IDEAL

WESPA®

MONTFORT
INTERNATIONAL

Montfort International ltée
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Contents

MONTFORT INTERNATIONAL

The company.....4

WESPA

The company.....5

IPC | Individual Performance Cutting®.....6

Tooth Shapes and Applications.....7

Circular Saw Blades.....8

Products for Solid Materials

CERTEC®.....9

TCT-TEC®.....12

HSS-TEC®.....14

Products for Pipes | Tubes

CERTEC®.....17

TCT-TEC®.....18

HSS-TEC®.....21

FLY-TEC®.....27

ORB-TEC®.....28

DIN-TEC®.....30

DRY-TEC®.....31

Technology

Cutting Parameter Solid Material.....15

Blade Choice Solid Material.....16

Cutting Parameter Pipes | Tubes.....22

Blade Choice Pipes | Tubes.....23

Formulars.....24

Saw Machine Specifications.....25

Flying Cutting Parameter.....30

Safety Notice.....31

Support.....32



MONTFORT INTERNATIONAL LTD

Since our founding in 1989 and the transformation of our very first bandsaw blade, we have become a key partner for each of our clients in their sawing and cutting operations.

Specialized business partners on a global scale, our experienced team continuously strives to improve the quality and performance of our products.

This continuous improvement of our products and services ensures optimal cuts, significant cost savings, and, consequently, competitive advantages.

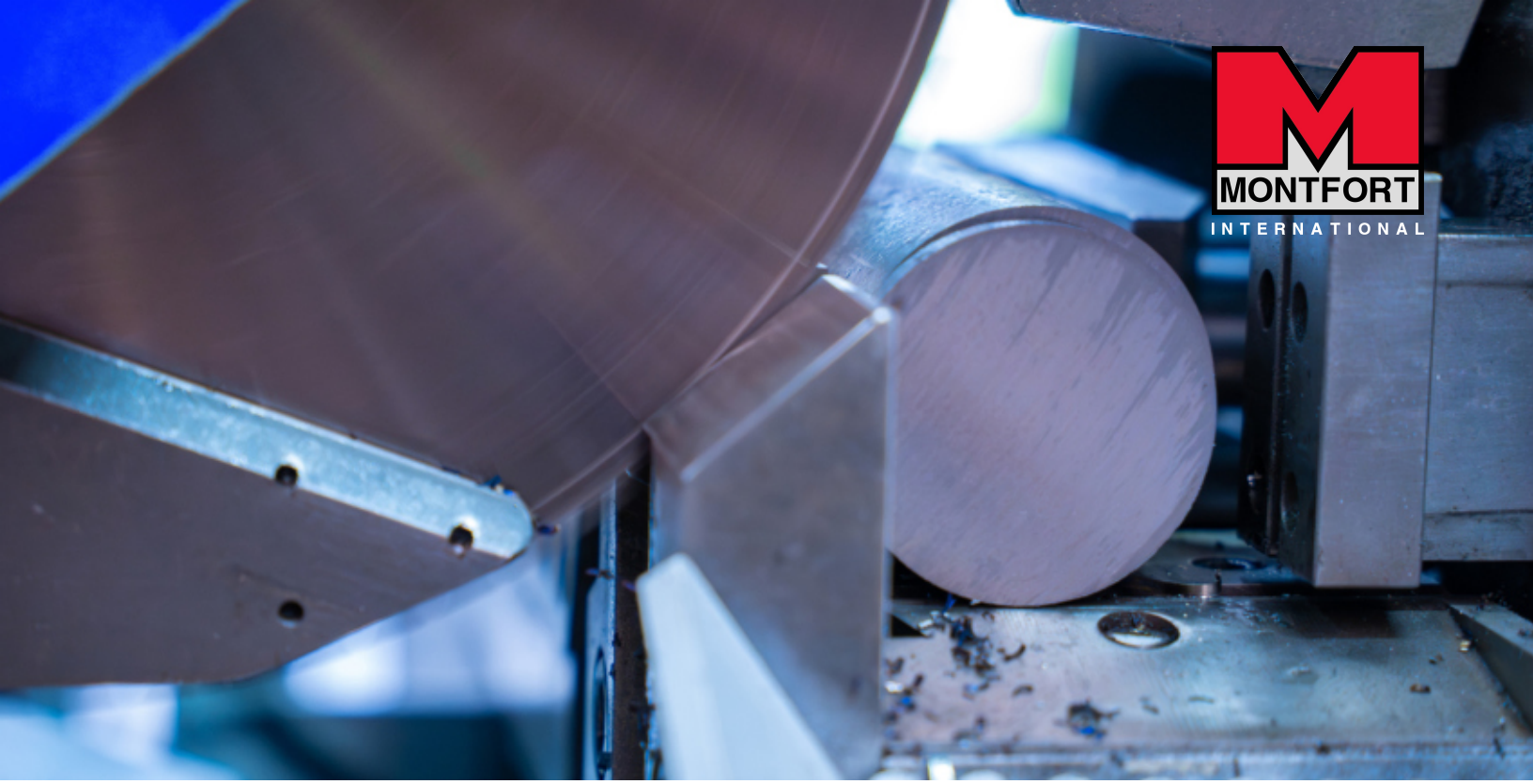
Montfort International is flexible; we provide tailor-made solutions to meet your specific sawing demands and applications.

Renowned national and international clients from all sectors of manufacturing and processing trust Montfort.

We place great importance on customer satisfaction and proudly guarantee rapid availability and comprehensive service, which you will undoubtedly benefit from:

- We deliver any in-stock product within 24/48 hours
- Professionals who come directly to your factory and places of business to optimize your sawing machine settings, perform cutting tests, and train your operators
- Bandsaw blades entirely transformed and welded to the highest quality standards in our Quebec City workshop

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MONTFORT
INTERNATIONAL

Your Technology Partner For All Metal-Cutting Needs

Since our foundation in 1950 in Spangenberg, and the production of the first band saw tools for metal cutting, we have become a pivotal technology partner for every sawing requirement. Our experienced team have continuously improved the quality and performance of our products through innovation and precision.

The ongoing enhancement of our product and service offerings ensures optimal metal cutting, starting at the very first cut. This results in significant cost savings and critical competitive advantages for our customers.

WESPA remains adaptable to customer needs across a wide range of industries, delivering tailored solutions to meet their unique applications.

Our tools are designed to handle a wide range of materials, thanks to carefully engineered edge geometries and surface treatments.

Renowned national and international partners in sectors such as automotive, aerospace, and mechanical engineering place their trust in WESPA's sawing tools.

With a global sales network and specialized trading partners in over 100 countries, and our own companies in NorthAmerica, Asia and Canada we proudly guarantee fast availability and comprehensive service that you will surely benefit from!



MADE IN WESPA GERMANY

TÜV PROFI CERT ISO 9001
73 100 4655
www.proficert.com



IPC | Individual® Performance Cutting.

IPC – Individual Performance Cutting ®

At your request, we fine-tune circular saw blades to perfection with thorough analysis, tailoring them precisely to your specific applications. IPC circular saw blades excel in delivering extended tool life and meeting the most demanding cutting requirements, all while achieving exceptional results without the need for machine capacity expansion.

Perfecting Your Sawing Process

In today‘s cutting industry, users increasingly seek personalized sawing performance and production-focused service. Experience the superiority of our IPC circular saw blades, a testament to the excellence of your sawing processes, proudly brought to you by WESPA.

Detailed Analysis of Requirements

WESPA technical service staff analyzes the customer requirements and present operating conditions of the circular saw enviroment in order to offer an IPC product that is specially designed for the given sawing application.

C	Coating	**Hard Coating** for increased tool life and cutting performance

Improvement and Optimization

Cutting time	Machining performance
Vibrations	Straightness of the cut
Surface finish	Cost
Noise level	Blade life

The machining process thus achieves a very high level of efficiency. This is made possible by over 75 years of experience of WESPA in the development of customized sawing solutions and services for well-known customers and a wide range of industries.

Benefits of IPC for your production

- Higher feed rates and shorter cutting times
- Longer blade life
- Higher productivity and lower production costs
- Cost-effective substitute for standard cermet saw blades
- Shorter delivery times due to shorter cutting times
- Higher manufacturing production quality
- Increased production reliability
- Greater adaptability in work scheduling
- Protection of environment and resources

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Tooth Shapes and Applications

Product Features



Special Carbide Shape



Hook Tooth
positive rake angle



Triple Chip Geometry
ground



Chipbreaker

Areas of Application



Solid Material
large



Solid Material
small



Tubes and Profiles
thick-walled



Tubes and Profiles
thin-walled



Surface hardened

Product Advantages



Universally Applicable



Precision



Surface Finish



Wear Resistance



Performance



Cost Reduction



Vibration and Noise Reduction



Coolant
Water + Oil

Materialgroup

MATERIALGROUP **1**

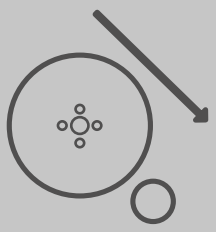
Non ferrous metals
Aluminum
Structural steel
Cast iron
Alloy steel
Tempered steel
Carbon steel
Work tool steel
High-speed steel

MATERIALGROUP **2**

Stainless steel
Hardened steels
Heat resistant steel
Steel and non-ferrous alloys
Titanium and Titanium alloys

