

ULTRA®

The World Sawing Specialist



BANDSAW BLADES





ULTRA International Customers



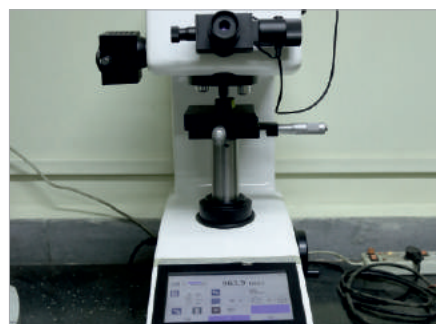
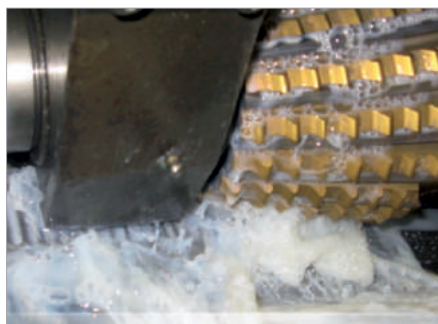
Distributor Centers

- Paris, France
- Singapore
- Amsterdam, Netherland



Manufacturing Sites (INDIA)

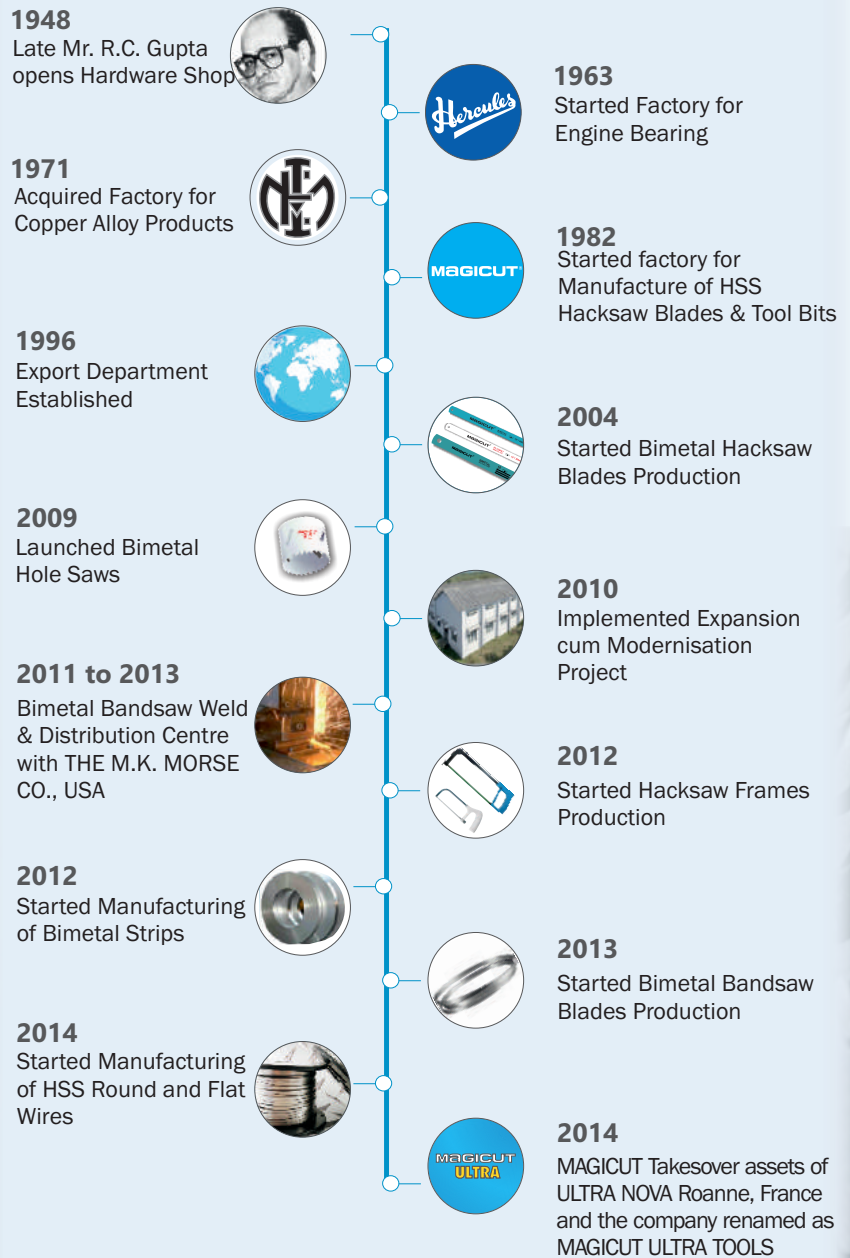
- Daman Saws & Tools
- Ankleshwar Bandsaw Blades
- Palghar Bimetal Strips & Flat Wires
- Mumbai Corporate Office



