

QUALITY PERFORMANCE PRECISION

SAW BLADES

lames de scie



ROYCE//AYR
Royce-Ayr Cutting Tools Inc.



ISO 9001:2008
registered

SATISFACTION GUARANTEED

Limited Warranty

All items in the Royce//Ayr catalogue, unless otherwise noted, are warranted for 90 days against defects in workmanship and materials. Normal wear and tear or use of a tool for other than the intended purpose is not covered by this warranty. Merchandise may be returned to Royce//Ayr Cutting Tools for repair or replacement at our option. Royce//Ayr liability is limited to repair or replacement of the merchandise. In no event shall Royce//Ayr be liable for any incidental or consequential damages.

Special Items

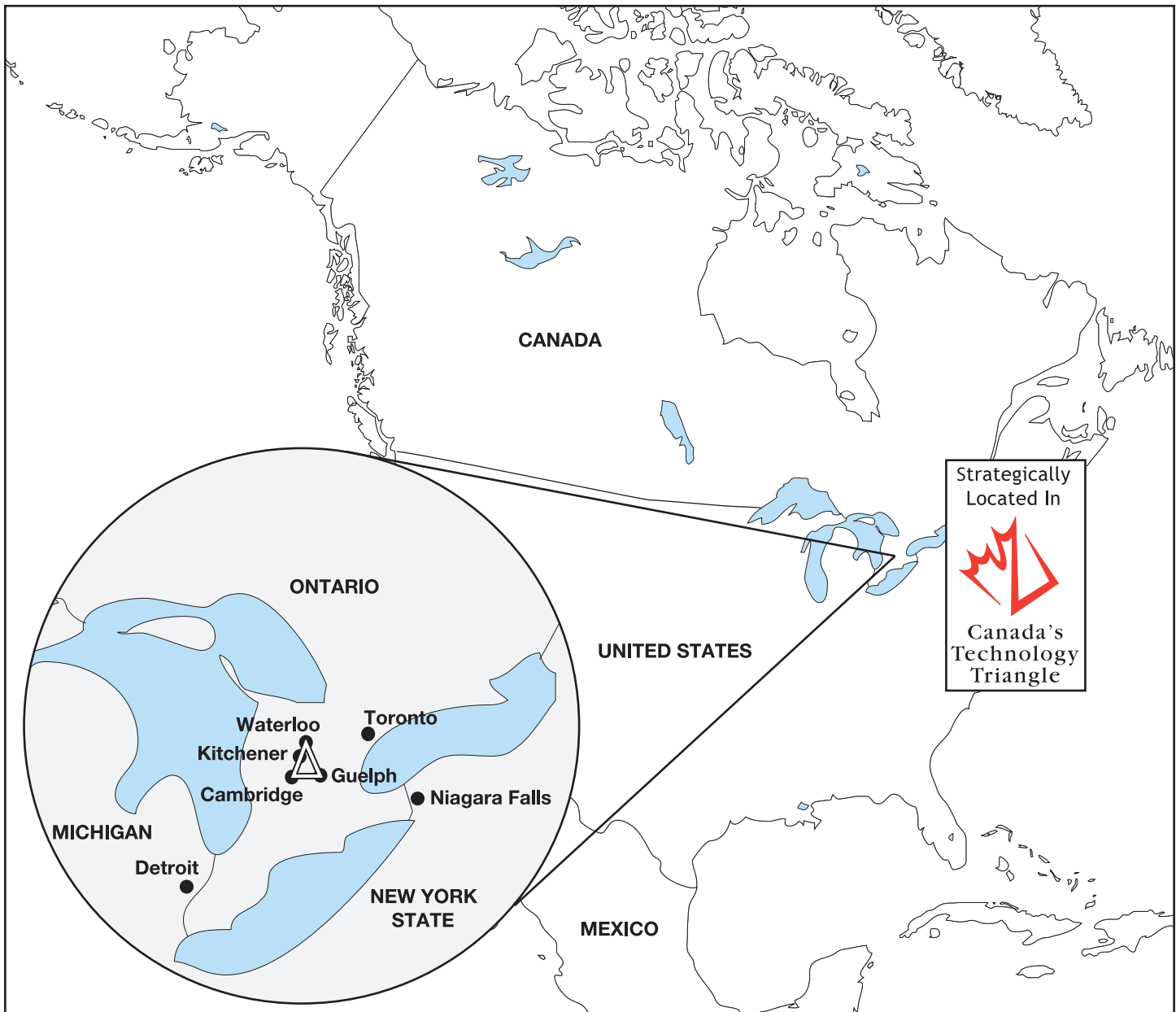
Special items are those not in the Royce//Ayr catalogue and are special ordered for the customer. These items are covered by our limited warranty. If a special item is defective, it is covered like any other catalogue item.

Custom Items

Custom items are those that are made to our customer's specifications and are not normally carried by Royce//Ayr or the manufacturer. The customer is responsible to make sure his specifications meet his needs. These items cannot be returned unless there is a defect in workmanship or materials.

No Sale is Final

If you have a problem with an order you placed with Royce//Ayr, please call. We want you to be satisfied with our products and service.



INDEX

Series	Description	Page
S-02	Universal Cut-Off Saw Blades "ATB"	8 & 9
S-02M	Melamine Saw Blades "ATB"	9
S-03	Universal Cut-Off Saw Blades "TCG"	10 & 11
S-03M	Solid Surface & Laminate Cutting Saw Blades "TCG"	11
S-04	Melamine Saw Blades (Hollow Ground)	7
S-05U	"Ultima" Panel Saw Blades	17 & 18
S-05UM	"Ultima Max" Panel Saw Blades	19
	PANEL & SCORING SAW - MATCH UP CHART	22 & 23
S-06	Adjustable Scoring Saw Blades	21
S-07	Tapered Scoring Saw Blades	21
S-07U	"Ultima" Tapered Scoring Saw Blades	20
S-08	Universal Scoring Saw Blades	23
S-09	Euro-Style Rip Saw Blades	3
S-10	Standard Rip Saw Blades	4
S-10TK	Thin-Kerf Rip Saw Blades	4
S-10W	Multi-Rip Saws with Wiper Blades (Strobe Style) - Made to Order	3
S-11	Easy-Cut Rip Saw Blades	5
S-12	Glue Joint Rip Saw Blades	5
S-13	Radial Arm Saw Blades	6
S-14	Combination Saw Blades	7
S-15	Double End Trim Saw Blades	12
S-16	Mitre Joint Saw Blades (for Wood)	12
S-17	Rescue/Emergency Saw Blades	6
S-18	Optimizer Saw Blades - V-Top	13
S-19	Nail-Biter, Construction Saw Blades	6
S-20TK & S-21TK	Thin-Kerf Saw Blades "TCG" & "ATB"	13
S-22 & S-23	Thin-Rim Saw Blades "TCG" & "ATB"	14
S-25	Plastic Cutting Saw Blades	14
S-26	Portable Air Saw Blades	15
S-27	Mitre Joint Saw Blades (for Plastic/Aluminum)	15
S-28	Non-Ferrous Metal Saw Blades	16
S-29	Steel Cutting Saw Blades - C/T	16
S-30 & S-31	Dado Sets & Replacement Parts	25
S-32	Lamello Style Groovers	27
S-35	Grooving Saw Blades (Metric & Imperial)	26
S-36	Edge-Banding Saw Blades	24
S-37	Segmented Hoggers & Accessories	28
P-10	Rip Saw Blades	29
P-12	Glue Joint Rip Saw Blades	29
P-14	Combination Saw Blades	30
P-16	Mitre Joint Saw Blades	30
P-17	Cut-Off Saw Blades "ATB"	30
P-17	Trim Saw Blades "ATB"	31
P-18	Thin Kerf Mitre Joint Saw Blades	31
P-21	Cut-Off Saw Blades "TCG"	31
P-21	Trim Saw Blades "TCG"	32
P-22	Melamine Saw Blades	32
P-23	Solid Surface Saw Blades	32
P-26	General Purpose Saw Blades	33
P-28	Non-Ferrous Saw Blades	33
	Technical Information	39 & 40
C-31	HSS Coldsaw Blades	35
	SELECTION GUIDE FOR HSS COLDSAW BLADES	36
M-32	HSS Metal Saw Blades	34
S-33	HSS Segmental Saw Blades & Segments	37
F-34	CV-Friction Saw Blades	37
122	HSS Circular Knives - Made to Order	38
580's	Saw Accessories (Bushings, Shims, Flanges)	27

About our product:

Royce//Ayr carbide tipped saw blades are made of the highest quality, heat treated saw steel and all blades are carefully tensioned to operate at the required RPM and load conditions. Fine grain, high tensile, tungsten carbide tips are brazed with a high strength silver cadmium alloy to ensure bond on each setting surface. All tips are precision ground and honed.

Blade type

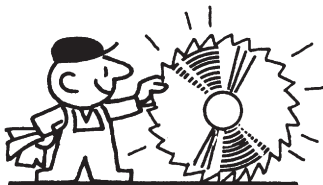
Blade type, the particular number of teeth, design of teeth and grade of carbide must be selected according to the specific application to achieve maximum performance.

Note: To obtain a minimum of vibration on saw blades we suggest that saw flanges should be one half or at least one third of the diameter of the saw blade used. Cleaning and service in good time will maintain performance of saw blades throughout the blade's entire life.

Ask for **Royce//Ayr "Pitch Off"** an excellent non-toxic pitch remover.

Important details for ordering

- Type of saw blade
- Diameter
- Kerf
- Size of bore
- If required, dimensions and number of keyways
- Diameter, and position of pinholes (measure center to center)
- Number of teeth
- Material to be cut
- R.P.M.
- Rate of feed in ft./sec.
- Mechanical or hand fed



Technical Service

The **Royce//Ayr** range of carbide-tipped circular saws covers the majority of operations in industries working with timber, fiberboard, chipboard, plywood, wallboard, veneered and laminated sheets, plasterboard, and different types of plastics.

Royce//Ayr have acquired experience in catering to a variety of customers—sawmills, joinery mills, manufacturers of different kinds of board, mechanical industries, plastic industries, furniture factories, etc. This wealth of experience is at your disposal. If you are doubtful about the choice of tools, we can advise and help—all we need is the following information: type of material, thickness of materials, and whether it is going to be worked with or across the grain; feed rate, spindle speed, and the maximum and minimum acceptable blade diameters. When ordering, also state the diameter of the center hole, and give details of pinholes or keyways.

Care of Tools

Royce//Ayr carbide-tipped blades are precision tools, and must be looked after if they are to retain their accuracy and capacity.

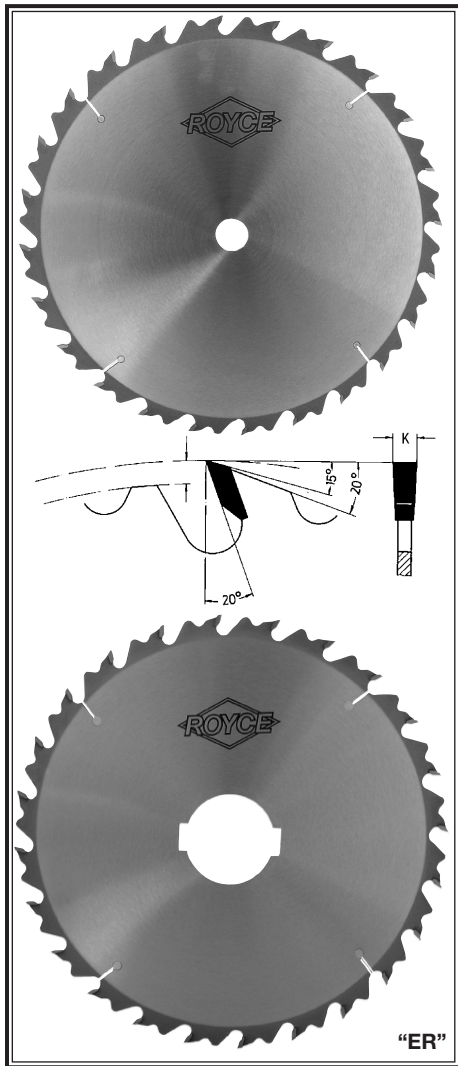
Assembly: The saw blades should always be handled carefully, especially the carbide-tipped edges, which can easily be damaged by heavy blows or jolts. A blade should therefore never be laid on a hard surface, and a little extra care should be taken when fitting them into the machine. It is important that the diameter of the flange should be as large as possible—preferably minimum one-third of the diameter of the blade.

Feeding: The feed rate should be within the limits recommended by **Royce//Ayr**. The material should be fed parallel to the blade—oblique feeding can damage the teeth and scorch the blade.

Cleaning and Storing. Resin and the like, which readily fastens onto the sides of the blade, can often cause overheating. This can result in the blade buckling, or even cracking. The blade should therefore always be kept clean. This is best done by using **"Pitch Off"**—never scrape the blade clean with a hard utensil. When the blade is not in use, it should be kept in the original carton—cleaned and well-oiled to prevent rusting.

Re-sharpening and Re-conditioning: It is uneconomical to continue using a blade which has become dulled. In this way the teeth can be damaged, with the result that an unnecessarily large amount of the carbide tipping must be ground off in sharpening, which reduces the life of the blade. A

Royce//Ayr specialist should therefore be contacted in good time, so that the blades can be restored to its original condition quickly and competently. Sharpening of these blades is precision work which entails the use of special equipment.



S-09 METRIC RIP SAW BLADES WITH CHIP LIMITER

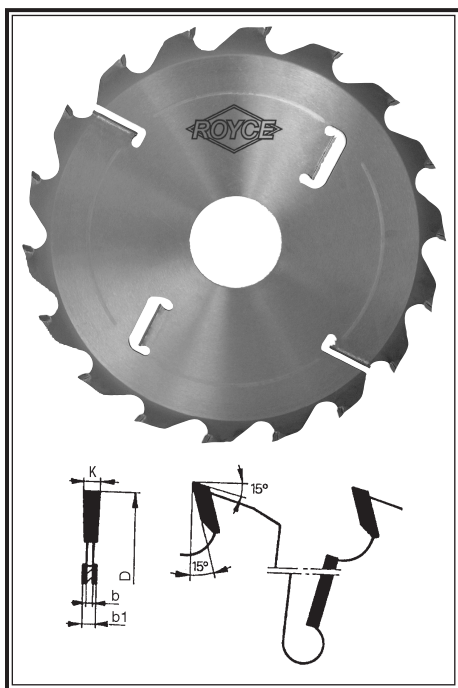
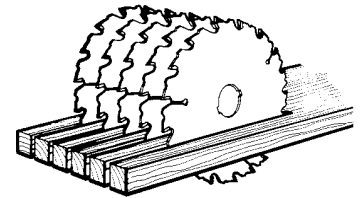
PART NO. STANDARD	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	TEETH
09250240	• 250	2.2	.087	3.2	.126	5/8"	24
09300281	• 300	2.2	.087	3.2	.126	1"	28
09350321	• 350	2.5	.098	3.5	.138	1"	32
09400361	• 400	2.8	.110	3.8	.150	1"	36
09450401	450	2.8	.110	4.0	.157	1"	40
09500441	500	3.0	.118	4.2	.165	1"	44

S-09 METRIC RIP SAW BLADES WITH CHIP LIMITER

PART NO. STANDARD	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	KEYWAY	TEETH
09250247	• 250	2.2	.087	3.2	.126	70MM	2KW-20X5	24
09300287	• 300	2.2	.087	3.2	.126	70MM	2KW-20X5	28
09350327	• 350	2.5	.098	3.5	.138	70MM	2KW-20X5	32

Use for ripping soft and hard woods on table and/or multiple-rip saws. Chip limiter prevents kickback and increases stability.

Pour la coupe en long de bois massif sur machines mono ou multilames. Forme de dent avec refouleur pour une bonne stabilité et une limitation de l'épaisseur du copeau.



S-10W RIP SAW BLADES WITH WIPER SLOTS

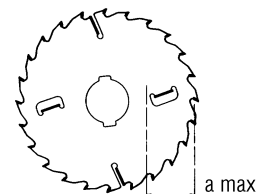
PART NO. STANDARD	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	KEYWAY	TEETH	"A"=MAX
101010W	10	2.2	.087	3.2	.126	TBA	TBA	10+2	2"
101010W-H	10	2.5	.098	3.5	.138	TBA	TBA	10+2	2"
101212W	12	2.2	.087	3.2	.126	TBA	TBA	12+2	2-1/2"
101212W-H	12	2.5	.098	3.5	.138	TBA	TBA	12+2	2-1/2"
101414W	14	3.0	.118	4.3	.169	TBA	TBA	14+2	3"
101416W	14	3.0	.118	4.3	.169	TBA	TBA	16+2	3"

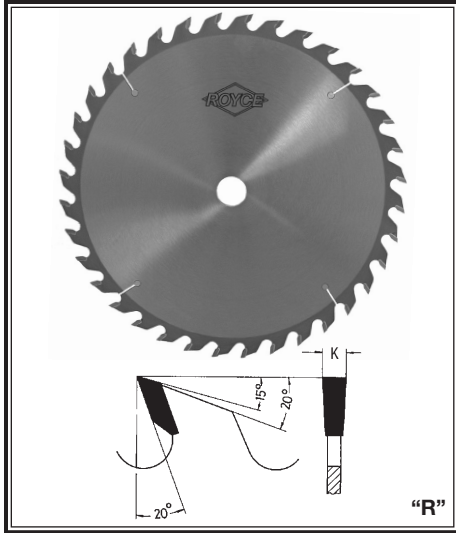
For longitudinal cutting of non-seasoned solid woods. Wiper slots help to make deeper cuts and keep the lumber separated while cutting.

Pour le délignage en long dans le bois massif. Éléments de stabilisation sont très avantageux dans les bois gelés ou humides.

Note: S-10W available only on special order, and are also available with 2+2 wiper slots.

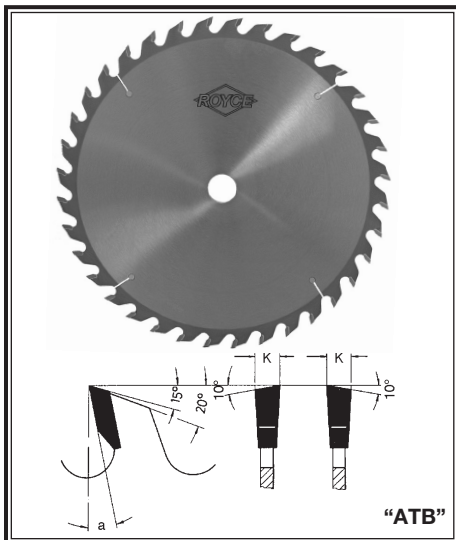
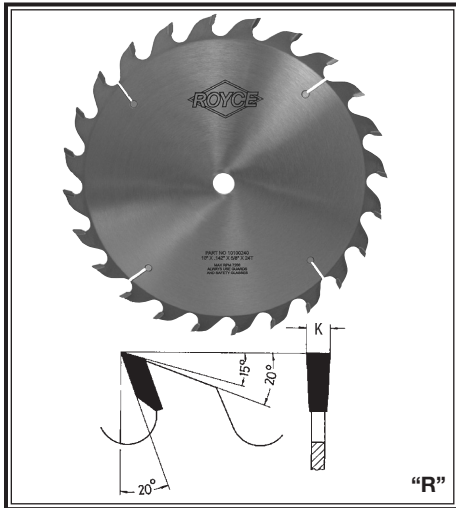
Fabriquer a mesure.





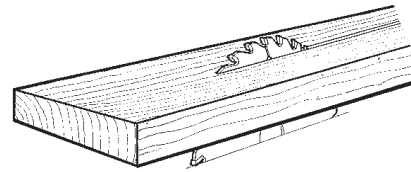
"R" - STANDARD RIP SAW BLADES for ripping soft and hardwoods. Suitable for table saws and multiple rip saws.

SCIE CIRCULAIRE À REFENDRE pour coupes longitudinales de bois durs et tendres.



S-10 STANDARD RIP SAW BLADES

PART NO. STANDARD	PART NO. ULTIMA	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	TEETH
10080240	•	8	2.2	.087	3.4	.134	5/8"	24
10090240	•	9	2.2	.087	3.4	.134	5/8"	24
10100240	• 10100240U	• 10	2.4	.094	3.6	.142	5/8"	24
10120241	• 10120241U	• 12	2.8	.110	4.0	.157	1"	24
10120301	• 10120301U	• 12	2.8	.110	4.0	.157	1"	30
10140241	•	14	3.0	.118	4.3	.170	1"	24
10140301	• 10140301U	• 14	3.0	.118	4.3	.170	1"	30
10140361	•	14	3.0	.118	4.3	.170	1"	36
10160301	•	16	3.0	.118	4.3	.170	1"	30
10160361	•	16	3.0	.118	4.3	.170	1"	36
10180361	•	18	3.4	.134	4.7	.185	1"	36



S-10 STANDARD RIP SAW BLADES FOR MULTIPLE SAWS

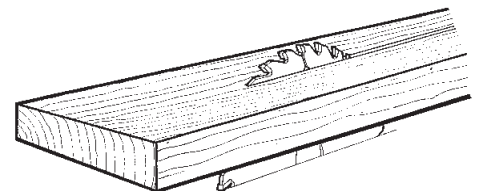
PART NO. STANDARD	PART NO. ULTIMA	DIAM. IN./MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	KEYWAY	TEETH
10100247	•	10	2.4	.094	3.6	.142	70MM	2KW-20X5	24
10300288*	10300288U*	300	2.2	.087	3.4	.134	80MM	2KW+6PH	28
10120247	•	12	2.8	.110	4.0	.157	70MM	2KW-20X5	24
10120307	•	12	2.8	.110	4.0	.157	70MM	2KW-20X5	30
10140307	•	14	3.0	.118	4.3	.170	70MM	2KW-20X5	30

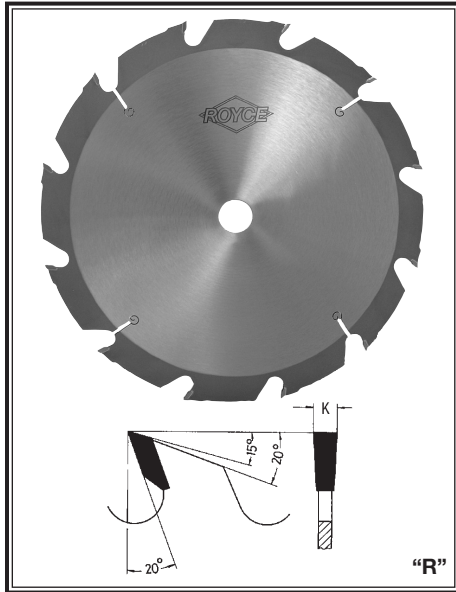
* RAIMANN

S-10TK THIN KERF RIP/ CROSSCUT SAW BLADES

PART NO. STANDARD	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	TEETH
10080340TK	8	1.6	.063	2.4	.095	5/8"	34
10100400TK	10	1.6	.063	2.4	.095	5/8"	40
10120481TK	12	1.8	.071	2.6	.102	1"	48
10140541TK	14	1.8	.071	2.6	.102	1"	54

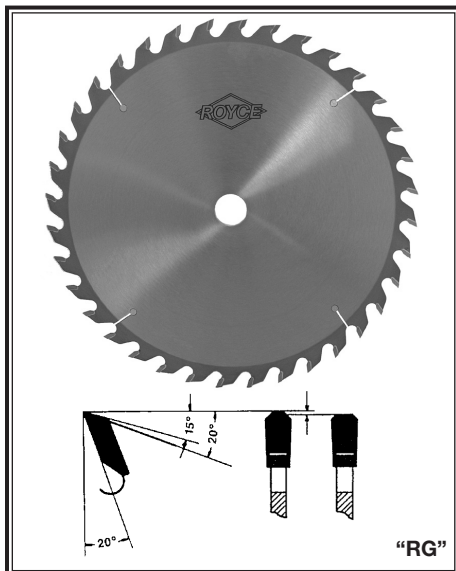
Note: Do not use to cut over 3/4" material without the use of saw blade stabilizers





“EZ” - EASY CUT RIP SAW for ripping all woods in heavy duty application. Suitable for high speed ripping and wet lumber operations.

SCIE CIRCULAIRE À REFENDRE pour coupes longitudinales de bois sec et humide.



“RG” - TRIPLE CHIP TOOTH for perfect glue joints on soft or hardwoods, especially suited for straight line rip saws.

SCIE CIRCULAIRE À REFENDRE Indiquées pour obtenir un bon finissage dans les coupes longitudinales. Elles sont recommandées sur des machines à avance mécanique pour exécuter des joint de colle.

