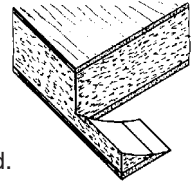


S-37 SEGMENTED HOGGING UNITS



Hoggers are used for simultaneous trimming and hogging of off-cuts on double-end tenoners, trim saws and dimensioning saws.

The trimming saw is selected according to the material such as solid wood, boards with or without veneer or plastic laminates, plywood, blockboard, chipboard and hardboard.



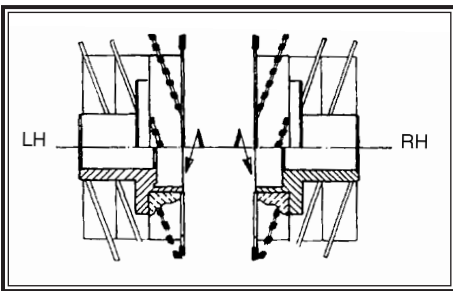
S-37 HOGGING UNITS

PART NO. STANDARD	DIAM. INCH	DIAM. MM	TEETH SAWS	NO. OF SEGMENTS	TEETH ON SEGMENTS	TOTAL WIDTH	MAX BORE	SAW TOOTH STYLE
372003040L/R	8	200	40	4	7	30	40	LH OR RH BEVEL
372003060L/R	8	200	60	4	7	30	40	LH OR RH BEVEL
372503048L/R	10	250	48	4	7	30	80	LH OR RH BEVEL
372503072L/R	10	250	72	4	7	30	80	LH OR RH BEVEL
373003048L/R	12	300	48	6	7	30	80	LH OR RH BEVEL
373003072L/R	12	300	72	6	7	30	80	LH OR RH BEVEL
373503060L/R	14	350	60	8	7	30	100	LH OR RH BEVEL
373503084L/R	14	350	84	8	7	30	100	LH OR RH BEVEL

NOTE: HUBS NOT INCLUDED IN PRICES

S-37 REPLACEMENT HOGGER SAWS

PART NO. STANDARD	DIAM. INCH	PLATE MM	PLATE INCH	KERF INCH	TEETH	HOOK ANGLE	STANDARD BORE	SAW TOOTH STYLE
37200408L/R	8	2.6	.102	.142	40	15	80	LH OR RH BEVEL
37200608L/R	8	2.6	.102	.142	60	15	80	LH OR RH BEVEL
372504813L/R	10	2.6	.102	.142	48	15	130	LH OR RH BEVEL
372507213L/R	10	2.6	.102	.142	72	15	130	LH OR RH BEVEL
373004813L/R	12	2.8	.110	.150	48	15	130	LH OR RH BEVEL
373007213L/R	12	2.8	.110	.150	72	15	130	LH OR RH BEVEL
373506015L/R	14	3.0	.118	.158	60	15	150	LH OR RH BEVEL
373508415L/R	14	3.0	.118	.158	84	15	150	LH OR RH BEVEL



S-37 EXTENSION HOGGERS

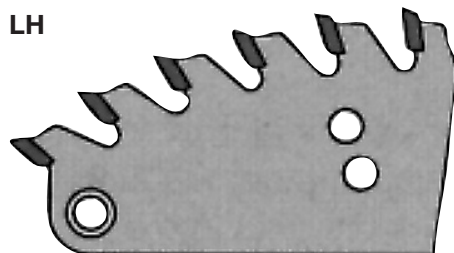
PART NO. STANDARD	DIAM. INCH	DIAM. MM	WIDTH MM	WIDTH INCH	TEETH ON SEGMENT	NO. OF SEGMENTS	MAX. BORE
37200300407	8	200	30	1 3/16"	7	4	80
37250300407	10	250	30	1 3/16"	7	4	80
37300300607	12	300	30	1 3/16"	7	6	80
37350300807	14	350	30	1 3/16"	7	8	100

On request, we can supply replacement hogger segments for most manufacturers, when inquiring, supply drawing or sample as well as make of hogger if possible.

