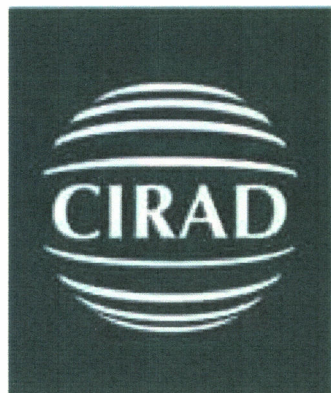




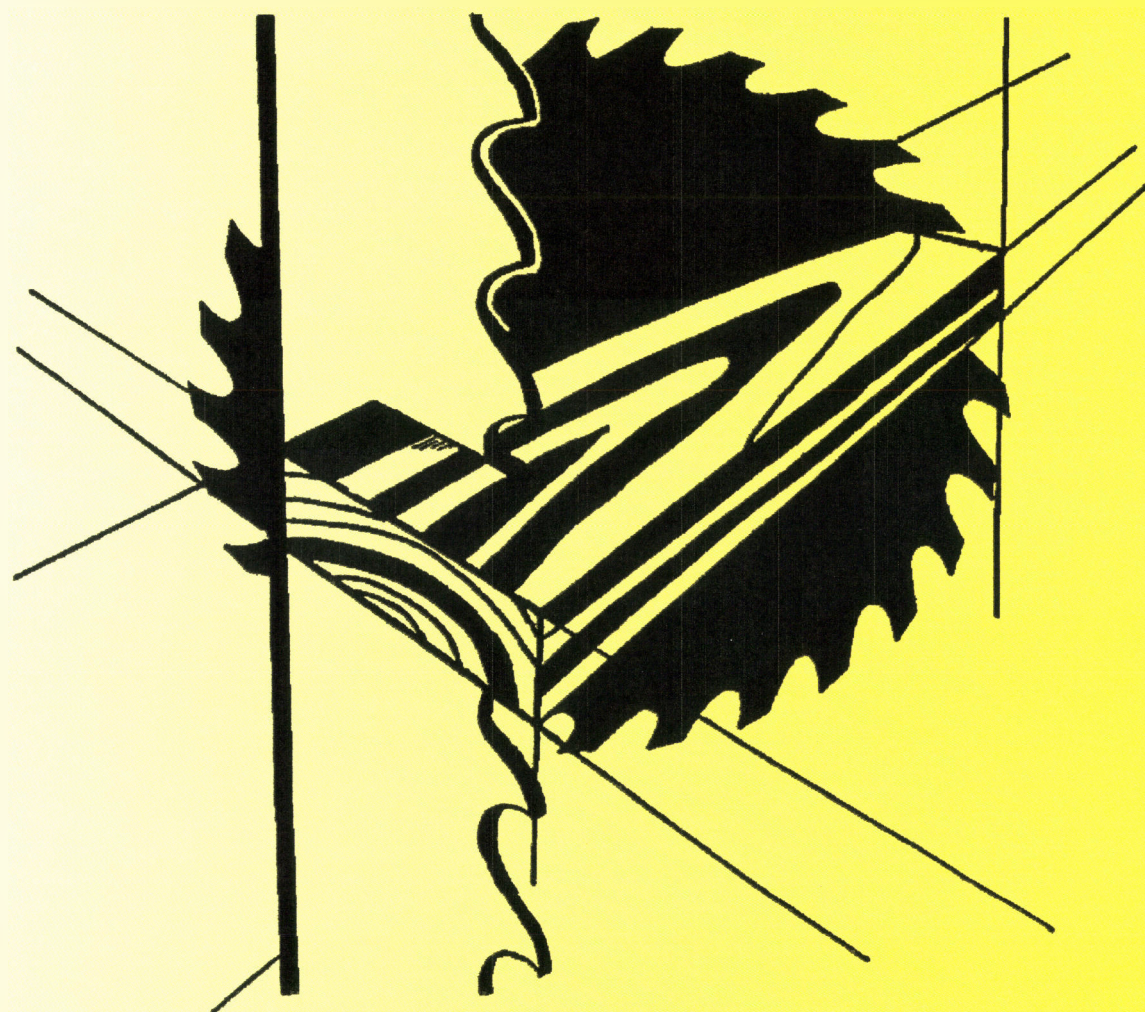
Centre International de Recherche Agronomique pour le Développement

73 rue Jean François Breton
34398 Montpellier
☎ 04-67-61-65-31
✉ 04-67-61-65-60



COURS SCIAGE AFFUTAGE

Novembre 2006
Claude DAIGREMONT



DK 540 242

BA-RP 2682



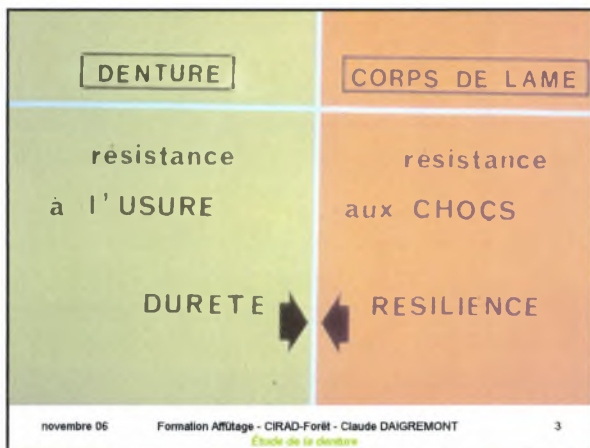
Formation Affûtage CIRAD-Forêt Claude DAIGREMONT

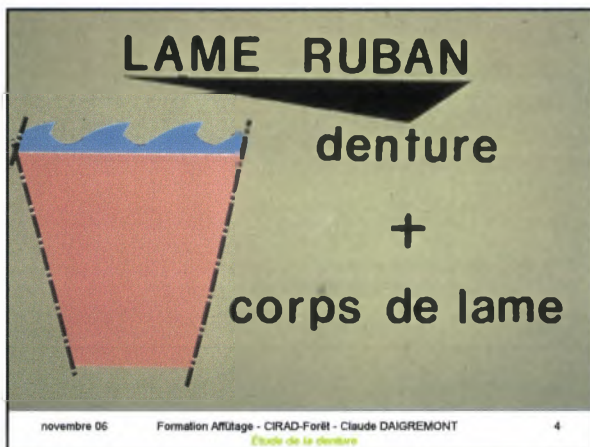


Photo Stratégie Bois

BA-RP 2681

LAMES DE SCIES A RUBAN





COMPOSITION DES ACIERS

composants en %		au nickel	au nickel - chrome
Carbone	C	0 , 67	0 , 80
Silicium	Si	0 , 20	0 , 33
Manganèse	Mg	0 , 20	0 , 38
Nickel	Ni	2 , 20	0 , 50
Chrome	Cr	0 , 05	0 , 10
Vanadium	V	0 , 02	0 , 02

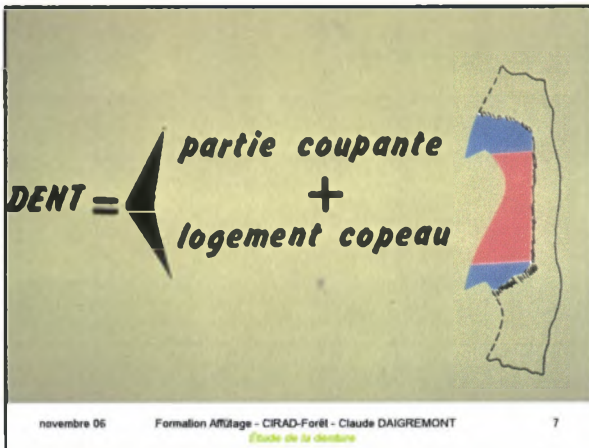
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 5
Étude de la denture

