High precision arbor
Patented Micrometer with H6,
Ovality Deviation <0.005MM.

Rare alloy steel plate
Patented YB09 steel plate
with 5 kinds of rare metal elements
enables 3 times anti- resistance.

Ultra-high-pressure treatment
Patented technology:
72 hours of continuous heat treatment,
more uniform and tighter steel plate structure,
natural leveling surface.

Big data based test for tension
Tension inspection based on big data,
precise tension value for each saw blade.

German welding technology
Tooth firmness and durability:
German Gerling welding machine,
German Umicore sandwich solder.

Precision grinding
Multi-sided and multi-wheel fine grinding craft:
grinding on 6 sides by 6 types of different grinders.

Balanced polishing technology
Patented Technology:
Balanced polishing technology.

Chengdu Yibai Technology Co.,Ltd.
Http://www.ybtool.com
Tel : 400-0866-860
Address: No.19 Hengsheng Road,Dayi Economic Dev. Zone, East Shaqu Town, Dayi County, Chengdu, Sichuan Province, P.R.China.

KWS®

PRODUCTS CATALOG
YIBAI TOOL

GERMAN TECHNOLOGY
EXPORTED TO 68 COUNTRIES

BRIEF INTRODUCTION

Chengdu Yibai Technology Co., Ltd. is a manufacturer of cutting tools， which is located in Chengdu China. With ‘KWS’ as its well-known brand, Yibai has been devoting it self into R&D of PCD saw blades, TCT saw blades, cold saw blades, finger joint cutter, drill bits, router bits and spiral cutter head since its establishment in 2002.

Yibai's facility including 8 Buildings covering more than 40000m² with annual output of more than 1 million pieces. Yibai has setup automatic production line with famous machines that from worldwide (automatic rate above 90%)like Mitsubishi Laser cutting, Gerling Automatic welding machine and Automatic machine etc.

With more than 20 R&D personnels' continuous hard work, Yibai is working closely with customers to improve its quality Till now, we have got 22 national patents. The company has become one of the few manufacturers in the saw blade industry to obtain ISO 9001,45001,14001 system certification

Till now, KWS products have been exported to more than 68 countries and awarded high reputation. Meanwhile Yibai has more than 100 chain stores nationwide for better service.

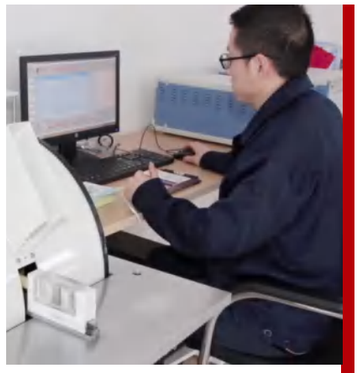
Yibai spares no efforts to provide professional quality products & service to our clients constantly. We sincerely hope to develop long term cooperation with all customers base on Win-Win conditions

