MOUNTING A KEYED SLITTING SAW

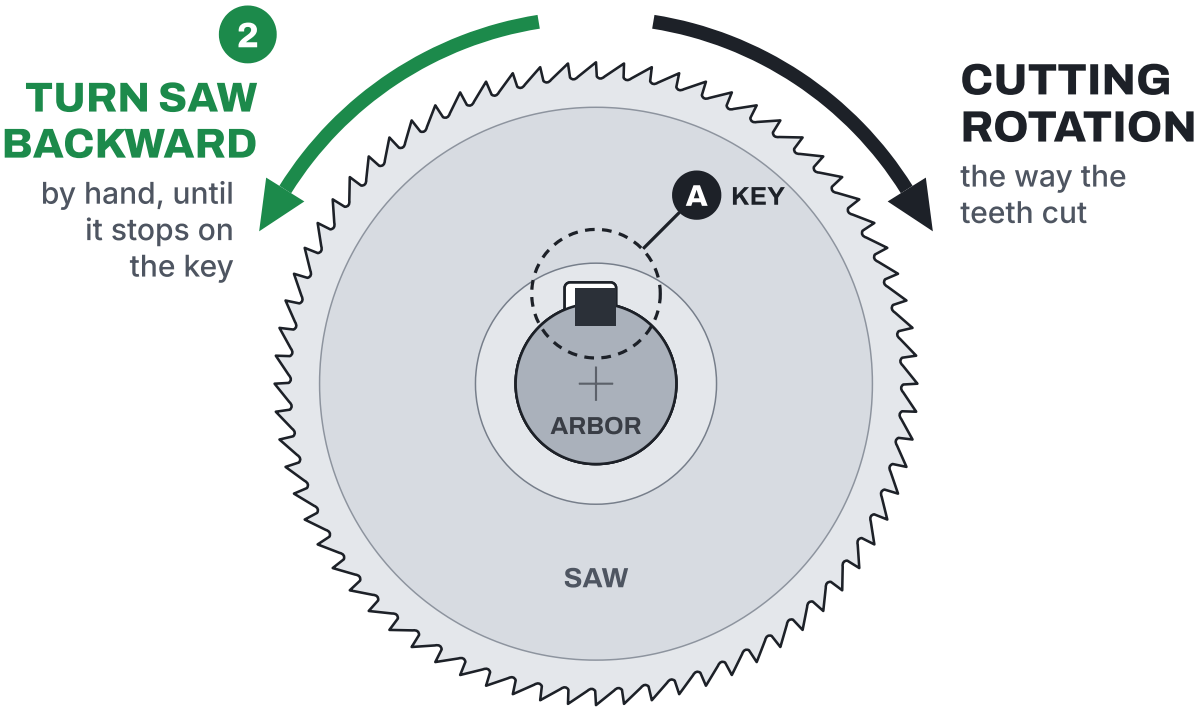
Turn the saw backward against the key, then tighten the nut

Three steps, every time the saw goes on the arbor. It reduces the shock on the keyway, where cracks start.

WHO DOES THIS
The person who mounts the saw (operator or setup)

APPLIES TO
Any slitting saw with a keyway, on an arbor with a drive key

> **Before you start.** Machine stopped and locked out. Check both keyway corners: never run a saw that shows a crack. Use a rag or gloves, the teeth are sharp.



1

Slide the saw on over the key. Leave the nut loose.

2

Turn the saw backward by hand, against the direction the teeth cut, until it stops on the key. It only moves a little.

3

Keep light backward pressure on the saw and snug the nut by hand. Then tighten.

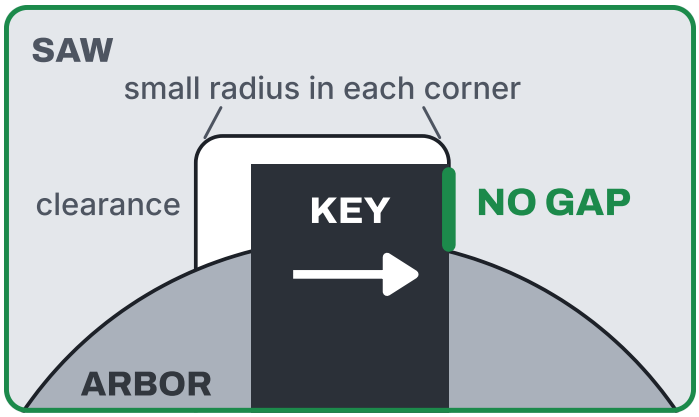
> **When you tighten.** Hold the arbor with its wrench or the spindle lock, never by the saw. If the saw turns with the nut, loosen it and start again.

