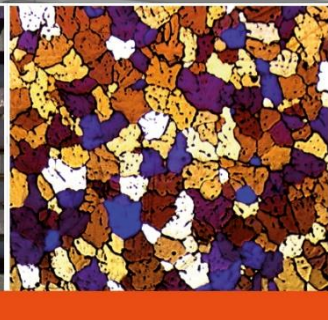
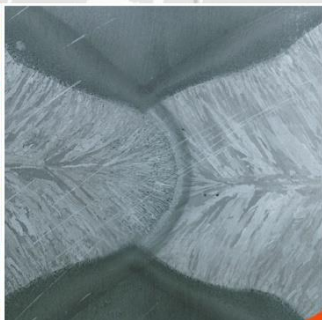
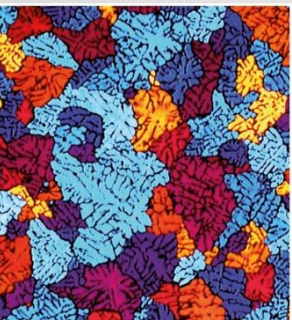


Application lab report

Cutting a titanium plate



QATM-Preparation method

Objective:

One specimen has been received. The specimen is to be cut in stripes with the Qcut 350 A. It is important that the strips are parallel and as many as possible are separated in one pass. Detailed parameters and images will follow in the report.



Figure 1: Overview of the specimen.

Cutting

 Cutting			
Device	Cut-off disc	Anti-corrosion coolant	Clamping tool
Qcut 350 A	Ti-A 300SC 95012537	QATM Cool Cut	-2x Easy-clamping Base L* (Z2236011) -HPL Plate (230x190 mm) -2x Universal Vice Piccolo 100 (Z1350012)
Cutting method			
Horizontal cut (X-axis)			
Parameters			
Feed speed	Pulse parameter	Cut-off disc rotational speed	
0,3 mm/s	Without Pulse	3000 RPM	
Notes			
- To avoid vibrations, we used an HPL plate as a base. It is important that the specimen is supported on both sides. - 4-5 stripes can be cut in one pass. - *If the HPL plate is higher, the Easy-clamping L plates are not needed.			