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Circular Saw Blades

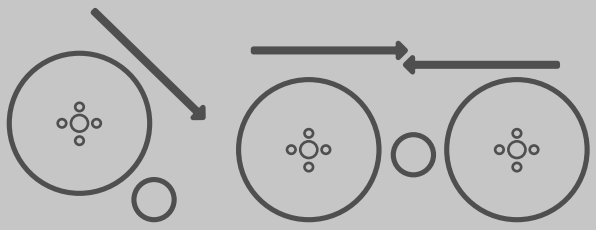


CERTEC ®

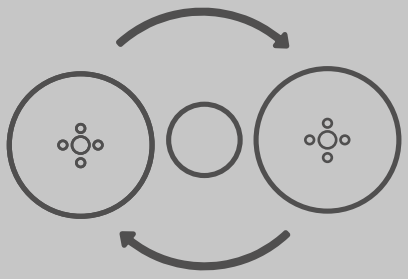
TCT-TEC ®

HSS-TEC ®

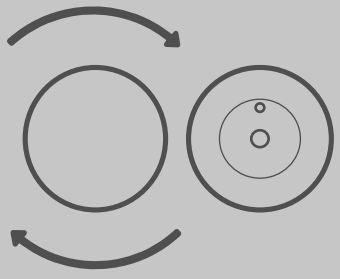
DRY-TEC ®



FLY-TEC ®



ORB-TEC ®

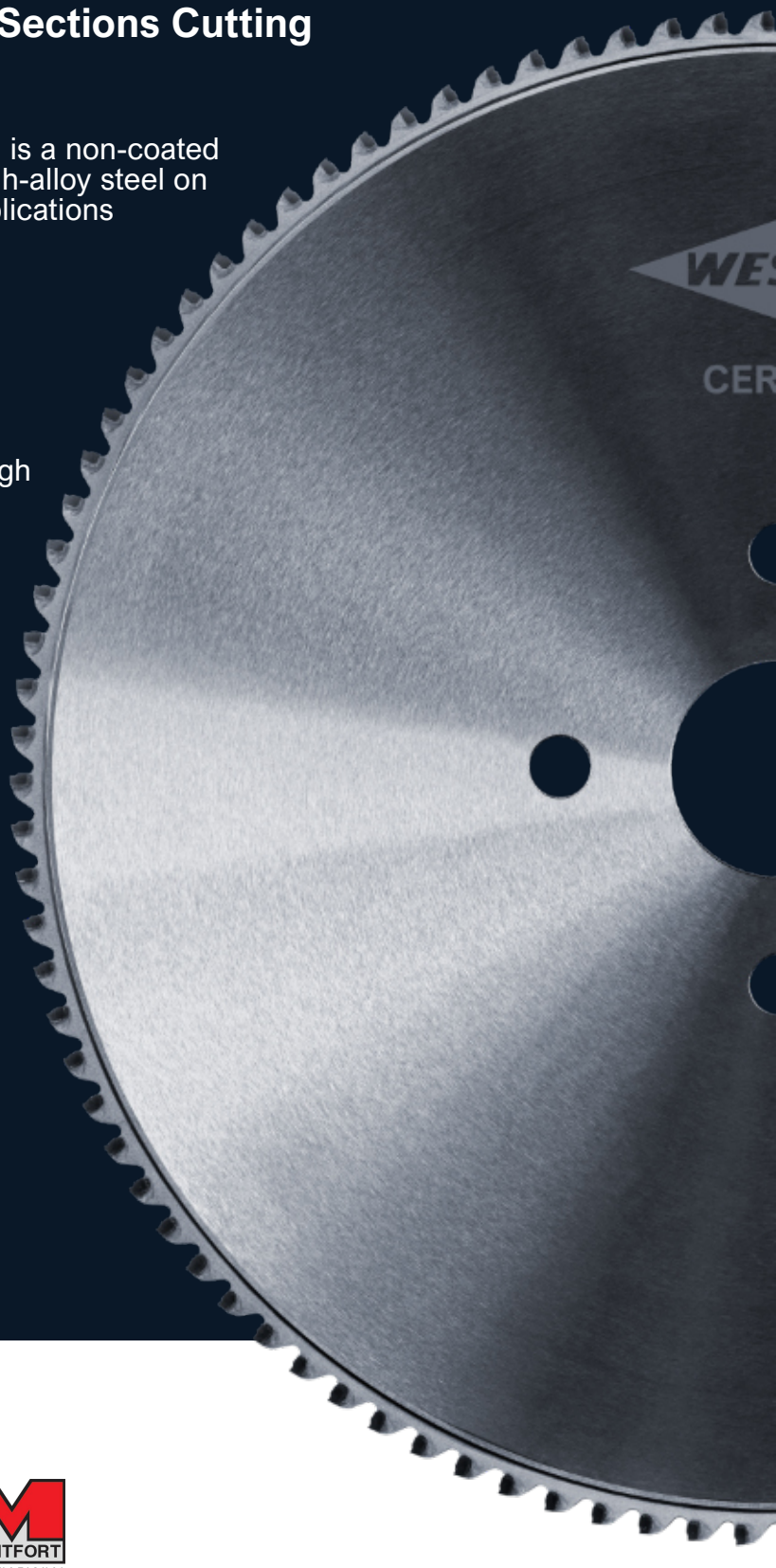


DIN-TEC ®

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Cermet Circular Saws For Solid Sections Cutting

The circular blade with CERMET tipped teeth is a non-coated blade suitable for cutting solid sections in high-alloy steel on static machines. It is the best solution for applications aiming for maximum productivity.



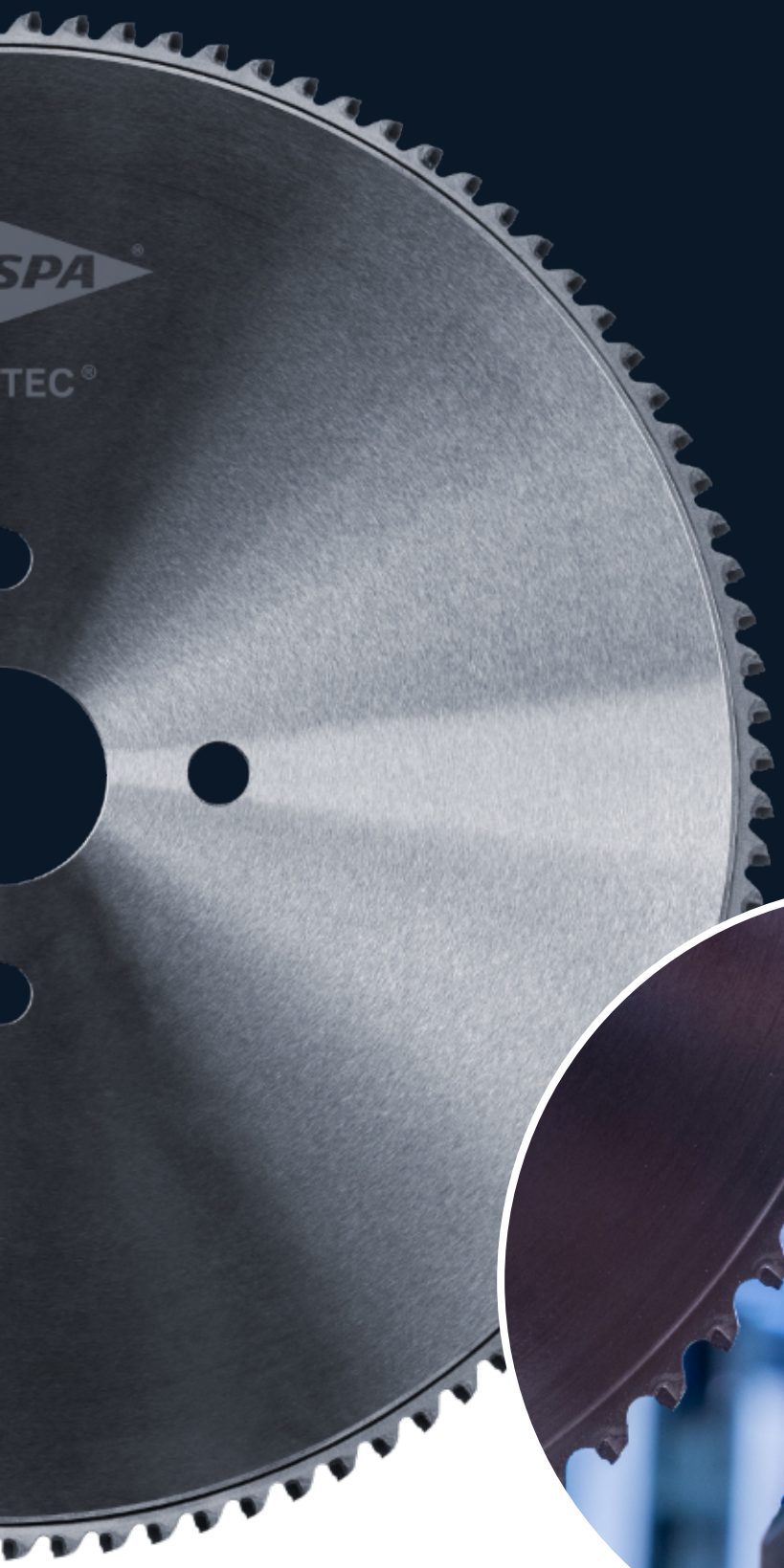
GEOMETRY

Angles and clearances designed to achieve the best finishing performance and ensure high productivity in terms of workpieces. The side relief angle reduces the effort and heat generation during cutting, making this type of blade particularly suitable for cutting high-carbon steels.

TEETH IN CERMET

The solid cermet used on our blades is a composite material made up of a special mixture of sinterized components able to resist at high vibrations to ensure the maximum performance of the blade.

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BODY

The bodies of the blade are made from special steels sourced from steel mills, which are hardened and tempered. Cutting edge construction methods allow the blade to achieve maximum levels of durability and cutting performance.

RUN OUT AND FLATNESS

A WESPA blade body ensures very low deformation tolerances, thus providing high quality in terms of cutting finish and tool performance. A body that is not perfectly straight can cause vibration problems and premature blade wear.



CERTEC ®



Cermet-tipped blade with optimized tooth geometry for efficient serial production of solid bars. Ensures long tool life, precise cutting quality and reduced heat and noise emission.

CERTEC for Solid Material

Diameter	Thickness		Bore	Teeth						
[mm]	[mm]		[mm]	40	50	54	60	72	80	100
250	2,00	1,7	32				■	■	■	
285	2,00	1,7	32			■	■	■	■	
285	2,00	1,75	40			■	■	■	■	
315	2,30	2,00	32/40				■	■	■	
330	2,30	2,0	32/40				■	■	■	
360	2,60	2,25	32/40/50				■	■	■	■
425	2,70	2,25	50		■		■		■	
460	2,70	2,25	40/50	■	■		■		■	■
480	2,70	2,25	40						■	
560	3,00	2,5	40/50			■	■		■	
580	3,00	2,5	80				■		■	■
630	3,40	2,7	80		■		■			
660	3,80	3,2	50/80				■		■	■
750	3,80	3,2	50				■		■	■
840	4,00	3,2	80				■		■	■
900	4,00	3,6	80				■		■	■

High-performance circular saw blade with thin-kerf technology, designed for efficient serial production of solid bars. The optimized tooth geometry with reduced relief angle decreases cutting resistance and minimizes heat generation as well as noise emission.

This ensures stable operation with high dimensional accuracy and consistent cutting quality. The excellent wear and adhesion resistance of the cutting edges provides extended tool life and stable performance – even at high feed rates in continuous industrial use.

The cermet used on our blades is a composite material made up of a special mixture of ceramic oxides, where the ceramic matrix in the cermet structure gives properties such as wear resistance, idel to ensure the maximum performance of the blade.