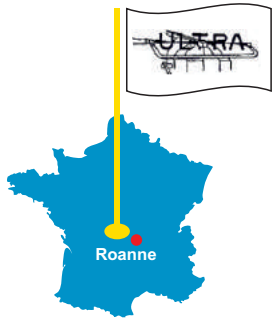
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ABOUT US



Celebrating 100 Years of a Rich Legacy



1923

Established DÉMURGER SA
in Roanne, France

1932

Launched Hand Tools



1995

New Production Workshop
for Bandsaw Blades
Inaugurated

Started Production
of Hole Saws

1990



1984

Launched Bi Hard Cobalt
Hacksaw Blade

1996

Company Obtains
ISO 9001 Certificate



DIAM Group Takes Over and name
changed to ULTRA DIAM

2006



2008

ALFRA Group Takes Over
and name changed to
ULTRA NOVA



Implemented 5S
Operational System

2021



2018

Ultra Tools Obtains
ISO 9001 Certificate



ULTRA TOOLS SAS
Established in Paris,
France

2017

Purchased Equipements for
Hacksaws & Carbon Band
Saws from DORMER TOOLS
INDIA PVT LTD

2022

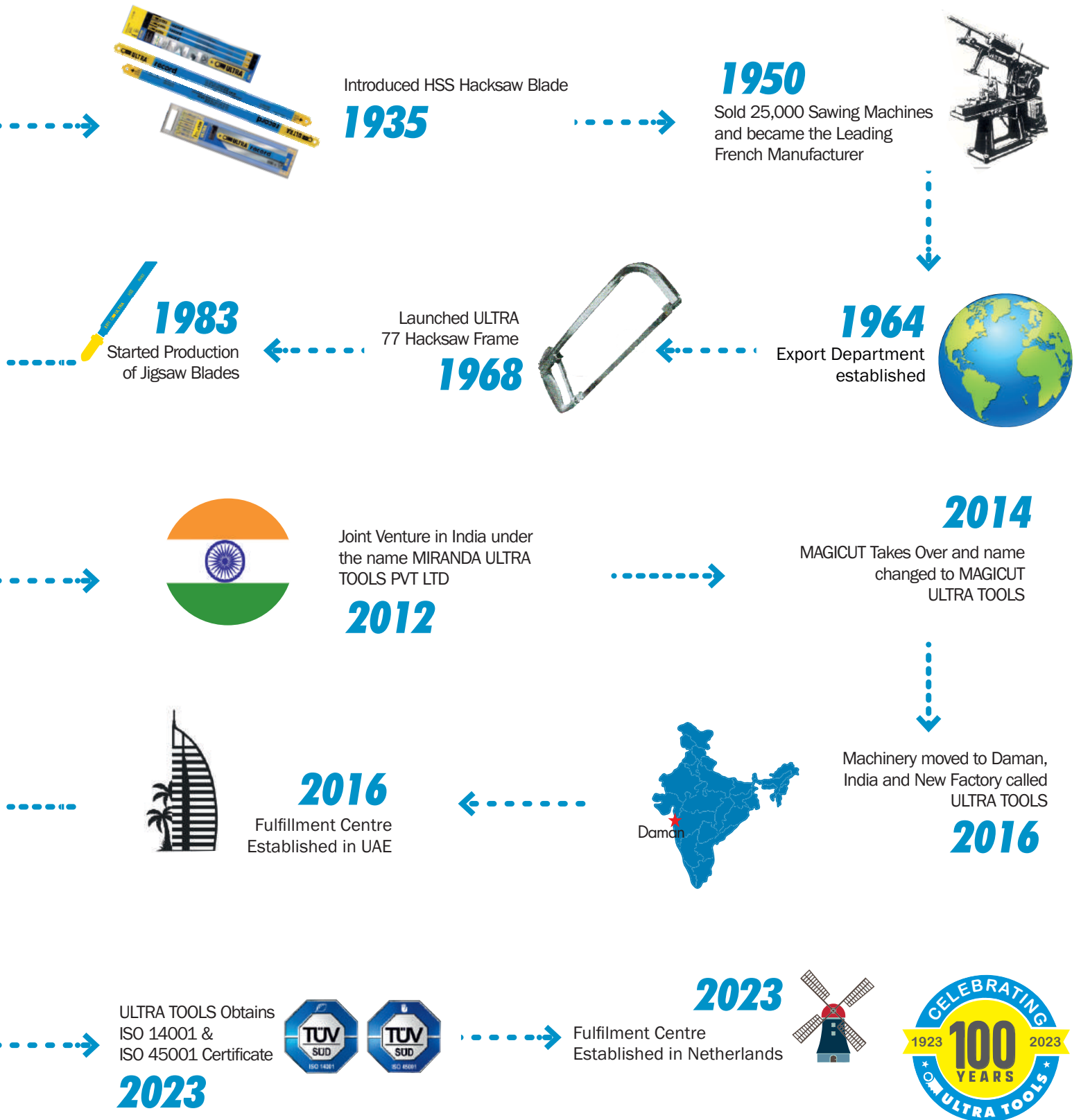


2023

ULTRA gets back the Ankleshwar
Unit and Consolidates all Bandsaw
Blades Manufacturing at this location

ULTRA ALUMINIA M42

Looking Forward to Building an Exciting Future



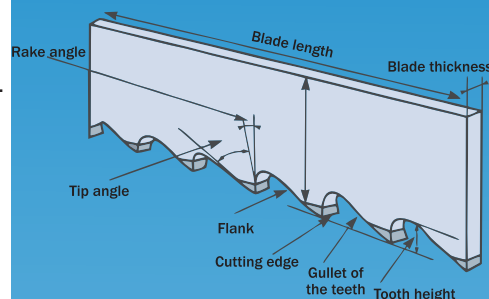
SELECTING the right blade

Toothing

The teeth are obtained by milling according to different profiles developed in our laboratories.

They give a combination of parameters:

