

## CUT-OFF BLADE NOTES

Continental Cut-Off Blades are available for almost all tube sizes and wall thicknesses. These blades are manufactured from S-7 Tool Steel. They are held to precise tolerances and heat treated to provide a long life. They may be resharpened using one of the Continental Grinders (see current catalog), or sent to Continental Pipe & Tube Cut-Off Machines for resharpening. With proper care, Continental Cut-Off Blades will provide thousands of cuts.

Following is a checklist of circumstances that can result in shortened blade life. Review this list when blade life is shorter than expected, or when unsatisfactory cutting action is encountered.

1. Make certain correct blade model is being used. Check current Continental Catalog for applications.
2. #5723 Nut must be tightened securely to make certain the Cut-Off Blade is clamped flat and cannot slip.
3. Make certain that the blade does not touch the cutter block rolls at the end of the stroke. This will immediately damage both the blade and the rolls.
4. Check alignment of the tubing in the pipe supports and cutter block roll (see OPERATION Section). This alignment is critical for smooth cuts and long blade life.
5. Make certain that the tube spins freely on the supports. Any drag or binding can cause the Cut-off Blade to slip against the pipe as it cuts.
6. Check adjustment of the Length Gauge to make certain it clears the tube shortly after the Cut-Off Blade engages the cut. As the cut is made, the end of the tube is actually moved towards the Length Gauge. If the gauge has not cleared the end of the tube it will cause binding.
7. On air powered machines, check to be sure the Hydrocheck engages BEFORE the Cut-Off Blade contacts the tube.
8. Make sure that the tubing is not striking the side of the Cut-Off Blade as it is advanced into position.
9. On tough or heavy wall material, a lubricating oil may be required to assist the cut. Use LUBRICATING oil, NOT cutting oil.
10. Do not attempt to cut excessively bent, twisted or otherwise distorted material.
11. Tubing material can vary significantly, even within one lot. Hard areas may be encountered, which can shorten blade life.
12. If material is long (over 20 ft.) or very heavy, the Cut-Off Blade may have difficulty spinning it. This will cause the blade to slip, shortening blade life.
13. During resharpening, the edge of the blade must not become overheated. This will cause the edge to soften.
14. After resharpening, the edge of the blade should be honed with a stone (available as Continental Part No. #5959) to remove the sharp edge, and provide a rounded edge. The sharper the edge the more fragile it is.

NOTE:

- A. If a sharper edge is left on the blade (less honing), the blade will cut faster and with less pressure, but will not last as long between resharpenings. This is more appropriate for thin-walled, softer, materials.
  - B. If a more blunt edge is left on the blade (more honing), the blade will require more pressure to cut, but will last longer between resharpenings. This is more appropriate for heavier walled, tougher materials.
15. If a Cut-Off Blade becomes dull or nicked during use, remove it immediately and have it resharpened. If it is left in service, the damage will become worse. In a relatively short time, the blade will be ruined.