

CATALOG

I.T.E.C.

CUTTING SOLUTIONS

11 | 2021



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www.drytech.de

I.T.E.C. CUTTING SOLUTIONS

leading through Innovation

I.T.E.C. founded in 1994 with the aim of developing innovative, environmentally friendly concepts for the metal sawing process among others supported and awarded by the EU Life program.

Since then, our DRYTECH® TCT saw blades has been proven itself in a wide variety of fields of application.

DRYTECH® TCT saw blades stands for constant improvement of the cold sawing process for tubes and profiles in steel, stainless steel, aluminum, non-ferrous metals, as well as composite materials. All in a context of respect for the environment.

Thanks to our advanced technology, DRYTECH® TCT saw blades feature a shorter cutting cycle, cold (lubricant-free) and virtually burr-free cutting, faster cutting as well as lasting considerably lengthened blade life. We offer a wide range of blades from ø 100 to 730 mm (special dimensions on request), with up to 5 times resharping.

Our Research & Development department also provides innovative solutions, based on requested specifications, such as for example:

- DRYTECH® NSF Long Life saw blades, with a specific coating and suitable heat treatment, for cutting stainless steel (see page ..)
- DRYTECH® LBS extremely thin-walled, impact-resistant saw blades for cordless machines (see page ..)
- DRYTECH® Aurora the best solution for cutting carbon and aramid fiber reinforced plastics (see page 22)

We can adapt the geometry of the teeth according to the material to be cut and its section, which guarantees the best results in Thin-walled blades, starting from 0.5 mm thickness, to remove less material and noise reduction, thanks to laser cutting of grooves then filled with synthetic resin, is our first concern. Improving the productivity of automated or semi-automatic sawing units, as well as construction saws, will still be our primary concern in the future, while respecting the environment.

In the past we completed our product range with a line of TCT saw blades for aluminum, Throw away saw blades and HSS saw blades to fulfill the requirements of our customers.

Nikola Nestler
Managing Director

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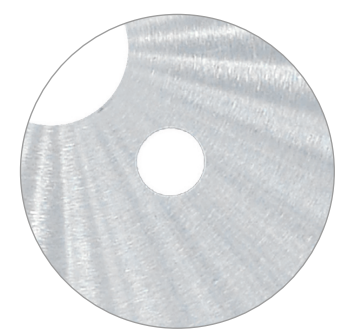
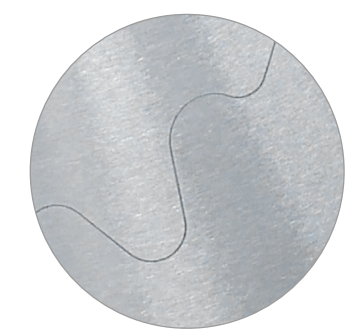
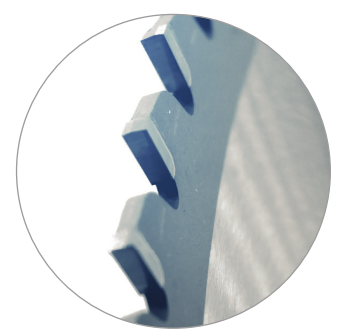
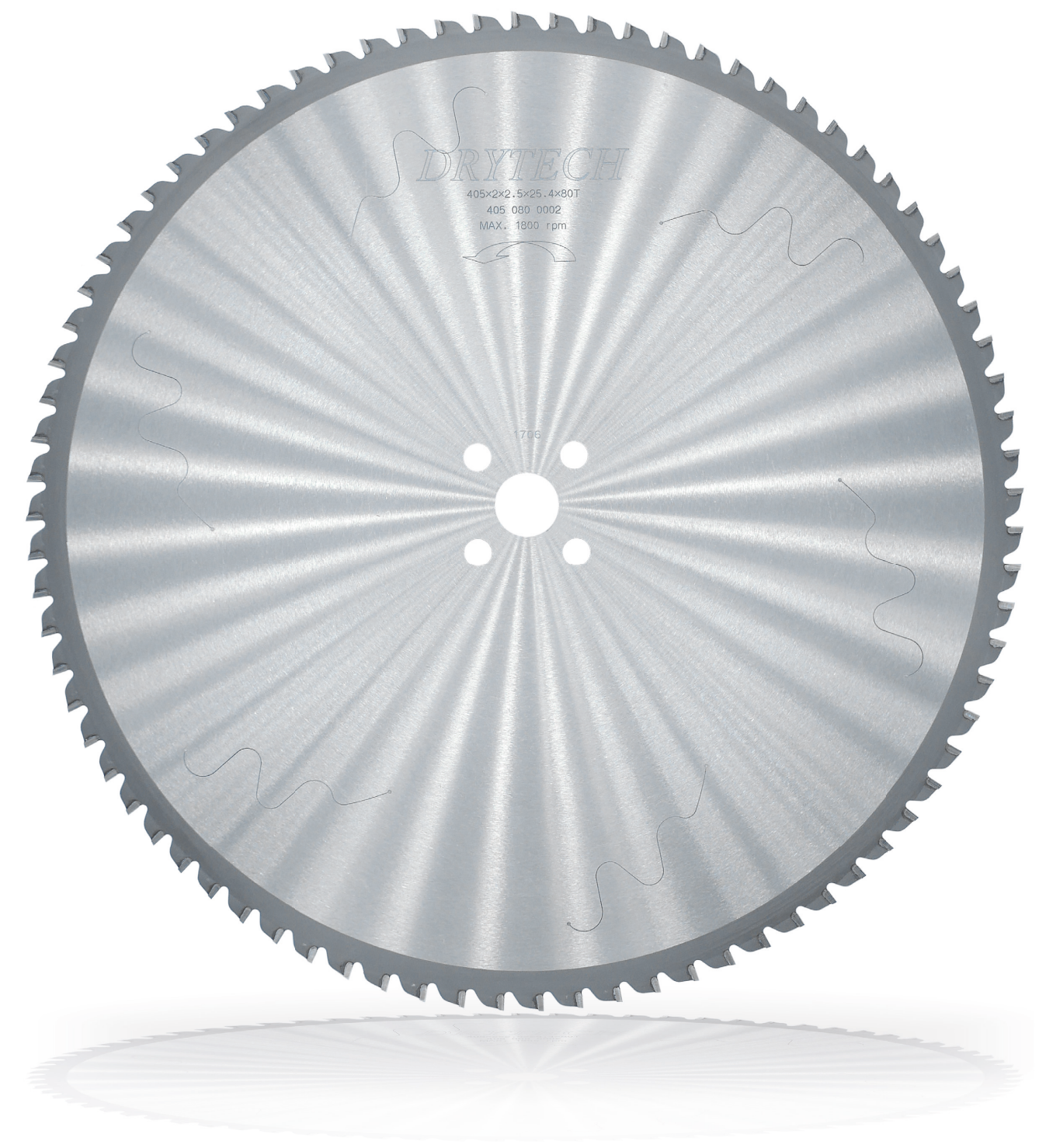
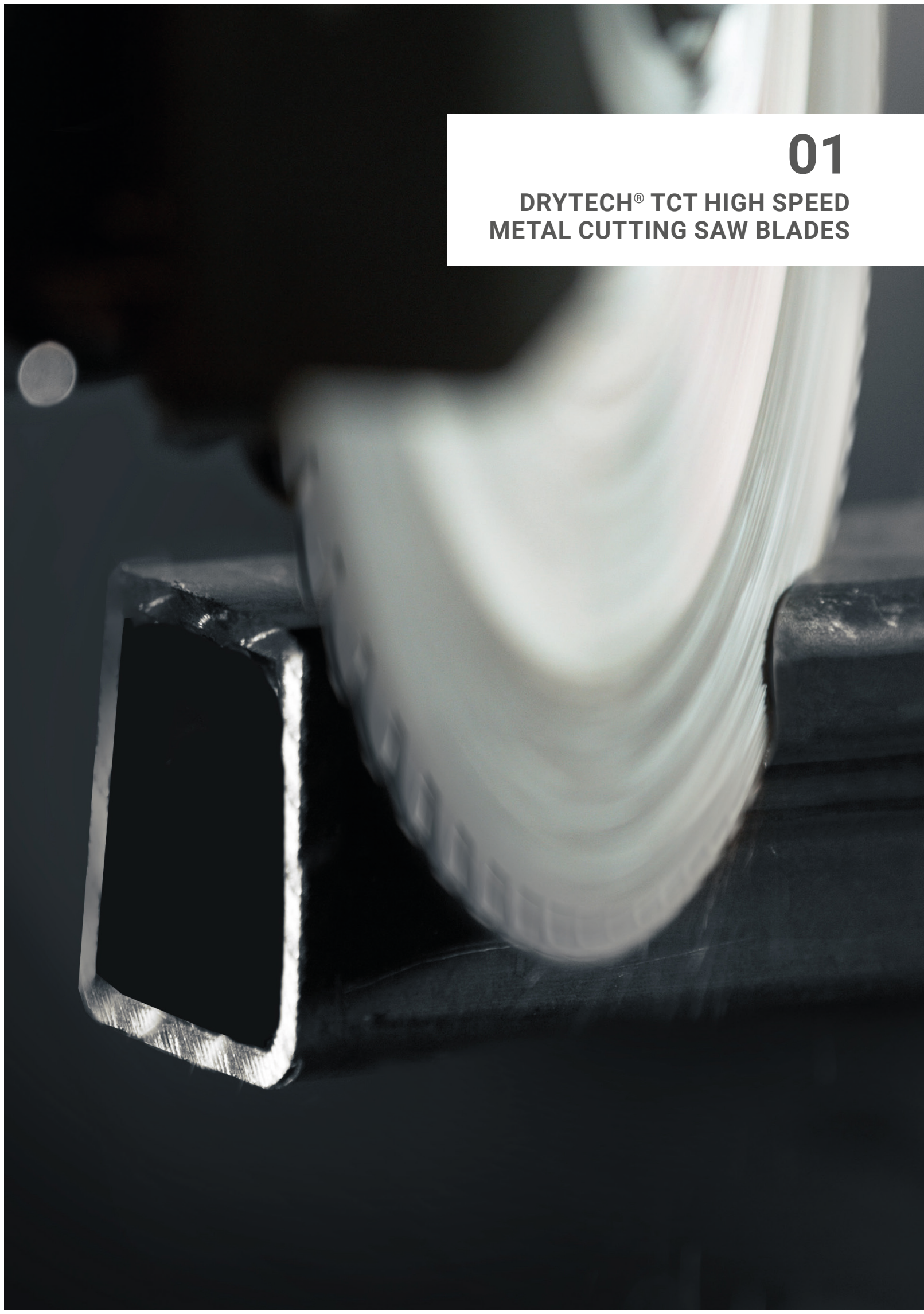
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01

DRYTECH® TCT HIGH SPEED METAL CUTTING SAW BLADES



DRYTECH® TCT HIGH SPEED METAL CUTTING SAW BLADES

environmentally friendly thanks to dry cutting technology 

Carbide or cermet tipped saw blades are suitable for high speed stationary semi-automatic and full automatic cutting units!

