



03/2020

I.T.E.C.
Carbon Cutting Solutions

Leading Through Innovation

Industrial Saw Blades for Carbon Composite Materials

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DryTech® TCT SAW BLADES

Applicable on:

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

Suitable for:

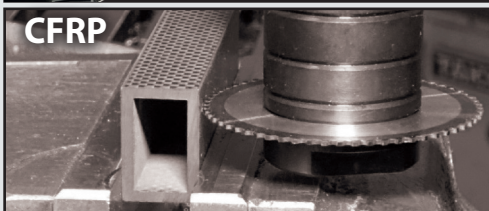
- *CFRP, CFRTP, Aramid Fibre Reinforced Plastics, GF, Prepreg*
- *Pipes, profiles, plates*

Advantages:

- Clean cutting edge
- Prevent delamination due to finest pitch
- No delamination against different direction
- Less chip volume
- Material saving through thin cut technology
- Less heat processing due to lower cutting resistance

Wall thickness ≤ 10 mm					
Ø [mm]	Kerf [mm]	Body [mm]	Bore [mm]	Teeth	Reference
70	1	0,9	22,2H	60	AURDTS07060
80	1	0,9	22,2H	68	AURDTS08068
115	1	0,9	22,2H	100	AURDTS115100
120	1	0,9	22,2H	60	AURDTS120060
120	1	0,9	22,2H	80	AURDTS120080
120	1	0,9	22,2H	100	AURDTS120100
150	1	0,94	25,4H	80	AURDTS150080
150	1	0,94	25,4H	100	AURDTS150100
150	1	0,94	25,4H	120	AURDTS150120
192	1	0,94	20,0H	160	AURDTS192160
200	1,2	0,94	30,0H	180	AURDTS200180
255	1,4	1,2	25,4H	220	AURDTS255220
305	1,6	1,4	25,4H	260	AURDTS305260
355	2,0	1,7	25,4H	300	AURDTS355300
405	2,5	2,25	30,0H	280	AURDTS405280
Customized pin holes and bore on request!					

Recommended Cutting Parameters	
Cutting speed	3.000 m/min
Feed speed	4.000 - 15.000 mm/min
Dry Cutting!	

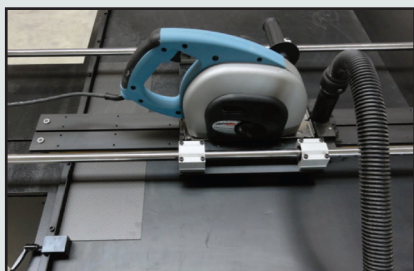
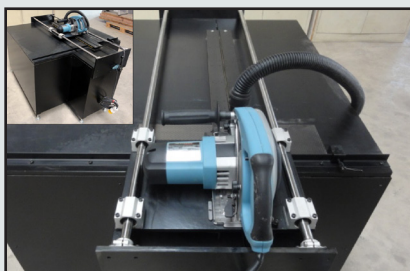


Wall thickness ≥ 10 mm					
Ø [mm]	Kerf [mm]	Body [mm]	Bore [mm]	Teeth	Reference
250	4	3,0	30,0H	80	AURDTS250080
305	4	3,0	30,0H	100	AURDTS305100
355	4	3,0	30,0H	120	AURDTS355120
Customized pin holes and bore on request!					

CFRP Panel Cutting Unit

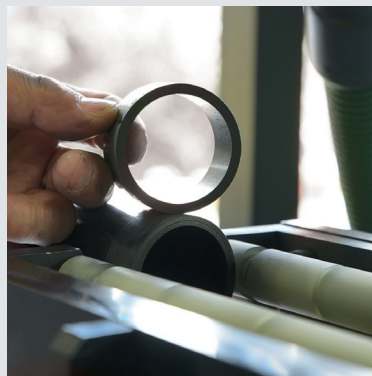
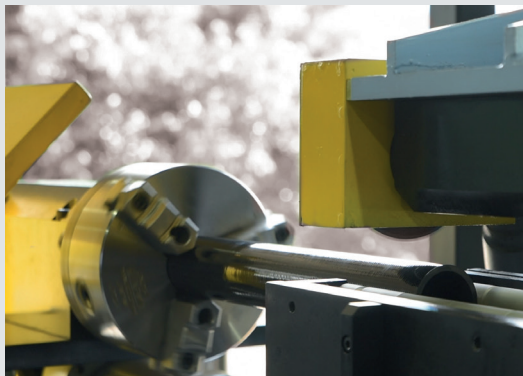
- Sturdy built construction, completely covered
- Max. Cutting Capacity: 800 x 800 x 6 mm
- Anti-slip rubber pad to protect against material damage
- Spring pressure clamping system
- Length stopper
- Dust vacuum up directly from the cut (90%), further exhaust pipe at the rear part of the table available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

