



Cold Saw Blade

Features



- **CERMET TIP:** ASPHALT uses high grade CERMET alloy tip, Within the special grinding machine ASPHALT cold saw blade will become your best Friend in metal cutting.
 - **BODY:** ASPHALT uses only the very best steel for its saw blades. After heat treatment, the saw plate is very flat. ASPHALT'S proprietary flattening and surface grinding process ensure that the plate is distortion free and has a uniform thickness. A good plate with high rigidity is essential for straight running of saw blades.
 - TIP SHAPE: Cold saw blade is different from the normal sawblade. Because it has special shape's tip, and tip is using CERMET.
 - **BRAZING:** Our special brazing technology leads to a higher braze joint strength and therefore teeth are Firmly attached to the plate to prevent carbide breakage.
 - **Grinding:** Actively Introduce the latest equipment. The robot polishing machine dramatically improves the polishing accuracy by fully automating, and the German polishing machine realizes high production by labor saving. Trust is born from the short delivery time by high efficiency production and high quality by high precision processing.
- **PERFORMANCE:** Due to originally developed coating, our cold saw blades provide the longest lifetime and stable performance for the maximum productivity and the lowest cost per cut. Also **ASPHALT** cold saw blade can be resharpened several times.



Cold Saw Blade For Metal Cutting

Recommended For

Carbon Steel Alloy Steel Bearing Steel

Diameter	Arbor	Kerf	Body Thickness	Teeth
250	32	2	1.7	60/72/80/100/120
285	32	2	1.7	60/72/80/100/120
315	32 / 40	2	1.7	60/72/80/100/120
360	40	2.6	2.25	60/72/80/100
390	40	2.6	2.25	60/72/80
420	50	2.7	2.25	60/72/80/100
460	50	2.7	2.25	60/72/80

Grade Description

Factors	PL2O - Series	PM2O - Series (Recommended)	PH2O - Series
Edge Material	Cermet + PVD (Golden Coated)	Cermet	Cermet
Work Material	Low Carbon Steel	Medium/High Carbon Steel	High Carbon Steel
Carbon Content	≤0.25 %	≤0.45 %	≤0.75 %
RPM	90-130	90-120	70-100
Chip Load	0.04-0.07	0.04-0.06	0.04-0.06







Cermet tipped with a special tooth geometry



Cold Saw Blade For Metal Cutting

Recommended For

Stainless Steel

Diameter	Arbor	Kerf	Body Thickness	Teeth	Grade
250	32	2	1.7	60/72/80/100	M20
285	32	2	1.7	60/72/80/100/120	M20
315	32	2	1.7	60/72/80/100	M20



Factors	M2O - Series
Edge Material	Cermet + PVD
Work Material	Stainless Steel
RPM	40-100
Chip Load	0.03-0.05

Case Study

Factors	PL2O - Series	PM2O - Series	M2O - Series
Model	285x2x1.7x32x72-PL20	315x2x1.7x32x60-PM20	285x2x1.7x32x72-M20
Material	A-105	A-8620	SS 304
Component	Round Bar	Round Bar	Round Bar
Diameter	34	52	38
RPM	115	100	70
Chip Load	0.040	0.046	0.030
Cutting Time	10 Sec.	16 Sec.	13.5 Sec.
Tool Life(Sq/Cm)	4,78,000	6,62,100	93,984



Cold Saw Blade For Metal Cutting

Pin Hole Dimension Selection Chart Formula

Pin Hole Dimension

Diameter	Arbor (Bore ID)	Ріп Ноle
250/285/315	32	4 Hole 9.1mm PCD 50 4 Hole 11.1mm PCD 63
315/360/390	40	4 Hole 11.1mm PCD 90 4 Hole 15.1mm PCD 80
420/460	50	4 Hole 12.1mm PCD 90 4 Hole 15.1mm PCD 80

Selecting Th	e Right No of	Teeth For Sol	lid Applications
		1001110100	II Applications

	Material Diameter In MM																	
Diameter	Teeth	0	10	20	30	40	50	60	70	80	90	100	110	120	130	140	150	160
	60																	
250	72																	
230	80																	
	100																	
	60																	
	72																	
285	80																	
	100																	
	120																	
	60																	
	72																	
315	80																	
	100																	
	120																	
	60																	
360	72																	
000	80																	
	100																	
	60																	
390	72																	
	80																	
	60																	
400	72																	
420	80																	
	100																	
	60																	
460	72																	
	80																	

Formula

$fz = \frac{V_f}{z \times n}$ (mm)	$V_c = \frac{D \times \pi \times n}{1000} (m/min)$
fz = Feed per tooth (mm)	V_c = Cutting Speed (m/min)
V _f = Feed rate (chip load) (mm/min)	n = Rotation per min (RPM)
z = Number of Teeth	π = 3.141592
n = Rotation per min (RPM)	



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