Cermet SM

Product Features

Areas of Application

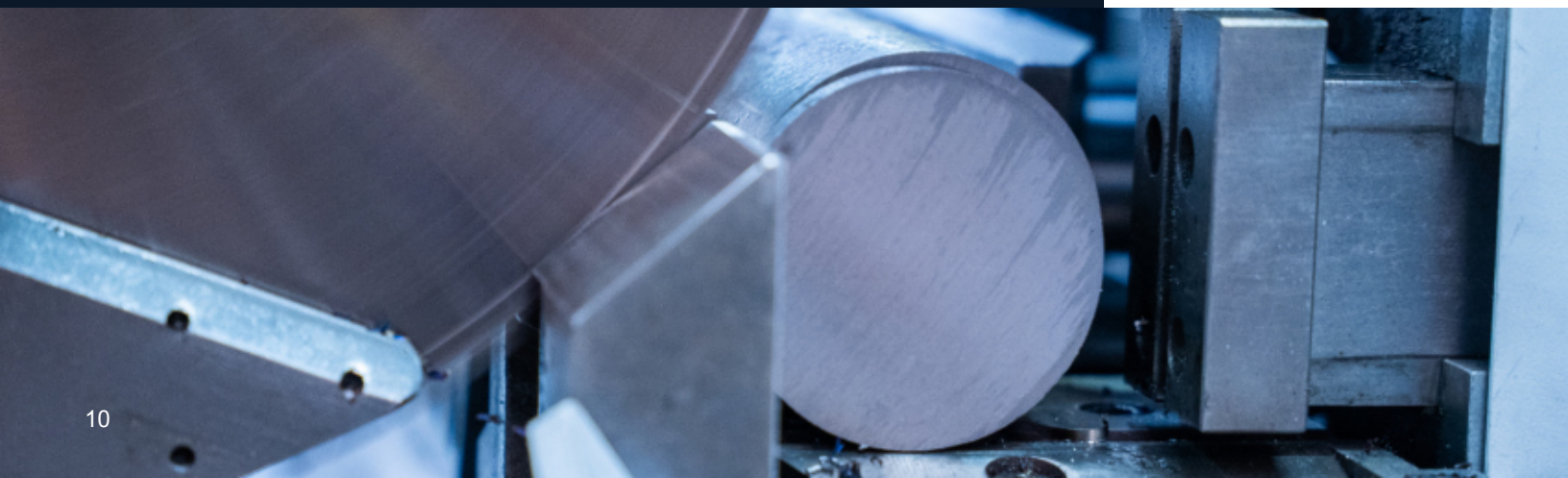
MATERIALGROUP 1

Product Advantages

All products available with IPC C

IPC Individual® Performance Cutting.

Hard Coating
for increased tool life
and cutting performance



TCT-TEC ®



Carbide-tipped blade with Hard Coating for increased tool life and cutting performance. Heat- and abrasion resistant tooth geometry for efficient serial production of solid bars. Ensures long tool life, precise cutting quality, and reduced heat and noise emission.

TCT-TEC for Solid Material

Diameter	Thickness		Bore	Teeth						
[mm]	[mm]		[mm]	40	50	54	60	72	80	100
250	2,00	1,7	32				■	■	■	
285	2,00	1,7	32			■	■	■	■	
285	2,00	1,75	40			■	■	■	■	
315	2,30	2,00	32/40				■	■	■	
330	2,30	2,0	32/40				■	■	■	
350	2,60	2,25	32/40/50				■		■	■
360	2,60	2,25	32/40/50				■	■	■	■
380	2,60	2,25	40				■		■	■
425	2,70	2,25	50		■		■		■	■
460	2,70	2,25	40/50	■	■		■		■	■
480	2,70	2,25	40		■		■		■	■
560	3,00	2,5	40/50			■	■		■	■
580	3,00	2,5	80				■		■	■
630	3,40	2,7	80		■		■			
660	3,80	3,2	50/80				■		■	■
750	3,80	3,2	50				■		■	■
840	4,00	3,2	80				■		■	■
900	4,20	3,6	80				■		■	■

High-performance circular saw blade with thin-kerf technology, designed for efficient serial production of solid bars. The optimized tooth geometry with reduced relief angle decreases cutting resistance and minimizes heat generation as well as noise emission.

This ensures stable operation with high dimensional accuracy and consistent cutting quality. The excellent wear and adhesion resistance of the cutting edges provides extended tool life and stable performance – even at high feed rates in continuous industrial use.



Carbide SM

Product Features

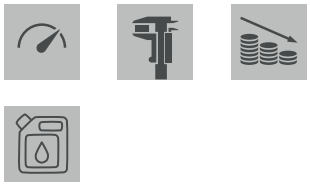


Areas of Application



MATERIALGROUP **2**

Product Advantages



All products with IPC C

IPC Individual® Performance Cutting.



Hard Coating
for increased tool life
and cutting performance



TCT-TEC ®

Carbide-tipped blade with special silicium based hard coating for increased tool life and cutting performance on austenitic stainless steel. Abrasion resistant tooth geometry for efficient serial production of stainless steel solid bars. Ensures long tool life on special material, precise cutting quality and reduced noise emission.

TCT-TEC for Solid Material

Diameter	Thickness		Bore	Teeth						
[mm]	[mm]		[mm]	40	50	54	60	72	80	100
250	2,00	1,7	32				■	■	■	
285	2,00	1,7	32			■	■	■	■	
285	2,00	1,75	40			■	■	■	■	
315	2,30	2,00	32/40				■	■	■	
330	2,30	2,0	32/40				■	■	■	
350	2,60	2,25	32/40/50				■		■	■
360	2,60	2,25	32/40/50				■	■	■	■
380	2,60	2,25	40				■		■	■
425	2,70	2,25	50		■		■		■	■
460	2,70	2,25	40/50	■	■		■		■	■
480	2,70	2,25	40		■		■		■	■
560	3,00	2,5	40/50			■	■		■	■
580	3,00	2,5	80				■		■	■
630	3,40	2,7	80		■		■			
660	3,80	3,2	50/80				■		■	■
750	3,80	3,2	50				■		■	■
840	4,00	3,2	80				■		■	■
900	4,20	3,6	80				■		■	■

High-performance circular saw blade with thin-kerf technology, designed for efficient serial production of solid bars. The optimized tooth geometry with reduced relief angle decreases cutting resistance and minimizes heat generation as well as noise emission.

This ensures stable operation with high dimensional accuracy and consistent cutting quality. The excellent wear and adhesion resistance of the cutting edges provides extended tool life and stable performance – even at high feed rates in continuous industrial use.



Specially designed for

STAINLESS STEEL

Carbide ES

Product Features

Areas of Application

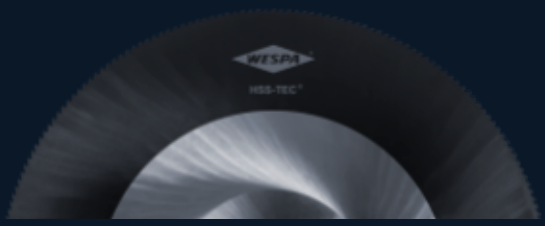
MATERIALGROUP **2**

Product Advantages

All products with IPC C

IPC Individual® Performance Cutting.

Hard Coating
for increased tool life
and cutting performance



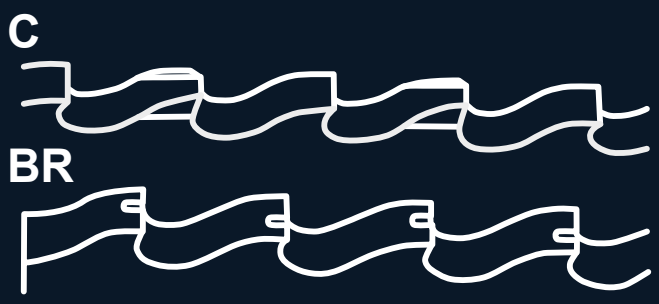
HSS-TEC ®

HSS circular saw blade for metal cutting

HSS-TEC for Solid Material							
Diameter	Thickness		Bore	Teeth			
[mm]	[mm]		[mm]	90	130	140	150
250	1,20	1,2	32			Br	
285	1,20	1,2	32		Br		
315	1,60	1,6	32/40			Br	
350	2,00	2,0	32/40/50	C			C
360	2,00	2,0	32/40/50	Br			Br

These high speed steel circular saw blades are specially made to be used on solid material. The use is mainly on static automatic static cutting machines and sometimes on flying cutting ones to cut small thicknesses. The blades are always with our IPC C coating in this case important to reduce the friction on the cutting edges but also to increase the hardness of the blade from 900 to 3400 HV.

The higher temperatures that the coating grant, allows to use oil mist instead of coolant. The blades are made with M35 or M2 material to allow performances respectably on stainless or carbon steel. The blades need to be used always on single head cutting machines. The blades can be resharpened many many times.



HSS SM

Product Features

Areas of Application

MATERIALGROUP 1

MATERIALGROUP 2

Product Advantages

All products with IPC C

IPC Individual® Performance Cutting.

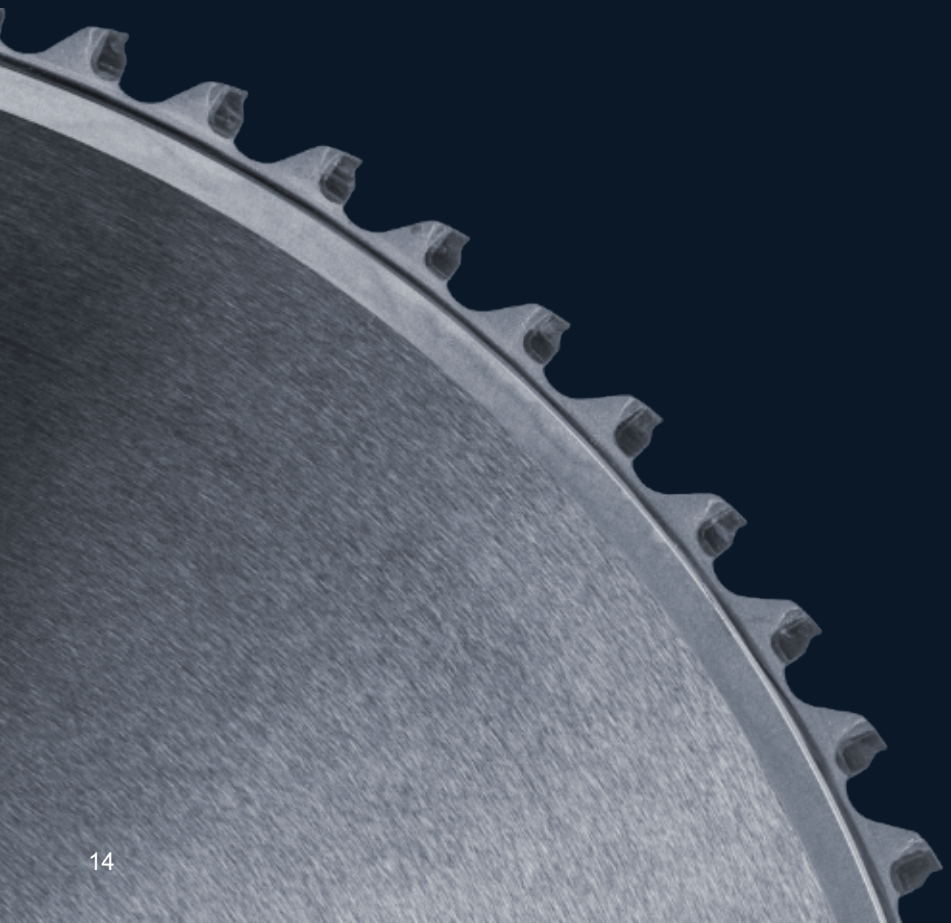
Hard Coating
for increased tool life
and cutting performance