Fast cutting, burr free and without coolant of pipes and profiles made of:

Steel, stainless steel, plastics, composite materials, aluminum and other non-ferrous metals

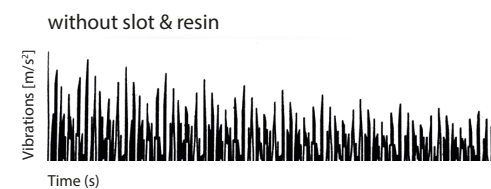
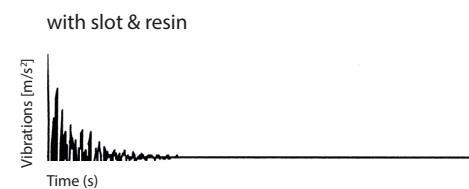
The DryTech® saw blades are able to cut diverse kinds of material and shapes due to a wide range of different geometries (trims, tubes, shutter profiles, sandwich panels, window profiles and airing profiles etc.). The special tooth shape guarantees a perfect cutting surface and a long cutting life of the blade.

- Shortest cycle times due to high cutting speed
- Material saving through thin cut technology with wall thickness starting from 0,5 mm
- Flexible application in divers materials and shapes
- Very high durability
- Excellent cutting quality
- Up to 5 times resharpenable

saw blades with excellent performance in stainless steel

Ø [mm]	Bore [mm]	Kerf [mm]	Teeth	Reference	Specifications
230	25,4	2,0	48	2300481003COA	Saw blade diameter 100 - 730 [mm]
255	25,4	2,0	66	2550661003COA	Cutting capacity Ø 6 - 240 [mm]
355	25,4	2,2	90	3550901004COA	Cutting speed max. 1.800 [m/min]
405	25,4	2,5	102	4051021003COA	Feed speed max. 6.000 [mm/min]
455	50,0	3,4	120	4551201003COA	Cutting width (kerf) 2,0 - 4 [mm]
560	50,0	3,6	132	5601321003COA	Center hole Customer specific
					Pin holes Customer specific

noise reduction due to laser slots with resin.



DRYTECH® TCT HIGH SPEED METAL CUTTING SAW BLADES

range of carbide-tipped saw blades

Ø [mm]	Bore [mm]	Kerf [mm]	Teeth	Reference	Application
100	20	1,0	40	DTS1002040	thin steel
100	20	1,6	22	DTS1002022	steel
100	20	2,5	26	DTS1002026	steel
110	20	1,6	24	DTS1102024	steel
110	20	1,6	36	DTS1102036	stainless
125	20	1,6	28	DTS1252028	steel
125	20	1,5	30	DTS1252030	steel
160	20	3,0	28	DTS1602028	steel
160	30*	1,8	32	DTS1603032	steel
180	30*	1,85	36	DTS1803036	steel
180	20	1,85	48	DTS1802048	steel
180	20	1,6	48	DTS1802048YS	steel
192	20	1,85	48	DTS1922048	steel - thin
192	20	1,85	70	DTS1922070	metal sheets
200	30*	1,9	40	DTS2003040	steel
200	30*	1,9	60	DTS2003060	steel - thin
210	30*	2	42	DTS2103042	steel
210	30*	2	64	DTS2103064	steel - thin
230	25,4	2	48	DTS2303048	steel
230	25,4	2	60	DTS2303060	aluminum
230	25,4	2	68	DTS2303068	steel - thin
230	25,4	2	84	DTS2303084	metal sheets
255	25,4	2	60	DTS2550600002	steel
255	25,4	2	66	DTS2550661003	steel - thin
305	25,4	2,2	60	DTS3050600002	steel
305	25,4	2	72	DTS3050720002C	steel and stainless
305	25,4	3	72	DTS3050720003C	cast iron
305	25,4	2,2	80	DTS3050801003	steel - thin
355	25,4	2,2	90	DTS3550901004	steel & stainless - thin
355	25,4	2,2	72	DTS3550721003	steel & stainless - medium
355	25,4	2,2	66	DTS3550660002	steel
355	25,4	2,2	120	DTS355120001	stainless steel super thin
405	25,4	2,5	80	DTS4050800002	steel
405	25,4	2,5	102	DTS4051021003	steel & stainless
455	50	3,4	100	DTS4551000002	steel
455	50	3,4	120	DTS4551201003	steel & stainless
560	50	3,6	120	DTS5601200002	steel
560	50	3,6	132	DTS5601321003	steel & stainless
630	60	4	140	DTS6301400002	steel
630	60	4	150	DTS6301501003	steel & stainless
630	60	4	210	DTS6302100002	steel
680	60	4	140	DTS6801400002	steel
680	60	4	150	DTS6801501003	steel
680	60	4	210	DTS6802100002	steel
700	60	4	210	DTS7002100002	steel
730	60	4	210	DTS7302100002	steel

* Reducing rings included: 30/25, 30/20, 30/16

NSF-SPECIAL COATED SAW BLADES

for stainless steel

lower friction - up to 3 times higher durability

The NSF saw blades are processed with an aluminum-titanium-chromium nitride layer, so that they are also ideally suited for special applications when machining materials that tend to stick together. The silver-colored layer is characterized by high hardness and resistance to oxidation. In addition, the NSF saw blade is designed to minimize the tendency to adhesion when processing stainless steel. The NSF saw blades are suitable for stainless steels in the food and construction sectors.

Advantages of coated saw blades

- Cutting of stainless steel
- Up to 3 times higher durability
- No tarnishing of materials
- Lower friction
- Lower cost than standard saw blades
- resharpenable up to 5 times

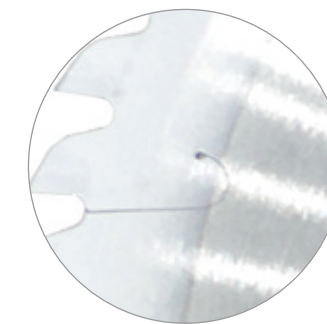
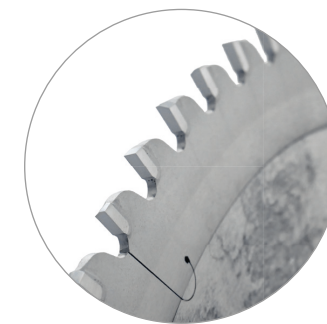
Technical data

Material	Aluminium titanium chromium nitride, AlTiCrN (Stacked)
Microhardness HV 0,05	3.000 +/- 30
Coefficient of friction against steel 100Cr6	0,4
Maximale operating temperature	800° C / 1.470°F
Thickness	2 - 4 µm

Coated saw blades range (special dimensions on request)

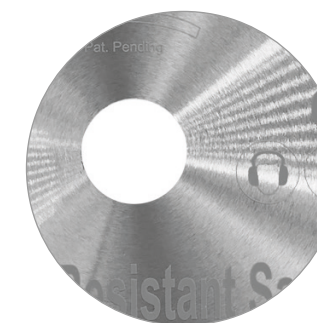
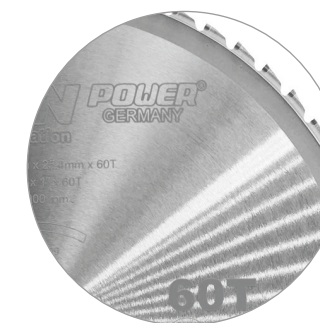
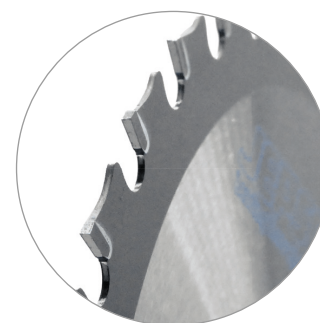
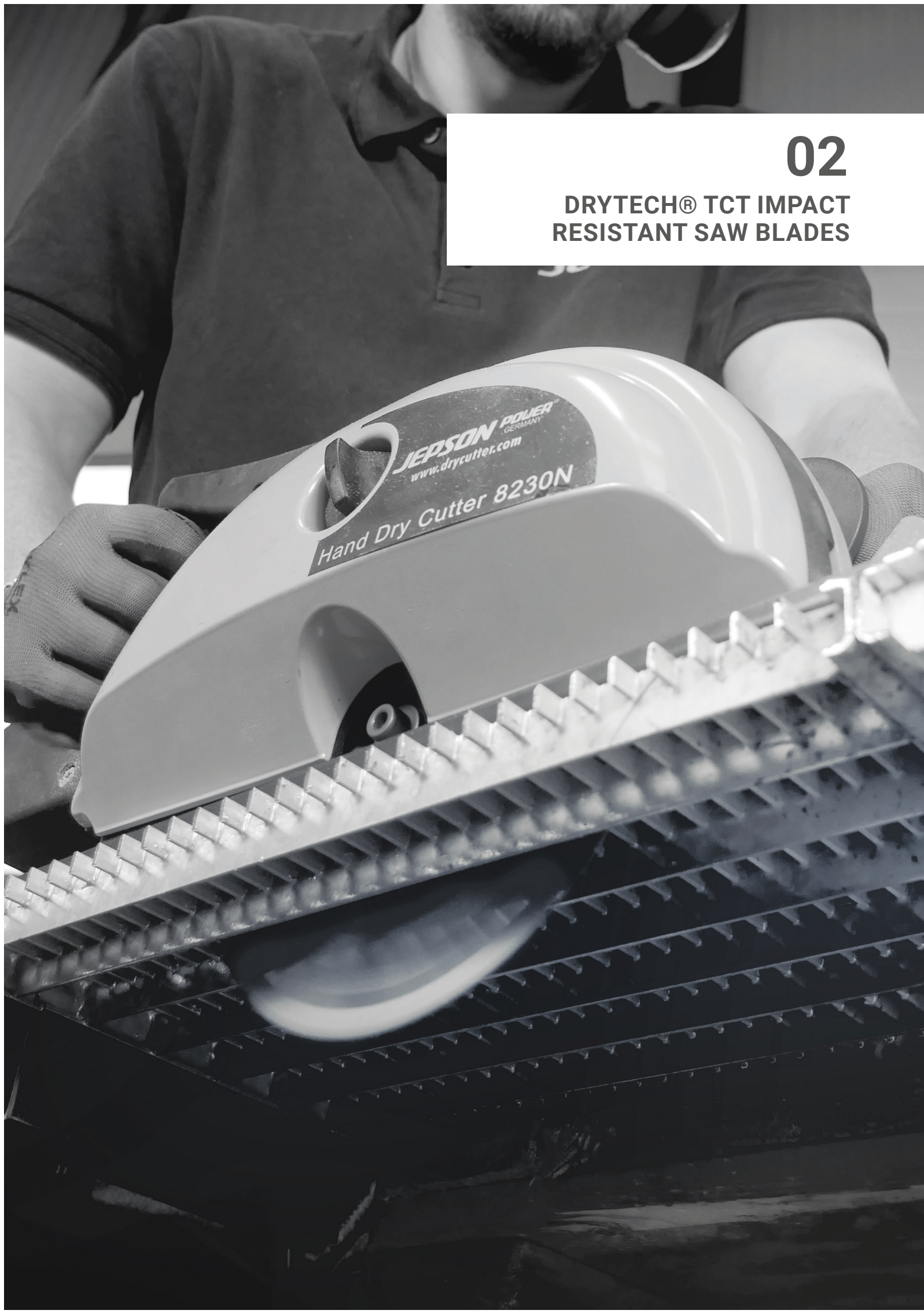
Ø [mm]	Bore	Kerf	Teeth	Reference	Use
137	20	1,0	30	72213730	food and construction
150	20	1,2	34	72215034	food and construction
165	20	1,2	40	72216540	food and construction
230	25,4	2,0	48	2300481003COA	food and construction
255	25,4	2,0	66	2550661003COA	food and construction
320	25,4	2,2	84	608275NSF	food and construction
355	25,4*	2,2	90	3550901004COA	food and construction

