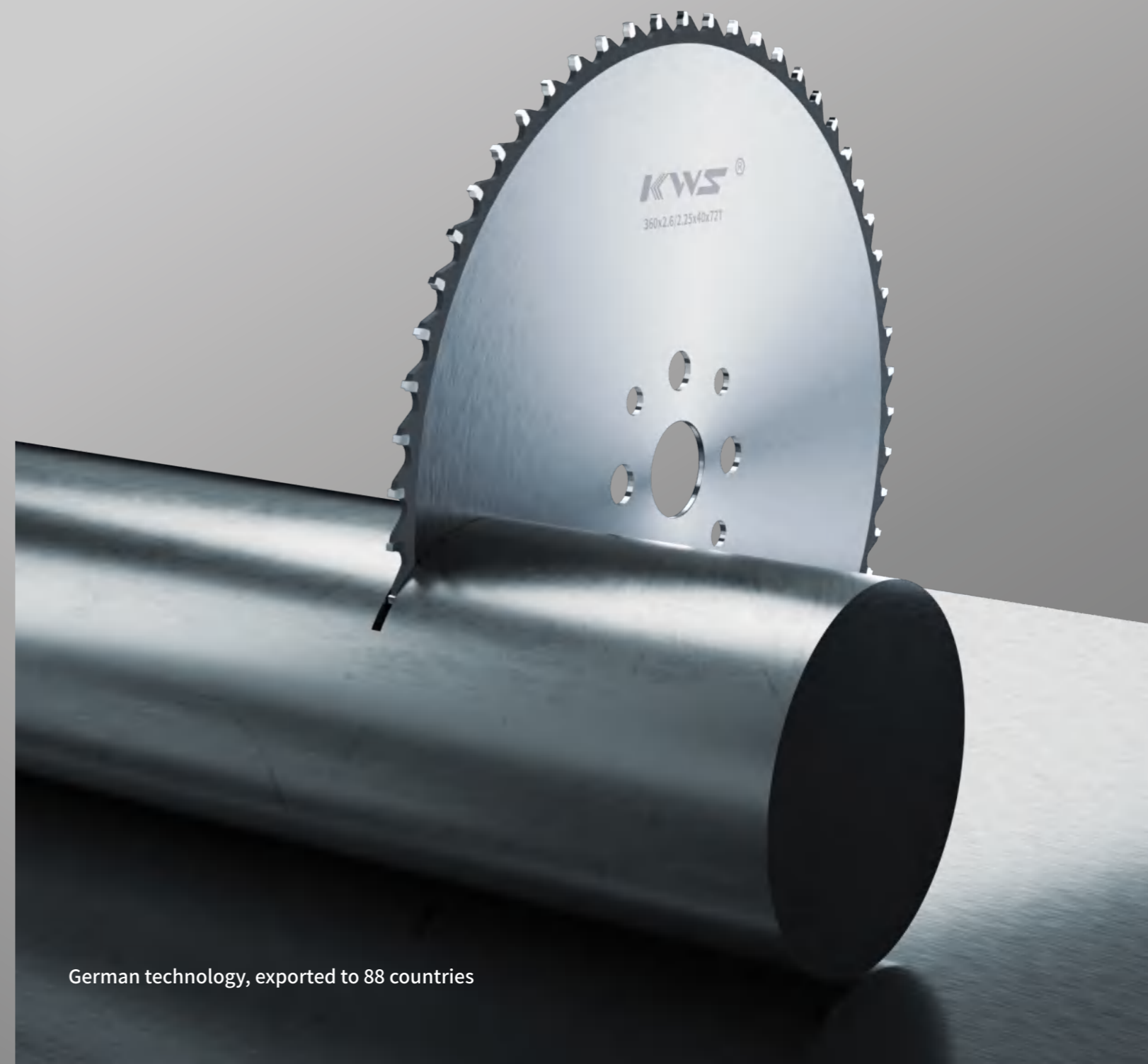
