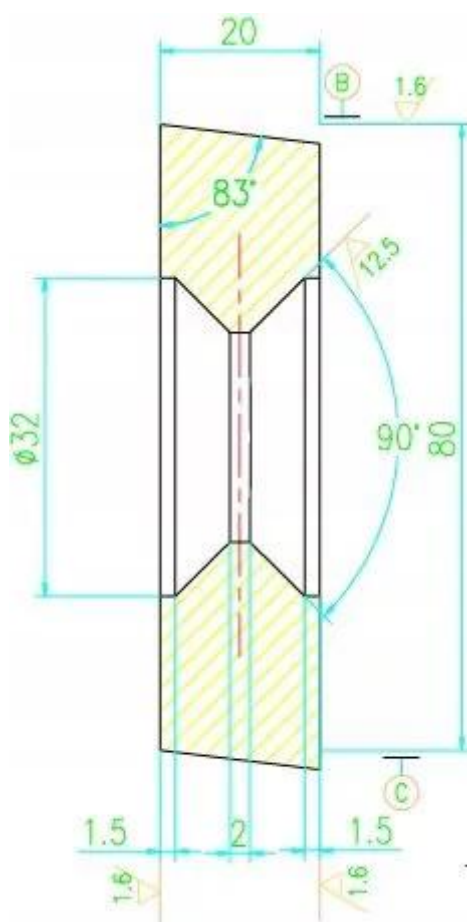


6x4000 mm upper guillotine blades for NG4 hydraulic 4-way shears – replacement





Upper blade for 6x4000 hydraulic guillotine – 9CrSi tool steel

Hardness HRC 55–60

Characteristics and intended use of the 6x4000 bottom knife

Digima presents a high-performance upper (movable) blade, designed specifically for the most demanding cutting systems with 6x4000 specifications. This is a key cutting element which, by moving along the guide rails of the cutter beam, ensures a precise and clean cut of sheet metal across the entire working width of 4000 millimetres. Our Digima product features a robust construction, capable of withstanding the extreme loads encountered when cutting materials up to 6 millimetres thick.

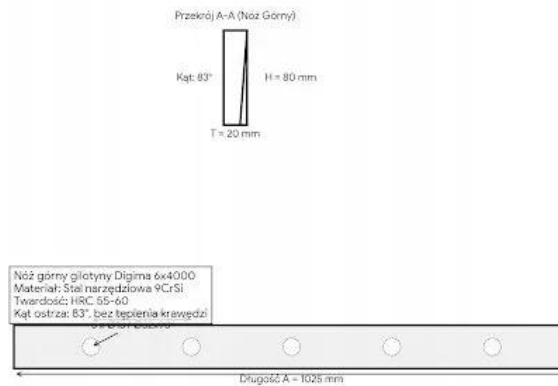
Detailed technical specifications of the Digima top blade:

- **Blade type:** Top blade (movable blade/beam-type).
- **Intended use:** Industrial guillotine shears with a cutting capacity of up to 6 millimetres in thickness and 4000 millimetres in width.
- **Length of a single segment (A):** 1,025 millimetres.
- **Set configuration:** A full 4-metre-wide cutting line consists of four precisely matched Digima segments.



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RYSUNEK TECHNICZNY DIGIMA - NÓŻ GÓRNY 6x4000



Analysis of the technical specifications of the Digima 6 top blade for the 4000 model

The upper blade in the 6/4,000 system has been designed to maintain the highest cutting precision whilst withstanding the enormous cutting forces required for machining sheet metal six millimetres thick. Below is a detailed summary of the technical parameters shown in the drawing:

- **Geometry and Design Dimensions:**

Segment length: This is exactly one thousand and twenty-five millimetres. A full set for a machine with a working width of four thousand millimetres consists of four such Digima segments.

Profile height: The blade is eighty millimetres high.

Blade thickness: The blade is twenty millimetres thick, which ensures stability when cutting thick sheets.

Cutting edge angle: Precisely ground to an angle of eighty-three degrees, which facilitates penetration of the material and reduces resistance during machine operation.

- **Digima Mounting System:**

Number of holes: Each segment is fitted with five mounting holes.

Axial hole spacing: Exactly one hundred and eighty-five millimetres between the centres of the holes.

Hole diameter: Through-holes with a diameter of eighteen millimetres.

Screw sockets: These feature countersinks with a diameter of thirty-two millimetres, allowing the screw head to be completely concealed beneath the blade's surface.

