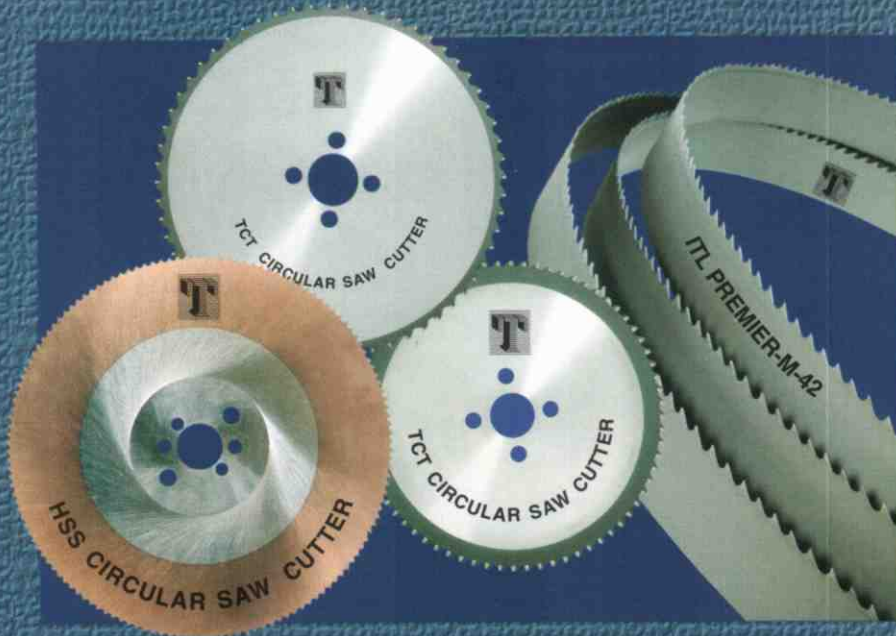


INDORE



Technology with Time



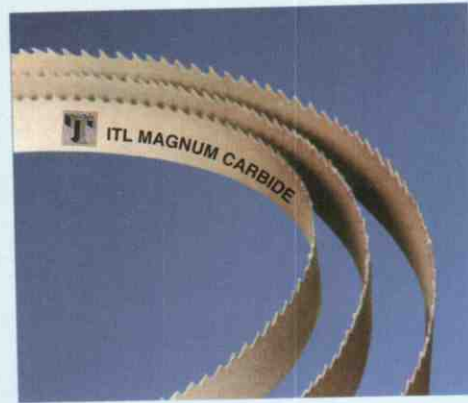
Affordable Metal Cutting Solution Provider

ITL MAGNUM CARBIDE

INDORE

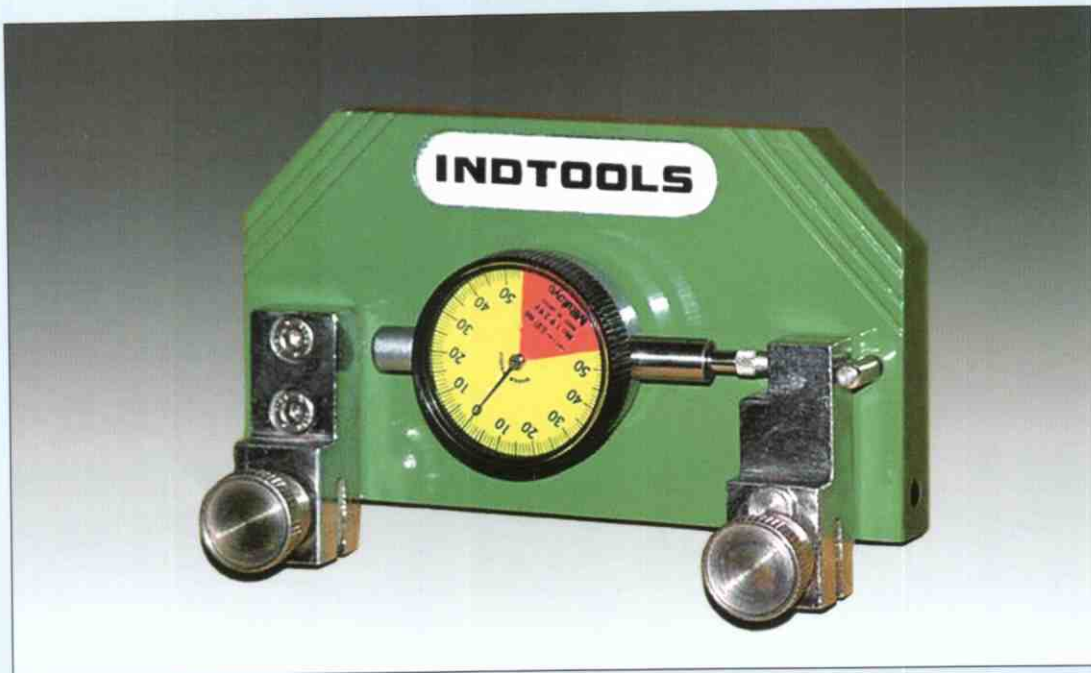
Carbide tipped bandsaw blade is essentially used for sawing tough alloys such as Cobalt, Nickel, Zirconium and Titanium based metal with extremely good surface finish. Higher cutting rates can be achieved in cutting S.S., High Alloy and Tool Steels.