* with pin bore (4/11/TK 55 mm)



02

DRYTECH® TCT IMPACT RESISTANT SAW BLADES



DRYTECH® TCT IMPACT RESISTANT SAW BLADES

thin - efficient - faster

DRYTECH® LBS TCT saw blades are designed for cordless power tools. Special cermet tipped, super strong against wear and an excellent blade life are just some advantages. The DRYTECH® TCT LBS are developed with an ultra-thin kerf to minimize the cutting resistance and achieving with less CO2 emission even a longer blade life, a perfect cutting surface and at least a longer battery power life. With 1.0 to 1.5 mm LBS-blades are much thinner than conventional sawblades. Please use it with steel cutting machines, see listed below. Sawing process with LBS-saw blades saves material, resources, and time.

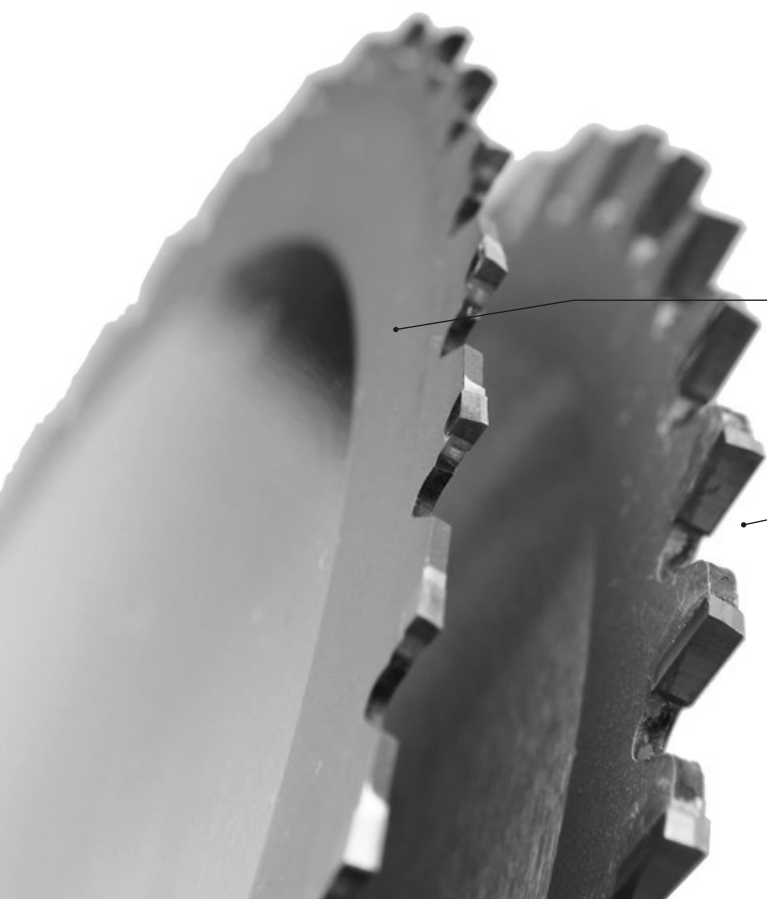
Ideal for cutting

- metal grids and grates,
- trapezoidal sheets,
- metal profiles
- conduit
- shutter pipes
- and much more.

Suitable for common metal cutting machines like

- AEG
- Bosch
- Dewalt
- Flex
- Hilti
- Hitachi
- Jepson Power
- Makita
- Metabo
- Milwaukee

35 % less chips



LBS saw blade
1,4 mm kerf Ø 230/60T

conventional saw blade
1,85 mm kerf Ø 230/60T

DRYTECH® TCT IMPACT RESISTANT SAW BLADES

Ø [mm]	Kerf	Blade body width	Bore	Teeth	Max. no load speed	Reference	For machine
137	1,0	0,8	20	30	4500 rpm	72213730	Bosch, Milwaukee, Makita etc.
150	1,2	0,94	20	34	4500 rpm	72215034	Makita, Milwaukee etc.
165	1,2	0,94	20	40	4200 rpm	72216540	Metabo, Milwaukee, Hikoki, Hilti
180	1,2	0,94	20	48	4000 rpm	72218048	Flex, Hitachi, Makita, Rexon, Hilti etc.
184	1,2	0,94	16	48	4000 rpm	72218448	Bosch, Dewalt, Makita, Milwaukee
192	1,2	0,94	20	48	4000 rpm	72219248	Jepson Power HDC 8219
203	1,2	0,94	25,4/30	48	3800 rpm	72220348	AEG, Bosch, Jepson Power etc.
230	1,4	1,2	25,4	60	3000 rpm	72223060	Jepson Power HDC 8230N
255	1,5	1,2	25,4	66	2200 rpm	72225566	Jepson Power DMC 9410ND

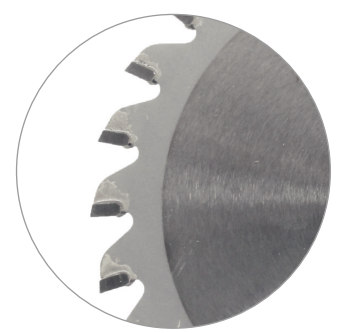
carbide tipped saw blades for stainless steel

Ø [mm]	Schnittbreite	Stammbblattstärke	Bohrung	Zähne	Max. Leerlaufdrehzahl	Artikel-Nr.	Für Maschine
137	1,5	1,3	20	30	4000 min ⁻¹	72113730I	Bosch, Milwaukee, Makita etc.
150	1,5	1,3	20	42	4000 min ⁻¹	72115042I	Makita, Milwaukee etc.
165	1,7	1,4	20	48	4000 min ⁻¹	72116548I	Metabo, Milwaukee, Hikoki, Hilti



03

**DRYTECH® TCT MILLING
SAW BLADES FOR METAL**



DRYTECH® TCT MILLING SAW BLADES for metal

sawing - milling - slotting - cutting off

Drytech® Milling Cutter offers an extraordinary range of carbide-tipped saw blades for a wide variety of applications. Our R&D department will be delighted to support you by customer-specific adaptations. By offering competent advice, we can produce special saw blades according to your requirements from saw blade diameter of 100 mm.

Standard bore design: 16H and 22H and 22H

If you need other dimensions, we can adapt them according to your requirements, drawings.

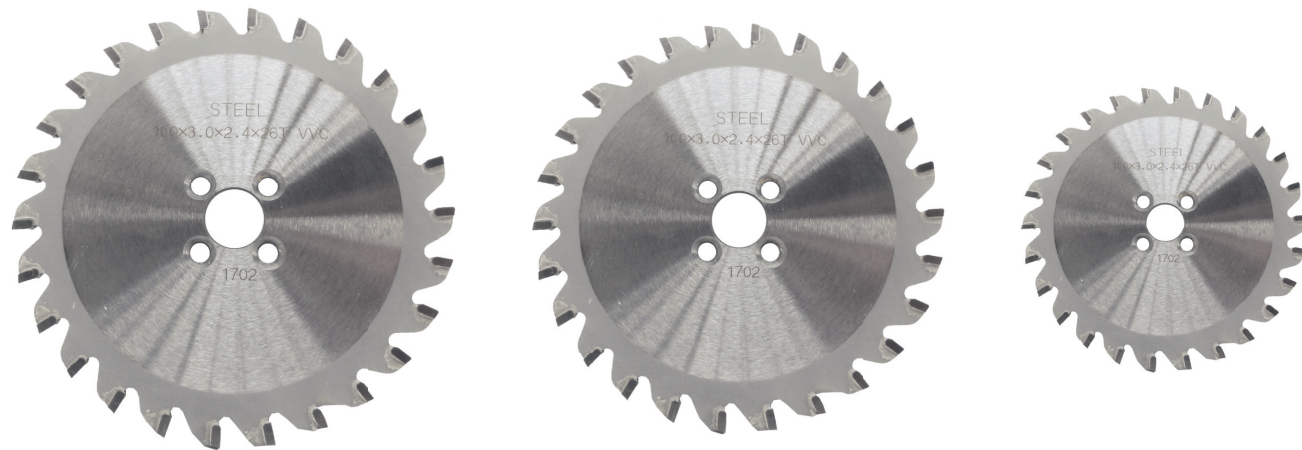
Application: materials made of stainless steel, mild steel and aluminum

Advantages:

- High resistance TCT saw blade
- Cost-effectiveness
- Excellent cutting surface
- Resharpenable
- for deep saw cuts, slotting or milling.
- Variable pitch for aluminum cutting
- Anti - vibration for smooth cutting and higher blade life.

Recommend with radial feed and use of coolant!

Drytech® Milling saw blades are suitable for CNC machining center and automatic saws.