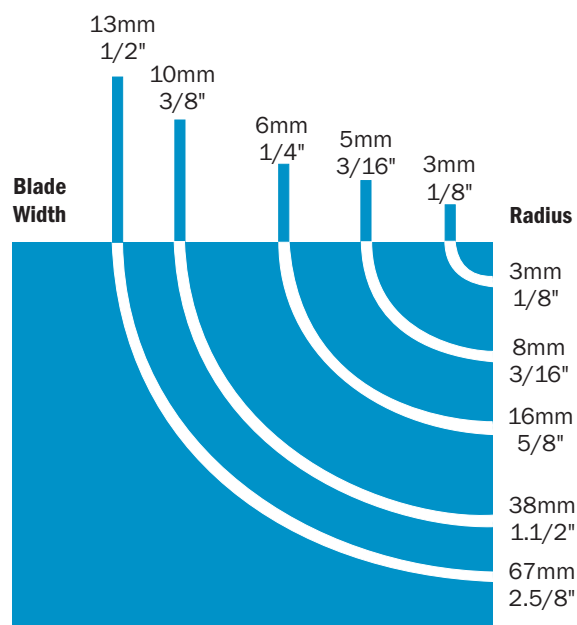
- Variable pitch (marked by the letters V),
- Constant pitch with rake angle (marked by letter I, CI, X and G), with 0 rake angle (marked by letter N)
- High output work (alternate set) or with improved surface condition (Raker set)



	Aluminium		Bronze		Low Carbon steels		High Carbon steels		Alloy Steels	Bearing steels	Steel for molds	Tool steels	Stainless steels	Nickel based Stainless	Titanium
	Profiles	Solids	Profiles	Solids	Profiles	Solids	Profiles	Solids	Solids	Solids	Solids	Solids	Solids	Solids	Solids
FLEX															
VULCA															
FURIA															
OPTIMA															
KATANA															
PROFILA															
ALUMINIA															
WOOD															
TITAN															
ULTIMA															
ADVANCE															
CS m/mn	+600		+100		90		70		60		45		40	20	15

Blade Width

Use the blade width recommended by the machine manufacturer, except for contour cutting in vertical machines when you should use the chart below.

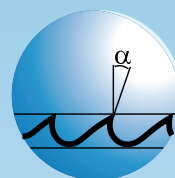


The length and the section of the bandsaw blade

- Length and section are linked to the machine
- Length and width is measured in millimeters
- Thickness is linked to the section and is also measured in millimeters.