Dimension in mm	Teeth per inch				Dimension in inches
	0.75/1.25	1.4/2	2/3	3/4	
20 x 0.80				X	3/4 x 0.032
27 x 0.90				X	1.1/16 x 0.035
34 x 1.10			X	X	1.3/8 x 0.042
41 x 1.30		X	X	X	1.5/8 x 0.050
54 x 1.60	X	X	X		2.1/8 x 0.063
67 x 1.60	X	X	X		2.5/8 x 0.063
80 x 1.60	X	X			3.1/8 x 0.063



Tooth Design K = Hook Tooth with positive rake angle, N = Neutral Tooth with 0° rake angle Standard pitch blades available on request.

ITL TENSION METER



Correct Band Tension is vital to ensure cut straightness. The ITL Tension Meter quickly & simply measures the exact blade tension while it is mounted on the band. Recommended pressure is provided with the machine manual. This will help to avoid off square cutting through low tension & blade breakage and machine damage through excessively high tension.

TCT CIRCULAR SAW CUTTERS T. A. TYPE

Dia.	Kerf	Plate	Bore	Standard No. of Teeth.	Standard Pin hole.
250 mm	2.0	1.7	32 mm	60,72,80,90	4-9-50,4-11-63
285 mm	2.0	1.7	32 mm	60,72,80,90	4-9-50, 4-11-63
360 mm	2.6	2.25	40 mm	60,72,80,100	4-15-80,4-12-90
460 mm	2.7	2.25	50 mm	60,72,80,100,140	4-11-90, 4-12-80
560 mm	3.0	2.5	50 mm	40,60,100,140	4-12-80, 4-11-90



ITL offers variety of TCT Circular Saw cutters for different application. Please select appropriate Grade as per your cutting requirement .

ITL "FE" for cutting Ferrous material (MS, EN - 8, Low Carbon Steel Etc.)

ITL "FE SPL" for cutting Alloy's, High Carbon Etc.

ITL "SS" for cutting Stainless Steel

ITL "NFCU" for cutting Non Ferrous materials (Copper, Brass Etc.)

ITL "AL" for cutting Aluminium

Please use ITL Micromist Oil for best results.

For any other Size, Pin Hole & Bore, No. of Teeth please contact.

CIRCULAR SAW BLADES IN HSS-M2/M35

HSS CIRCULAR SAW BLADES MADE FROM HSS M2, HSS-M35 grades

With 7 different types of coating for various applications. Used for burrfree & multiple-life performance on Tubes, Pipes, Solids of:

ALLOY STEELS, ALUMINIUM, STAINLESS STEEL, BRASS, COPPER, STEEL, TITANIUM ZIRCONIUM etc.



Diameter Ø(mm)	Thickness (mm)							Number of teeth and their shape													
								Pitch (mm)													
								T3	T4	T5	T6	T7	T8	T9	T10	T11	T12	T14	T16		
175	1.2	1.5	2.0				180BW	140BW	110HZ	90HZ											
200	1.0	1.2	1.5	1.8	2.0	2.5	200BW	160BW	130HZ	100HZ			64HZ								
210	2.0						210BW	160BW		110HZ		80HZ									
225	1.2	1.5	1.8	1.9	2.0	2.5	220BW	180BW	140HZ	120HZ		90HZ	80HZ								
250	1.2	1.6	2.0	2.5	3.0		250BW	200BW	160HZ	128HZ	110HZ	110HZ		80HZ		64HZ					
275	1.6	2.0	2.5	3.0			280BW	220BW	180HZ	140HZ	120HZ	110HZ		90HZ							
300	1.6	2.0	2.5	3.0			300BW	220BW	180HZ	160HZ	140HZ	120HZ		94HZ							
315	2.0	2.5	3.0	3.5			300BW	240BW	200HZ	160HZ	140HZ	120HZ		100HZ			80HZ	70HZ			
325	2.0	2.5	3.0				320BW	250BW	200HZ	170HZ		128HZ									
350	2.0	2.5	3.0	3.5			350BW	280BW	220HZ	180HZ	160HZ	140HZ	120HZ	110HZ		90HZ	80HZ				
370	2.5	3.0	3.5					280BW	220HZ	190HZ	160HZ	140HZ	120HZ	110HZ		100HZ	80HZ	70HZ			
400	2.5	3.0	3.5	4.0				310BW	250HZ	200HZ		160HZ		120HZ	110HZ	100HZ		80HZ			
425	2.5	3.0	3.5	4.0				320BW	260HZ	220HZ		160HZ		130HZ		110HZ		80HZ			
450	3.0	3.5	4.0					350BW		230HZ		180HZ		140HZ		120HZ		90HZ			
500	3.0	3.5	4.0	5.0					310HZ	260HZ		200HZ		160HZ		130HZ		100HZ			
525	3.5	4.0						410BW	330HZ	270HZ		210HZ		164HZ		140HZ		104HZ			
550	4.0	5.0						440BW	340HZ	280HZ		220HZ		170HZ		140HZ					
570	4.0	5.0						450BW	360HZ	300HZ		220HZ		180HZ		150HZ					
600	4.0	5.0						460BW	380HZ	320HZ		240HZ		190HZ		160HZ					