Cutting Parameter Solid Material

Cutting Parameter for Solid Material

		CERTEC | TCT-TEC		CERTEC [SM]		CERTEC [SM] IPC C		TCT-TEC [SM] IPC C		TCT-TEC [ES] IPC C		HSS-TEC [SM] IPC C			
Material	Tensile Strength [N/mm²]	Feed per Teeth [mm/Z]		Cutting Speed [m/1']		Cutting Speed [m/1']		Cutting Speed [m/1']		Cutting Speed [m/1']		Feed per Tooth [mm/Z]		Cutting Speed [m/1']	
Mild Steel	< 400	0,05	0,10	60	150	90	190	90	300	60	150	0,03	0,07	30	150
Carbon Steel	400 - 650	0,05	0,09	60	130	90	170	90	280	60	140	0,025	0,06	30	120
Alloyed Steel	650 - 1000	0,05	0,09	60	100	90	130	90	260	60	100	0,025	0,05	30	90
High Tensile Strength Steel	> 1000	0,04	0,09			60	120	60	140	60	140				
Aluminium | Light Alloys	< 1%	0,03	0,05					110	450			0,03	0,06	100	280
Austenitic Stainless Steel	500 - 800	0,03	0,06					60	140	60	140	0,02	0,04	25	50
Ferritic Stainless Steel	400 - 700	0,03	0,07					100	250	70	150	0,02	0,06	30	120



Circular Saw Blade Choice For Solid Material

Blade Choice

Diameter [mm]	Thickness [mm]		Bore [mm]	Z	Cutting Dimensions min.	Cutting Dimensions max.	HSS-TEC IPC C	CERTEC	CERTEC IPC C	TCT-TEC IPC C
250	2,00	1,7	32	60	25	50		■	■	■
				72	23	45		■	■	■
				80	20	40		■	■	■
	1,20	1,2	32	140	8	23	■			
285	2,00	1,7	32	54	38	75		■	■	■
				60	35	70		■	■	■
				72	30	60		■	■	■
				80	23	45		■	■	■
	1,2	1,2	32	130	10	28	■			
285	2,00	1,75	40	54	38	75		■	■	■
				60	35	70		■	■	■
				72	30	60		■	■	■
				80	23	45		■	■	■
315	2,30	2,00	32/40	60	45	80		■	■	■
				72	40	70		■	■	■
				80	30	60		■	■	■
	1,60	1,6	32/40	140	10	29	■			
330	2,30	2,0	32/40	60	50	90		■	■	■
				72	45	80		■	■	■
				80	35	70		■	■	■
350	2,60	2,25	32/40/50	60	50	95				■
				80	40	70				■
				100	23	45				■
	2,00	2,0	32/40/50	90	32	80	■			
				150	20	48	■			
360	2,60	2,25	32/40/50	60	50	100		■	■	■
				72	45	80		■	■	■
				80	40	70		■	■	■
				100	23	45		■	■	■
	2,00	2,0	32/40/50	90	33	82	■			
				150	20	49	■			
380	2,60	2,25	40	60	60	120				■
				80	45	90				■
				100	30	60				■
425	2,70	2,25	50	50	60	130		■	■	■
				60	55	110		■	■	■
				80	40	80		■	■	■
				100	33	65				■
460	2,70	2,25	40/50	40	88	176		■	■	■
				50	70	140		■	■	■
				60	60	120		■	■	■
				80	45	90		■	■	■
				100	35	70		■	■	■
480	2,70	2,25	40	50	80	160				■
				60	65	135				■
				80	50	100		■	■	■
				100	40	80				■
560	3,00	2,5	40/50	54	93	185		■	■	■
				60	83	165		■	■	■
				80	63	125		■	■	■
				100	50	100				■
580	3,00	2,5	80	60	95	190		■	■	■
				80	70	140		■	■	■
				100	58	115		■	■	■
630	3,40	2,7	80	50	120	240		■		■
				60	100	200		■		■
660	3,80	3,2	50/80	60	105	210		■		■
				80	80	160		■		■
				100	65	130		■		■
750	3,80	3,2	50	60	125	250		■		■
				80	90	180		■		■
				100	75	150		■		■
840	4,00	3,2	80	60	140	280		■		■
				80	105	210		■		■
				100	85	170		■		■
900	4,20	3,6	80	60	155	310		■		■
				80	115	230		■		■
				100	90	180		■		■



CERTEC ®

Cermet-tipped blade with optimized tooth geometry for efficient serial production of pipes. Ensures long tool life, precise cutting quality and reduced heat and noise emission.

CERTEC for Pipes | Tubes							
Diameter	Thickness		Bore	Teeth			
[mm]	[mm]		[mm]	100	120	132	140
250	2,00	1,7	32	■			
285	2,00	1,7	32	■	■		
315	2,30	2,00	32/40	■	■		■
330	2,30	2,0	32/40	■	■		
360	2,60	2,25	32/40/50		■		
425	2,70	2,25	50				■
460	2,70	2,25	40/50	■		■	

High-performance circular saw blade with thin-kerf technology, designed for efficient serial production of pipes.The optimized tooth geometry with reduced relief angle decreases cutting resistance and minimizes heat generation as well as noise emission.

This ensures stable operation with high dimensional accuracy and consistent cutting quality. The excellent wear and adhesion resistance of the cutting edges provides extended tool life and stable performance – even at high feed rates in continuous industrial use.

The cermet used on our blades is a composite material made up of a special mixture of ceramic oxides, where the ceramic matrix in the cermet structure gives properties such as wear resistance, idel to ensure the maximum performance of the blade.

IDEAL

Cermet PT

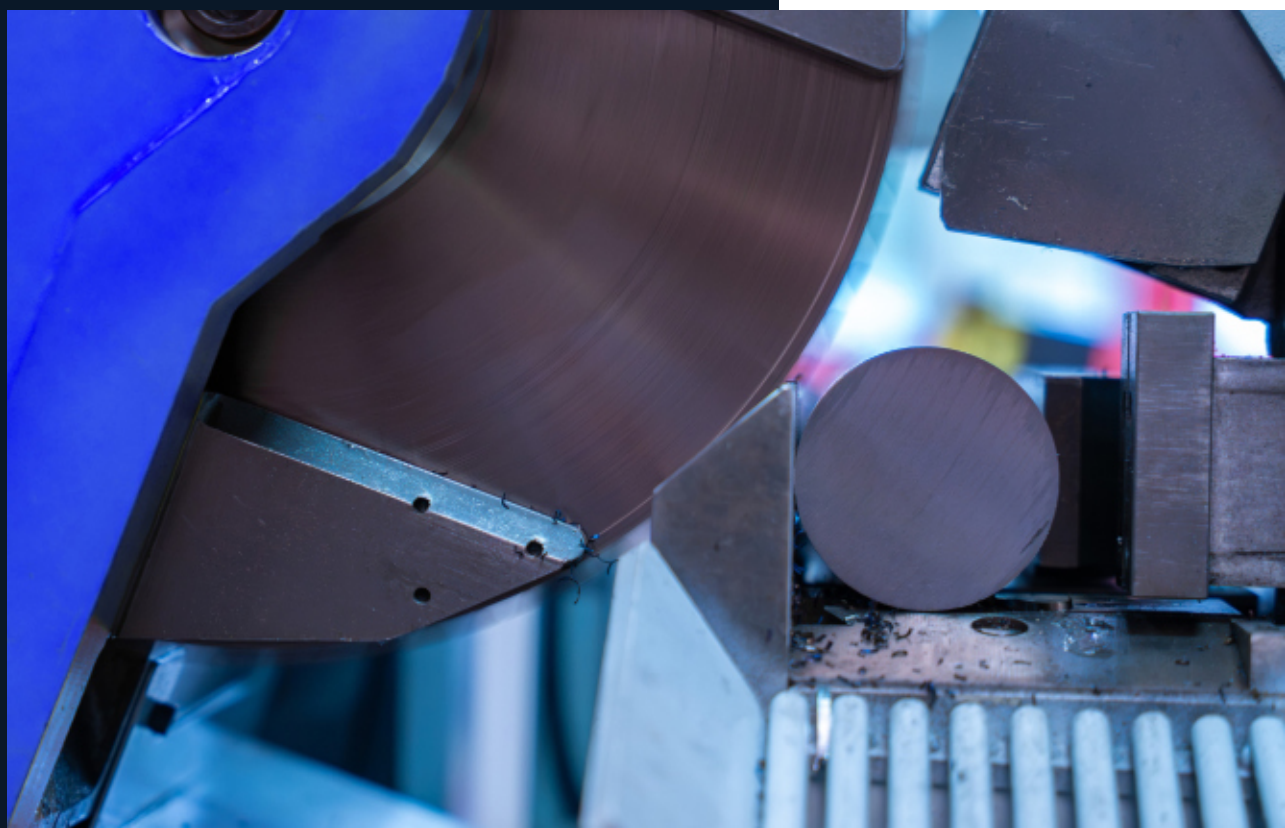
Product Features

Areas of Application

MATERIALGROUP 1

Product Advantages

MONTFORT INTERNATIONAL



WESPA®



TCT-TEC ®

Carbide-tipped blade with Hard Coating for increased tool life and cutting performance.
Heat- and abrasion resistant tooth geometry for efficient serial production of pipes.
Ensures long tool life, precise cutting quality, and reduced heat and noise emission.

TCT-TEC for Pipes | Tubes

Diameter	Thickness		Bore	Teeth					
[mm]	[mm]		[mm]	60	80	100	120	140	160
250	2,00	1,7	32	■	■	■			
285	2,00	1,7	32		■	■	■	■	
315	2,30	2,00	32/40		■	■	■	■	
330	2,30	2,0	32/40			■	■		
360	2,60	2,25	32/40/50		■	■	■	■	
420	2,70	2,25	50		■	■	■	■	
425	2,70	2,25	50		■	■	■	■	
450	2,70	2,25	50			■	■	■	■
460	2,70	2,25	40/50			■	■	■	■
480	2,70	2,25	40			■	■	■	■
500	3,00	2,5	40/50				■	■	■
560	3,00	2,5	40/50				■	■	■
580	3,00	2,5	80				■	■	■

High-performance circular saw blade with thin-kerf technology, designed for efficient serial production of pipes. The optimized tooth geometry with reduced relief angle decreases cutting resistance and minimizes heat generation as well as noise emission.

This ensures stable operation with high dimensional accuracy and consistent cutting quality. The excellent wear and adhesion resistance of the cutting edges provides extended tool life and stable performance – even at high feed rates in continuous industrial use.

IDEAL

Carbide PT

Product Features

Areas of Application

MATERIALGROUP 1

MATERIALGROUP 2

Product Advantages

All products with IPC C

IPC Individual® Performance Cutting.