ETUDE D'UNE DENTURE

novembre 06

Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Étude de la denture

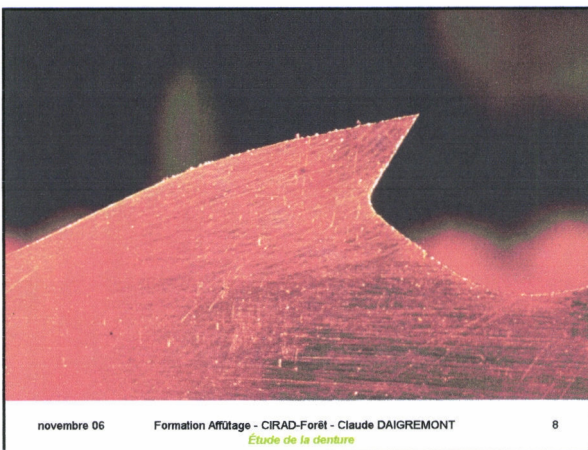
6

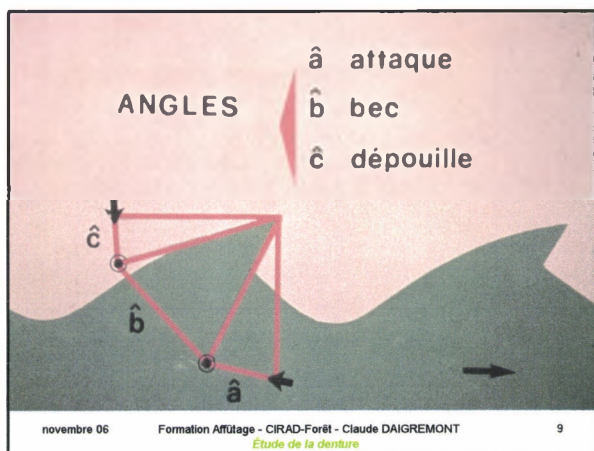


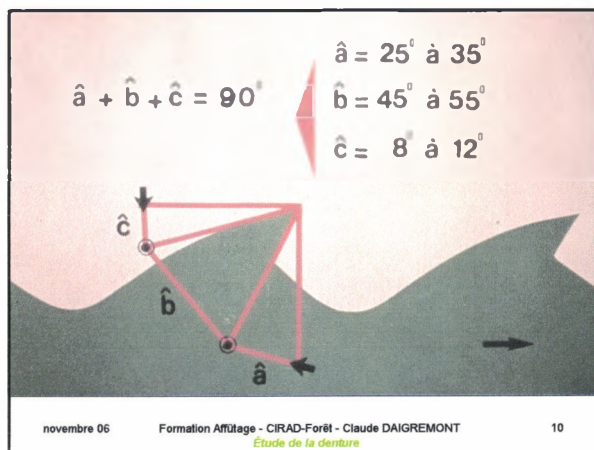
novembre 06

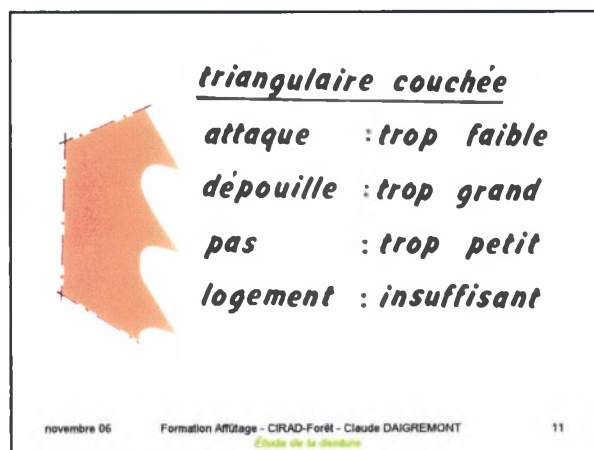
Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Étude de la denture

7





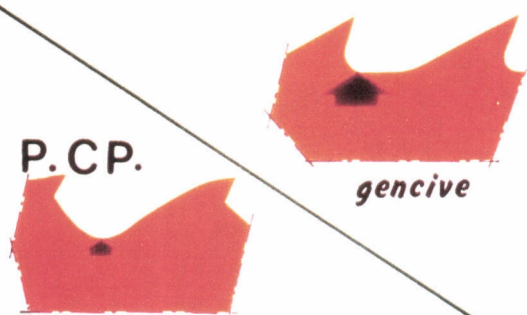






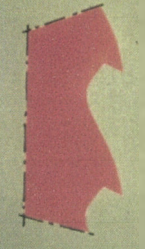
triangulaire gincive
attaque : trop faible
dépouille : trop grand
logement : insuffisant
pas : BON

novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 12
Étude de la denture



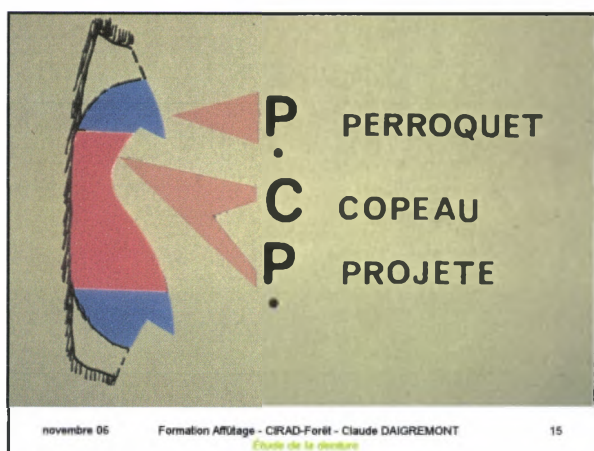
P.C.P. **gincive**

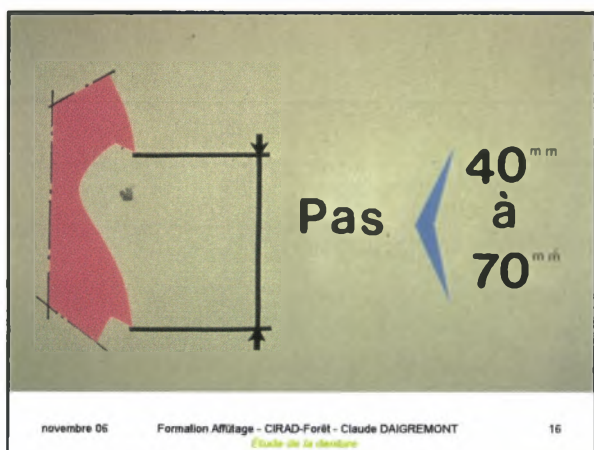
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 13
Étude de la denture

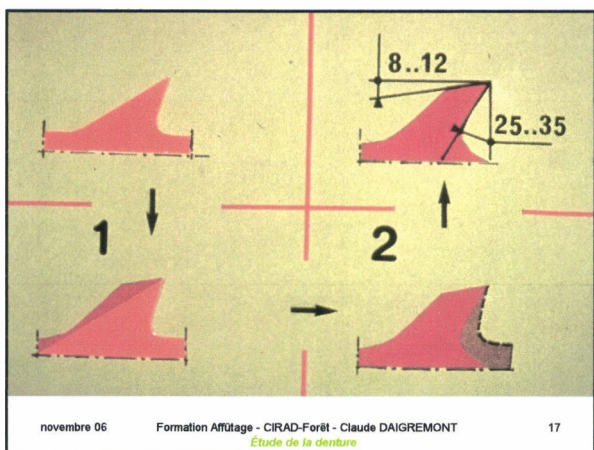


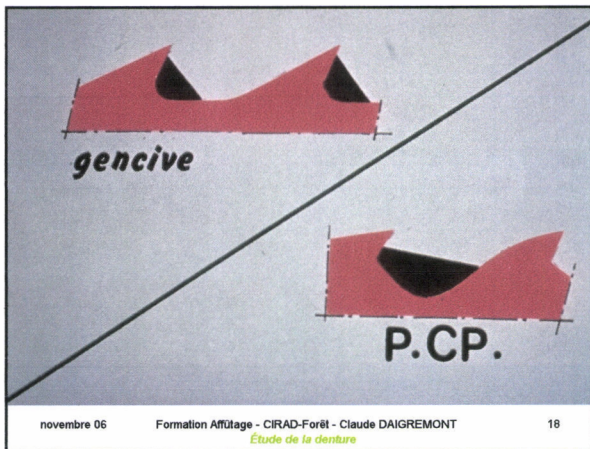
P. CP.
attaque
dépouille
logement
pas **BON**

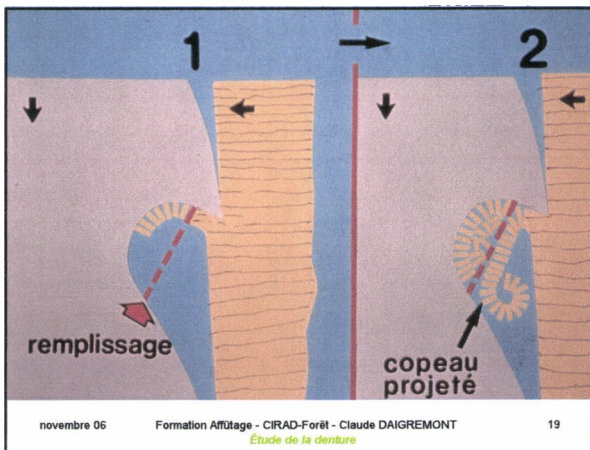
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 14
Étude de la denture

