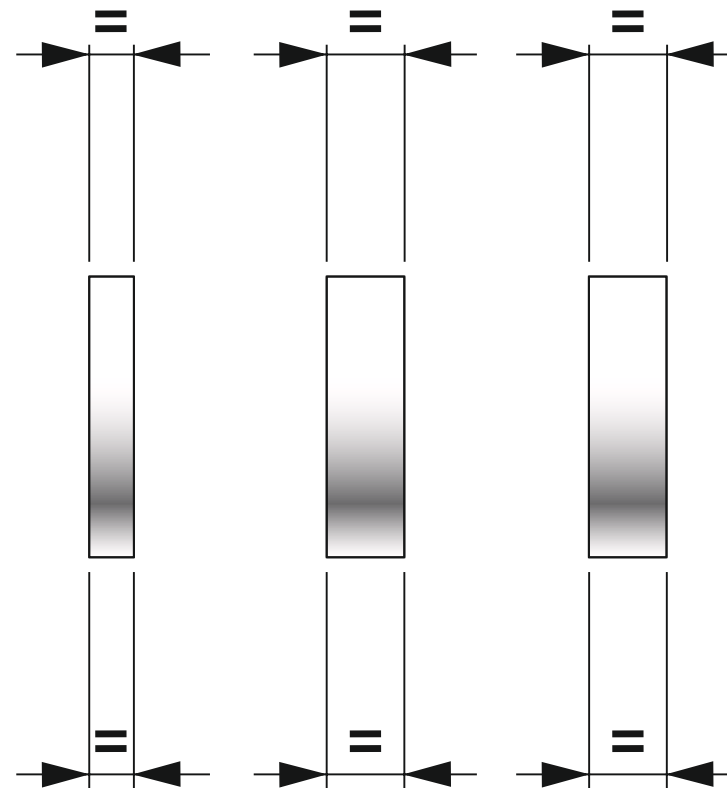
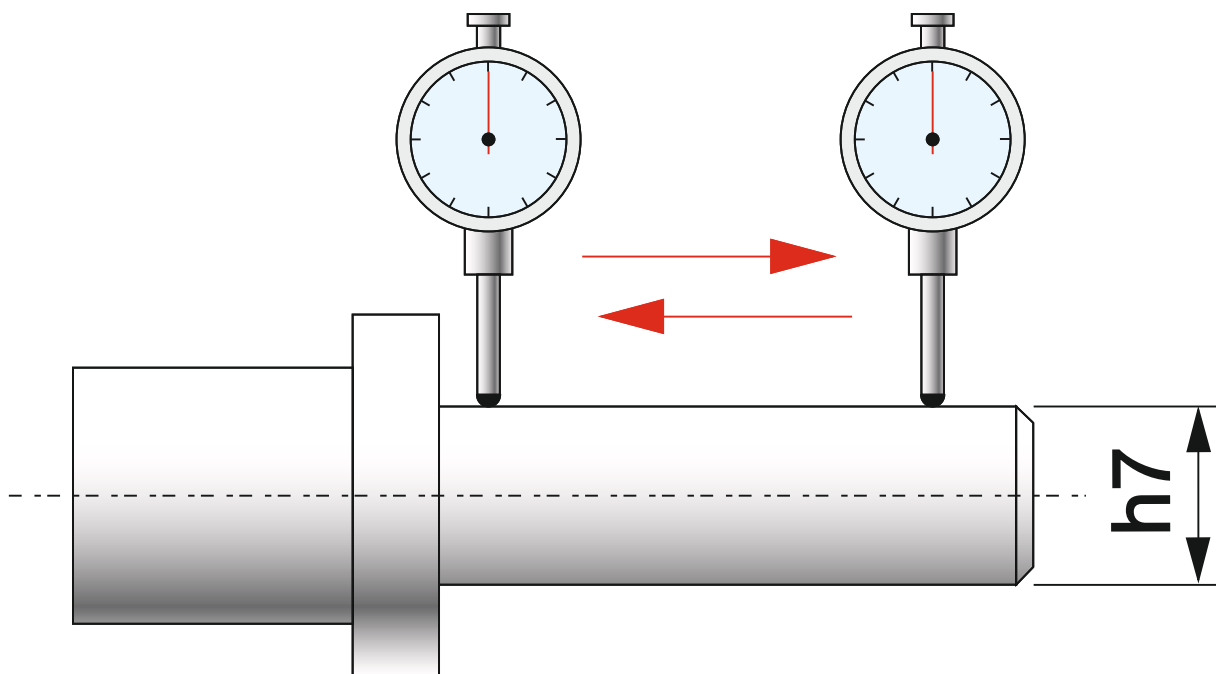




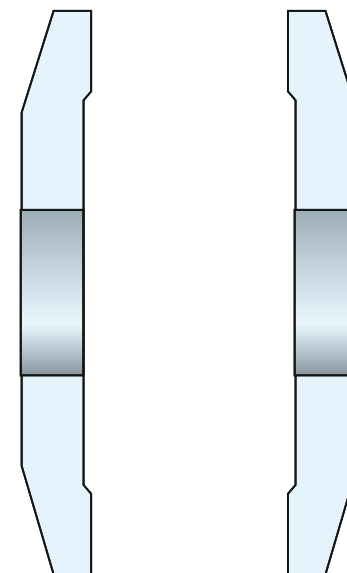
Minimálny priemer prírub



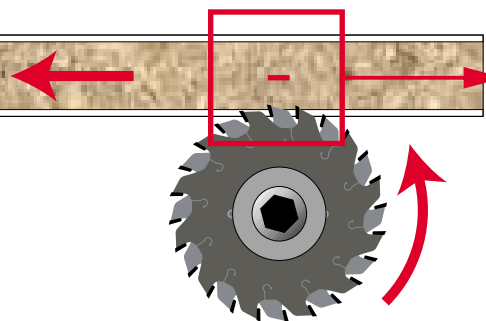
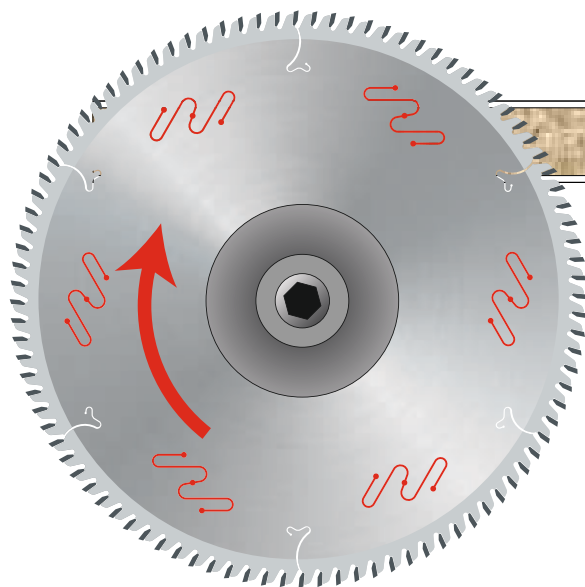
**Ravnobežnosť
medzikrúžkov**



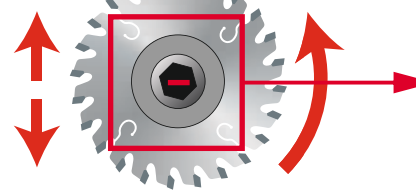
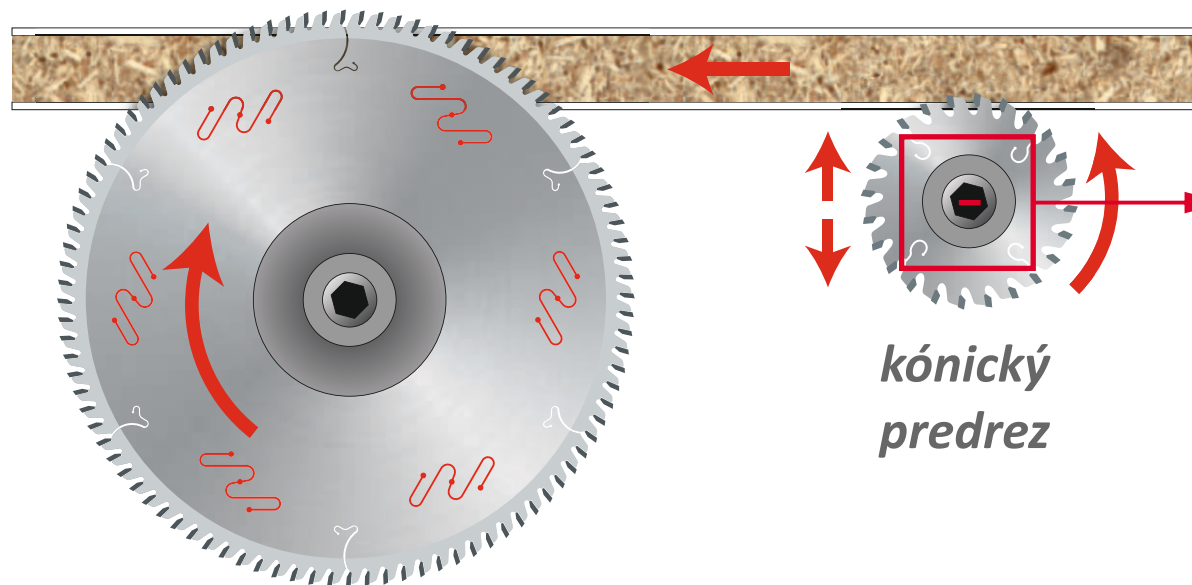
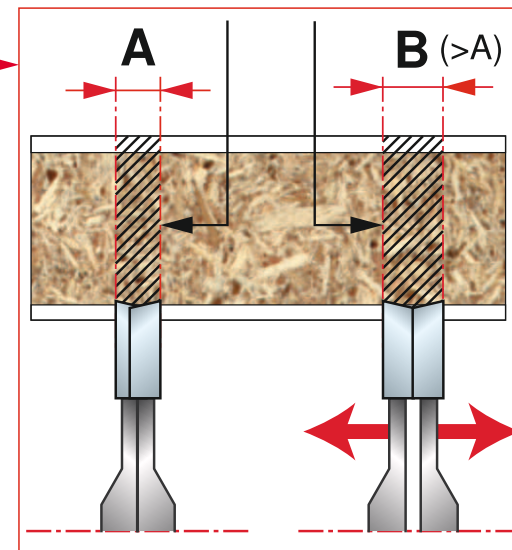
Presnosť hriadeľa a otvoru pílového kotúča



