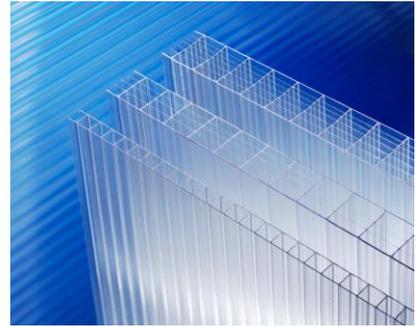


## marlon<sup>st</sup> LONGLIFE Cutting



Recommended blade conditions:

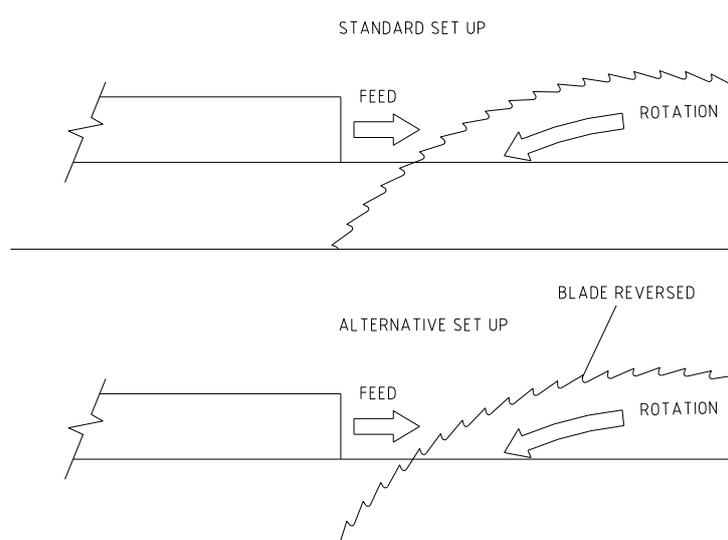
|                     |                |
|---------------------|----------------|
| CIRCUMFERENCE SPEED | 2400 m/min     |
| TOOTH SPACING       | 10 mm approx.  |
| DIAMETER            | 250 mm approx. |
| CLEARANCE ANGLE     | 20-30°         |
| RAKE ANGLE          | 15°            |

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.



Plastic Sheets

Brett Martin Ltd. pursues a policy of continuous product development and reserves the right to amend specifications without notice.

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