Specifications Model: JEPSON HDC 8200	
Power input	1.700 W
Voltage	230V/50Hz or 115V/60Hz
No load speed	3.700 rpm
Saw blade	Aurora Ø 200 x 1,2 x 0,94 x 30 x 180T included
Dimensions	1.100 x 1.490 x 890 mm
Weight, Color	372 kg, black
Connection hose	Ø 35,5 mm



CF Pipe Cutting Machine

Suitable for CFRP, CFRTF, FRP & other composite pipes
High speed DRY CUTTING with high precision



Sawing by rotating pipe & saw blade

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

2-step feed speed

1st step: slow motion feed: cut into material slowly

2nd step: high speed cutting feed to avoid burrs

Precise clamping

Pipe clamping through split claw scroll chuck.

Excellent cutting accuracy.

Specifications	
Weight	500kg
Power	380V 2,6kW
Revolution	MAX6000rpm (variable)
Feed rate	Variable
Saw blade diameter	Ø 115mm
Applicable pipe size: Outer diameter	Ø 10-120mm
Applicable pipe size: Thickness	0.5-10t (maximum thickness of Ø 30mm up to 5mm wall thickness)



DRYTECH - Aurora TCT

saw blade

115 x 1.0 x 0.94 x 100 T

recommended

DryTech® JIG/Recipro Saw Blades

Excellent cutting quality without delamination in Carbon Fibre Reinforced Plastics.

Advantages:

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

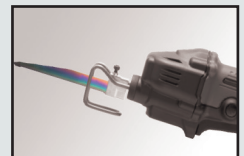
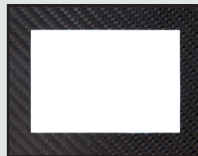
Applicable on:

- on common Jig- and Recipro Saws

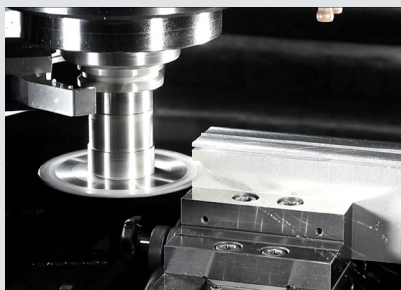
Suitable for:

- *CFRP, CFRTF, AFRP, GFC*

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



DryTech® TCT Saw Blades for Aluminum



Mass Cutting:

- Aluminum and NF-Metals
- Tubes and Profiles
- Solid Materials

Saw blade diameter
from Ø 200 mm up to 600 mm

Saw blade revolution: 3.000 rpm

Special Milling Cutters		
Aluminum $v_c = 320 \text{ m/min}$	$f_z = 0,029 \text{ mm}$	
Sizes in mm	$a_e \text{ Max}$	Number of teeth
100 x 3	35	16
125 x 3	42,5	16
160 x 3	55	20

Reference	Ø [mm]	Kerf/Body [mm]	Bore [mm]	Teeth
AL20030060	200	3.0 / 2.0	30	60
AL21630060	216	3.0 / 2.0	30	60
AL25030060	250	3.2 / 2.2	30	60
AL25032060	250	3.2 / 2.2	32	60
AL25030080	250	3.2 / 2.2	30	80
AL25032080	250	3.2 / 2.2	32	80
AL30030072	300	3.2 / 2.4	30	72
AL30032072	300	3.2 / 2.4	32	72
AL30030084	300	3.2 / 2.4	30	84
AL30032084	300	3.2 / 2.4	32	84
AL30030096	300	3.2 / 2.4	30	96
AL30032096	300	3.2 / 2.4	32	96
AL35030084	350	3.4 / 2.8	30	84
AL35032084	350	3.4 / 2.8	32	84
AL35030096	350	3.4 / 2.8	30	96
AL35032096	350	3.4 / 2.8	32	96
AL35030108	350	3.4 / 2.8	30	108

Reference	Ø [mm]	Kerf/Body [mm]	Bore [mm]	Teeth
AL35032108	350	3.4 / 2.8	32	108
AL40030096	400	3.4 / 2.8	30	96
AL40032096	400	3.4 / 2.8	32	96
AL40030120	400	3.4 / 2.8	30	120
AL40032120	400	3.4 / 2.8	32	120
AL42030108	420	3.8 / 3.0	30	108
AL42032108	420	3.8 / 3.0	32	108
AL45030096	450	3.8 / 3.0	30	96
AL45032096	450	3.8 / 3.0	32	96
AL45030108	450	3.8 / 3.0	30	108
AL45032108	450	3.8 / 3.0	32	108
AL50030120	500	4.0 / 3.2	30	120
AL50032120	500	4.0 / 3.2	32	120
AL55030132	550	4.2 / 3.5	30	132
AL55032132	550	4.2 / 3.5	32	132
AL60030144	600	4.2 / 3.5	30	144
AL60032144	600	4.2 / 3.5	32	144

Special sizes on request!