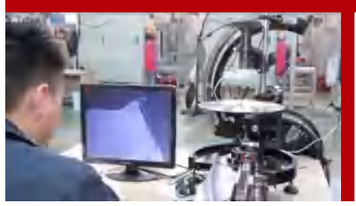
ISO

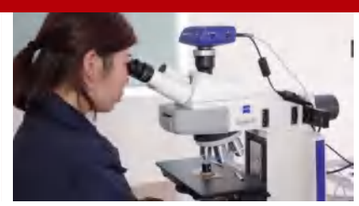
ISO9001 ISO14000 ISO45001

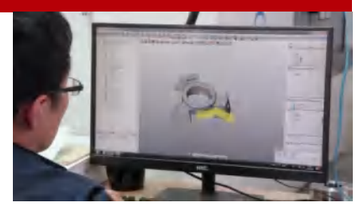
PATENT

QUALITY CONTROL



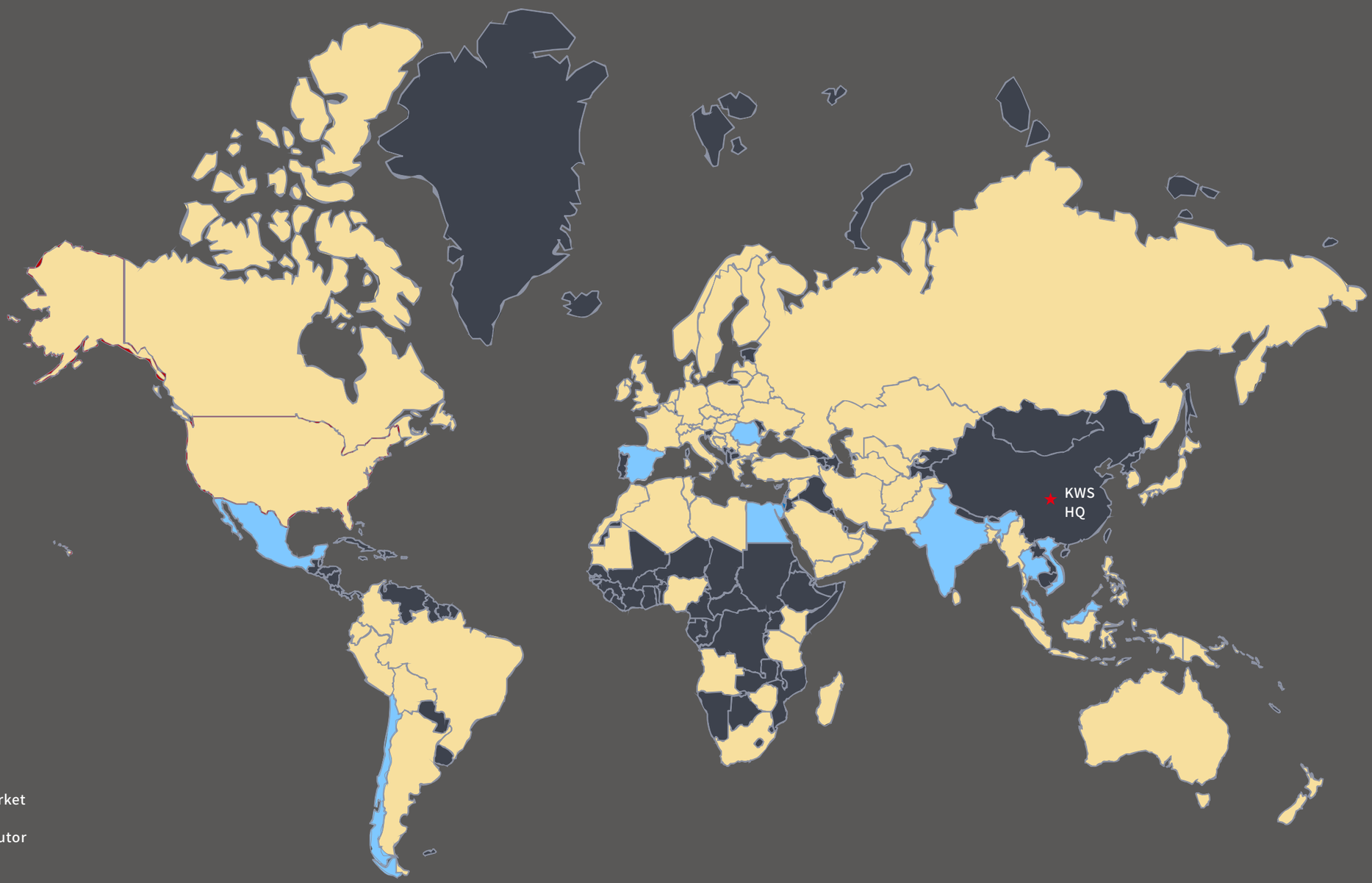






Introduction Of

KWS



TIPS FOR THE CORRECT USE OF A SAW BLADE

In order to obtain the best performance, we suggest to follow these instruction
*The machine must be in good condition, no vibrations.
*The spindle must be 100% straight and with an H7 tolerance
*The blade must be secured with the same diameter, at least 1/3 of the saw blade's diameter
*The flanges must be parallel to each other. Also check tolerances on diameters, sides and concentricity, by using a clock gauge (Fig. 2)
*The spacers must be perfectly parallel (Fig. 2)
*After used for a certain long period. Please remove the blade and clean it.
*The blades must be sharpened while it become dull. Must maintaining the original tooth angles
* While sharpening, please use the correct grinding wheels with cooling liquid.
*Keep spacers and flanges clean
*While sharpening, the shoulder of the teeth must not be lowered more than needed, otherwise the risk of breaking the tip or upsetting the blade balance will happened
*On ripping machines, the feeding track must be levelled with the fixed table. Before starting the cut of the material, make sure the blade is correctly locked according to the machine's specifications.

SAW BLADE ALIGNMENT ON A TABLE SAW

In order to obtain the best performance, we suggest to follow these instruction
*The machine must be in good condition, no vibrations.
*The spindle must be 100% straight and with an H7 tolerance
*The blade must be secured with the same diameter, at least 1/3 of the saw blade's diameter
*The flanges must be parallel to each other. Also check tolerances on diameters, sides and concentricity, by using a clock gauge (Fig. 2)
*The spacers must be perfectly parallel (Fig. 2)
*After used for a certain long period. Please remove the blade and clean it.
*The blades must be sharpened while it become dull. Must maintaining the original tooth angles
* While sharpening, please use the correct grinding wheels with cooling liquid.
*Keep spacers and flanges clean
*While sharpening, the shoulder of the teeth must not be lowered more than needed, otherwise the risk of breaking the tip or upsetting the blade balance will happened
*On ripping machines, the feeding track must be levelled with the fixed table. Before starting the cut of the material, make sure the blade is correctly locked according to the machine's specifications.

