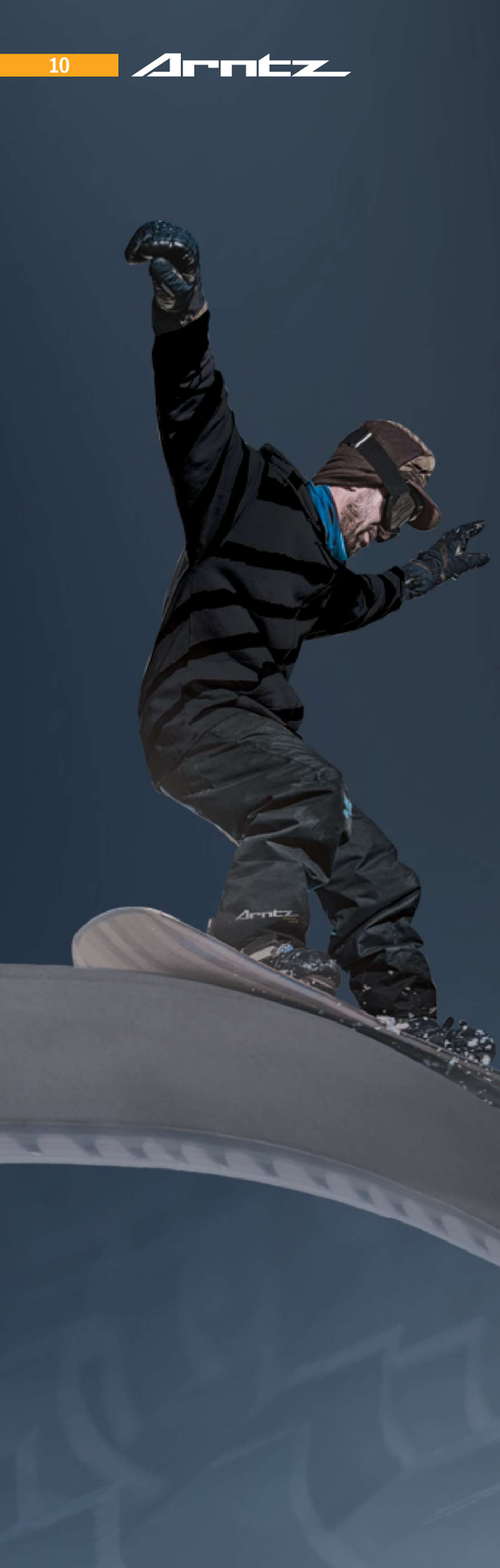

R-TEC

Faster, Straighter, Longer!

R-TEC OPTIONAL

Second generation ramping technology with improved design capability to give custom made solutions to the most challenging applications.

Benefits

- Increases tooth penetration without adding more machine feed pressure
- Allows the blade to cut a wider range of dimensions
- Precise edge radius control to reduce backer fatigue and improve blade life
- A fully redesigned machine to support coolant and filtration systems to increase speed, keeping production costs low
- Newly designed propriety software gives us maximum versatility in ramp design

R-TEC

TOOTHING GUIDELINE

Toothing recommendation for thin-walled profiles

Wall thickness in mm	Profile outer diameter in mm						
	20	40	60	80	100	120	150
2	14	14	14	14	14	14	10/14
3	14	14	14	14	10/14	10/14	8/11 | 8/12
4	14	14	10/14	10/14	8/11 | 8/12	8/11 | 8/12	6/10
5	14	10/14	10/14	8/11 | 8/12	8/11 | 8/12	6/10	6/10
6	14	10/14	8/11 | 8/12	8/11 | 8/12	6/10	6/10	5/7 | 5/8
8	14	8/11 | 8/12	6/10	6/10	5/7 | 5/8	5/7 | 5/8	5/7 | 5/8
10	-	6/10	6/10	5/7 | 5/8	5/7 | 5/8	5/7 | 5/8	–

Toothing recommendation for thick-walled profiles

Wall thickness in mm	Profile outer diameter in mm							
	80	100	120	150	200	300	500	750
10	-	-	-	4/6	4/6	4/6	3/4	2/3
15	4/6	4/6	4/6	4/6	4/6	3/4	2/3	2/3
20	4/6	4/6	4/6	4/6	3/4	3/4	2/3	2/3
30	4/6	4/6	4/6	3/4	3/4	2/3	2/3	2/3
50	-	-	3/4	3/4	2/3	2/3	2/3	1,4/2
80	-	-	-	-	2/3	2/3	1,4/2	1,4/2
100	-	-	-	-	-	2/3	1,4/2	1,4/2

Toothing recommendation for solid material

Cross section mm	Teeth per inch tpi
from 550	0,75/1,25
380 - 750	1/1,3
250 - 550	1,4/2
120 - 350	2/3
80 - 140	3/4
60 - 110	4/6
40 - 70	5/7 | 5/8
30 - 60	6/10
20 - 40	8/11 | 8/12
to 25	10/14

Quick Tips

- The required tooth pitch depends on the wall thickness and diameter of the profiles tobe cut. The tables apply to single cuts. If two or more profiles are cut next to each other, the tables apply taking into account two times the wall thickness with a single profile outer diameter
- Always ensure at least 3 teeth are in contact with the material for clean cuts and to avoid blade binding
- For wider material, use lower TPI to reduce strain and improve chip clearance
- For smaller materials, use higher TPI to prevent tearing or jagged edges