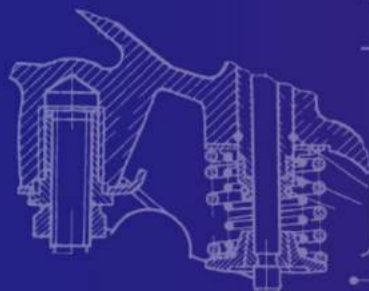




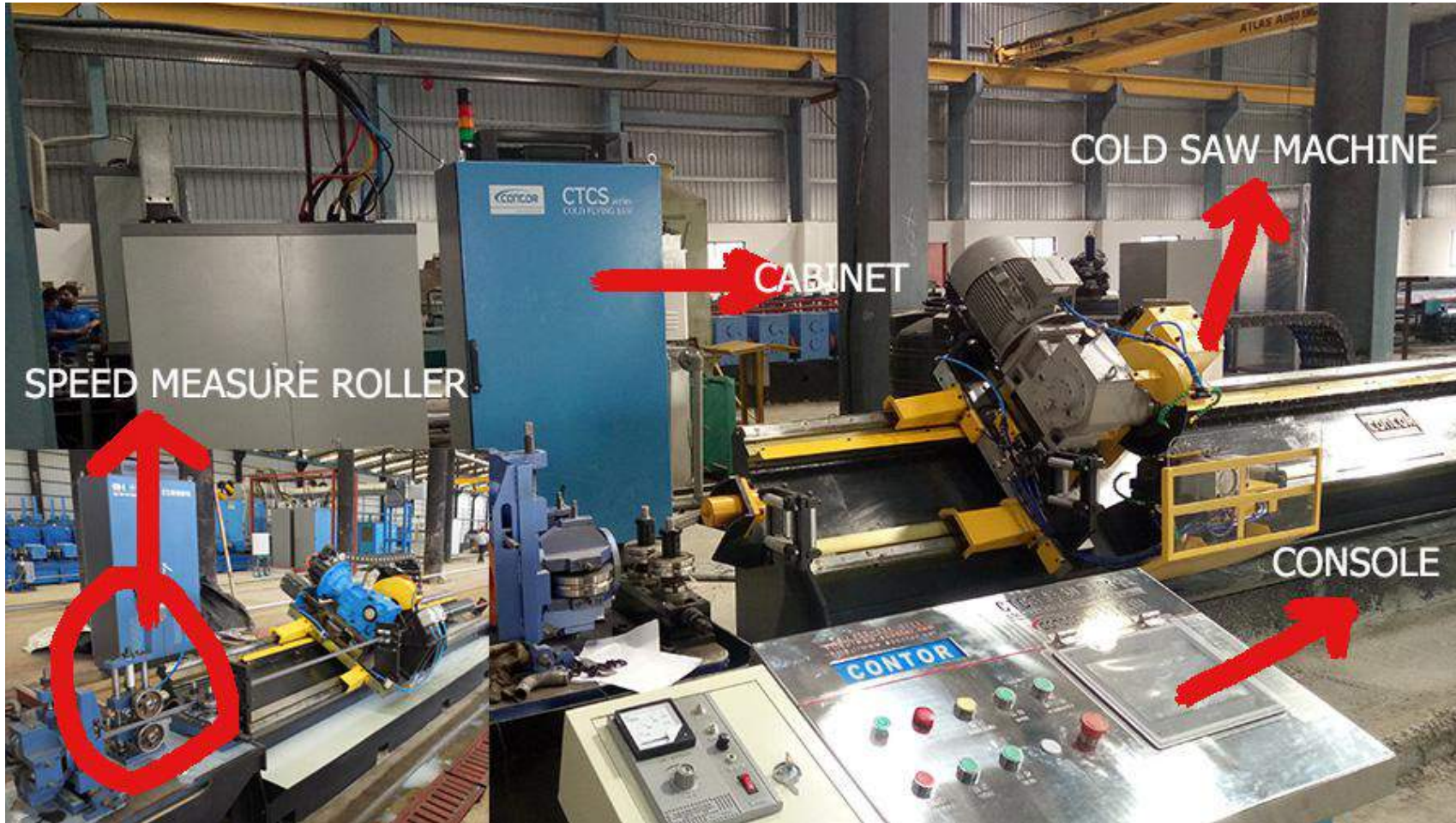
CONTOR COLD SAW OPERATION

SHENYANG CONTOR M.&E.CO.,LTD

2018-12-11



Equipment Composition

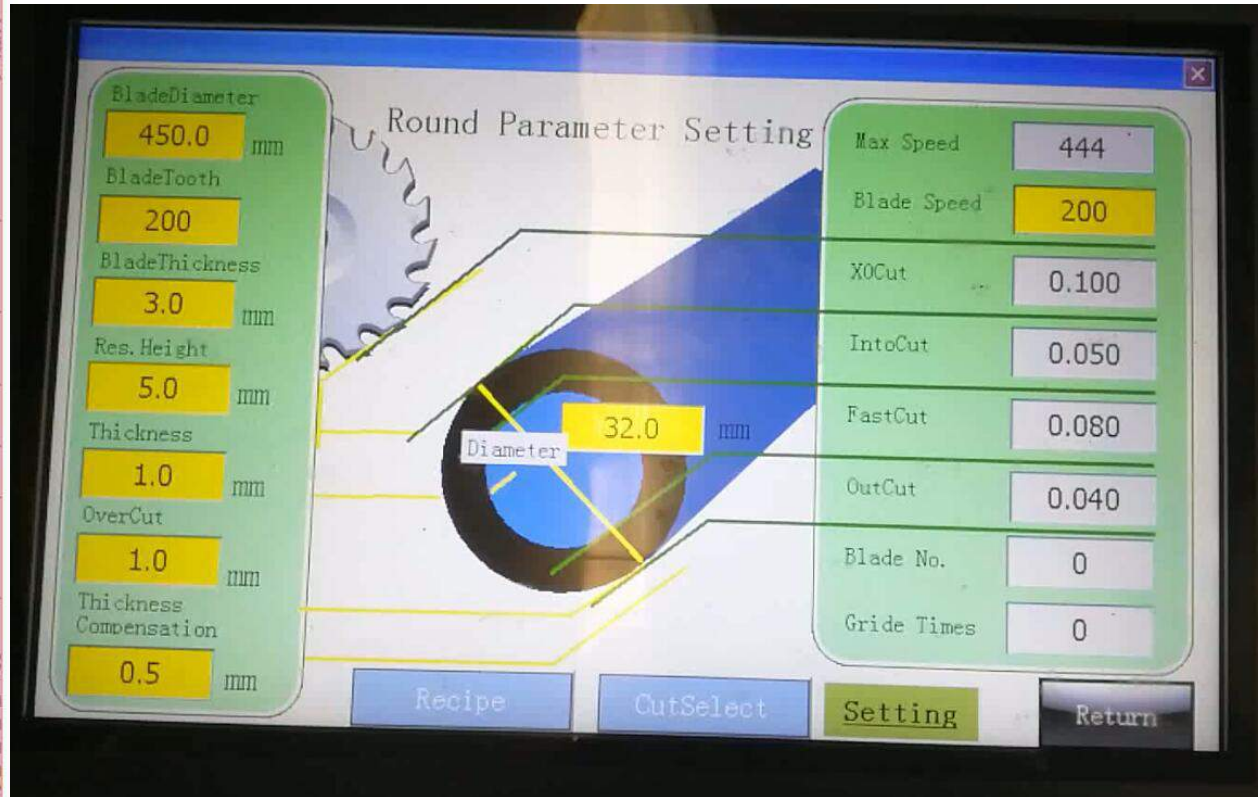


1.Preparation of operation



- Press button of "Power ON" , and then wait for the initiation of the HMI and the control system.
- Check the saw (clamps, speed measuring device) to make sure there' s nothing abnormal.

2. Running



- On the Touch screen, according to the pipes you' re going to produce, set the parameters of pipe OD, wall thickness and the cutting length.
- Measure the real blade parameters (OD and teeth quantity) and input these parameters through the tough screen to set suitable blade line speed and feed amount.