Hard Coating
for increased tool life
and cutting performance

MONTFORT INTERNATIONAL



TCT Circular Saws For Solid and Pipe Cutting

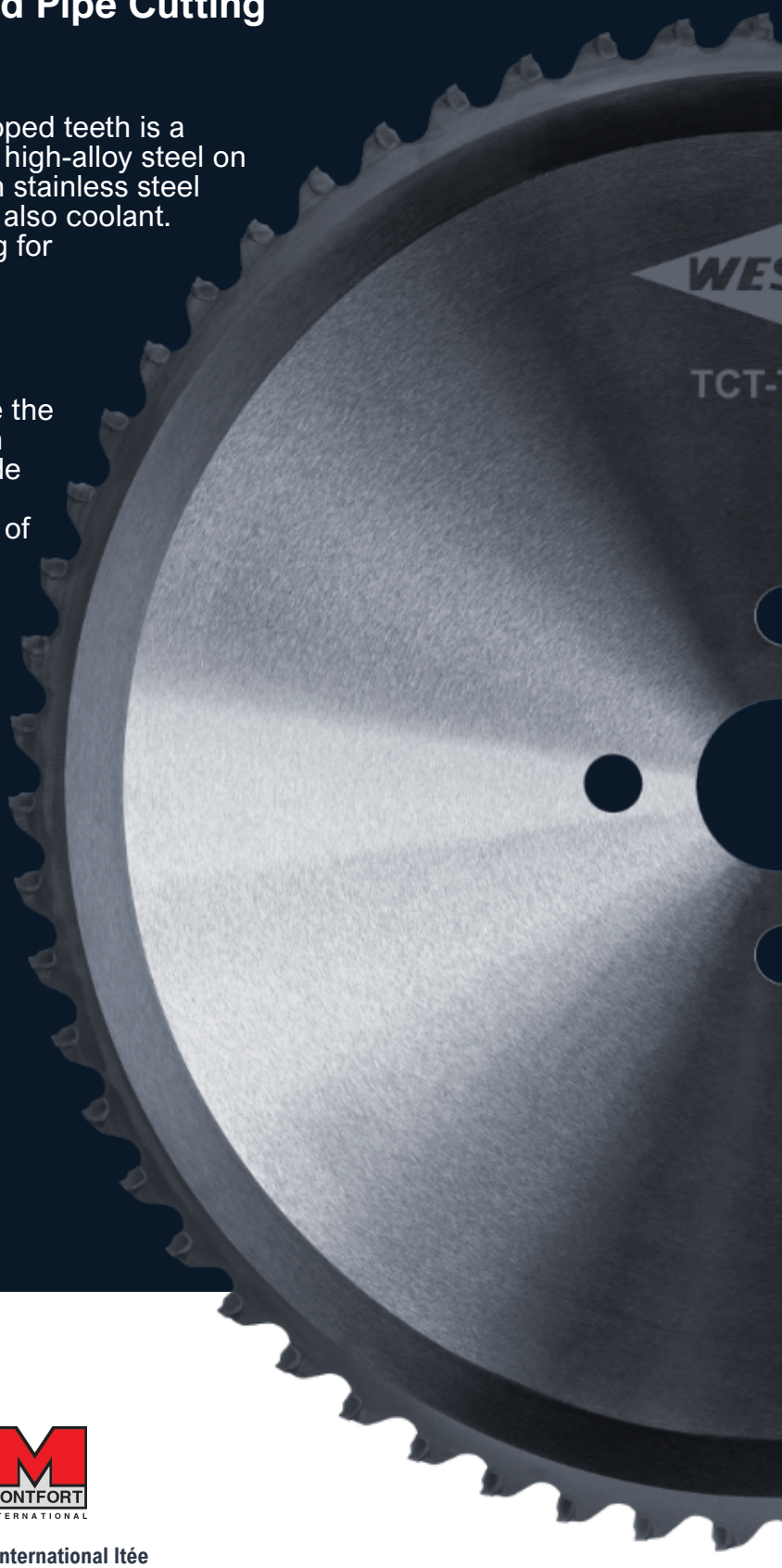
The circular blade with coated CARBIDE tipped teeth is a blade suitable for cutting solid and pipes in high-alloy steel on static machines. These blades can cut even stainless steel and can be used not only with spray oil but also coolant. It is the best solution for applications aiming for maximum productivity.

GEOMETRY

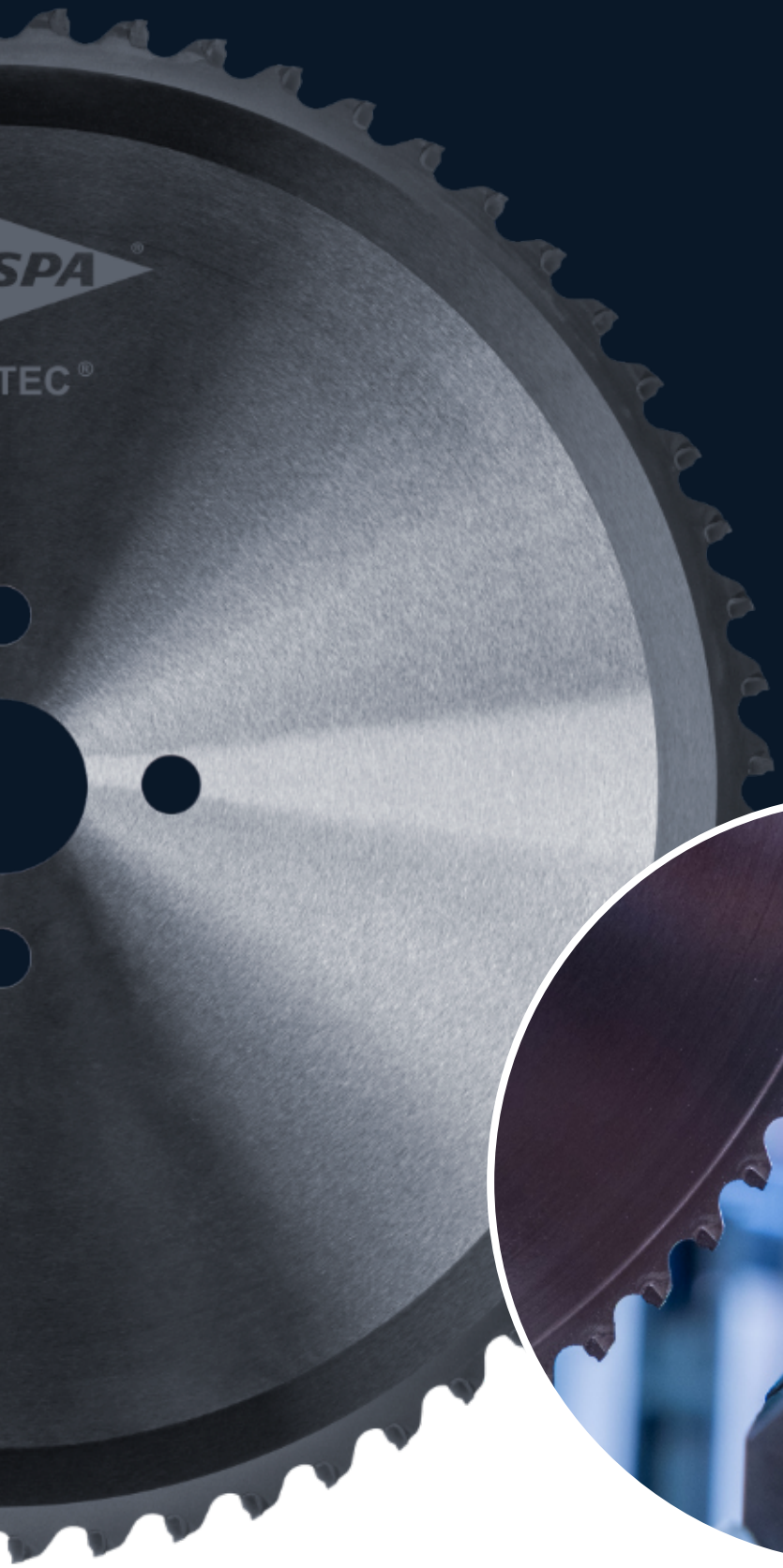
Angles and clearances designed to achieve the best finishing performance and ensure high productivity in terms of workpieces. The side relief angle reduces the effort and heat generation during cutting, making this type of blade particularly suitable for cutting high-carbon steels.

TEETH IN CARBIDE

The solid carbide used on our blades is a composite material made up of a special mixture of sinterized components able to resist at high vibrations to ensure the maximum performance of the blade.



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BODY

The bodies of the blade are made from special steels sourced from steel mills, which are hardened and tempered. Cutting edge construction methods allow the blade to achieve maximum levels of durability and cutting performance.

RUN OUT AND FLATNESS

A WESPA blade body ensures very low deformation tolerances, thus providing high quality in terms of cutting finish and tool performance. A body that is not perfectly straight can cause vibration problems and premature blade wear.





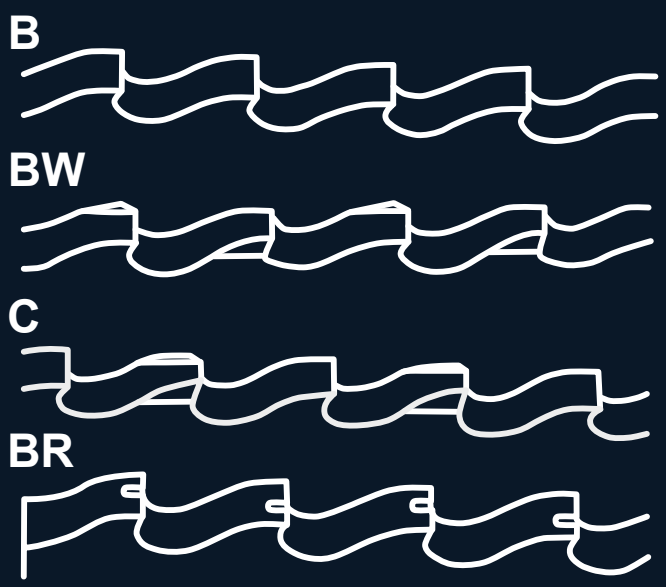
HSS-TEC ®

HSS circular saw blade for metal cutting

HSS-TEC for Pipes | Tubes									
Diameter	Thickness		Bore	Teeth					
[mm]	[mm]		[mm]	130	140	150	180	200	220
250	1,20	1,2	32		Br				B
285	1,20	1,2	32	Br			Br		
315	1,60	1,6	32/40		Br			Br	
350	2,00	2,0	32/40/50			C			Br
360	2,00	2,0	32/40/50			Br			Br

These high speed steel circular saw blades are specially made to be used on solid material. The use is mainly on static automatic static cutting machines and sometimes on flying cutting ones to cut small thicknesses. The blades are always with our IPC C coating in this case important to reduce the friction on the cutting edges but also to increase the hardness of the blade from 900 to 3400 HV.

The higher temperatures that the coating grant, allows to use oil mist instead of coolant. The blades are made with M35 or M2 material to allow performances respectably on stainless or carbon steel. The blades need to be used always on single head cutting machines. The blades can be resharpened many many times.



HSS PT

Product Features

Areas of Application

MATERIALGROUP 1

MATERIALGROUP 2

Product Advantages

All products with IPC C

IPC Individual® Performance Cutting.