QATM-Preparation method

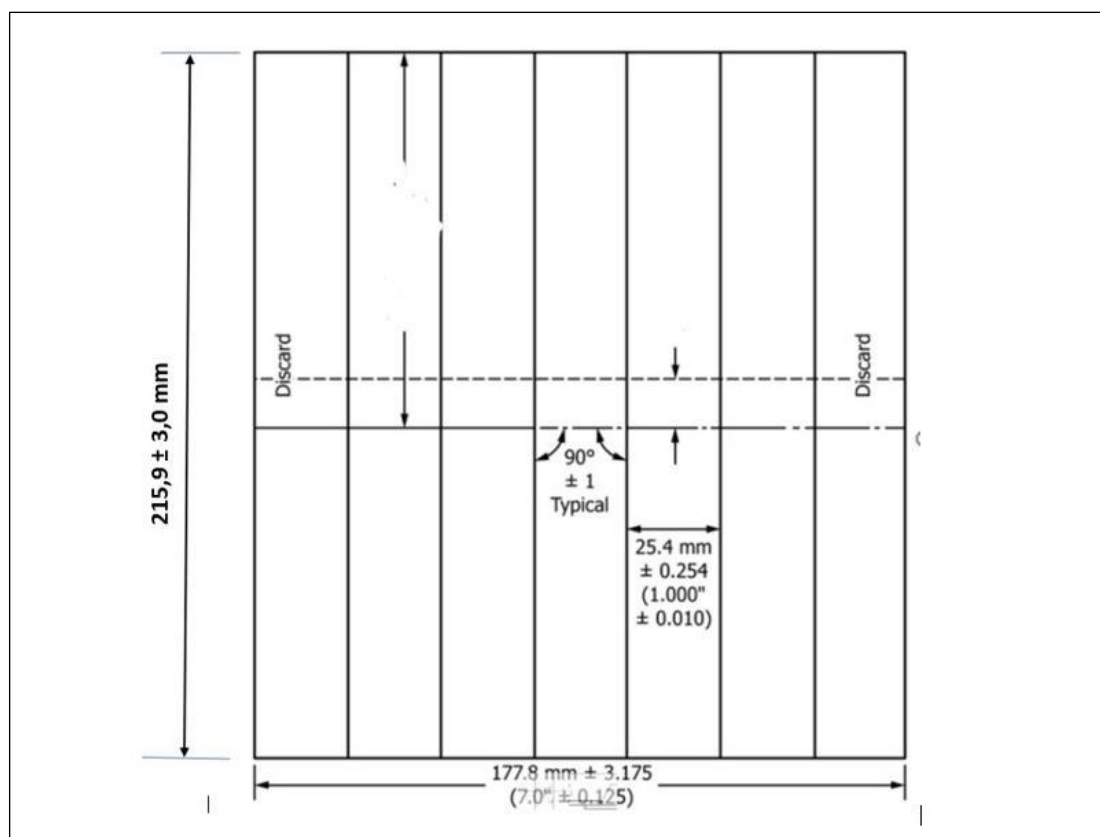


Figure 2: Drawing of the separation cuts.

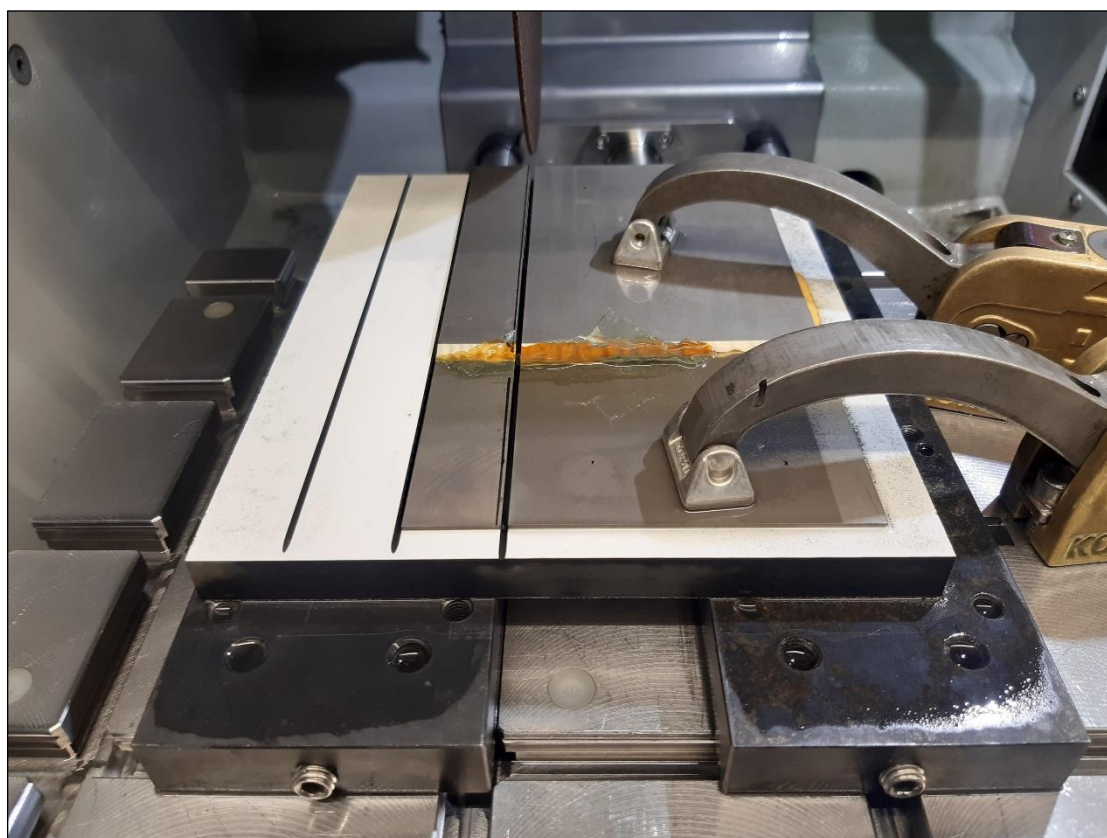


Figure 3: Specimen after 3 cuts.

QATM-Preparation method



Figure 4: Specimen after 3 cuts.



Figure 5: Cut specimen.