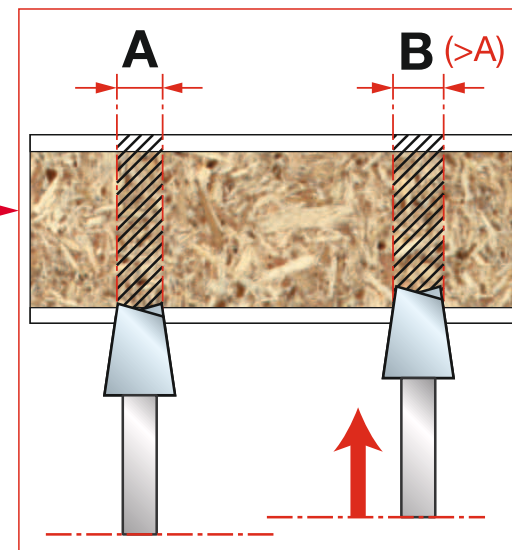
Presnosť prírub



*skladaný
predrez*



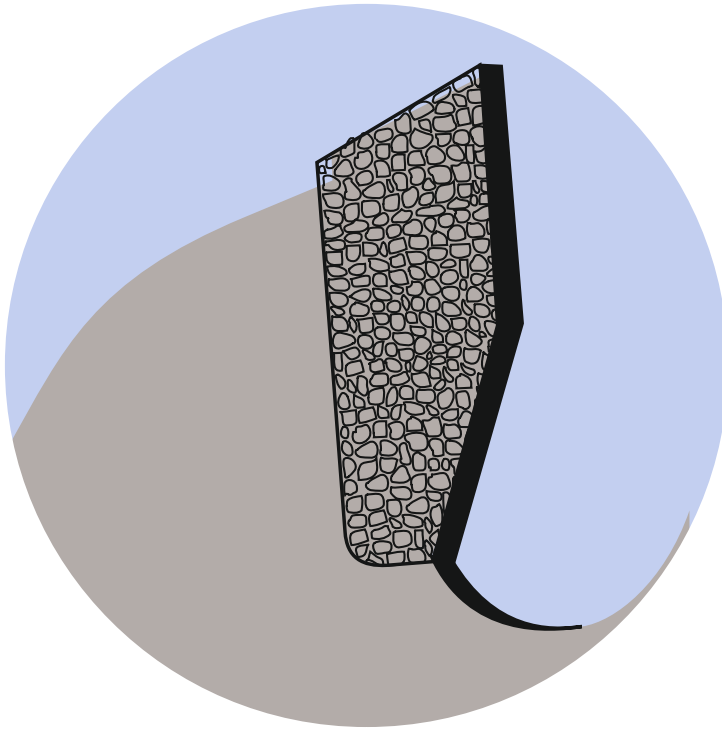
*kónický
predrez*



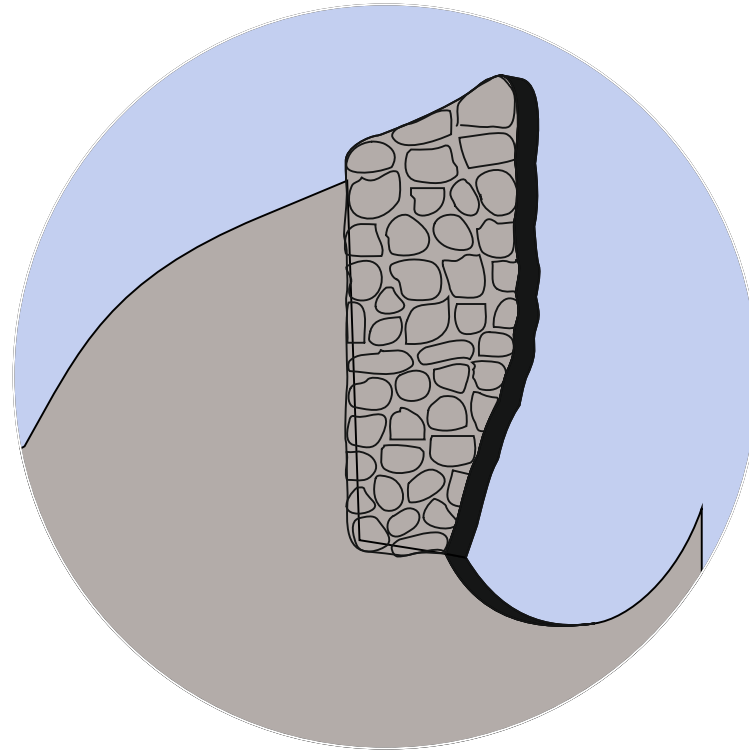
zdvih 1mm = rozšírenie +0,25mm

Rezanie materiálov s predrezom

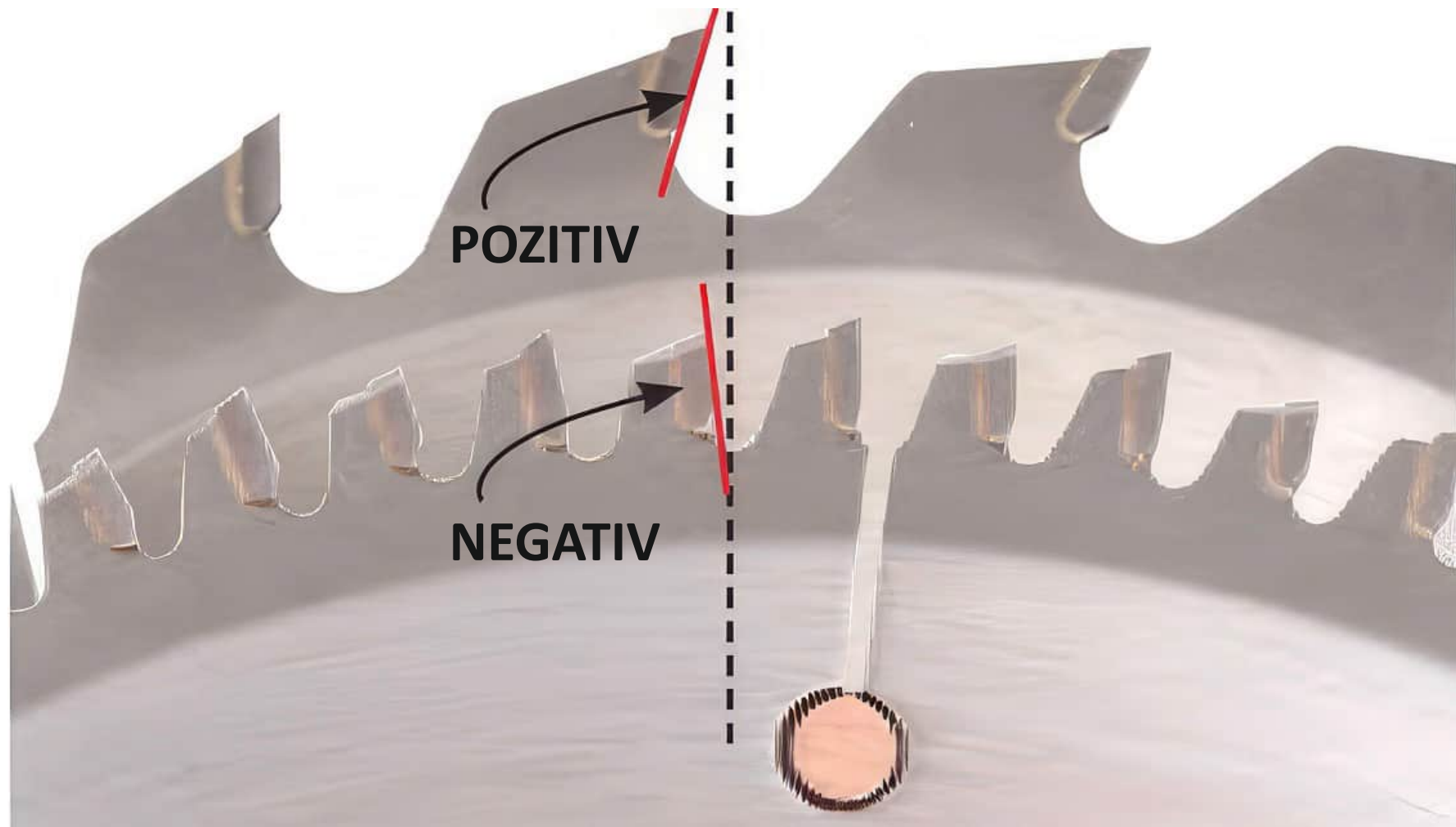
micrograno



šstandart



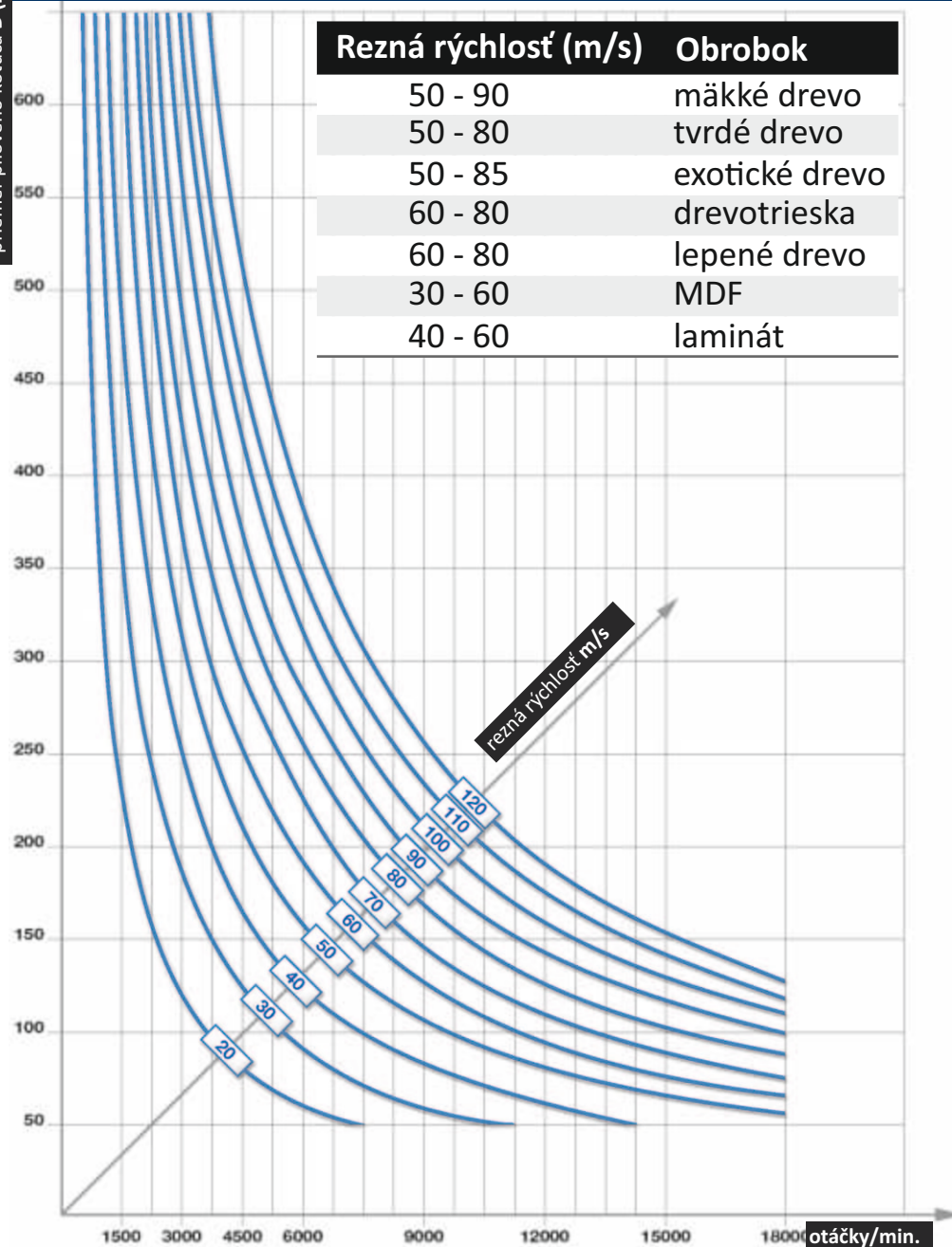
veľkosť zrna spekaného karbidu



Pozitívna - negatívna geometria

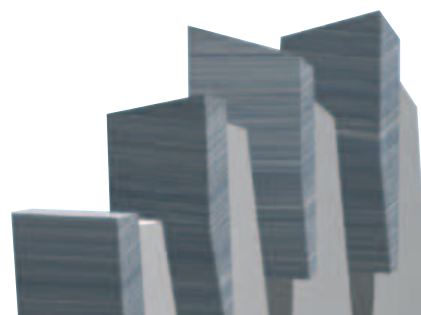
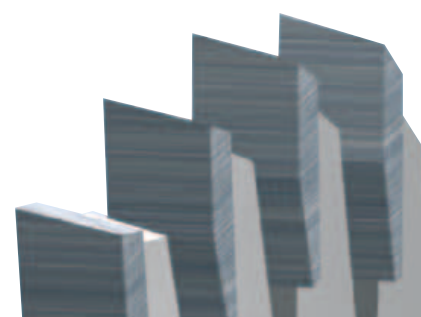
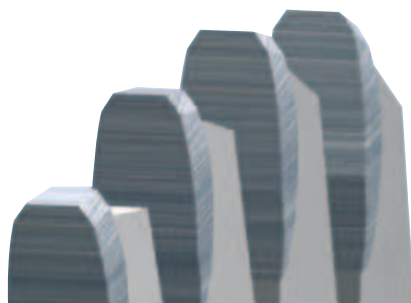
Odporúčané parametre

priemer pílového kotúča D (mm)



Priemer pílového kotúča	Max. otáčky ot./mian.
100 mm	23.000
125 mm	18.000
150 mm	14.500
180 mm	11.500
185 mm	11.000
200 mm	10.000
225 mm	8.500
250 mm	8.000
255 mm	7.800
280 mm	7.100
300 mm	6.500
320 mm	6.000
350 mm	5.500
380 mm	5.000
400 mm	4.700
430 mm	4.400
450 mm	4.200
500 mm	3.750
550 mm	3.400
600 mm	3.100
630 mm	2.950
650 mm	2.800
700 mm	2.600
730 mm	2.500
760 mm	2.400
800 mm	2.250