Hard Coating
for increased tool life
and cutting performance

Cutting Parameter Pipes | Tubes

Cutting Parameter for Pipes | Tubes

		CERTEC | TCT-TEC		CERTEC		TCT-TEC IPC C		HSS-TEC IPC C			
Material	Tensile Strength [N/mm²]	Feed per Tooth [mm/Z]		Cutting Speed [m/1']		Cutting Speed [m/1']		Feed per Tooth [mm/Z]		Cutting Speed [m/1']	
Mild Steel	< 400	0,04	0,12	60	150	90	300	0,03	0,12	60	240
Carbon Steel	400 - 650	0,04	0,12	60	130	90	280	0,025	0,1	60	240
Alloyed Steel	650 - 1000	0,04	0,12	60	100	90	260	0,025	0,1	30	120
High Tensile Strength Steel	> 1000	0,04	0,12			60	140				
Aluminium | Light Alloys	< 1%	0,03	0,09			110	450	0,03	0,12	100	280
Austenitic Stainless Steel	500 - 800	0,03	0,09			60	140	0,02	0,08	25	50
Ferritic Stainless Steel	400 - 700	0,03	0,09			100	250	0,025	0,1	30	120

Circular Saw Blade Choice For Pipes | Tubes

Blade Choice

Diameter	Thickness		Bore	Z	Pipe Dimensions Range		TCT-TEC IPC C	CERTEC	HSS-TEC IPC C
[mm]	[mm]	[mm]	[mm]		max. D	Wallthickness			
250	2,00	1,7	32	60	60	5 - 10	■		
	2,00	1,7	32	80	60	4 - 7,5	■		
	2,00	1,7	32	100	60	3 - 6	■	■	
	1,20	1,2	32	140	60	1,6 - 3,5			■
	1,20	1,2	32	200	60	< 1,6			■
285	2,00	1,7	32/40	80	80	4 - 7,5	■		
	2,00	1,7	32/40	100	80	3 - 6	■	■	
	2,00	1,7	32/40	120	80	2,5 - 5	■	■	
	2,00	1,7	32/40	140	80	2 - 10	■		
	1,20	1,2	32/40	130	80	4 - 10			■
	1,20	1,2	32/40	180	80	< 3,9			■
315	2,30	2,0	32/40	80	90	4 - 7,5	■		
	2,30	2,0	32/40	100	90	3 - 6	■	■	
	2,30	2,0	32/40	120	90	2,5 - 5	■	■	
	2,30	2,0	32/40	140	90	2 - 4	■	■	
	1,60	1,6	32/40	140	90	4 - 10			■
	1,60	1,6	32/40	200	90	< 3,9			■
330	2,30	2,0	32/40	100	90	3 - 6	■	■	
	2,30	2,0	32/40	120	90	2,5 - 5	■	■	
350	2,60	2,25	32/40/50	80	95	4 - 8	■		
	2,60	2,25	32/40/50	100	95	3 - 6,5	■		
	2,60	2,25	32/40/50	120	95	2,5 - 5,5	■		
	2,60	2,25	32/40/50	140	95	2,2 - 4,5	■		
	2,00	2,0	32/40/50	150	95	4 - 10			■
	2,00	2,0	32/40/50	220	95	< 3,9			■
360	2,60	2,25	40/50	80	100	4,5 - 9	■		
	2,60	2,25	40/50	100	100	3,5 - 7	■		
	2,60	2,25	40/50	120	100	3 - 6	■	■	
	2,60	2,25	40/50	140	100	2 - 4,5	■		
	2,00	2,0	32/40/50	150	100	4 - 10			■
	2,00	2,0	32/40/50	220	100	< 3,9			■
380	2,60	2,25	40	100	120	4 - 8	■		
	2,60	2,25	40	120	120	3,5 - 7	■		
	2,60	2,25	40	140	120	3 - 5,5	■		
425	2,70	2,25	50	100	130	4,5 - 9	■		
	2,70	2,25	50	120	130	4 - 7,5	■		
	2,70	2,25	50	140	130	3 - 6	■	■	
450	2,70	2,25	50	100	145	5 - 9,5	■		
	2,70	2,25	50	120	145	4 - 8	■		
	2,70	2,25	50	140	145	3,5 - 7	■		
	2,70	2,25	50	160	145	2,5 - 6	■		
460	2,70	2,25	40/50	100	150	5 - 9,5	■	■	
	2,70	2,25	40/50	120	150	4 - 8	■		
	2,70	2,25	40/50	132	150	3,5 - 7,5		■	
	2,70	2,25	40/50	140	150	3,5 - 7	■		
	2,70	2,25	40/50	160	150	3 - 6	■		
480	2,70	2,25	40/50	100	160	5 - 9,5	■		
	2,70	2,25	40/50	120	160	4 - 8	■		
	2,70	2,25	40/50	140	160	3,5 - 7	■		
	2,70	2,25	40/50	160	160	3 - 6	■		
500	3,00	2,5	50	120	170	4,5 - 9	■		
	3,00	2,5	50	140	170	4 - 8	■		
	3,00	2,5	50	160	170	3 - 6	■		
560	3,00	2,5	40/50	120	180	5 - 9,5	■		
	3,00	2,5	40/50	140	180	4 - 8,5	■		
	3,00	2,5	40/50	160	180	3,5 - 7,5	■		
580	3,00	2,5	50/80	120	190	5 - 10	■		
	3,00	2,5	50/80	140	190	4,5 - 8,5	■		
	3,00	2,5	50/80	160	190	4 - 7,5	■		

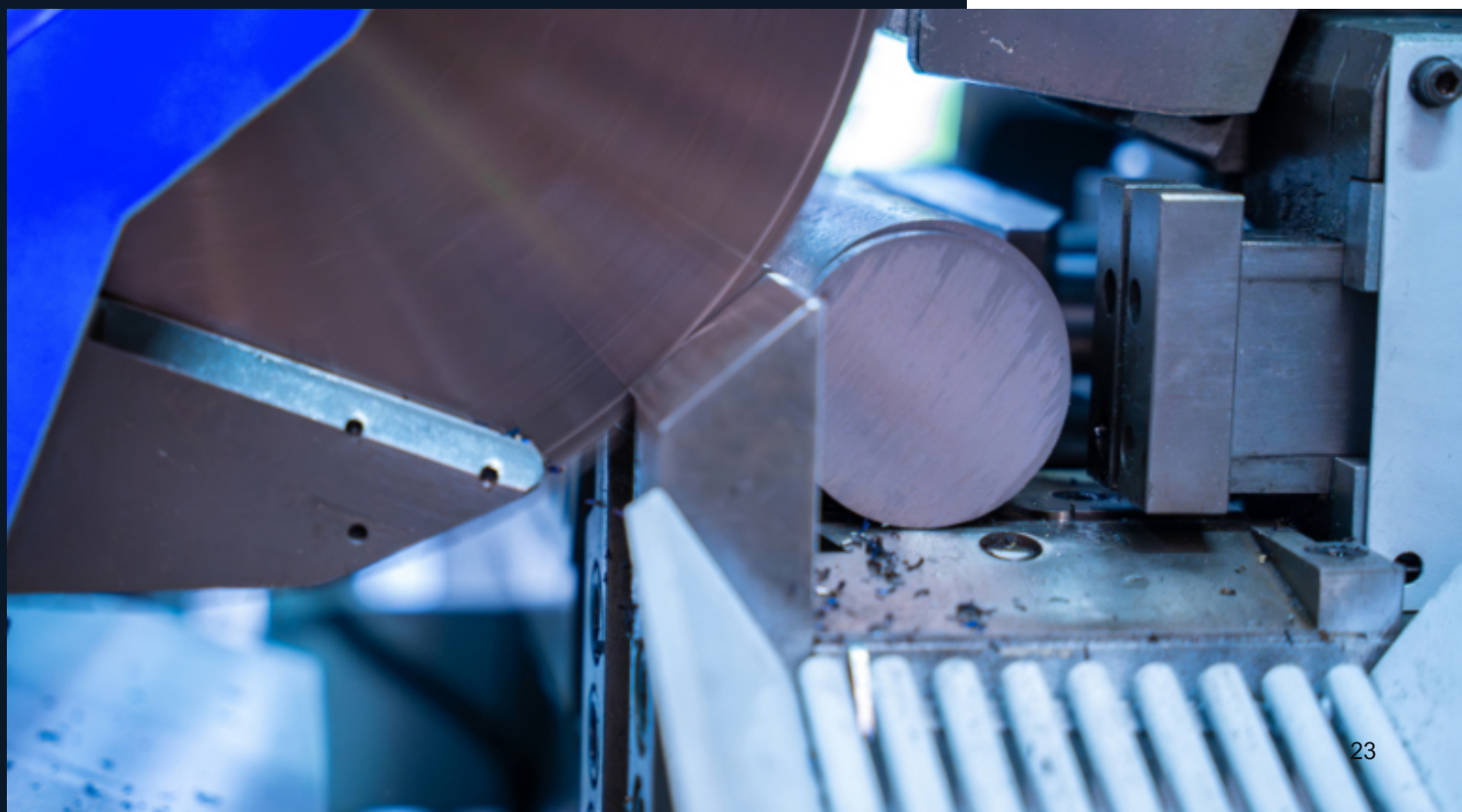
Formulars

RPM = (V*1000)/(D*3,14)			
Blade Diameter	D=		[mm]
Blade Speed	V=		[m/min]
	RPM=		[rpm]

To determine the number of revolutions per minute (RPM) to be set on the machine, use the formular, where (V)= Cutting speed and (D)= Saw diameter.

A = RPM x Az x Z			
Blade Speed	RPM =		[rpm]
Blade Feed per Tooth	Az =		[mm/Z]
Blade Teeth	Z =		[Z]
Blade Feed	A =		[mm/min]

In addition to the cutting speed, the table also provides recommended values for feed per tooth (Az), which can be used to determine the total feed rate to be set on the machine.