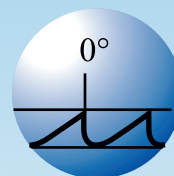
Cutting Angle

- Use a positive cutting angle to saw hardworking or non-ferrous materials..



CI, VI, VX, V+

- Use a zero cutting angle for lightly alloyed construction steels and profiles

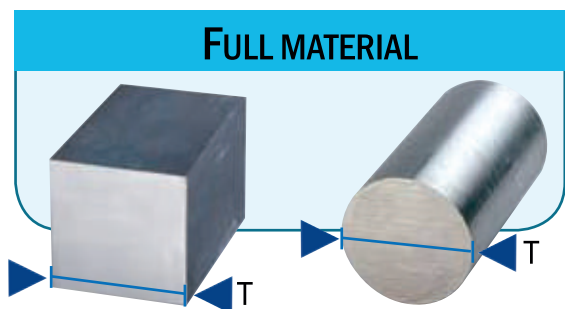


N, VN

SELECTING the right blade

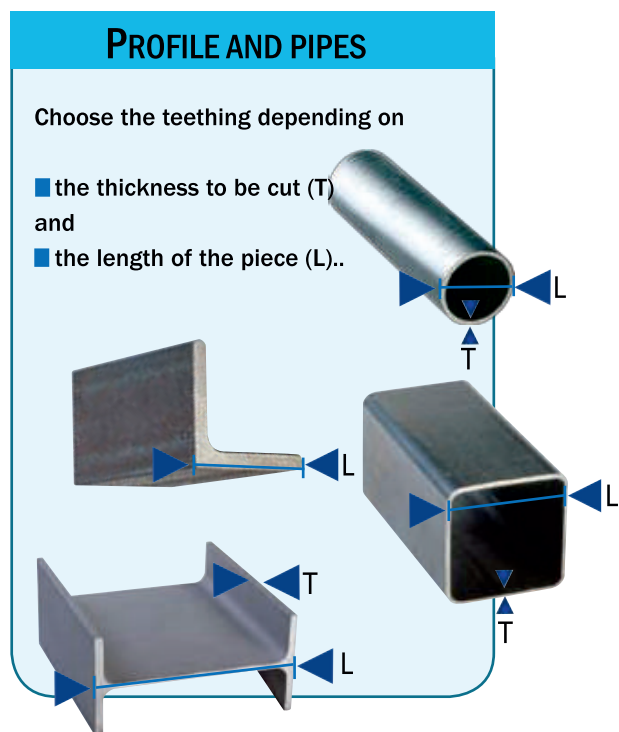
The choice of the teething

Choose the right teething from the above chart. The teething is indicate in teeth per inch
(1 inch = 25.4 mm) When section varies during sawing operation,
choose variable pitch teething, allowing wider sawing possibilities.



Constant pitch	18	14	10	8	6	4	3	2	1,2	0,75
Thickness T (mm)	2 - 3	5 - 8	12 - 16	22 - 30	40 - 70	100 - 140	200 - 240	300 - 450	600	
Variable Pitch	10/14	8/12	6/10	5/8	4/6	3/4	2/3	1/2	0.7/1.2	

Variable sections & structurals and tubes cutting



L (mm) \ T (mm)	20	40	60	80	100	120	150	200	300	500
2	14	14	10/14	10/14	10/14	10/14	10/14	8/12	6/10	6/10
3	10/14	10/14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	5/8
4	8/12	8/12	8/12	8/12	8/12	6/10	6/10	6/10	5/8	5/8
5	8/12	8/12	8/12	6/10	6/10	6/10	6/10	5/8	5/8	4/6
6	6/10	6/10	6/10	6/10	6/10	6/10	5/8	5/8	4/6	4/6
8	6/10	6/10	6/10	6/10	5/8	5/8	5/8	4/6	4/6	3/4
10		5/8	5/8	5/8	5/8	5/8	4/6	4/6	4/6	3/4
12		5/8	5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4
15		4/6	4/6	4/6	4/6	4/6	3/4	3/4	3/4	2/3
20			4/6	4/6	3/4	3/4	3/4	3/4	2/3	2/3
30				3/4	3/4	3/4	2/3	2/3	2/3	2/3
50					2/3	2/3	2/3	2/3	2/3	1,2/2

SELECTING the right blade

The technical advices

The cutting rate Cutting rate is the surface in cm² divided by the cutting time. This fundamental. It guaranties the best compromised between performance and blade life.

The blade set up Install the blade into the machine so that the teeth will engage the material, if necessary turn the blade and carefully put the back of the blade in between the guide rollers.

