SAMURAI
SAW WORKS CO.,LTD.
Cold sawblade for Metal Cutting

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Distributed agent by:



SR-1 Series **Resharpenable type** of saw blade

When the competition is worn & done.The Samurai re-sharpend is still No.1!
While you throw away the competition you can resharpen and resue our saw blade.
As time goes the competitions blade will wear but Samurai saw blades can be resharped without quality loss.

Samurai the essence of precision Cold saw blade technology！

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SAMURAI®
Saw Works

The Spirit Of Samurai Precision Blades Technology



All New Evolution
SR-1 Series *Cold saw blade Resharpenable type*

The new cutting-edge technology!

SAMURAI Saw Works SAMURAI SAW WORKS CO., LTD.

SR-Series Reshapenable type

When the competition is worn & done The Samurai Re-sharpend is still No.1! While you throw away the competition you can resharpen and reuse our saw blade. As time goes the competitions blade will wear but Samurai saw blades can be resharped without quality loss.



SR-1 No.1 of cutting mate
The blade has been specially developed for cutting solid alloy and high carbon steel.



SR-1A Alumin of cutting mate
The blade has been specially developed for cutting aluminum.



SR-1C Copper of cutting mate
The blade has been specially developed for cutting solid copper.



SR-1P Pipe of cutting mate
The blade has been specially developed for cutting tubes and iron pipe tubes.

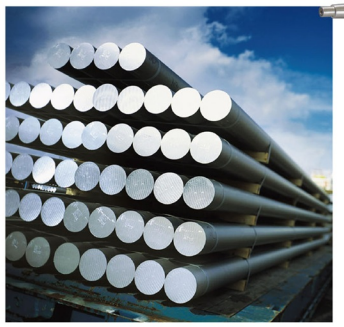


SR-1S Super of cutting mate
Type specially for cutting stainless steel and high carbon steel.



SR-1T TiAIN costing of cutting mate
The blade has been specially developed for cutting iron pipe, cast iron and construction iron.

Suitable cutting materials



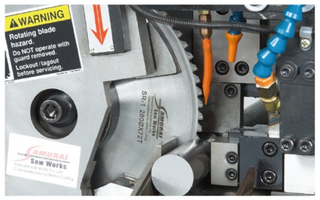


MATERIALS			SAW BLADE TYPE					
JIS	SAE AISI	DIN	SR-1	SR-1A	SR-1C	SR-1P	SR-1S	SR-1T
S10 C	1010	C10 E	✔					✔
S15 C	1015	C15 E	✔					✔
S20 C	1020	C20 E	✔					✔
S25 C	1025	C25 E	✔					✔
S35 C	1035	C35 E	✔					
S45 C	1045	C45 E	✔					
S50 C	1050	C50 E					✔	
S55 C	1055	C55 E					✔	
SCM-415	4115	15CrMo5	✔					
SCM-420	4120	25CrMo4	✔					
SCM-435	4135	34CrMo4	✔					
SCM-440	4140	42CrMo4	✔					
SCR-415	5015	15Cr3	✔					
SCR-435	5135	37Cr4	✔					
SCR-440	5140	41Cr4	✔					
SNCM-220	8620	20NiMo2	✔					
SNCM-439	4340	40NiCrMo6	✔					
SMN-420	1524	22Mn6	✔					
SMN-433	1536	34Mn5	✔					
SACM-645	7140	41CrA1					✔	✔
SUJ-2	52100	100Cr6					✔	✔
SKD-11	D2	X165CrMoV12					✔	✔
SKD-1	D3	X210Cr12					✔	✔
SKD-61	H13	X40CrMoV51					✔	✔
SKD-6	H11	X38CrMoV51					✔	✔
SUS-303	303	X8CrNiS8-9					✔	
SUS-304	304	X8CrNiS18-10					✔	
SUS-316	316	X6CrNiMoTi17 12 2					✔	
SUS-403	403	X6Cr13					✔	
SUS-410	410	X12Cr13					✔	
SUS-420	420	X20Cr13					✔	
SUS-430	430	X6Cr17					✔	
SUS-434	434	X6CrMo17-1					✔	
STKM11-15A-C	A570	ST37/42				✔		✔
SS490	A572	ST52/60				✔		✔
C1100	C11000				✔			
C3601-4B	C36000				✔			
A2011 & A6061	2100 & 6061			✔				

SAMURAI Saw Works SAMURAI SAW WORKS CO., LTD.