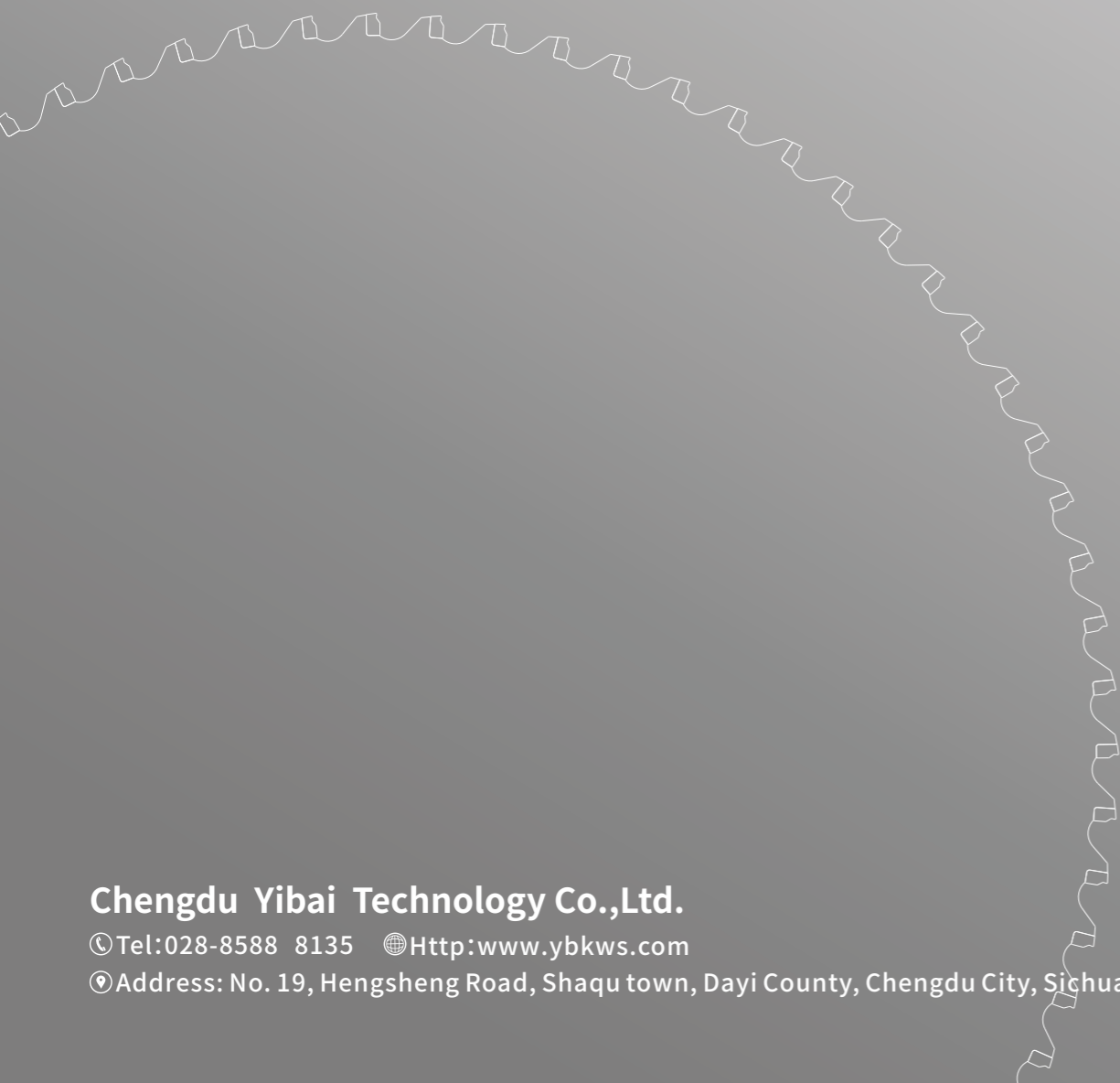