Saw Machine Specification

Machine	Model	Diameter	Thickness		Central bore	Driving holes
		[mm]	[mm]		[mm]	
AIGE	CM 502	285	2,00	1,75	40	4/11/63
	CM 601/602	315	2,50	2,25	32	4/11/63
	CM 601/602	360	2,60	2,27	32/40	4/11/63
AMADA	CM 65AN	285	2,00	1,75	40	2/12/80
	CM 75AN	285	2,00	1,75	40	2/12/80
	CM100AN	360	2,60	2,27	40	4/12/90
	CM150AN	460	2,70	2,27	40	4/12/90
ANDERSON	NCB-70	285	2,00	1,70	32	4/11/63
	NCB-100	360	2,60	2,27	40	4/11/90
BEHRINGER EISELE	HCS 70	250	2,00	1,75	40	2/15/80
		285	2,00	1,75	40	2/15/80
		315	2,30	2,00	40	2/15/80
	HCS 90	285	2,00	1,75	40	2/15/80
		315	2,30	2,00	40	2/15/80
		360	2,60	2,27	40	2/15/80
	HCS 130	315	2,30	2,00	40	2/15/80
		360	2,60	2,27	40	2/15/80
		420	2,60	2,27	40	2/15/80
	HCS 150	360	2,60	2,27	40	2/15/80
		420	2,60	2,27	40	2/15/80
		460	2,70	2,25	40	2/15/80
	HCS 160	360	2,60	2,27	40	2/15/80
		420	2,60	2,27	40	2/15/80
		480	2,70	2,25	40	2/15/80
BEKAMAK	75 XS	285	2,00	1,70	32	4/11/63
	100 XS	360	2,60	2,27	40	2/16/80
	130 XS	425	2,60	2,27	40	2/16/80
	150 XS	460	2,70	2,27	40	2/16/80
BEWO	ECH108	250	2,00	1,75	40	4/12/64
CHING HSYANG	CH 70-4A	285	2,00	1,70	32	4/12/63
	NC-100-4A	360	2,60	2,27	40	4/11/90
	NC-150-4A	460	2,70	2,27	50	4/14/90
CONNI/RALC	GEMINI 802	315	2,20	1,90	32	4/11/63
DAITO/DELTA	P-65A	285	2,00	1,75	40	4/12/80
	P-100A	360	2,60	2,27	40	4/12/90
ENDO	HS-36-SS-36	360	2,60	2,27	50	4/16/80
EVERISING	P-65A	250	2,00	1,70	32	4/11/63
	P-70B	285	2,00	1,70	32	4/11/63
	P-100B	360	2,60	2,25	40	4/12/90
	P-150B	460	2,70	2,25	50	4/12/90
	P-230B	750	3,80	3,20	50	4/12/90
EXACTCUT	MAC 60	250	2,00	1,70	32	4/9/50
	MAC 75-TWIN	285	2,00	1,70	32	4/9/50
	MAC 105	360	2,60	2,27	40/50	4/16/80 - 4/21/90
	MAC 155	425	2,60	2,27	40/50	4/16/80 - 4/21/90
	MAC 155	460	2,70	2,27	40/50	4/16/80 - 4/21/90
FICEP	S30	285	2,30	2,00	32	4/11/63
	S30	315	2,30	2,00	32	4/11/63
	S35	360	2,60	2,27	50	4/16/80
	S50	460	2,70	2,27	50	4/18/100
	S50	500	2,70	2,27	50	4/18/100
	S56/S56P	460	2,70	2,27	50	4/18/100
	S56/S56P	560	3,40	2,80	50	4/18/100
FONG HO	THC-70NC	285	2,00	1,70	32	4/11/63
	THC-B90NC	315	2,30	2,00	32	4/11/63
	TAC-130NC	360	2,60	2,27	50	4/15/80
	TAC-130NC	425	2,70	2,27	50	4/15/80
	TCT-165NC	460	2,70	2,27	50	4/21/90
GERNETTI	SIC 350 K	350	2,60	2,27	40	4/15/80
	SIC 350 K	360	2,60	2,27	40	4/15/80
	SIC 500 K	460	2,70	2,27	50	4/18/100
	SIC 500 K	500	3,40	2,80	50	4/18/100
I.T.E.C.	DC-65	285	2,00	1,70	32	4/9/50 + 4/12/80
	DC-85	360	2,60	2,25	40	4/11/63
KALTENBACH	KMR 100AP	360	2,60	2,27	50	4/16/80
	MSK 471	425	2,70	2,27	50	4/16/80
		460	2,70	2,27	50	4/16/80
KASTO	WA C7	250	2,00	1,70	32	4/9/50
		285	2,00	1,70	32	4/9/50
	SPEED C9	250	2,00	1,70	32	4/9/50
		285	2,00	1,70	32	4/9/50
		315	2,50	2,25	32	4/9/50
	GRIPSPEED C10	360	2,60	2,25	40	4/11/90
	SPEED C14/C15	360	2,60	2,25	50	4/16/80
		425	2,70	2,25	50	4/16/80
		460	2,70	2,25	50	4/16/80
	VARIOSPEED C14/C15	360	2,60	2,25	50	4/16/80
		425	2,70	2,25	50	4/16/80

Saw Machine Specification

Machine	Model	Diameter	Thickness		Central bore	Driving holes
		[mm]	[mm]		[mm]	
KENTAI	KTC-65	285	2,00	1,70	32	4/11/63
	KTC-70EH	285	2,00	1,70	32	4/11/63
	KTC-70EH	315	2,20	1,90	32	4/11/63
	KTC-100EH	360	2,60	2,27	40	4/11/90
	KTC-130SP	360	2,60	2,27	50	4/11/90
	KTC-130SP	425	2,70	2,27	50	4/11/90
	KTC-150SP	460	2,70	2,27	50	4/11/90
MEGA	CS 65	280	2,00	1,75	32	4/12/63
	CS 75S	285	2,00	1,70	32	4/12/63
	CS 100S	360	2,60	2,27	40	4/11/90
	CS 150S	460	2,70	2,27	50	4/11/90
MEP	VELOCEX 65	250	2,00	1,70	32	4/9/50 + 4/11/63
	VELOCEX 80	285	2,00	1,70	32	4/9/50 + 4/11/63
	VELOCEX 100	360	2,60	2,27	40	4/15/80 + 4/12/90
	VELOCEX 125	420	2,70	2,27	50	4/15/80 + 4/12/90
	VELOCEX 150	460	2,70	2,27	50	4/15/80 + 4/12/90
	VELOCEX 175	560	3,00	2,50	50	4/12/80 + 4/11/90
MISSLER	CS 4	360	2,60	2,27	40	4/11/90
NISHIJIMA	NHC-050 ND	250	2,00	1,70	32	4/11/63
	NHC-070 NC (ND)	285	2,00	1,70	32	4/11/63
	NHC-100 NC (ND)	360	2,60	2,27	50	4/16/80
	NHC-120 NB /ND)	380	2,60	2,27	50	4/16/80
	NHC-150 NB	460	2,70	2,27	50	4/21/90
	NHC-180 NB	560	3,00	2,50	50	4/21/120
	NHC-230NB	750	3,80	3,20	80	4/21/180
NORITAKE	NCS-2/50	240	2,00	1,75	32	2/11/63
	NCS-2A/70	285	2,00	1,75	40	2/11/80
	NCS-2A/100	360	2,50	2,25	40	2/11/80
	NCS-2A/100	360	2,60	2,25	40	2/11/80
	NCS-2/150	460	2,70	2,25	50	4/11/90
OMP	MD 70	285	2,00	1,75	40	4/12/90
	MD 100	360	2,60	2,27	40	4/12/90
	MD 150	460	2,70	2,27	50	4/12/90
PLANTOOL	QCS 15/210	250	2,00	1,75	40	4/12/64
	QCS 15/210	315	2,30	2,00	40	4/12/64
RATTUNDE	ACS90/2	350	2,60	2,30	50	4/15/80
ROHBITECH	KTC-65CNC	250	2,00	1,70	32	4/11/63
	KTC-65CNC	285	2,00	1,70	32	4/11/63
	KTC-85CNC	315	2,30	2,00	32	4/11/63
RSA	SC/SK	285	2,00	1,70	40	4/12/64
	CC90	285	2,00	1,70	40	4/12/64
	SH90	285	2,00	1,70	40	4/12/64
	S100	360	2,60	2,27	40	4/12/64
	CC150	460	2,70	2,27	50	4/15/80
	SH150	460	2,70	2,27	50	4/15/80
	XXL	460	2,70	2,27	50	4/15/80
SAMURAI	SR-70	285	2,00	1,70	32	4/11/63
	SR-100	360	2,60	2,27	40	4/11/90
SHYH HONG (SHOMA)	KD-70	285	2,00	1,70	32	4/11/63
	KD-100	360	2,60	2,27	40	4/11/90
SIMEC	SIMAX 100	360	2,60	2,27	50	4/16/80
	SIMAX 150	460	2,70	2,27	50	4/21/90
SINICO	TOP 1100	350	2,30	2,00	32	4/11/63
	TOP 2000	350/370	2,30	2,00	50	4/15/80
	TOP 2000	350	2,60	2,30	50	4/15/80
	TOP 2000	425	2,60	2,30	50	4/15/80
SOCO	SA-77NC	285	2,00	1,70	32	4/11/63
	SA-78NC	285	2,00	1,70	32	4/11/63
	SA-115NC	360	2,60	2,27	40	4/11/90
TRENNJAEGER	SPA 75	280	2,00	1,75	32	4/11/63
	SPA 100	360	2,60	2,25	40	4/11/90
	SPA 150	460	2,70	2,25	50	4/11/90
TSUNE	TK5C-50GL	250	2,00	1,70	32	4/11/63
	TK5C-72GL	285	2,00	1,70	32	4/11/63
	TK-100GL	360	2,60	2,27	50	4/16/80
	TK5C-102GL	360	2,60	2,27	50	4/16/80
	TK-130GL	420	2,60	2,27	50	4/16/80
	TK5C-160GL	580	3,20	2,70	80	4/22/120

WESPA®



FLY-TEC ®

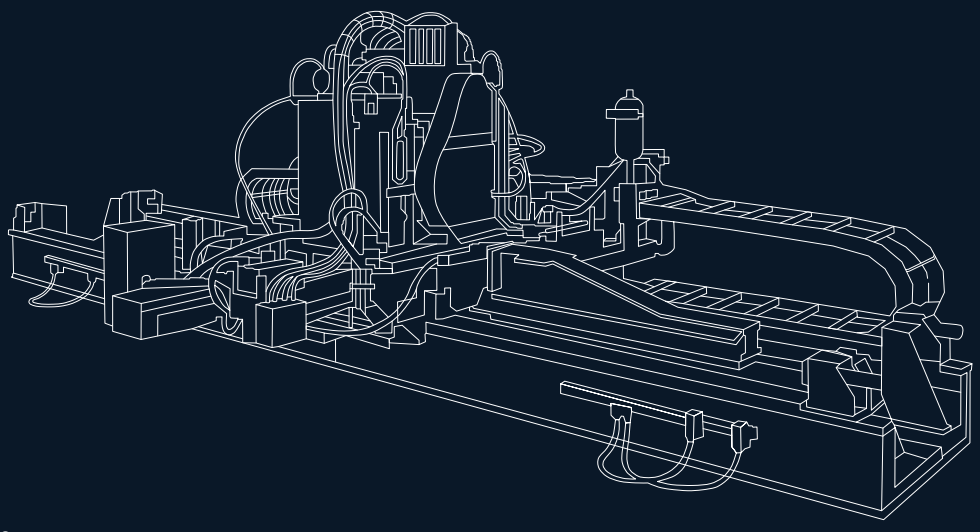
TCT FLYING cutting circular saw blade for metal cutting

FLY-TEC								
Diameter	Thickness		Bore	Teeth				
[mm]	[mm]		[mm]	100	120	140	160	180
315	2,3	2	32/40	■	■	■		
350	2,7	2,5	40/50	■	■	■		
400	2,9	2,5	40/50/80	■	■	■		
425	2,9	2,5	50		■	■	■	
450	2,9	2,5	50/80		■	■	■	
500	3,5	3	50/80			■	■	■
550	3,8	3,3	50/80/90/140		■	■	■	■
560	3,8	3,3	50/80/90/140		■	■	■	■
600	3,6	3,2	80/90/140		■	■	■	■
630	3,6	3,2	50/80		■	■	■	■
650	3,6	3,2	50/80		■	■	■	■
690	3,6	3,2	50/80			■	■	■

These carbide tipped circular saw blades are specially made to be used on fly cutting machines present in the pipe production mills. The blades are always equipped with our IPC C coating in this case important also for the higher temperatures that pipes have during their production and also for the low friction coefficient that support smooth cutting in extremely short time.

