



Chemical method to remove the hard alloy of cutting tool

Using chemical method to make kinds of brazed carbide tool bits lossing, which could recycle the scrip carbide cutter, and reuse by welding on the new tool rod.

Removing copper liquid:

Chromium anhydride (Cr_2O_3) (300 ~ 350 g/L), phosphoric acid (H_3PO_4) g/L (70 ~ 85), and the rest is water.

Method:

Using kerosene to soak brazing tool for 1 h, smeary clean on the cutting tool. After finishing oil tool, put them into removing copper liquid and heat till (70 ~ 80) °C.

After two or three days later, the cutter bar will break away with the cutter head. The soaking time depends on the size of the cutter. Then take out the knife and blade, leave them into water and wash away the chromic anhydride. So, the cutter arbor could still using by welding new head.