The blade tension Once the blade is correctly seated on the machine. Start to lighten the blade. When done, you have to check that the blade remains in the correct position, Follow the values given by the machine manufacturers. You can also us a tension gauge to verify your adjustments.

If your machine manufacture gives no indications use this chart a guide

Section (mm)	Horizontal machine		Vertical machine	
	Min	Max	Min	Max
20	14	20	18	24
27	16	22	19	26
34	21	27	23	30
41	23	28	24	29
54	24	31	24	31
67	24	31	24	31

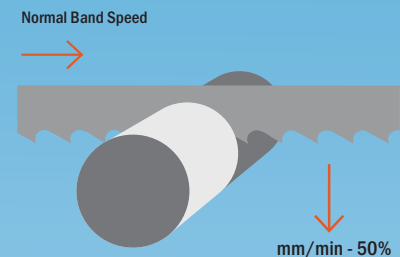
$$TX = \frac{\text{Surface}}{\text{Cutting time}}$$

IMPORTANT : check the guide rollers.

The break in

Bandsaw blades like all HSS cutting tools must have a break in period to maximise life. A good break in period will reduced the occurrence of teeth stripping and optimized blade life.

For the first cuts, it's imperative to reduce the feed rate by 50% and cutting speed by 30%. After the initial break in period, gradually increase the speed and feed to reach the desired values.



Using Metal Chips to Troubleshoot

You can improve the productivity of your metal cutting operation by paying close attention to the chips made by the blade cutting through metal. This chart show some of the common problems that can be discovered and solved by paying attention to chips

Chip Form	Chip Condition	Chip Color	Blade Speed	Blade Feed Rate
	Thin, or Powderly chips	Silver	Decrease ↓	Increase ↑
	Loosely and Curled	Silver	Suitable ✓	Suitable ✓
	Heavy, Thick, and Tightly Curled	Blue	Suitable ✓	Decrease ↓

The important points machine

- Guide arms : Adjust the guide arms as close to the work as possible.
- Guides: Check ball bearings for wear and tear.
- Hydraulic circuit : Visually check the hydraulic circuit, checking for leaks in the bow and on the vice.
- Lubrication : Check the coolant delivery, level and the concentration (5% to 10%)
- Brush : Check the brush position to ensure chip are efficiently removed.

Various precautions:

- Check that the teeth are in the cutting direction
- Adjust the guide arms as close to the work as possible
- Maximum of coolant.

ULTRA[®] VULCA

Manufactured in Matrix II Steel, the VULCA bandsaw blade offers a good compromise between hardness and resilience and is ideally suited for cutting profiles and thin metal sheets from low alloyed steel and non ferrous metals.

Designed to offer excellent shock resistance, VULCA teething offers a 20% increased life and enhances the safety of the operator.

Characteristics

Advantages

Reinforced tooth shape

>

Increase precision and cutting performance in small profiles

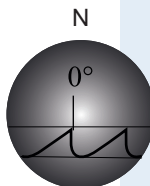
Shock resistance

>

20% longer life time

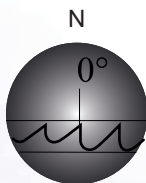
Constant pitch

Section		Teeth per inch					
mm	pouce / inch	6	8	10	14	18	24
13 x 0.065	1/2 x 0.025		■	■	■	■	■



Variable pitch

Section		Teeth per inch				
mm	inch	4/6	5/8	6/10	8/12	10/14
13 x 0.065	1/2 x 0.025			■	■	■



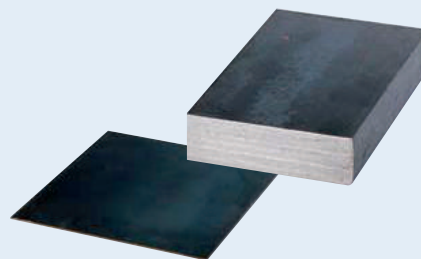
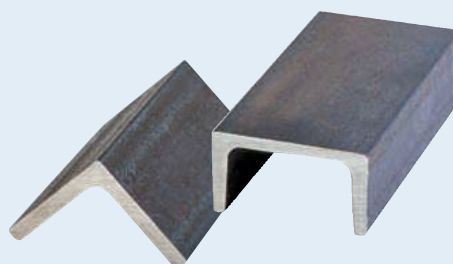
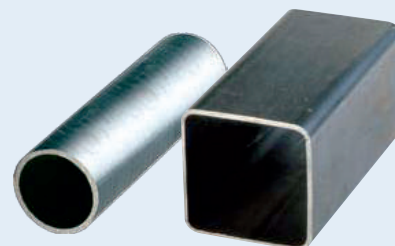
Matrix II

67 HRC



Less brittle, It has greater impact resistance

PRECISION



ULTRA VULCA MATRIX II 13 x

ULTRA® FURIA

This multipurpose blade is designed to cut all kinds of steels, both ferrous and non-ferrous, in all dimensions and shapes. Combining durability and high hardness, this bandsaw blade is suitable for industrial sawing with automatic and semi-automatic machines.

