

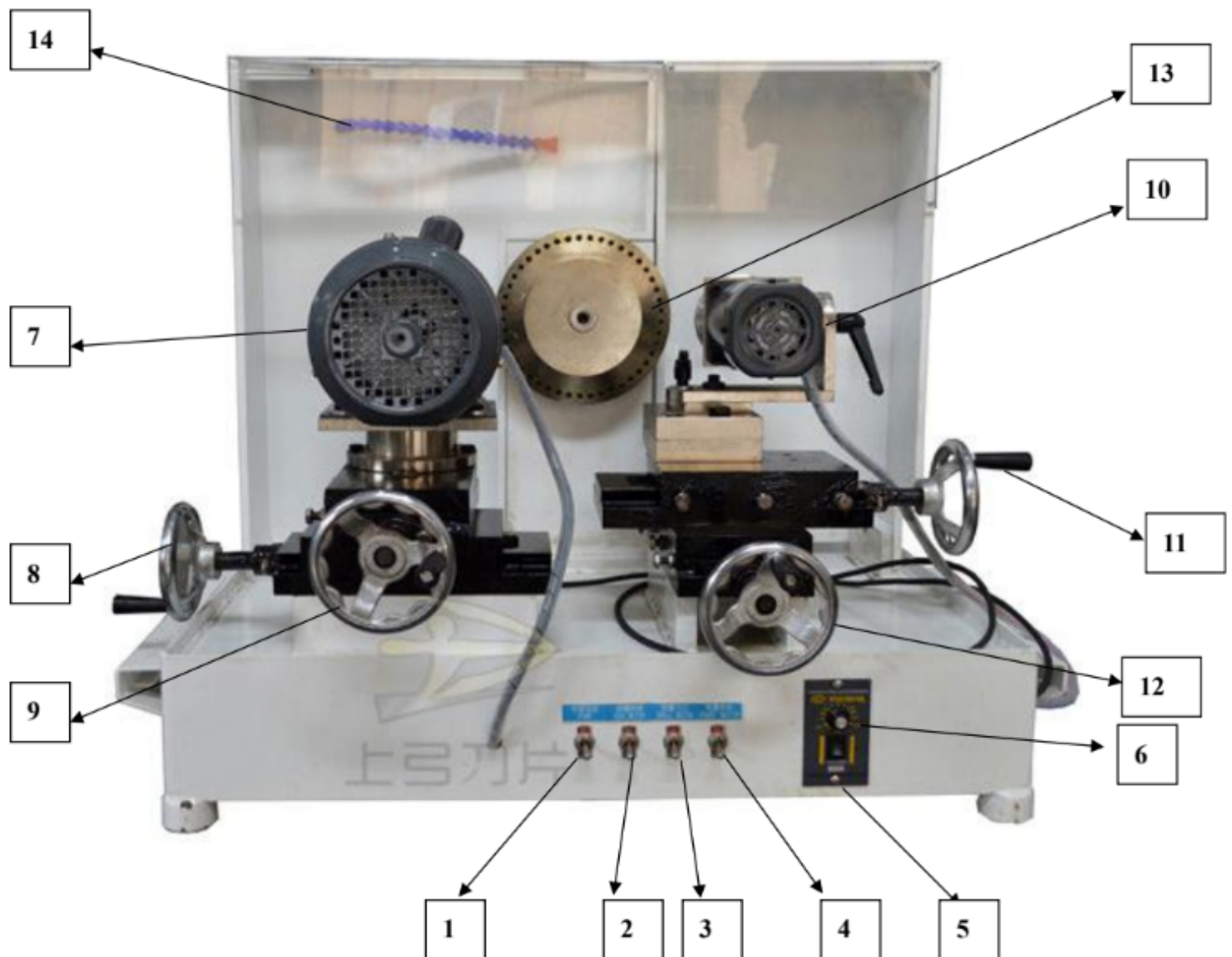


บริษัท ชินไทย อินดัสเทรียล จำกัด
HSIN-THAI INDUSTRIAL CO., LTD

Round Knife Grinding Machine Model: SG-500



Configuration	
● Main axle motor	Main axle 40w speed adjustable motor Taiwan Shenli;
● Knife slope grinding	Knife slope 550W Nanjing gaoqi (Taiwan company) (Angle adjustable+/- 15°)
	Grinding wheel 125 x 48x16*3mm
● knife edge grinding	Knife edge 140W Taiwan shenli (Angle adjustable+/- 15°)
	Grinding wheel CBN 100 x 29x12*3mm
● Cooling pump	60W
● Round knife fixture	100/160(standard size can grind OD350, over this size is optional parts)



1. Knife bevel grinding wheel rotation switch
2. Cooling motor switch
3. Knife edge grinding wheel rotation switch
4. Power switch
5. Round knife rotation switch
6. Round knife rotation speed knob
7. Knife bevel grinding motor

8. Knife size adjustment handle
9. Feed grinding handle
10. Knife edge grinding motor
11. Knife size adjustment handle
12. Feed grinding handle
13. Round knife fixture
14. Cooling pipe

Function

1. Round knife bevel grinding.
2. Round knife edge sharpening.
3. Round knife knife bevel and knife edge mirror surface grinding.