RESHARPING

Now ITL can resharpen your used cutters ranging from 250 mm to 900 mm with any Tooth Profile & Geometry by maintaining All Angles & geometry. This may bring down your per cut cost significantly so that you can compare circular saw cutting by any mode of cutting .

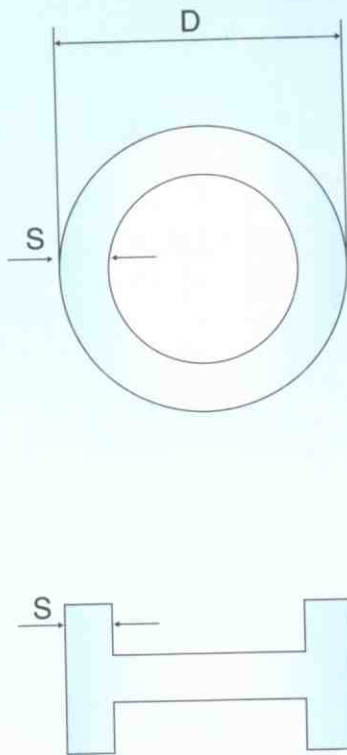
* Resharping is possible only when all Teeth & Body is intact.

TPI SELECTION CHART

INDORE

20		30		50		80		100		200		300		500		800		(mm)
10/14	8/12	8/12	6/10	5/8	4/6	4/6	3/4	3/4		2/3	2/3			1.4/2		0.75/1.25		
Toothing										Teeth/Inch (tpi)								

To Determine the Correct Toothing for Sawing Tube and Profiles



D (mm)	Tooth pitch (tpi)									
	20	40	60	80	100	150	200	300	500	
S (mm)										
2	14	14	14	14	10/14	10/14	10/14	10/14	8/12	
3	14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	6/10	6/10
4	14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	4/6	4/6
5	14	10/14	10/14	8/12	6/10	6/10	5/8	4/6	4/6	4/6
6	14	10/14	8/12	8/12	6/10	5/8	5/8	4/6	4/6	4/6
8	14	8/12	6/10	6/10	6/10	5/8	5/8	4/6	4/6	4/6
10		6/10	6/10	5/8	5/8	4/6	4/6	4/6	3/4	3/4
12		6/10	5/8	4/6	4/6	4/6	4/6	3/4	3/4	3/4
15				4/6	4/6	3/4	3/4	3/4	2/3	2/3
20				4/6	4/6	3/4	3/4	3/4	2/3	2/3
30				3/4	3/4	3/4	2/3	2/3	2/3	2/3
50						2/3	2/3	2/3	1.4/2	1.4/2
75							2/3	1.4/2	1.4/2	1.4/2
100								1.4/2	0.75/1.25	0.75/1.25
150									0.75/1.25	0.75/1.25

BREAK-IN-PROCEDURE

Life of Bandsaw Blades mainly depends on a controlled break - in. Following Feeding conditions have been tested to be favourable. By following this procedure the Life of Band Saw Blade can be increased significantly.

1. Set band speed at normal cutting speed for material being cut
2. Reduce feeds low as possible while still generating a chip (do not let blade run without creating a chip.)
3. Easy to cut material:- about 1/3 of normal feed pressure.
4. Difficult to cut material:- i.e. work hardening steels reduce it to 1/2 of normal feed pressure.
(make sure sufficient down feed so material does not work harden and damage teeth)
5. After cutting approx. 400-600 cm² turn up to normal feed.