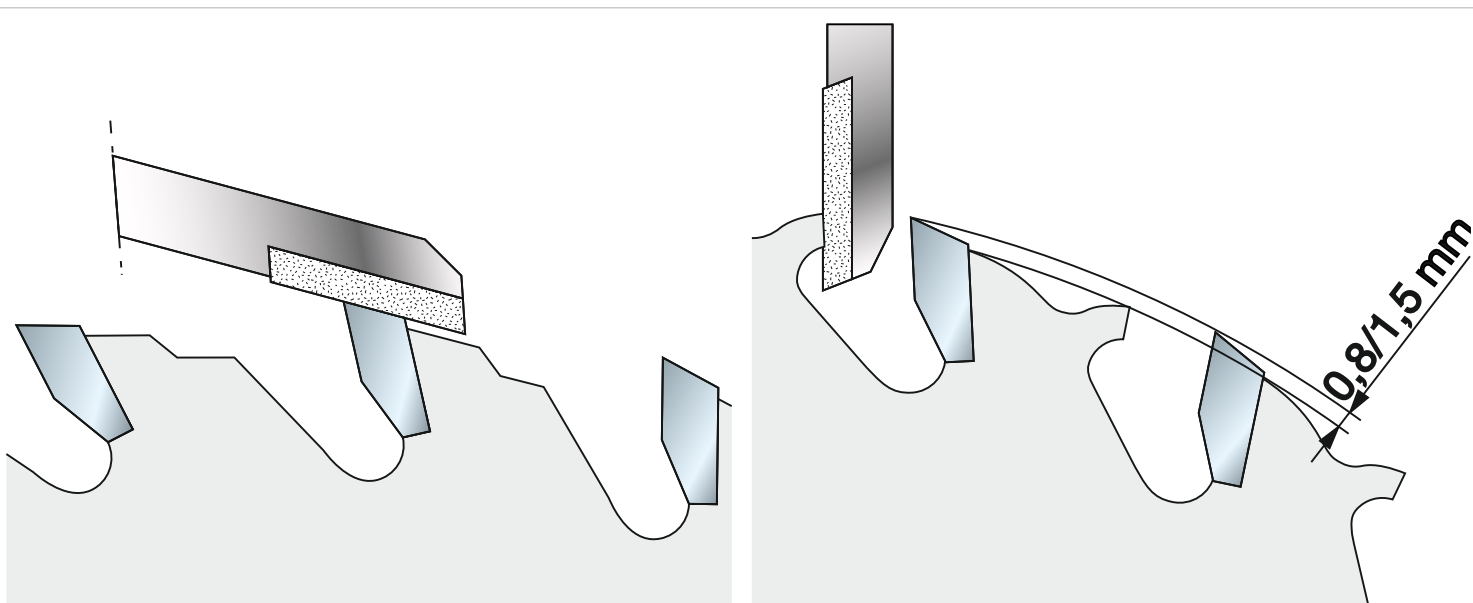
Obmedzenie otáčok



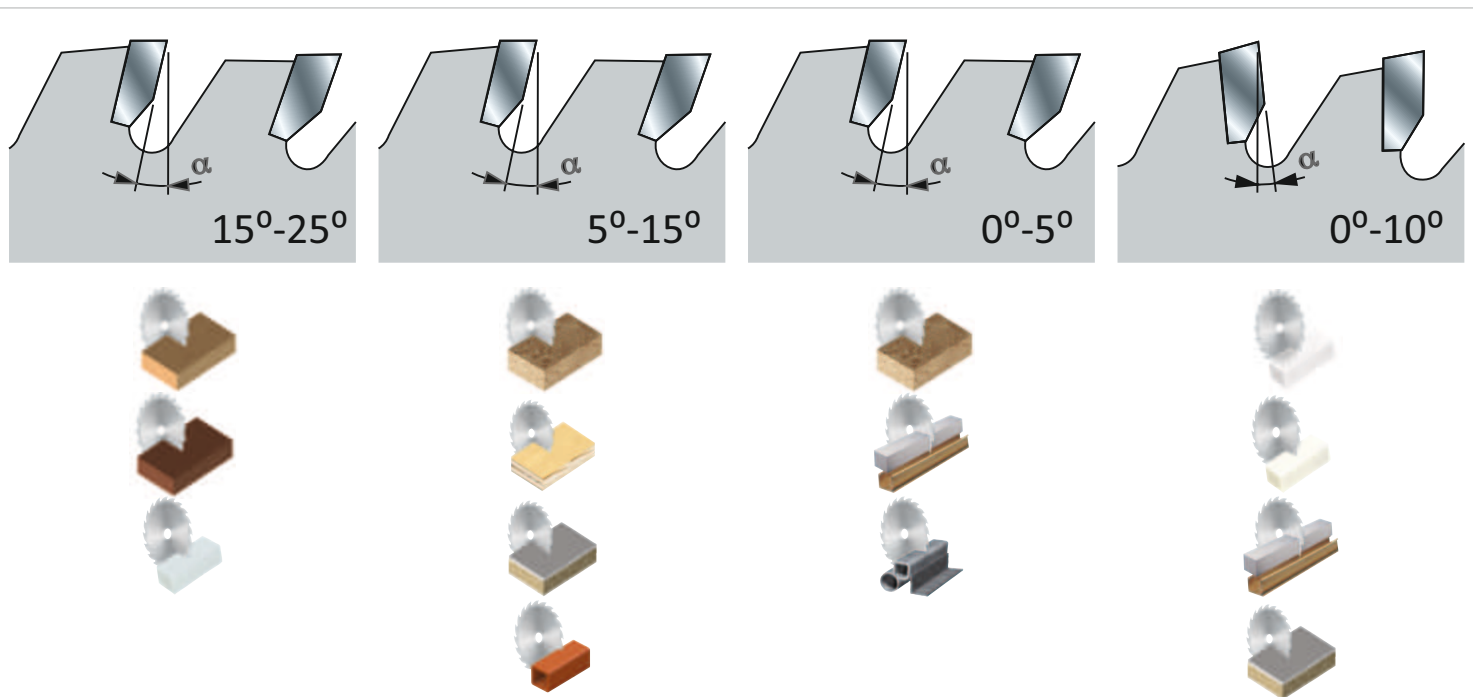
Geometria ostra



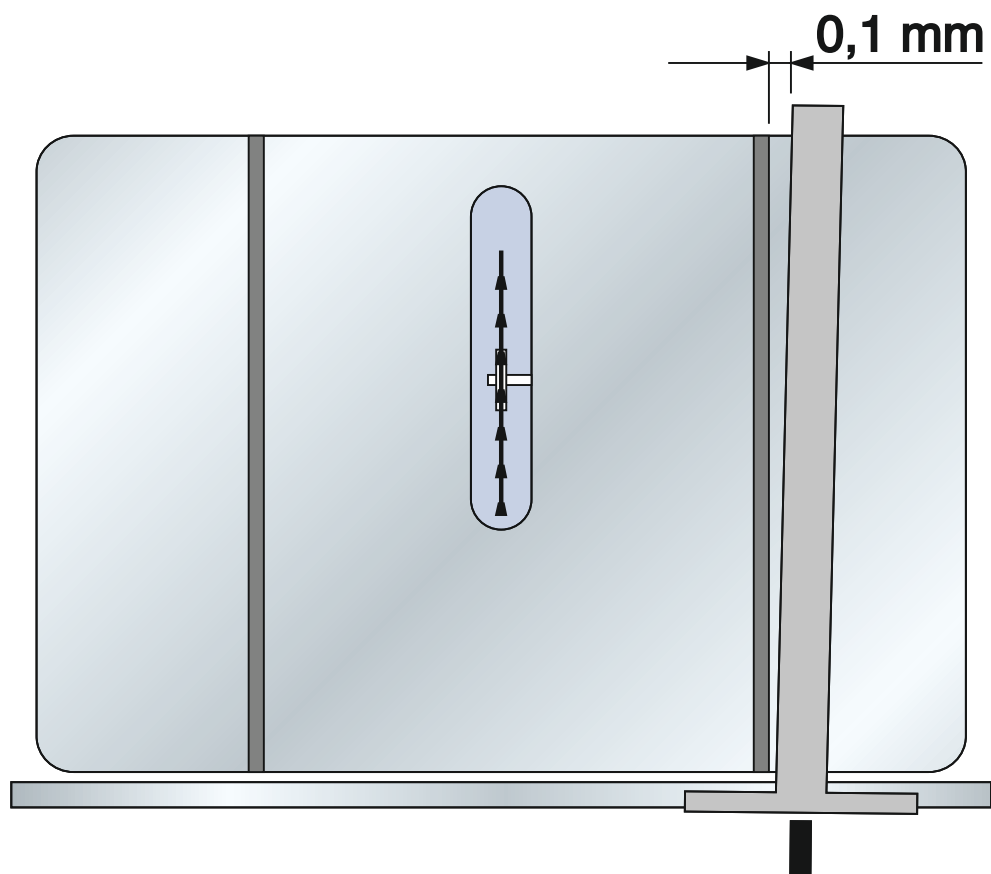
Pozdĺžne - priečne rezanie masívu



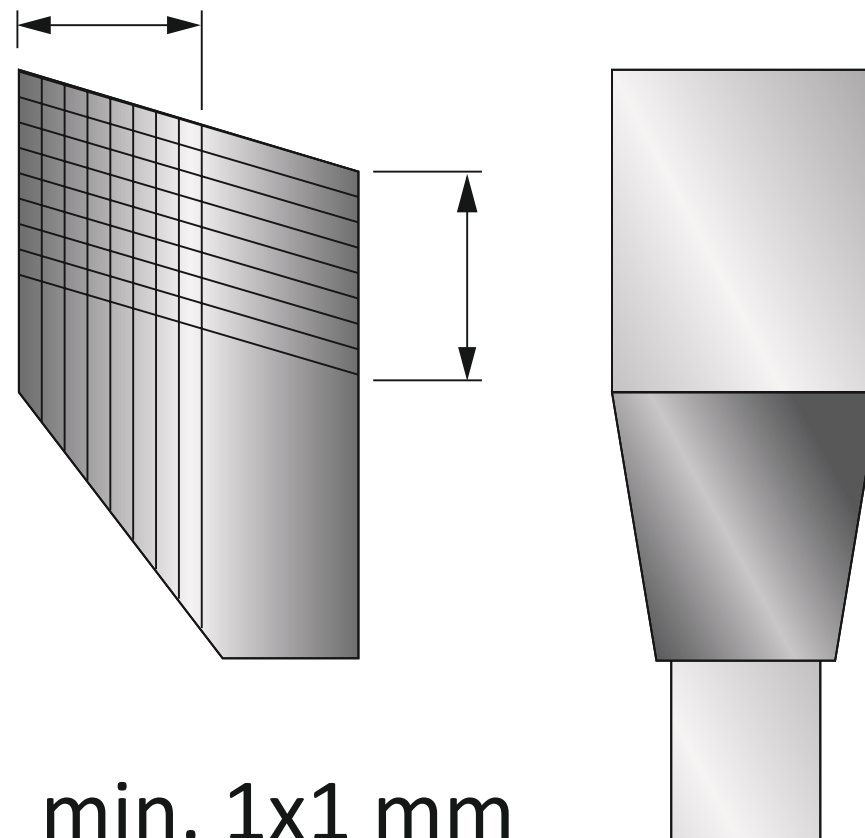
Ostrenie pílových kotúčov



Uhol čela



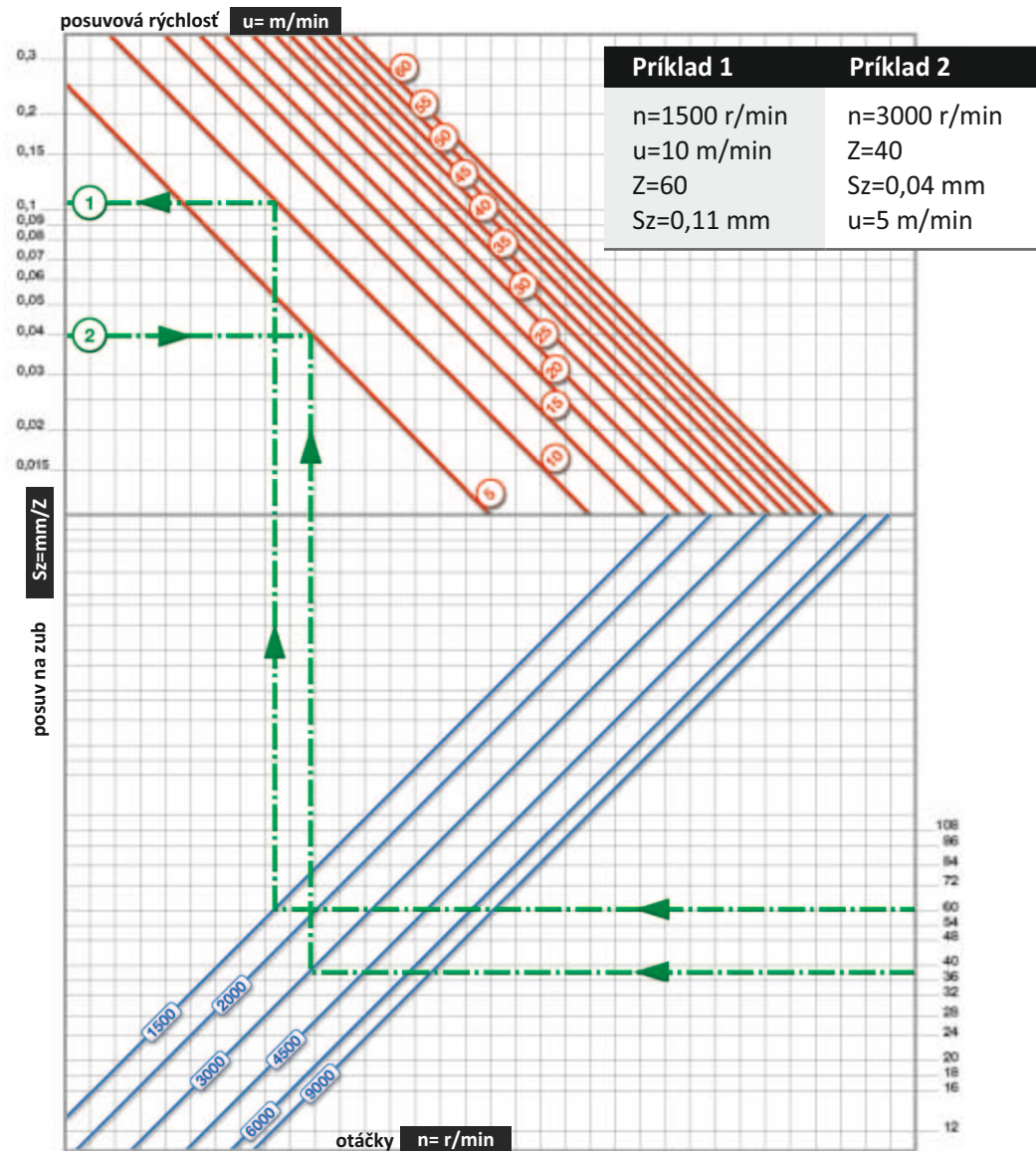
„Otvorené“ paralelné pravítko



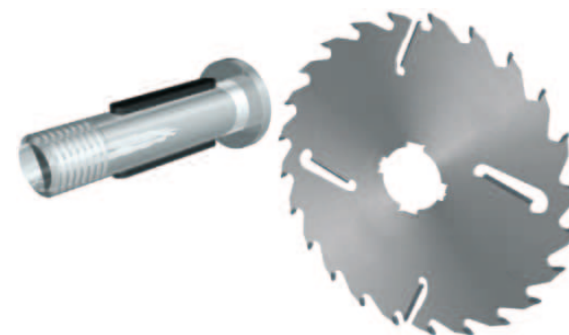
