

SAW BLADE

High Quality
From Japan
Since 1981

TONE

MADE IN JAPAN
285x2 0x32 60z

811064401001



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TONE SAW SHIZUOKA, JAPAN

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Best Quality Products

TONE

For Ferrous Metals

Saw Blades for Ferrous Metals

FOR HEAVY & LIGHT DUTY CUTTING / THROW AWAY TYPE



MATERIALS

Steel pipe STKM11A, 12A, 13A

SHAPES OF MATERIALS

Thin-walled pipe, Thick-walled pipe, Seamless pipe

BLADE DIMENSION

Diameler	Bore	Teeth
285	32,40	60,80 100,120
360	40,50	
460	40,50	

PVD COATING FOR STAINLESS STEEL



MATERIALS

Stainless Steel, Special Steel

SHAPES OF MATERIALS

Bar Steel, Bar Stainless Steel

BLADE DIMENSION

Diameler	Bore	Teeth
285	32,40	60,80 100,120
360	40,50	
460	40,50	

High Quality Tippled Saw Blade

Teeth	Application	Blade surface speed / min. (m/min)	Chip load (mm/tooth)	Material shape	※1 Machine category	Material													
						Carbon steel/ Alloy steel						Bearing steel	Stainless steel	Die steel	Thick Steel Pipe	Thin Steel Pipe	Stainless Pipe	Non Ferrous Metal	
						C (炭) %													
						0.1	0.2	0.3	0.4	0.5	0.6								
Cermet	steel bar	110-125	0.06-0.07		A														
Cermet	steel bar	100-125	0.05-0.07																
TCT Coated	bearing steel	100-110	0.04-0.05																
TCT Coated	stainless bar	65	0.03																
TCT Coated	die steel	60-70	0.04-0.05																
Cermet	steel pipe	100-125	0.03-0.05		B														
TCT Coated	stainless pipe	65	0.03																
TCT Coated	steel bar & pipe	200-350	0.04-0.12		C														
TCT Coated	stainless bar & pipe	80-140	0.03-0.08																
TCT Coated	steel pipe	350-400	0.04-0.12		D														
TCT Coated	stainless pipe	60-120	0.035-0.10																
TCT	non ferrous metal	2000-4000	0.005-0.01		E														
TCT	steel bar & pipe	1500-2000	Manual feed		E														

*1 MACHINE CATEGORY

A	Stationary	Low Speed	TSUNE Nishijimax Noritake AMADA KASTO Behringer Kaltenbach I.T.E.C Fong Ho SOCO MEGA Everising Kentai EXACTCUT etc..
B	Stationary	High Speed	RattundeBEWO Sinico RSA Adigi OMP etc..
C	Flying (on line)	High Speed	MTM OTO mills Elmaksan Kusakabe Linsinger SMS Meer etc..
D	Stationary	High Speed	High RPM Non Ferrous cut machine
E	Portable	High Speed	High RPM Portable DRY Metal cutting machine. Evolution, JEPSON, MK MORSE, Milwaukee, MAKITA, HITACHI etc.. They are power tool.

THE NUMBER OF TEETH FOR BAR

Dia.	Teeth	Pitch(mm)	0	10	20	30	40	50	60	70	80	90	100	110	120	130	140	150	160
250	60	13.08																	
	72	10.90																	
	80	9.81																	
	100	7.85																	
285	60	14.92																	
	72	12.43																	
	80	11.19																	
	100	8.95																	
	120	7.46																	
360	140	6.39																	
	60	18.84																	
	80	14.13																	
	100	11.30																	
460	120	9.42																	
	40	36.11																	
	60	24.07																	
	80	18.06																	
	100	14.44																	
	120	12.04																	

THE NUMBER OF TEETH FOR THE TUBE WALL THICKNESS

↓ Wall thickness (mm)

Dia.	Teeth	Pitch(mm)	Max dia.	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40							
250	72	10.90	φ50																																															
	80	9.81																																																
	100	7.85																																																
285	72	12.43	φ75																																															
	80	11.19																																																
	100	8.95																																																
	120	7.46																																																
315	140	6.39	φ90																																															
	72	13.74																																																
	80	12.36																																																
	100	9.89																																																
360	120	8.24	φ100																																															
	80	14.13																																																
	100	11.30																																																
425	120	9.42	φ120																																															
	80	16.68																																																
	100	13.34																																																
460	120	11.12	φ160																																															
	80	18.06																																																
	100	14.44																																																
	120	12.04																																																

UTS more than 800N/mm² and V more than 200m/min TCT COATED is suggested

UTS under 800N/mm² or V under 200m/min CERMET is suggested

*UTS = Ultimate Tensile Strength