S-11 EASY-CUT RIP SAW BLADES

PART NO. STANDARD		DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
11080100	•	8	2.2	.087	3.5	.138	5/8"	20	10
11090100	•	9	2.2	.087	3.5	.138	5/8"	20	10
11100100	•	10	2.2	.087	3.5	.138	5/8"	20	10
11120121	•	12	2.6	.102	3.9	.154	1"	20	12
11140141	•	14	3.0	.118	4.3	.170	1"	20	14
11160161	•	16	3.0	.118	4.3	.170	1"	20	16

S-12 GLUE JOINT RIP SAW BLADES

PART NO. STANDARD		PART NO. ULTIMA		DIAM. IN./MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
12080240	•			8	2.2	.087	3.4	.134	5/8"	20	24
12090240	•			9	2.2	.087	3.4	.134	5/8"	20	24
12100240	•	12100240U	•	10	2.4	.094	3.6	.142	5/8"	20	24
12100300	•			10	2.4	.094	3.6	.142	5/8"	20	30
12100423		12100423U		10	2.2	.087	3.2	.126	3-1/8"	20	42
12300288**	•	12300288U**		300	2.8	.110	4.0	.157	80MM	20	28
12300288TK**		12300288U-TK**		300	2.0	.080	2.8	.110	80MM	20	28
12300368**	•	12300368U**		300	2.8	.110	4.0	.157	80MM	20	36
12300368TK**		12300368U-TK**		300	2.0	.080	2.8	.110	80MM	20	36
12300488**		12300488U**		300	2.8	.110	4.0	.157	80MM	20	48
12300488TK**		12300488U-TK**		300	2.0	.080	2.8	.110	80MM	20	48
12300548**		12300548U**		300	2.8	.110	4.0	.157	80MM	15	54
12120361	•	12120361U	•	12	2.8	.110	4.0	.157	1"	20	36
12120361TK	•	12120361U-TK	•	12	2.2	.087	3.2	.126	1"	20	36
12120362*	•	12120362U*	•	12	2.8	.110	4.0	.157	2"	20	36
12120363^	•	12120363U^	•	12	2.8	.110	4.0	.157	3-1/8"	20	36
12120363TK^	•	12120363U-TK^	•	12	2.2	.087	3.2	.126	3-1/8"	20	36
12120367***	•	12120367U***	•	12	2.8	.110	4.0	.157	70MM	20	36
12120427TK		12120427U-TK		12	2.2	.087	3.2	.126	70MM	20	42
12120429TK		12120429U-TK^^		12	2.0	.080	2.8	.110	90MM	20	42
12330288**		12330288U**		330	2.8	.110	4.0	.157	80MM	20	28
12140361	•	12140361U		14	3.0	.118	4.3	.170	1"	20	36
12140362*	•	12140362U*		14	3.0	.118	4.3	.170	2"	20	36
12140363^		12140363U^		14	3.0	.118	4.3	.170	3-1/8"	20	36
12140367***		12140367U***		14	3.0	.118	4.3	.170	70MM	20	36
12360368**		12360368U**		360	3.0	.118	4.3	.170	80MM	20	36
12160361	•			16	3.0	.118	4.3	.170	1"	20	36

* DIEHL, 1-9/16" 5" BC

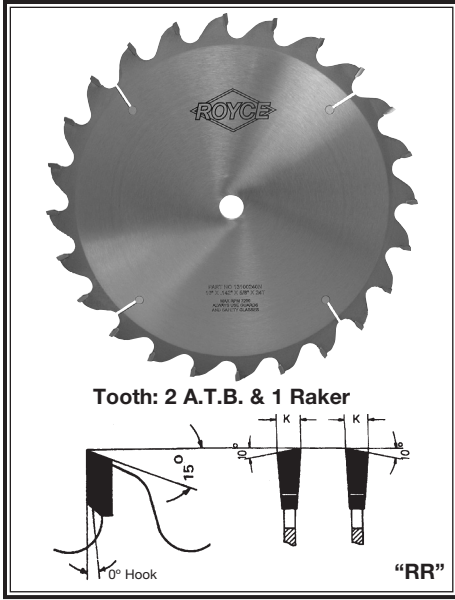
** RAIMANN, 2 KEYWAY 3.5 x 13.5, 6 PH's 2/13/100+, 4/6.5/95

*** SCM

^ MEREEN-JOHNSON, 1 KEYWAY 1/4 x 1/4, 12" DIA

^^ KENTWOOD, 2 KEYWAY, 6 PH's

S-13 RADIAL ARM / PENDULUM SAW BLADES

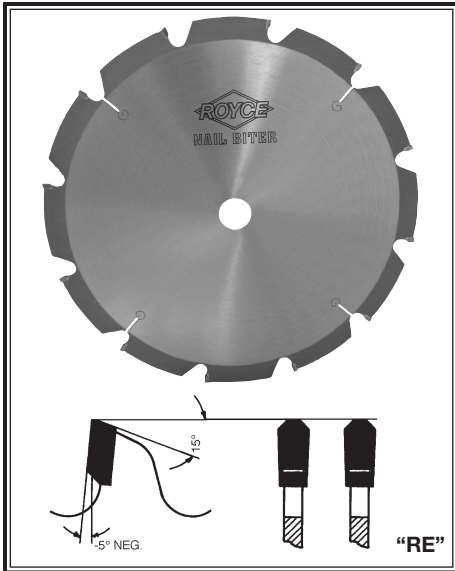


PART NO. STANDARD	PART NO. ULTIMA	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
13100240	• 13100240U	10	2.4	.094	3.6	.142	5/8"	0	24
13120301	• 13120301U	12	2.8	.110	4.0	.157	1"	0	30
13140361	• 13140361U	14	3.0	.118	4.2	.165	1"	0	36
13160401	•	16	3.0	.118	4.2	.165	1"	0	40

For cross cutting on radial arm saws and pendulum type saws.

Pour la coupe transvers sur scies radiales et scies à onglet.

S-17 RESCUE / EMERGENCY SAW BLADES



PART NO. STANDARD	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE INCH/MM	HOOK ANGLE	TEETH
17120122	• 12	2.6	.102	3.9	.154	20MM	-5	12
17120242	• 12	2.8	.110	4.1	.161	20MM	-5	24
17140241	• 14	3.0	.118	4.3	.169	1"	-5	24

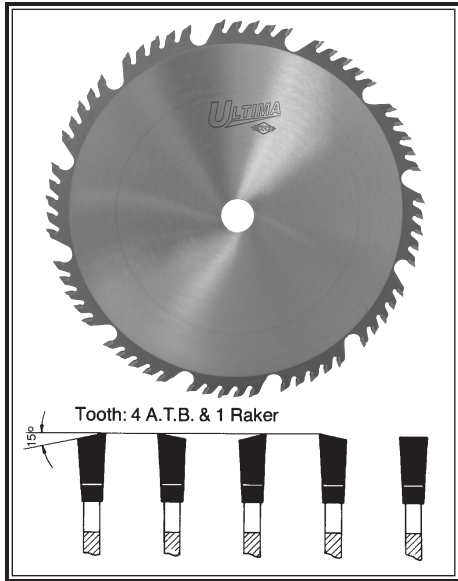
Designed for rough cutting applications.

N.B. Manufactured for: Homelite, Stihl, Partner, Hoffco, Neilson, McCullough, & other chainsaws.

S-19 NAIL-BITER SAW BLADES

PART NO. STANDARD	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
19100100	10	2.4	.094	3.6	.142	5/8"	-5	10
19100240	10	2.4	.094	4.0	.157	5/8"	0	24
19120121	12	2.6	.102	3.8	.150	1"	-5	12
19120241	12	2.8	.102	4.4	.173	1"	0	24
19140141	14	3.0	.118	4.3	.169	1"	-5	14
19140241	14	3.0	.118	4.6	.181	1"	0	24
19160161	16	3.0	.118	4.3	.169	1"	-5	16
19160301	16	3.4	.134	5.0	.197	1"	0	30
19160401	16	3.0	.118	4.3	.169	1"	-5	40
19180361	18	3.4	.134	4.8	.189	1"	-5	36

Note: Due to the rough applications for which these blades may be used they are not guaranteed.



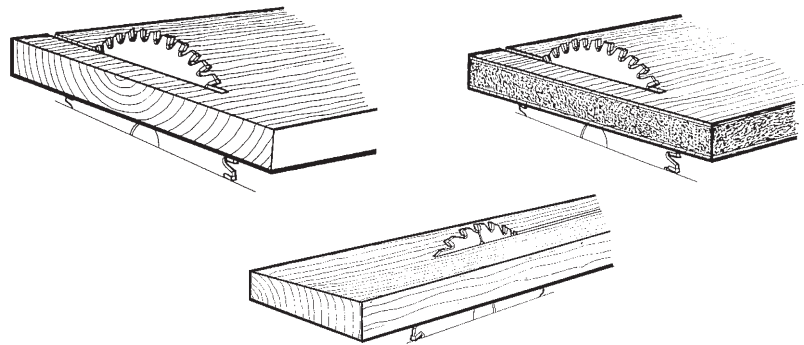
An all round saw for almost every use. This blade will rip, cross cut and mitre solid woods as well as cut particle board and plywood.

*SCIE CIRCULAIRE UNIVERSELLE
pour débits en travers et pour coupes
longitudinales*

S-14 COMBINATION SAW BLADES (4 A.T.B. + 1 RAKER)

PART NO. STANDARD	PART NO. ULTIMA		DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
14100500	• 14100500U	•	10	2.4	.094	3.6	.142	5/8"	15	50
14120601	• 14120601U	•	12	2.8	.110	4.0	.157	1"	15	60
14140701	• 14140701U		14	3.0	.118	4.2	.165	1"	15	70
14160801	•		16	3.0	.118	4.2	.165	1"	15	80
14180901	•		18	3.4	.134	4.6	.181	1"	15	90

N.B. For smaller diameters, refer to page 30

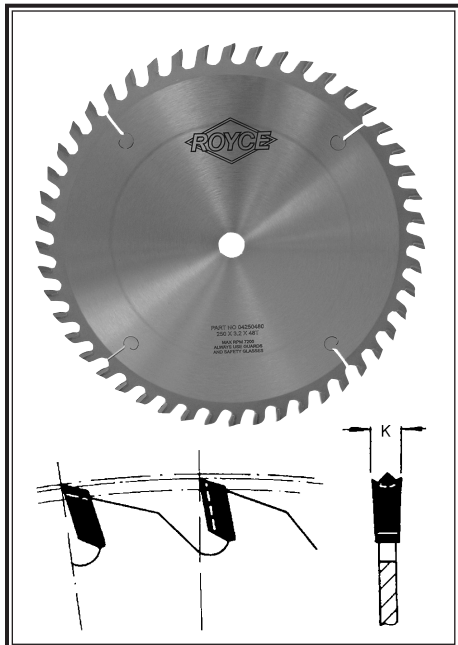


S-04 HOLLOW FACE SAW BLADES

PART NO. STANDARD		DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
04220420	•	220	2.2	.087	3.2	.126	5/8"	10	42
04220403**	•	220	2.2	.087	3.2	.126	30MM	10	42
04220403-N**	•	220	2.2	.087	3.2	.126	30MM	-5	42
04250480		250	2.2	.087	3.2	.126	5/8"	10	48
04250483**	•	250	2.2	.087	3.2	.126	30MM	10	48
04250483-N**		250	2.2	.087	3.2	.126	30MM	-5	48
04300600*		300	2.2	.087	3.2	.126	5/8"	10	60
04300601	•	300	2.2	.087	3.2	.126	1"	10	60
04350721	•	350	2.2	.087	3.2	.126	1"	10	72

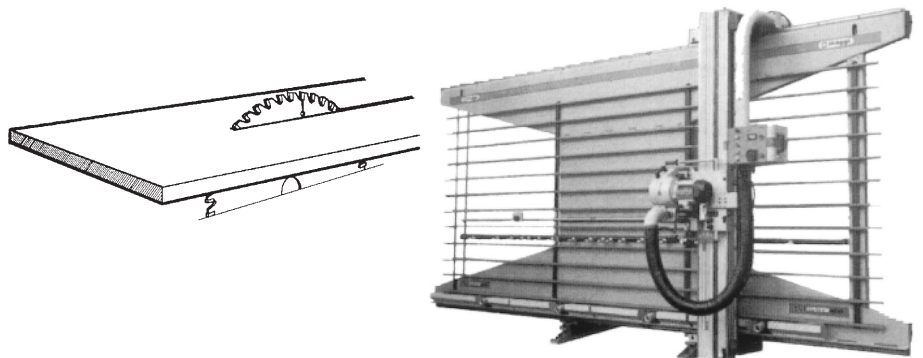
*PISTORIUS

**HOLZ-HER, STREIBIG

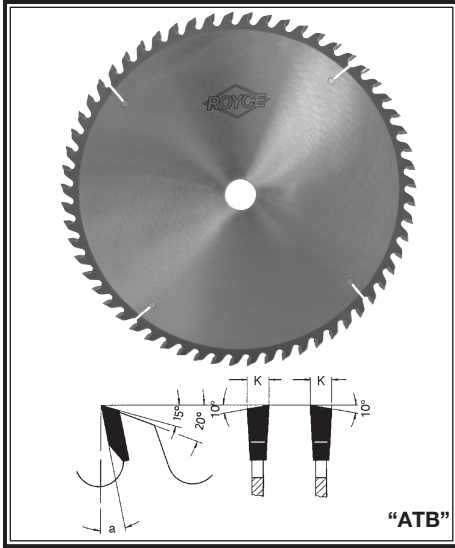


This specially designed saw blade will produce a perfect cut on both sides, without using a scoring blade on material such as: Melamine Panels, Vinyl Overlays, Plastic Laminated Plywoods, Particle Boards and Painted Wood Panels.

*SCIE AVEC DENTURE CONCAVE
pour le débit de panneaux lamifiés avec
mélamine sans l'usage de inciseur.*

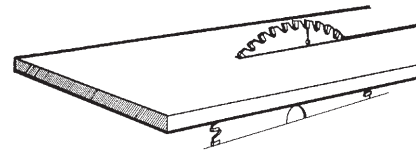
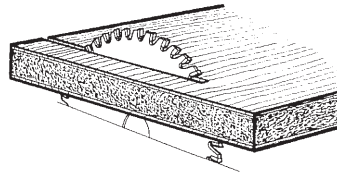


S-02 UNIVERSAL CUT OFF SAW BLADE



For precision sawing of solid woods, plywood and veneered panels as well as edging of doors.

*SCIE CIRCULAIRE UNIVERSELLE
pour le débit de panneaux contreplaqués et placages, pour
panneaux - fibres durs et tendres et pour panneaux stratifiés*



TYPE-02 (ATB GRIND) - STANDARD CUT

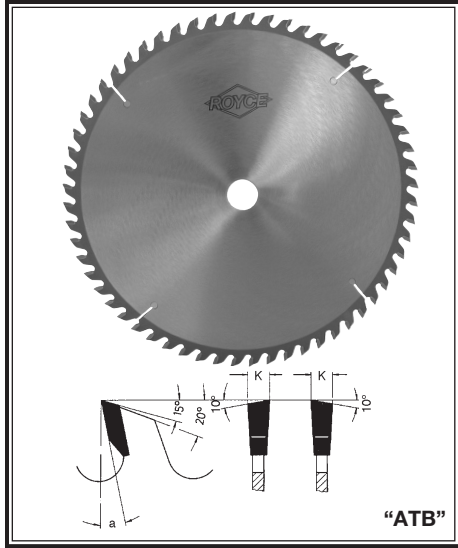
PART NO. STANDARD	PART NO. ULTIMA	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
02100480	•	10	2.2	.087	3.2	.126	5/8"	10	48
02120481	• 02120481U •	12	2.5	.098	3.5	.138	1"	15	48
02140601	• 02140601U •	14	2.5	.098	3.5	.138	1"	10	60
02140601H	• 02140601HU •	14	3.0	.118	4.0	.157	1"	10	60
02160601	• 02160601U •	16	3.0	.118	4.0	.157	1"	10	60
02180601	•	18	3.4	.134	4.6	.181	1"	10	60
02200801	•	20	3.4	.134	4.6	.181	1"	15	80

TYPE-02 (ATB GRIND) - MEDIUM CUT

PART NO. STANDARD	PART NO. ULTIMA	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
02080480	•	8	2.2	.087	3.2	.126	5/8"	10	48
02090480	•	9	2.2	.087	3.2	.126	5/8"	10	48
02100600	• 02100600U •	10	2.2	.087	3.2	.126	5/8"	10	60
02120601	• 02120601U •	12	2.5	.098	3.5	.138	1"	10	60
02120601H	• 02120601HU •	12	2.8	.110	3.8	.150	1"	10	60
02120801	• 02120801U •	12	2.5	.098	3.5	.138	1"	5	80
02140801	• 02140801U •	14	2.5	.098	3.5	.138	1"	10	80
02140801H	• 02140801HU •	14	3.0	.118	4.0	.157	1"	10	80
02160801	• 02160801U •	16	3.0	.118	4.0	.157	1"	10	80
02180801	•	18	3.4	.134	4.6	.181	1"	10	80
02201001	•	20	3.4	.134	4.6	.181	1"	10	100

TYPE-02 (ATB GRIND) - FINE CUT

PART NO. STANDARD	PART NO. ULTIMA	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
02080600	• 02080600U •	8	2.2	.087	3.2	.126	5/8"	5	60
02090600	• 02090600U •	9	2.2	.087	3.2	.126	5/8"	5	60
02100800	• 02100800U •	10	2.2	.087	3.2	.126	5/8"	5	80
02121001	• 02121001U •	12	2.5	.098	3.5	.138	1"	5	100
02141001	• 02141001U •	14	2.5	.098	3.5	.138	1"	5	100
02141001H	• 02141001HU •	14	3.0	.118	4.0	.157	1"	5	100
02161001	• 02161001U •	16	3.0	.118	4.0	.157	1"	5	100
02161201	• 02161201U •	16	3.0	.118	4.0	.157	1"	5	120
02181001	• 02181001U •	18	3.4	.134	4.6	.181	1"	10	100
02181201	• 02181201U •	18	3.4	.134	4.6	.181	1"	5	120
02201201	• 02201201U •	20	3.4	.134	4.6	.181	1"	10	120



For precision sawing of solid woods, plywood and veneered panels as well as edging of doors.

SCIE CIRCULAIRE UNIVERSELLE pour le débit de panneaux contreplaqués et placages, pour panneaux - fibres durs et tendres et pour panneaux stratifiés

S-02 (ATB GRIND) METRIC - MEDIUM CUT SAW BLADES

PART NO. STANDARD	PART NO. ULTIMA	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE PINHOLES	HOOK ANGLE	TEETH
02220483**	• 02220483U**	• 220	2.2	.087	3.2	.126	30+2/7/42	10	48
02250603	• 02250603U	• 250	2.2	.087	3.2	.126	30^	10	60
02300723*	• 02300723U*	• 300	2.5	.098	3.5	.138	30^	10	72
02350843	• 02350843U	• 350	2.5	.098	3.5	.138	30+2/10/60	10	84

* Altendorf, Omg, SCM, Streibig

** Holz-Her

^ Available with these pinholes: 2/7/42 + 2/9/46.35 + 2/10/60

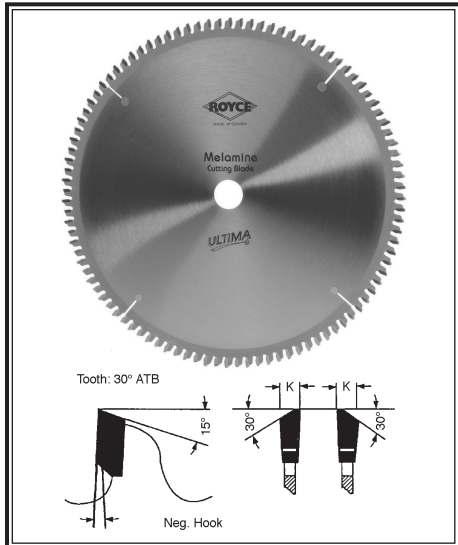
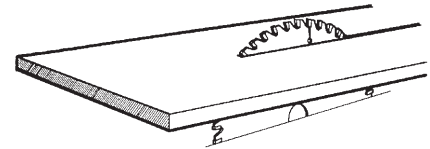
S-02 (ATB GRIND) METRIC - FINE CUT SAW BLADES

PART NO. STANDARD	PART NO. ULTIMA	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE PINHOLES	HOOK ANGLE	TEETH
02220643**	• 02220643U**	• 220	2.2	.087	3.2	.126	30+2/7/42	10	64
02250803	• 02250803U	• 250	2.2	.087	3.2	.126	30^	10	80
02300963*	• 02300963U*	• 300	2.5	.098	3.5	.138	30^	10	96
02351083	• 02351083U	• 350	2.5	.098	3.5	.138	30+2/10/60	10	108

* Altendorf, Omg, SCMI, Streibig

** Holz-Her

^ Available with these pinholes: 2/7/42 + 2/9/46.35 + 2/10/60



30° ATB grind recommended for chip-free top and bottom cuts in melamine or polyester boards, double faced high and low pressure laminates and printed or painted stock, where a scoring unit is not used.

Pour le débit de panneaux lamifiés avec mélamine, sans l'usage de inciseur.

S-02M MELAMINE SAW BLADES (HIGH ATB - NEGATIVE HOOK)

PART NO. STANDARD	PART NO. ULTIMA	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
02080600M	• 02080600MU	• 8	2.2	.087	3.0	.118	5/8"	-5	60
02090600M	• 02090600MU	• 9	2.2	.087	3.0	.118	5/8"	-5	60
02100800M	• 02100800MU	• 10	2.2	.087	3.0	.118	5/8"	-5	80
02121001M	• 02121001MU	• 12	2.5	.098	3.3	.130	1"	-5	100
02141001M	• 02141001MU	• 14	2.5	.098	3.3	.130	1"	-5	100
02161201M	• 02161201MU	• 16	3.2	.126	4.2	.165	1"	-5	120

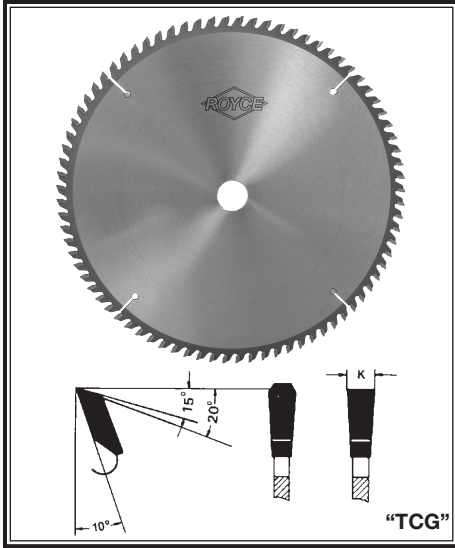
S-02M METRIC - MELAMINE SAW BLADES (HIGH ATB - NEGATIVE HOOK)

PART NO. STANDARD	PART NO. ULTIMA	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE PINHOLES	HOOK ANGLE	TEETH
02220643M*	• 02220643MU*	• 220	2.2	.087	3.0	.118	30+2/7/42	-5	64
02250803M	• 02250803MU	• 250	2.2	.087	3.0	.118	30^	-5	80
02300963M	• 02300963MU	• 300	2.5	.098	3.3	.130	30^	-5	96

* Holz-Her

^ Available with these pinholes: 2/7/42 + 2/9/46.35 + 2/10/60

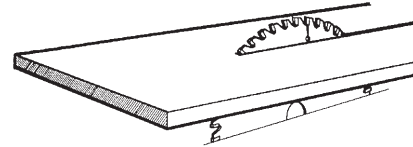
S-03 SAW BLADES FOR RAW AND LAMINATED PANELS



This saw blade is recommended over the "S-02" type on abrasive materials. The T.C.G. grind will last longer and give you the finest cut on plastic laminated boards, laminated plywood-chipboard, arborite, formica and other plastic materials.

SCIE CIRCULAIRE POUR PANNEAUX STRATIFIÉS

Indiquées pour le sectionnement et l'équarrissage de précision de panneaux recouverts de laminé des deux côtés, laminés en bois avec matières plastiques.