Customized center and pin holes

Reshaping services

DryTech® Dry - Fast - Burr Free High-Speed Metal Cutting Saw Blades

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

Fast cutting, burr free and without coolant of pipes and profiles made of steel, stainless steel, plastics, **composite materials**, aluminum and other non-ferrous metals.

DryTech® TCT saw blades are designed to cut diverse kinds of materials and shapes due to a wide range of different geometries (trims, tubes, shutter profiles, sandwich panels, window profiles and airing profiles etc.). Special tooth shapes guarantee a perfect cutting surface and a long blade life.

Advantages:

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

Specifications	
Saw blade diameter	125 - 730 [mm]
Cutting capacity	Ø 6 - 240 [mm]
Cutting speed	max. 1.800 [m/min]
Feed speed	max. 6.000 [mm/min]
Cutting width (kerf)	2,0 - 4 [mm]
Center hole	Customer specific
Pin holes	Customer specific

DryTech® Dry - Fast - Burr Free High-Speed Metal Cutting Saw Blades

Ø [mm]	Bore [mm]	Kerf [mm]	Teeth	Reference	Application	Ø [mm]	Bore [mm]	Kerf [mm]	Teeth	Reference	Application
160	30*	1,80	32	DTS1603032	steel	305	25,4	3,00	72	DTS3050720003C	cast iron
180	30*	1,85	36	DTS1803036	steel	305	25,4	2,20	80	DTS3050801003	steel - thin
180	20	1,85	48	DTS1802048	steel	355	25,4	2,20	90	DTS3550901004	steel & stainless - thin
180	20	1,60	48	DTS1802048YS	steel	355	25,4	2,20	72	DTS3550721003	steel & stainless - medium
192	20	1,85	40	DTS1922040	steel	355	25,4	2,20	66	DTS3550660002	steel
192	20	1,85	48	DTS1922048	steel - thin	405	25,4	2,50	80	DTS4050800002	steel
192	20	1,85	70	DTS1922070	metal sheets	405	25,4	2,50	102	DTS4051021003	steel & stainless
200	30*	1,90	40	DTS2003040	steel	455	50,0	3,40	100	DTS4551000002	steel
200	30*	1,90	60	DTS2003060	steel - thin	455	50,0	3,40	120	DTS4551201003	steel & stainless
210	30*	2,00	42	DTS2103042	steel	560	50,0	3,60	120	DTS5601200002	steel
210	30*	2,00	64	DTS2103064	steel - thin	560	50,0	3,60	132	DTS5601321003	steel & stainless
230	25,4	2,00	48	DTS2303048	steel	630	60,0	4,00	140	DTS6301400002	steel
230	25,4	2,00	60	DTS2303060	aluminum	630	60,0	4,00	150	DTS6301501003	steel & stainless
230	25,4	2,00	68	DTS2303068	steel - thin	630	60,0	4,00	210	DTS6302100002	steel
230	25,4	2,00	84	DTS2303084	metal sheets	680	60,0	4,00	140	DTS6801400002	steel
255	25,4	2,00	60	DTS2550600002	steel	680	60,0	4,00	150	DTS6801501003	steel
255	25,4	2,00	66	DTS2550661003	steel - thin	680	60,0	4,00	210	DTS6802100002	steel
305	25,4	2,20	60	DTS3050600002	steel	700	60,0	4,00	210	DTS7002100002	steel
305	25,4	2,00	72	DTS3050720002C	steel and stainless	730	60,0	4,00	210	7302100002	steel

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

Special sizes on request!

Saw blades with excellent performance in stainless steel



Ø [mm]	Bore [mm]	Kerf [mm]	Teeth	Reference
25,4	2,0	2,0	48	2300481003COA
25,4	2,0	2,0	66	2550661003COA
25,4	2,2	2,2	90	3550901004COA
25,4	2,5	2,5	102	4051021003COA
25,4	3,4	3,4	120	4551201003COA
25,4	3,6	3,6	132	5601321003COA

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