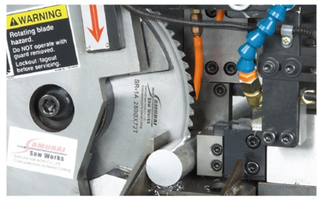
SR-Series Sawblade Resharpenable type

Cold saw blade specifically designed can be re-sharpend.



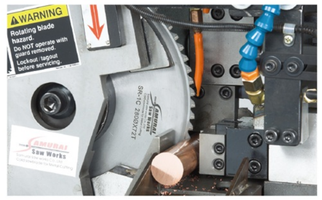
SR-1

Type specially for cutting solid alloy and low, mild carbon steel.



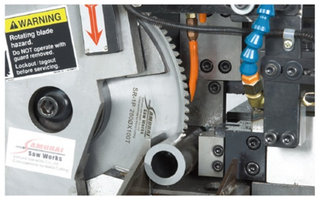
SR-1A

Type specially made for cutting solid aluminum.



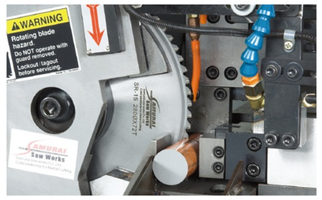
SR-1C

Type specially for cutting solid copper.



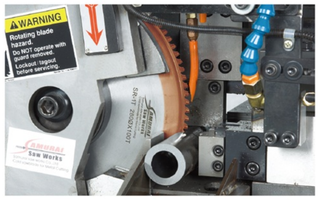
SR-1P

Type specially designed for cutting tubes and iron pipe tubes.



SR-1S

Type specially made for cutting stainless steel and High carbon steel.



SR-1T

Type specially made for cutting construction iron and cast iron or iron pipe.

Optimum Number of teeth for cutting Material diameter

Saw blade (Diameter)	No. of Teeth	Material diameter (mm) 0 10 20 30 40 50 60 70 80 90 100 110 120 130 140 150
250	60	
	72	
	80	
280 / 285	60	
	72	
	80	
360	60	
	72	
	80	
	100	
420 / 425	60	
	80	
	100	
460	72	
	80	

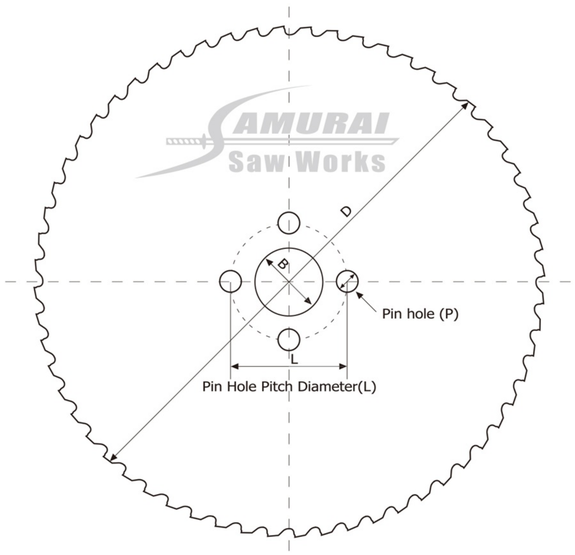
Cold saw blade Cutting Parameter:

