

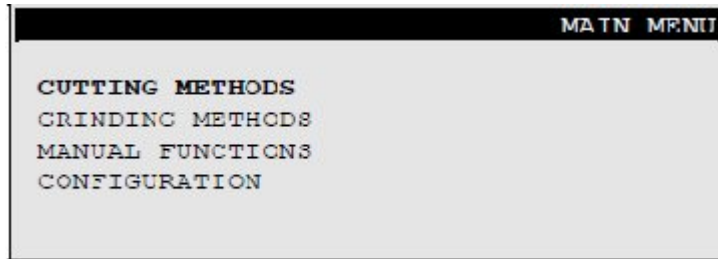
# Accutom-50

## InstructionManual

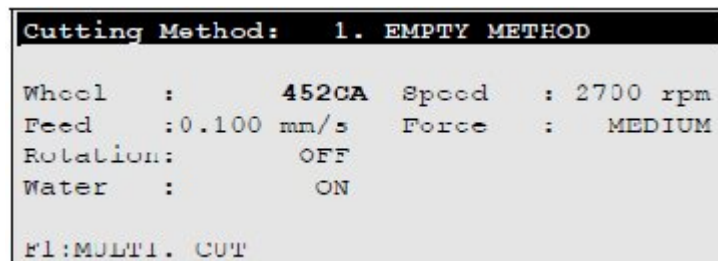
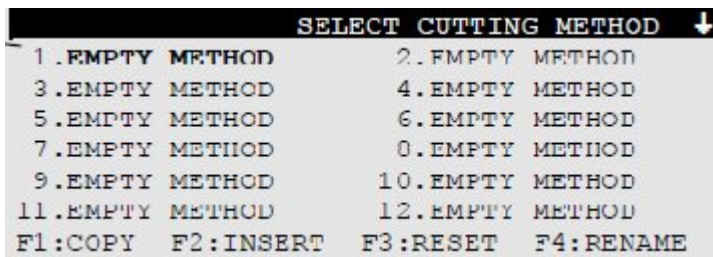


# Cutting with Accutom-50

- Switch on the power at the main switch located at the back of the machine.
- Select Cutting Methods and press Enter




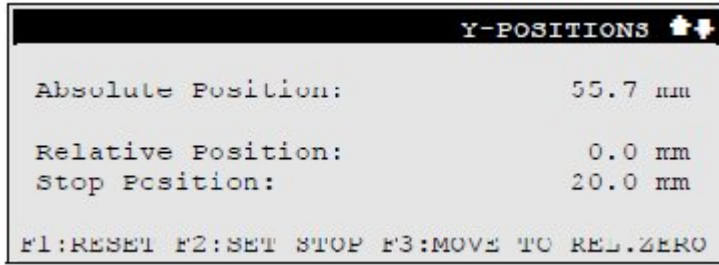
- Select the method you want to use and press Enter.






- Place the specimen holder with the sample in the specimen holder head and clamp it.






## **If you know the cutting length.**

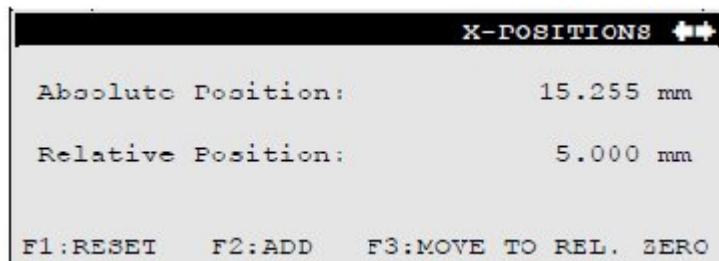
- Position the sample correctly in front of the cut-off wheel using the positioning key.
- Press one of the positioning key  to change to the Y-Positions screen.




- Press **F1-RESET** to reset the relative Y-Position.
- Press Enter  and use the **MENU** arrow  to adjust the Y-stop value. Press Enter  again to accept the new value or Esc to cancel.

**If you do not know the cutting length in advance:**

- Position the sample correctly in front of the cut-off wheel using the positioning keys.
- Press **F1:RESET** to reset the relative X-position.
- Press one of the positioning keys  to change to the Y-Positions screen.
- Press **F1:RESET** to reset the relative Y-position.
- Move the sample to the right using the positioning key  so that it can pass along the cut-off wheel.
- Move the sample along the cut-off wheel to the desired stop position using the positioning key . Press **F2.SET STOP** to record the stop position.
- Press **F3:MOVE TO REL:ZERO** to move the sample back to the initial Y-position.
- Press one of the positioning keys  or  to change to the X-Positions screen.



- Press **F3:MOVE ZERO TO REL:** to move the sample back to the initial X-position.
- Press **START**  to start the cutting process.

Recommended Cutting Parameters				
Material	Hardness	Force limit	Feed speed [mm/s]	Wheel speed [rpm]*)
Ceramics, minerals and crystals	> HV 800	LOW	0.005-0.15	5000
		LOW	0.005-0.20	4000
		HIGH	0.005-0.30	3200
		HIGH	0.005-0.30	2700
Sintered carbides and hard ceramics	> HV 800	MEDIUM	0.005-0.25	3200
		MEDIUM	0.005-0.25	2700
Extremely hard ferrous metals	> HV 500	MEDIUM	0.005-0.25	5000
Hard and very hard ferrous metals	HV 350-800	MEDIUM	0.05-0.30	1000-5000
		MEDIUM	0.05-0.30	1000-5000
Hard and very hard ferrous metals with larger dimensions	HV 350-800	MEDIUM	0.05-0.30	1000-5000
Soft and medium soft metals	HV 30-350	MEDIUM	0.05-0.30	1000-5000
		MEDIUM	0.05-0.30	1000-5000
Soft and ductile non ferrous metals	HV 70-400	MEDIUM	0.05-0.30	1000-5000
Plastics and very soft metals	< HV 100	MEDIUM	0.05-0.30	max. 1200