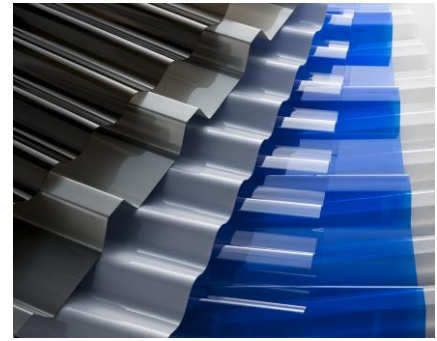


marlon **CS**
LONGLIFE

CUTTING



Marlon CS can be cut with a variety of tools:

- Fine tooth hand saw: hold the saw at a shallow angle and cut with slow steady strokes.
- Jig saw fitted with a metal cutting blade
- Band saw fitted with a high speed metal cutting blade
- Circular saw fitted with a diamond grit blade.

Support the sheet to avoid stress and vibration.

Cutting multiple sheets can be achieved but extra care must be taken.

The basic blade characteristics which we have used for multiple sheets is:

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.



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

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