Particularly resistant to wear, this blade offers increased life when exposed to less than ideal working conditions resulting in better productivity with reduced costs. Accurate, efficient and resistant, this blade guarantees a clean cut at a low cost.

Characteristics

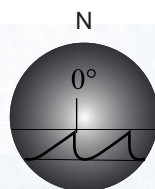
Highly durable and hard
Multiple Tooth geometry
Tooth sequence designed to avoid vibrations generating noise and premature wear

Advantages

> Increased lifetime and cutting performance
> Suitable for full material and profiles
> Better use comfort
> Sawing of a wider selection of material and sections
> Increased lifetime

Constant pitch

Section		Teeth per inch							
mm	inch	2	3	4	6	8	10	14	
20 x 0.090	3/4 x 0.035				■	■	■	■	
27 x 0.090	1 x 0.035			■	■	■	■	■	
34 x 1.10	1 1/4 x 0.042		■	■	■				
41 x 1.30	1 1/2 x 0.050	■	■	■	■				



Variable pitch

Section		Teeth per inch							
mm	inch	2/3	3/4	4/6	5/8	6/10	8/12	10/14	
20 x 0.090	3/4 x 0.035			■	■	■	■	■	
27 x 0.090	1 x 0.035	■	■	■	■	■	■	■	
34 x 1.10	1 1/4 x 0.042	■	■	■	■	■			
41 x 1.30	1 1/2 x 0.050	■	■	■					



M42
67 / 68 HRc



Provides the best compromise between hardness and impact resistance..

MULTIPURPOSE



ULTRA[®] OPTIMA

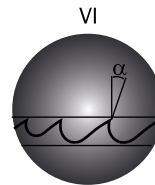
Bandsaw blades to complete the Furia range. M42 steel with heat treatment adopted to reduce impact resistance. Positive cutting angle allowing all materials to be cut. The back of the tooth is reinforced for a better impact resistance, improve gullet line to facilitate the chip disposal. Teeth sequence cancelling noise during the cut.

Uses: Sawing plants, mechanics on automatic and semi-automatic machines. Cut steel, structural steel alloy, stainless steel, pretreated steel.

Characteristics	Advantages
2 teething, 3 sections	> An easier tooth selection
Reduced Impact Resistance	> Long life significant improvement in standard steel and stainless steel pipes.

Variable Pitch

Section		Teeth per inch					
mm	inch	0.75/1.25	1.4/2	2/3	3/4	4/6	5/8
27 x 0.090	1 x 0.035			■	■	■	■
34 x 1.10	1 1/4 x 0.042			■	■	■	■
41 x 1.30	1 1/2 x 0.050		■	■	■	■	■
54 x 1.30	2 x 0.050	■	■	■	■	■	
54 x 1.60	2 x 0.063	■	■	■	■	■	
67 x 1.60	2.5/8 x 0.063	■	■	■			
80 x 1.60	3 x 0.063	■	■				

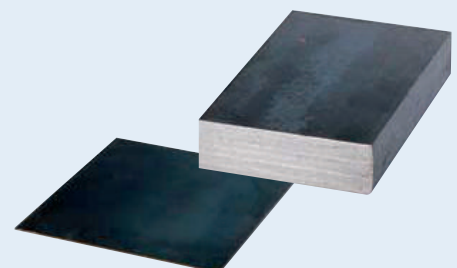
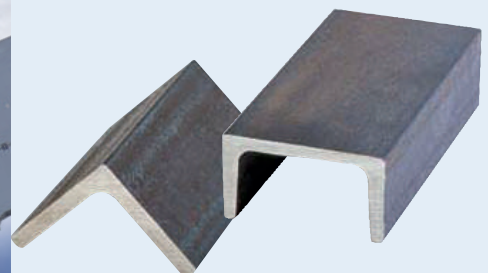


M42
67 / 68 HRc



Provides the best compromise between hardness and impact resistance.