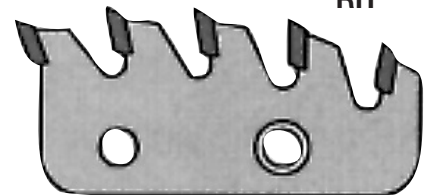
S-37 SEGMENTS

PART NO.	DIAM.	TEETH
372007000	200	7
372507000	250	7
373007000	300	7
373507000	350	7

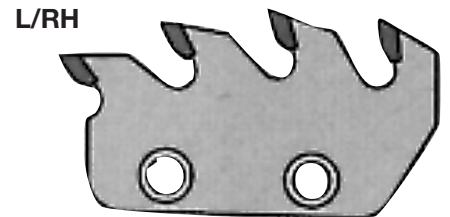
LH



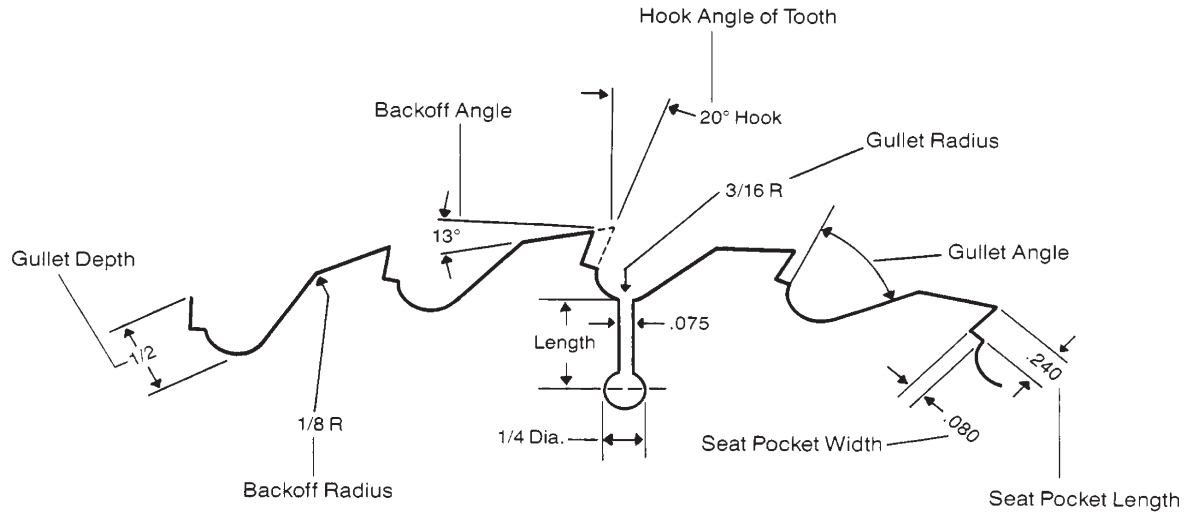
RH



L/RH



Custom Manufactured Saw Blades