COLD SAW BLADE SERIES NO VIBRATION, STRAIGHT CUTTING

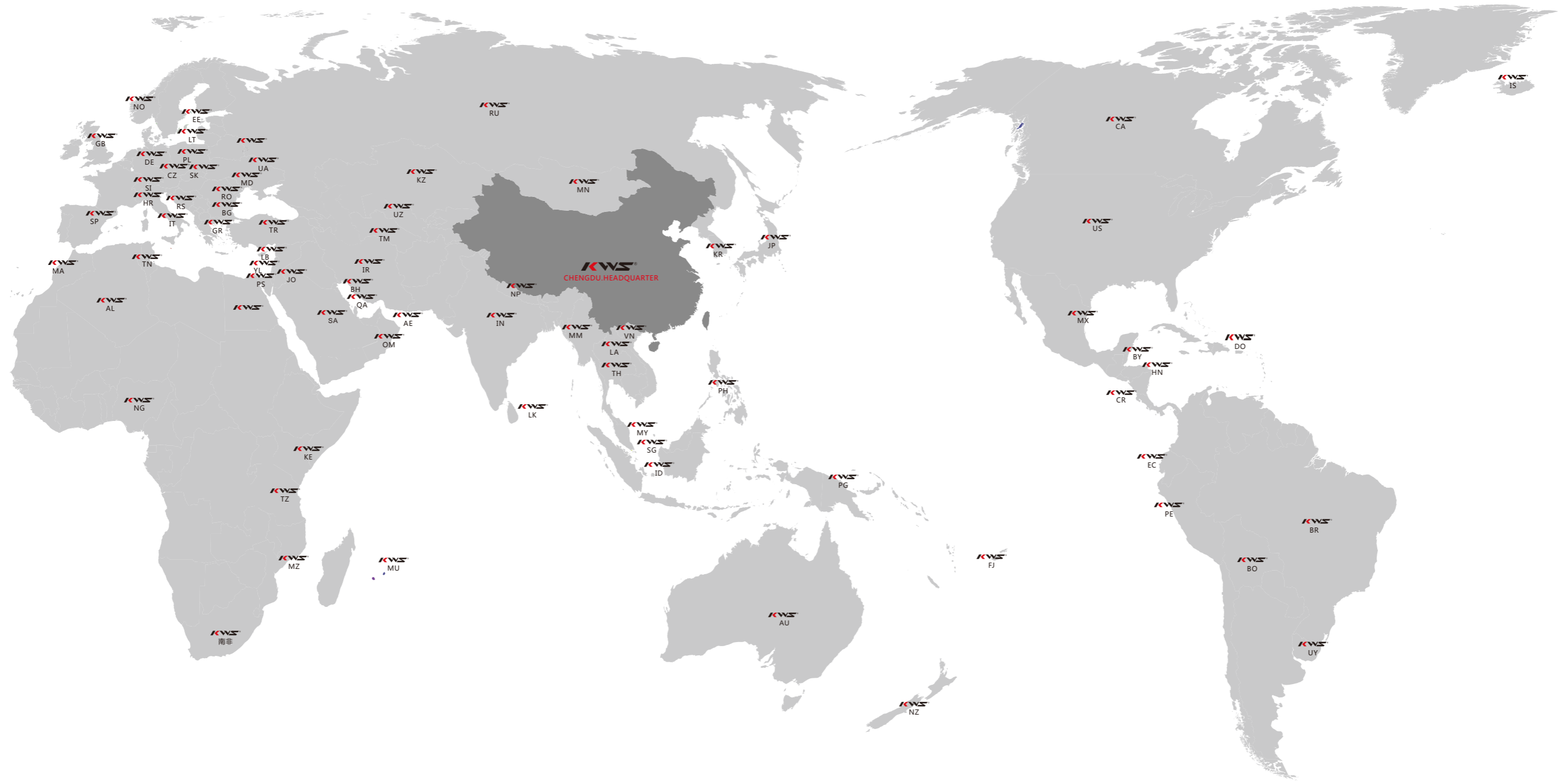


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German technology, exported to 88 countries