DRYTECH® TCT MILLING SAW BLADES for metal

Ø [mm]	Kerf	Teeth	Reference
100	3,0	26	DTS100326
125	3,0	26	DTS125326
160	3,0	28	DTS160328
100	1,0	40	DTS10040TS
100	1,6	22	DTS10022S
100	2,5	26	DTS10026S
110	1,6	24	DTS11024S
110	1,6	36	DTS10036ST
125	1,6	28	DTS12528S
125	1,5	30	DTS12530ST
160	3,0	28	DTS16028S
100	1,8	30	DTS10030A
100	2,5	16	DTS10016A
100	3,0	16	DTS10016A1
110	1,8	30	DTS11030A
125	1,8	36	DTS12536A
125	3,0	16	DTS12516A
160	3,0	16	DTS16016A

Cutting Parameters

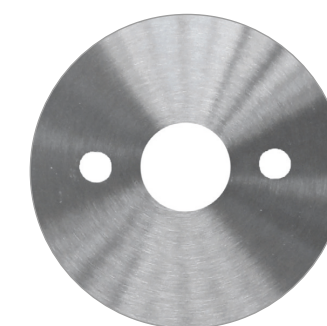
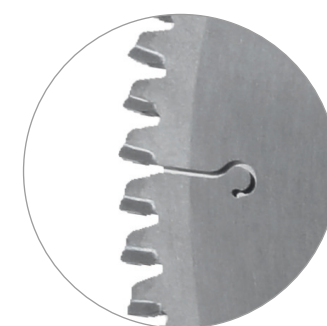
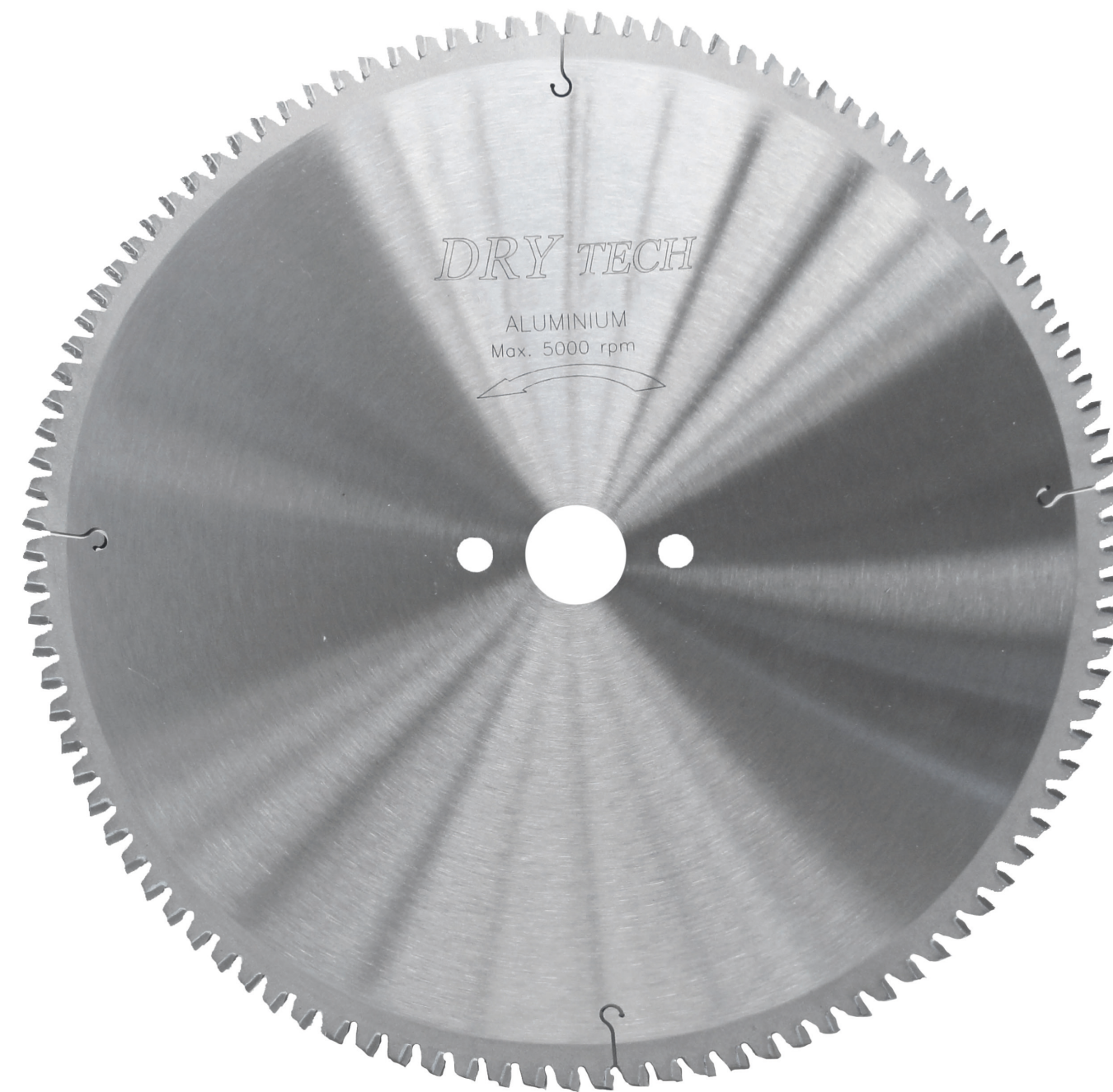
Aluminium $v_c = 320$ m/min $f_z = 0,029$ mm

Steel $v_c = 125$ m/min $f_z = 0,029$ mm

Inox $v_c = 125$ m/min $f_z = 0,029$ mm

04

**DRYTECH® TCT
SAW BLADES FOR ALUMINIUM**



DRYTECH® TCT SAW BLADES FOR ALUMINUM

non-ferrous metal - profiles - solids

Ideal for mass cutting aluminium and NF-METALS, pipes, profiles and solid materials.

Saw blade diameter:

from Ø 150 mm up to 600 mm

Saw blade revolution:

6.000 rpm

- Special sizes on request!
- Customized center and pin holes
- Resharping services
- Feed rate fz 0,01 - 0,02 mm/tooth
- Available standard negative hook angel positive hook on request

Design:

Special silent execution for a maximum of noise reduction

Suitable for:

CNC machine center

- stationary machines
- double mitre saws
- manual
- semi or fully automated stationary machines

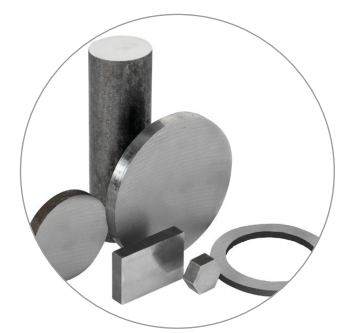
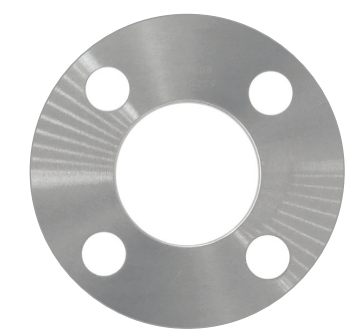
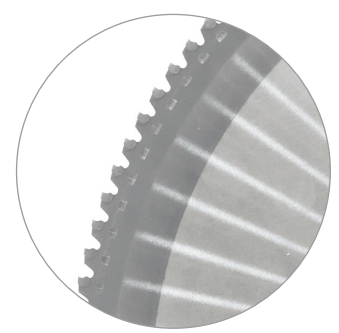
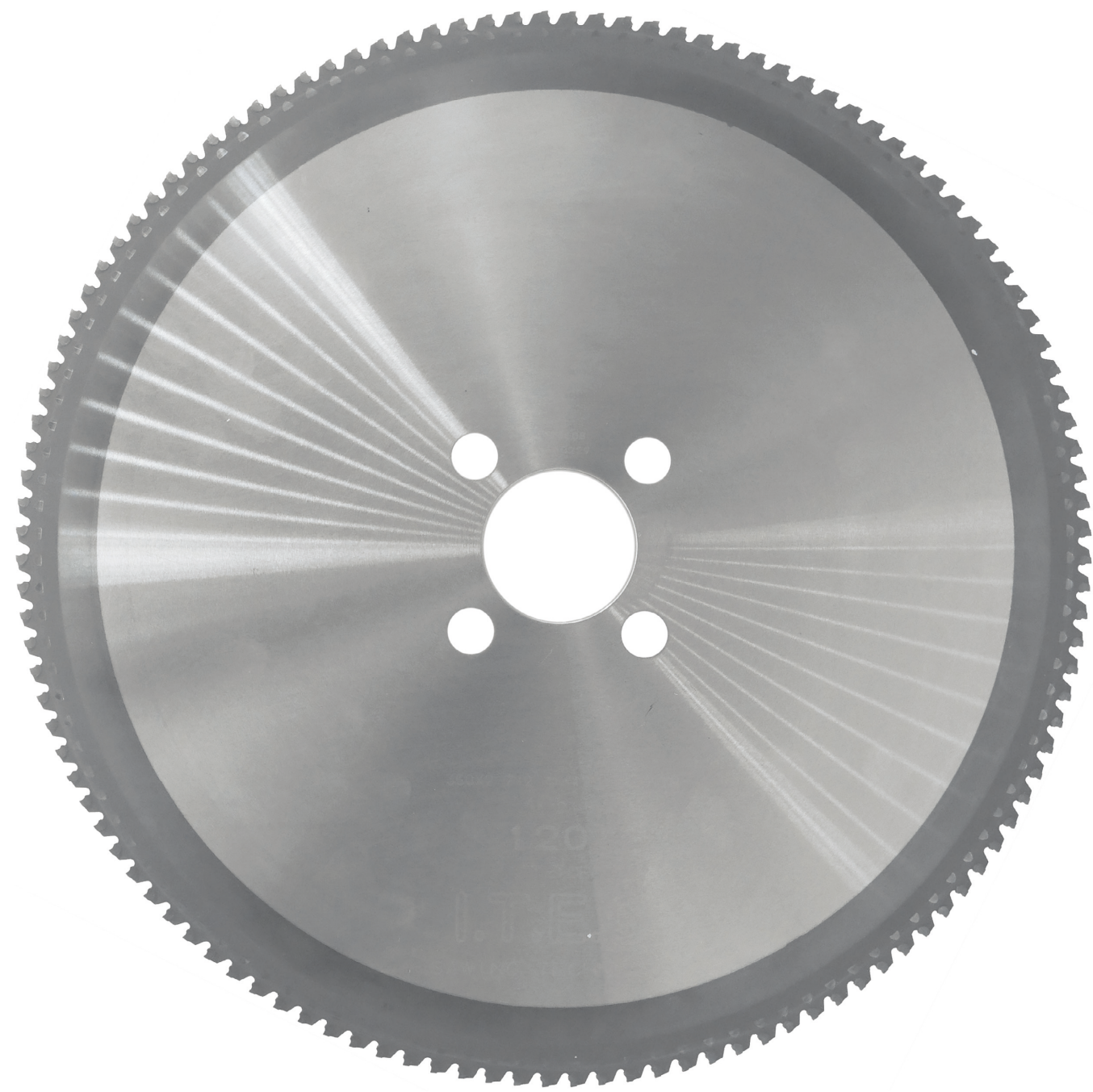
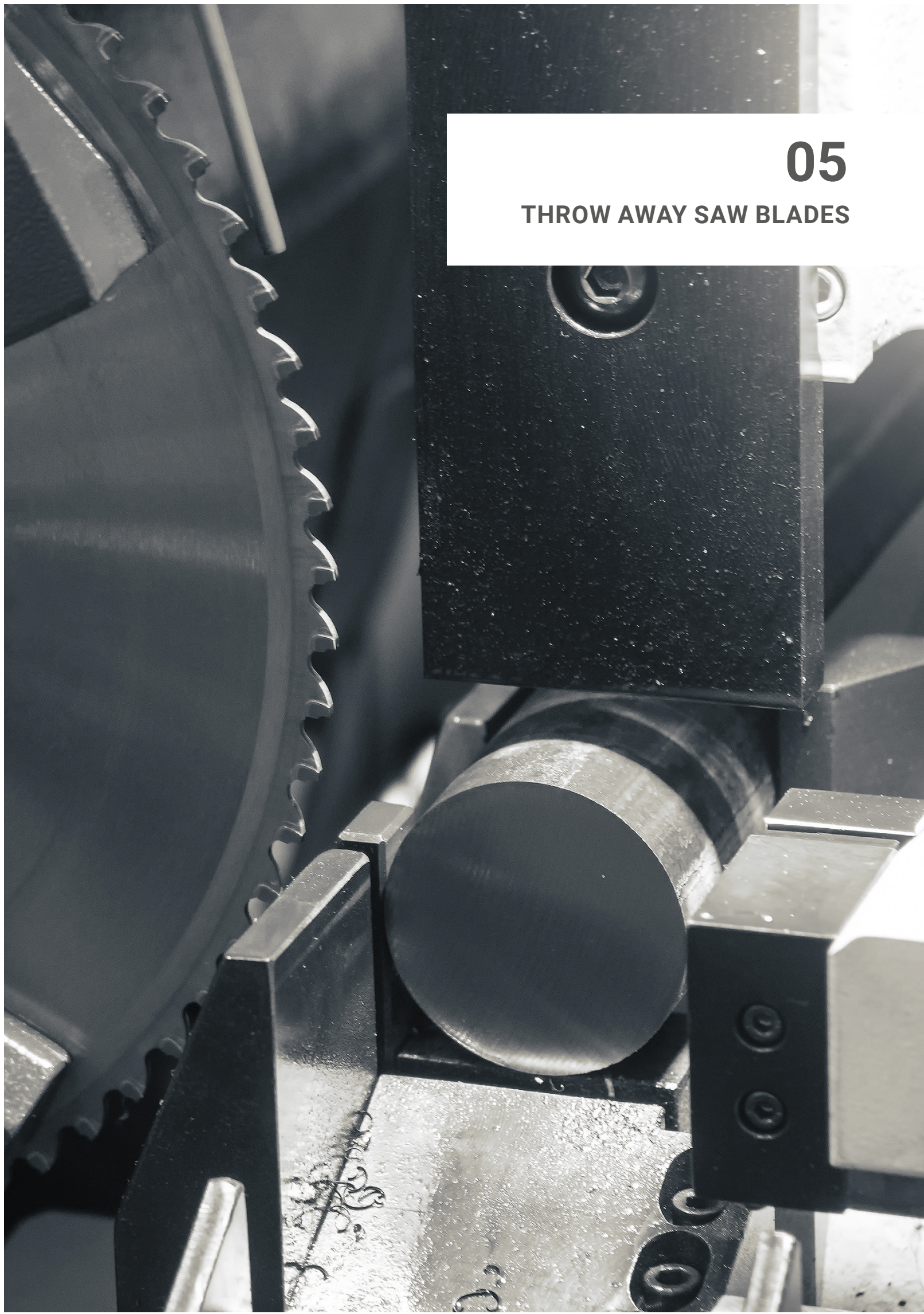
DRYTECH® TCT SAW BLADES FOR ALUMINUM