- **Material and Manufacturing Properties:**

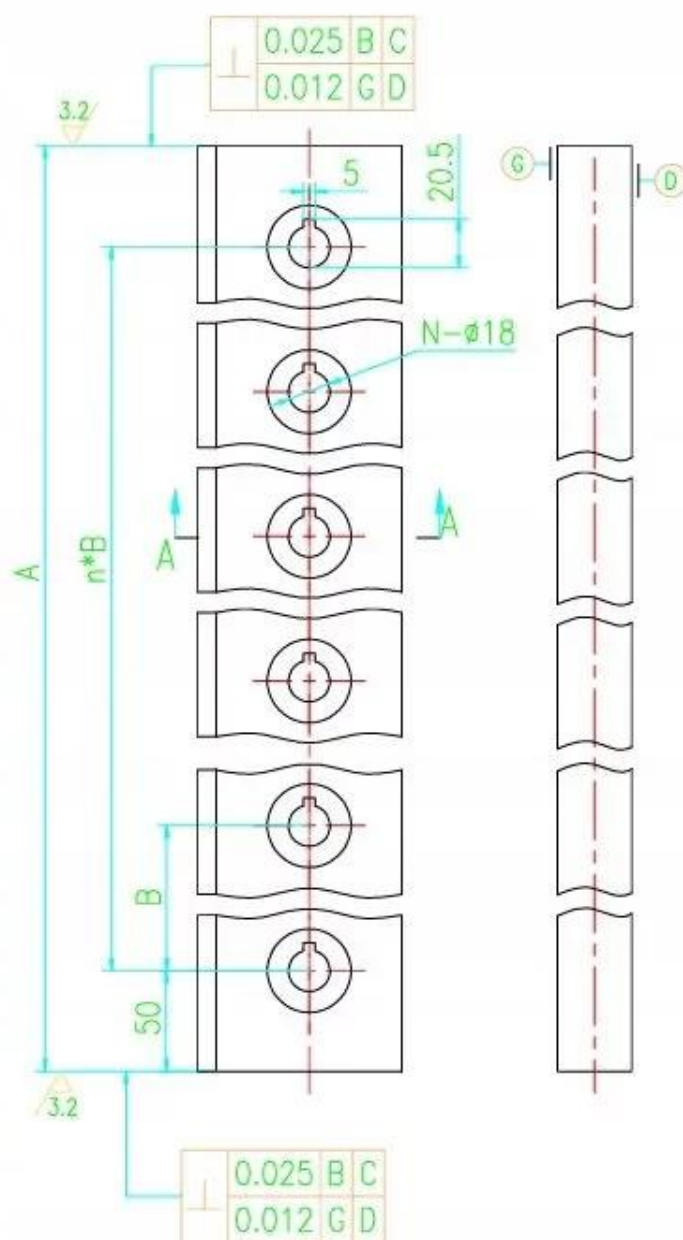
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Material grade: High-alloy tool steel 9CrSi.

Working hardness: Between fifty-five and sixty HRC.

Surface finish: The cutting edge is ground to a sharp point, and the specifications strictly prohibit it from being blunted or rounded off.

Quality control: Components undergo non-destructive testing to eliminate internal defects in the steel.





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9CrSi high-alloy tool steel and the durability of Digima

At Digima, we make no compromises when it comes to materials. The 6x4000 model is made from high-alloy silicon-chromium tool steel designated **9CrSi**. This steel is characterised by excellent dimensional stability and extreme resistance to abrasion and blunting, which is essential for intensive machining of steel sheets. Thanks to an advanced hardening process, Digima blades maintain their performance characteristics throughout a very long service life.

Material properties and quality processes:

- **Steel grade:** Specialised 9CrSi tool steel with high hardenability.
- **Hardness after heat treatment:** A stable range of 55 to 60 HRC on the Rockwell scale.
- **Heat treatment:** A complete annealing and hardening process ensuring a uniform material structure throughout the entire cross-section of the blade.
- **Consistency guarantee:** Every Digima segment undergoes rigorous non-destructive testing to rule out any internal defects.

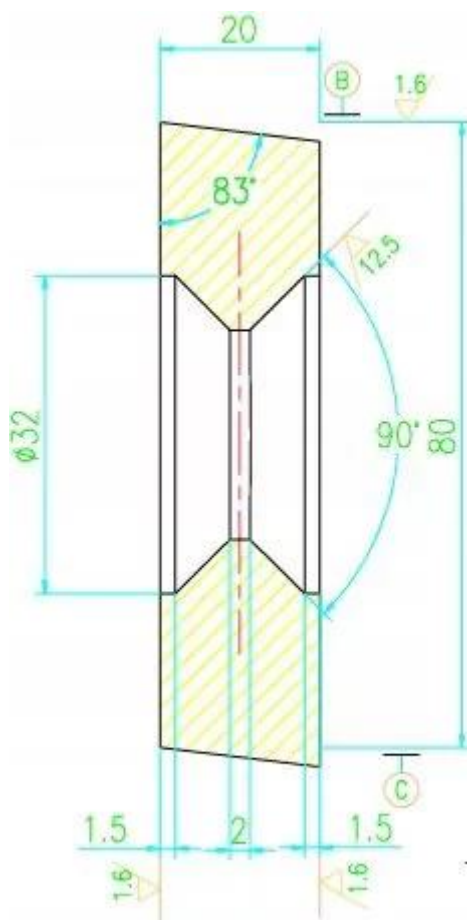
Digima assembly engineering and geometric precision

Every component of the Digima top blade has been designed to facilitate its correct installation and calibration of the cutting gap. The special blade geometry, ground at an angle of 83 degrees, allows for progressive penetration into the material, which significantly reduces the load on the machine's hydraulic system. The system of mounting holes ensures the blade fits perfectly against the guillotine beam, eliminating the risk of vibration when operating under maximum load.

Fitting and dimensional parameters:

- **Number of mounting holes (n):** 5 holes per 1025 mm segment.
- **Axial spacing of holes (B):** Exactly 185 millimetres between the centres of adjacent holes.
- **Hole diameter:** 18 millimetres, suitable for standard N-type fixing bolts.
- **Recesses for screw heads:** Special milled recesses with a diameter of 32 millimetres, allowing the fasteners to be completely concealed within the blade body.

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Cutting performance and professional service from Digima

Digima 6x4000 top blades are characterised by a robust cross-section, which is essential for maintaining a straight cutting line when processing 6 mm sheet metal. The blade is ground to the highest precision and, in accordance with technical standards, must not become blunt or have its edges rounded – it must remain perfectly sharp to ensure a clean cut without burrs. As Digima, we offer not only the product but also full technical support, including professional blade replacement at the customer's premises.

Dimensions and quality requirements:

- **Blade thickness:** A solid 20 millimetres to ensure maximum rigidity under load.
- **Blade height:** 80 millimetres, guaranteeing resistance to bending forces.
- **Cutting edge angle:** A precise 83 degrees for easier piercing of sheet metal.

Please note that not only can you purchase top-class cutting components from our company, but we also offer a **professional blade replacement service**.