TYPE-03 (TC GRIND) - STANDARD CUT

PART NO. STANDARD	PART NO. ULTIMA	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
03100480	• 03100480U	10	2.2	.087	3.2	.126	5/8"	10	48
03120481	•	12	2.5	.098	3.5	.138	1"	15	48
03140601	• 03140601U	• 14	2.5	.098	3.5	.138	1"	10	60
03140601H	• 03140601HU	• 14	3.0	.118	4.0	.157	1"	10	60
03160601	• 03160601U	• 16	3.0	.118	4.0	.157	1"	10	60
03180601	•	18	3.4	.134	4.6	.181	1"	10	60
03200801	•	20	3.4	.134	4.6	.181	1"	15	80

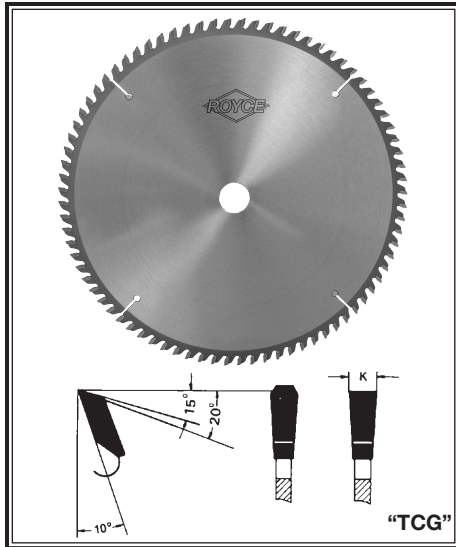
TYPE-03 (TC GRIND) - MEDIUM CUT

PART NO. STANDARD	PART NO. ULTIMA	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
03080480	•	8	2.2	.087	3.2	.126	5/8"	10	48
03090480	•	9	2.2	.087	3.2	.126	5/8"	10	48
03100600	• 03100600U	• 10	2.2	.087	3.2	.126	5/8"	10	60
03120601	• 03120601U	• 12	2.5	.098	3.5	.138	1"	10	60
03120601H	• 03120601HU	• 12	2.8	.110	3.8	.150	1"	10	60
03120801	• 03120801U	• 12	2.5	.098	3.5	.138	1"	5	80
03140801	• 03140801U	• 14	2.5	.098	3.5	.138	1"	10	80
03140801H	• 03140801HU	• 14	3.0	.118	4.0	.157	1"	10	80
03160801	• 03160801U	• 16	3.0	.118	4.0	.157	1"	10	80
03180801	• 03180801U	• 18	3.4	.134	4.6	.181	1"	10	80
03201001	• 03201001U	• 20	3.4	.134	4.6	.181	1"	10	100

TYPE-03 (TC GRIND) - FINE CUT

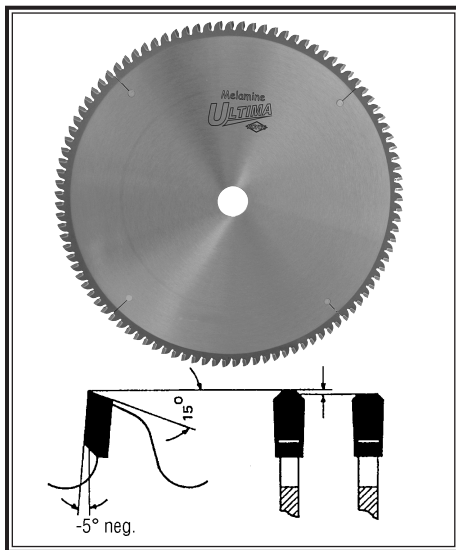
PART NO. STANDARD	PART NO. ULTIMA	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
03080600	• 03080600U	• 8	2.2	.087	3.2	.126	5/8"	5	60
03090600	• 03090600U	• 9	2.2	.087	3.2	.126	5/8"	5	60
03100800	• 03100800U	• 10	2.2	.087	3.2	.126	5/8"	5	80
03100800H	• 03100800HU	• 10	3.0	.118	4.0	.157	5/8"	5	80
03101000	•	10	2.0	.079	3.0	.118	5/8"	5	100
03121001	• 03121001U	• 12	2.5	.098	3.5	.138	1"	5	100
03141001	• 03141001U	• 14	2.5	.098	3.5	.138	1"	5	100
03141001H	• 03141001HU	• 14	3.0	.118	4.0	.157	1"	5	100
03161001	• 03161001U*	• 16	3.0	.118	4.0	.157	1"	5	100
03161001H	• 03161001HU	• 16	3.4	.134	4.8	.188	1"	5	100
03161201	• 03161201U*	• 16	3.0	.118	4.0	.157	1"	5	120
03181001	• 03181001U*	• 18	3.4	.134	4.6	.181	1"	10	100
03181201	• 03181201U*	• 18	3.4	.134	4.6	.181	1"	5	120
03201201	• 03201201U*	• 20	3.4	.134	4.6	.181	1"	10	120

* FOR COUNTER TOP MACHINES



For the cutting of hardboard and medium-density board; for plastic and high-pressure laminated chip board for plastics. Max. thickness 25mm.

Pour le débit de panneaux-fibres durs et tendres et lamifiés et de particules stratifiés. Pour matières plastiques. Hauteurs max 25mm.



Recommended for chip-free top and bottom cuts in melamine or polyester boards, double faced high and low pressure laminates and printed or painted stock, where a scoring unit is not used.

Pour le débit de panneaux lamifiés avec mélamine, sans l'usage de inciseur.

S-03 (TC GRIND) METRIC - MEDIUM CUT SAW BLADES

PART NO. STANDARD	PART NO. ULTIMA	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE PINHOLES	HOOK ANGLE	TEETH
03220483	• 03220483U	• 220	2.2	.087	3.2	.126	30+2/7/42	10	48
03250603	• 03250603U	• 250	2.2	.087	3.2	.126	30^	10	60
03300723*	• 03300723U*	• 300	2.5	.098	3.5	.138	30^	10	72
03350843	• 03350843U	• 350	2.5	.098	3.5	.138	30+2/10/60	10	84

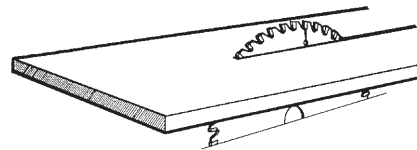
* Altendorf, Omega, SCM

^ Available with these pinholes: 2/7/42 + 2/9/46.35 + 2/10/60

S-03 (TC GRIND) METRIC - FINE CUT SAW BLADES

PART NO. STANDARD	PART NO. ULTIMA	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE PINHOLES	HOOK ANGLE	TEETH
03220643	• 03220643U	• 220	2.2	.087	3.2	.126	30+2/7/42	10	64
03250803	• 03250803U	• 250	2.2	.087	3.2	.126	30^	10	80
03300963	• 03300963U	• 300	2.5	.098	3.5	.138	30^	10	96
03351083	• 03351083U	• 350	2.5	.098	3.5	.138	30+2/10/60	10	108

^ Available with these pinholes: 2/7/42 + 2/9/46.35 + 2/10/60



S-03M SOLID SURFACE BLADES (TC GRIND - NEGATIVE HOOK)

PART NO. STANDARD	PART NO. ULTIMA	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
03080600M	• 03080600MU	• 8	2.2	.087	3.2	.126	5/8"	-5	60
03100800M	• 03100800MU	• 10	2.2	.087	3.2	.126	5/8"	-5	80
03120801M	• 03120801MU	• 12	2.5	.098	3.5	.138	1"	-5	80
03121001M	• 03121001MU	• 12	2.5	.098	3.5	.138	1"	-5	100
03141001M	• 03141001MU	• 14	2.5	.098	3.5	.138	1"	-5	100
03161001M	• 03161001MU	• 16	3.2	.126	4.2	.165	1"	-5	100
03161201M*	• 03161201MU*	• 16	3.2	.126	4.2	.165	1"	-5	120
03181201M	• 03181201MU	• 18	3.4	.134	4.6	.181	1"	-5	120
03201201M	• 03201201MU	• 20	3.4	.134	4.6	.181	1"	-5	120

* FOR COUNTER TOP MACHINES

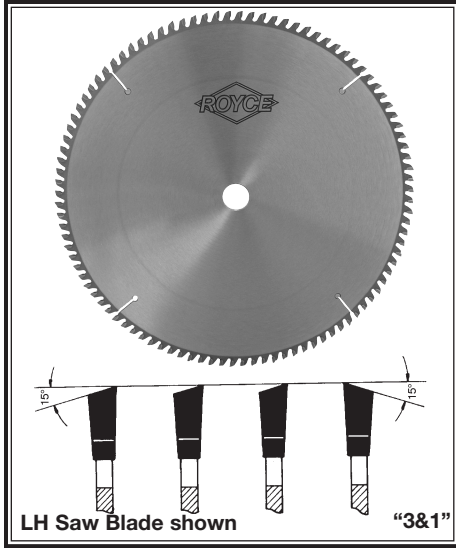
S-03M METRIC - SOLID SURFACE BLADES (TC GRIND - NEGATIVE HOOK)

PART NO. STANDARD	PART NO. ULTIMA	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE PINHOLES	HOOK ANGLE	TEETH
03220643M*	• 03220643MU*	• 220	2.2	.087	3.2	.126	30+2/7/42	-5	64
03250803M	• 03250803MU	• 250	2.2	.087	3.2	.126	30^	-5	80
	• 03300723MU**	• 300	2.5	.098	3.5	.138	30^	-5	72
03300963M	• 03300963MU	• 300	2.5	.098	3.5	.138	30^	-5	96

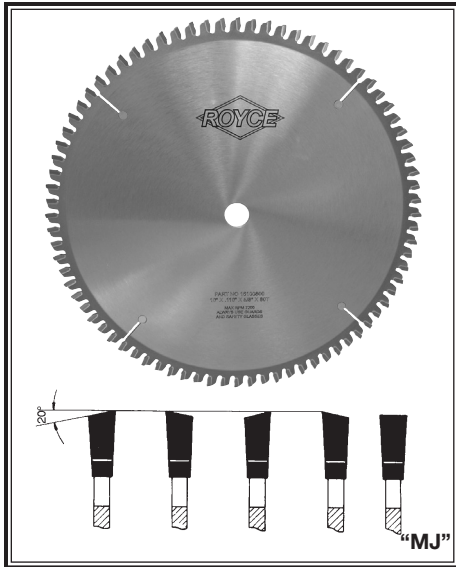
* Holz-Her

** Altendorf, Striebig

^ Available with these pinholes: 2/7/42 + 2/9/46.35 + 2/10/60



Exceptionally fine trim cuts are produced on the trim station of Double-End Tenoners with this special ground saw. The 3&1 Tooth Grind will cut soft and hard woods, composition, veneer, plastic, and others with equal quality finish.



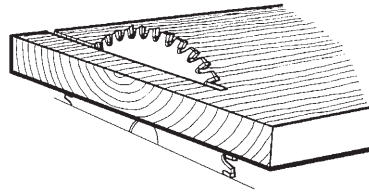
"MJ" - 20° ALTERNATE TOP BEVEL
For smooth, trim mitre cuts on mouldings, picture frames, furniture parts, and where angle cut finishes are critical.

*LAME CIRCULAIRE DE PRECISION.
Denture alternée en carbure. Exécution spéciale pour nombre et inclination des dents. Qualité de coupe optimale dans la coupe de profils à parois mince (matières plastiques) et moulures en bois. Utilisable sur scie à onglet.*

S-15 DOUBLE END TRIM SAW BLADES (3+1 GRIND)

PART NO. STANDARD	PART NO. ULTIMA	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH	SECTIONS LH + RH
15100600R/L	• 15100600UR/L	• 10	2.8	.110	4.0	.157	5/8"	5	60	45 + 15
15120801R/L	• 15120801UR/L	• 12	3.0	.118	4.2	.165	1"	5	80	60 + 20
15140801R/L	• 15140801UR/L	• 14	3.4	.134	4.6	.181	1"	5	80	60 + 20
15141001R/L	• 15141001UR/L	• 14	3.4	.134	4.6	.181	1"	5	100	75 + 25
15161001R/L	• 15161001UR/L	• 16	3.4	.134	4.6	.181	1"	5	100	75 + 25

Note: Choose saw blade from above and specify bore size required.

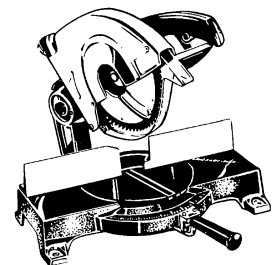


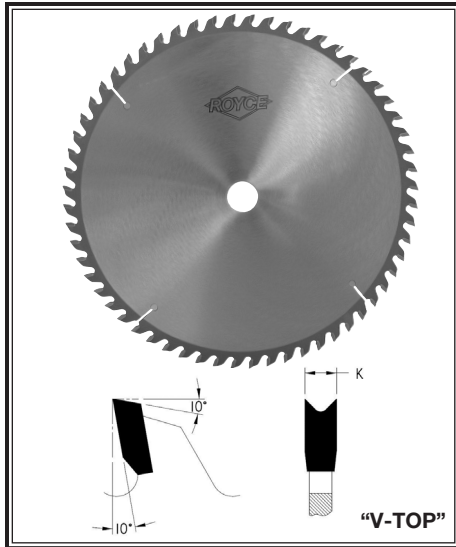
S-16 MITRE JOINT SAW BLADES (4 A.T.B. @ 20° + 1 RAKER)

PART NO. STANDARD	PART NO. ULTIMA	DIAM. INCH	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
16080600	•	8	205	2.2	.087	3.2	.126	5/8"	-5	60
16084600(a)	•	8-1/4	210	2.2	.087	3.2	.126	5/8"	-5	60
16085240(b)*	•	8-1/2	216	2.2	.087	3.2	.126	5/8"	-15	24
16085480(b)*	•	8-1/2	216	2.2	.087	3.2	.126	5/8"	-15	48
16085600(b)	•	8-1/2	216	2.2	.087	3.2	.126	5/8"	-5	60
16090600	•	9	230	2.2	.087	3.2	.126	5/8"	-5	60
16100600(c)	•	10	255	2.2	.087	3.2	.126	5/8"	-5	60
16100800(c)	• 16100800U	• 10	255	2.2	.087	2.8	.110	5/8"	-5	80
16101000(c)	•	10	255	2.2	.087	2.8	.110	5/8"	-5	100
16120800(d)(g)	•	12	305	2.5	.098	3.2	.126	5/8"	-5	80
16120801	•	12	305	2.5	.098	3.5	.138	1"	-5	80
16121000(d)	• 16121000U(d)	• 12	305	2.5	.098	3.2	.126	5/8"	-5	100
16121001	• 16121001U	• 12	305	2.5	.098	3.2	.126	1"	-5	100
16131003(e)	•	13	330	2.8	.110	3.8	.150	30MM	-5	100
16141000(d)	•	14	355	3.2	.126	3.8	.150	5/8"	-5	100
16141001	•	14	355	2.5	.098	3.5	.138	1"	-5	100
16151001(f)	•	15	380	2.8	.110	3.8	.150	1"	-5	100

*ATB GRIND

- (a) Ryobi, B&D
- (b) Elu, Hitachi
- (c) Delta, Makita
- (d) Pistorius, CTD
- (e) Wegoma, Haffner, Salvarani
- (f) Hitachi, Ryobi
- (g) Dewalt (Rebored to 1")





V-Top saw blades for trim perfect cuts on heavy wood parts and mouldings where crosscut finish is critical.

Les lames V-Top sont impeccables pour dégrossissage de bois coupant contre le grain.

S-18 OPTIMIZER SAW BLADES - V-TOP

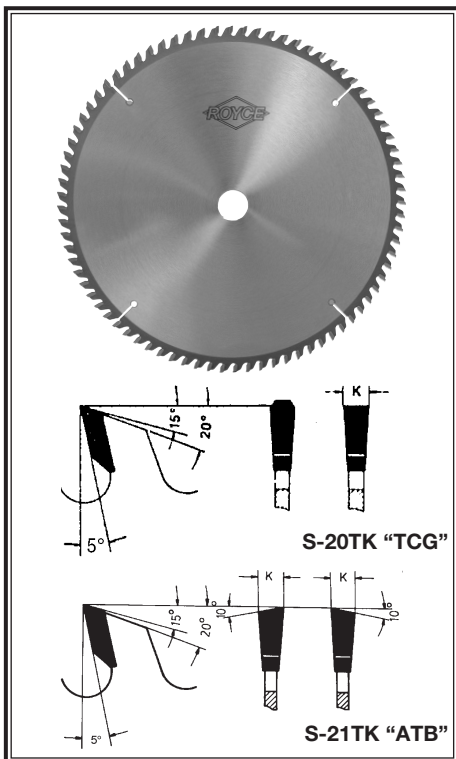
PART NO. STANDARD	DIAM. INCH	PLATE MM	KERF MM	KERF INCH	BORE IN./MM	TEETH	HOOK ANGLE	V-TOP ANGLE
18120601	12	2.5	3.5	.138	1"	60	10	45
18140601	14	2.5	3.5	.138	1"	60	10	45
18140801	14	2.5	3.5	.138	1"	80	10	45
18160801	16	3.0	4.0	.157	1"	80	10	45
18161001	16	3.0	4.0	.157	1"	100	10	45
18181001	18	3.4	4.6	.181	1"	100	10	45
18181201	18	3.4	4.6	.181	1"	120	10	45

S-20 THIN KERF SAW BLADES (TCG STYLE)

PART NO. STANDARD	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
20080600TK	• 8	1.6	.063	2.2	.087	5/8"	5	60
20100800TK	• 10	1.6	.063	2.2	.087	5/8"	5	80
20101000TK	• 10	1.6	.063	2.2	.087	5/8"	5	100
20121001TK	• 12	1.6	.063	2.2	.087	1"	5	100
20141201TK	• 14	1.8	.071	2.4	.095	1"	5	120

S-21 THIN KERF SAW BLADES (ATB STYLE)

PART NO. STANDARD	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
21080600TK	• 8	1.6	.063	2.2	.087	5/8"	5	60
21100800TK	• 10	1.6	.063	2.2	.087	5/8"	5	80
21101000TK	• 10	1.6	.063	2.2	.087	5/8"	5	100
21121001TK	• 12	1.6	.063	2.2	.087	1"	5	100
21141201TK	• 14	1.8	.071	2.4	.095	1"	5	120



“TCG” - TRIPLE CHIP GRIND

Used for finished work on expensive & abrasive materials such as acrylics and thin plastic extrusions where material saving is important. (max. thickness - 20mm)

“ATB” - ALTERNATE TOP BEVEL

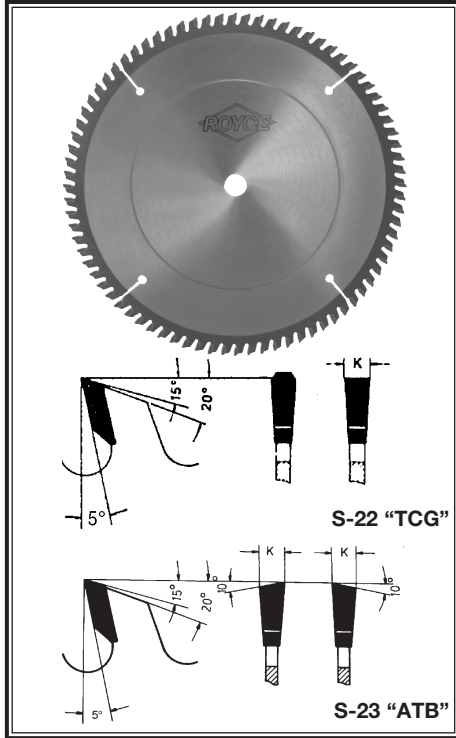
Used for finished work on expensive grained materials such as solid wood, plywood and veneers where material saving is important. (max. thickness -20mm)

S-22 THIN RIM SAW BLADES (TRIPLE CHIP STYLE)

PART NO. STANDARD		DIAM. INCH	RIM DEPTH	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
22080600	•	8	2"	.087	2.2	.087	5/8"	5	60
22100800	•	10	2"	.087	2.2	.087	5/8"	5	80
22120801	•	12	2"	.094	2.4	.094	1"	5	80
22121001	•	12	2"	.094	2.4	.094	1"	5	100

S-23 THIN RIM SAW BLADES (ATB STYLE)

PART NO. STANDARD		DIAM. INCH	RIM DEPTH	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
23080600	•	8	2"	.087	2.2	.087	5/8"	5	60
23100800	•	10	2"	.087	2.2	.087	5/8"	5	80
23120801	•	12	2"	.094	2.4	.094	1"	5	80
23121001	•	12	2"	.094	2.4	.094	1"	5	100



HIGH-EFFICIENCY THIN CIRCULAR SAW BLADE for the cutting of frames and plastics. (max thickness 20mm)

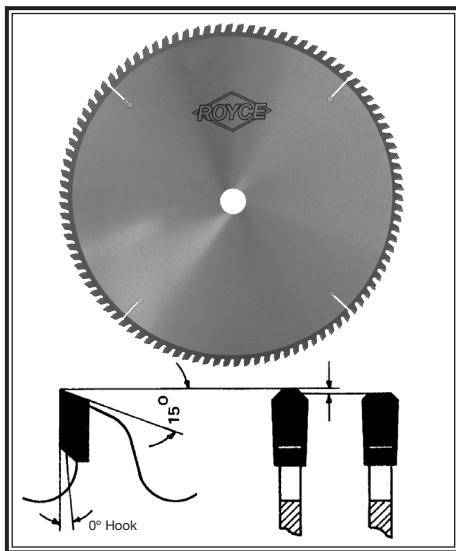
SCIE CIRCULAIRE MINCE À HAUTE RENDEMENT pour le débit de profiles et de matières plastiques jusqu'à 20mm.



S-25 PLASTIC CUTTING SAW BLADES "MELT FREE"

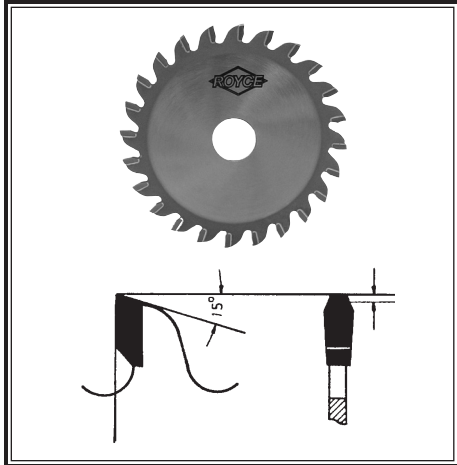
PART NO. STANDARD	PART NO. ULTIMA	DIAM. IN./MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE IN./MM	HOOK ANGLE	TEETH
25080600	• 25080600U	• 8	2.2	.087	2.7	.106	5/8"	0	60
25220643*	• 25220643U*	• 220	2.2	.087	2.7	.106	30+2/7/42	0	64
25100800	• 25100800U	• 10	2.2	.087	2.7	.106	5/8"	0	80
25121001	• 25121001U	• 12	2.5	.098	3.2	.126	1"	0	100
25141001	• 25141001U	• 14	3.0	.118	3.7	.146	1"	0	100
25161201	• 25161201U	• 16	3.2	.126	3.8	.150	1"	-5	120
25181201	• 25181201U	• 18	3.4	.134	4.0	.157	1"	-5	120

* Holz Her



Designed and recommended for cutting single or multiple sheets of plastic, acrylics and PVC where melting or chipping is a concern.

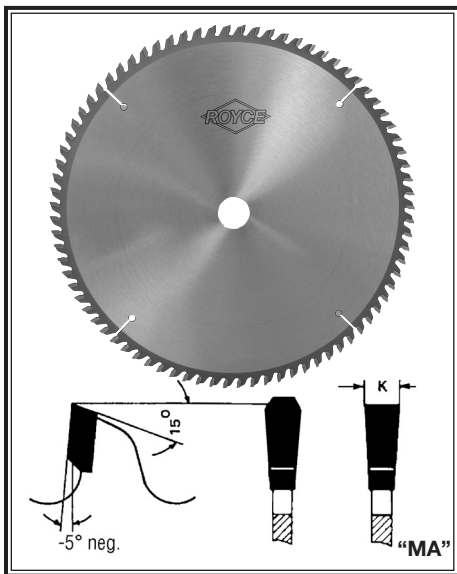
Pour le débit de matières plastiques tendres. Pour la mise à format de panneaux plaqués et stratifiés.



These blades are designed for use on portable Pneumatic trim saws such as Dotco and Aro brand saws and are ideal for fiberglass, plastics and aluminum.

S-26 ALUMINUM BLADES FOR PORTABLE MACHINES

PART NO. STANDARD	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
26100240	100	2.2	.087	2.8	.110	3/4"	0	24
26100240H	100	3.4	.134	3.9	.154	5/8"	-5	24
26115240H	115	3.4	.134	3.9	.154	7/8"	-5	24



For aluminum and vinyl sections or non-ferrous metals. Max thickness 10mm

LAME CIRCULAIRE POUR METAUX non-ferreux. Denture plate + trapézoïdale en carbure. Pour le tronçonnage de profilés non-ferreux. Pour les profilés avec parois minces utiliser lames à haut nombre de dents.

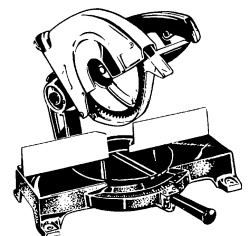
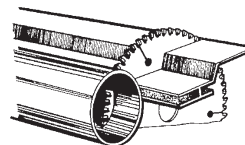
S-27 MITRE CUT BLADES FOR THIN SECTIONS OF PLASTICS AND NON-FERROUS METALS

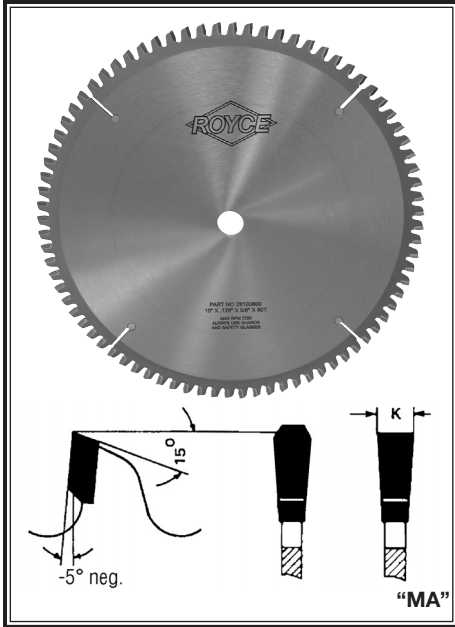
PART NO. STANDARD	DIAM. INCH	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
272160480(a)	8-1/2		2.2	.087	2.8	.110	5/8"	-15	48
272160600(a)	8-1/2		2.2	.087	2.8	.110	5/8"	-5	60
272551000*	10		2.2	.087	2.8	.110	5/8"	-5	100
272501260*		250	1.8	.071	2.2	.087	5/8"	-10	126
272501261*		250	1.8	.071	2.2	.087	1"	-10	126
272751404*		275	2.0	.079	2.4	.094	40MM	-5	140
273009630**		300	2.6	.102	3.2	.126	30MM	-5	96
273051000(b)	12		2.6	.102	3.2	.126	5/8"	-5	100
273301030		330	2.8	.110	3.4	.134	30MM	-5	100
273301032		330	2.8	.110	3.4	.134	32MM	-5	100
273510832		350	2.8	.110	3.4	.134	32MM	-5	108
273551000(b)	14		2.8	.110	3.4	.134	5/8"	-5	100
273801032(c)		380	2.8	.110	3.4	.134	32MM	-5	100

* FOR VERY THIN SECTIONS OF PLASTICS OR ALUMINUM

** 30mm Bore & Pinholes 2/10/60

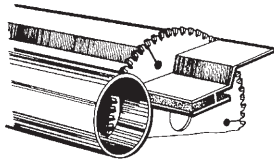
- (a) Elu, Hitachi
- (b) Pistorius
- (c) Hitachi, Ryobi





Circular blades for cutting anodized aluminum profiles or non-ferrous metal alloys.