range of saw blades

Reference	Ø [mm]	Kerf / Body [mm]	Bore [mm]	Teeth
AL100030	100	1,8	20	30
AL100016	100	2,5	20	16
AL100316	100	3,0	20	16
AL110030	110	1,8	20	30
AL125036	125	1,8	20	36
AL125016	125	3,0	22	16
AL160016	160	3,0	22	16
AL20030060	200	3.0 / 2.0	30	60
AL21630060	216	3.0 / 2.0	30	60
AL25030060	250	3.2 / 2.2	30	60
AL25032060	250	3.2 / 2.2	32	60
AL25030080	250	3.2 / 2.2	30	80
AL25032080	250	3.2 / 2.2	32	80
AL30030072	300	3.2 / 2.4	30	72
AL30032072	300	3.2 / 2.4	32	72
AL30030084	300	3.2 / 2.4	30	84
AL30032084	300	3.2 / 2.4	32	84
AL30030096	300	3.2 / 2.4	30	96
AL30032096	300	3.2 / 2.4	32	96
AL35030084	350	3.4 / 2.8	30	84
AL35032084	350	3.4 / 2.8	32	84
AL35030096	350	3.4 / 2.8	30	96
AL35032096	350	3.4 / 2.8	32	96
AL35030108	350	3.4 / 2.8	30	108
AL35032108	350	3.4 / 2.8	32	108
AL40030096	400	3.4 / 2.8	30	96
AL40032096	400	3.4 / 2.8	32	96
AL40030120	400	3.4 / 2.8	30	120
AL40032120	400	3.4 / 2.8	32	120
AL42030108	420	3.8 / 3.0	30	108
AL42032108	420	3.8 / 3.0	32	108
AL45030096	450	3.8 / 3.0	30	96
AL45032096	450	3.8 / 3.0	32	96
AL45030108	450	3.8 / 3.0	30	108
AL45032108	450	3.8 / 3.0	32	108
AL50030120	500	4.0 / 3.2	30	120
AL50032120	500	4.0 / 3.2	32	120
AL55030132	550	4.2 / 3.5	30	132
AL55032132	550	4.2 / 3.5	32	132
AL60030144	600	4.2 / 3.5	30	144
AL60032144	600	4.2 / 3.5	32	144

05

THROW AWAY SAW BLADES



THROW AWAY CARBIDE TIPPED SAW BLADES

for solid materials and thick walled tubes

higher cutting speed - higher durability - excellent cutting surface

The choosed saw blades are one of the most important components in the preparation process of the mass production. Therefore, very precise sawing of workpieces in the mass production request a high performance of the saw blades.

Application: Steel, stainless steel, non-ferrous steel, cast iron

Applicationb examples: Hinges, Gear wheels, Cylinder barrels, Forgings, Ball bearings Bevel wheel, Iron and steel trade

Advantages: Up to 15.000 cuts, higher cutting life, better cutting surface, higher cutting speed

The TH-TCT saw blades are designed for mass cutting of automobile parts and forged materials which requires severe cutting controls of section.

- Saw blade diameter from 250 mm up to 460 mm
- Saw blade revolution from 12 - 200 rpm
- Special sizes on request
- Customized center and pin holes

Teeth material Carbide: Suitable for stainless steel
Cermet: For use in steel, non-ferrous material and cast Coating for higher durability and tempered steel
 All saw blades are in original blank. They all can be coated on request!

To be used mainly for constant length cutting of round solid bar, square solid bar, solid-drawn pipe and so on. This item is produced under the strict quality control because the users produce automobile parts and forging materials and need strict controls on cutting surface, precision and any other aspects.

Application: Mild steel, alloy steel, stainless steel, non-ferrous steel, corresponding to general cut-off machines.

THROW AWAY CARBIDE TIPPED SAW BLADES

range of saw blades

Diameter	Kerf	Central bore	Number of teeth	Cutting capacity
250	2.0	32	54	Ø 40 ~ Ø 50
			60	Ø 30 ~ Ø 40
			72	Ø 15 ~ Ø 30
285	2.0	32/40	54	Ø 50 ~ Ø 65
			60	Ø 35 ~ Ø 50
			72	Ø 20 ~ Ø 35
350	2.7	50	80	Ø 15 ~ Ø 30
			120	Ø 15 ~ Ø 30
			140	Ø 30 ~ Ø 50
360	2.6	40/50	60	Ø 55 ~ Ø 100
			80	Ø 30 ~ Ø 50
			100	Ø 20 ~ Ø 30
425	2.7	50	60	Ø 50 ~ Ø 65
			80	Ø 35 ~ Ø 50
			100	Ø 20 ~ Ø 35
460	2.7	50	120	Ø 20 ~ Ø 35
			60	Ø 50 ~ Ø 65
			80	Ø 35 ~ Ø 50
250	2.0	32	100	Ø 20 ~ Ø 35
285	2.0	32	160	
			180	
			200	~ Ø 35

carbide tipped saw blade Ø 285 mm

Material DIN	Diameter mm	Sawblade	Leerlaufdrehzahl	Vorschub/Zahn
St 33	10 - 15	285 x 2.0t x 120T	140 (120 - 140) bei Rohren 200	0.05 (0.04-0.08)
CK 10 C10	26 - 40	285 x 2.0t x 80T	140 (120 - 140)	0.05 (0.04-0.08)
CK15 C15	41 - 50	285 x 2.0t x 72T	140 (120 - 140)	0.05 (0.04-0.08)
CK25 C25	51 - 65	285 x 2.0t x 60T	140 (120 - 140)	0.05 (0.04-0.08)
CK50 C35	10 - 25	285 x 2.0t x 120T	130 (120 - 140)	0.05 (0.04-0.07)
CK40 C40	41 - 50	285 x 2.0t x 72T	130 (120 - 140)	0.05 (0.04-0.07)
CK45 C45	51 - 65	285 x 2.0t x 60T	130 (120 - 140)	0.05 (0.04-0.07)
CK50 C50	10 - 25	285 x 2.0t x 120T	100 (100 - 120)	0.05 (0.04-0.07)
CK55 C55				
CK60 C60				
37Cr 4	41 - 50	285 x 2.0t x 72T	100 (100 - 120)	0.05 (0.04-0.07)
41Cr 4				
34CrMo 4				
42CrMo 4	51 - 65	285 x 2.0t x 60T	100 (100 - 120)	0.05 (0.04-0.07)
100Cr 6				
X 210 Cr 12	10 - 25	285 x 2.0t x 120T	100	0.05 (0.04-0.06)
DINX	26 - 40	285 x 2.0t x 80T	100	0.05 (0.04-0.06)
5CrnNi	41 - 50	285 x 2.0t x 72T	100	0.05 (0.04-0.06)
1810	51 - 65	285 x 2.0t x 60T	100	0.05 (0.04-0.06)