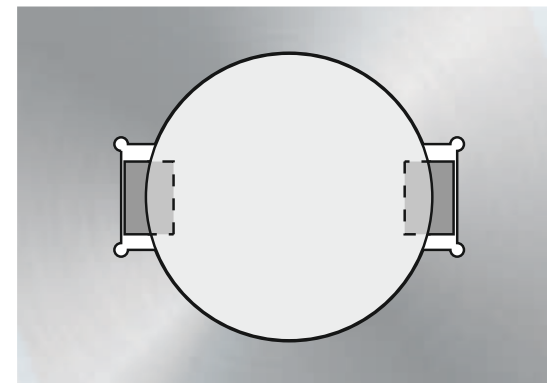
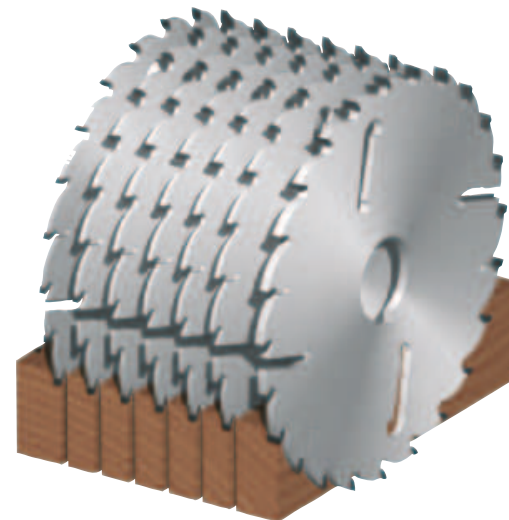
Počet ostrení

Odporúčaná rýchlosť posuvu na zub ($S_z = \text{mm/zub}$)		Obrobok
0,20 - 0,30		mäkké drevo priečne
0,10 - 0,20		mäkké drevo pozdĺžne
0,06 - 0,15		tvrdé drevo
0,10 - 0,25		drevotrieska

Odporúčaná rýchlosť posuvu na zub ($S_z = \text{mm/zub}$)		Obrobok
0,05 - 0,12		preglejka
0,05 - 0,10		laminát
0,02 - 0,25		ALU, plast, kompozit