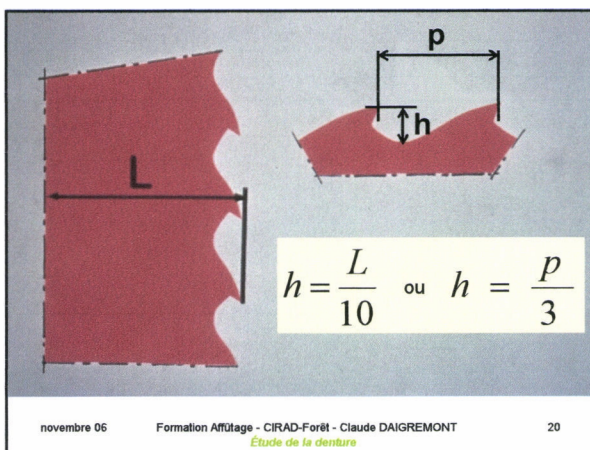








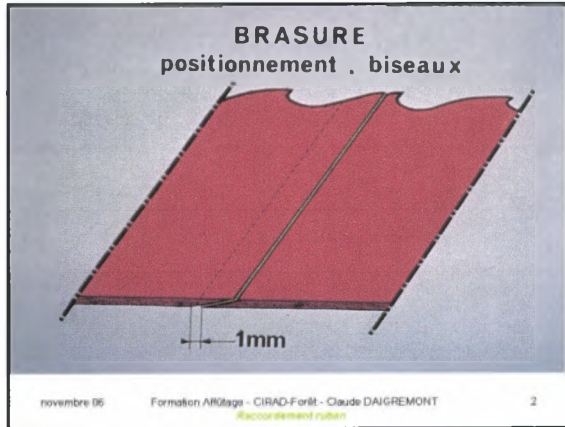


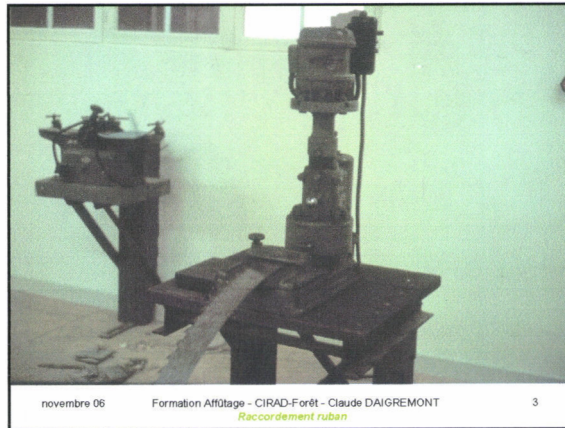


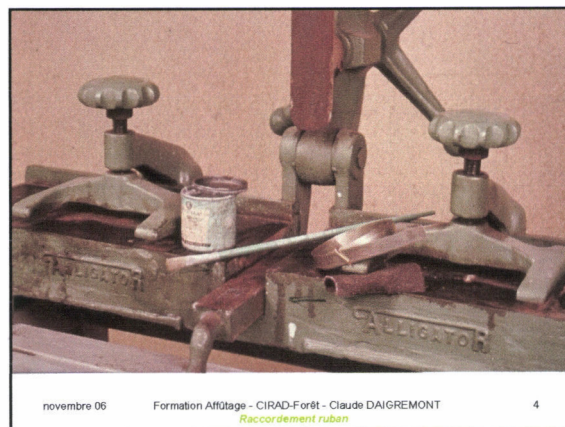
RACCORDEMENT DU RUBAN

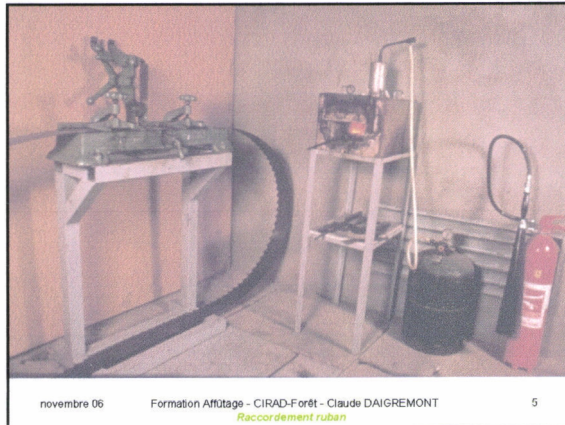
1. soudure

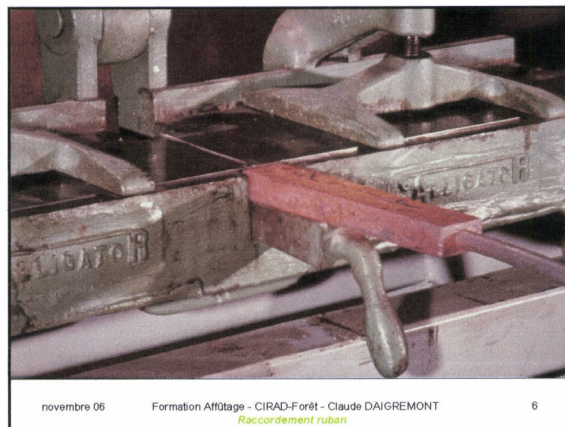
2. brasure

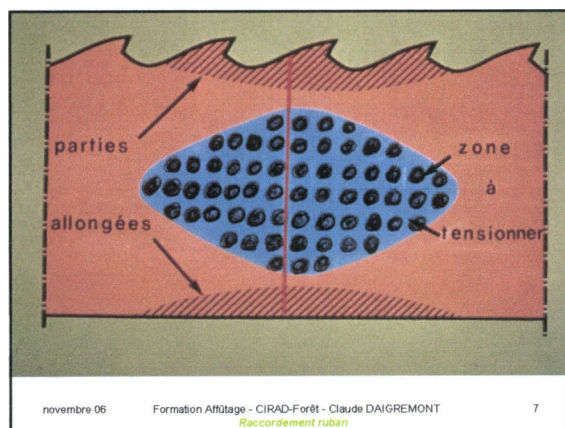






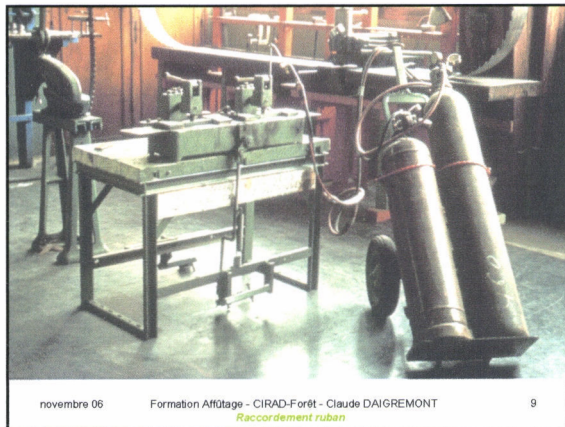








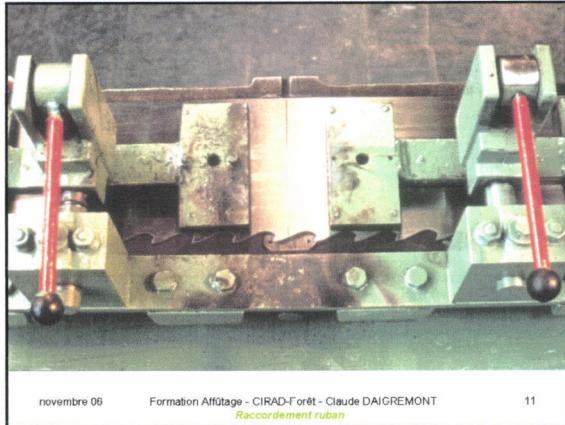
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 8
Raccordement ruban



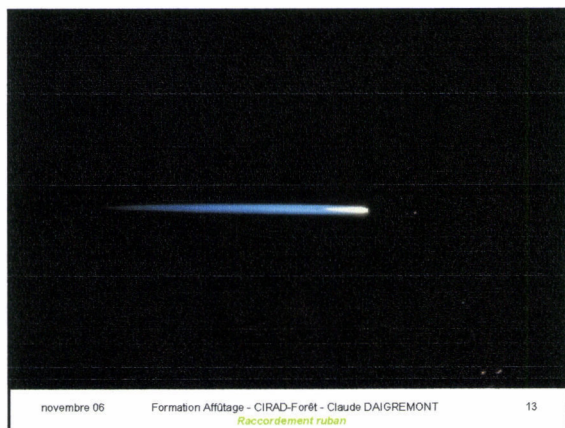
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 9
Raccordement ruban

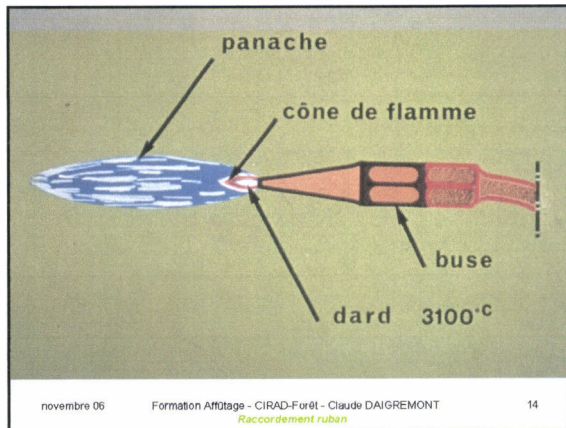


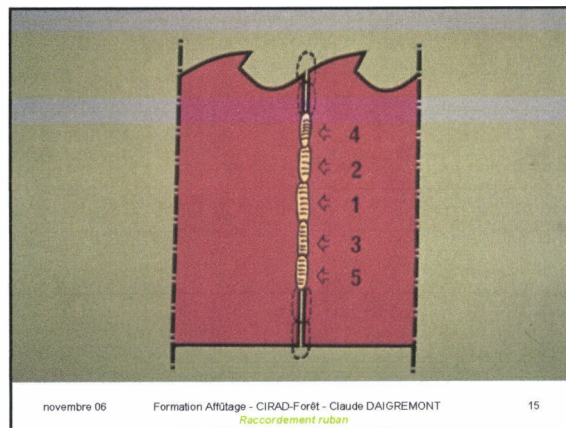
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 10
Raccordement ruban