Lames circulaires pour la coupe de profils en aluminium anodisé ou alliages en métal non-ferreux.



S-28 NON-FERROUS CUTTING SAW BLADES (HEAVY CUT)

PART NO. STANDARD	DIAM. INCH	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
28080480	8	200	2.2	.087	2.8	.110	5/8"	-5	48
28090480	9	230	2.2	.087	2.8	.110	5/8"	-5	48
28100600	10	250	2.6	.102	3.2	.126	5/8"	-5	60
28110724	11	275	2.6	.102	3.2	.126	40MM	-5	72
28120601	12	300	2.6	.102	3.2	.126	1"	-5	60
28140601	14	350	3.0	.118	3.8	.150	1"	-5	60
28140801	14	350	3.2	.126	3.8	.150	1"	-5	80
28160801	16	400	3.2	.126	3.8	.150	1"	-5	80
28180801	18	450	3.4	.134	4.0	.157	1"	-5	80
28181001	18	450	3.4	.134	4.0	.157	1"	-5	100
28201001	20	500	3.4	.134	4.0	.157	1"	-5	100

For cutting and mitering of Non-Ferrous materials 5mm and over.

S-28 = made to metric OD

S-28 NON-FERROUS CUTTING SAW BLADES (LIGHT CUT)

PART NO. STANDARD	DIAM. INCH	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
28080600	8	200	2.2	.087	2.8	.110	5/8"	-5	60
28090600	9	230	2.2	.087	2.8	.110	5/8"	-5	60
28100800T	10	-	2.2	.087	2.8	.110	5/8"	-5	80
28100800	10	250	2.6	.102	3.2	.126	5/8"	-5	80
28110904	11	275	2.6	.102	3.2	.126	40MM	-5	90
28120801	12	300	2.5	.098	3.2	.126	1"	-5	80
28121001	12	300	2.5	.098	3.2	.126	1"	-5	100
28141001	14	350	3.2	.126	3.8	.150	1"	-5	100
28161001	16	400	3.2	.126	3.8	.150	1"	-5	100
28161201	16	400	3.2	.126	3.8	.150	1"	-5	120
28181201	18	450	3.4	.134	4.0	.157	1"	-5	120
28201201	20	500	3.4	.134	4.0	.157	1"	-5	120

For cutting and mitering of Non-Ferrous materials with a wall thickness of up to 5mm thick.

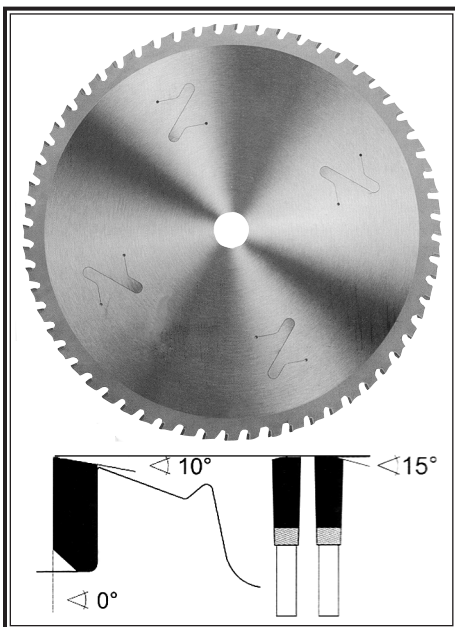
S-28 = made to metric OD except as marked

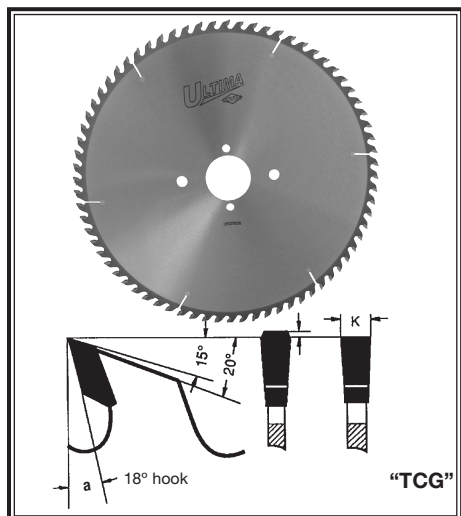
S-29 STEEL CUTTING AND MULTI PURPOSE (DRY CUTTING)

PART NO. STANDARD	DIAM. INCH	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH
29062300	6	1.6	.063	2.2	.087	5/8"	0	30
29070360	7	1.6	.063	2.2	.087	20MM	0	36
29100483	10	1.8	.071	2.4	.094	30MM	5	48
29100603	10	1.8	.071	2.2	.087	30MM	5	60
29120601	12	1.8	.071	2.2	.087	1"	5	60
29120601-WWF	12	1.8	.071	2.2	.087	1"	8	60
29120801-WWF	12	1.8	.071	2.2	.087	1"	8	80
29120841	12	1.8	.071	2.2	.087	1"	0	84
29140901	14	2.0	.079	2.5	.098	1"	5	90

Designed to cut iron and composite metals especially profiles, tubes, insulating boards and chipboards with metal on both sides. An ideal multi-purpose saw for the construction industry. We recommend the following RPM guidelines:

Saw Diameter	RPM	Saw Diameter	RPM
up to 82 (7.16")	2300	up to 300 (12")	1500
250 (10")	1700	350 (14")	1250





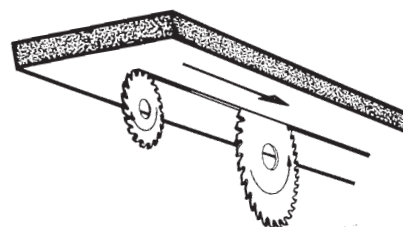
S-05U PANEL SIZING SAW BLADES "ULTIMA"

PANEL SIZING SAW BLADE

Edging and splitting of panels made of wood, chipboard, and laminated boards on panel sizing saws, edging saws, vertical panel sizing saws as well as panel splitting saws.

LAME CIRCULAIRE POUR DEBIT DE PANNEAUX.

Pour le débit et la mise à format de panneaux lamifié et stratifiés, par unité et en paquets.



**For the ultimate cutting life
in high volume applications**

PART NO. ULTIMA	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH	PINHOLES	MACHINE MAKE + MODEL
05240543230U	• 240	2.2	.087	3.2	.126	30	15	54	2/7/42	Scheer FM10
05250603230U	• 250	2.2	.087	3.2	.126	30	15	60	2/7/42	Casadei Linea, Panhans
05300724465U	• 300	3.2	.126	4.4	.173	65	15	72	2/9/110	Selco EB70
05305484430U	• 305	3.2	.126	4.4	.173	30	18	48		Mayer, Panhans
05305604430U	• 305	3.2	.126	4.4	.173	30	15	60		Mayer, Panhans
05305724430U	• 305	3.2	.126	4.4	.173	30	15	72		Mayer, Panhans
05320604465U	• 320	3.2	.126	4.4	.173	65	15	60	2/9/110	Selco EB80
05320724475U	• 320	3.2	.126	4.4	.173	75	15	72	3/13/95	Giben Smart
05330604450U	• 330	3.2	.126	4.4	.173	50	15	60	4/13/80	Giben
05350544475U	• 350	3.2	.126	4.4	.173	75	18	54		Giben Trend
05350604475U	• 350	3.2	.126	4.4	.173	75	18	60		Giben Gamma
05350724430U	• 350	3.2	.126	4.4	.173	30	18	72		Schelling FXH/FM
05350724450U	• 350	3.2	.126	4.4	.173	50	15	72	4/13/80	Giben Onix 90
05350724460U	• 350	3.2	.126	4.4	.173	60	15	72	2/14/100	Holzma Type 72
05350724480U	• 350	3.2	.126	4.4	.173	80	15	72	4/9/100+2/14/110	Gabbiani Galaxy 85
05350724481U	• 350	3.2	.126	4.4	.173	80	15	72	2/7/110+2/14/110	SCM Prima 90
05355724411U	• 355	3.2	.126	4.4	.173	1 1/4"	15	72		SCMI
05355724430U	• 355	3.2	.126	4.4	.173	30	15	72		Mayer, Panhans
05355724475U	• 355	3.2	.126	4.4	.173	75	15	72		Giben Trend
05355724480U	• 355	3.2	.126	4.4	.173	80	15	72	2/9/130+4/19/120	Selco EB90
05360724465U	• 360	3.2	.126	4.4	.173	65	15	72	2/9/110	Selco EB100
05360724475U	• 360	3.2	.126	4.4	.173	75	15	72	4/15/105	Giben/Starmatic
05370724430U	• 370	3.2	.126	4.4	.173	30	15	72	2/10/60	Panhans
05380604460U	• 380	3.2	.126	4.4	.173	60	15	60	2/14/100	Holzma Type 81
05380724450U	• 380	3.2	.126	4.4	.173	50	15	72	4/13/80	Giben Onix 105
05380724480U	• 380	3.2	.126	4.4	.173	80	15	72	2/7/110 + 2/14/110	SCM Sigma Impact 105
05380724860U	• 380	3.5	.138	4.8	.189	60	15	72	2/14/100	Holzma Type 82
05400604430U	• 400	3.2	.126	4.4	.173	30	15	60	2/10/60	Schelling AW, FW, Panhans
05400604475U	• 400	3.2	.126	4.4	.173	75	15	60	4/15/105	Giben
05400604480U	• 400	3.2	.126	4.4	.173	80	15	60	4/9/100+2/14/110	Gabbiani Galaxy 115
05400724430U	• 400	3.2	.126	4.4	.173	30	15	72	2/10/60	Schelling AW, FW, Panhans
05400724460U	• 400	3.2	.126	4.4	.173	60	15	72		Anthon LNA
05400724475U	• 400	3.2	.126	4.4	.173	75	15	72	4/15/105	Giben Prismatic-1/Starmatic
05400724480U	• 400	3.2	.126	4.4	.173	80	15	72	4/9/100+2/14/110	Gabbiani Galaxy 115
05400724481U	• 400	3.2	.126	4.4	.173	80	15	72	2/9/130+4/19/120	Selco EB110
05400844475U	• 400	3.2	.126	4.4	.173	75	15	84	4/15/105	Giben Prismatic-1
05420724460U	• 420	3.2	.126	4.4	.173	60	15	72	2/10/80+2/14/125	Holzma Type 92
05420724860U	• 420	3.5	.138	4.8	.189	60	15	72	2/10/80+2/14/125	Holzma Type 92
05430724430U	• 430	3.2	.126	4.4	.173	30	15	72		Anthon CP
05430724460U	• 430	3.2	.126	4.4	.173	60	15	72	2/11/85	Giben Prismatic 115
05430724475U	• 430	3.2	.126	4.4	.173	75	15	72	4/15/105	Giben Prismatic 115

PART NO. ULTIMA		DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE	HOOK ANGLE	TEETH	PINHOLES	MACHINE MAKE + MODEL
05430724480U	•	430	3.2	.126	4.4	.173	80	15	72	2/9/130+4/19/120	Selco EB120
05430964475U	•	430	3.2	.126	4.4	.173	75	10	96	4/15/105	Giben Prismatic-115
05450604860U	•	450	3.5	.138	4.8	.189	60	15	60	2/10/80+2/14/125	Holzma Type 11
05450724430U	•	450	3.2	.126	4.4	.174	30	15	72		Panhans, Schelling AL,FL
05450724460U	•	450	3.2	.126	4.4	.174	60	15	72	2/10/80+2/14/125	Holzma Type 11
05450724480U	•	450	3.2	.126	4.4	.174	80	15	72	4/9/100+2/14/110	Gabbiani Galaxy 140
05450724481U	•	450	3.2	.126	4.4	.174	80	15	72	2/9/130+4/19/120	Selco WN 600
05450724482U	•	450	3.2	.126	4.4	.173	80	15	72	2/7/110+2/14/110	SCM Sigma 115
05450724860U	•	450	3.5	.138	4.8	.189	60	15	72	2/10/80+2/14/125	Holzma Type 11
05450724880U	•	450	3.5	.138	4.8	.189	80	15	72	2/9/130+4/19/120	Selco WN 600
05460604430U		460	3.2	.126	4.4	.173	30	15	60		Schelling FL
05460724430U		460	3.2	.126	4.4	.173	30	15	72		Schelling FL
05470724875U	•	470	3.5	.138	4.8	.189	75	15	72	4/15/105	Giben Prismatic-3
05470964475U	•	470	3.2	.126	4.4	.174	75	10	96	4/15/105	Giben Prismatic-3
05480724430U		480	3.2	.126	4.4	.174	30	15	72		Schelling FL
05480724830U		480	3.5	.138	4.8	.189	30	15	72		Schelling FL
05480724880U	•	480	3.5	.138	4.8	.189	80	15	72	2/9/130+4/19/120	Selco WN 600
05500604430U	•	500	3.2	.126	4.4	.173	30	18	60		Schelling FW
05500604475U	•	500	3.2	.126	4.4	.173	75	18	60		Giben
05500604860U	•	500	3.5	.138	4.8	.189	60	18	60	2/11/115	Holzma Type 21
05500724475U	•	500	3.2	.126	4.4	.173	75	15	72		Giben
05500724860U	•	500	3.5	.138	4.8	.189	60	15	72	2/11/115	Holzma Type 22
05500724875U	•	500	3.5	.138	4.8	.189	75	15	72		Giben
05500725080U	•	500	3.5	.138	4.8	.189	80	15	72	4/9/100+2/14/110	Gabbiani A/10
05500964860U	•	500	3.5	.138	4.8	.189	60	10	96		Holzma Type 21
05510724880U		510	3.5	.138	4.8	.189	80	15	72	2/9/130 + 4/19/120	Selco
05520604860U	•	520	3.5	.138	4.8	.189	60	18	60	2/11/115+2/19/120	Holzma Type 23
05520724860U	•	520	3.5	.138	4.8	.189	60	15	72	2/11/115+2/19/120	Holzma Type 23
05520724875U	•	520	3.5	.138	4.8	.189	75	15	72		Giben
05520724880U	•	520	3.5	.138	4.8	.189	80	15	72	4/9/100+2/14/110	Gabbiani
05530605030U	•	530	3.5	.138	5.0	.197	30	18	60		Schelling AL
05530724880U	•	530	3.5	.138	4.8	.189	80	15	72	4/9/100+2/14/110	Gabbiani
05540844860U		540	3.5	.138	4.8	.189	60	15	84	2/11/115+2/19/120	Holzma Type 33 (USA)
05550725040U		550	3.5	.138	5.0	.197	40	18	72		Schelling FT/AT
05550725010U	•	550	3.5	.138	5.0	.197	100	15	72		Giben Model 17/19
05565605010U		565	3.5	.138	5.0	.197	100	18	60		Giben Model 17/19
05565725010U		565	3.5	.138	5.0	.197	100	15	72		Giben Model 17/19
05570604860U	•	570	3.5	.138	4.8	.189	60	18	60		Holzma Type 42
05570605860U	•	570	4.0	.157	5.8	.228	60	18	60		Holzma Type 42
05580605540U		580	4.0	.157	5.5	.217	40	18	60	2/12.5/122	Schelling AT
05600605860U	•	600	4.0	.157	5.8	.228	60	18	60	2/11/115+2/19/120	Holzma Type 33, 42
05600725860U	•	600	4.0	.157	5.8	.228	60	18	72	2/11/115+2/19/120	Holzma Type 33, 42
05630606240U		630	4.0	.157	6.2	.244	40	18	60		Schelling
05650606010U		650	4.0	.157	6.0	.236	100	18	60	2/10.5/150	Giben Model 19
05650606240U		650	4.0	.157	6.2	.236	40	18	60	1/11/140	Schelling FS, AS
05650726240U	•	650	4.0	.157	6.2	.244	40	18	72	1/11/140	Schelling FS, AS
05670725860U		670	4.0	.157	5.8	.228	60	18	72	2/11/148+2/19/120	Holzma Type 61
05670726040U		670	4.0	.157	6.0	.236	40	18	72	1/11/140	Schelling FS
05680606240U		680	4.2	.165	6.2	.244	40	18	60	2/13/140	Schelling FS

NOTE: Cooling Slots available on blades 450mm dia. and up - on special order only



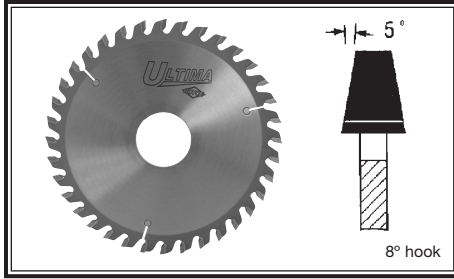
For the ultimate cutting life
in high volume applications

ULTIMAX

Developed by Royce//Ayr to extend the life of Carbide Tipped Panel Saw Blades

NEW	tooth configuration using Ultrafine grain carbide with proven longer life. Corrosion abrasion and oxidation resistant.	IMPROVED	laser cut saw body with dampening slots and more consistent tension.	BEST	German saw steel, leveled and staightened to perfect flatness.
------------	--	-----------------	--	-------------	--

PART NO. ULTIMAX	DIA MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE MM	HOOK	TEETH	PINHOLES	MACHINE MAKE & MODEL
05305604430UM	305	3.2	.126	4.4	.173	30	15	60	2/10/60	MAYER
05320604465UM	320	3.2	.126	4.4	.173	65	15	60		SELCO EB80
05355724480UM	355	3.2	.126	4.4	.173	80	15	72	2/9/130 & 4/19/120	SELCO
05370724430UM	370	3.2	.126	4.4	.173	30	15	72	2/10/60	SCHELLING FM-H
05380724860UM	380	3.5	.138	4.8	.189	60	15	72	2/14/100 (S0006-RD)	HOLZMA TYPE 82
05400724475UM	400	3.2	.126	4.4	.173	75	15	72	4/15/105	GIBEN PRISMATIC-1/STARMATIC
05400844475UM	400	3.2	.126	4.4	.173	75	15	84	4/15/105	GIBEN PRISMATIC-1
05420724860UM	420	3.5	.138	4.8	.189	60	15	72		HOLZMA
05430604480UM	430	3.2	.126	4.4	.173	80	15	60	2/9/130 & 4/19/120	SELCO
05430724430UM	430	3.2	.126	4.4	.173	30	15	72		
05430964475UM	430	3.2	.126	4.4	.173	75	15	96	4/15/105	GIBEN PRISMATIC-2
05450604430UM	450	3.2	.126	4.4	.173	30	15	60	2/8.5/60	SCHEER FM 22
05450604860UM	450	3.5	.138	4.8	.189	60	15	60	2/14/125	HOLZMA TYPE 11
05450604880UM	450	3.5	.138	4.8	.189	80	15	60	2/9/130 & 4/19/120	SELCO
05450724430UM	450	3.2	.126	4.4	.173	30	15	72		
05450724880UM	450	3.5	.138	4.8	.189	80	15	72		SELCO WN600/132
05450724881UM	450	3.5	.138	4.8	.189	80	15	72	2/9/130 & 4/19/120	SELCO
05480604830UM	480	3.5	.138	4.8	.189	30	15	60		SCHELLING AL/FL
05480724430UM	480	3.2	.126	4.4	.173	30	15	72		SCHELLING FL
05480724830UM	480	3.5	.138	4.8	.189	30	15	72		SCHELLING AL/FL
05500604860UM	500	3.5	.138	4.8	.189	60	15	60	2/11/115	HOLZMA
05500724860UM	500	3.5	.138	4.8	.189	60	15	72	2/11/115	HOLZMA
05500725080UM	500	3.5	.138	5.0	.197	80	15	72		GABIAN, A10
05510724880UM	510	3.5	.138	4.8	.189	80	15	72	2/9/130 & 4/19/120	SELCO
05565605010UM	565	3.5	.138	5.0	.197	100	15	60		GIBEN MODEL 69/19
05600605860UM	600	4.0	.157	5.8	.228	60	15	60	2/11/115 & 2/19/120	HOLZMA TYPE 33
05600725860UM	600	4.0	.157	5.8	.228	60	15	72		HOLZMA TYPE 33



S-07U TAPERED SCORING SAW BLADES "ULTIMA"

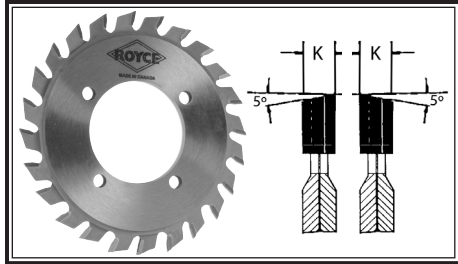
SCORING SAW BLADE
T.C.T. conical tooth. Scoring of plastic-laminated panels with adjustable thickness. For use in panel sizing saw with scoring unit.



LAME CIRCULAIRE INCISEUSE.
Denture conique en carbure. Pour l'incisage à épaisseur variable de panneaux revêtus. Utilisable sur scie à panneaux avec agrégat d'incisage.

TYPE-07 - TAPERED SCORING SAW BLADES "ULTIMA" FOR PANEL SAWS

PART NO. ULTIMA	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	BORE MM/INCH	PINHOLES	HOOK ANGLE	TEETH	MACHINE MAKE + MODEL
07125243220U	• 125	2.2	.087	3.2 - 4.2	20		8	24	Casadei Linea
07125244420U	• 125	3.2	.126	4.4 - 5.4	20		8	24	Panhans
07125244422U	• 125	3.2	.126	4.4 - 5.4	22		8	24	Martin
07125244445U	• 125	3.2	.126	4.4 - 5.4	45		8	24	Giben
07125244845U	• 125	3.5	.138	4.8 - 5.8	45		8	24	Giben
07127244445U	• 127	3.2	.126	4.4 - 5.4	45		8	24	Giben
07140244445U	• 140	3.2	.126	4.4 - 5.4	45		8	24	Euromac
07140323216U	• 140	2.2	.126	3.2 - 4.2	16	1/6/33	8	32	Scheer
07150244411U	• 150	3.2	.126	4.4 - 5.4	1-1/4"		8	24	SCMI
07150244420U	• 150	3.2	.126	4.4 - 5.4	20		8	24	Schelling
07150244430U	• 150	3.2	.126	4.4 - 5.4	30		8	24	Mayer
07150364411U	• 150	3.2	.126	4.4 - 5.4	1-1/4"		8	36	SCMI
07150364430U	• 150	3.2	.126	4.4 - 5.4	30		8	36	SCM
07150364455U	• 150	3.2	.126	4.4 - 5.4	55	3/7/66	8	36	Gabbiani
07160284445U	• 160	3.2	.126	4.4 - 5.4	45	3/11/70	8	28	Giben Prismatic
07160364455U	• 160	3.2	.126	4.4 - 5.4	55	3/7/66	8	36	Gabbiani, SCM
07160364855U	• 160	3.5	.138	4.8 - 5.8	55	3/7/66	8	36	Gabbiani
07175284445U	• 175	3.2	.126	4.4 - 5.4	45		8	28	Holzma
07175364845U	• 175	3.5	.138	4.8 - 5.8	45		8	36	Holzma
07180304420U	• 180	3.2	.126	4.4 - 5.4	20		8	30	Schelling - Anthon
07180304445U	• 180	3.2	.126	4.4 - 5.4	45		8	30	Schelling - Anthon
07180364430U	• 180	3.2	.126	4.4 - 5.4	30		8	36	Panhans
07180364445U	• 180	3.2	.126	4.4 - 5.4	45		8	36	Holzma, HPP 350
07180364845U	• 180	3.5	.138	4.8 - 5.8	45		8	36	Holzma Type 82
07180365055U	• 180	3.5	.138	5.0 - 6.0	55		8	36	Giben
07180423216U	• 180	2.2	.126	3.2 - 4.2	16	1/6/33	8	42	Scheer FM
07180444450U	• 180	3.2	.126	4.4 - 5.4	50	3/12.5/80	12	44	Giben Onix
07200364420U	• 200	3.2	.126	4.4 - 5.4	20		8	36	Schelling
07200364430U	• 200	3.2	.126	4.4 - 5.4	30		8	36	Scheer FM
07200364445U	• 200	3.2	.126	4.4 - 5.4	45		8	36	Holzma
07200364465U	• 200	3.2	.126	4.4 - 5.4	65	2/9/100 + 2/9/110	8	36	Selco EB85+EB100
07200444450U	• 200	3.2	.126	4.4 - 5.4	50	3/13/80	12	44	Giben Smart
07200364820U	• 200	3.5	.138	4.8 - 5.8	20		8	36	Schelling
07200364845U	• 200	3.5	.138	4.8 - 5.8	45		8	36	Holzma
07200364865U	• 200	3.5	.138	4.8 - 5.8	65	2/9/100 + 2/9/110	8	36	Selco
07200365020U	• 200	3.5	.138	5.0 - 6.0	20		8	36	Schelling
07200365520U	• 200	4.0	.157	5.5 - 6.5	20		8	36	Schelling
07200365845U	• 200	4.0	.157	5.8 - 6.8	45		8	36	Holzma
07200366220U	• 200	4.0	.157	6.2 - 7.2	20		8	36	Schelling
07215424450U	• 215	3.2	.126	4.4 - 5.4	50	3/15/80	8	42	Giben Prismatic
07215424850U-ATB	• 215	3.5	.138	4.8 - 5.8	50	3/15/80		42	Giben Prismatic
07300484420U	• 300	3.2	.126	4.4 - 5.4	20		8	48	Schelling FXH
07300484430U	• 300	3.2	.126	4.4 - 5.4	30		8	48	
07300484450U	• 300	3.2	.126	4.4 - 5.4	50	3/15/80	8	48	Giben Prismatic
07300484465U	• 300	3.2	.126	4.4 - 5.4	65	2/9/100 + 2/9/110	8	48	Selco
07320484845U	• 320	3.5	.138	4.8 - 5.8	45		8	48	Holzma



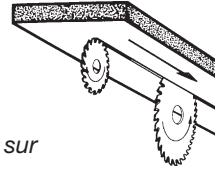
S-06 2 PC. ADJUSTABLE SCORING SAW BLADES

ADJUSTABLE SCORING SAW BLADE

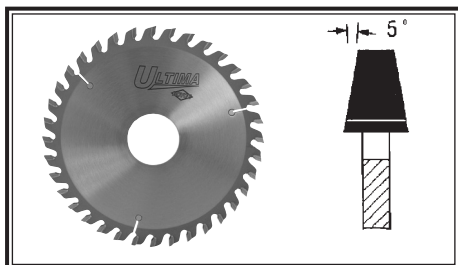
T.C.T. flat tooth. Scoring of plastic-laminated panels, adjustable by shims. For use in panel sizing saw with scoring unit.