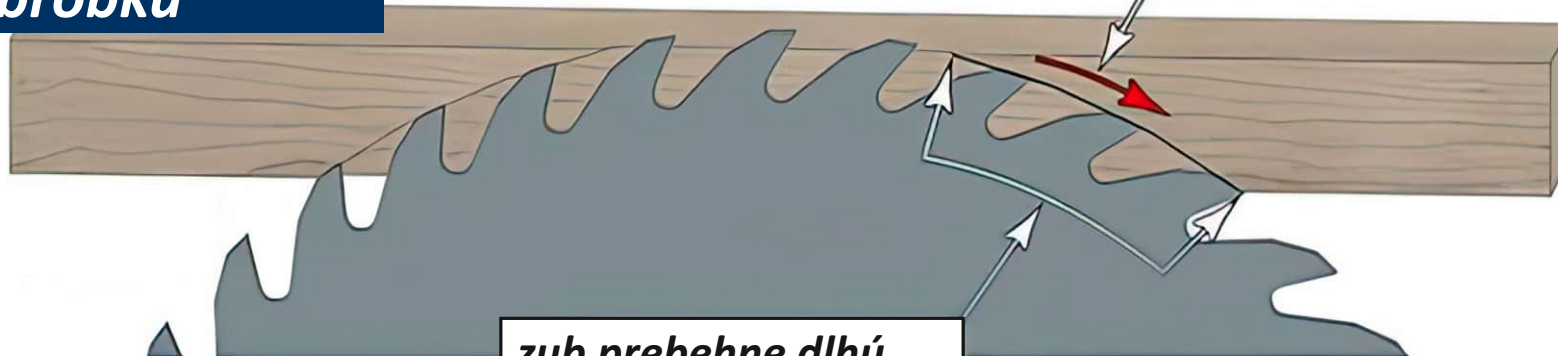
Odporúčané hodnoty pre rezanie



Rozmietacie pílové kotúče

**NÍZKA pozícia
kotúča voči
obrobku**

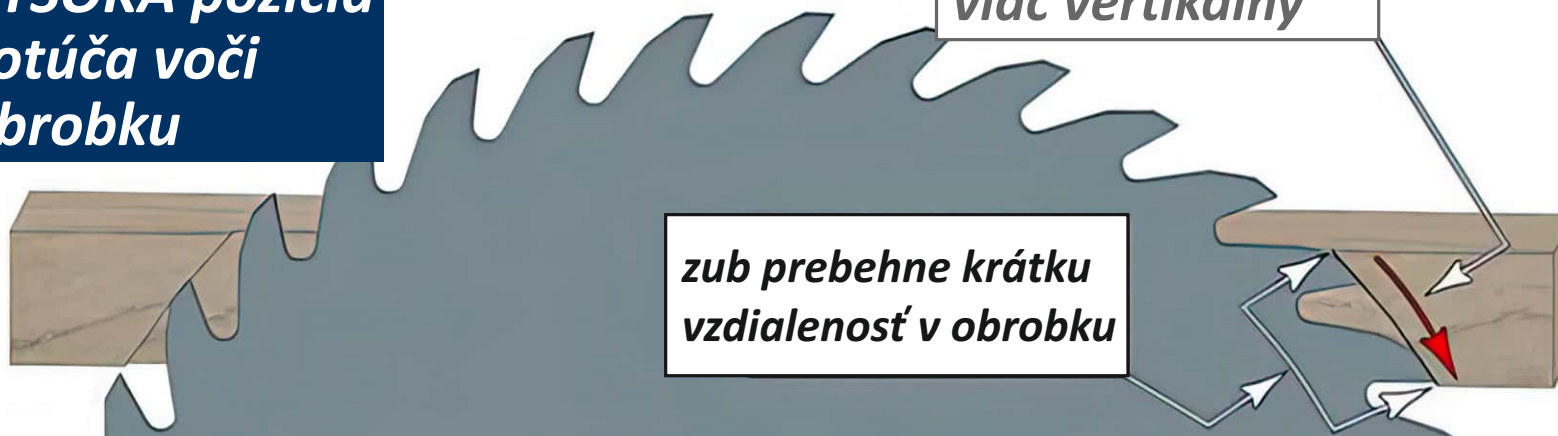
rezný odpor je
viac horizontálny



zub prebehne dlhú
vzdialenosť v obrobku

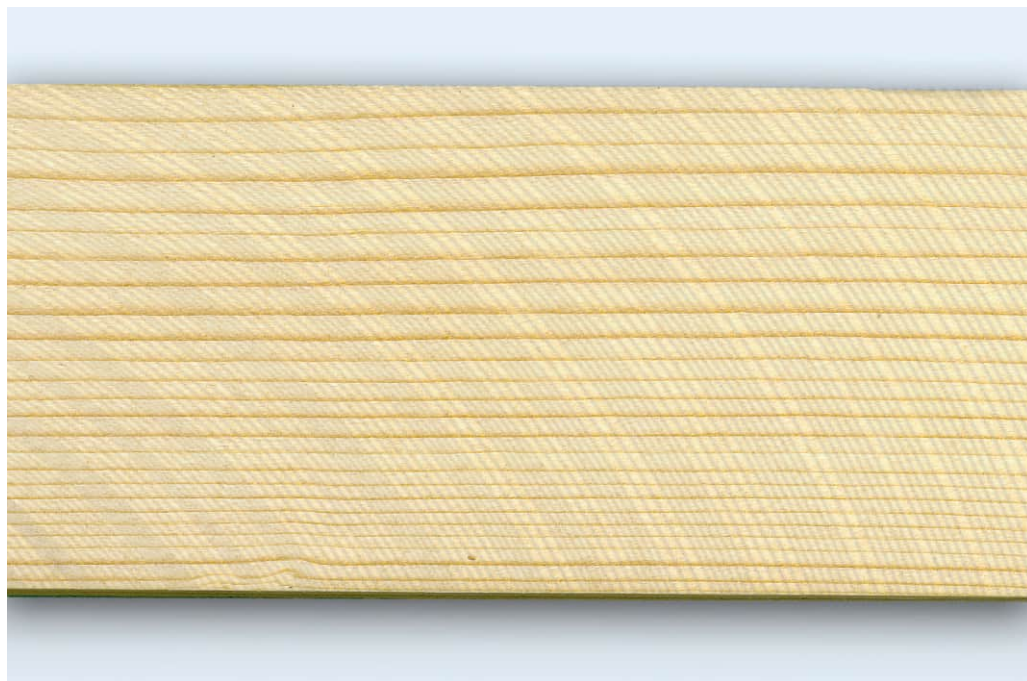
**VYSOKÁ pozícia
kotúča voči
obrobku**

rezný odpor je
viac vertikálny

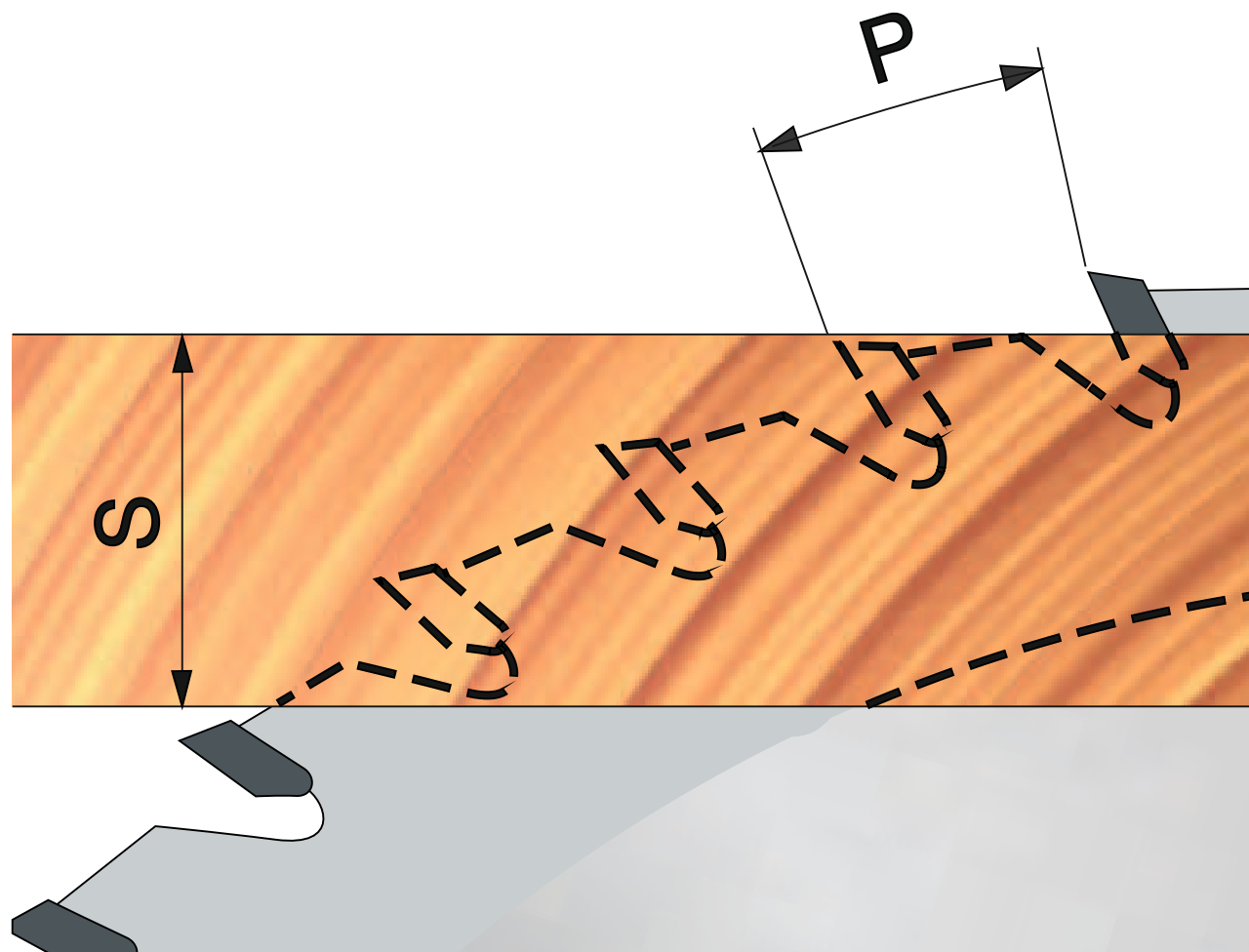


zub prebehne krátku
vzdialenosť v obrobku

Pozícia kotúča voči obrobku



Kvalita rezaného povrchu obrobku

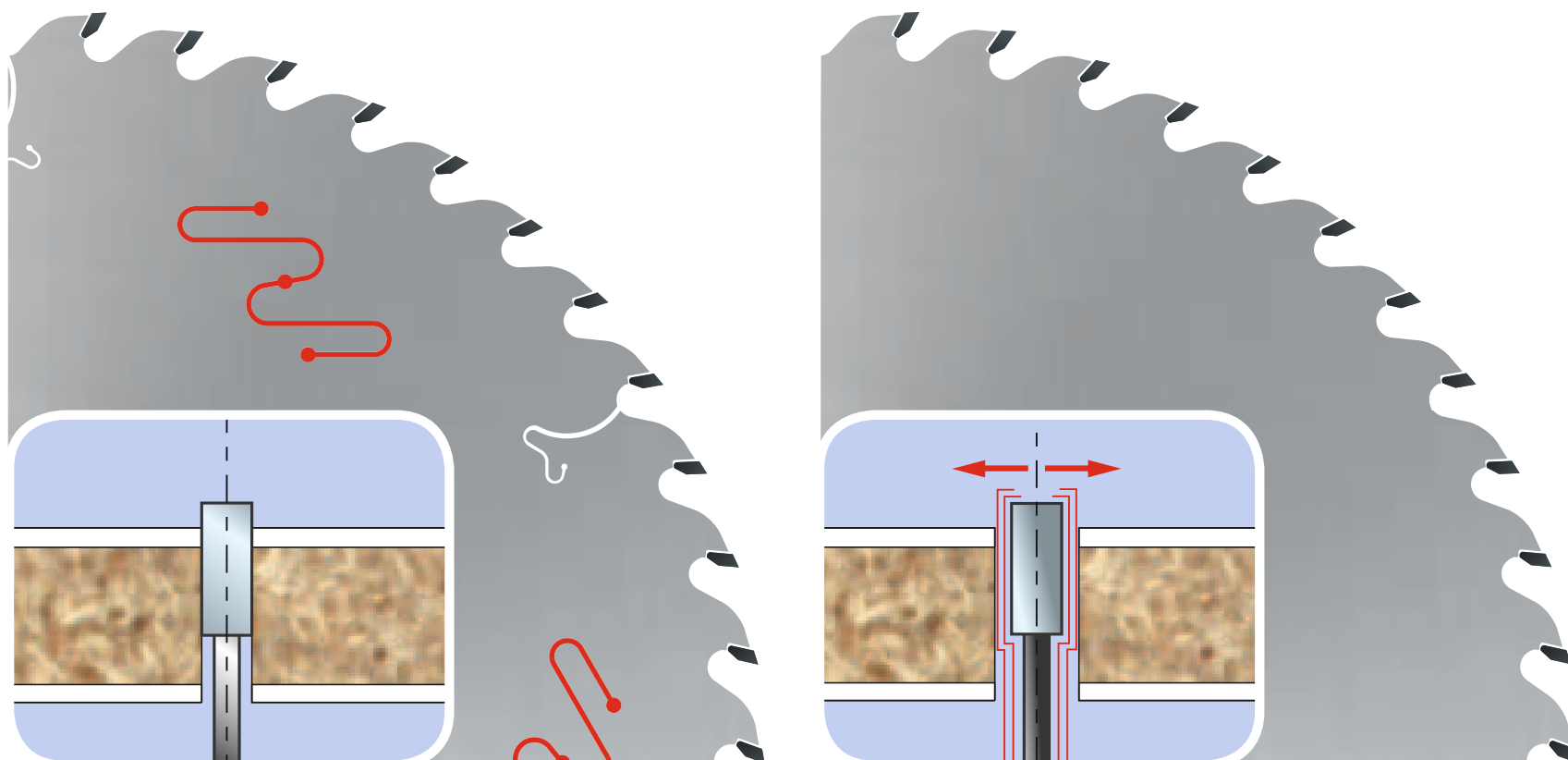


$$P = \frac{S \times 1,4142}{3}$$

$$Z = \frac{D \times 3,14}{P}$$

$$Z = \frac{D \times 8}{S}$$

Závislost' hrúbky obrobku na počte zubov



Antivibračné otvory v tele kotúča



ručný posuv

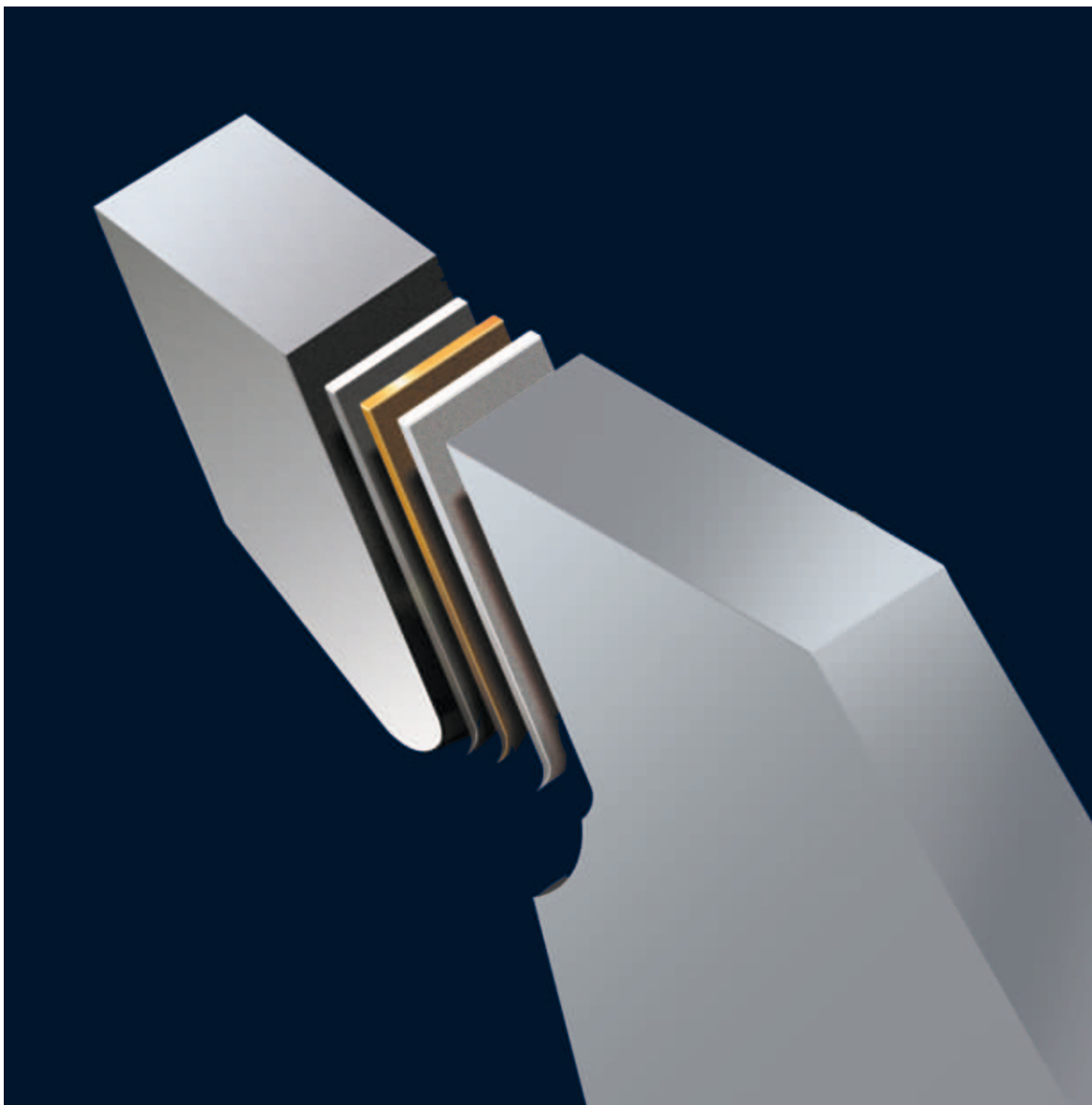