ALL - ROAD



ULTRA® KATANA

Designed with a flat gullet and a highly positive cutting angle, KATANA is the perfect blade for sawing tool and stainless steels. This blade combines an aggressive tooth design and a resilient steel giving it all the required strength to cut the toughest of steels. Easy to use, KATANA is accurate and efficient in all alloyed steels.

This band is the most suitable for materials requiring cutting speeds between 25 and 50m/min.

M42
67 / 68 HRc



Provides the best compromise between hardness and impact resistance.

Characteristics

Advantages

M42 quality	> Hardness & toughness
Extremely positive cutting angle	> Facilitates cutting difficult materials and reduced the cutting effort
Flat gullet	> Positive cutting angle
Variable pitch	> Reduction of vibration resulting in an increase of life

PERFORMANCE

Variable Pitch

Section		Teeth per inch						
mm	inch	0.75/1.25	1.2/2	2/3	3/4	4/6	5/8	
27 x 0.090	1 x 0.035			■	■	■	■	
34 x 1.10	1 1/4 x 0.042			■	■	■	■	
41 x 1.30	1 1/2 x 0.050			■	■	■	■	
54 x 1.30	2 x 0.050		■	■	■	■		
54 x 1.60	2 x 0.063	■	■	■	■	■		
67 x 1.60	2.5/8 x 0.063	■	■	■				

VX



ULTRA[®] PROFILA+

The PROFILA+ blade has been especially designed for cutting large steel and stainless steel profiles, singularly or in bundles.

The blade's progressive setting, enhances the safety conditions when cutting I-beams and girders reducing the occurrence of pinching and binding.

PROFILA+'s reinforced teething substantially increases the blades resistance to shocks.

M42
67 / 68 HRc



Provides the best compromise between hardness and impact resistance.

PROFILES

Characteristics

Variable pitch with a stronger back clearance angle

Positive cutting angle

Progressive setting

M42 quality material with some unique processes

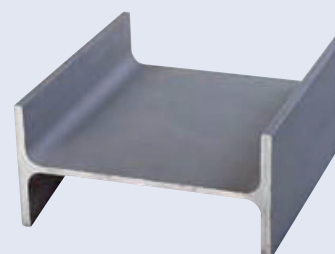
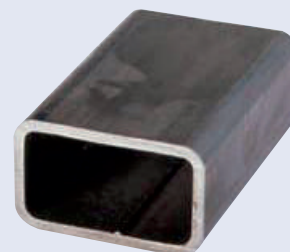
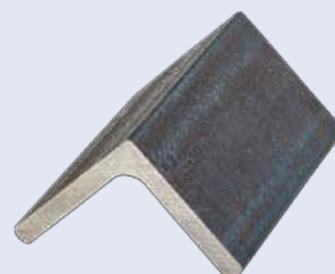
Advantages

- Reduction of vibrations and noise during cutting operation. Better resistance to shocks.
- Easier material penetration
- Reduced risk of blade pinching in material
- Excellent shock and fatigue resistance of the blade

Variable Pitch

Section		Teeth per inch		
mm	inch	3/4	4/6	5/7
27 x 0.090	1 x 0.035	■	■	■
34 x 1.10	1 1/4 x 0.042	■	■	■
41 x 1.30	1 1/2 x 0.050	■	■	■

XL



ULTRA[®] ALUMINIA

Developed for the European leader in aluminium manufacturing, this blade offers 50% greater lifetime as well as providing a 30% higher cutting rate when comparing it to other bandsaw blades in its category. Its extra large teething and positive cutting angle guarantee significant productivity and financial gains.

Perfectly suitable for sawing of aluminium blocks, it can also be used for trimming cast moulding and cutting aluminium profiles in bundle operations.

M42
67 / 68 HRc



Provides the best compromise between hardness and impact resistance..

