

Decorative Cutting

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The Tools for Hollow Glass

- Cutting wheels
 - Geometric definition
 - Recommendations



Diamond machining of hollow glass



Decorative Cutting

Introduction

Formerly done on large diameter wheels with natural abrasive, the decorative cutting of crystal glass is now performed on diamond wheels, which have brought to this industry the technology associated with productivity and profitability.

We will review the developments in diamond cutting wheels resulting in the technically sophisticated tool that today's modern industry requires.

The various cutting profiles

The various cutting profiles performed on crystal and soda glass products can be classified according to their cross section (in sq. mm), their shape and aspect.

These three parameters will determine:

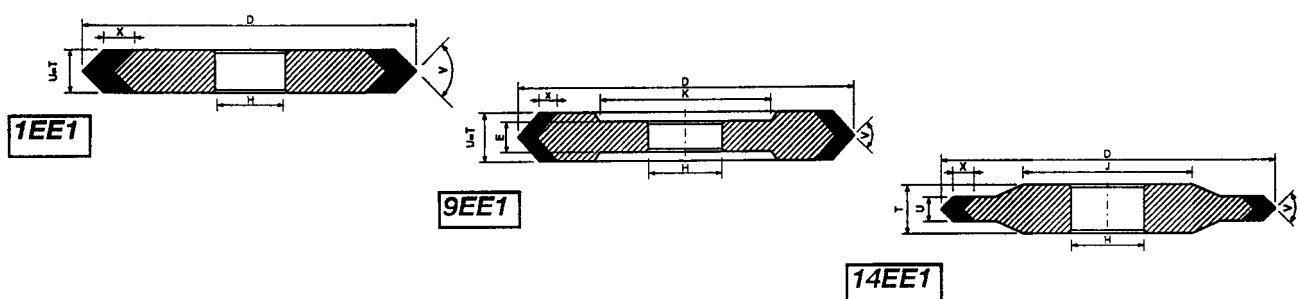
- the specification of the wheel
- the working sequence(s)
- the form of the wheels.

The Tools for Hollow Glass

Cutting wheels

Geometric definition

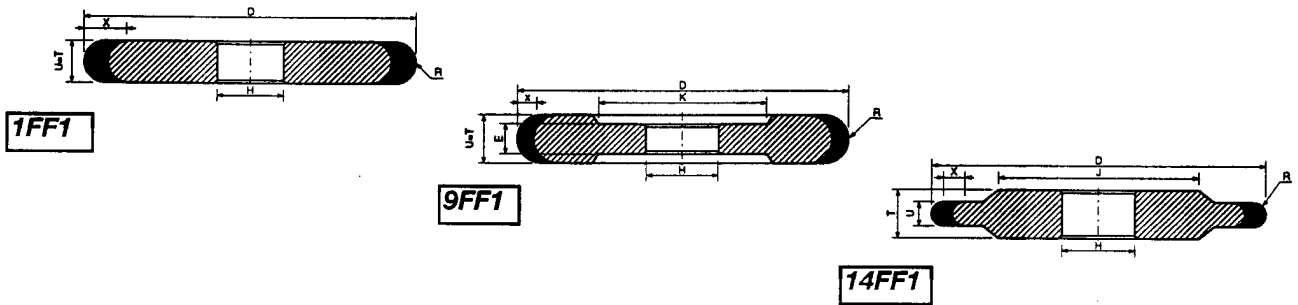
The "V" cut



ALTIFORT-BOART Form

L14B-D-U/V-X-Specification-H/T-J or E-K – FEPA 1EE1, 9EE1, 14EE1

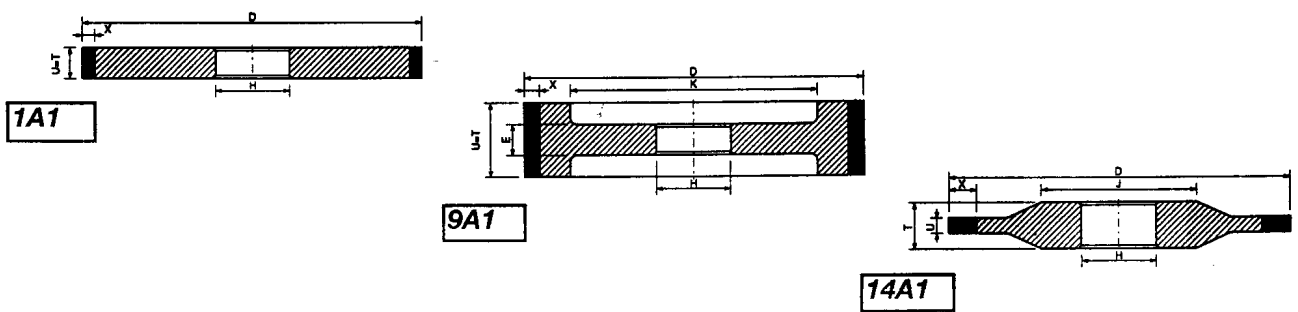
The "Olive" cut



ALTIFORT-BOART Form

L13B-D-U/R-X-Specification-H/T-J or E-K – FEPA 1FF1, 9FF1, 14FF1

The "Flat" cut



ALTIFORT-BOART Form

L10A-D-T-X-Specification-H

FEPA 1A1

L10H-D-T-X-Specification-H/E-K

FEPA 9A1

L10B-D-U-X-Specification-H/T-J

FEPA 14E1

Recommendations

Cutting type		Grit	Concentration
Fine	« matt »	MD25B – D46	40 → 80
	« high gloss »	D39 – D54	40 → 80
Medium		D39 – D54	40 → 80
Deep	rough	D91 – D181	30 → 50
	semi-finishing	D64 – D91	40 → 50
	finishing	D39 – D46	40 → 60

