Cutters for bevellers of other manufacturers.

Cutters	Art. Nr.
Cutting tool ECO for the machine CEVISA - CHP6, CHP12 and other bevelling systems	2135
Cutting tool PVD for the machine CEVISA - CHP6, CHP12 and other bevelling systems	2235
Cutting tool ECO for the machine GULLCO - KBM 18	2133
Cutting tool PVD for the machine GULLCO - KBM 18	2233

Art. Nr. 2135

Art. Nr. 2133

Expected life and the recommended care for the tool:

Tools intended for machining by rotary shear are designed for materials with the maximum strength of Rm up to 600 MPa / 87 022 PSI.
Upon the compliance with all conditions specified in the instruction manual, the tool life may be up to 4000 m / 13 123 ft and more.

Reallisticaly the life is about 2000 – 3000 m / 6561 - 9842 ft. A tool life is influenced by several factors:

Material and its preparation
As already mentioned it is necessary to adhere to the maximum strength of the machined material.
When bevelling materials with higher than allowable strength the tool life rapidly decreases, but there is also a risk of the destruction of the tool or damaging the drive unit.

The tool life can also be affected by the preparation of the material before machining. If the material at your workshop is cut by burning, you should clean the edges intended for bevelling by angle grinder.
When burning, especially when plasma burning, edges of the material might be little bit hardened.
This can have a significant impact on the ultimate tool life.

Care for tool
The maintenance of the tool and especially the care for the tool has significant influence on the life of the tool.
During bevelling, it is important to check sharpness of the tool on a regular basis and if it is blunt, it is necessary to sharpen it immediately.
If you continue to work with a blunt tool chipping or destruction of the tool might occur.

Working procedure
The machining procedure is important.
Generally, when implementing the maximum possible reductions (bevel edge width) machining must be divided into two cuts.

This whole issue is described in detail in the machine user manual.