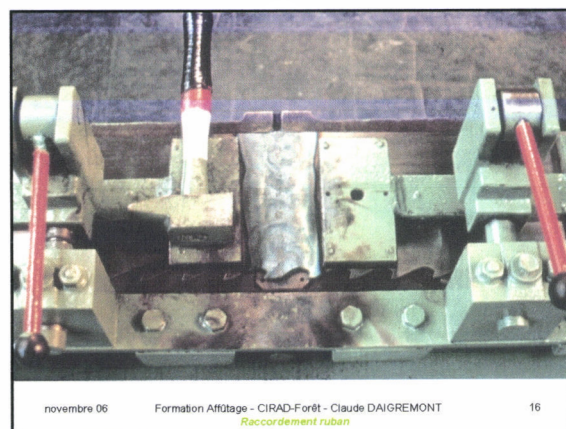


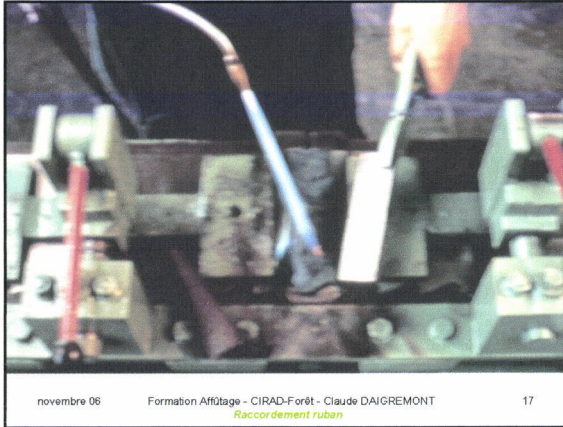






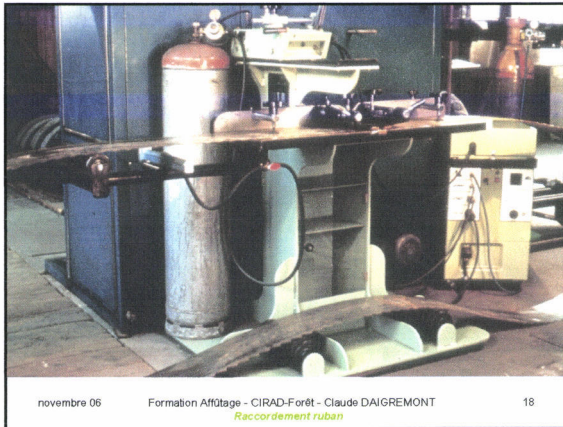






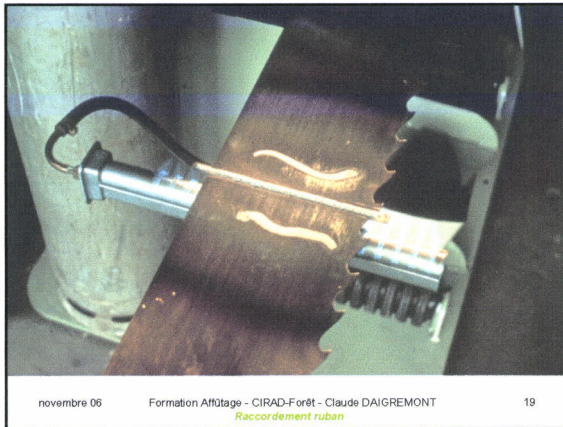
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Raccordement ruban

17



novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Raccordement ruban

18



novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Raccordement ruban

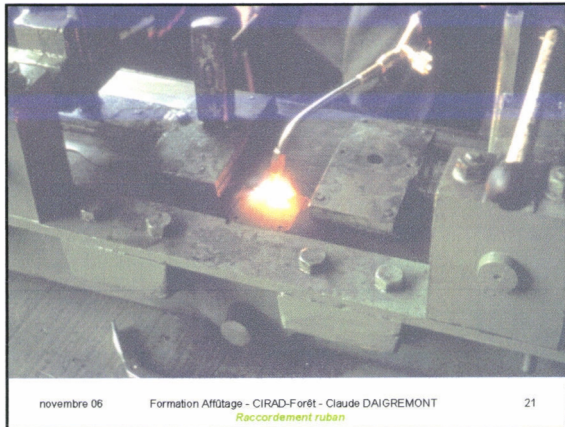
19





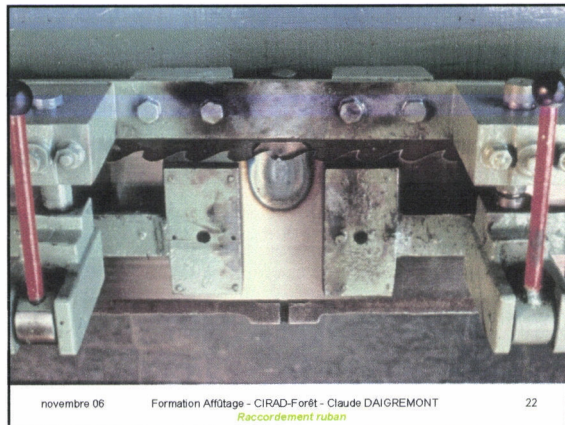
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Raccordement ruban

20



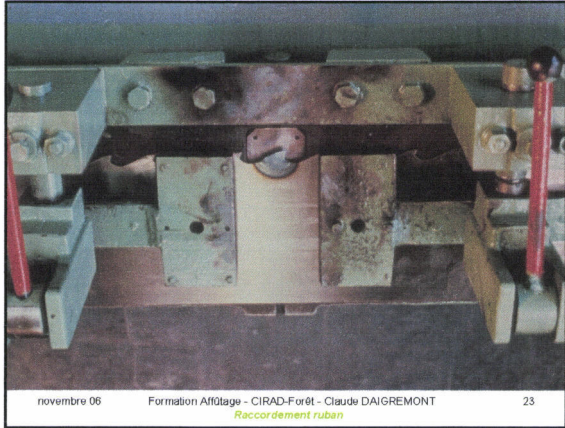
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Raccordement ruban

21



novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Raccordement ruban

22



novembre 06

Formation Afilage - CIRAD-Forêt - Claude DAIGREMONT
Raccordement ruban

23

PREPARATION ET ENTRETIEN DES LAMES DE SCIES

PREPARATION DE LA LAME

PREPARATION DU CORPS DE LAME

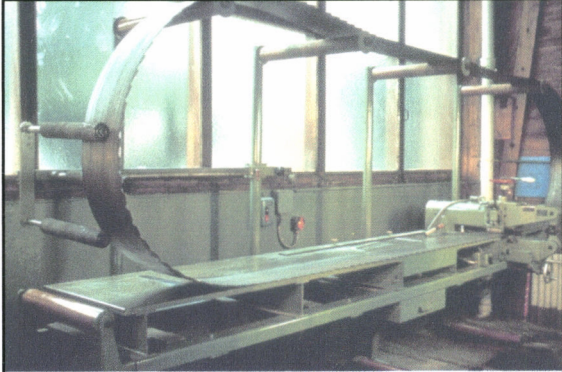
BONNE PREPARATION

1.contrôle

2.détection

3.correction

novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 4
Préparation et entretien des lames

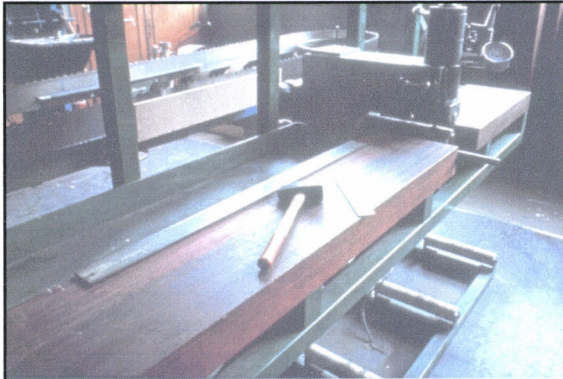


novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 5
Préparation et entretien des lames

tensionnage

planage ↔ **dressage**

novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 6
Préparation et entretien des lames



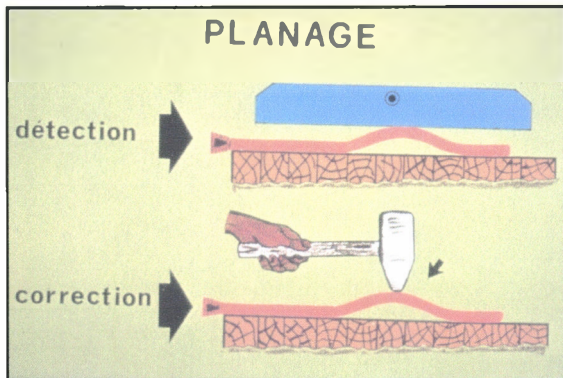
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Préparation et entretien des lames

7



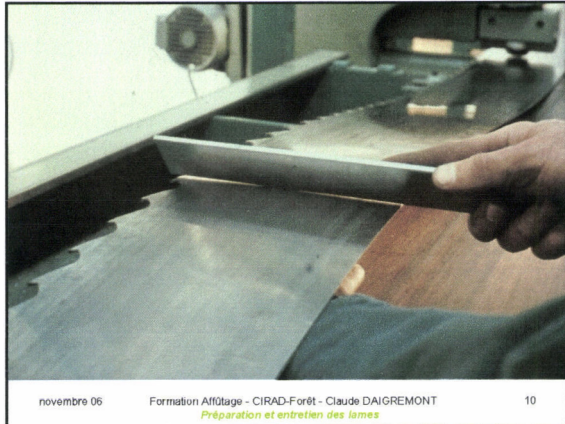
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Préparation et entretien des lames

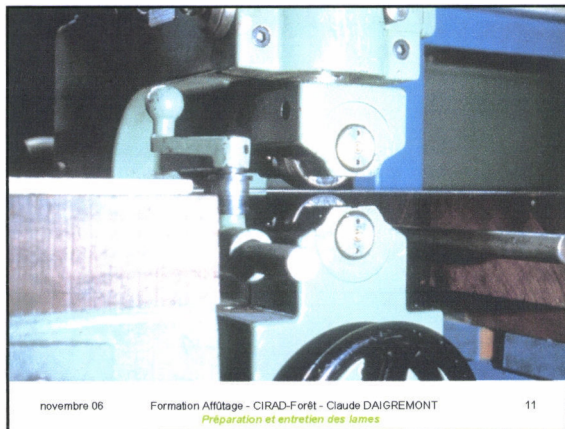
8

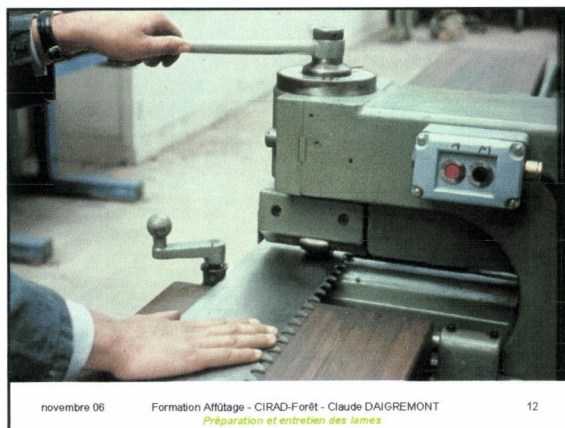


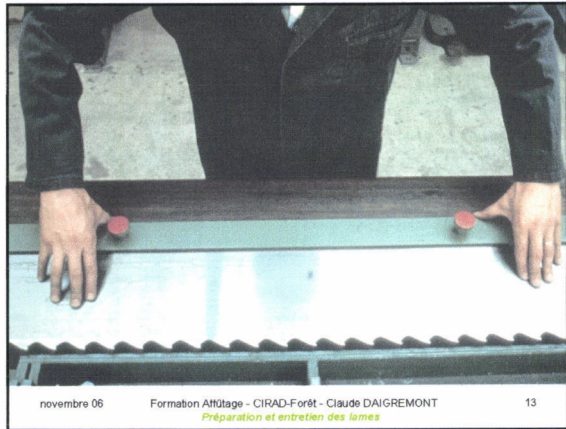
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Préparation et entretien des lames