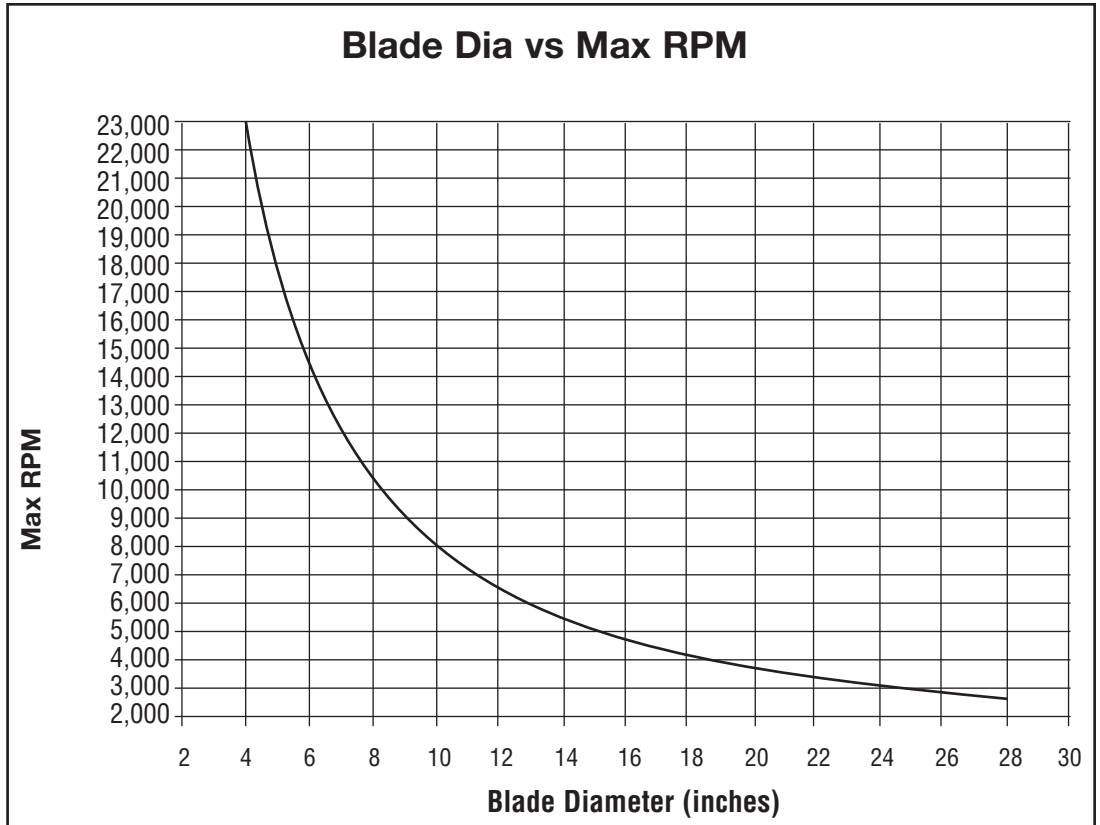


Beside the range of Industrial saw blades featured in this catalogue Royce//Ayr also manufacturers saw blades to your exact specifications. Above sketch shows some of the information we may need to be able to build your special saw blade.