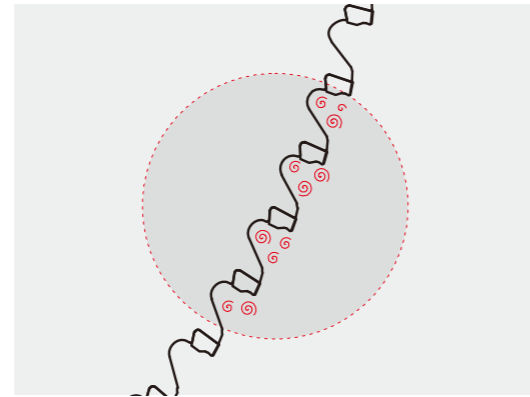


German technology, exported to 88 countries

Cold saw for medium and low carbon steel cutting



•Teeth shape•



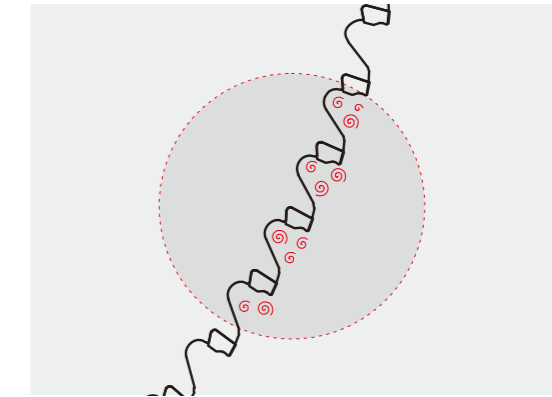
•Characteristics•

- 1.Cermet alloy teeth
- 2.Special angle design
- 3.Perfect straight cutting
- 4.Mirror surface
- 5.Durable

Cold saw for high carbon steel cutting



•Teeth shape•



•Characteristics•

- 1.Customized steel plate with rare alloy
- 2.Cermet alloy teeth
- 3.Special angle design
- 4.Perfect straight cutting Mirror surface
- 5.Durable

Production Information

Application	For medium and low carbon steel cutting
Equipment	High precise cold saw machine
RPM	V=100-130m/min
The amount of cut per tooth	Bar FZ=0.04-0.09 Tube FZ=0.03-0.06
Material	C≤0.45% Carbon steel
Tips	Cermet alloy
Features	1.Cermet alloy teeth 2.Special angle design 3.Perfect straight cutting 4.Mirror surface 5.Durable

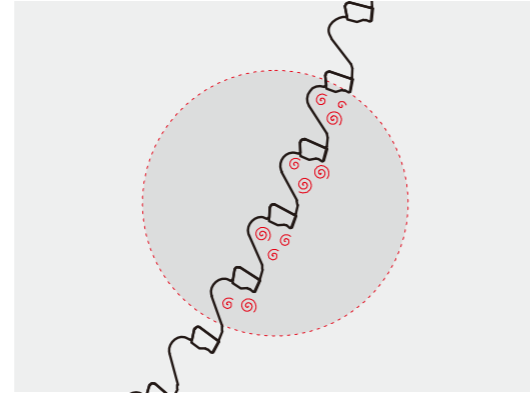
Production Information

Application	For high carbon steel cutting
Equipment	High precise cold saw machine
RPM	V=70-100m/min
The amount of cut per tooth	Bar FZ=0.04-0.07 Tube FZ=0.03-0.06
Material	C≤0.75% Carbon steel, Alloy steel
Tips	Cermet alloy
Features	1.Customized steel plate with rare alloy 2.Cermet alloy teeth 3.Special angle design 4.Perfect straight cutting Mirror surface 5.Durable

