SHARP, WEAR-RESISTANT, LONG-LASTING

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YELDA KNIFE

Focus on metallurgical industry

Slitter knife
Rubber spacer
Spacer
Seperator discs

CHINA · YELDA

www.yeldaknife.com

PROCESS EQUIPMENT

About Yelda

Yelda knife a leading manufacture of knife for steel coil slitting industry, with 20 years experience .We win good name and established long lasting coorperation with overseas customers , providing high precision slitter knife for customers.

Our products including slitting knife, spacers, rubber spacers, seperator discs. Serve for steel mills ,metallurgical plants , steel coil slitting company .

Yelda knife only choose high quality raw steels and advanced manufacturing techniques to produce knife, our slitting knife achieving thickness tolerance +/-0.001mm flatness and parallelism of 0.002mm, our rubber spacers have long lasting working performance.

At Yelda knife , we are committed to provide excellent service to our customers on the basis of high quality knife.

Choose Yelda knife, choose the best quality knife !

YELDA KNIFE

SLITTER KNIFE

Thickness tolerance +/-0.001mm
OD tolerance +/-0.1mm
ID Tolerance 0/+0.02mm

- Thickness tolerance +/-0.001mm; OD tolerance +/-0.1mm; ID Tolerance 0/+0.02mm; Flatness 0.002; Parallelism; 0.002; ESR Purified Raw Material.

Sharp, wear-resistant, long-lasting

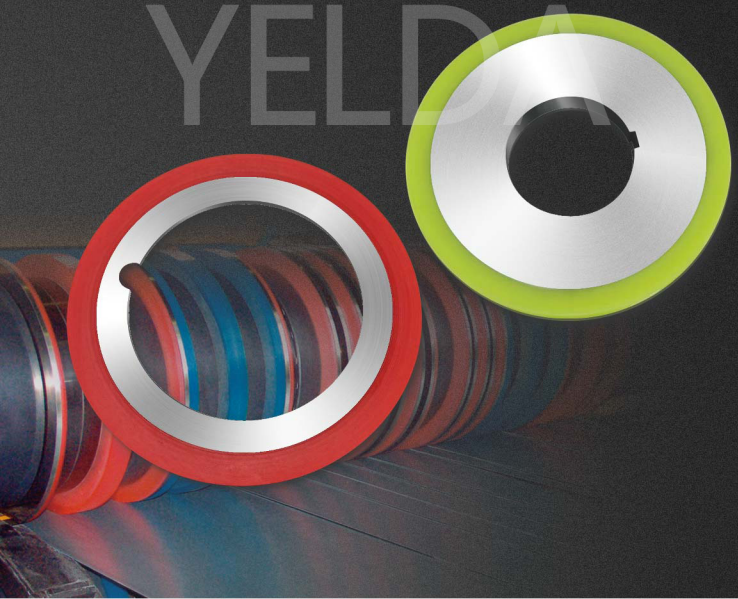
Material Selection of Blade

Type of material to be cut		Thickness of material to be cut				
		< 0.6mm	< 1.5mm	< 3.0mm	< 6.0mm	> 6.0mm
Cold-rolled material		LS11 LS53 LS51	LS11 LS53	LS11 LS53 LS7	LS7 LS6 LS13	LS7 LS13
Hot-rolled material				LS7 LS6	LS7 LS6 LS13	LS7 LS13
Electrical Steel	Oriented	LS5 LS53 LS51	LS7 LS5			
	Unoriented	LS51 TCT	LS51 LS5 LS42			
Stainless steel		LS7 LS5 LS53	LS7 LS53	LS7 LS6	LS7 LS6 LS13	LS7 LS13
Copper, Aluminum, Foil tape		LS7 LS11 LS51	LS11 LS5 LS53	LS11 LS53 LS7	LS13 LS53 LS7	LS7 LS13
Hardened strip		TCT LS23 LS42 LS51	LS5 LS53 LS51			

YELDA KNIFE

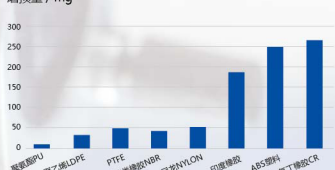
RUBBER SPACER

- There are two types of live rubber rings (two-color rings): composite rubber rings and pure rubber rings. Composite rubber rings are made of low-hardness rubber or polyurethane on the outside and high-hardness rubber or polyurethane on the inside. Pure rubber rings are made of single polyurethane and rubber. Different processing materials use different rubber rings and hardness.
- They are generally suitable for products with low shearing accuracy requirements. They need to have good elasticity such as oil resistance, wear resistance, acid and alkali resistance, and heat expansion resistance. The hardness range is generally between 70-95°C on Shore A.
- Due to the many varieties of rubber and polyurethane, users can formulate rubber rings of different qualities, hardness, colors, and outer diameters according to product requirements.