Application

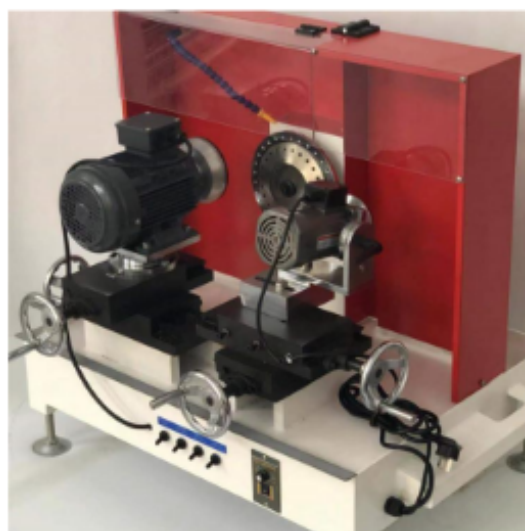
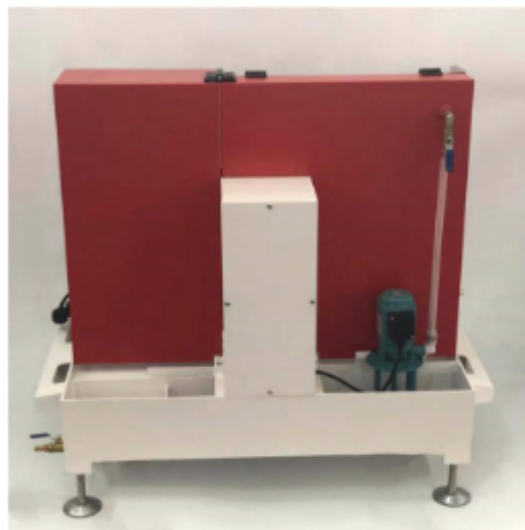
Size: outer diameter 50-500mm round knife

Material: 9CrSi, SKD-11, SKH-51, High speed steel, alloy steel, stainless steel, Tungsten carbide and so on.

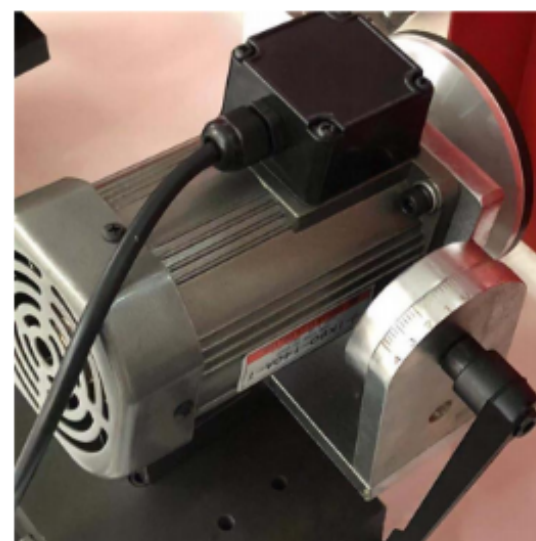
Type: Roll cutting knife, slitting knife.



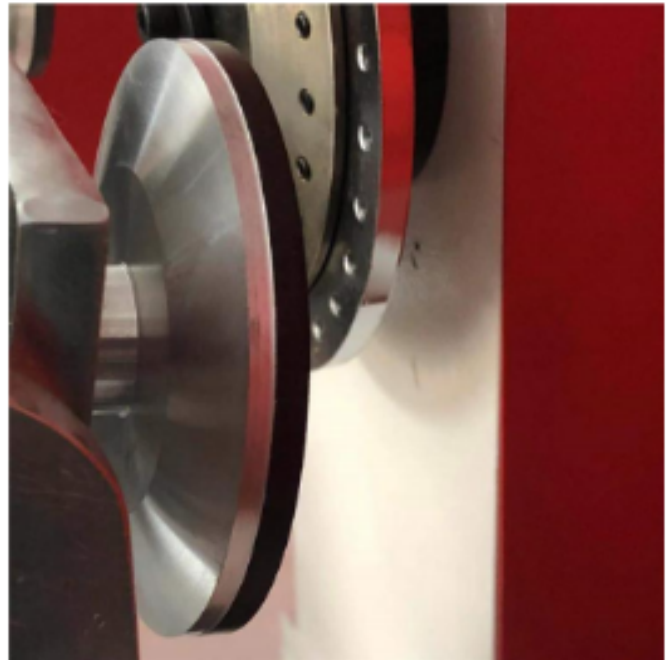
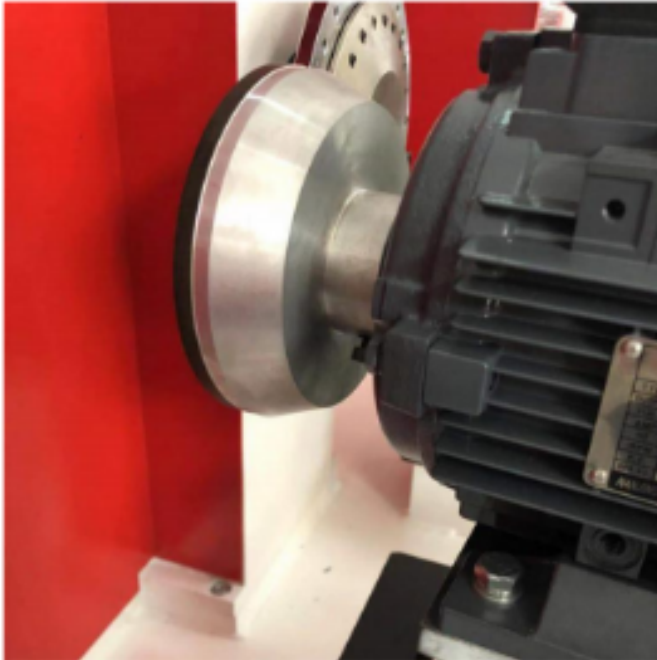
Round Knife Grinding and Sharpening Machine