THROW AWAY CARBIDE TIPPED SAW BLADES

for solid materials and thick walled tubes



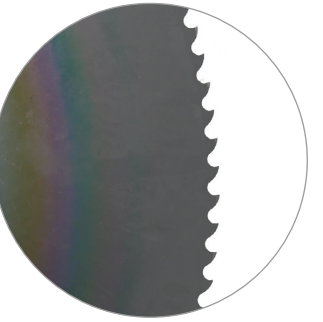
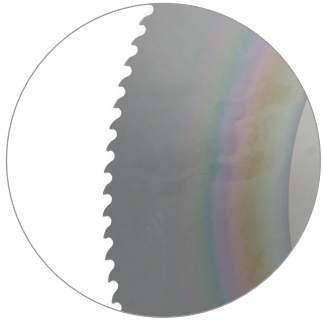
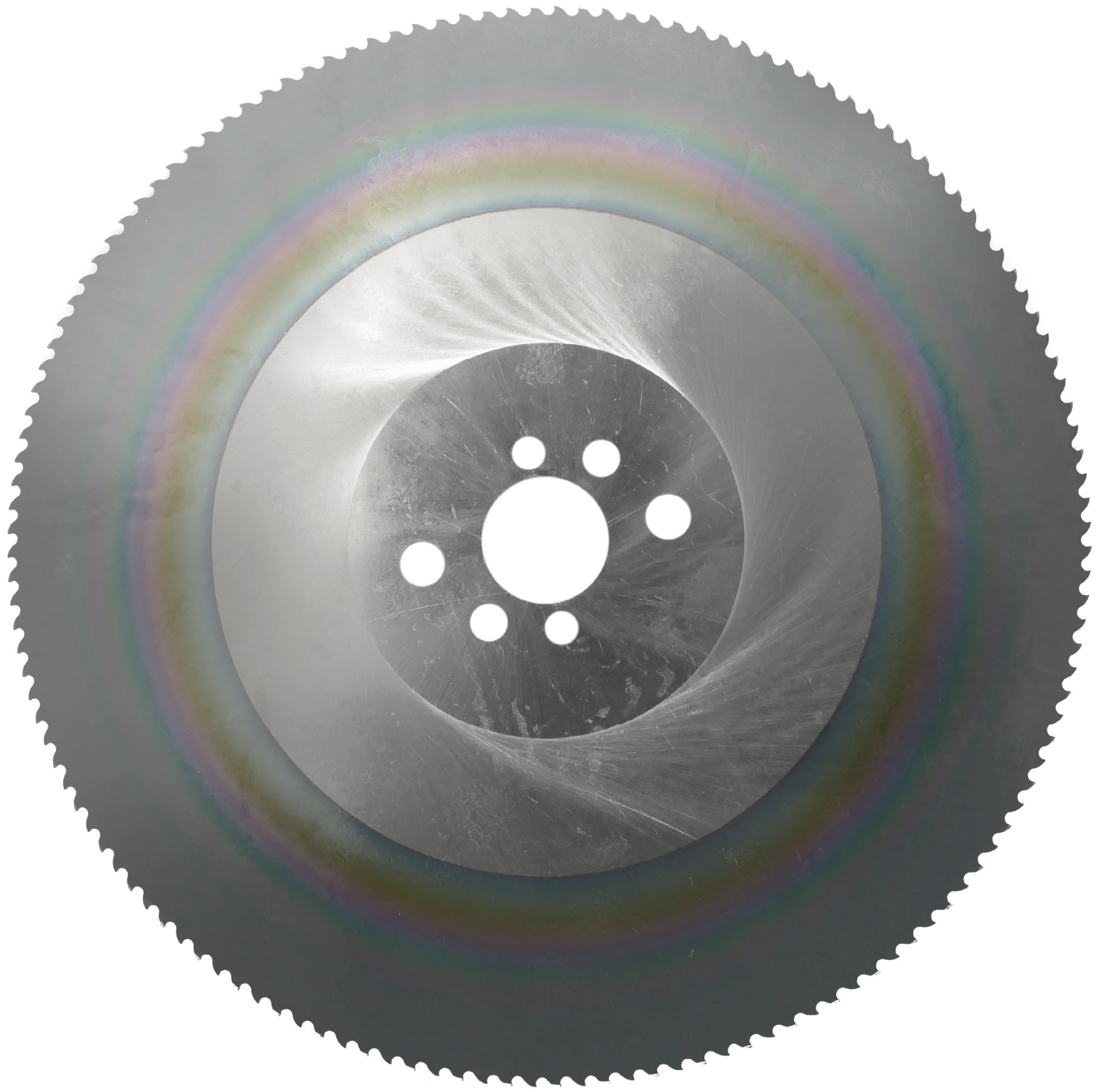
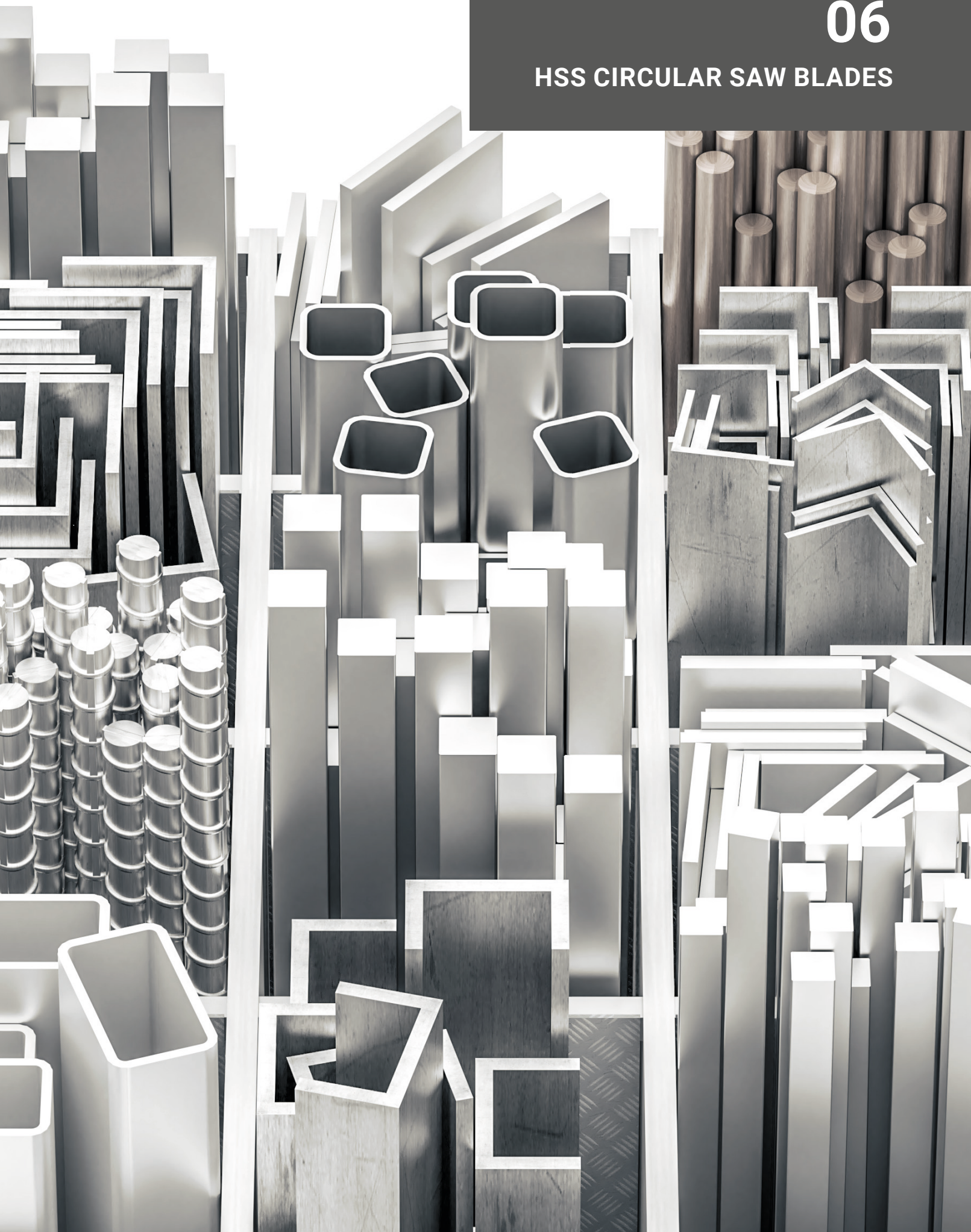
Type	TH	TH-LBS	Performances
Specification	120T	200T	+ 80 teeth
Cutting speed [m/min]	180	180	O.K.
Revolution [min-1]	200	200	O.K.
Feed / tooth [mm]	0.04	0.04	O.K.
Feed speed [mm/min]	960	1.600	+ 67 % faster
Cutting time [s]	3.1	1.9	- 37 % shorter
Cycle time [s]	5.5	4.3	- 22 % shorter
Number of cuts / [hour]	654	837	+ 28 % [+ 183 cuts]
Number of cuts / 8 [hours]	5.263	6.697	+ 28 % [+ 1.461 cuts]