strojný posuv

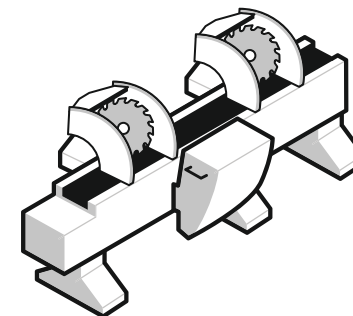
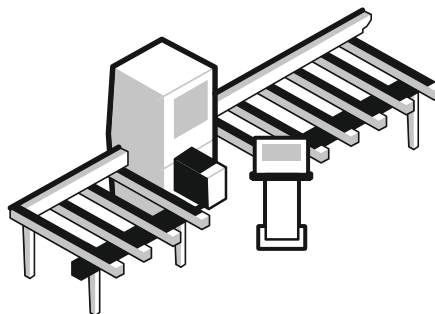
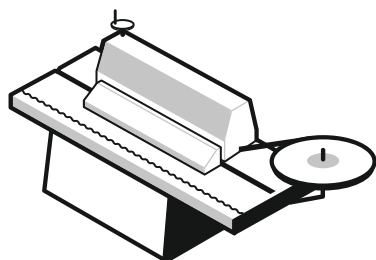
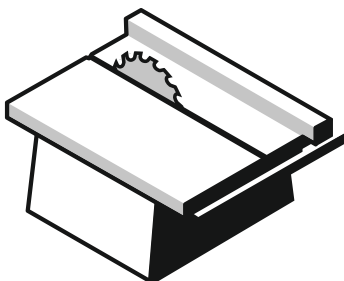
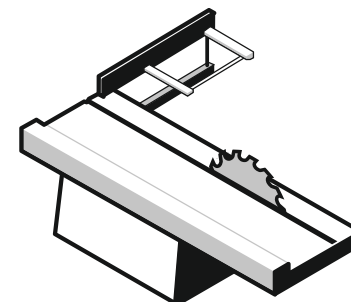
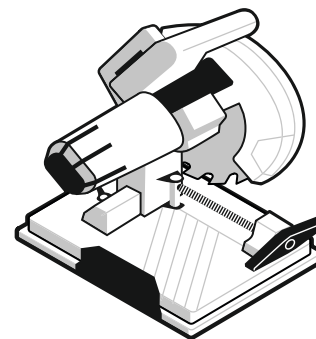
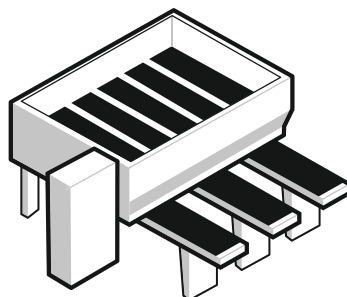
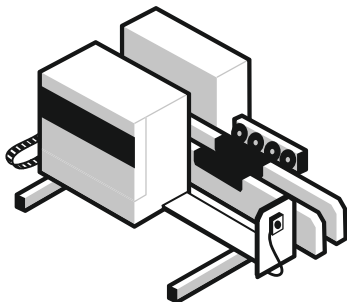
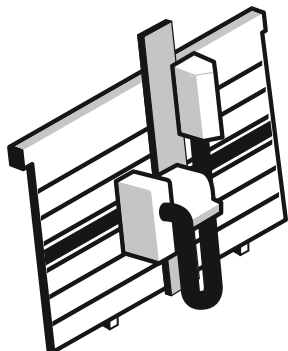
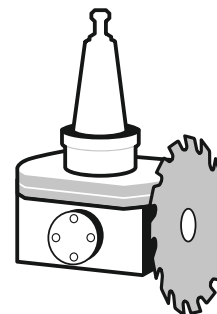
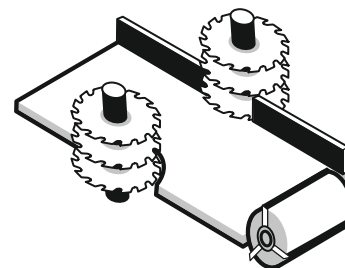
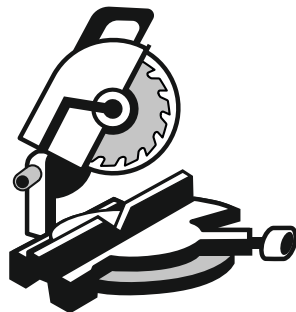
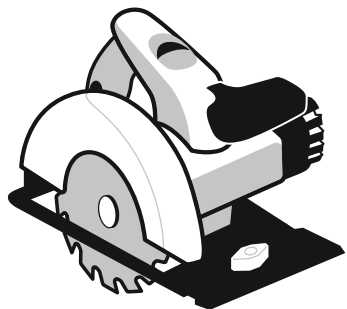
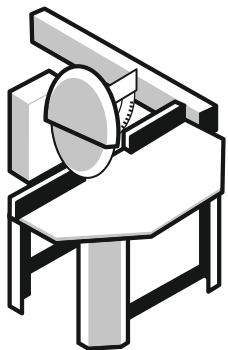
Vyhotovenie pílového kotúča



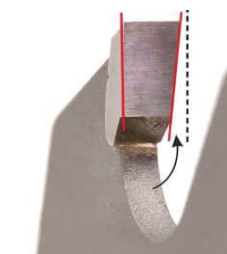
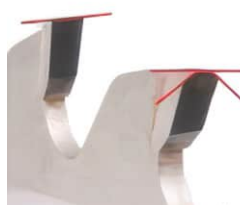
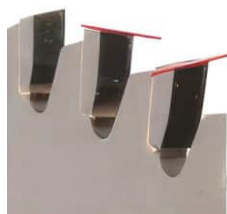
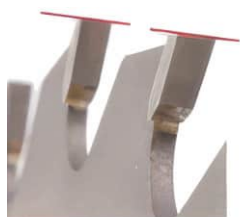
