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Izvorni znanstveni članak

Influence of saw blade clearance over the workpiece on tool-wear

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Sažetak

This paper presents the results of experimental measurement of tool-wear in the cutting process with circular saw of oak wood depending on the upper clearance of 5mm and 50 mm, respectively. The circular saw blade made of HSS by Pilana was used for the experiment. The measurement was carried out by the experimental equipment designed by the Department of Woodworking, Technical University of Zvolen and DMMA-36 circular saw made by Reszelski Zaklad Przemyslu Leoenictwa in Reszel. The tool-wear was evaluated by two parameters and namely by the radius of the cutting edge r_n and by the cutting edge recession SV. The results of tool-wear are presented in dependence on the indicated chip length and cutting material length. With the change of the clearance from 5 mm to 50 mm and with the thickness of the test specimen $h = 30$ mm almost double amount of sawn wood is required to attain the same chip length. The results have shown that in dependence on the length of the cutting material, the tool wear is smaller at a higher clearance of saw blade over the workpiece.

Ključne riječi

circular saw; tool-wear; clearance; saw blade

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