LAME CIRCULAIRE INCISEURE À ÉPAISSEUR RÉGLABLE

Pour l'incisage à épaisseur variable de panneaux revêtus. Utilisable sur scie à panneaux avec agrégat d'incisage.



PART NO. STANDARD		DIAM. MM	KERF MM	BORE INCH/MM	TEETH	MACHINE MAKE & MODEL
06070202820	•	70	2.8 - 3.6	16	2x8	EMA Casadei, Minimax
06080202820	•	80	2.8 - 3.6	20	2x10	
06100242820	•	100	2.8 - 3.6	20	2x12	Schelling Altendorf, Martin, Panhans SCMI, Delta Delta
06100242822	•	100	2.8 - 3.6	22	2x12	
06100242834	•	100	2.8 - 3.6	3/4"	2x12	
06100242810	•	100	2.8 - 3.6	1"	2x12	
06120242820	•	120	2.8 - 3.6	20	2x12	SCM, Holz-Her Altendorf, Martin, Panhans SCMI Altendorf
06120242822	•	120	2.8 - 3.6	22	2x12	
06120242834	•	120	2.8 - 3.6	3/4"	2x12	
06120242850	•	120	2.8 - 3.6	50	2x12	
06125242820	•	125	2.8 - 3.6	20	2x12	Holz-Her SCMI SCM Holzma
06125242822	•	125	2.8 - 3.6	22	2x12	
06125242834	•	125	2.8 - 3.6	3/4"	2x12	
06125404020	•	125	4.0 - 4.4	20	2x20	
06125404045	•	125	4.0 - 4.4	45	2x20	Holzma
06160322830	•	160	2.8 - 3.6	30	2x16	Bauerle
06180404445	•	180	4.4 - 5.2	45	2x20	Holzma
06180404845	•	180	4.8 - 5.6	45	2x20	Holzma



S-07 TAPERED SCORING SAW - FOR SLIDING TABLE SAW

SCORING SAW BLADE

T.C.T. conical tooth. Scoring of plastic-laminated panels with adjustable thickness. For use in panel sizing saw with scoring unit.

LAME CIRCULAIRE INCISEUSE

Denture conique en carbure. Pour l'incisage à épaisseur variable de panneaux revêtus. Utilisable sur scie à panneaux avec agrégat d'incisage.

PART NO. STANDARD		DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	BORE INCH/MM	HOOK ANGLE	TEETH
07080163220	•	80	2.2	.087	3.1 - 4.1	.122 - .161	20	8	16
07100243210	•	100	2.2	.087	3.1 - 4.1	.122 - .161	1"	8	24
07100243520	•	100	2.5	.098	3.4 - 4.4	.134 - .173	20	8	24
07100244020	•	100	3.0	.118	3.9 - 4.9	.154 - .193	20	8	24
07110243520	•	110	2.5	.098	3.4 - 4.4	.134 - .173	20	8	24
07110244020	•	110	3.0	.118	3.9 - 4.9	.154 - .193	20	8	24
07115243520	•	115	2.5	.098	3.4 - 4.4	.134 - .173	20	8	24
07115244020	•	115	3.0	.118	3.9 - 4.9	.154 - .193	20	8	24
07120243520	•	120	2.5	.098	3.4 - 4.4	.134 - .173	20	8	24
07120243534	•	120	2.5	.098	3.4 - 4.4	.134 - .173	3/4"	8	24
07120244020	•	120	3.0	.118	3.9 - 4.9	.154 - .193	20	8	24
07120244034	•	120	3.0	.118	3.9 - 4.9	.154 - .193	3/4"	8	24
07125243520	•	125	2.5	.098	3.4 - 4.4	.134 - .173	20	8	24
07125243522	•	125	2.5	.098	3.4 - 4.4	.134 - .173	22	8	24
07125243534	•	125	2.5	.098	3.4 - 4.4	.134 - .173	3/4"	8	24
07125244020	•	125	3.0	.118	3.9 - 4.9	.154 - .193	20	8	24
07150243520	•	150	2.5	.098	3.4 - 4.4	.134 - .173	20	8	24
07150244020	•	150	3.0	.118	3.9 - 4.9	.154 - .193	20	8	24

PANEL & SCORING SAW EASY MATCH UP CHART

MAIN BLADE:

SCORING SAW:

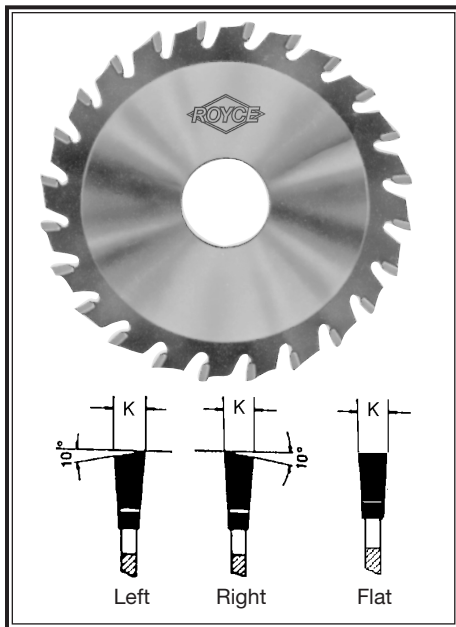
PART NO. ULTIMA	DIAM. MM	KERF MM	BORE	TEETH	MACHINE	PART NO. ULTIMA	DIAM. MM	KERF MM	BORE	TEETH
05400724460U	400	4.4	60	72	Anthon LN	07180304420U	180	4.4 - 5.4	20	30
05430724460U	430	4.4	60	72	Anthon CP	07180304420U	180	4.4 - 5.4	20	30
05250603230U	250	3.2	30	60	Casadei Linea	07125243220U	125	3.2 - 4.2	20	24
05350724480U	350	4.4	80	72	Gabbiani Galaxy 85	07160364455U	160	4.4 - 5.4	55	36
05400604480U	400	4.4	80	60	Gabbiani Galaxy 115	07160364455U	160	4.4 - 5.4	55	36
05400724480U	400	4.4	80	72	Gabbiani Galaxy 115	07160364455U	160	4.4 - 5.4	55	36
05450724480U	450	4.4	80	72	Gabbiani Galaxy 140	07200364465U	200	4.4 - 5.4	65	36
05500724880U	500	4.8	80	72	Gabbiani A/10	07200364865U	200	4.8 - 5.8	65	36
05520724880U	520	4.8	80	72	Gabbiani	07160364855U	160	4.8 - 5.8	55	36
05530724880U	530	4.8	80	72	Gabbiani	07160364855U	160	4.8 - 5.8	55	36
05320724475U	320	4.4	75	72	Giben Smart	07200444450U	200	4.4 - 5.4	50	44
05355544475U	355	4.4	75	54	Giben Trend	07125244445U	125	4.4 - 5.4	45	24
05355604475U	355	4.4	75	60	Giben Gamma	07125244445U	125	4.4 - 5.4	45	24
05355724475U	355	4.4	75	72	Giben Trend	07125244445U	125	4.4 - 5.4	45	24
05365724475U	365	4.4	75	72	Giben	07125244445U	125	4.4 - 5.4	45	24
05380724450U	380	4.4	50	72	Giben Onix 105	07180444450U	180	4.4 - 5.4	50	44
05400604475U	400	4.4	75	60	Giben	07125244445U	125	4.4 - 5.4	45	24
05400724475U	400	4.4	75	72	Giben	07125244445U	125	4.4 - 5.4	45	24
05400844475U	400	4.4	75	84	Giben Prismatic-1	07160364455U	160	4.4 - 5.4	45	36
05430724475U	430	4.4	75	72	Giben Prismatic-115	07215424450U	215	4.4 - 5.4	50	42
05430964475U	430	4.4	75	96	Giben Prismatic-115	07215424450U	215	4.4 - 5.4	50	42
05470724875U	470	4.8	75	72	Giben Prismatic-3	07215424850U	215	4.8 - 5.8	50	42
05470964475U	470	4.4	75	96	Giben Prismatic-3	07215424450U	215	4.4 - 5.4	50	42
05500604475U	500	4.4	75	60	Giben	07125244445U	125	4.4 - 5.4	45	24
05500724475U	500	4.4	75	72	Giben	07125244445U	125	4.4 - 5.4	45	24
05500724875U	500	4.8	75	72	Giben	07125244845U	125	4.8 - 5.8	45	24
05550725010U	550	5.0	100	72	Giben Model 17/19	07180365055U	180	5.0 - 6.0	55	36
05565605010U	565	5.0	100	60	Giben Model 17/19	07180365055U	180	5.0 - 6.0	55	36
05565725010U	565	5.0	100	72	Giben Model 17/19	07180365055U	180	5.0 - 6.0	55	36
05380724860U	380	4.8	60	72	Holzma Type 81	07200364845U	200	4.8 - 5.8	45	36
05380724860U	380	4.8	60	72	Holzma Type 82	07180364845U	180	4.8 - 5.8	45	36
05420724460U	420	4.4	60	72	Holzma Type 92	07200364445U	200	4.4 - 5.4	45	36
05420724860U	420	4.8	60	72	Holzma Type 92	07200364845U	200	4.8 - 5.8	45	36
05450604860U	450	4.8	60	60	Holzma Type 11	07200364845U	200	4.8 - 5.8	45	36
05450724460U	450	4.4	60	72	Holzma Type 11	07200304445U	200	4.4 - 5.4	45	30
05450724860U	450	4.8	60	72	Holzma Type 11	07200364845U	200	4.8 - 5.8	45	36
05500604860U	500	4.8	60	60	Holzma Type 21	07200364845U	200	4.8 - 5.8	45	36
05500724860U	500	4.8	60	72	Holzma Type 22	07200364845U	200	4.8 - 5.8	45	36
05500964860U	500	4.8	60	96	Holzma Type 21	07200364845U	200	4.8 - 5.8	45	36
05520604860U	520	4.8	60	60	Holzma Type 23	07200364845U	200	4.8 - 5.8	45	36
05520724860U	520	4.8	60	72	Holzma Type 23	07200364845U	200	4.8 - 5.8	45	36
05540844860U	540	4.8	60	84	Holzma Type 33	07200364845U	200	4.8 - 5.8	45	36
05570604860U	570	4.8	60	60	Holzma Type 42	07200364845U	200	4.8 - 5.8	45	36
05570605860U	570	5.8	60	60	Holzma Type 42	07200365845U	200	5.8 - 6.8	45	36
05600605860U	600	5.8	60	60	Holzma Type 33, 42	07200365845U	200	5.8 - 6.8	45	36
05600725860U	600	5.8	60	72	Holzma Type 33, 42	07200365845U	200	5.8 - 6.8	45	36
05670605860U	670	5.8	60	60	Holzma Type 61	07200365845U	200	5.8 - 6.8	45	36
05670725860U	670	5.8	60	72	Holzma Type 61	07200365845U	200	5.8 - 6.8	45	36
05240543230U	240	3.2	30	54	Scheer FM10	07180423216U	180	3.2 - 4.2	16	42
05350724430U	350	4.4	30	72	Schelling FXH	07300484420U	300	4.4 - 5.4	20	48
05370724430U	370	4.4	30	72	Schelling FM	07200364420U	200	4.4 - 5.4	20	36

CONTINUED

MAIN BLADE:

SCORING SAW:

PART NO. ULTIMA	DIAM. MM	KERF MM	BORE	TEETH	MACHINE	PART NO. ULTIMA	DIAM. MM	KERF MM	BORE	TEETH
05400604430U	400	4.4	30	60	Schelling AW, FW	07150244420U	150	4.4 - 5.4	20	24
05400724430U	400	4.4	30	72	Schelling AW, FW	07150244420U	150	4.4 - 5.4	20	24
05450724430U	450	4.4	30	72	Schelling AL, FL	07200364420U	200	4.4 - 5.4	20	36
05480724430U	480	4.4	30	72	Schelling AL, FL	07200364420U	200	4.4 - 5.4	20	36
05500604430U	500	4.4	30	60	Schelling FW	07180364420U	180	4.4 - 5.4	20	36
05530605030U	530	5.0	30	60	Schelling AL	07200365020U	200	5.0 - 6.0	20	36
05550605040U	550	5.0	40	60	Schelling FT/AT	07200365020U	200	5.0 - 6.0	20	36
05580605540U	580	5.5	40	60	Schelling AT	07200365520U	200	5.5 - 6.5	20	36
05630606240U	630	6.2	40	60	Schelling	07200366220U	200	6.2 - 7.2	20	36
05650726240U	650	6.2	40	72	Schelling FS, AS	07200366220U	200	6.2 - 7.2	20	36
05670726040U	670	6.0	40	72	Schelling FS	07200366020U	200	6.0 - 7.0	20	36
05680606240U	680	6.2	40	60	Schelling FS	07200366220U	200	6.2 - 7.2	20	36
05350724481U	350	4.4	80	72	SCM Prima 90	07160364455U	160	4.4 - 5.4	55	36
05355724430U	355	4.4	30	72	SCM	07160364455U	160	4.4 - 5.4	55	36
05400724482U	400	4.4	80	72	SCM Sigma 115	07160364455U	160	4.4 - 5.4	55	36
05355724411U	355	4.4	1-1/4"	72	SCMI	07150244411U	150	4.4 - 5.4	1-1/4"	24
05320604465U	320	4.4	65	60	Selco EB80	07200364465U	200	4.4 - 5.4	65	36
05355724480U	355	4.4	80	72	Selco EB90	07200364465U	200	4.4 - 5.4	65	36
05360724465U	360	4.4	65	72	Selco EB100	07200364465U	200	4.4 - 5.4	65	36
05400724481U	400	4.4	80	72	Selco EB110	07200364465U	200	4.4 - 5.4	65	36
05430724481U	430	4.4	80	72	Selco EB120	07200364465U	200	4.4 - 5.4	65	36
05450724481U	450	4.4	80	72	Selco WN 600/132	07200364465U	200	4.4 - 5.4	65	36
05450724881U	450	4.8	80	72	Selco WN 600/132	07200364865U	200	4.8 - 5.8	65	36
05480724880U	480	4.8	80	72	Selco WN 600/145	07200364865U	200	4.8 - 5.8	65	36



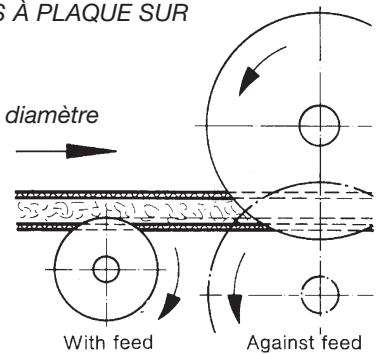
S-08 UNIVERSAL SCORING SAW BLADES

SCORING SAW BLADE FOR EDGE-BANDING AND TENONING MACHINES.

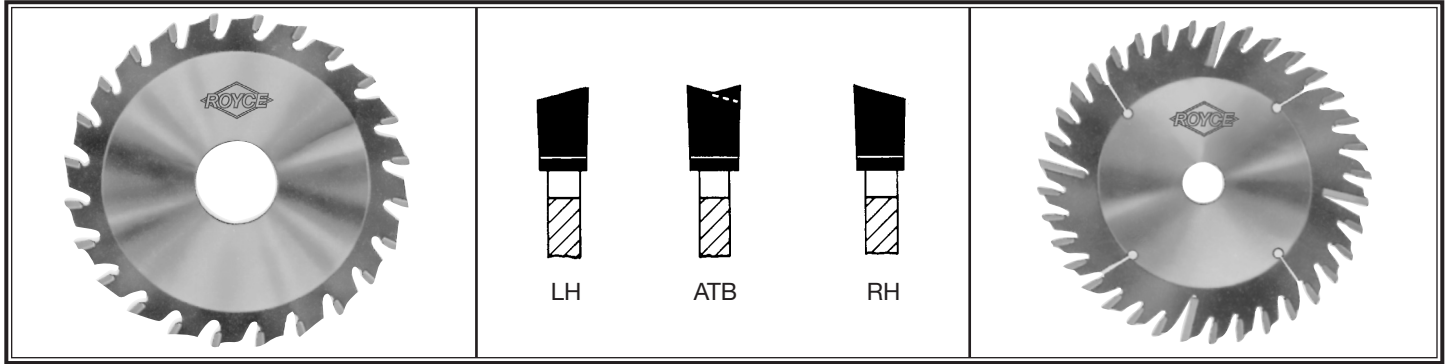
- T.C.T. one side bevel tooth;
 - usable in pairs on Double-End Tenoning machine.
- When ordering state: part number, external diameter, bore diameter, number of teeth.

LAME CIRCULAIRE INCISEUSE POUR MACHINES À PLAQUE SUR CHANTS ET TENONNEUSES.

- denture en carbure biaise unilatérale;
 - utilisable par couples sur Tenonneuses double.
- Dans les commandes indiquer: numéro de l'article, diamètre extérieur, diamètre de l'alésage, nombre de dents



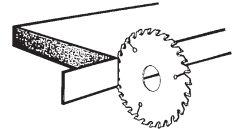
PART NO. L.H.		PART NO. R.H.		PART NO. FLAT		DIAM. INCH	DIAM. MM	PLATE MM	PLATE INCH	KERF MM	KERF INCH	HOOK ANGLE	TEETH
08150301	•	08150302	•	08150303	•	6	150	2.2	.087	3.2	.126	10	30
08150481	•	08150482	•	08150483	•	6	150	2.2	.087	3.2	.126	10	48
08180361	•	08180362	•	08180363	•	7	180	2.2	.087	3.2	.126	10	36
08180541	•	08180542	•	08180543	•	7	180	2.2	.087	3.2	.126	10	54
08200481	•	08200482	•	08200483	•	8	200	2.2	.087	3.2	.126	10	48
08200601	•	08200602	•	08200603	•	8	200	2.2	.087	3.2	.126	10	60



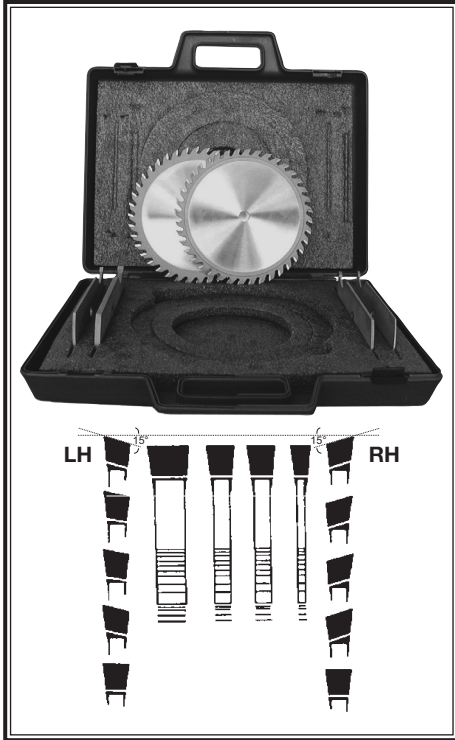
S-36 EDGE BANDING / EDGE CLIPPING SAW BLADES

For use on Edge Banding Machines and Automatic Edge Banders

+ : positive hook for solid woods & veneers - : negative hook for plastic laminates



PART NO. STANDARD	DIAM. MM	KERF MM	PLATE MM	HOOK ANGLE	BORE PINHOLES	TEETH	MACHINE
3610010L	• 100/92	5.6	2.2	+8	32	20+20	Homag
3610010R	• 100/92	5.6	2.2	+8	32	20+20	Homag
3610012	• 100	2.4	1.6	+15	22	12	Holz Her
3610008	• 100	2.6	1.6	+8	32	30	Brandt
3610002L16	• 100	3.2	2.2	-6	16	20LH	Ott
3610002R16	• 100	3.2	2.2	-6	16	20RH	Ott
3610002L32	• 100	3.2	2.2	-6	32	20LH	Wilmsmeyer
3610002R32	• 100	3.2	2.2	-6	32	20RH	Wilmsmeyer
3610004L	• 100	3.0	2.0	+8	32	20LH	Homag
3610004R	• 100	3.0	2.0	+8	32	20RH	Homag
3610006	• 100	3.6	2.2	+8	32	20	Homag
3611002-22	• 110	3.6	2.5	+8	22	20	Holz Her
3611002-32	• 110	3.6	2.5	+8	32	20	Homag
3611003L40	• 110	3.2	2.5	+10	40+4/6CS/52	20LH	Homag
3611003R40	• 110	3.2	2.5	+10	40+4/6CS/52	20RH	Homag
3611502L52	• 115	3.2	2.5	+10	52	30LH	Biesse
3611502R52	• 115	3.2	2.5	+10	52	30RH	Biesse
3611502L56	• 115	3.2	2.2	+10	56+3/6.6CS/68.2	30L/RH	Biesse
3611502R56	• 115	3.2	2.2	+10	56+3/6.6CS/68.2	30L/RH	Biesse
3612002-20	• 120	3.2	2.5	+10	20	20	Homag
3612002-32	• 120	3.2	2.5	+10	32	20	Homag
3612004L	• 120	3.2	2.5	-5	40+4/6CS/52	20LH	Homag
3612004R	• 120	3.2	2.5	-5	40+4/6CS/52	20RH	Homag
3612006	• 120	3.6	2.8	+8	40+8/6CS/52	24	Homag
3614002	• 140	3.2	2.2	+10	16	36	Ott
3615002L	• 150	3.5	2.2	+12	20	30LH	Olympia
3615002R	• 150	3.5	2.2	+12	20	30RH	Olympia
3615004L20	• 150	3.5	2.2	-8	20	30LH	Olympia
3615004R20	• 150	3.5	2.2	-8	20	30RH	Olympia
3615004L30	• 150	3.5	2.2	-8	30	30LH	Homag
3615004R30	• 150	3.5	2.2	-8	30	30RH	Homag
3615006	• 150	3.2	2.2	+10	22	48	IMA
3615007L	• 150	3.6	2.5	10	30+4/6.3CS/50	24+6	Stefani
3615007R	• 150	3.6	2.5	10	30+4/6.3CS/50	24+6	Stefani
3616002	• 160	3.2	2.2	+15	30	24	Holz Her
3616004	• 160	3.2	2.2	+10	20	48	Holz Her
3616006	• 160	3.2	2.2	-8	22	48	IMA
3617002L20	• 170	3.2	2.2	+10	20	40LH	Stefani
3617002R20	• 170	3.2	2.2	+10	20	40RH	Stefani
3617002L30	• 170	3.2	2.2	+10	30	40LH	SCM
3617002R30	• 170	3.2	2.2	+10	30	40RH	SCM



S-30 DADO SETS AND FILLERS (STANDARD CUT)

PART NO. STANDARD		DIAM. INCH	TEETH SAWS	TEETH FILLERS	BORE SIZE	MAX WIDTH
3006240	•	6	24	2	5/8"	13/16"
3008240	•	8	24	2	5/8"	13/16"
3008241	•	8	24	2	1"	13/16"
3010240	•	10	24	2	5/8"	13/16"
3010241	•	10	24	2	1"	13/16"
3012361	•	12	36	2	1"	13/16"

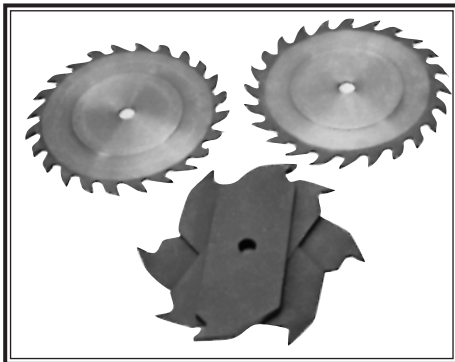
S-30 DADO SETS AND FILLERS (FINE CUT)

PART NO. STANDARD		DIAM. INCH	TEETH SAWS	TEETH FILLERS	BORE SIZE	MAX WIDTH
3008400	•	8	40	2	5/8"	13/16"
3008401	•	8	40	2	1"	13/16"
3010600	•	10	60	2	5/8"	13/16"
3010601	•	10	60	2	1"	13/16"
3012601	•	12	60	2	1"	13/16"

S-30M DADO SETS TO CUT MELAMINE

PART NO. STANDARD		DIAM. INCH	TEETH SAWS	TEETH FILLERS	BORE SIZE	MAX WIDTH	HOOK ANGLE
3008400M		8	40	2	5/8"	13/16"	-5
3010600M		10	60	2	5/8"	13/16"	-5

Designed for grooving or tenoning veneers, composite boards, melamine and laminates from 1/4" to 13/16", and wider on request. Two fine tooth outside cutters and four various inside cutters provide a chip free finish in any desired width of groove.