THROW AWAY CARBIDE TIPPED SAW BLADES

range of saw blades

Maschine	Modell	Diameter in/mm	Kerf	Bore	Mitnehmer	
Adige	CM502-CM601	14"/ 360 mm	2,6 2,27	32	4/11/63	
		11"/ 285 mm	2,0 1,75	40	2/12/80	
Amada	CM100AN CM150AN	14"/ 360 mm	2,6 2,27	40	4/12/90	
		18"/ 460 mm	2,7 2,27	40	4/12/90	
	HCS 70	10"/ 250 mm	2,0 1,75	40	2/15/80	
		11"/ 285 mm	2,0 1,75	40	2/15/80	
	HCS 90	11"/ 285 mm	2,0 1,75	40	2/15/80	
		14"/ 360 mm	2,6 2,27	40	2/15/80	
Behringer - Eisele	HCS 130	14"/ 360 mm	2,6 2,27	40	2/15/80	
		16 1/2"/ 420 mm	2,7 2,27	40	2/15/80	
	HCS 150	14"/360 mm	2,6 2,27	40	2/15/80	
		16 1/2"/ 420 mm	2,7 2,27	40	2/15/80	
		18"/460 mm	2,7 2,27	40	2/15/80	
			2,0 1,75	40	4/12/64	
Bewo	ECH 108	10"/250 mm	2,0 1,75	40	4/12/64	
Exact-cut	Mac 60	10"/250 mm	2,0 1,75	32	4/9/50	
		12 1/2"	2,2 1,90	40	4/15/80	
Ficep	S35 S50	14"/360 mm	2,6 2,27	40	2/15/80	
		18"/460 mm	2,7 2,27	50	2/18/100	
Gernetti Kaltenbach	SIC 350 K SIC 500 K KMR 100	14"/350 mm	2,6 2,27	40	4/14/80	
		14"/350 mm	2,6 2,27	40	4/14/80	
		18"/460 mm	2,7 2,27	50	4/18/100	
		19 1/2/ 500 mm	3,4 2,80	50	4/18/100	
		14"/360 mm	2,6 2,27	50	4/15/80	
			10"/250 mm	2,0	1,70	32
Kasto	WAC7 SPEED C9	11"/285 mm	2,0	1,70	32	4/9/50+4/11/63
		10"/250 mm	2,0	1,70	32	4/9/50+4/11/63
		11"/285 mm	2,0	1,70	32	4/9/50+4/11/63
		12 1/2"	2,5 2,25	32	4/9/50+4/11/63	
	VARIOSPEED C14 VARIOSPEED C15	14"/360 mm	2,6 2,27	50	4/15/80	
		17"/425 mm	2,7 2,27	50	4/15/80	
		17"/425 mm	2,7 2,27	50	4/15/80	
		18"/460 mm	2,7 2,27	50	4/15/80	

06
HSS CIRCULAR SAW BLADES



HSS CIRCULAR SAW BLADES

higher cutting speed - higher durability - excellent cutting surface

Ø [mm]	Thickness [mm]	Central bore [mm]	Hub [mm]	Side run out [mm]	Number of teeth [toothpitch] and toothform					Number of teeth [toothpitch] and toothform												
					T2,5 A	T3 BW	T4 BW	T4,5 BW	T5 BW	T5,5 BW	T6 HZ	T7 HZ	T8 HZ	T9 HZ	T10 HZ	T12 HZ	T14 HZ	T16 HZ	T18 HZ			
68	1,6	16	42			72			44													
80	1,6	16	42					54														
250	1,5 [1,6]	32	100	0,25	320	240	200	180	160	140	128	110	100	90	80	66						
250	2,0	25,4 / 32 / 40	100	0,25	320	240	200	180	160	140	128	110	100	90	80	66						
250	2,5	25,4 / 32 / 40	100	0,25	320	240	200	180	160	140	128	110	100	90	80	66						
275	1,6	32 / 40	100	0,25	340	280	220	200	180	160	140	120	110	96	90	70	60					
275	2,0	32 / 40	100	0,25	340	280	220	200	180	160	140	120	110	96	90	70	60					
275	2,5	25,4 / 32 / 40	100	0,25	340	280	220	200	180	160	140	120	110	96	90	70	60					
300	2,0	32 / 40	100	0,25	380	300	220	210	180	170	160	140	120	104	94	80	68					
300	2,5	32 / 38 / 40	100	0,25	380	300	220	210	180	170	160	140	120	104	94	80	68					
315	2,0	32 / 40	100	0,30	400	300	240	220	200	180	160	140	120	110	100	80	70	60				
315	2,5	32 / 40	100	0,30	400	300	240	220	200	180	160	140	120	110	100	80	70	60				
315	3,0	32 / 40	100	0,30	400	300	240	220	200	180	160	140	120	110	100	80	70	60				
325	2,5	32 / 40	100	0,30	410	320	250	220	200	190	170	146	128	110	100	80	72	64				
130	2,0	32 / 40	120	0,30	440	350	280	240	220	200	180	160	140	120	110	90	80	70	60			
130	2,5	32 / 40 / 50	120	0,30	440	350	280	240	220	200	180	160	140	120	110	90	80	70	60			
130	3,0	32 / 40 / 50	120	0,30	440	350	280	240	220	200	180	160	140	120	110	90	80	70	60			
370	2,5	32 / 40 / 50	120	0,30		380	280	260	220	210	190	160	140	120	110	100	80	70	64			
370	3,0	32 / 40 / 50	120	0,30		380	280	260	220	210	190	160	140	120	110	100	80	70	64			
400	2,5	32 / 40 / 50	120	0,30			310	280	250	230	200	180	160	140	120	110	96	80	70			
400	3,0	32 / 40 / 50	120	0,30			310	280	250	230	200	180	160	140	120	110	96	80	70			
400	3,5	40 / 50	120	0,30			310	280	250	230	200	180	160	140	120	110	96	80	70			
400	4,0	40 / 50	120	0,30			310	280	250	230	200	180	160	140	120	110	96	80	70			
425	3,0	32 / 40 / 50	130	0,35			320	300	260	240	220	190	160	150	130	110	96	84	70			
425	3,5	32 / 40 / 50	130	0,35			320	300	260	240	220	190	160	150	130	110	96	84	70			
425	4,0	32 / 40 / 50	130	0,35			320	300	260	240	220	190	160	150	130	110	96	84	70			
450	3,0	40 / 50	130	0,35			350	320	280	260	230	200	180	160	140	120	100	90	80			
450	3,5	40 / 50	130	0,35			350	320	280	260	230	200	180	160	140	120	100	90	80			
450	4,0	40 / 50	130	0,35			350	320	280	260	230	200	180	160	140	120	100	90	80			

Available in Co5 and DMo5 TiAlN Steamed and Coated. Customized pin holes, bore and hub on request!

Bw Standard tooth shape for the pipe cutting

B For blades with thin thickness [$< 1,3$ mm] as an alternative of Bw

Br Best tooth shape for automatic pipe cutting machines

A Best tooth shape for small tooth pitch [$T < 3$ mm]

HZ For solid cutting or thicker pipes [> 3 mm]

VP Variable pitch for irregular sections

Bw Standard tooth shape for the pipe cutting

B For blades with thin thickness [$< 1,3$ mm] as an alternative of Bw

Br Best tooth shape for automatic pipe cutting machines

A Best tooth shape for small tooth pitch [$T < 3$ mm]

HZ For solid cutting or thicker pipes [> 3 mm]

VP Variable pitch for irregular sections



07
DRYTECH® TCT
AURORA SAW BLADES



DRYTECH® TCT AURORA SAW BLADES

environmentally friendly sawing that's our passion 

Machining of carbon-fiber-reinforced plastics is currently dominated by milling technology, as this is associated with challenges for conventional saws due to the amount of dust volume. But sawing instead of milling is an advantage by trimming large parts during the machining process.

Using DRYTECH® Aurora saw blades in Carbon fiber-reinforced plastics lead to high-cost efficiency due to time and material savings, due to our high-tech thin-cutting technology and the associated low dust volume in connection with high blade life performance and excellent cutting quality which make further reworking superfluous.

In addition to our standard program, we also manufacture customer-specific dimensions, competent advice and the possibility of performing cutting tests in our in-house test center fulfill our service.

Applicable on:

Robots, Milling Centres, 5-Axe CNC Machining Centres or Common Aluminium and Wood Working Machines

Suitable for:

CFRP, CFRTP, Aramid Fibre Reinforced, Plastics, GF, Prepreg, Pipes, profiles, plates

Advantages:

Clean cutting edge, Prevent delamination due to finest pitch, Less chip volume, Material saving through thin cut technology, Less heat processing due to lower cutting resistance

DRYTECH® TCT AURORA SAW BLADES

range of saw blades

wall thickness **up to** 10 mm

Ø [mm]	Kerf [mm]	Body [mm]	Bore [mm]	Teeth	Reference
70	1	0,9	22,2H	60	AURDTS07060
80	1	0,9	22,2H	68	AURDTS08068
115	1	0,9	22,2H	100	AURDTS115100
120	1	0,9	22,2H	60	AURDTS120060
120	1	0,9	22,2H	80	AURDTS120080
120	1	0,9	22,2H	100	AURDTS120100
150	1	0,94	25,4H	80	AURDTS150080
150	1	0,94	25,4H	100	AURDTS150100
150	1	0,94	25,4H	120	AURDTS150120
192	1	0,94	20,0H	160	AURDTS192160
200	1,2	0,94	30,0H	180	AURDTS200180
255	1,4	1,2	25,4H	220	AURDTS255220
305	1,6	1,4	25,4H	260	AURDTS305260
355	2,0	1,7	25,4H	300	AURDTS355300
405	2,5	2,25	30,0H	280	AURDTS405280

Customized pin holes and bore on request!

wall thickness **greater than** 10 mm

Ø [mm]	Kerf [mm]	Body [mm]	Bore [mm]	Teeth	Reference
250	4	3,0	30,0H	80	AURDTS250080
305	4	3,0	30,0H	100	AURDTS305100
355	4	3,0	30,0H	120	AURDTS355120

Customized pin holes and bore on request!