MOUNTING THE SAW BLADE ONTO THE TABLE

The precise measuring instruments are requested to using while mounting your saw blade
Make sure the saw blade is clean then mount the saw blade onto the arbor.
Adjust the arbor to its maximum height, With the aid of the most precise measuring instrument available, verify that the saw blade is parallel to the miter gauge slots.
Adjust it if needed. Which is necessary to obtain crosscuts
With the maximum in quality finish and for setting up the fence for ripping

POSITIONING THE FENCE FOR RIPPING

After positioned the saw blade to be parallel to the miter gauge slot you may proceed with setting the fence. The fence should be parallel to the saw blade. it is necessary to leave a slight margin of clearance on the exit side of the cut so as to avoid the wood becoming wedged in between the fence and the saw blade
Adjust the fence so as when it is aligned to the miter gauge slots, there is a space of
0. 1 mm (for the correct adjustment, reference to the machine's instruction manual)
The maximum RPM of a circular saw blade varies according to the diameter of the blade itself. If you exceed this limit, the cutting performance and the life cycle of the blade will be affected heavily, and the dangers may incur and leads to injury.
The saw blade's projection (T) with respect to the workpiece must be at least equal to the height of the blade's tooth (ig, 9), adjust the projection of the saw blade to improve the quality of the cutting finish
The number of teeth cutting must be between 3 or 4. With less than three teeth cutting, the saw blade begins to vibrate leading to an uneven cut. If you want to cut workpieces with increased thicknesses but wish to use the same diameter saw blade, then use a blade with less teeth If you want to cut workpieces with a reduced thickness, but also maintain the same diameter saw blade, then use a blade with more teeth.

To obtain the pitch (P)of a blade (the distance between teeth: fg. 11–(see formula "a") multiply the thickness of the workpiece by 1.4142 and divide by 3 (if you want 3 teeth cutting) or by 4 (if you want 4 teeth cutting
Formula "b" to obtain the number of teeth (Z) of the saw blade, multiply the diameter D of the saw blade by 3.14(π)and divide by the pitch of the saw blade -obtain from the previous formula. The shorter formula " c " allows you to obtain the nr. of the saw blade's teeth. knowing its diameter and the thickness of the workpiece.

Formula A	Formula B	Formula C
$P=\frac{Sx1.4142}{3}$	$Z=\frac{Dx3.14}{P}$	$Z=\frac{Dx8}{S}$

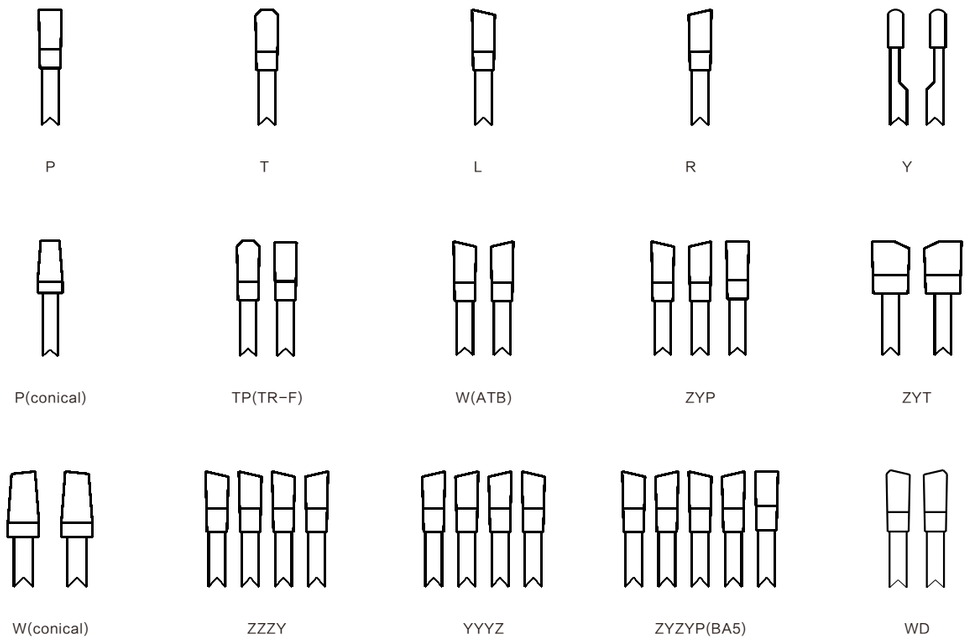
THE MEANING OF LETTER:

P= pitch
S= thickness of the workpiece
Z= Qty of teeth of the saw blade
D= diameter of the saw blade

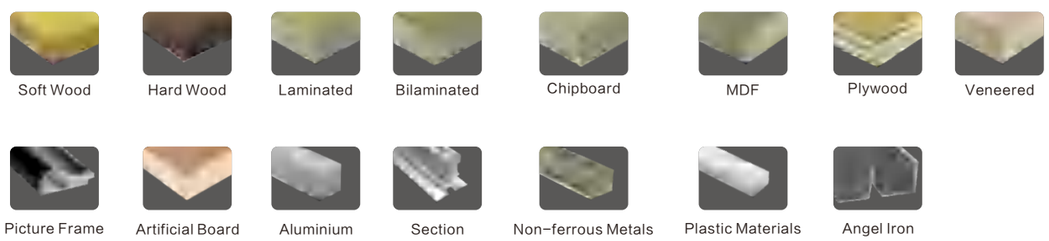
ATTENTION:

These formulas are valid for crosscutting and cutting other wood composites of (MDE plywood, chipboard and laminated panels) and cannot be applied for ripping

◉Tooth configuration



◉Workpiece Diagrams



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