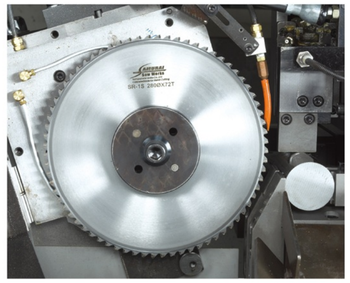
Saw blade (Diameter)	Material (JIS)	Number of (Teeth)	Material Dimension (mm)	Rotational Speed (RPM / min)	Cutting Speed (mm / sec)
360	S10~25C	60 T	90~100	105~110 rpm/min	4.5~5mm/sec
		72 T	60~90	100~110 rpm/min	5~5.5mm/sec
		80 T	40~60	98~110 rpm/min	5.5~6mm/sec
	S35~45C	60 T	90~100	100~105 rpm/min	4.5~5mm/sec
		72 T	60~90	95~105 rpm/min	5~5.5mm/sec
		80 T	40~60	93~105 rpm/min	5.5~6mm/sec
	SCM~415	60 T	90~100	105~110 rpm/min	4.5~5mm/sec
		72 T	60~90	100~110 rpm/min	5~5.5mm/sec
		80 T	40~60	98~110 rpm/min	5.5~6mm/sec
	SCM~440	60 T	90~100	90~95 rpm/min	3~3.8mm/sec
		72 T	60~90	85~95 rpm/min	3.2~4mm/sec
		80 T	40~60	83~95 rpm/min	3.5~4.2mm/sec
	SNCM~220	60 T	90~100	100~105 rpm/min	4.2~4.8mm/sec
		72 T	60~90	95~105 rpm/min	4.8~5.2mm/sec
		80 T	40~60	93~105 rpm/min	5.2~5.8mm/sec
	SNCM~439	60 T	90~100	90~95 rpm/min	2.8~3.6mm/sec
		72 T	60~90	85~95 rpm/min	3~3.8mm/sec
		80 T	40~60	83~95 rpm/min	3.3~4mm/sec

More cutting parameter information please contact with samurai

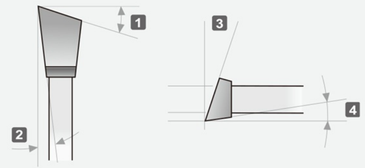
The SR-Series

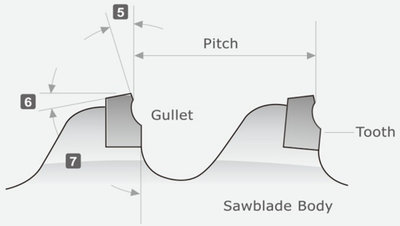
Cold saw blade's have a specially uniquely designed angle that can be re-sharpend to extended the blade cutting life.

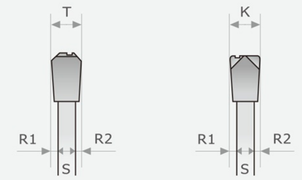




Technical Note







Angle Designation

Top Bevel Angle	1
Radial Clearance Angle	2
Face Bevel Angle	3
Tangential Clearance Angle	4
Hook negative Angle	5
Clearance Angle	6
Tooth Point Angle	7
Diameter	D
Bore hole Diameter	B
Pin Hole Pitch Diameter	L
Ke rf	K
Saw Body Thickness	S
Number of Teeth	T
Radial Clearance Angle	R1,R2
Pin Hole Diameter	P

SR-1 Series Cold saw blade Resharpenable type

Features

1. The **SR-1** Cold sawblade can be re-sharpened for extended use of the blade.
2. The **SR-1** Cold sawblade's teeth have a uniquely designed angle that enhances the quality of cutting and lengthens the life span of the blade.
3. The blade has been specially developed for cutting solid alloy and high carbon steel.



Specification

Pin Holes (P) / Pin Holes Pitch Diameter (L)				Bore Hole Diameter (B)	
				mm	inch
4 / 9 / 50	4 / 11 / 63			32,00	1,25
4 / 11 / 63	4 / 11 / 90	2 / 12 / 65	2 / 15 / 80	40,00	1,57
4 / 11 / 90	4 / 16 / 80	4 / 21 / 90		50,00	1,96

