

Skiving tool AT-60



The AT-60 is a preparing device for skiving (grind to a thin wedge for a glued Thermofix joint) of Habasit belts and tapes up to a width of 60 mm / 2.4 in. and a thickness of 2 mm / 0.08 in.. The belt / tape is clamped and stuck on a steel plate. It is ground manually by means of a skiving disc. Adjustment is done with two different settings.

The AT-60 is especially suitable for occasional preparation of single belts or spindle tapes on site in maintenance.

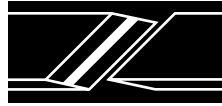
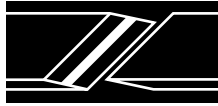


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Appendix:

- Product Liability



1. General information

1.1 Application

Skiving tool AT-60 has been especially designed for the quick and safe preparation (skiving) of the Thermofix end-joints of Habasit drive belts and transport tapes with a width of up to 60 mm (right-angled) or 25 mm (75° joining angle). The maximum belt/tape thickness is 2 mm.

The AT-60 skiving tool was developed solely for the purposes described in the operating instructions. Improper use, or use for other reasons than those described in the instructions, is not permissible. Habasit accepts no liability for the consequences of improper application.

The AT-60 is manufactured according to recognized engineering principles and state-of-the-art technology, and complies with applicable regulations.

These operating instructions imply that all assembly, maintenance, and repair work, as well as operation of the skiving tool, be carried out by skilled personnel or monitored by responsible specialists.

For reasons of scope, these instructions cannot cover all possible aspects of operation, maintenance, or repair. The indications given herein refer to the use of the machines according to their designated purpose by skilled personnel.

In case of doubt or if further detailed information is required, please consult the manufacturer (Chapter 1.4)

1.2 Important safety terms

In these operating instructions, you will find the terms WARNING, CAUTION, and INDICATION. They signal dangers or special information to be borne in mind.

WARNING If disregarded, there is a danger of severe injury, and/or severe material damage.

CAUTION If disregarded, there is a danger of injury, and/or material damage may be caused.

INDICATION Technical information is emphasized if it is important and not readily apparent, even for skilled personnel.

Please observe all indications for assembling, operating, and maintaining the machines, as well as all technical data! This will prevent possible trouble and/or damage to people or materials.

Skilled personnel refer to persons authorized to perform the required work. These people have been sufficiently trained and introduced to their field of activity so that they are able to recognize and prevent dangers. They are aware of the pertinent provisions and safety regulations.



1.3 Scope of supply

Qty.	Item	Order no.
1	Skiving tool AT-60 incl. wear plate	A-0565000
2	Grinding disc, self-adhesive 60 grain (One grinding disc supplied with original equipment)	N-28545
1	Operating instructions	

1.4 Ordering of spare parts

Spare parts can be ordered directly from the manufacturer.

Address:

Habasit Italiana S.p.A.
Via A. Meucci 8, Zona Industriale
I-31029 Vittorio Veneto/TV
Tel. ++39 438 91 13
Fax ++39 438 91 2374

Please accurately describe the parts required.
State the numbers according to Section 8, Drawings.

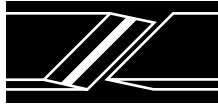
WARNING	The use of parts by other manufacturers not meeting Habasit specifications is not admissible. Habasit declines all responsibility for the consequences if non-Habasit parts are used.
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1.5 Warranty

All tools undergo a strict final inspection. On the assumption of correct handling, they are warranted against material and manufacturing defects for 1 year.

1.6 Technical advice

Our specialists will be pleased to advise you. For technical questions concerning function and condition of the skiving device, please contact the manufacturer (see Chapter 1.4 for the address).



2. Mode of operation

The beveling (skiving) of the belt/tape end is carried out by the manual rotation of the skiving plate with the grinding disc bonded in place.

Tapered grinding is achieved by the angle created between the skiving plate and the belt/tape end.

3. Initial start-up

- Attach the skiving table (5) to a workbench or directly to a suitable location on the machine/installation with the clamping screw (6).
- Setting of the skiving plate:** Adjustment to the relevant belt thickness is carried out by positioning the angle-adjusting device (3):
 - Belts/tapes $t \leq 1$ mm: Angle-adjusting device (3) positioned fully forward in the direction of the skiving edge
 - Belts/tapes $t > 1$ mm: Angle-adjusting device (3) positioned fully back in the direction of the tape clamp (4)
- Loosen screw (8) with Allen key SW 2.5 and move angle-adjusting device (3) under the skiving plate (2) as shown. Retighten screw (8).