Čistenie kotúčov PULITOOLOM



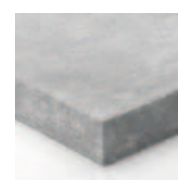
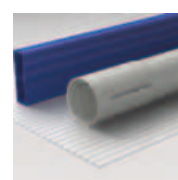
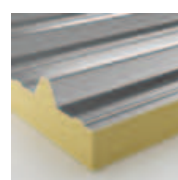
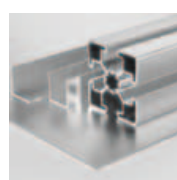
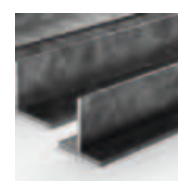
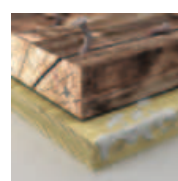
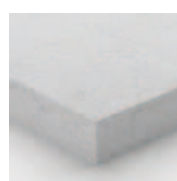
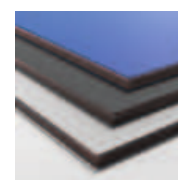
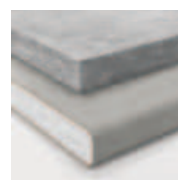
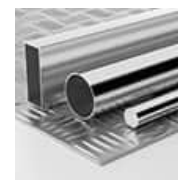
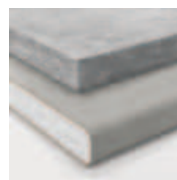
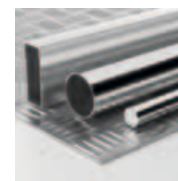
Navarenie plátku na telo kotúča



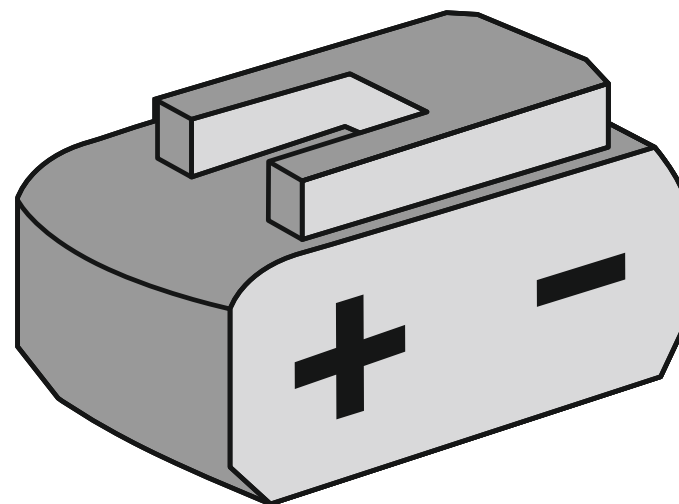
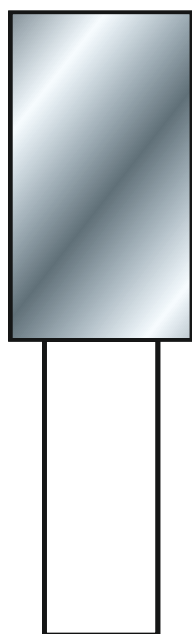
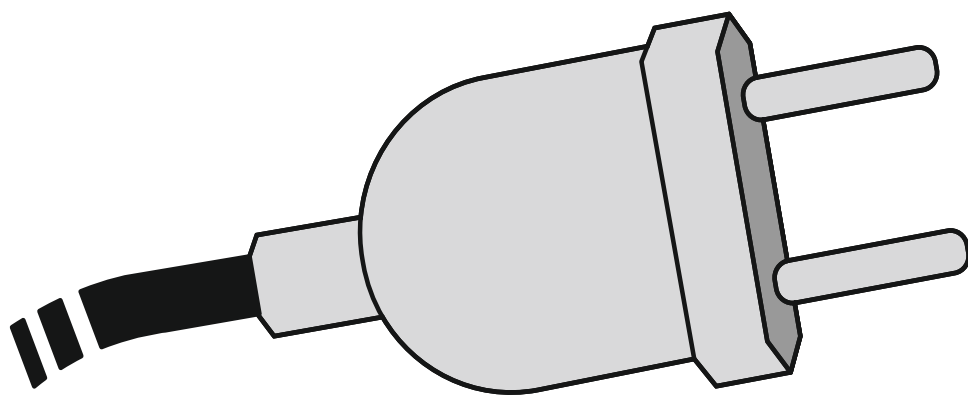
Typ stroja



Tvar zuba



Druh rezaného obrobku



Znižovanie merného rezného odporu