

OTH TERÄPALVELU OY



Cutting tools

- Slot milling
- Cutting off
- Contour and profile milling
- Sawing

OTH-SawSystem

-Slot milling, cutting-off

Our newly developed System, allows slotting and cutting-off more precise and efficient than standard circular saws. Advantages over traditional circular saw blades:

- Defined cutting edge geometry
- High performance coating
- Longer tool life
- distance to shoulder 0,01mm
- through spindle cooling
- Easy and fast setup



Benefits of our re-sharpening service.

OTH-SawSystem blades can be re-sharpened up to 3 times.

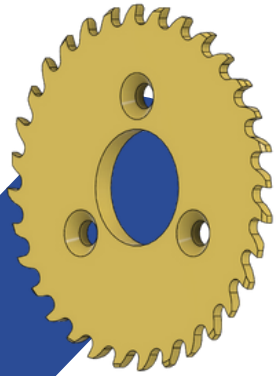
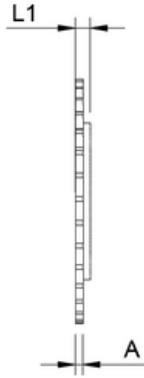
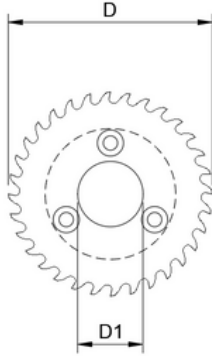
Recoating available on request

- Longer tool life
- lower costs
- Smaller Co2 footprint

OTH-SawSystem

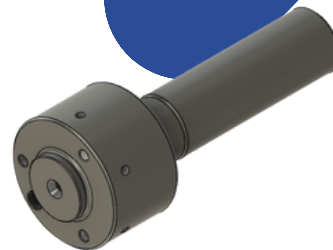
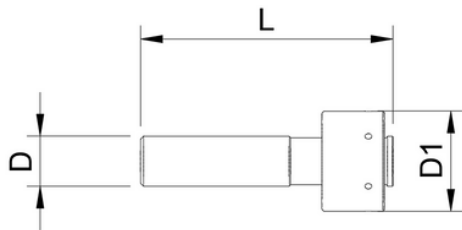
-Slot milling, cutting-off

Standard Blades



D	L1	A	Z	D1
50	3,00	0,50-2,50	22 Bw	16
50	3,00	0,50-2,50	32 Bw	16
63	3,00	0,50-2,50	22 Bw	16
63	3,00	0,50-2,50	32 Bw	16

General tolerance: A+0,00 -0,03 D+0,00 -0,30



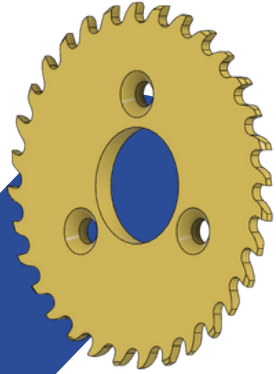
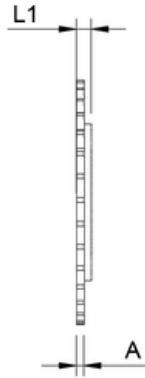
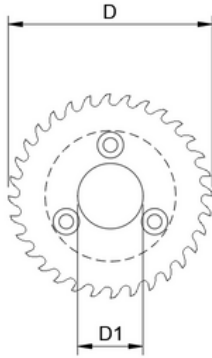
order nr.	D	D1	L
0635073	16 HB	32	80,75