Cold saw for pipes cutting

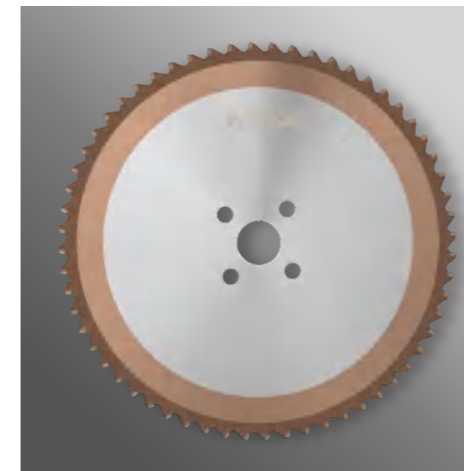


• Teeth type •

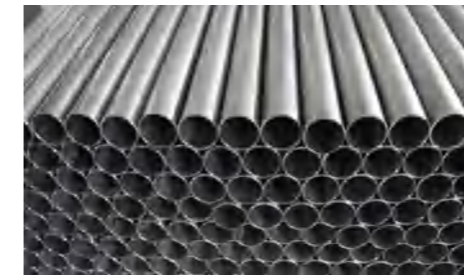
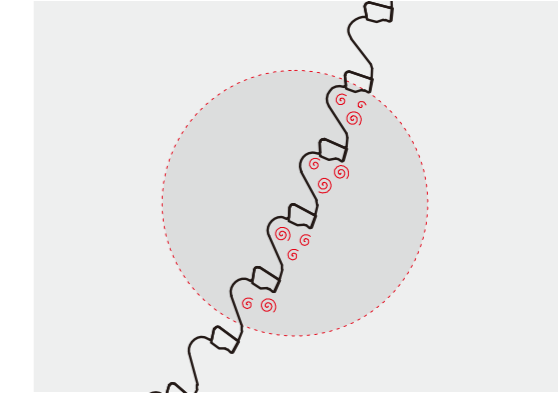


- Characteristics •
- 1.Special anti-vibration teeth
 - 2.Special angle design
 - 3.Little resonance
 - 4.Strong impact resistance
 - 5.Reliable performance

Cold saw for stainless steel cutting



• Teeth type •



- Characteristics •
- 1.PVD coating
 - 2.Clean cutting
 - 3.High wear resistance coating surface
 - 4.Durable



Production Information

Application	For pipes cutting
Equipment	High precise cold saw machine
Recommended linear velocity	SZ=0.040mm--0.070mm
Material	Tubular materials, stainless steel excluded
Tips	Cermet alloy
Features	<ol style="list-style-type: none"> 1.Special anti-vibration teeth 2.Special angle design 3.Little resonance 4.Strong impact resistance 5.Reliable performance

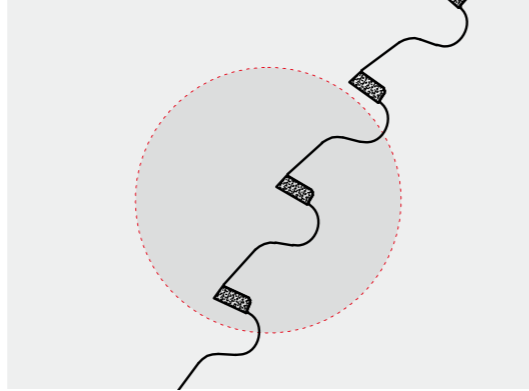
Production Information

Application	For stainless steel cutting
Equipment	High precise cold saw machine
The amount of cut per tooth	FZ=0.03mm--0.050mm
Material	SUS304 stainless steel
Tips	Cermet alloy+PVD coating
Features	<ol style="list-style-type: none"> 1.PVD coating 2.Clean cutting 3.High wear resistance coating surface 4.Durable

Cold saw for manual device

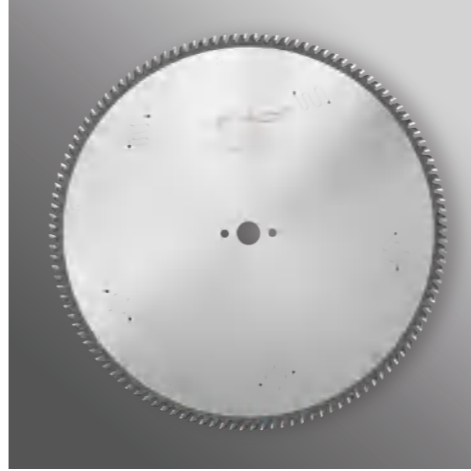

• Teeth shape •



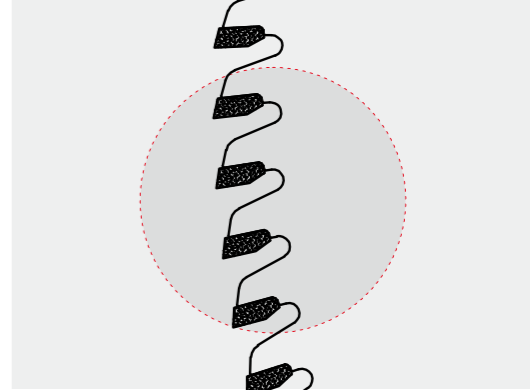
• Characteristics •

- 1.Low cost
- 2.Convenient and flexible cutting
- 3.High cutting performance and difference