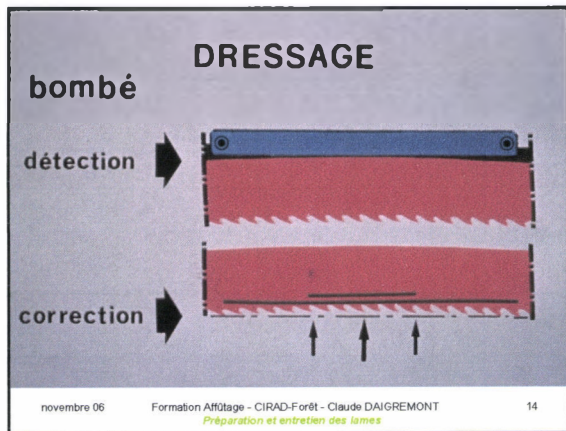
9

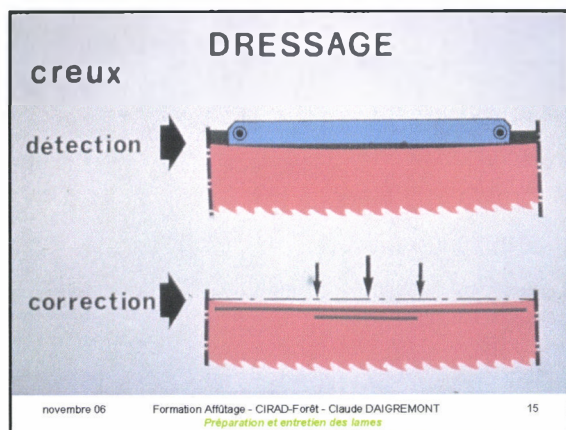












DEFAUTS DE TENSION

manque

excès

gouttiere

novembre 06

Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Préparation et entretien des lames

16

MANQUE

détection

correction

novembre 06

Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Préparation et entretien des lames

17

EXCES

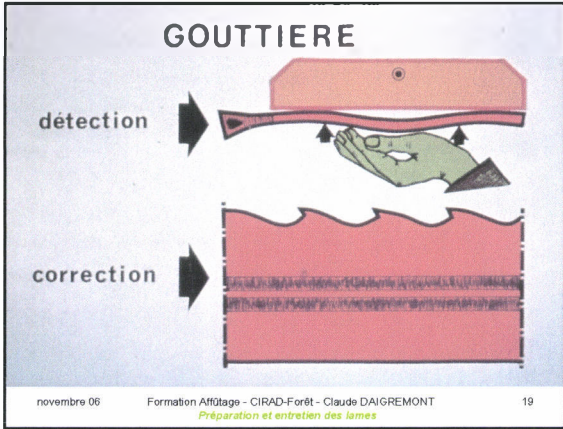
détection

correction

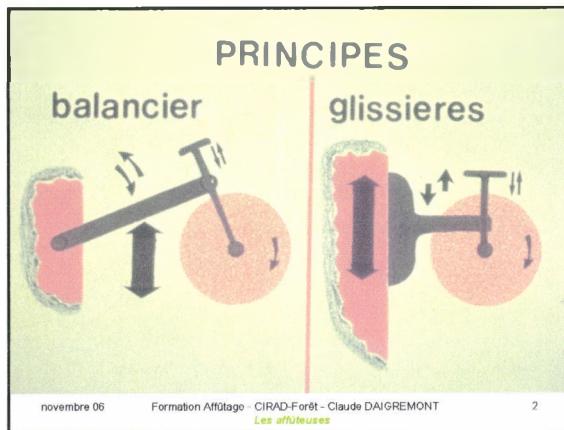
novembre 06

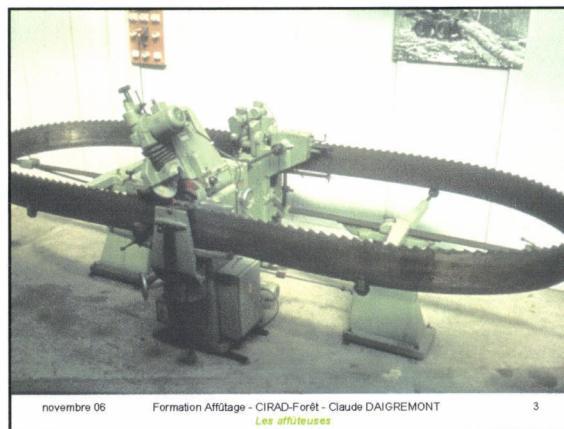
Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Préparation et entretien des lames