4. Skiving belt /tape ends

- Introduce the belt/tape under the tape clamp (4) and align it parallel to the grinding surface (to the edge) at a distance of approx. 1 mm behind the front edge of the skiving plate (2) (in the direction of the tape clamp).
- Fix the belt/tape by shifting the tape clamp (4).
- Insert the skiving disc (1) in the guide bushing of the skiving table (5) and turn it uniformly until a soft metallic grinding sound is audible.
- Remove the skiving disc (1) and check whether the belt/tape edge appears wafer thin. If this is not the case, slightly readjust the belt/tape and repeat the skiving process.
- Release the belt/tape by lightly twisting and pushing back the tape clamp and remove it from the skiving tool.
- Free the skiving plate (2) of dust and repeat the procedure at the other end of the belt/tape, **on the opposite side**.





5. Service

5.1 Maintenance

- If necessary, clean all grinding dust from the AT-60 skiving tool.

5.2 Replacement of the worn grinding disc

- Remove the worn grinding disc (7) and clean the surface of the skiving disc (1) with solvent.
- After taking off the protective film, apply the new grinding disc evenly by hand.

NOTE	There must be no air bubbles between the grinding disc (7) and the skiving disc (1)!
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5.3 Replacement of the worn skiving plate

- As the skiving plate (2) is symmetric, all eight edges can be used before the plate has to be replaced.
- Loosen the screw (8) using an Allen key SW 2.5 and turn the skiving plate (2).

CAUTION	In doing so, take care not to lose the angle-adjusting device (3)!
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- Retighten screw (8).

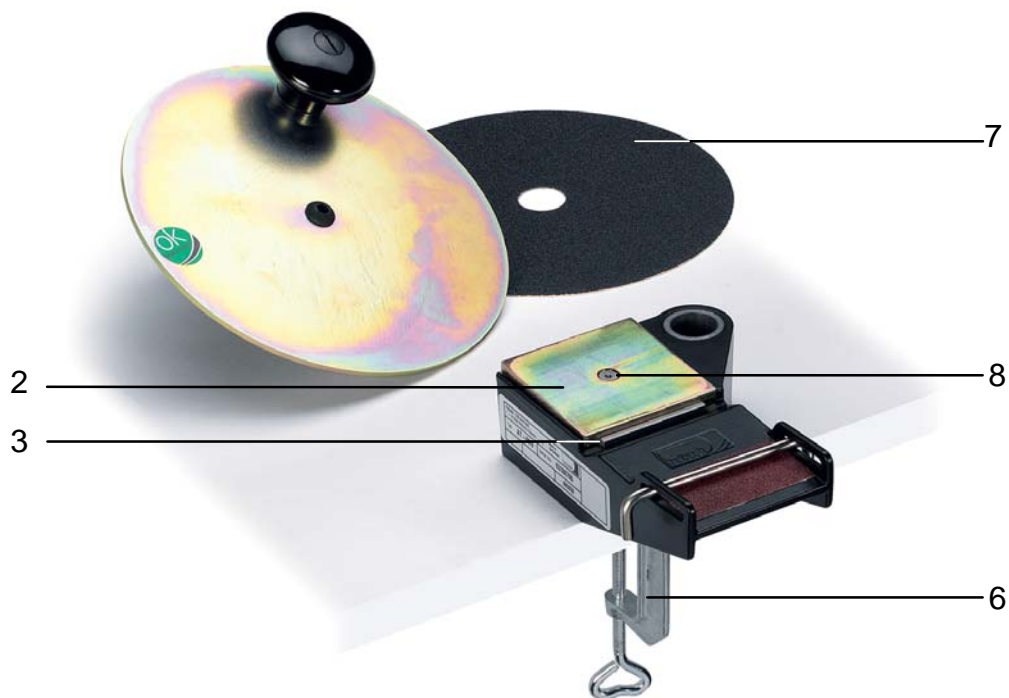


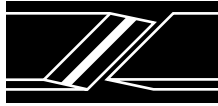
6. Illustrations



Legend:

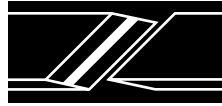
- 1 Skiving disc
- 2 Skiving plate
- 3 Angle-adjusting device
- 4 Belt/tape clamp
- 5 Skiving table
- 6 Clamping screw
- 7 Grinding disc
- 8 Screw
- 9 Rating plate