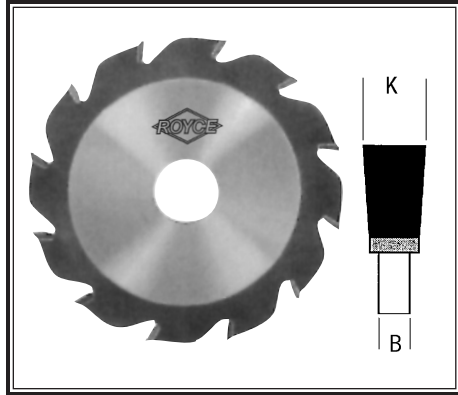
Note: When ordering extra Dado Filler, choose the appropriate number from below and advise bore size required.

S-31 DADO SET REPLACEMENT PARTS - OUTSIDE SAWS

PART NO. LEFT HAND	PART NO. RIGHT HAND	DIAM. INCH	TEETH	BORE SIZE
3106240L	3106240R	6	24	5/8"
3108240L	3108240R	8	24	5/8"
3108241L	3108241R	8	24	1"
3108400L	3108400R	8	40	5/8"
3108400ML	3108400MR	8	40	5/8"
3108401L	3108401R	8	40	1"
3110240L	3110240R	10	24	5/8"
3110241L	3110241R	10	24	1"
3110600L	3110600R	10	60	5/8"
3110600ML	3110600MR	10	60	5/8"
3110601L	3110601R	10	60	1"
3112361L	3112361R	12	36	1"
3112601L	3112601R	12	60	1"

S-31 DADO SET REPLACEMENT PARTS - 2 TEETH FILLERS

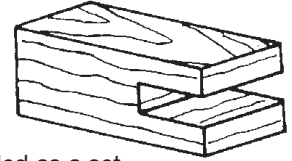
PART NO.	KERF INCH	PART NO.	KERF INCH	PART NO.	KERF INCH
3106062	1/16"	3106125	1/8"	3106250	1/4"
3108062	1/16"	3108125	1/8"	3108250	1/4"
3108062M	1/16"	3108125M	1/8"	3108250M	1/4"
3110062	1/16"	3110125	1/8"	3110250	1/4"
3110062M	1/16"	3110125M	1/8"	3110250M	1/4"
3112062	1/16"	3112125	1/8"	3112250	1/4"



S-35 T.C.T. GROOVING SAW BLADES

For chip-free grooving on stationary machines

- in solid wood with the grain
- in solid wood across the grain with feed
- in uncoated and laminated panel materials with feed
- other groove widths are possible when tools are assembled as a set



S-35 GROOVING SAW BLADES (METRIC SIZES)

PART NO. STANDARD	DIAM. MM	DIAM. INCH	KERF MM	KERF INCH	PLATE MM	BORE	HOOK ANGLE	TEETH
35061215	150	6	1.5	.059	1.0	30	15	12
35061220	150	6	2.0	.079	1.6	30	15	12
35061222	150	6	2.2	.087	1.6	30	15	12
35061225	150	6	2.5	.098	1.8	30	15	12
35061230	150	6	3.0	.118	2.0	30	15	12
35061232	150	6	3.2	.126	2.0	30	15	12
35061235	150	6	3.5	.138	2.5	30	15	12
35061240	150	6	4.0	.157	2.8	30	15	12
35061245	150	6	4.5	.177	3.5	30	15	12
35061250	150	6	5.0	.197	3.6	30	15	12
35061260	150	6	6.0	.236	5.0	30	15	12
35061270	150	6	7.0	.276	5.5	30	15	12
35061280	150	6	8.0	.315	5.5	30	15	12
35061210	150	6	10.0	.394	7.5	30	15	12
35061815	150	6	1.5	.059	1.0	30	15	18
35061818	150	6	1.8	.071	1.0	30	15	18
35061820	150	6	2.0	.079	1.4	30	15	18
35061825	150	6	2.5	.098	1.8	30	15	18
35061830	150	6	3.0	.118	2.0	30	15	18
35061840	150	6	4.0	.157	2.8	30	15	18
35061850	150	6	5.0	.197	3.6	30	15	18
35061860	150	6	6.0	.236	5.0	30	15	18
35061880	150	6	8.0	.315	5.5	30	15	18
35061810	150	6	10.0	.394	7.5	30	15	18
35071820	180	7	2.0	.079	1.6	30	15	18
35071825	180	7	2.5	.098	1.8	30	15	18
35071830	180	7	3.0	.118	2.0	30	15	18
35071840	180	7	4.0	.157	2.8	30	15	18
35071850	180	7	5.0	.197	3.6	30	15	18
35071810	180	7	10.0	.394	7.5	30	15	18

S-35 GROOVING SAW BLADES (INCH SIZES)

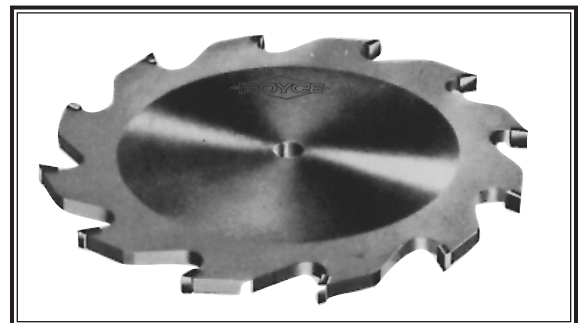
PART NO. STANDARD	DIAM. INCH	DIAM. MM	KERF INCH	KERF MM	PLATE MM	BORE	HOOK ANGLE	TEETH
35061224	6	150	3/32"	2.38	1.8	5/8"	15	12
35061231	6	150	1/8"	3.18	2.2	5/8"	15	12
35061247	6	150	3/16"	4.76	3.5	5/8"	15	12
35061263	6	150	1/4"	6.35	4.8	5/8"	15	12
35061279	6	150	5/16"	7.94	6.4	5/8"	15	12
35061295	6	150	3/8"	9.53	8.0	5/8"	15	12
35082431	8	200	1/8"	3.18	2.2	5/8"	15	24
35082447	8	200	3/16"	4.76	3.5	5/8"	15	24
35082463	8	200	1/4"	6.35	4.8	5/8"	15	24
35082479	8	200	5/16"	7.94	6.4	5/8"	15	24
35082495	8	200	3/8"	9.53	8.0	5/8"	15	24
35102431	10	250	1/8"	3.18	2.2	5/8"	15	24
35102447	10	250	3/16"	4.76	3.5	5/8"	15	24
35102463	10	250	1/4"	6.35	4.8	5/8"	15	24
35102479	10	250	5/16"	7.94	6.4	5/8"	15	24
35102495	10	250	3/8"	9.53	8.0	5/8"	15	24

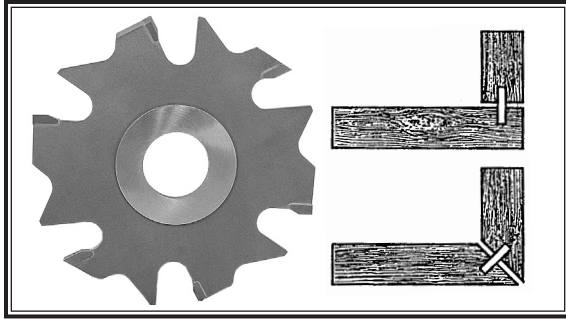
S-35 SPECIAL GROOVING SAWS FOR CNC MACHINES

PART NO. STANDARD	DIAM. INCH	DIAM. MM	KERF INCH	KERF MM	BORE INCH	HOOK ANGLE	TEETH	PIN-HOLES
35051640	4.72	120	.157	4.0	35	-5	16	1/6/46
35051640CS	4.72	120	.157	4.0	35	-5	16	4/5CS/50
35062440	5.82	150	.157	4.0	35	-5	24	1/6/46

CARBIDE GROOVER SAWS

For any special application carbide groover saws are available on request. Specify diameter, width of groove, bore size, spindle speed, approximate feed rate and if the groove to be cut is to be made with or across the grain.



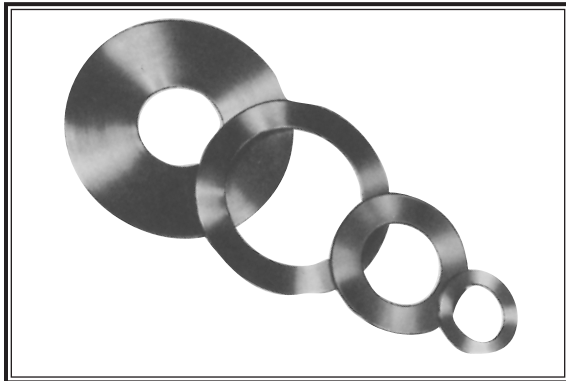
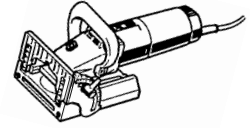


S-32 PLATE JOINTER REPLACEMENT CUTTER

PART NO.	DIAM.	KERF	BORE	TEETH
3210062	100mm	3.95mm	22mm	2+4
3210062CS*	100mm	3.95mm	22mm	2+4

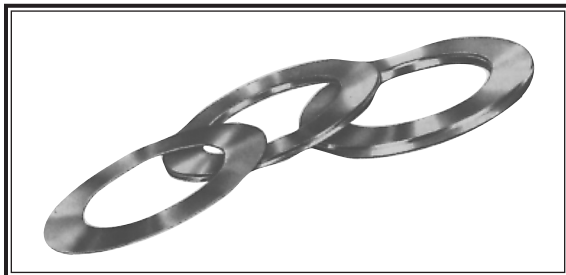
Fits the following plate jointers:
Lamello, Virutex, Porter Cable, Elu,
Freud and Kaiser.

* 4 Countersunk Holes 4/4/36



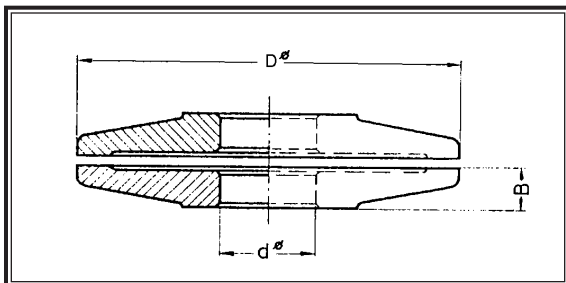
#584 REDUCING BUSHINGS

DIAM.	THICK	BORE SIZE									
3/4"	.086	5/8"									
1"	.086	5/8"	3/4"	7/8"							
1-1/4"	.086	5/8"	3/4"	7/8"	1"	1-1/8"					
1-1/2"	.086	-	3/4"	7/8"	1"	1-1/8"	1-1/4"	1-3/8"			
1-3/4"	.086	-	-	-	1"	-	1-1/4"	-	1-1/2"	1-5/8"	
2"	.086	-	-	-	1"	-	1-1/4"	-	1-1/2"	-	1-3/4"
22mm	.086	5/8"	3/4"	-	-	-	-	20mm			
30mm	.086	5/8"	3/4"	-	1"	-	-	20mm	25mm		
35mm	.086	-	-	-	1"	-	1-1/4"	20mm	25mm	30mm	
40mm	.086	-	-	-	1"	-	1-1/4"	-	25mm	30mm	35mm



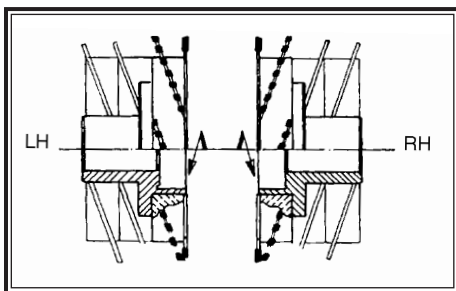
#583 SHIM SETS FOR SCORING SAWS #S-06

PART NO.	DIAM.	BORE	PINHOLES
583-SET.M22	60	22	34mm c. to c.
583-SET.M22A	80	22	34mm c. to c.
583-SET.M22B	80	22	42mm c. to c.
583-SET.M25	80	1"	34mm c. to c.
583-SET.M30	80	30	52mm c. to c.



#583 SAW STIFFENERS (FLANGES)

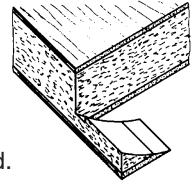
PART NO. DIAM.	BORE	APPLICATION	583-SS3500 3.5
5/8"	for 8", 9", 10",	12" saws	583-SS3501
3.5	1"		583-SS5000
5	5/8"	for 12", 14", 16"	saws
583-SS5001	5	1"	



S-37 SEGMENTED HOGGING UNITS

Hoggers are used for simultaneous trimming and hogging of off-cuts on double-end tenoners, trim saws and dimensioning saws.

The trimming saw is selected according to the material such as solid wood, boards with or without veneer or plastic laminates, plywood, blockboard, chipboard and hardboard.



S-37 HOGGING UNITS

PART NO. STANDARD	DIAM. INCH	DIAM. MM	TEETH SAWS	NO. OF SEGMENTS	TEETH ON SEGMENTS	TOTAL WIDTH	MAX BORE	SAW TOOTH STYLE
372003040L/R	8	200	40	4	7	30	40	LH OR RH BEVEL
372003060L/R	8	200	60	4	7	30	40	LH OR RH BEVEL
372503048L/R	10	250	48	4	7	30	80	LH OR RH BEVEL
372503072L/R	10	250	72	4	7	30	80	LH OR RH BEVEL
373003048L/R	12	300	48	6	7	30	80	LH OR RH BEVEL
373003072L/R	12	300	72	6	7	30	80	LH OR RH BEVEL
373503060L/R	14	350	60	8	7	30	100	LH OR RH BEVEL
373503084L/R	14	350	84	8	7	30	100	LH OR RH BEVEL

NOTE: HUBS NOT INCLUDED IN PRICES

S-37 REPLACEMENT HOGGER SAWS

PART NO. STANDARD	DIAM. INCH	PLATE MM	PLATE INCH	KERF INCH	TEETH	HOOK ANGLE	STANDARD BORE	SAW TOOTH STYLE
37200408L/R	8	2.6	.102	.142	40	15	80	LH OR RH BEVEL
37200608L/R	8	2.6	.102	.142	60	15	80	LH OR RH BEVEL
372504813L/R	10	2.6	.102	.142	48	15	130	LH OR RH BEVEL
372507213L/R	10	2.6	.102	.142	72	15	130	LH OR RH BEVEL
373004813L/R	12	2.8	.110	.150	48	15	130	LH OR RH BEVEL
373007213L/R	12	2.8	.110	.150	72	15	130	LH OR RH BEVEL
373506015L/R	14	3.0	.118	.158	60	15	150	LH OR RH BEVEL
373508415L/R	14	3.0	.118	.158	84	15	150	LH OR RH BEVEL

S-37 EXTENSION HOGGERS

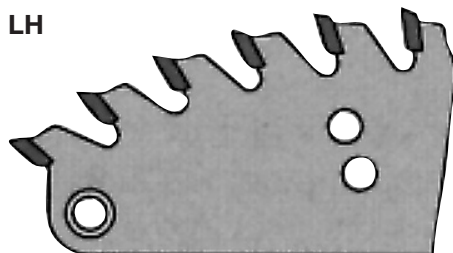
PART NO. STANDARD	DIAM. INCH	DIAM. MM	WIDTH MM	WIDTH INCH	TEETH ON SEGMENT	NO. OF SEGMENTS	MAX. BORE
37200300407	8	200	30	1-3/16"	7	4	80
37250300407	10	250	30	1-3/16"	7	4	80
37300300607	12	300	30	1-3/16"	7	6	80
37350300807	14	350	30	1-3/16"	7	8	100

On request, we can supply replacement hogger segments for most manufacturers, when inquiring, supply drawing or sample as well as make of hogger if possible.

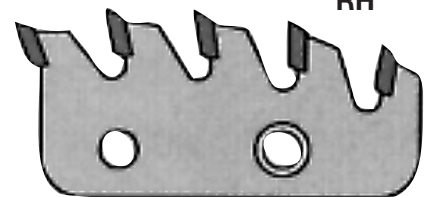
S-37 SEGMENTS

PART NO.	DIAM.	TEETH
372007000	200	7
372507000	250	7
373007000	300	7
373507000	350	7

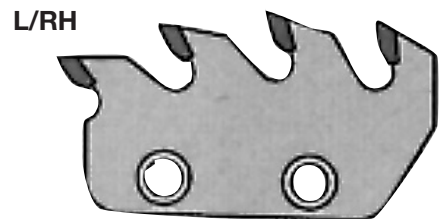
LH



RH



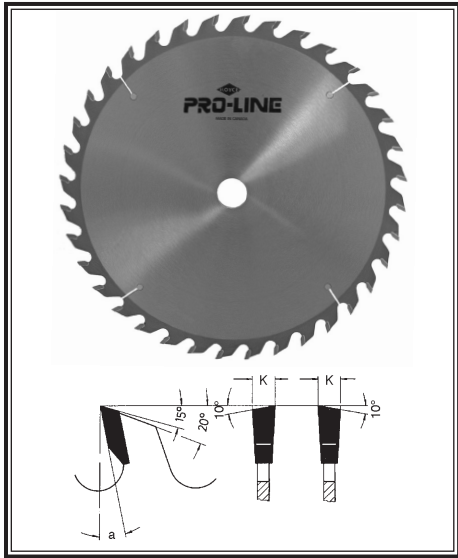
L/RH



PROFESSIONAL SAW BLADES

Royce-Ayr cutting tools, continues to meet manufacturing excellence and consumer demand with their line of "PRO-LINE" carbide tipped quality saw blades. Competitively priced by one of North America's premiere suppliers of cutting tools to the manufacturing industry. Now the quality that Royce-Ayr

is famous for, is available to you. "PRO-LINE" carbide tipped blades are made of the highest quality heat treated steel, precision ground and honed. They are pre-tensioned to respond to your RPM and load requirements.



P-10 RIP SAW BLADES

PART NUMBER	DIA. INCH	BORE SIZE	NO. TEETH	TOP BEVEL	PLATE KERF	STYLE CUT	HOOK ANGLE
P1010020	10	5/8"	20	10°	.087/.126	ATB	20°
P1012024	12	1"	24	10°	.087/.126	ATB	20°
P1014036	14	1"	36	10°	.098/.138	ATB	20°

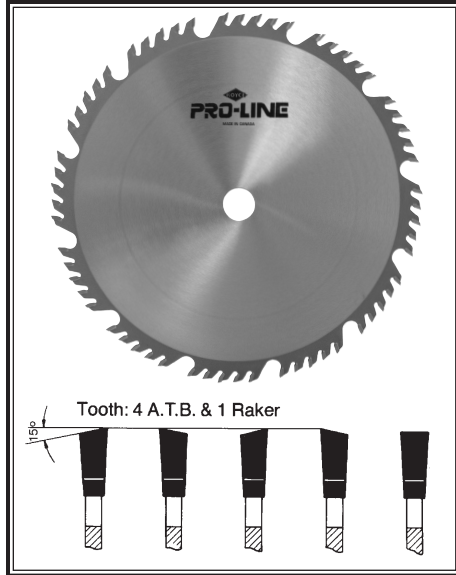
For ripping soft and hard woods.
Suitable for table saws and multiple rip saws.



P-12 GLUE JOINT RIP SAW BLADES

PART NUMBER	DIA. INCH	BORE SIZE	NO. TEETH	TOP BEVEL	PLATE KERF	STYLE CUT	HOOK ANGLE
P1210030	10	5/8"	30		.087/.126	TCG	20°
P1212036	12	1"	36		.087/.126	TCG	20°

For perfect glue joints on soft or hard woods.
Especially suited for straight line rip saws.

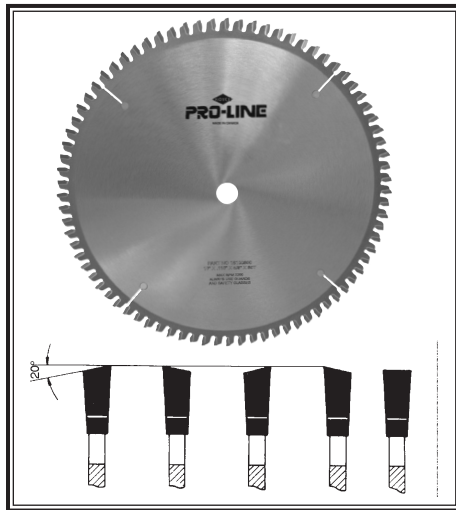


P-14 COMBINATION SAW BLADES

PART NUMBER	DIA. INCH	BORE SIZE	NO. TEETH	TOP BEVEL	PLATE KERF	STYLE CUT	HOOK ANGLE
P1407240	7-1/4	5/8" S	40	15°	.071/.110	COMB	15°
P1408040	8	5/8" S	40	15°	.071/.110	COMB	15°
P1409040	9	5/8"	40	15°	.078/.118	COMB	15°
P1410050	10	5/8"	50	15°	.087/.126	COMB	15°
P1412060	12	1"	60	15°	.087/.126	COMB	15°

S = Skill Bore

An all around saw for almost every use. This blade will rip, cross cut and mitre solid woods as well as cut particle board and plywood.

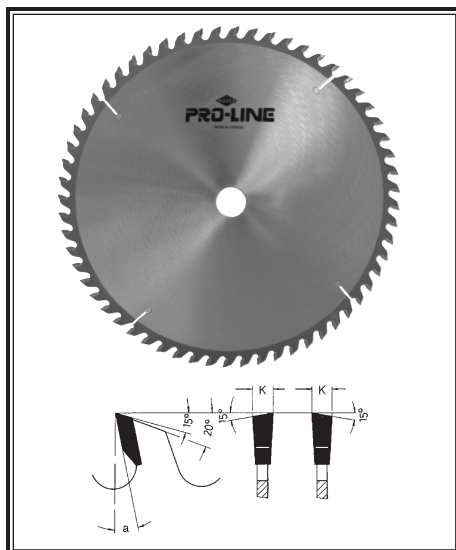


P-16 MITRE JOINT SAW BLADES

PART NUMBER	DIA. INCH	BORE SIZE	NO. TEETH	TOP BEVEL	PLATE KERF	STYLE CUT	HOOK ANGLE
P1608060	8	5/8" S	60	20°	.071/.110	4ATB+R	-5°
P1609060	9	5/8"	60	20°	.071/.110	4ATB+R	-5°
P1610060	10	5/8"	60	20°	.087/.115	4ATB+R	-5°
P1610080	10	5/8"	80	20°	.087/.115	4ATB+R	-5°
P1612080	12	1"	80	20°	.102/.126	4ATB+R	-5°
P1612105	12	5/8"	100	20°	.098/.126	4ATB+R	-5°
P1612100	12	1"	100	20°	.098/.126	4ATB+R	-5°

S = Skill Bore

For smooth, trim mitre cuts on mouldings, picture frames, furniture parts, and where angle cut finishes are critical.