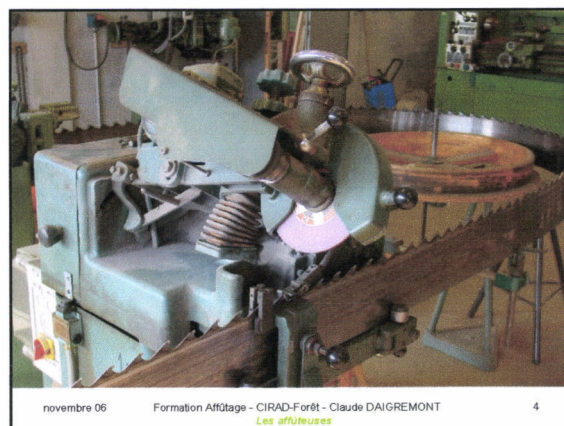
18

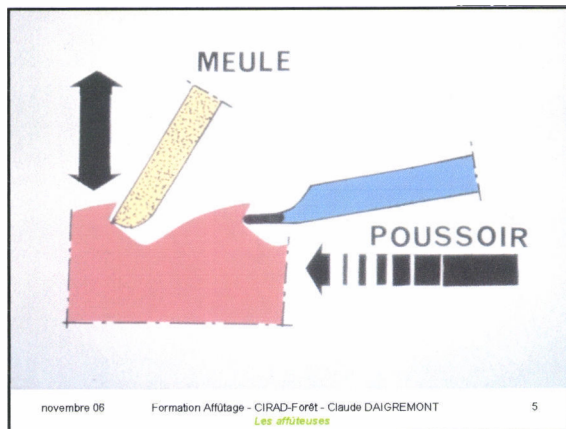


LES AFFUTEUSES





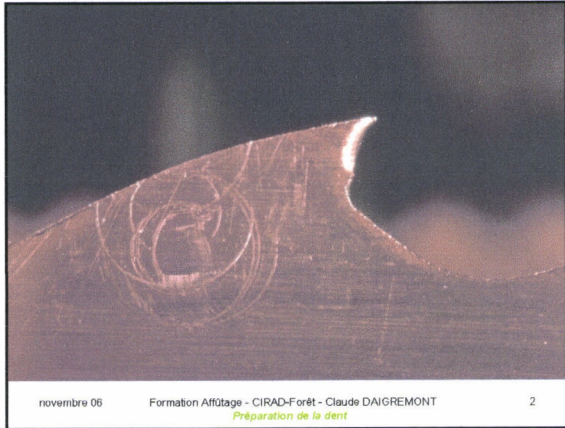


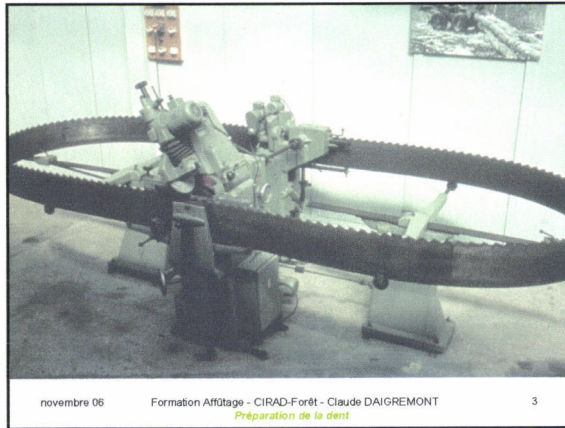


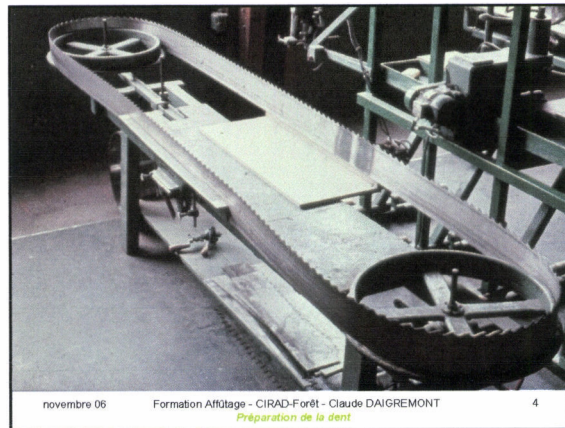


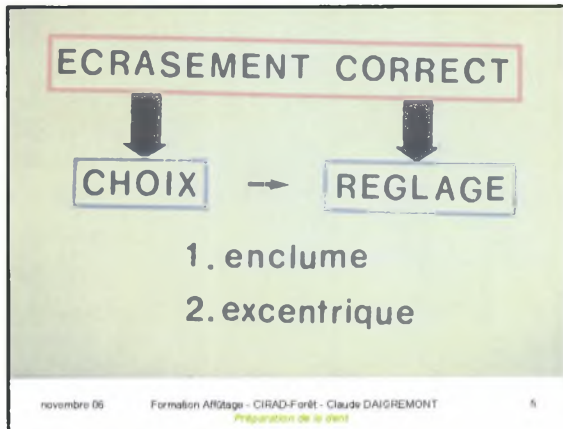
PREPARATION DE LA DENT

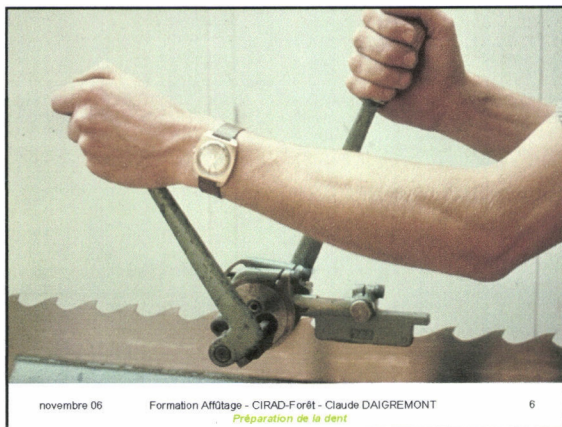
1. défonçage
2. avoyage
3. affûtage

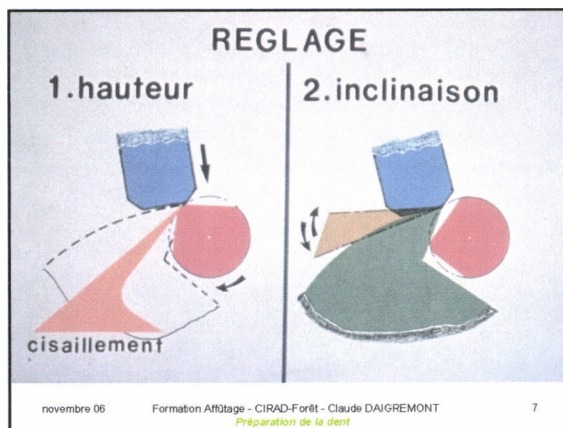


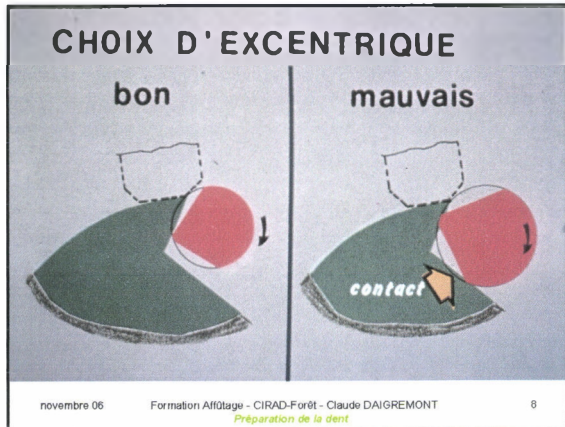


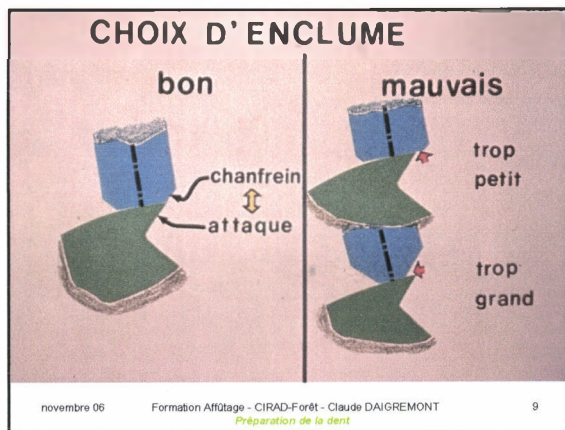


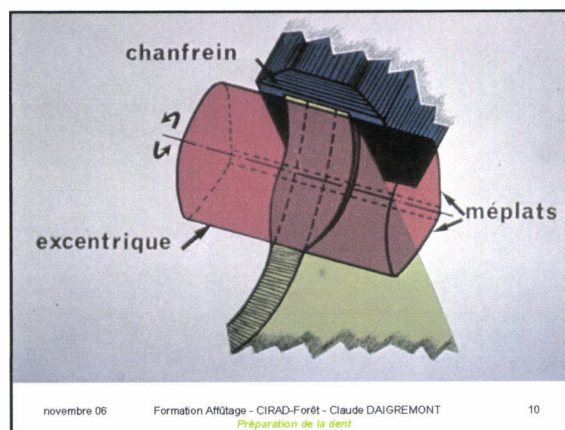


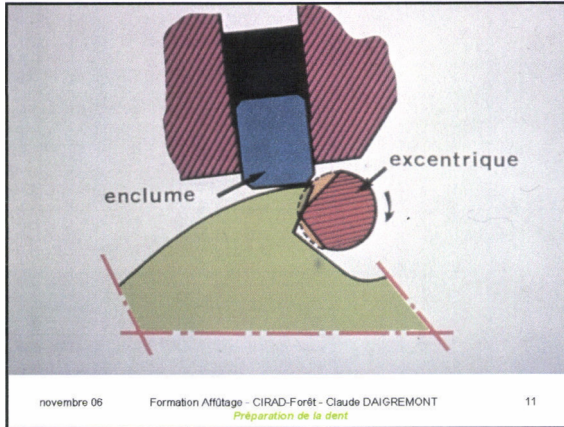


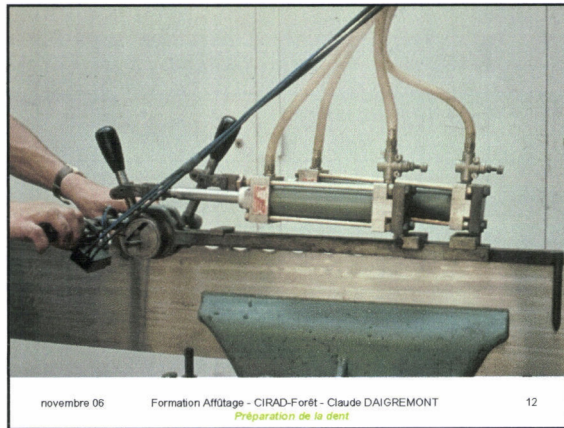


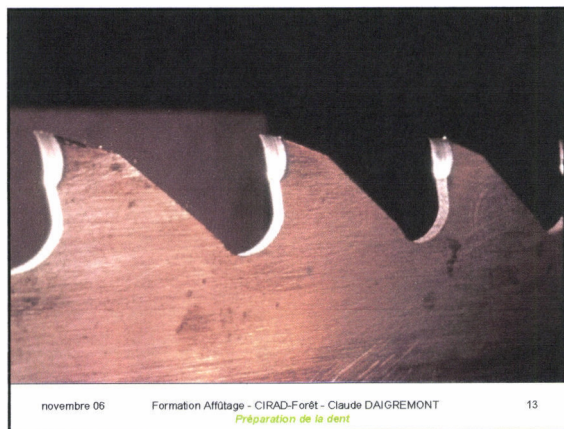


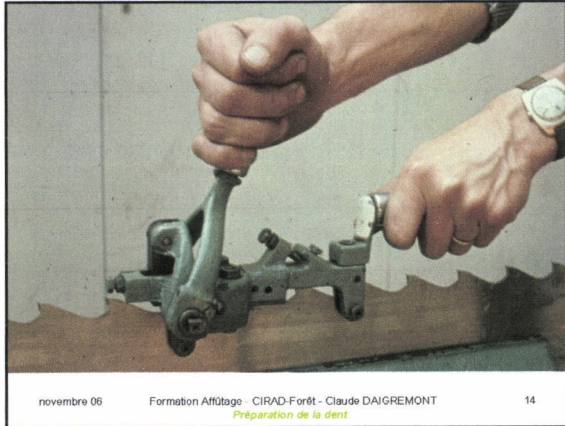






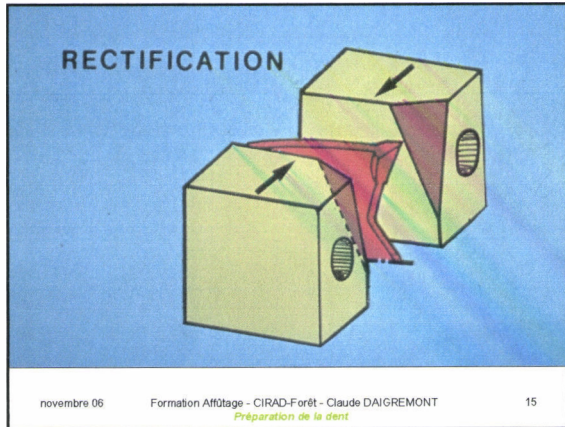






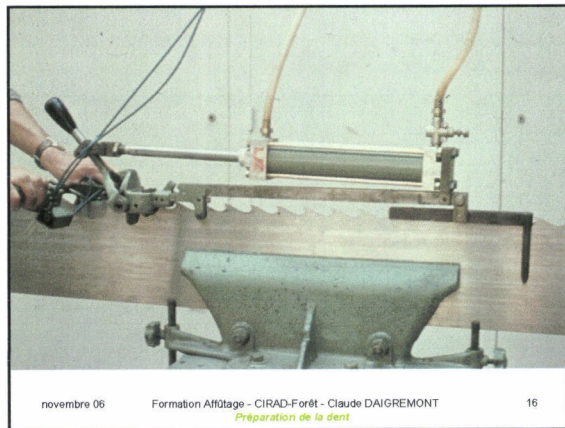
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Préparation de la dent