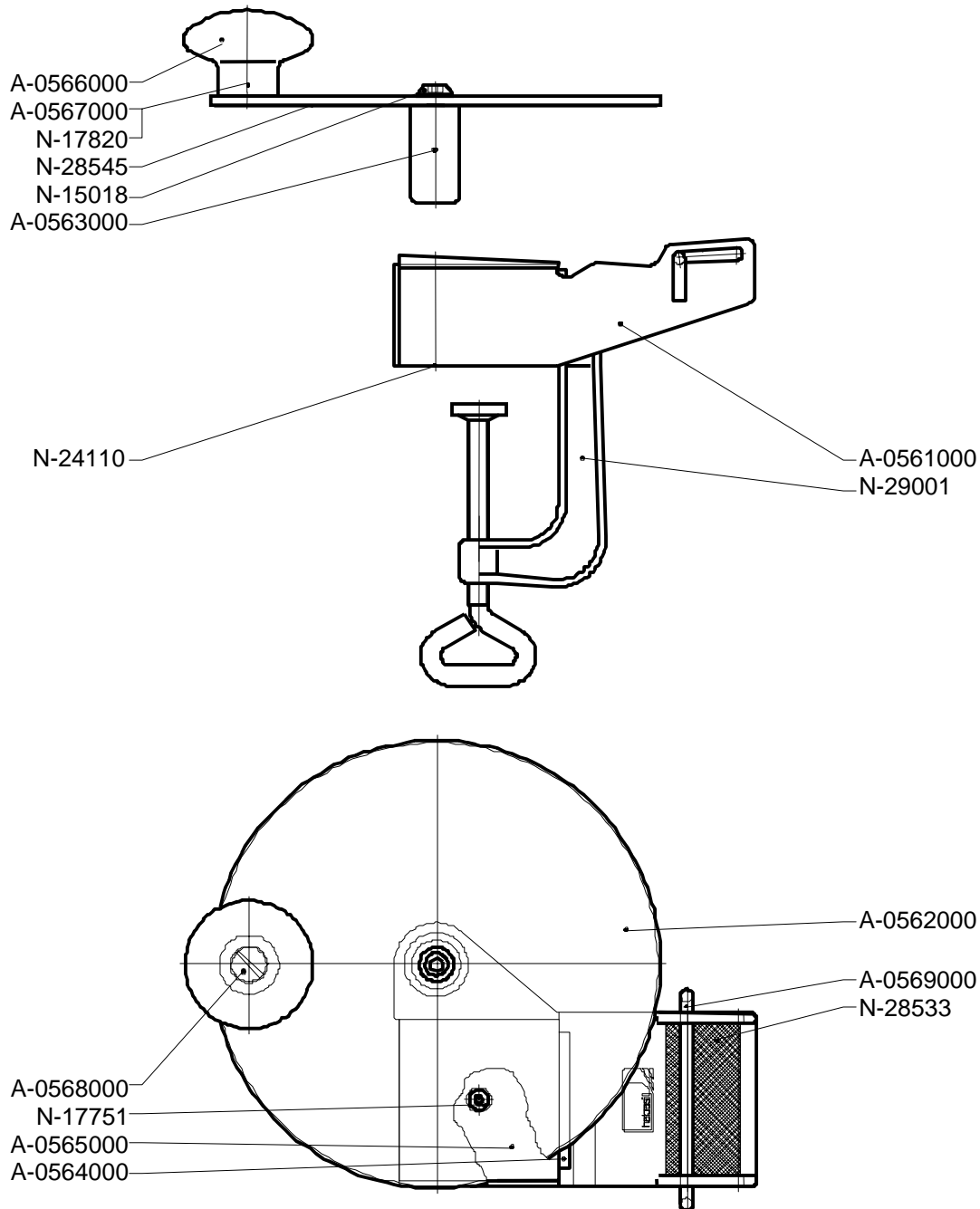


7. Technical data

Max. belt width [mm] [<i>in.</i>] with 90° joining angle	60	2.4
Max. belt width [mm] [<i>in.</i>] with 75° joining angle	25	1.0
Belt/tape thickness max. [mm] [<i>in.</i>]	2	0.08
Max. skiving length [mm] [<i>in.</i>]	40	2.6
Dimensions (L x W x H) [mm] [<i>in.</i>]	220 x 190x 85	8.7 x 7.5 x 3.4
Net weight [kg] [<i>lbs.</i>]	1.5	3.3



8. Drawings and spare part numbers





Product liability, application considerations

If the proper selection and application of Habasit products are not recommended by an authorized Habasit sales specialist, the selection and application of Habasit products, including the related area of product safety, are the responsibility of the customer.

All indications / information are recommendations and believed to be reliable, but no representations, guarantees, or warranties of any kind are made as to their accuracy or suitability for particular applications. The data provided herein are based on laboratory work with small-scale test equipment, running at standard conditions, and do not necessarily match product performance in industrial use. New knowledge and experiences can lead to modifications and changes within a short time without prior notice.

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