QATM-Preparation method

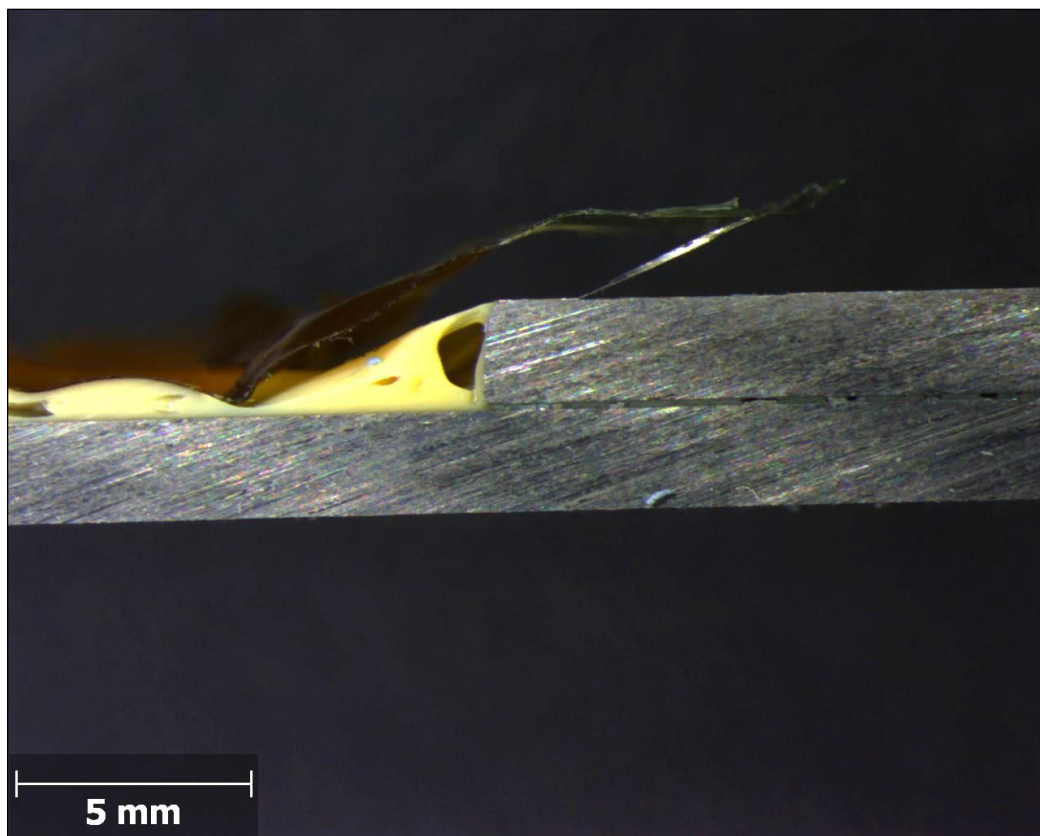


Figure 6: Cut specimen 8x.