14



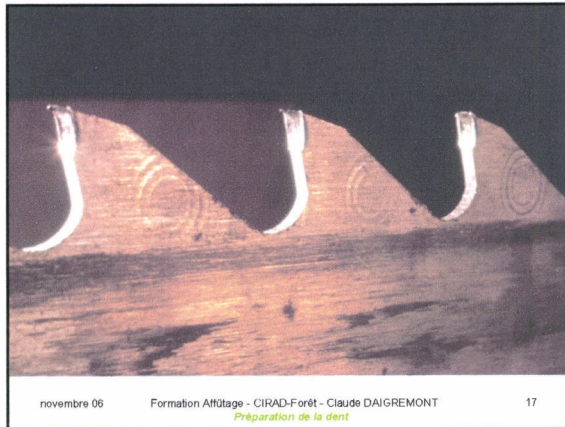
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Préparation de la dent

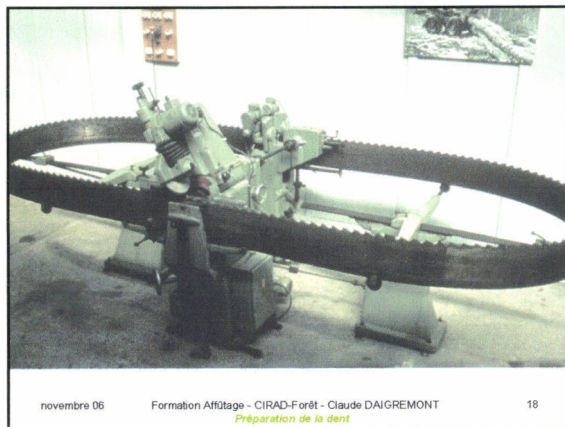
15

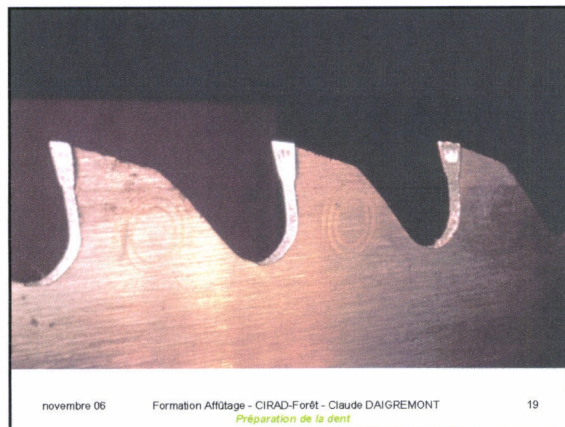


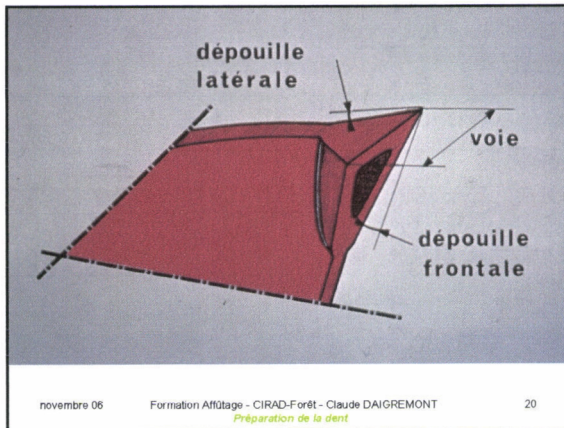
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT
Préparation de la dent

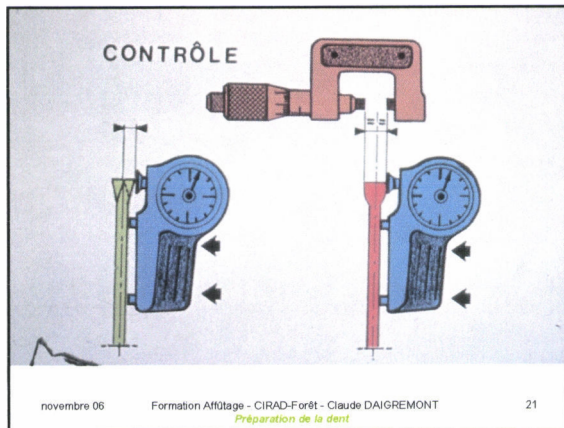
16

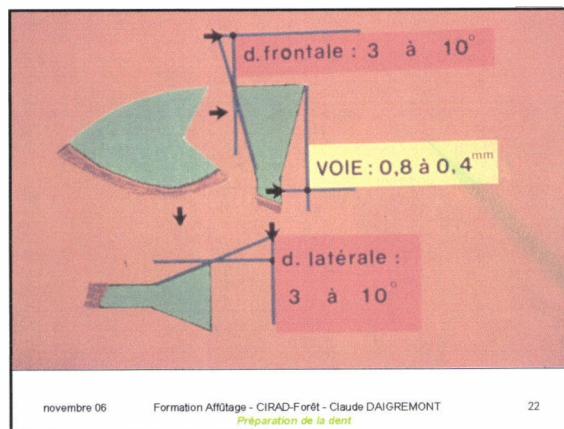


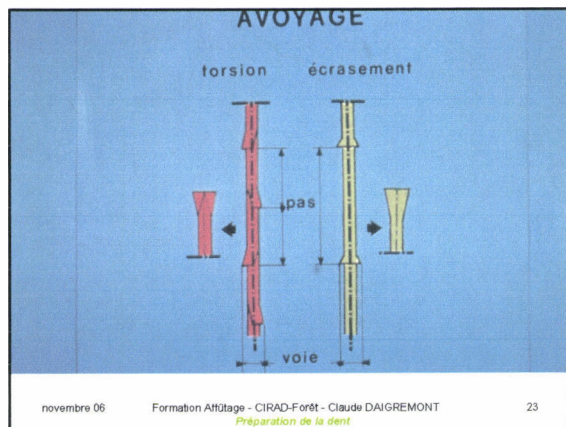












AMELIORATION DE LA TENUE DE COUPE

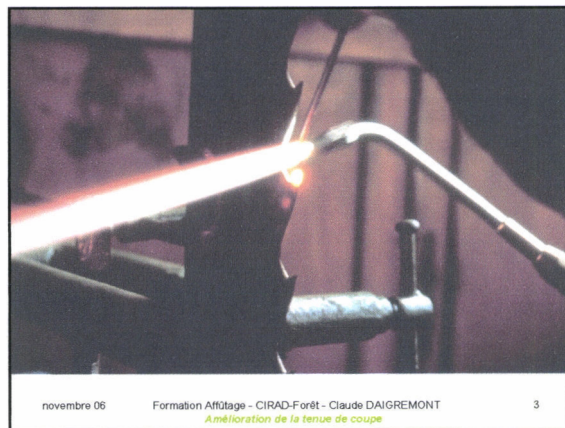
1. stellitage

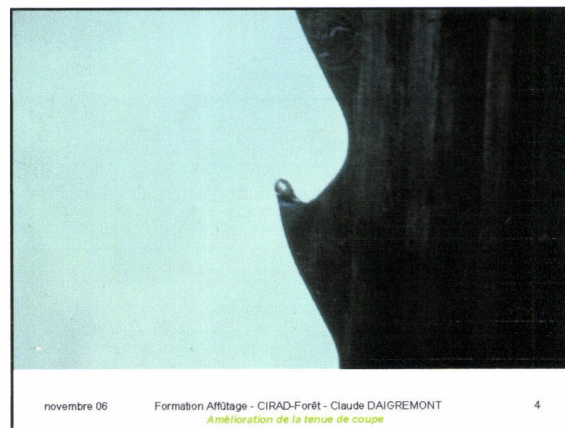
2. trempe

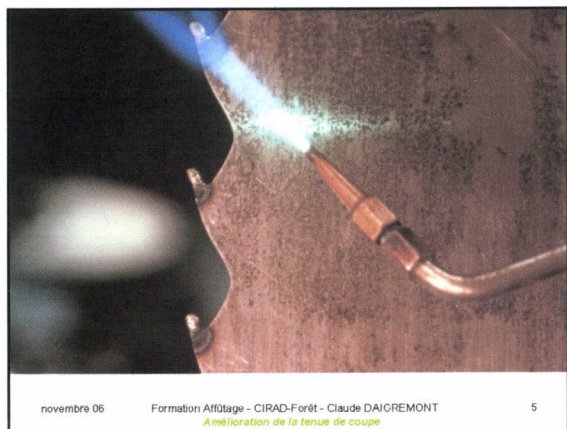
STELLITES USUELS		
	GRADES	
	1	12
repère		
résistance à l'usure	excellente	bonne
résistance aux chocs	moyenne	bonne
meulabilité	difficile	moyenne