(D) mm	(K) mm	(S) mm	(H) mm	(T) Teeth	(D) inch	(K) inch	(S) inch	(H) inch	(T) Teeth
240,00	2,00	1,75	32,00	60	9,45	0,079	0,069	1,26	60
240,00	2,00	1,75	32,00	72	9,45	0,079	0,069	1,26	72
250,00	2,00	1,7	32,00	72	9.84	0,079	0,067	1,26	72
250,00	2,00	1,7	32,00	80	9.84	0,079	0,067	1,26	80
250,00	2,00	1,7	32,00	60	9.84	0,079	0,067	1,26	60
250,00	2,00	1,75	40,00	72	9.84	0,079	0,069	1,57	72
250,00	2,00	1,75	40,00	60	9.84	0,079	0,069	1,57	60
250,00	2,00	1,75	40,00	80	9.84	0,079	0,069	1,57	80
280,00	2,00	1,75	40,00	60	11,02	0,079	0,069	1,57	60
280,00	2,00	1,75	40,00	72	11,02	0,079	0,069	1,57	72
280,00	2,00	1,75	40,00	80	11,02	0,079	0,069	1,57	80
285,00	2,00	1,7	40,00	60	11,22	0,079	0,067	1,26	60
285,00	2,00	1,7	40,00	80	11,22	0,079	0,067	1,26	80
285,00	2,00	1,75	40,00	60	11,22	0,079	0,069	1,26	60
285,00	2,00	1,75	40,00	60	11,22	0,079	0,069	1,57	60
285,00	2,00	1,75	40,00	72	11,22	0,079	0,069	1,57	72
285,00	2,00	1,75	40,00	80	11,22	0,079	0,069	1,57	80
315,00	2,30	2,00	32,00	72	12,40	0,079	0,079	1,26	72
360,00	2,60	2,25	40,00	60	14,17	0,091	0,089	1,57	60
360,00	2,60	2,25	40,00	72	14,17	0,102	0,089	1,57	72
360,00	2,60	2,25	50,00	80	14,17	0,102	0,089	1,97	80
380,00	2,60	2,25	50,00	72	14,96	0,102	0,089	1,97	72
380,00	2,50	2,25	50,00	80	14,96	0,098	0,089	1,97	80
380,00	2,50	2,25	50,00	100	14,96	0,098	0,089	1,97	100
420,00	2,60	2,25	40,00	60	16,54	0,102	0,089	1,57	60
420,00	2,60	2,25	40,00	72	16,54	0,102	0,089	1,57	72
420,00	2,60	2,25	40,00	80	16,54	0,102	0,089	1,57	80
425,00	2,70	2,25	50,00	60	16,73	0,106	0,089	1,97	60
425,00	2,70	2,25	50,00	80	16,73	0,106	0,089	1,97	80
425,00	2,70	2,25	50,00	100	16,73	0,106	0,089	1,97	100
460,00	2,70	2,25	40,00	80	18,11	0,106	0,089	1,57	80
460,00	2,70	2,25	40,00	72	18,11	0,106	0,089	1,57	72
460,00	2,70	2,25	50,00	80	18,11	0,106	0,089	1,97	80
460,00	2,70	2,25	50,00	72	18,11	0,106	0,089	1,97	72

SR-1 Cold saw blade Instruction Manual Operation



A: Always make sure that the rotation of the saw is correct direction.
B: Notice while installing or replacing the saw, no foreign clean the saw surface.



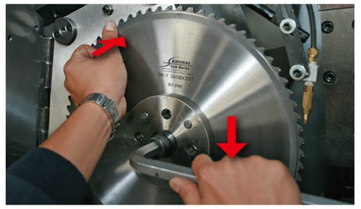
On the first cut pay careful attention that the material being cut has a length of at least 20mm, shorter then this will create more stress on the blade and may cause damage to the saw blade's teeth.



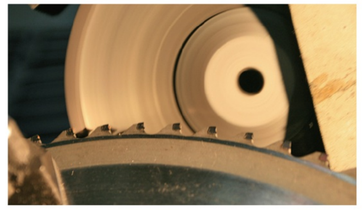
While replacing the new saw blade make certain the machine is turned off.



Before installing the saw blade should be cleaning the Tungsten Carbide Clamp. If the saw blade still has a problem, it might be the Tungsten carbide Clamp causing the curving or distortion.



While replacing and lacking the saw blade be attention to press holding opposite direction of the saw blade.



Remember the saw blade may be Re-sharpened and does not need to be discarded when dull.



Save saw blade life skill. Believe or not !

1. On the first cut pay careful attention that the material being cut has a length of at least 20mm, shorter then this will create more stress on the blade andmay cause damage to the saw blade's teeth.
2. If the " teeth break " always on the right side face . because first material being cut are too shorter .
3. In order to maintain longer lasting saw blades, on the first cut you can't cut to short or you will break the saw's teeth. If the teeth break the life of saw blade will be reduced dramatically.
4. Sometimes the machine makes a mistake while cutting to make " teeth break" andhas nothing to do with the saw blade.
5. Before installing the saw blade should be cleaning the Tungsten Carbide Clamp. If the saw blade still has a problem, it might be the Tungsten carbide Clamp causing the curving or distortion. Please pay attention !