TCT saw for aluminum cutting

• Teeth shape •



• Characteristics •

- 1.Professional silence line design
- 2.Low cutting noise
- 3.Smooth cutting without burr
- 4.Durable

Production Information

Application	For various middle&low carbon steel cutting
Equipment	Portable circular saw machine
RPM	N=700rpm--1300rpm
Cutting Material	Channel steel, angle steel, rectangular tube, steel rod, copper and copper alloys, aluminum and aluminum alloys, aluminum-wood composite materials, etc. (excluded stainless steel)
Tips	Cermet alloy
Features	<ol style="list-style-type: none"> 1.Low cost 2.Convenient and flexible cutting 3.High cutting performance and difference

Production Information

Application	For all kinds of aluminum material cutting
Application	Manual device, mitre saw, CNC center
RPM	FZ=0.03mm--0.050mm
Cutting Material	Plastic steel, aluminum profile aluminum bar, non-ferrous metal, etc.
Tips	TCT, PCD
Features	<ol style="list-style-type: none"> 1.Professional silence line design 2.Low cutting noise 3.Smooth cutting without burr 4.Durable

Installation Guide



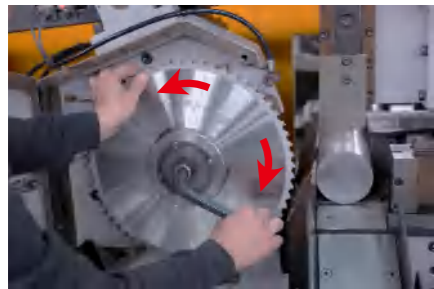
1 A: Saw blade must be mounted at the correct direction
B: Always clean the surface of the plate before mounting to the arbor of machine



2 Flange must be free from scratches and wiped clean.



3 The cover of flange must be free from scratches and wiped clean.



4 When locking, the saw blade and flange must be in different direction to get rid of the gaps between them.



5 The length of work piece should not be shorter than 20mm. Otherwise, the saw blade will be broken.

Safety Use And Maintenance Guide

- 1、 The machine must be in good condition, free of vibrations.
- 2、 The flanges used to secure the blade must be of the same diameter, at least 1/3 of the blade's diameter, and the flanges must be parallel to each other.
- 3、 The spindle must be perfectly straight and with an h7 standard tolerance.
- 4、 Before install the blade, the flange, spindle and blade must be cleaned. After continuous use, remove the blade and clean it again.
- 5、 Before cutting process, make sure the blade is correctly locked and the size is comply to the machine's requirement.
- 6、 The blade must be resharpened as soon as it becomes dull, when the carbide tips thickness is less than 0.5mm, don't re-sharpen and use it.
- 7、 The Maximum re-boring size can't exceed 20mm base on original bore size. Exceeding this value will lead to abnormal work and overall performance will be affected.

Cutting Amount And Cutting Speed

Cutting Amount Per Tooth(fz)

$Fz(\text{mm/blade})=F/N*Z$
Fz: the amount of cut per tooth
F: feed speed (mm/min)
N: Equipment spindle speed (rpm)
Z: number of teeth

Recommended Parameters

Bar Fz=0.04~0.07(mm/blade)
Pipe Fz=0.03~0.05(mm/blade)

Cutting Speed (saw Blade Line Speed) (v)

$V(\text{m/min})=\pi*D*N/1000$
V: cutting line speed (m/min)
D: outer diameter (mm)
N: Equipment spindle speed (rpm)

Recommended Parameters

Medium and low carbon steel V=100~130(m/min)
High carbon, alloy steel V=70~100(m/min)