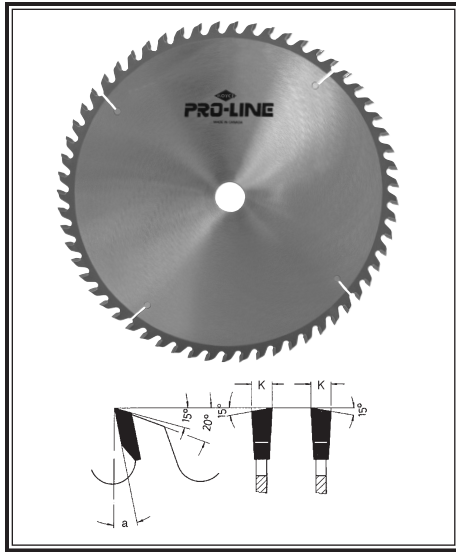


P-17 CUT-OFF SAW BLADES "ATB"

PART NUMBER	DIA. INCH	BORE SIZE	NO. TEETH	TOP BEVEL	PLATE KERF	STYLE CUT	HOOK ANGLE
P1706540	6-1/2	5/8"	40	15°	.071/.110	ATB	10°
P1707240	7-1/4	5/8" S	40	15°	.071/.110	ATB	10°
P1708040	8	5/8" S	40	15°	.071/.110	ATB	10°
P1708060	8	5/8" S	60	15°	.071/.110	ATB	5°
P1708240	8-1/4	5/8" S	40	15°	.071/.110	ATB	15°
P1710040	10	5/8"	40	15°	.087/.126	ATB	12°
P1710060	10	5/8"	60	15°	.087/.126	ATB	12°
P1712072	12	1"	72	15°	.087/.126	ATB	12°
P1714084	14	1"	84	15°	.098/.138	ATB	15°

S = Skill Bore

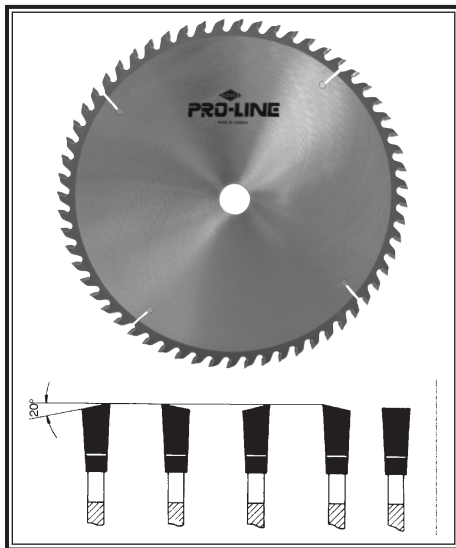
For precision sawing of solid woods, plywood and veneered or plastic laminated panels as well as edging of doors.



P-17 TRIM SAW BLADES "ATB"

PART NUMBER	DIA. INCH	BORE SIZE	NO. TEETH	TOP BEVEL	PLATE KERF	STYLE CUT	HOOK ANGLE
P1710080	10	5/8"	80	15°	.087/.126	ATB	5°
P1712096	12	1"	96	15°	.087/.126	ATB	5°
P1714108	14	1"	108	15°	.098/.138	ATB	5°

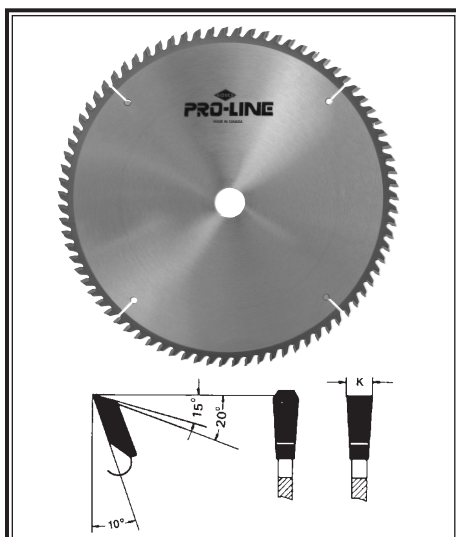
For the cutting of hardboard and medium-density board; for plastic and high pressure laminated chip board for plastics. Max thickness 25mm.



P-18 THIN KERF MITRE JOINT SAW BLADES

PART NUMBER	DIA. INCH	BORE SIZE	NO. TEETH	TOP BEVEL	PLATE KERF	STYLE CUT	HOOK ANGLE
P1810060	10	5/8"	60	20°	.071/.091	4ATB+1R	-5°
P1812060	12	1"	60	20°	.087/.110	4ATB+1R	-5°
P1812080	12	1"	80	20°	.079/.099	4ATB+1R	-5°

Excellent for mitre saws with low horse power. Designed for clean crosscuts in a variety of materials such as soft and hard woods and veneered particle board.

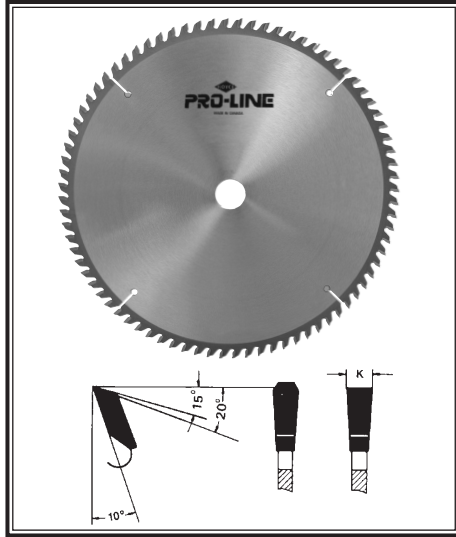


P-21 CUT-OFF SAW BLADES "TCG"

PART NUMBER	DIA. INCH	BORE SIZE	NO. TEETH	TOP BEVEL	PLATE KERF	STYLE CUT	HOOK ANGLE
P2106540	6-1/2	5/8"	40		.071/.110	TCG	10°
P2107240	7-1/4	5/8" S	40		.071/.110	TCG	10°
P2108060	8	5/8" S	60		.071/.110	TCG	5°
P2110040	10	5/8"	40		.087/.126	TCG	10°
P2110060	10	5/8"	60		.087/.126	TCG	12°
P2112060	12	1"	60		.087/.126	TCG	15°
P2112072	12	1"	72		.087/.126	TCG	12°
P2112073	12	30MM+PH	72		.087/.126	TCG	12°
P2114084	14	1"	84		.098/.138	TCG	15°

S = Skill Bore

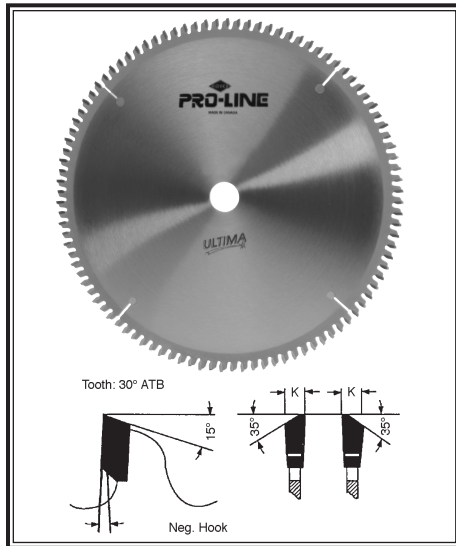
This blade is recommended over the P-17 type on abrasive materials. The T.C.G. grind will last longer and give you the finest cut on plastic laminated boards, laminated plywood-chipboard, arborite, formica and other plastic materials.



P-21 TRIM SAW BLADES "TCG"

PART NUMBER	DIA. INCH	BORE SIZE	NO. TEETH	TOP BEVEL	PLATE KERF	STYLE CUT	HOOK ANGLE
P2110080	10	5/8"	80	.087/.126		TCG	5°
P2112093	12	30MM+PH	96	.087/.126		TCG	5°
P2112096	12	1"	96	.087/.126		TCG	5°

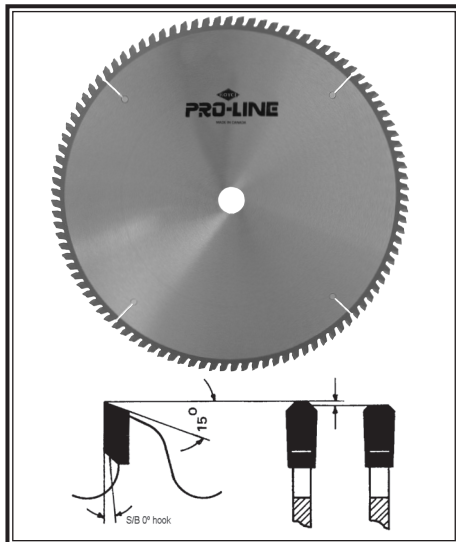
Used for finished work on expensive & abrasive materials as acrylics and thin plastic extrusions where material saving is important. Max thickness 20mm.



P-22 MELAMINE SAW BLADES

PART NUMBER	DIA. INCH	BORE SIZE	NO. TEETH	TOP BEVEL	PLATE KERF	STYLE CUT	HOOK ANGLE
P2210080	10	5/8"	80	35°	.087/.118	ATB	-5°
P2212100	12	1"	100	35°	.087/.118	ATB	-5°
P2212103	12	30MM+PH	100	35°	.087/.118	ATB	-5°

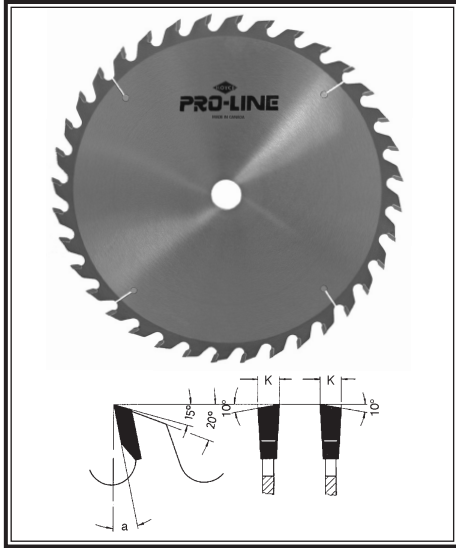
35°ATB grind recommended for chip-free top and bottom cuts in melamine or polyester boards, double faced high and low pressure laminates and printed or painted stock, where a scoring unit is not used.



P-23 SOLID SURFACE SAWBLADES

PART NUMBER	DIA. INCH	BORE SIZE	NO. TEETH	TOP BEVEL	PLATE KERF	STYLE CUT	HOOK ANGLE
P2308060	8	5/8"	60		.087/.126	2TCG	0°
P2309063	220	30MM+PH	60		.087/.126	2TCG	0°
P2310060	10	5/8"	60		.087/.126	2TCG	0°
P2310072	10	5/8"	72		.087/.126	2TCG	0°
P2312084	12	1"	84		.087/.126	2TCG	0°

For making fine cuts in double sided laminated panels, plexiglass and solid surface materials.

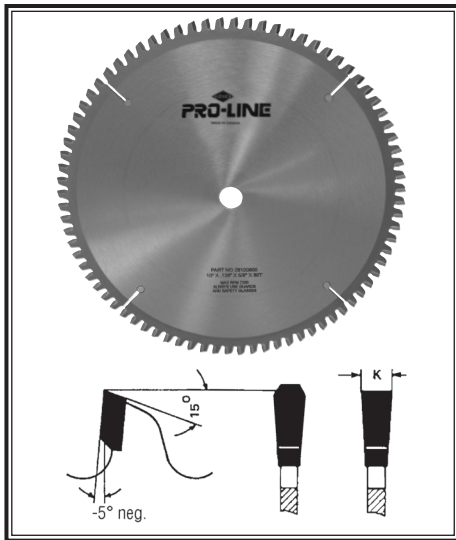


P-26 GENERAL PURPOSE SAW BLADES

PART NUMBER	DIA. INCH	BORE SIZE	NO. TEETH	TOP BEVEL	PLATE KERF	STYLE CUT	HOOK ANGLE
P2606524	6-1/2	5/8"	24	15°	.071/.110	ATB	15°
P2607220	7-1/4	5/8" S	20	15°	.071/.110	ATB	15°
P2608024	8	5/8" S	24	15°	.071/.110	ATB	15°
P2609024	9	5/8"	24	15°	.078/.118	ATB	15°
P2610030	10	5/8"	30	15°	.087/.126	ATB	15°
P2612048	12	1"	48	15°	.087/.126	ATB	15°
P2614042	14	1"	42	15°	.087/.126	ATB	15°

S = Skill Bore

Powerfully built for all purpose cutting under the difficult conditions portable hand saws often face. Alternate top bevel for smooth cuts.



P-28 NON-FERROUS SAW BLADES

PART NUMBER	DIA. INCH	BORE SIZE	NO. TEETH	TOP BEVEL	PLATE KERF	STYLE CUT	HOOK ANGLE
P2807240	7-1/4	5/8" S	40		.071/.095	TCG	-5°
P2808040	8	5/8" S	40		.071/.095	TCG	-5°
P2808060	8	5/8" S	60		.071/.095	TCG	-5°
P2810060	10	5/8"	60		.102/.126	TCG	-5°
P2810080	10	5/8"	80		.102/.126	TCG	-5°
P2810100	10	5/8"	100		.102/.126	TCG	-5°
P2812080	12	1"	80		.102/.126	TCG	-5°
P2812100	12	1"	100		.102/.126	TCG	-5°
P2812103	12	30MM+PH	100		.102/.126	TCG	-5°

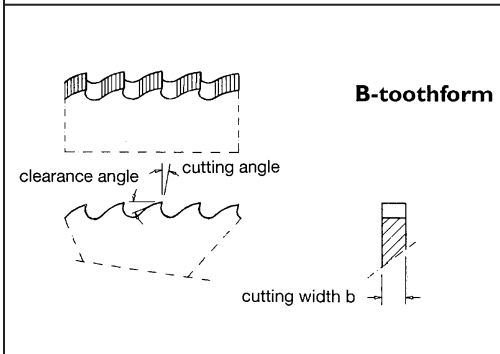
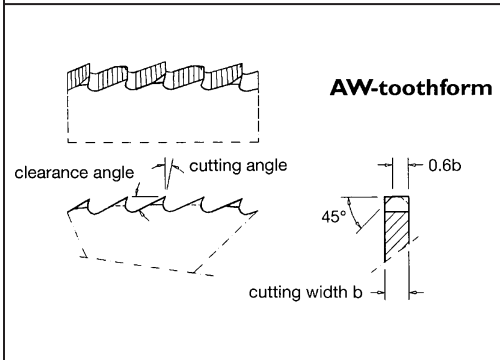
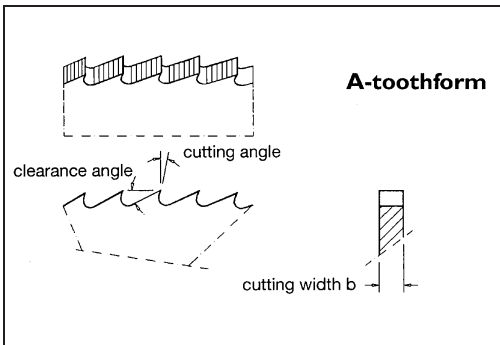
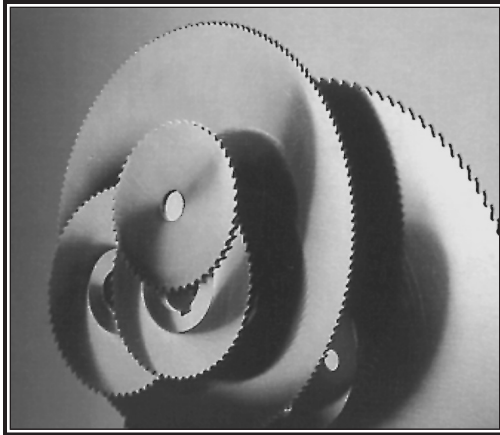
S = Skill Bore

For aluminum and vinyl sections or non-ferrous metals. Max thickness 10mm.

M-32 HSS SAW BLADES - FOR NON-FERROUS METALS



ACCURA HSS saw blades for non-ferrous materials are made of HSS/M-2 material and designed to run at speeds up to 7000 SFPM. These blades are hollow ground, normally in BRIGHT finish and used for cutting aluminum, copper, brass and bronze as well as a variety of plastics. These blades will allow you to cut the above materials with a very clean and scorefree finish.



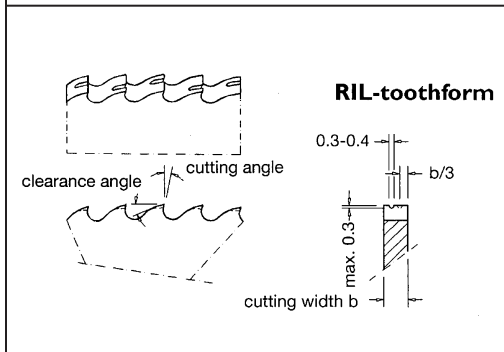
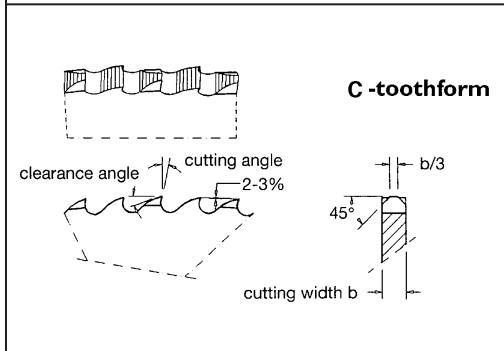
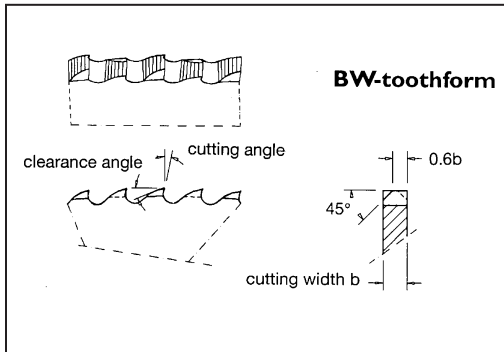
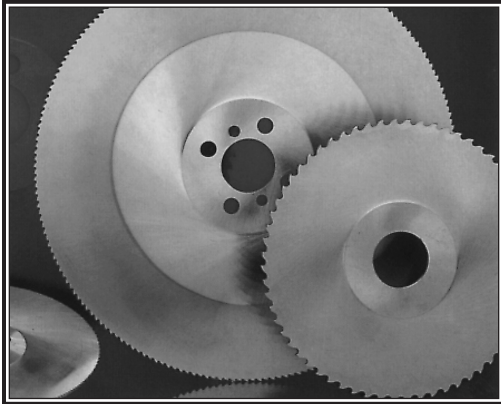
- A** Herringbone tooth used for cutting narrow sections of non-ferrous materials such as aluminum and cooper.
- AW** Herringbone tooth with alternate chip for thicker blades.
- B** Curved tooth for cutting solid sections of non-ferrous materials and materials that produce long chips.

PART NO. STANDARD	DIAM. INCH	DIAM. MM	KERF INCH	KERF MM	BORE	TEETH
M32150121	6	150	.047	1.2	5/8"	AS
M32150161	6	150	.063	1.6	5/8"	
M32175161	7	175	.063	1.6	5/8"	
M32200121	8	200	.047	1.2	5/8"	REQUIRED
M32200161	8	200	.063	1.6	5/8"	
M32200201	8	200	.078	2.0	5/8"	
M32200251	8	200	.098	2.5	5/8"	
M32200301	8	200	.118	3.0	5/8"	
M32225121	9	225	.047	1.2	5/8"	
M32225161	9	225	.063	1.6	5/8"	AS
M32225201	9	225	.078	2.0	5/8"	
M32225251	9	225	.098	2.5	5/8"	
M32250121	10	250	.047	1.2	5/8"	
M32250161	10	250	.063	1.6	5/8"	REQUIRED
M32250201	10	250	.078	2.0	5/8"	
M32250251	10	250	.098	2.5	5/8"	
M32250301	10	250	.118	3.0	5/8"	
M32275201	11	275	.098	2.0	5/8"	
M32300122	12	300	.047	1.2	1"	
M32300161	12	300	.063	1.6	5/8"	AS
M32300162	12	300	.063	1.6	1"	
M32300201	12	300	.078	2.0	5/8"	
M32300202	12	300	.078	2.0	1"	REQUIRED
M32300251	12	300	.098	2.5	5/8"	
M32300252	12	300	.098	2.5	1"	
M32300301	12	300	.118	3.0	5/8"	
M32300302	12	300	.118	3.0	1"	
M32315251	12.5	315	.098	2.5	5/8"	
M32315252	12.5	315	.098	2.5	1"	AS
M32315301	12.5	315	.118	3.0	5/8"	
M32350202	14	350	.078	2.0	1"	
M32350251	14	350	.098	2.5	5/8"	REQUIRED
M32350252	14	350	.098	2.5	1"	
M32350302	14	350	.118	3.0	1"	
M32400252	16	400	.098	2.5	1"	
M32400302	16	400	.118	3.0	1"	REQUIRED
M32400352	16	400	.138	3.5	1"	

Other sizes are available on request.

HSS saw blades are hollow ground and furnished with herringbone teeth for use on table, radial arm and chop saws.

Note: It is important that materials to be cut are securely held in place and the use of a lubricant is advised for easier cutting and longer blade life.



“Notch” tooth -RIL

This tooth form is specially designed for cutting off thin-walled tubes and small sections. With this tooth form, one can work with higher cutting speeds and feeds (50-200%) and in addition the service life is improved.

Always use high quality cutting fluid for maximum efficiency in cutting and blade life.

C-31 COLD SAW BLADES - FOR FERROUS METALS

COATING: BLACK VAPORIZED

PART NO. STANDARD	DIAM. MM	KERF MM	BORE MM	TEETH
C31160163	160	1.6	32	A S
C31200173	200	1.7	32	
C31200203	200	2.0	32	
C31210203	210	2.0	32	R E Q U I R E D
C3122516*	225	1.6	32 or 40	
C3122520*	225	2.0	32 or 40	
C31250254	250	2.5	40	
C3125016*	250	1.6	32 or 40	
C3125020*	250	2.0	32 or 40	
C3125025*	250	2.5	32 or 40	A S
C3125030*	250	3.0	32 or 40	
C3127520*	275	2.0	32 or 40	
C3127525*	275	2.5	32 or 40	R E Q U I R E D
C31275304	275	3.0	40	
C31300203	300	2.0	32	
C3130025*	300	2.5	32 or 40	R E Q U I R E D
C31300256	300	2.5	38	
C3130030*	300	3.0	32 or 40	
C31315204	315	2.0	40	A S
C3131525*	315	2.5	32 or 40	
C31315256	315	2.5	38	
C3131530*	315	3.0	32 or 40	R E Q U I R E D
C3132525*	325	2.5	32 or 40	
C31325256	325	2.5	38	
C3132530*	325	3.0	32 or 40	A S
C3135025*	350	2.5	32 or 40	
C31350255	350	2.5	50	
C3135030*	350	3.0	32 or 40	R E Q U I R E D
C31350305	350	3.0	50	
C31370254	370	2.5	40	
C3137030*	370	3.0	32 or 40	A S
C31370305	370	3.0	50	
C31400304	400	3.0	40	
C31400305	400	3.0	50	
C31400354	400	3.5	40	
C31400355	400	3.5	50	A S
C31425354	425	3.5	40	
C31425355	425	3.5	50	
C31450354	450	3.5	40	R E Q U I R E D
C31450355	450	3.5	50	
C31500404	500	4.0	40	
C31500405	500	4.0	50	

COATING: PERFORMANCE OR KIN 101

PART NO. STANDARD	DIAM. MM	KERF MM	BORE MM	TEETH
C31225203 PERF or KIN101	225	2.0	32	A
C31250203 PERF or KIN101	250	2.0	32	S
C31250254 PERF or KIN101	250	2.5	40	
C3127525* PERF or KIN101	275	2.5	32 or 40	R
C3130025* PERF or KIN101	300	2.5	32 or 40	E
C31315204 PERF or KIN101	315	2.0	40	Q
C3131525* PERF or KIN101	315	2.5	32 or 40	U
C3135025* PERF or KIN101	350	2.5	32 or 40	I
C31350305 PERF or KIN101	350	3.0	50	R
C31400354 PERF or KIN101	400	3.5	40	E
C31400355 PERF or KIN101	400	3.5	50	D

* add 3 in place of asterix for 32mm bore

* add 4 in place of asterix for 40mm bore

SELECTION GUIDE FOR HSS COLD SAW BLADES

Type of Machine	DIAM.	BORE	Pinholes
ADIGE-SALA	200-250	32	4/9/50
	275-315	32	2/11/63
	350	40	4/12/64
	400-425	50	4/15/80
BAIER	175-250	32	Keyways
BEWO	250-300	32	2/8/45 Man.
	315	40	2/8/55 Man.
	350	40	4/11/63 Man.
	315	40	4/11/63 Aut.
BIMAX	100-300	32	2/8/45
BONAK	250-350	40	2/8/55+4/12/64
BROBO-WALDOWN	250	32	2/11/63
	300	38	2/9/55
	300-400	40	2/8/55+4/12/64
	500	40	2/8/55+4/12/64+2/12/80
CONNI	400-425	40	4/11/63
	400-425	50	4/15/80
DEMURGER	160-300	25.4	- - -
	200-250	32	2/8/45+2/11/63
	225-300	40	2/8/55+4/12/64
DONG-JIN	300-370	40	2/8/55+4/12/64
DORINGER	315-350	40	2/12/64
EISELE	210-225	40	2/8/55
	250-350	40	2/8/55+4/12/64
	370-450	40	2/12/64+2/15/80
	500	40	2/15/80+2/15/100
FABRIS	225-350	32	2/8/45+2/11/63
FEMI	225-315	32	2/8/45+2/11/63
FONG-HO	250-275	32	2/8/45+2/9/50+2/11/63
	300-400	32	4/11/63
	360	40	2/11/63+3/11/65
HAEBERLE	225-315	40	2/8/55
IBP-PEDRAZOLLI	200-350	32	2/11/63
	425	50	4/15/80
IMET	250-350	32	2/8/45+2/11/63
	315-350	40	2/8/55+4/12/64
KALTENBACH	225-250	32	- - -
	350-370	50	4/15/80
KASTO	425	50	4/15/80
MACC	225-350	32	2/8/45+2/11/63

Type of Machine	DIAM.	BORE	Pinholes
MACO	425	50	5/15/80
MAIR	300-350	32	2/8/45+2/11/63
	300-350	40	2/8/55+4/12/64
MEP	225-350	32	2/8/45+2/11/63
METORA	275-350	32	2/11/80
OMES	250-300	32	2/8/45+2/11/63
O.M.P.	250-370	32	2/8/45+2/11/63
	400-525	50	4/15/80
R.G.A.	250	25.4	- - -
	275-370	40	2/8/55+2/11/63
ROBEJO	250-350	32	2/8/45+2/11/63
ROHBI	175-250	32	2/8/45
SCOTCHMAN	250-275-300	32	2/8/45+2/11/63
	275-315-350	40	2/8/55+4/12/64
SIMEC	250-350	32	4/11/63
SINICO	350	32	2/8/45+2/11/63
SOCO	250-350	32	2/11/63
	300-315	32	2/11/80
STAYER	225	32	- - -
THOMAS	225-300	32	2/8/45+2/11/63
	315-350	32	2/11/63+2/12/75
TOMET	200-315	32	2/8/45+2/11/63
TRENNJAEGER	250-275	40	4/11/63
	315-360	50	4/14/85
	400	50	4/14/85
ULMIA	160-250	32	- - -
	250-400	40	4/11/63
VIEMME	250-350	32	2/8/45+2/11/63
VOUCHER	275	35	2/13,5/57,2
WAGNER	200-315	32	4/9/50
	350	50	4/14/80
WAHLEN	250-400	40	2/8/55+2/11/63
WEIDMAN	210-275	32	2/8/45
WINTER	250-315	40	2/8/55+4/11/63
WUNSCH	210-250	32	2/8/45
	210-300	40	2/8/55
	315-400	40	2/8/55+4/12/64

Example: 2 / 8 / 45 means 2 pinholes of 8mm with a 45mm pinhole center distance.