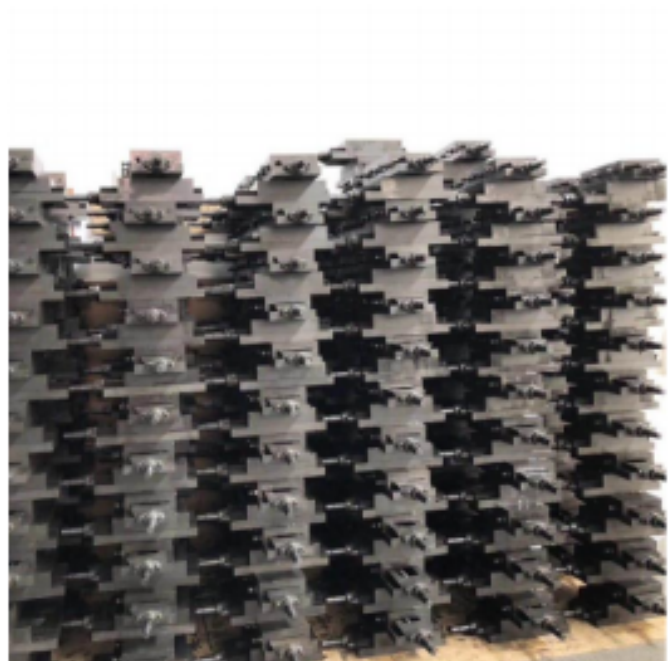
Taiwan's brand water-proof motor



Big and small grinding wheel



Japanese Brand NSK bearing and installation parts



Operation manual

The machine can grind Φ 50-500 round knife with a variety of angles.

Preparation work

1. Check if there is notch in the edge of knife, if the notch is big, using wire cutting method to cut the notch part and make the knife round.
2. Measure the length of the large and small bevel angle for the next grinding reference.
3. Choose fixture: the size of inner fixture should be close to the diameter of knife big bevel ; the outer fixture should be selected smaller than the inner fixture as long as it does not affect the grinding.
4. Measure the inner hole of the knife. If a ring is required, insert the ring into the inner hole of the round knife and install it together with the knife shaft. (Normal knife inner hole 25.4mm)
5. After the knife is fixed, diameter Φ 150 (Φ below 150 generally does not need correction, rely on the fixture for guarantee) above Φ 150 must use dial indicator to correct knife surface, correction position generally choose the middle of the big bevel, correction standard is: the plane runout should be below 0.04, otherwise there would be double knife edge, when we adjust the knife plane runout, we mainly adjust the inner fixture adjustment screws, try adjust outside fixture as little as possible.
6. Grinding step: Firstly understand the abrasion degree of the knife. If only the cutting edge of the knife is blunt, use the small motor No10 to sharpen the blade. The grinding angle is determined by the user, then adjust the scale of No. 10 small motor, Grinding after it is locked.

7. Please refer to the circular knife specification sheet on the grinding angle. The angle of the diagram is only for reference. The most important factor is determined by the hardness of the material after testing

8. Motor maintenance

When using only a large edge grinding motor or a small edge grinding motor, the another motor should be covered to reduce dust and water mist entering the motor to cause leakage or short circuit. The dirt on the motor fan should be cleaned frequently to ensure good heat dissipation. The dust inside the large oblique motor should be cleaned regularly by a professional electrician with an air gun to prevent the motor from leaking or short-circuiting when the humidity is high. The sludge in the tank should be cleaned once or twice per shift to prevent the waterproof pumps and water pipes is blocked. When replacing the grinding wheel, please pay attention to locking the fastening screw to prevent the grinding wheel from rubbing against the motor body, resulting in excessive motor load and even burning of the motor.

9. Cutting fluid of this machine: aqueous emulsion. Use a standard emulsion when grinding, otherwise the machine will be rusted, resulting in reduced accuracy.