Guidance

Specification

Pin Hole/pin Hole				Bore
4/9/50	4/11/63			32.00
4/11/63	4/11/90	2/12/65	2/15/80	40.00
4/11/90	4/16/80	4/21/90		50.00

Diameter (mm)	No. of Teeth (mm)	Cutting Material Thickness(mm)																																							
		0	10	15	20	25	30	35	40	45	50	55	60	65	70	75	80	85	90	95	100	105	110	115	120	125	130	135	140	145	150	160	165	170	175	180					
250	54																																								
	60																																								
	72																																								
285	60																																								
	72																																								
	80																																								
360	60																																								
	80																																								
	100																																								
425	60																																								
	80																																								
	100																																								
460	40																																								
	60																																								
	80																																								
560	60																																								
	80																																								
	100																																								

Tips

- 1. The cold saw can be reground to prolong the service life of the saw blade.
- 2. The unique design of tooth profile has fine cutting quality and high cost performance.
- 3. Different tooth angles are designed for different cutting materials.
- 4. The company provides regrinding services.



Specification And Model

NO	Type	D	d	B	Z
01	250*32*2.0*54	250	32	2.0	54
02	250*32*2.0*60	250	32	2.0	60
03	250*32*2.0*72	250	32	2.0	72
04	250*32*2.0*80	250	32	2.0	80
05	250*32*2.0*100	250	32	2.0	100
06	250*32*2.0*120	250	32	2.0	120
07	285*32*2.0*54	285	32	2.0	54
08	285*32*2.0*60	285	32	2.0	60
09	285*32*2.0*80	285	32	2.0	80
10	285*32*2.0*100	285	32	2.0	100
11	285*32*2.0*120	285	32	2.0	120
12	315*32*2.25*60	315	32	2.25	60
13	315*32*2.25*72	315	32	2.25	72
14	315*32*2.25*80	315	32	2.25	80
15	315*32*2.25*100	315	32	2.25	100
16	315*32*2.25*120	315	32	2.25	120
17	315*32*2.25*140	315	32	2.25	140
18	360*40*2.6*60	360	40	2.6	60
19	360*40*2.6*72	360	40	2.6	72
20	360*40*2.6*80	360	40	2.6	80
21	360*40*2.6*100	360	40	2.6	100
22	360*40*2.6*120	360	40	2.6	120
23	380*40*2.6*60	380	40	2.6	60
24	380*40*2.6*72	380	40	2.6	72
25	380*40*2.6*80	380	40	2.6	80
26	380*40*2.6*100	380	40	2.6	100

NO	Type	D	d	B	Z
27	400*50*2.7*50	400	50	2.7	50
28	400*50*2.7*60	400	50	2.7	60
29	400*50*2.7*80	400	50	2.7	80
30	400*50*2.7*100	400	50	2.7	100
31	425*50*2.7*40	425	50	2.7	40
32	425*50*2.7*60	425	50	2.7	60
33	425*50*2.7*80	425	50	2.7	80
34	425*50*2.7*100	425	50	2.7	100
35	460*50*2.7*40	460	50	2.7	40
36	460*50*2.7*60	460	50	2.7	60
37	460*50*2.7*72	460	50	2.7	72
38	460*50*2.7*80	460	50	2.7	80
39	460*50*2.7*100	460	50	2.7	100
40	460*50*2.7*120	460	50	2.7	120
41	485*50*2.7*60	458	50	2.7	60
42	485*50*2.7*72	485	50	2.7	72
43	485*50*2.7*80	485	50	2.7	80
44	485*50*2.7*100	485	50	2.7	100
45	520*50*3.0*60	520	50	3.0	60
46	520*50*3.0*72	520	50	3.0	72
47	520*50*3.0*80	520	50	3.0	80
48	560*50*3.0*60	560	50	3.0	60
49	630*80*3.4*60	630	80	3.4	60
50	630*80*3.4*72	630	80	3.4	72
51	630*80*3.4*80	630	80	3.4	80
52	630*80*3.4*100	630	80	3.4	100