Shown for a saw cutting clockwise. If yours cuts counter-clockwise, mirror the picture. The rule is the same: turn the saw backward onto the key. Close-ups of the key (A) are on page 2.

Why it matters: close-up of the key (A)

✓ CORRECT

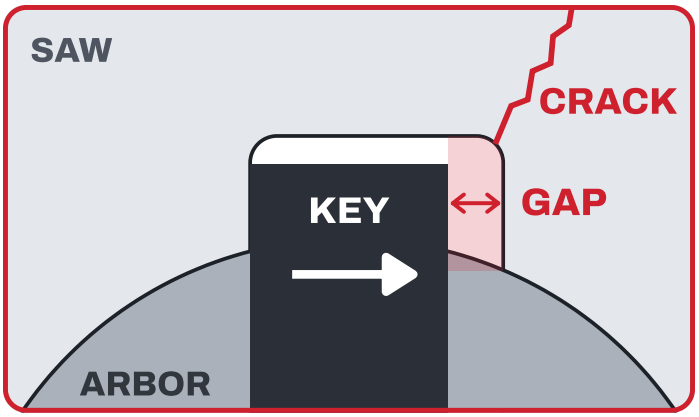
Keyway seated on the key



The key is already touching the keyway. The load comes on smoothly.

✕ WRONG

Gap on the driving side



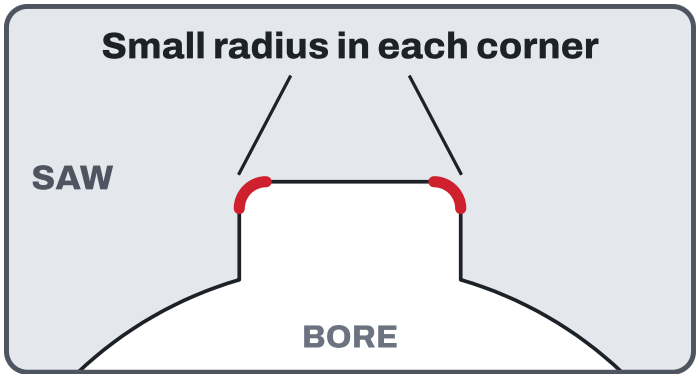
If the saw slips as the teeth enter the cut, the keyway slams back into the key. The shock concentrates at the small corner radius, where cracks start.

The key pushes the saw in the cutting direction (to the right here). The clearance is drawn larger than real so you can see it.

If cracks still show up: full-radius (round) keyway

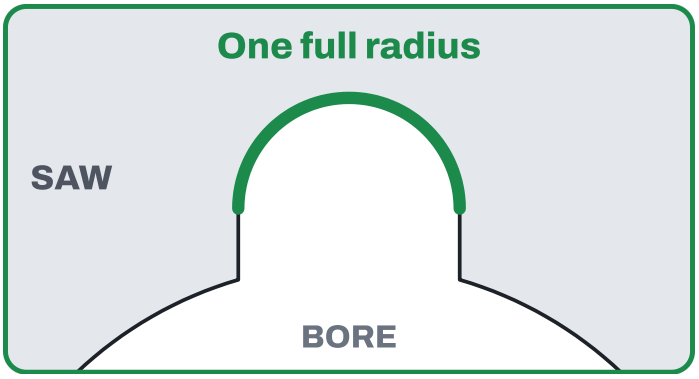
RobbJack can make the same saw with one large radius in place of the two small corner radii.

Standard keyway



A small radius in each corner. Under shock, stress concentrates there, and in carbide a crack can start.

Full-radius (round) keyway



One full radius in place of the two small ones. The load spreads around a much larger curve.

Pictures show the shape only and are not to scale. RobbJack confirms the fit to your arbor and key before making the saws.

Three quick checks at every saw change

Key
No burrs, dents or mushroomed edges. Replace a damaged key. After any saw failure, check the key, the key slot and the arbor under the saw.

Top of the key
With the nut loose, the saw has a little play on the key. The key touches only the keyway's straight side, never its top or corner radius.

Clamping
Flange and spacer faces clean and flat. Nut at the arbor maker's torque, so the clamp carries most of the load and the key takes less.