

SHEAR BLADES FOR GOB FEEDER



PUTSCH® Shear blades are made of high quality, heat resistant special steel. Stringent quality controls are applied to every blade produced. The shear blades in each packaged unit are sorted by height with a $\pm 1/250$ inch ($\pm 0,1$ mm).

Types 1775, 2316 and 4031 are used mainly in the production of glass bottles and glass containers with cutting rates up to 200 cuts per minute. In order for our shear blades to withstand this type of stress, our blades are made of high quality, high speed steel.

For the production of crystal and pressed glass articles, glass manufacturers mainly use PUTSCH® shear blades type 3533, 3167 and 3299. These blades are made from high precision solid specialty steel in our state-of-the-art machining centers. Shear blades manufactured in this processing manner guarantee superior cutting results and minimal wear and tear.

ADVANTAGES

- Every shear blade pair for double, triple and quadruple gob operation has the same pressure and wear at the cutting edge.
- The shear blades are sandblasted to increase the surface area. This causes better retention of the cooling liquid which optimizes the cooling effect.
- A special hardening process ensures that a high percentage of the materials alloying components are changed into carbides. The carbides guarantee that the hardness of the shear blades is preserved even if the shear blades are accidentally overheated.
- The shear blades have excellent emergency running properties in overheated situations.
- Custom blades manufactured for specialty glass applications.
- Special grind on blades available.
- Resharpening services available to reduce overall shear blade expenditure.



Shear Blade #1775 F / S

Single gob and double gob for bottles, containers, table and domestic glass ware

V-type 85°, usable cutting width:	3" (75 mm)
Width, max.:	3 5/8" (90 mm)
Length:	6" (145 mm)
F: straight cutting edge "Flat grind":	30° (standard) 45° (special design)
S: rounded cutting edge "Special grind"	

Equivalent to Emhart #760-212; Emhart #144-6883;
Emhart #144-13864



Shear Blade #5230 F / S

Double gob and triple gob for bottles, containers, table and domestic glass ware

V-type 85°, usable cutting width:	3" (75 mm)
Width, max.:	3 5/8" (90 mm)
Length:	6" (145 mm)
F: straight cutting edge "Flat grind":	30° (standard) 45° (special design)
S: rounded cutting edge "Special grind"	



Shear Blade #2316 F / S

Double gob, triple gob and quadruple gob for small bottles, containers, table and domestic glass ware

V-type 85°, usable cutting width:	2" (50 mm)
Width, max.:	2 3/4" (69 mm)
Length:	5 1/2" (133 mm)
F: straight cutting edge "Flat grind":	30° (standard) 45° (special design)
S: rounded cutting edge "Special grind"	

Equivalent to Emhart #144-6882



Shear Blade #3167

Single gob and double gob for heavy glass articles up to 10 lb (5 kg) weight

V-type, 86°, usable cutting width:	4" (100 mm)
Width, max.:	6" (145 mm)
Length:	6 1/2" (165 mm)

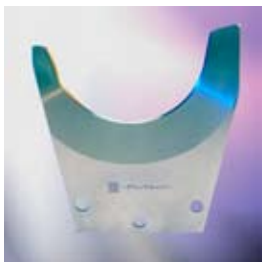
Equivalent to Emhart #144-12958



Shear Blade #3533

For technical, optical and crystal glass

U-type, usable cutting width:	1", 1 1/2", 1 3/4", 2 1/4", 2 1/2" (25, 35, 45, 55, 65 mm)
Cutting edge radius:	5/8", 7/8", 1", 1 1/4", 1 1/2" (15, 20, 25, 30, 35 mm)
Width, max.:	4" (100 mm)
Length:	6 1/4" (155 mm)
Special designs with cutting edge radius 3/8" (10 mm), 1/2" (13 mm), 3/4" (17.5 mm), 1 5/8" (40 mm), 1 3/4" (45 mm) available.	



Shear Blade #3299

For very heavy glass articles up to 16 lb (8 kg) weight

U-type, usable cutting width:	2 7/8" or 3 5/8" (70 or 90 mm)
Cutting edge radius:	1 5/8" or 2 1/8" (39 or 52,5 mm)
Width, max.:	6" (150 mm)
Length:	7 4/4" (191 mm)
Special designs with other cutting edge radius available.	

FEATURES

- Optimum cutting dynamics with partial flexibility in the clamping area, combined with the tempered cutting area.
- Parallelism and planimetry of the cutting edges within tight tolerances offer even, minimal stress on the cutting edges in addition to superior operating reliability.
- Exceptional durability within minimal wear and tear due to low cutting area pressure.
- Special relief grinding of the upper cutting edge avoids shear blade marks.
- Various cutting edge angles for special applications.
- Effective cooling agent adhesion due to the matted shear blade surface allows adjustment of the shear blade temperature for an optimum cutting result.
- High form stability of shear blades under stress due to the arrangement of side stamping developed from practical experience.
- Regrinding is possible with high quality PUTSCH® shear blades. The reground blades perform equal to new blades and thus lower the unit cost of the shear blade.

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Note: The physical and chemical properties listed represent typical, average values obtained in accordance with accepted test methods and are subject to normal manufacturing variations. They are supplied as a technical service and are subject to change without notice.

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