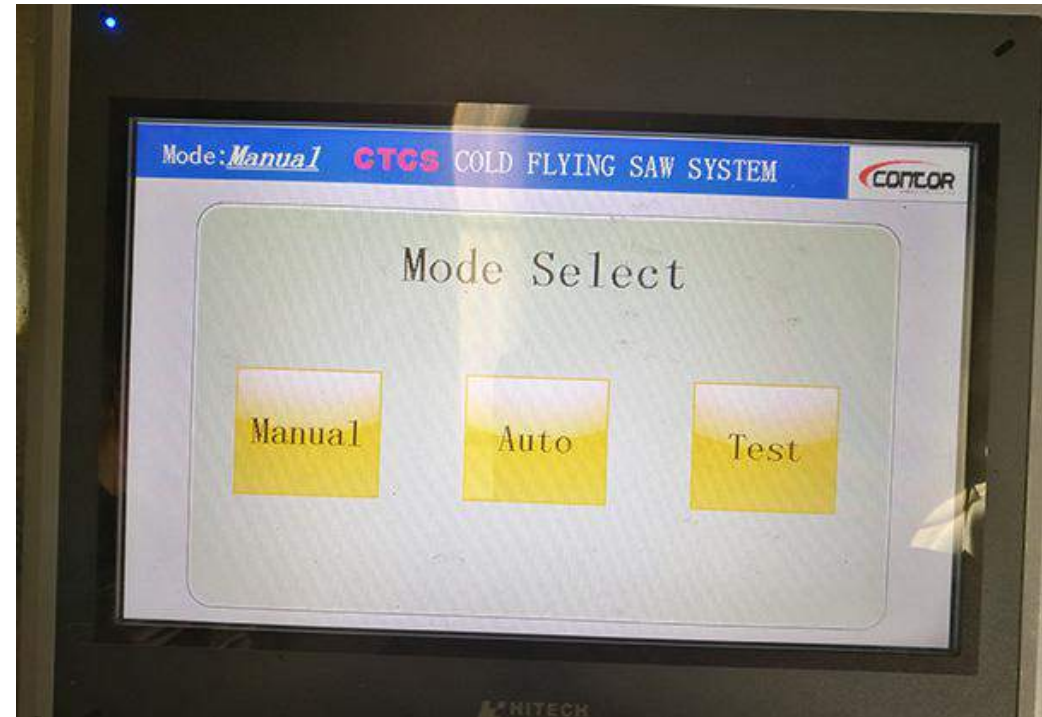
2. Running



- After finishing the above procedures, press orderly the buttons of feeding on, blade on and cart on and clamps on to make the machine cut in the condition of no pipes and observe if everything for cutting is normal.



- Test running: when you're going to produce a new size pipes or make maintenance for the saw, please do test running. Make the saw to be on the zero position by manual mode, set suitable test speed and let the saw run some minutes to make sure there's nothing abnormal and then exit from the test mode.



Auto running





- Auto running: First of all, please confirm the clamps and the speed measuring device are ready. Then make the cart and feeding to be on the zero position by manual to enter the auto mode. Press the short scale to see if the cutting is normal and if the cutting edge is qualified. Make some adjustment when the cutting can not meet your requirement.
- When everything is ready, make the saw begin to produce automatically.

3. Power off



- In the state of pipe stopping running, change the test mode to manual mode and then press the buttons of feeding off, blade off and cart off.
- Make records of running, and press button of power off. The system has no power and you can clean or maintain the saw.

4. Contor Cold Saw Spare Parts

Name	Qty	Brand	Country	Example
Touch Screen	1	Hitech	China	
Linear Guide Rail	1	THK/HIWIN	Japan/Taiwan	
Ball Screw	1	THK/HIWIN	Japan/Taiwan	
Saw Blade	2	JULIA/KINKELDER/STARK	**	
Clamp Blocks	4	Contor	China	
Motion Controller CT-III	1	Contor	China	



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THANKS

