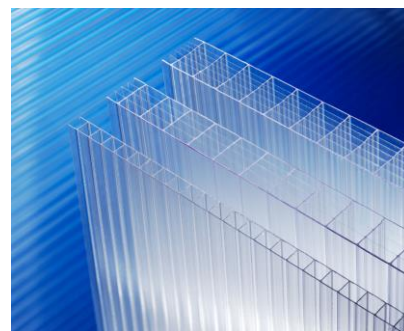


marlonst LONGLIFE Cutting



Recommended blade conditions:

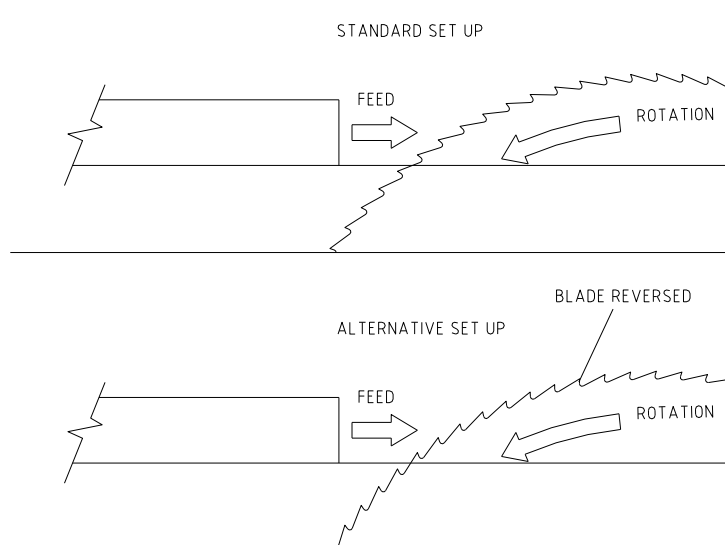
CIRCUMFERENCE SPEED	2400 m/min
TOOTH SPACING	10 mm approx.
DIAMETER	250 mm approx.
CLEARANCE ANGLE	20-30°
RAKE ANGLE	15°

Below are some factors which can affect the quality of the cut:

- The blade should only protrude through the sheet by about 10 mm. If the blade is too far through the sheet, the blade 'chips' at the sheet producing a bad cut.
- If the blade speed is too slow and the feed rate too high chipping may occur.
- If the feed rate is too slow too much heat is generated leading to melting at the ends of the sheet.
- If the blade is worn or blunt too much heat can be generated.
- If cutting Heatguard/Opal sheet it may be beneficial to put the Heatguard side to the bottom.

We have found that reversing the blade has a beneficial effect (see diagram).

These factors have worked for us, but some variance of the cutting speed and feed may be necessary for other equipment.



Access Plastics Ltd.

Access Plastics Ltd., pursues a policy of continuous product development and reserves the right to amend specifications without notice.

Access Plastics Ltd., Unit 16 Ashbourne Industrial Estate, Ashbourne, Co Meath. Ireland. A84 W972.
Tel: + 353 1801 0022 Email: sales@accessplastics.com

www.accessplastics.com | www.365plastics.ie | www.polycarbonatesheets.ie