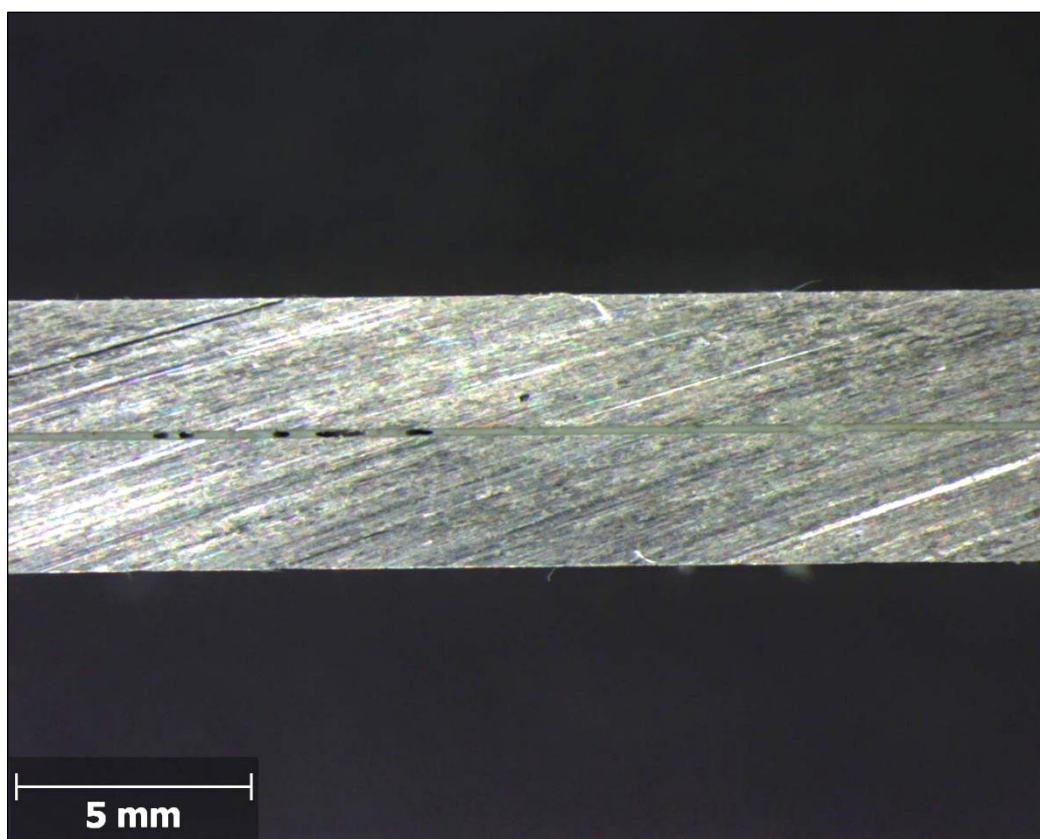


Figure 7: Cut specimen 8x.

QATM-Preparation method

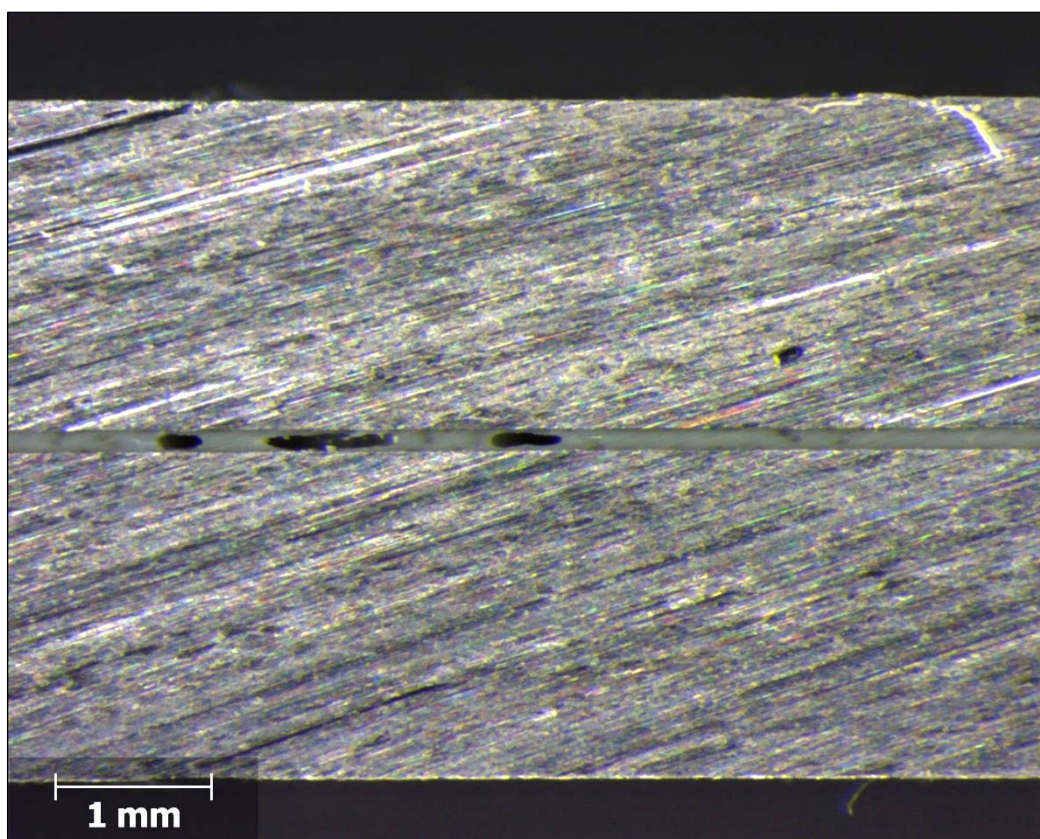


Figure 8: Cut specimen 25x.