

DURAFRAX® 2000 CUTTING GUIDELINES

Durafrax® 90% fine grain high alumina is supplied in numerous standard sizes in custom-cut or molded shapes. Use of several standard-sized tile plus field or precut pieces allows the user to economically install linings in his shop or in the field. Cutting the necessary pieces can be easily done by using a mason's hammer and chipping, or by cutting with a diamond-tip continuous rim masonry saw. Choice of cutting technique depends on the complexity of the job, the fit of the tile required, and the specific wear

Diamond Saw Method

A diamond saw is used when a job requiring close fits and tight joints is essential.

Equipment Required:

- Water cooled masonry saw
- Solid rim diamond wheel. Typical is a 10" diameter continuous rim diamond saw blade with a 1" arbor hole x 3/32" thick. Diamond concentration is approximately 75% with a 1/4" diamond depth.
- Coolant—plain water



Procedure:

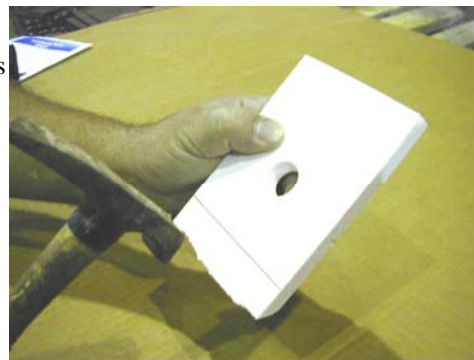
- Position tile on saw conveyor cart and secure firmly
- Apply light pressure during cutting process, do not stall blade
- Begin cut at furthest point and slide conveyor back and forth until cut is completed

Chipping Method

Chipping is used when the job does not require intricate cutting of the high alumina tile.

Equipment Required:

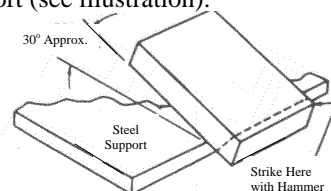
- Chipping hammer (Mason or Tack hammer)
- Carbide tipped hammers are not recommended since they will chip.
- Gloves
- Safety Glasses



Procedure:

- Support the tile in any of the three following manners:
 - 1.) supported on the edge of any available steel support
 - 2.) supported against your leg
 - 3.) held in your hand

In all cases the tile is to be held approximately a 30° angle to the support (see illustration).



- Chip a little at a time by striking down with a hammer. Chipping depth should be approximately 1/8" or less. Note that the resulting cut will bevel away from the impact point.