The tungsten carbide tips have a special grade that is less fragile but also much stronger to allow a smooth penetration in high tensile steel with important thickness.
The blades are designed for a single blade machine but also for a twin head system.

The right answer to the higher customer's expectations in tube cutting. Application: higher tensile strength values, thicker tube thickness, faster production line speed. Very low cutting efforts, higher cutting quality and longer blade life. Every single blade is inspected and marked with a batch number to guarantee cutting performance consistency.



IDEAL

Carbide PT

Product Features

Areas of Application

MATERIALGROUP 1

MATERIALGROUP 2

Product Advantages

All products with IPC C

IPC Individual® Performance Cutting.

Hard Coating
for increased tool life
and cutting performance

MONTFORT INTERNATIONAL

WESPA®



ORB-TEC ®

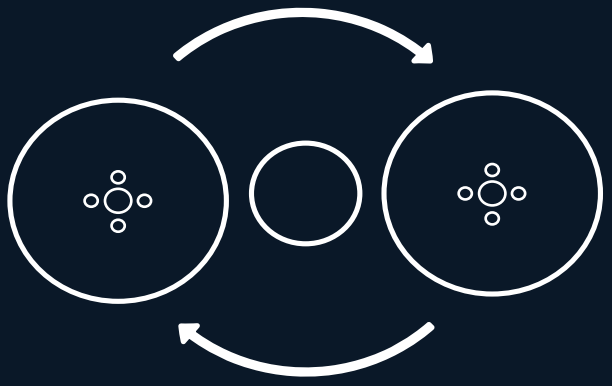
TCT ORBITAL cutting circular saw blade for metal cutting

ORB-TEC										
Diameter	Thickness		Bore	Teeth						
[mm]	[mm]		[mm]	44	52	60	70	80	90	100
250	3,50	2,70	45			■	■	■		
300	3,50	2,70	50	■	■	■	■	■		
315	3,50	2,70	50	■	■	■	■	■	■	
350	3,50	2,90	50		■	■	■	■	■	■
355	2,90	2,25	45			■	■	■	■	■
380	3,80	3,00	115		■	■	■	■	■	■
400	3,80	3,00	115		■	■	■	■	■	■

These carbide tipped circular saw blades are specially made to be used on fly cutting machines present in the pipe production mills. The blades are always equipped with our IPC C coating in this case important also for the higher temperatures that pipes have during their production and also for the low friction coefficient that support the smooth cutting in extremely short time.

The tungsten carbide tips have a special grade that is less fragile but also much stronger to allow a smooth penetration in high tensile steel with important thickness.
The blades are designed for orbital cutting machines with normally 2-3 or 4 heads rotating around the pipe. The blades are extremely robust and are resharpenable.

Circular saw blades suitable for orbital cutting machines with 2-3 or 4 blades. New PVD coated resharpenable blade. Target: to reduce the effort during cutting and to reach a longer tool life. Different toothing geometries special developed to obtain the highest cutting performance. Every single blade is inspected and marked with a batch number to guarantee cutting performance consistency.



IDEAL

Carbide PT

Product Features



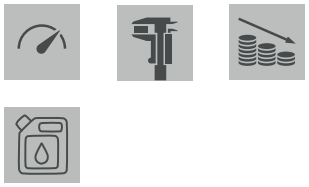
Areas of Application



MATERIALGROUP 1

MATERIALGROUP 2

Product Advantages



All products with IPC C

IPC Individual® Performance Cutting.



Hard Coating
for increased tool life
and cutting performance

DIN-TEC ®



HSS circular saw blade for orbital metal cutting

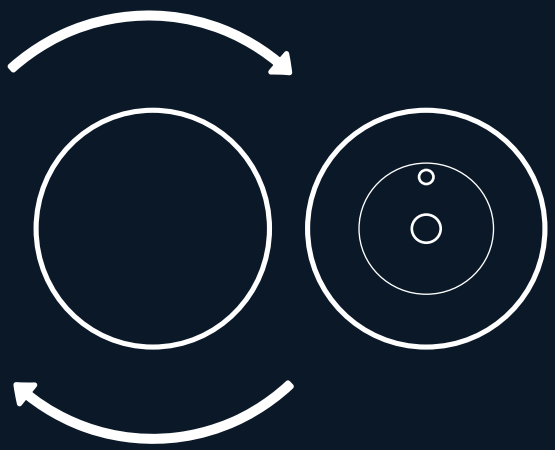
DIN-TEC														
Diameter	Thickness	Bore	Hub	Pin Hole	Teeth									
[mm]	[mm]	[mm]	[mm]	[mm]	32	34	44	54	64	72	76	80	84	100
63	1,20	16	36	01/03/38						■				■
	1,60		43				■		■			■		
68	1,60	16	43	01/03/38			■		■	■			■	
	2,00			01/03/38		■	■			■				
			42						■			■		
75	1,60	16	42				■				■			
	2,00				■		■		■					
80	1,60	16	42	01/03/38			■							
			44					■	■			■		
	2,00		42	01/03/38			■							
			44			■		■				■		

These high speed steel circular saw blades are specially made to be used on pipes and to cut them with portable orbital cutting machines. The blades can be equipped with our IPC C coating in this case important to reduce the friction on the cutting edges but also to increase the hardness of the blade from 900 to 3400 HV.

The higher temperatures that the coating grant, allow to cut totally dry. In case of the ones without IPC C we suggest the use of a high density oil or lubricant. The blades are made with M35 or M2 material to allow performances respectably on stainless or carbon steel.
The blades need to be used always on single head cutting machines. The blades can be resharpened.

BW





HSS PT

Product Features



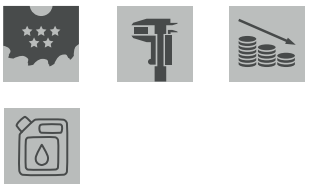
Areas of Application



MATERIALGROUP 1

MATERIALGROUP 2

Product Advantages



All products with IPC C

IPC Individual® Performance Cutting.



Hard Coating
for increased tool life
and cutting performance



DRY-TEC ®

TCT DRY cutting circular saw blade for metal cutting

DRY-TEC							
Diameter	Thickness		Bore	Teeth			
[mm]	[mm]		[mm]	60	72	80	90
305	2,20	1,80	25,40	■		■	
355	2,40	2,00	25,40		■		■

These carbide tipped circular saw blades are specially made to be used on portable cutting machines and are used mainly for pipe, profiles and small solids. They accept vibrations and they normally don't use IPC C.

The kerf is quite thin and the tooth shape is specially designed for the use without coolant and even oil mist. The cutting generate a small friction but a clean cut.

For dry cutting steel and other ferrous materials. Not suitable for cutting stainless steel.

Carbide PT

Product Features



Areas of Application



MATERIALGROUP 1

Product Advantages



Cutting Parameter

FLYING Cutting Parameter

		FLY-TEC | ORB-TEC		FLY-TEC		ORB-TEC		HSS-TEC IPC C			
Material	Tensile Strength [N/mm²]	Feed per Teeth [mm/Z]		Cutting Speed [m/1']		Cutting Speed [m/1']		Feed per Teeth [mm/Z]		Cutting Speed [m/1']	
Mild Steel	< 400	0,04	0,12	130	390	225	450	0,03	0,12	60	240
Carbon Steel	400 - 650	0,04	0,12	120	360	200	400	0,025	0,1	60	240
Alloyed Steel	650 - 1000	0,04	0,12	100	300	180	360	0,025	0,1	30	120
High Tensile Strength Steel	> 1000	0,04	0,12	60	180	100	200				
Aluminium | Light Alloys	< 1%	0,03	0,09	150	450	225	450	0,03	0,12	100	280
Austenitic Stainless Steel	500 - 800	0,03	0,09	60	140	70	140	0,02	0,08	25	50
Ferritic Stainless Steel	400 - 700	0,03	0,09	100	250	125	250	0,025	0,1	30	120

Safety Notice

Observe the safety warnings of the power tool/ cutting machine being used

Select suitable circular saw blades for the material being worked. Observe the material information on the packaging. Observe the thickness of the riving knife and the instructions of the machine. Before using, check the saw teeth, machine settings and rotation direction. Use only saw blades that are in perfect condition. Use the original packaging for storage and transportation

Safe Operation

- Maximum speed: The maximum speed given on the circular saw blade may not be exceeded. Observe the speed range (as far as indicated) of the catalogue.

- TCT circular saw blades: Circular saw blades that have cracks in their main body must be replaced. Repair are not permitted.

Fastening Circular Saw Blades and Machine Components

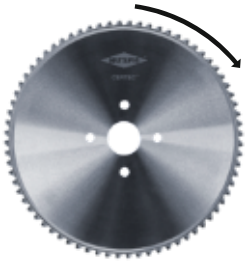
When replacing a saw blade, rule out accidental starting of the power tool/cutting machine. Mount and secure the circular saw blade in accordance ith the regulations of the machine manufacturer, observe the regulations specified by the machine manufacturer. Circular saw blades and machine components must be clamped in such a manner that they cannot become loose during operation. Observe the information supplied by manufacturer. When mounting the circular saw blade, make sure that the hub of the tool is properly clamped and that the saw blade teeth are not in contact with any part of the machine. Extending spanners or using hammers or similar for tightening purpose, is not permitted. The clamping surface must be free of grease, oil and water. Using loose reduction rings or bushings is not permitted. Using reduction rings that are firmly attached, is permitted when these are produced according to the manufacturer's specifications. The ring thickness must always be minimal less than the blade body thickness.

Repair and Resharpening of Circular Saw Blades

When repairing or resharpening, the design of TCT circular saw blades may not be changed. We recommend not to repairing or resharpening. Carbite tipped circular

saw blades may only be repaired or resharped trough competent persons with professional training and experience that know the design and construction requirements and understand the safety regulations to be achieved.

Notice the Following



Confirm the rotation direction before using.





MECAPRO MOBILE MAINTENANCE TEAM

Preventive and Corrective Maintenance Services

Entrust your machine's repair and maintenance to the expert hands of the Montfort technicians.

- **An increase in production with well maintained and mechanical failure-free equipment**
- Installation, integration and modifications of your equipment and machines
- Preventive maintenance according to the manufacturer’s specifications
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