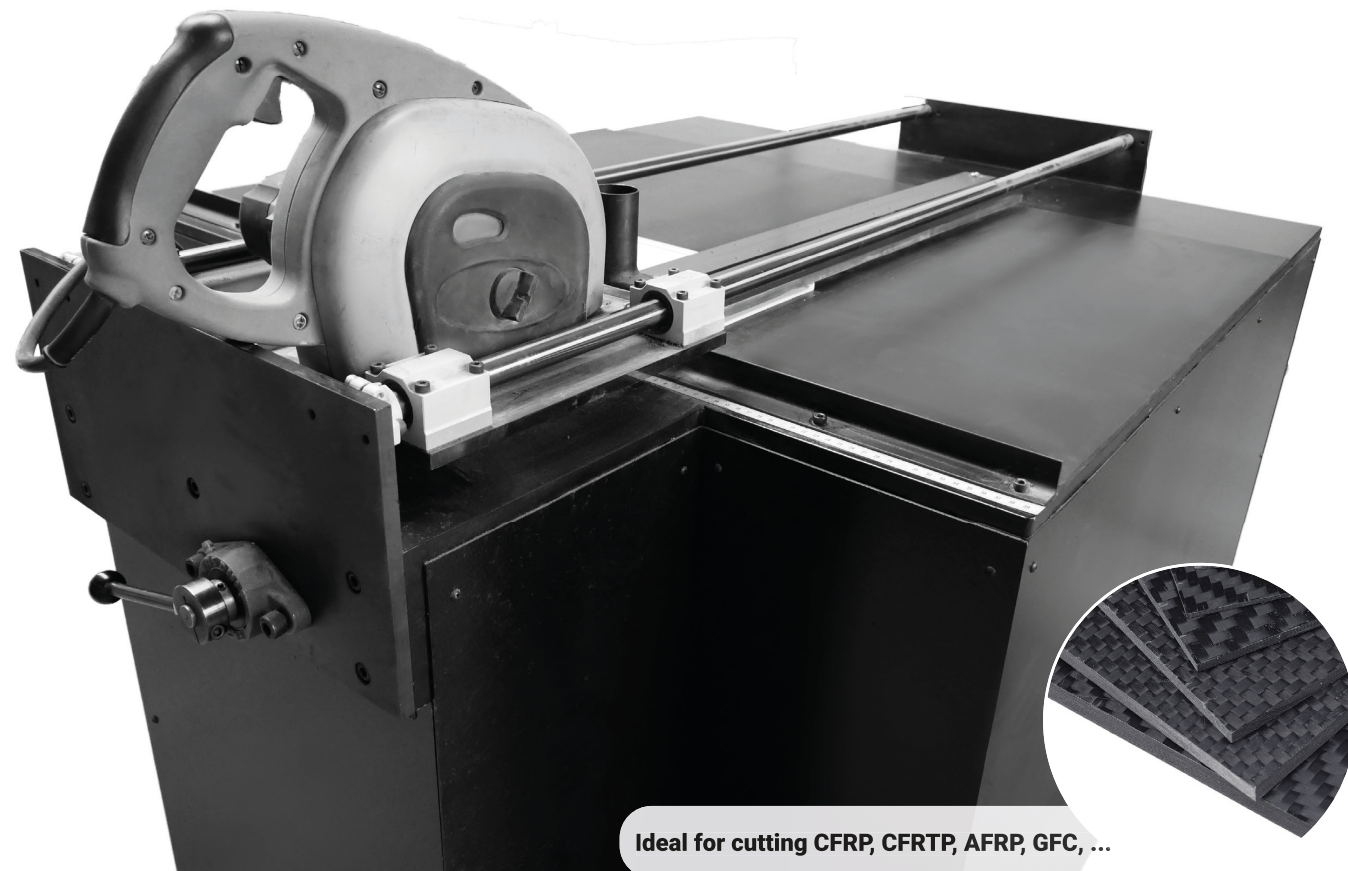
DRYTECH® TCT AURORA SAW BLADES

CFRP panel cutting unit

- Sturdy built construction, completely covered
- Max. Cutting Capacity: 800 x 800 x 6 mm
- Anti-slip rubber pad to protect against material damage
- Spring pressure clamping system
- Length stopper
- dust vacuum up directly from the cut (90%), further exhaust pipe at the rear part of the table available (Vacuum Cleaner not included)

Specifications Model: JEPSON HDC 8200

Power input	1.700 W
Voltage	230V/50Hz or 115V/60Hz
No load speed	3.700 rpm
Saw blade	Aurora Ø 200 x 1,2 x 0,94 x 30 x 180T included
Dimensions	1.100 x 1.490 x 890 mm
Weight, Color	372 kg, black
Connection hose	Ø 35,5 mm



DRYTECH® TCT AURORA SAW BLADES

CF pipe cutting machine

Sawing by rotating pipe & saw blade

Perfect cutting surface and no delamination due to cutting along the fiber direction.

2-step feed speed

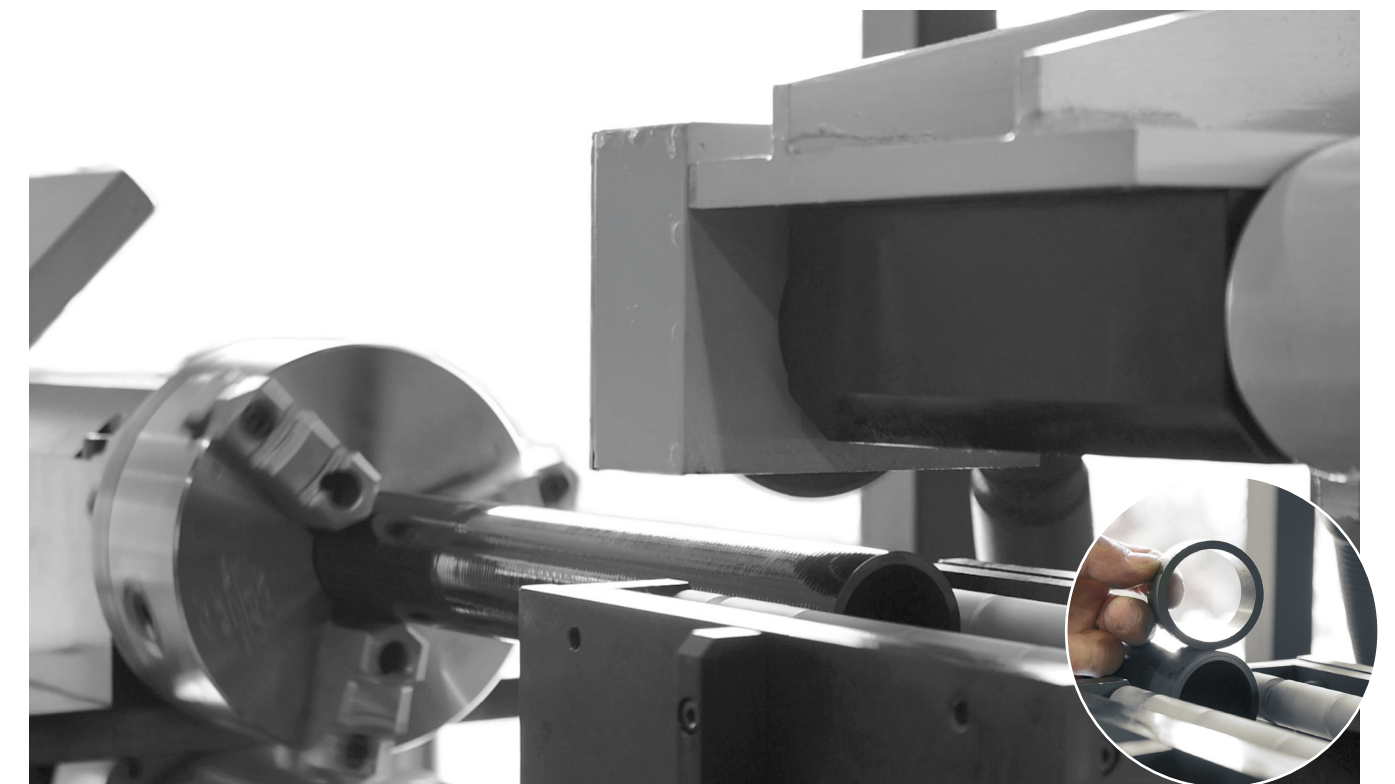
1st step: slow motion feed: cut into material slowly
2nd step: high speed cutting feed to avoid burrs

Precise clamping

Pipe clamping through split claw scroll chuck.
Excellent cutting accuracy.

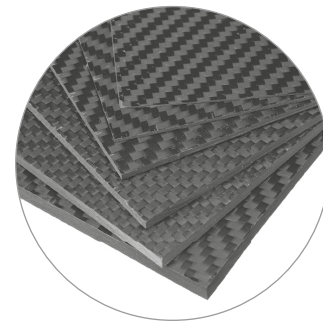
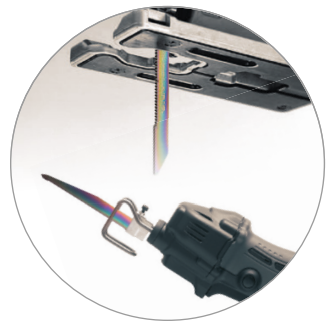
Specifications

Weight	500 kg
Power	380V 2,6 kW
Revolution	MAX6000 rpm (variable)
Feed rate	Variable
Saw blade diameter	Ø 115 mm
Applicable pipe size: outer diameter	Ø 10-120 mm
Applicable pipe size: thickness	0.5-10t (maximum thickness of Ø 30mm up to 5mm wall thickness)



DRYTECH® TCT AURORA SAW BLADES

JIG/Recipro Saw Blades



DRYTECH® TCT AURORA SAW BLADES

JIG/Recipro Saw Blades

Excellent cutting quality without delamination in Carbon Fibre Reinforced Plastics.

Advantages

- Produced in one shape
- Accurate Cutting Surface
- High Durability
- Also suitable in material with low melting point

Applicable on:

- on common Jig- and Recipro Saws

Suitable for:

- Carbon - fiber reinforced plastics
- Carbon - fiber reinforced thermo plastics
- Aramid - fiber reinforced plastics
- Glass - fiber composites

Specifications	Jig saw	Recipro saw
Item-Nr.	POLDTS11210	POLDTS11712TP
Length [mm]	100	117
Max. Cutting Depth [mm]	10	10
Body thickness [mm]	1,0	1,2
Stroke rate [min ⁻¹]	3.000	3.000

PVD COATINGS

bronze - silver - gold - grey - black



BRONZE

The natural substitute of bronze, is a multipurpose coating giving you a clear upgrade than a TIN coating due to the higher (HV) hardness and a lower friction coefficient.



SILVER

Best coating to cut stainless steels on semiautomatic and fully automatic machines. Can not be used on manual machines.



GOLD

Classic technology coating used to cut aluminum-silicium-compounds. Can not be used on copper, brass and bronze.



GREY

Best coating to cut solids and pipes with oil mist. Can not be used to cut soft steels with abundant coolant.



BLACK

Best coating to cut hard materials with dry cutting. Also applicable to cut pipes and profiles.

PVD COATINGS

PVD Coating	Surface Hardness	Oxidation temperature	Friction Coefficient	Description	Application	Processing	Line
Bronze	3500	800	0,2	nanostructure shock resistant	steel, stainless steel	dry cutting	drytech
Silver	3000	600	0,4	abraision resistance	stainless steel, non-ferrous	dry cutting	drytech
Gold	2800	600	0,5	nanostructure abraision resistant	aluminum with higher silicium content	micro lubrication	drytech Alu
Grey	3500	900	0,7	nanostructure anti-oxydation resistance	steel, stainless steel, high tensile	micro lubrication	TH - LBS
Black	3900	900	0,7	nanostructure anti-oxydation resistance	steel, stainless steel	dry cutting	drytech

RESHARPENING AND REPLACEMENT OF CARBIDE TEETH

We offer you resharpening, carbide tip replacement and coating services for

- carbide tipped saw blades,
- VHM carbide saw blades
- HSS saw blades
- Core Drills
- milling cutter

Further we provide special saw teeth geometries and customized center and pin holes

Process lead time : 5 working days

We are delighted to receive your inquiry.

I.T.E.C.
CUTTING SOLUTIONS

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