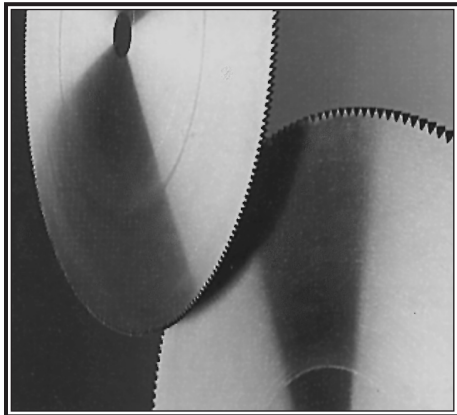


Heavy Duty Segmental Circular Saw Blades
with fitted HSS-segments
diam. 250-3000mm,
in all types of tothing for steel
and non-ferrous.

Always use our high quality Mecanoil cutting fluid for maximum efficiency in cutting and blade life.

S-33 HSS SEGMENTAL SAW BLADES

PART NO. BLADE	DIAM. MM	KERF MM	BORE MM	TEETH	PART NO. SEGMENT	DIAM. MM	KERF MM
S33250303	250	3.0	32		S3325030	250	3.0
S33250304	250	3.0	40		S3325030	250	3.0
S33275303	275	3.0	32		S3327530	275	3.0
S33275304	275	3.0	40		S3327530	275	3.0
S33315363	315	3.6	32	A	S3331536	315	3.6
S33360364	360	3.6	40	S	S3336036	360	3.6
S33360365	360	3.6	50		S3336036	360	3.6
S33400404	400	4.0	40	R	S3340040	400	4.0
S33400405	400	4.0	50	E	S3340040	400	4.0
S33460504	460	5.0	40	Q	S3346050	460	5.0
S33460506	460	5.0	60	I	S3346050	460	5.0
S33510575	510	5.7	50	R	S3351057	510	5.7
S33560505	560	5.0	50	E	S3356050	560	5.0
S33560508	560	5.0	80	D	S3356050	560	5.0
S33630608	630	6.0	80		S3363060	630	6.0
S33660608	660	6.0	80		S3366060	660	6.0
S33710628	710	6.2	80		S3371062	710	6.2
S33810688	810	6.8	80		S3381068	810	6.8
S33910708	910	7.0	80		S3391070	910	7.0
S331010800	1010	8.0	100		S33101080	1010	8.0

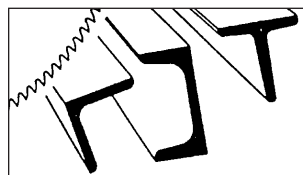


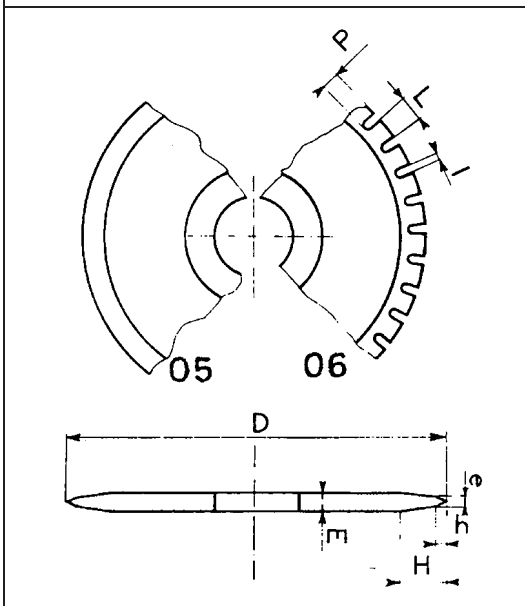
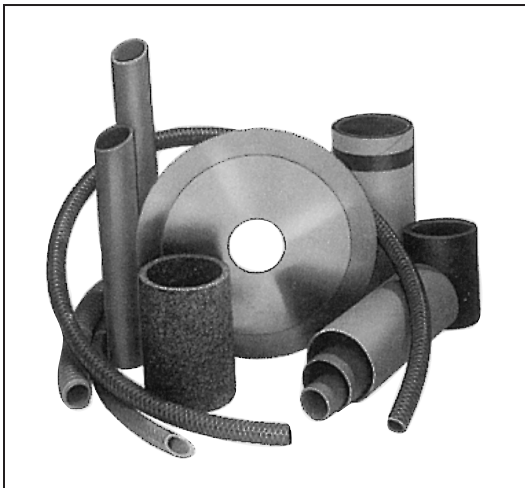
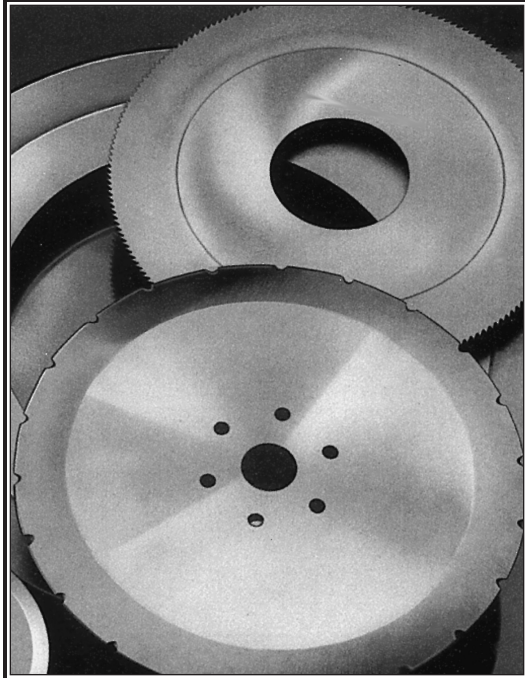
Friction saw blades are made of chrome vanadium or tungsten molybdenum steel and hollow ground on both sides. They are used on high speed machines to cut at 18,000 to 24,000 SFPM.

F-34 CV FRICTION SAW BLADES - FOR FERROUS METALS

PART NO. STANDARD	DIAM. MM	KERF MM	BORE MM	TEETH
F34200201	200	2.0	5/8"	160
F34250201	250	2.0	5/8"	180
F34250251	250	2.5	5/8"	180
F34300302	300	3.0	1"	180
F34350302	350	3.0	1"	200
F34400304	400	3.0	40MM	240
F34400404	400	4.0	40MM	240
F34450404	450	4.0	40MM	240
F34520404	520	4.0	40MM	300
F34520504	520	5.0	40MM	300
F34560504	560	5.0	40MM	300
F34600504	600	5.0	40MM	300
F34750604	750	6.0	40MM	360

Other sizes are available on request.





Accura®

Circular Knives

Series - 122

The Royce//Ayr range of production also includes circular knives made from M-2 High Speed Steel. M-2 is a tough tool steel with few compromises. All our knives are triple tempered to ensure maximum toughness.

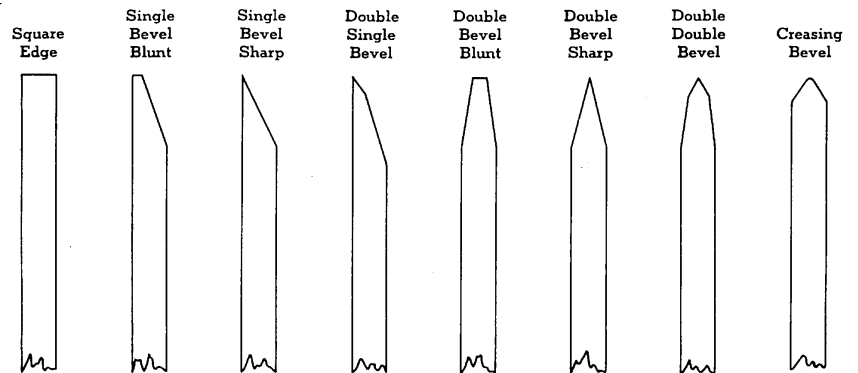
The technical characteristics of the knives such as Thickness, Angle of Bevel, Single or Double Bevel and the addition of teeth or slots depend on the material to be cut.

We gladly invite your special inquiries. All dimensions are available as special made-to-order items.

DIAM. MM	DIAM. INCH	KERF MM	KERF INCH	BORE
150	6	1.6	.063	5/8"
175	7	1.6	.063	5/8"
200	8	1.6	.063	5/8"
200	8	2.0	.078	5/8"
200	8	2.5	.098	5/8"
200	8	3.0	.118	5/8"
225	9	1.6	.063	5/8"
225	9	2.0	.078	5/8"
225	9	2.5	.098	5/8"
250	10	1.6	.063	5/8"
250	10	2.0	.078	1"
250	10	2.5	.098	1"

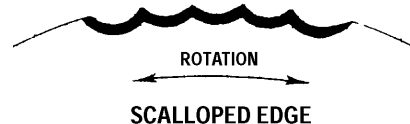
DIAM. MM	DIAM. INCH	KERF MM	KERF INCH	BORE
250	10	3.0	.118	1"
275	11	1.6	.063	1"
275	11	2.0	.078	1"
275	11	2.5	.098	1"
300	12	1.6	.063	1"
300	12	2.0	.078	1"
300	12	2.5	.098	1"
300	12	3.0	.118	1"
350	14	2.5	.098	1"
350	14	3.0	.118	1"
400	16	3.0	.118	1"
400	16	3.5	.138	1"

Other sizes are available on request.

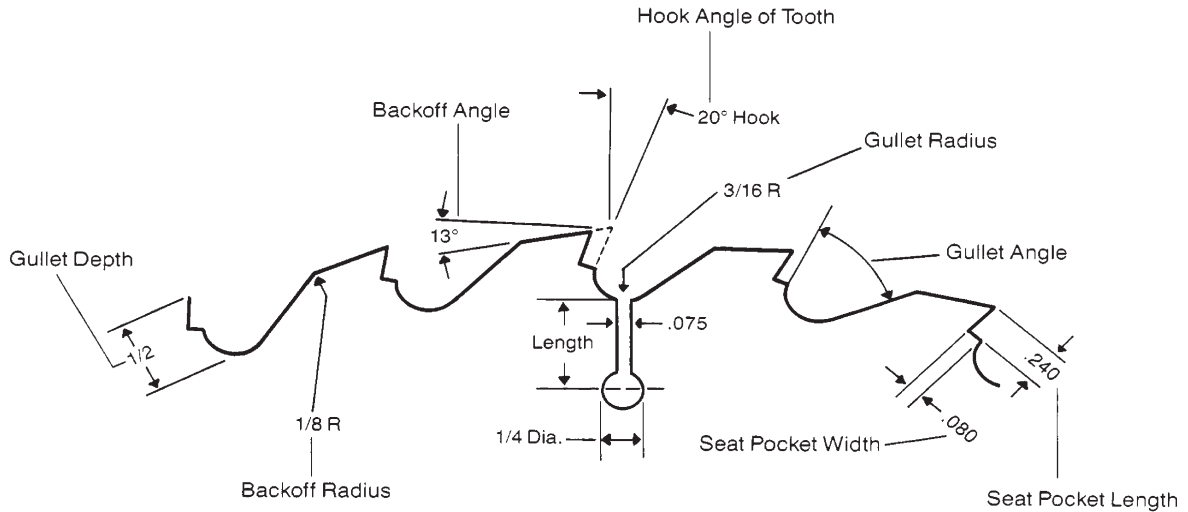


BEVELS

We recommend wherever possible that a single bevel cutter be used. They not only have a good cutting action but are much easier to maintain and to sharpen. The degree of bevel varies according to your application. Keeping in mind the objective is to provide strength to the edge, yet be small enough to minimize the compression and friction with attendant heat and added power that is required.



Custom Manufactured Saw Blades

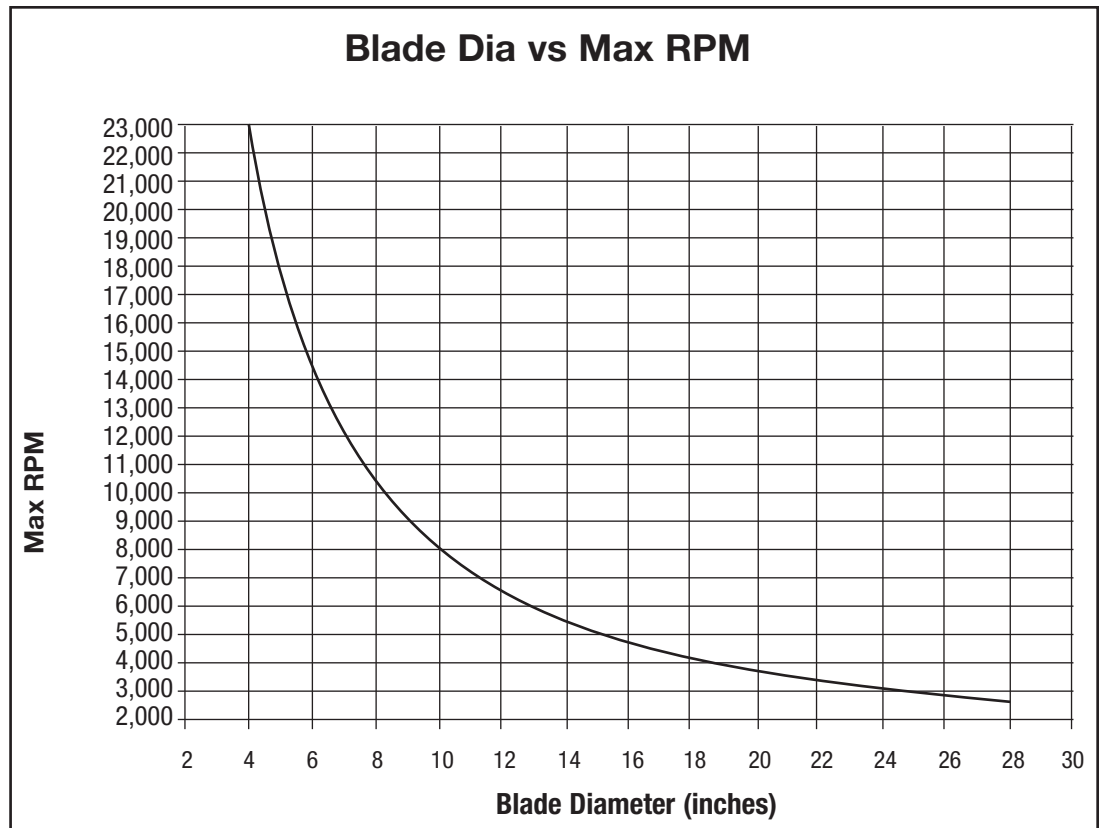


Beside the range of Industrial saw blades featured in this catalogue Royce//Ayr also manufactures saw blades to your exact specifications. Above sketch shows some of the information we may need to be able to build your special saw blade.

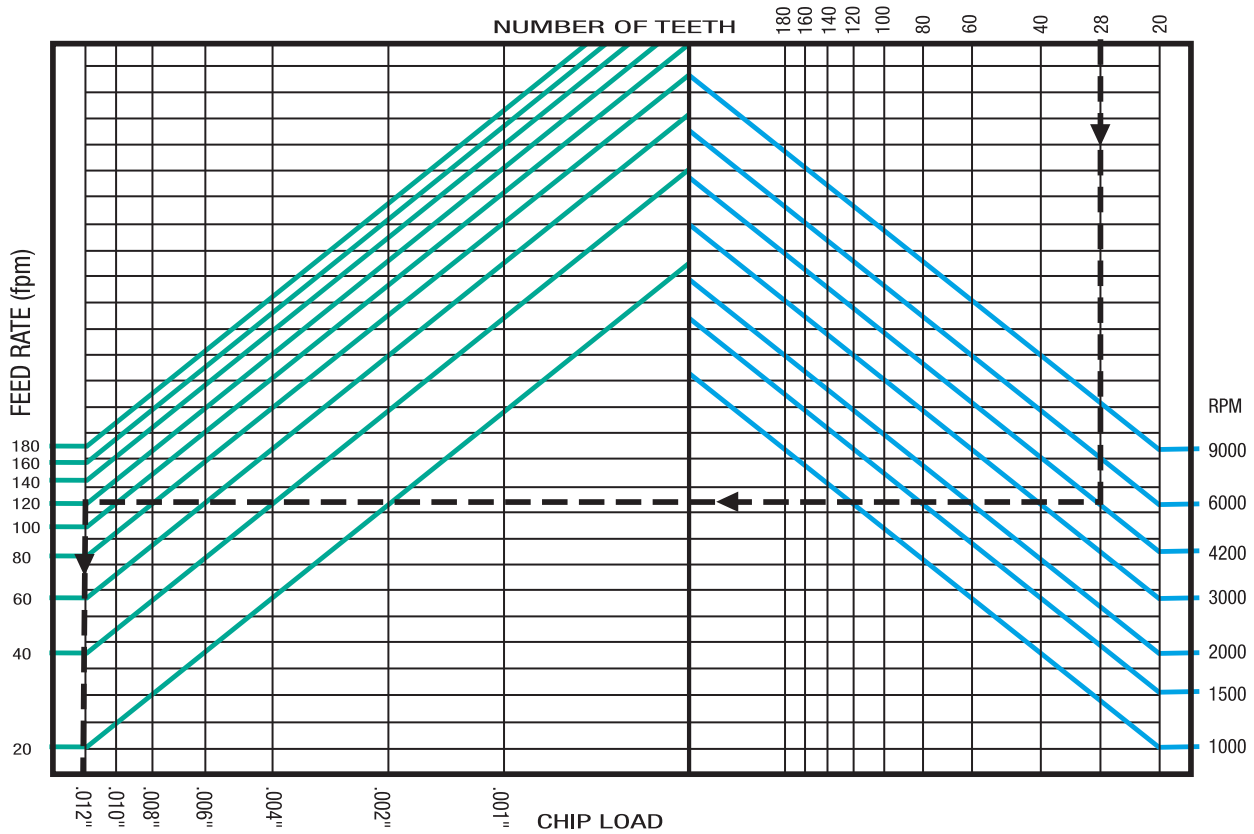
When ordering please also specify the outside diameter and bore size as well as any additional pinholes, countersunk holes or keyways needed. We also need to know the plate thickness you require and the finished kerf of the tip. Please also tell us the application this blade is to be used for and the arbor speed and if known; the feed speed. This information will help us to ensure that you are getting the very best product for your specific use.

Blade Max. RPMs in Relation to Diameter

BLADE DIA		MAX RPM
INCHES	MM	
3	80	22,900
4	100	22,600
5	125	18,300
5.5	140	16,300
6	150	14,000
7	175	13,000
8	200	11,400
9	230	10,600
10	250	9,100
12	300	7,550
14	350	5,250
16	400	4,500
18	450	4,000
20	500	3,500
22	550	3,000
24	600	2,750
26	650	2,700
28	700	2,500



Chip load per tooth



Example: A 28 tooth saw rotating at 4200 rpm with a feed rate of 120 fpm will have a chipload of .012"

The chip load per tooth may vary depending on the type of finish required. The following chip loads are recommended: Regular finish— .015", Fine finish— .010", Extra fine finish— .005"

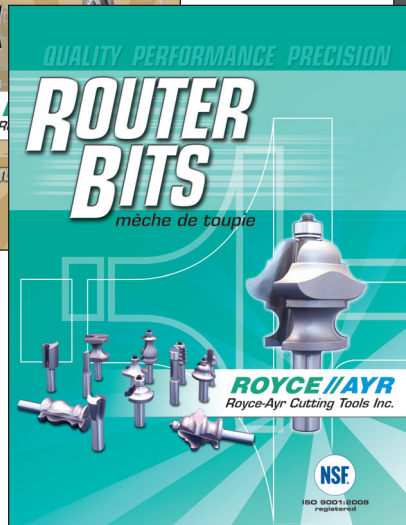
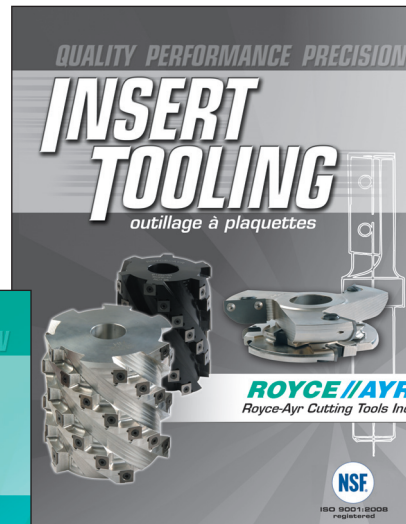
With saw arbor running at 3600 RPM the following summary gives the feed rate per revolution and the chip load per tooth in relation to the feed per minute into the saw.

FEED PER/MIN (FEET)	100	150	200	250	300
FEED PER/REVOLUTION	.333	.500	.666	.833	1 INCH
NO. OF TEETH					
12	.027	.040	.055	.069	.083
16	.020	.031	.041	.052	.062
20	.016	.025	.033	.041	.050
24	.013	.020	.027	.034	.041
30	.011	.016	.022	.027	.033
36	.009	.013	.018	.023	.027
40	.008	.012	.016	.020	.025
60	.005	.008	.011	.013	.016
80	.004	.006	.008	.010	.012
100	.003	.005	.006	.008	.010
120	.002	.004	.005	.007	.008

For other RPM values use this formula : $Chipload = \frac{12 \times \text{feed per minute}}{RPM \times \text{Number of teeth}}$

All tools offered from stock are subject to availability. The buyer agrees to partial deliveries which will be considered separate transactions. Cancellation or alteration of orders are subject to our written consent. Returns will only be accepted upon written prior approval and the assignment of an authorized return number. Custom tools made to special order are not returnable.

Delivery lead time is based on production scheduling and material availability, and starts from date of order confirmation. Every effort will be made to fulfill delivery commitments. Any delay, for any reason, will not be liability for any loss or damage.



GUARANTEE

All our tools are manufactured according to specifications described in this catalogue. Tools suspected to be defective and returned for inspection are to be shipped prepaid. We will only replace tools which prove, upon our examination, to have material and/or manufacturing defects. Tools that have been misused or carelessly handled are not guaranteed. We do not accept any responsibility or liability for mistakes caused by improper application, handling, or inappropriate sharpening. We reserve the right to change specifications from those published in this catalogue as part of our continual product improvement process.

**Canada's leading manufacturer
and supplier of quality stock
and custom designed tools for
the woodworking, plastics and
non ferrous metal industries.**

Products Include:

- Carbide Tipped Saw Blades
- Industrial Router Bits
- Custom Profile Cutters
- Diamond Tipped Tooling
- Sticker and Moulder Heads
- Insert Tooling
- Disposable Knives
- Boring Bits and Drills
- HSS and C/T Knife Stock
- Sharpening Service
- HSS Metal Cutting Saw Blades

*For a complete line of catalogs and competi-
tive prices, call our toll free phone number
or contact your local Royce-Ayr distributor.*



ROYCE//AYR
Royce-Ayr Cutting Tools Inc.

405 Sheldon Drive
Cambridge, ON Canada N1T 2B7
voice (519) 623.0580
(800) 959.5641
fax (519) 623.9371
www.royceayr.com
email: customer.service@royceayr.com

Edition: SB 2012