Shore hardness and quality customized to your application

Comparison of wear resistance of polyurethaneand other materials



被切材料种类 Type of material to be cut	聚氨酯 PU	丁腈橡胶 NBR
冷轧材料 Cold-rolled material	○	√
热轧材料 Hot-rolled material	○	√
电工钢 Electrical steel	√	○
不锈钢 Stainless steel	√	○
铜、铝、箔带 Copper, Aluminum, Foil tape	√	×

√推荐 recommend ○可选 optional ×不推荐 not recommend

YELDA KNIFE

SPACER

Thickness tolerance +/-0.001mm
OD tolerance +/-0.1mm
ID Tolerance 0/+0.02mm

- Carbon steel (Hot /Cold Rolled / Galvanized)
  Stainless steel, High strength steel, Magnetic steel, Aluminium, Copper, Brass.

Material Selection of Blade

Type of material to be cut		Thickness of material to be cut				
		< 0.6mm	< 1.5mm	< 3.0mm	< 6.0mm	> 6.0mm
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Electrical Steel	Oriented	LS5 LS53 LS51	LS7 LS5			
	Unoriented	LS51 TCT	LS51 LS5 LS42			
Stainless steel		LS7 LS5 LS53	LS7 LS53	LS7 LS6	LS7 LS6 LS13	LS7 LS13
Copper, Aluminum, Foil tape		LS7 LS11 LS51	LS11 LS5 LS53	LS11 LS53 LS7	LS13 LS53 LS7	LS7 LS13
Hardened strip		TCT LS23 LS42 LS51	LS5 LS53 LS51			

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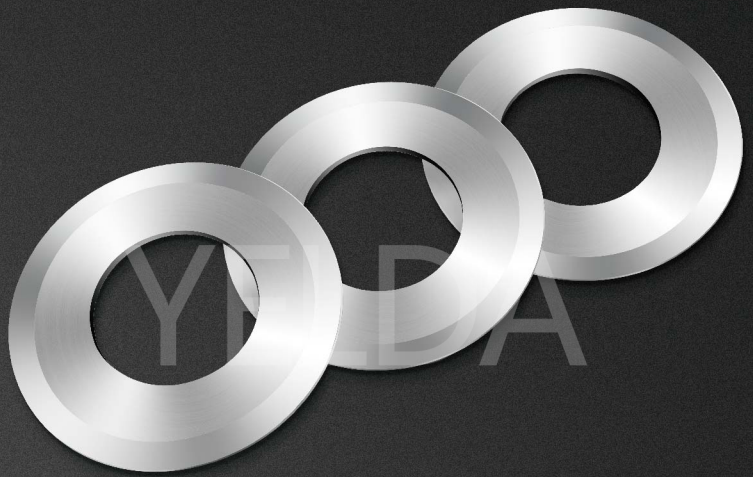
SEPERATOR DISCS



金属卷材裁切时上下圆刀之间水平间隙的选择十分重要

It is very important to choose the horizontal gap between the upper and lower slitting blades to cut metal coil

被切材料品种	抗拉强度	间隙占厚度百分比%
Type of material to be cut	Tensile Strength/MPa	Gap as a percentage of thickness
软态铝、铜、黄铜 Soft aluminum, copper, brass	≤100	3～5
软态钢和铜合金、硬铝 Soft steel and copper alloys, duralumin	≤240	10
中硬钢、软态不锈钢 Medium hard steel, soft stainless steel	≥420～620	12～14
不锈钢、高合金钢 Stainless steel, high alloy steel	≥700～1310	14～25

各种毛刺状态和解决问题方向

Various Burr States and Directions for Solving Problems

毛刺情况 Burr condition	解决问题方向 Direction of problem solving
所有板带的毛刺都完全没有规律 The burrs on all the strips are completely irregular	分别检查分条机和刀具的精度 Check the accuracy of slitting machine and cutting tool respectively
逢单数或逢双数的板条剪不下来 odd or even number of strips cannot be cut off	分条机轴肩错位大，第一间隙不好 Slitting machine shaft shoulder dislocation is large, the first gap is not good
板带两边的毛刺有规律的一边一个样 The burrs on both sides of the strip are the same on the regular side	分条机轴肩错位，或第一间隙不好 Splitter shoulder dislocation, or the first clearance is not good
整条板带在长度方向，有毛刺时好时坏 The whole strip has burrs in the direction of length	刀轴轴肩跳动大，刀片平行度差 Pilsaution of shaft shoulder is large,blade parallelism is bad
裁切多条板带时，有规律地有的板带毛刺好，有的差 When cutting multiple plates, some plates with burrs are good and some are bad regularly	刀片累计误差大，或刀上有锈斑 The accumulated error of the blade is large, or there are rust spots on the blade
所有板带两侧毛刺都有规律地过大 The burrs on both sides of all strips are regularly too large	刀片间隙选择过大 Gap of blades is too large
所有板带两侧边部都有规律的出现挤压状 Both sides of all strips are regularly squeezed	刀片间隙选择过小 Gap of blades is too small

碳素钢钢板厚度和刀片重叠量的关系

Relationship Between Carbon Steel Plate Thickness and Blade Overlap