Delivery includes clamping screws and pins

OTH-SawSystem

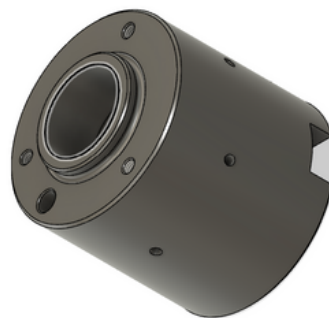
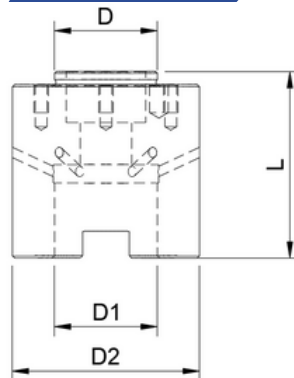
-Slot milling, cutting-off

Standard Blades



D	L1	A	Z	D1
80	3,00	1,00-2,50	22 Bw	22
80	3,00	1,00-2,50	32 Bw	22
100	3,00	1,00-2,50	20 Bw	22
100	3,00	1,00-2,50	30 Bw	22
125	3,00	1,00-2,50	20 Bw	22
125	3,00	1,00-2,50	30 Bw	22

General tolerance: A+0,00 -0,03 D+0,00 -0,30



order nr.	D	D1	D2	L
01008040	22	22	40	39,9

Delivery includes clamping screws and pins

HSS-Dm05 ColdSawblades

Toothform B: For thin blades (<1,3mm), alternative for Bw

Toothform Bw: Standard for pipe cutting

Toothform C (pitch >5mm) : Cutting solid material and thicker pipes

BR (Chipbreaker): Best alternative for cutting pipes on automatic machines.

Vario (Unequal pitch): Cutting components that cause vibration and harmonics, longer lasting blades

As material we use highest quality High speed steel Dm05 and Co5

Recommended cutting data

Material	Speed Vc=m/min	Feed/tooth Fz=mm/z
Steels up to 500 N/mm ² (C10, C15, St37, St44)	30-40	0,05-0,08
Steels up to 820 N/mm ² (C40, C60, 15Cr3, 16MnCr5, 26CrMo4)	20-35	0,03-0,05
Steels up to 1220N/mm ² (38NCD4, 14NiCr14, 40CrMnMo7)	15-25	0,02-0,06
Stainless steel	15-25	0,02-0,06
Aluminum	400-900	0,05-0,10
Titanium	12-15	0,02-0,05
Cast iron	20-30	0,03-0,05
Brass	160-400	0,04-0,06
Bronze	50-120	0,04-0,06
Copper	90-400	0,04-0,06

Customer success:

Customer in Estonia sawing EN 10139 square bar.

Standard HSS blades lasted 6000 cuts, implementing OTH blades with defined cutting edge and coating, they lasted 22 000!

Reducing downtime and costs significantly for the customer

Diameter	Strength	Bore	Toothform
200	1,20	32	B/Bw
200	1,60	32	Bw/Br
200	2,00	32	Bw/Br
200	2,50	32	Bw/Br
250	1,20	32	B/Bw
250	1,60	32	Bw/Br
250	2,00	32	Bw/Br
250	2,50	32	Bw/Br
275	1,20	32/40	B/Bw
275	1,60	32/40	Bw/Br
275	2,00	32/40	Bw/Br
275	2,50	32/40	Bw/Br
275	3,00	32/40	Bw/Br
300	1,60	32/40	Bw/Br/C
300	2,00	32/40	Bw/Br/C
300	2,50	32/40	Bw/Br/C
300	3,00	32/40	Bw/Br/C
315	2,00	32/40	Bw/Br/C
315	2,50	32/40	Bw/Br/C
315	3,00	32/40	Bw/Br/C
350	2,00	32/40	Bw/Br/C
350	2,50	32/40	Bw/Br/C
350	3,00	32/40	Bw/Br/C
370	2,00	32/40	Bw/Br/C
370	2,50	32/40	Bw/Br/C
370	3,00	32/40	Bw/Br/C
450	2,50	32/40/50	Bw/Br/C
450	3,00	32/40/50	Bw/Br/C
500	2,50	32/40/50	Bw/Br/C
500	3,00	32/40/50	Bw/Br/C

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