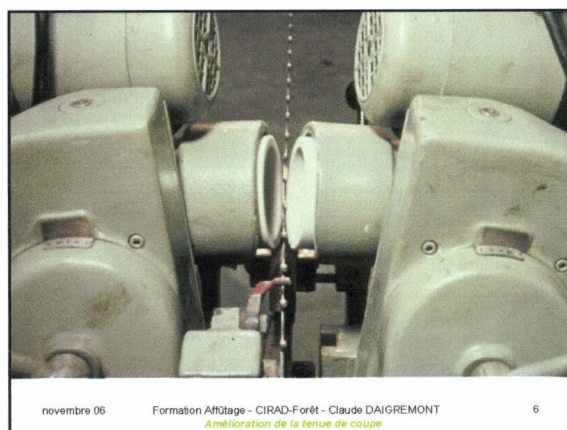
novembre 06 Formation Affûtage - CIRAD-Forest - Claude DAIGREMONT 2

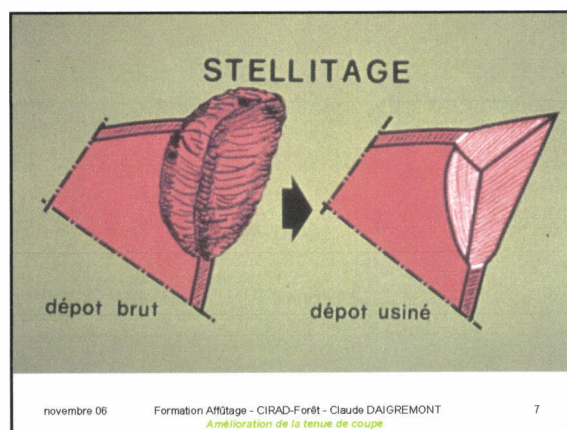
Amélioration de la tenue de coupe

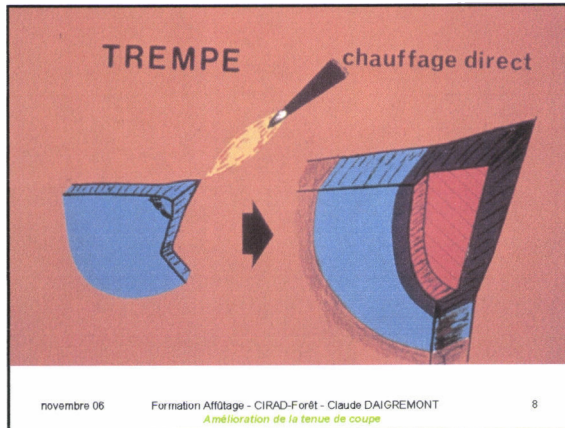












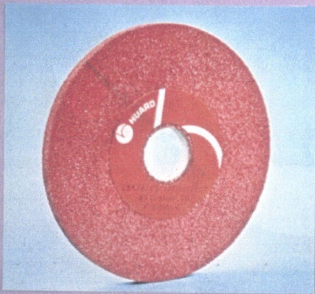
LES MEULES VITRIFIÉES

novembre 06

Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT

Les meules

1



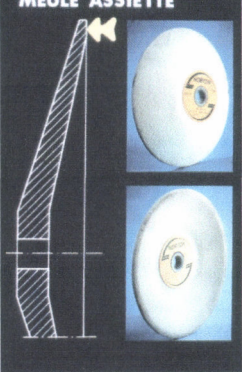
MEULE PLATE

novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 2
Les meules



BOISSEAU DROIT

novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 3
Les meules



MEULE ASSIETTE

novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 4
Les meules

LES MEULES

novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 5

Les meules

OXYDE D'ALUMINIUM	ACIER
CARBURE DE SILICIUM	
NITRURE DE BORE	ACIERS FORTEMENT ALLIES
DIAMANT	CARBURE DE TUNGSTENE

novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 6

Les meules

NATURE DE L'ABRASIF

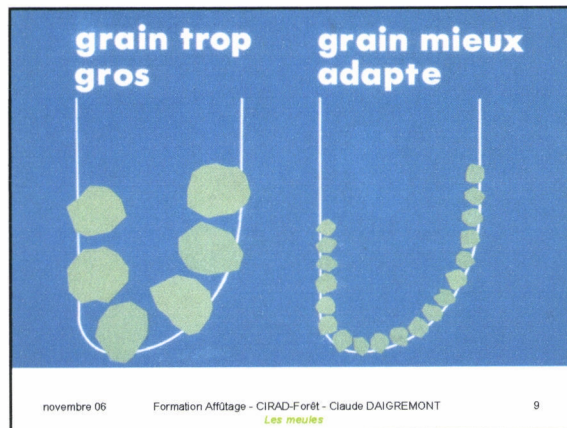
OXYDE D'ALUMINIUM	OO	A
CARBURE DE SILICIUM	VERT	OO
	NOIR	OO
		C

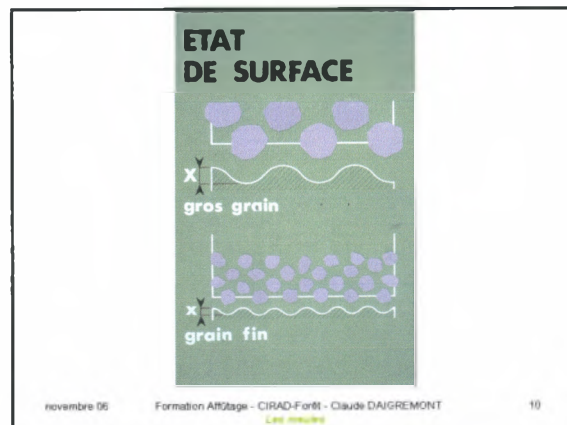
novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 7

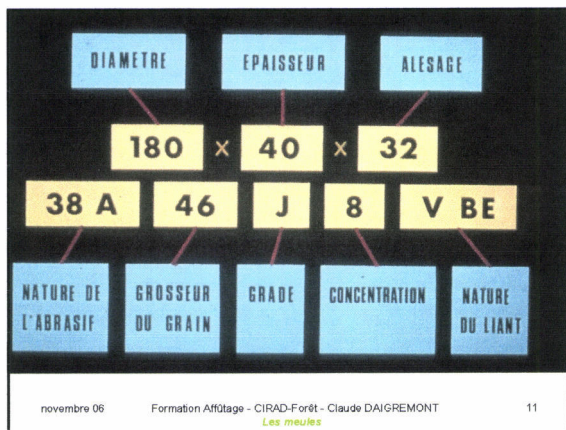
Les meules

GROSSEUR DES GRAINS					
TRES GROS	GROS	MOYEN	FIN	TRES FIN	POUDRE
6	12	30	90	220	400
8	14	36	100	240	500
10	16	40	120	280	600
	20	46	150	320	
	24	50	180		
		60			
		80			

novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 8







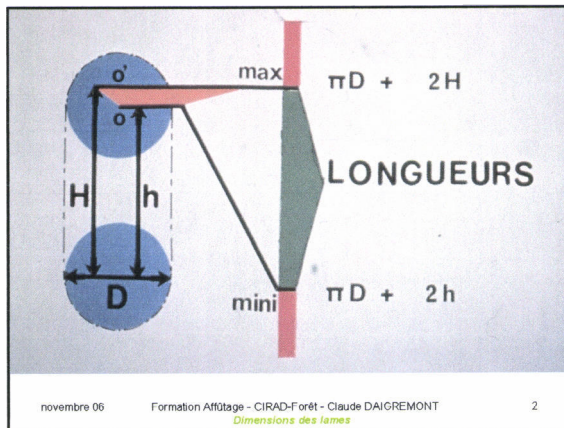
DIMENSIONS :

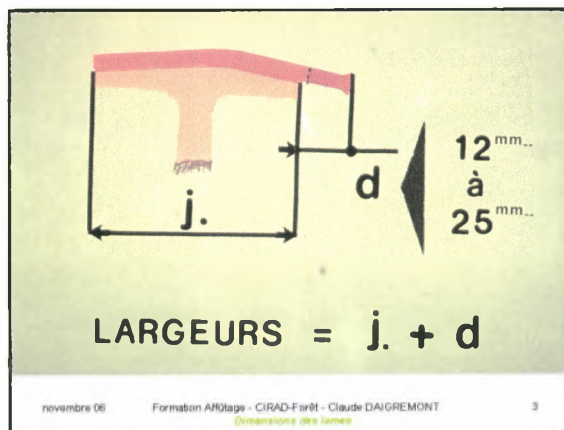
Longueur

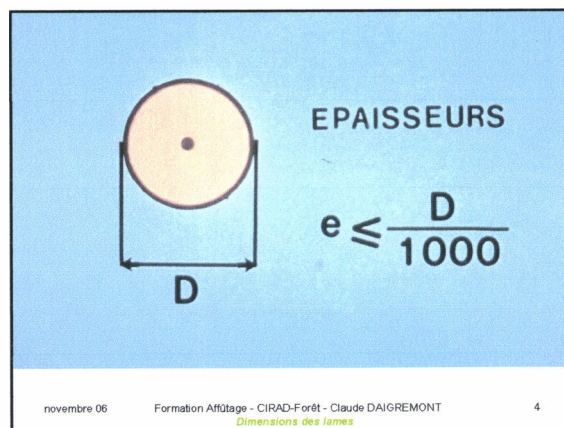
largeur

épaisseur

?







STABILITE DES LAMES

- | | | |
|------------------|--|---------|
| 1. dénivellement | | volants |
| 2. bombé | | |
| 3. tensionnage: | | lames |

BOMBES

$p = 1 \text{ à } 5 \text{ ‰}$

novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 2

Stabilité des lames

DENIVELLEMENT

double **simple**

novembre 06 Formation Affûtage - CIRAD-Forêt - Claude DAIGREMONT 3

Stabilité des lames