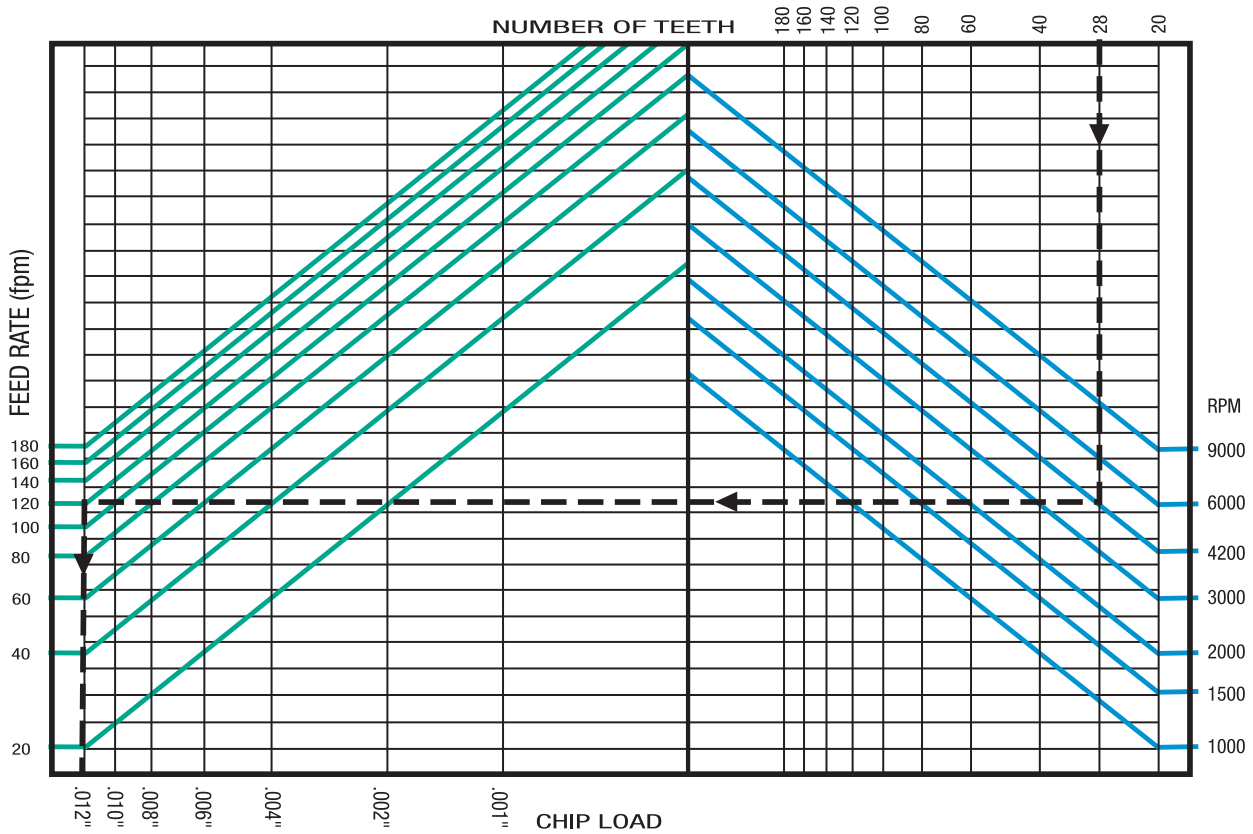
When ordering please also specify the outside diameter and bore size as well as any additional pinholes, countersunk holes or keyways needed. We also need to know the plate thickness you require and the finished kerf of the tip. Please also tell us the application this blade is to be used for and the arbor speed and if known; the feed speed. This information will help us to ensure that you are getting the very best product for your specific use.

Blade Max. RPMs in Relation to Diameter

BLADE DIA		MAX RPM
INCHES	MM	
3	80	22,900
4	100	22,600
5	125	18,300
5.5	140	16,300
6	150	14,000
7	175	13,000
8	200	11,400
9	230	10,600
10	250	9,100
12	300	7,550
14	350	5,250
16	400	4,500
18	450	4,000
20	500	3,500
22	550	3,000
24	600	2,750
26	650	2,700
28	700	2,500



Chip load per tooth



Example: A 28 tooth saw rotating at 4200 rpm with a feed rate of 120 fpm will have a chipload of .012"

The chip load per tooth may vary depending on the type of finish required. The following chip loads are recommended: Regular finish— .015", Fine finish— .010", Extra fine finish— .005"

With saw arbor running at 3600 RPM the following summary gives the feed rate per revolution and the chip load per tooth in relation to the feed per minute into the saw.

FEED PER/MIN (FEET)	100	150	200	250	300
FEED PER/REVOLUTION	.333	.500	.666	.833	1 INCH
NO. OF TEETH					
12	.027	.040	.055	.069	.083
16	.020	.031	.041	.052	.062
20	.016	.025	.033	.041	.050
24	.013	.020	.027	.034	.041
30	.011	.016	.022	.027	.033
36	.009	.013	.018	.023	.027
40	.008	.012	.016	.020	.025
60	.005	.008	.011	.013	.016
80	.004	.006	.008	.010	.012
100	.003	.005	.006	.008	.010
120	.002	.004	.005	.007	.008

For other RPM values use this formula : Chipload = $\frac{12 \times \text{feed per minute}}{\text{RPM} \times \text{Number of teeth}}$