Characteristics

Advantages

60% larger setting

➤ No more binding blades in the material during sawing operations

➤ Higher chip capacity

Raker group 5

➤ Less vibrations while cutting

M42 quality steel

➤ Greater abrasion and fatigue resistance for the blade

Positive cutting angle

➤ Less cutting efforts

Redesigned gullet

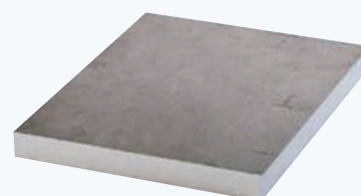
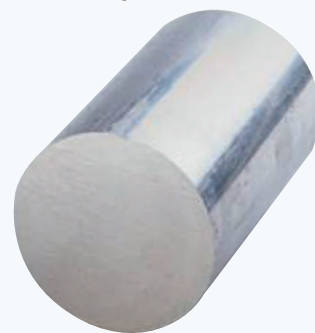
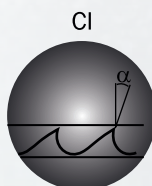
➤ Reduced twist

➤ Better and easier chip removal properties

A L U M I N I U M

Constant Pitch

Section		Teeth per inch		
mm	inch	2	3	4
20 x 0.090	3/4 x 0.035		■	■
27 x 0.090	1 x 0.035		■	■
34 x 1.10	1 1/4 x 0.042	■	■	■
41 x 1.30	1 1/2 x 0.050	■	■	



By the use of M51, the TITAN offers unrivalled hardness and excellent abrasion resistance. Combined with an aggressive teething, this blade is specially suited for cutting exotic and high alloyed steels.

The hardest in its category, it offers a definite and efficient solution for sawing stainless steel, inconel and nickel or chromium based steels.

M51

68 / 69 HRC



High-alloy, is extremely hard for cutting the toughest materials..

Characteristics

Advantages

M 51 quality

➤ High hardness and resistance to abrasion

VX profile

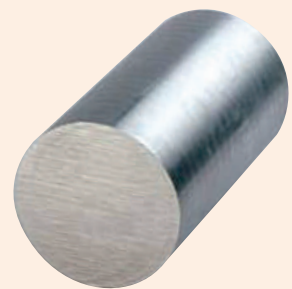
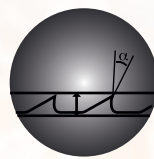
➤ Tolerates high feeding pressure
➤ Excellent penetration to reduce cutting efforts
➤ Reduced vibration

AGRESSIVITY

Variable Pitch

Section		Teeth per inch					
mm	inch	0.75/1.25	1.2/2	2/3	3/4	4/6	5/8
27 x 0.090	1 x 0.035			■	■	■	■
34 x 1.10	1 1/4 x 0.042		■	■	■	■	■
41 x 1.30	1 1/2 x 0.050			■	■	■	■
54 x 1.60	2 x 0.063	■	■	■	■		
67 x 1.60	2.5/8 x 0.063	■	■	■	■		

VX



ULTRA TITAN M51 41 x 1

ULTRA[®] WOOD

Bimetal bandsaw blade, developed for the saw mill industry of wood, this tape offers a longer service life by 50% and cut rate 30% higher compared with other conventional bandsaw blades. Its extra large teeth and positive rake angle guarantee increased productivity and profitability high.

Specially adapted for cutting softwood and hardwood, it can be used for trimming operations and cutting logs with knots.

Characteristics

Advantages

Positive cutting angle

>

Less cutting efforts

Longevity

>

Profitability

Constant Pitch

Section		Teeth Per Inch
mm	inch	1.2
27 x 0.90	1 x 0.035	■
34 x 1.10	1 1/4 x 0.042	■

CI



M42

67 / 68 HRc



Provides the best compromise between hardness and impact resistance.

WOOD



ULTRA WOOD M42 27 X 0.90

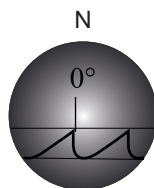
Flex TD

Of older conception, this carbon blade is used for “lighter” cutting applications such as sawing slightly alloyed and non alloyed steels.

This tooth-only-hardened blade is flexible and meets the requirement for contouring operations.

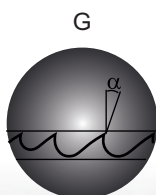
Constant pitch

Section		Teeth per inch						
mm	inch	4	6	8	10	14	18	24
6 x 0.090	1/4 x 0.035			■	■	■	■	■
8 x 0.065	5/16 x 0.025				■	■	■	
10 x 0.090	3/8 x 0.035			■	■	■	■	■
13 x 0.065	1/2 x 0.025		■	■	■	■	■	■
16 x 0.080	5/8 x 0.032	■	■	■	■	■	■	■
20 x 0.080	3/4 x 0.032		■	■	■	■	■	■
25 x 0.090	1 x 0.035	■	■	■	■	■	■	■



Skip

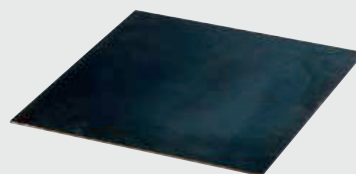
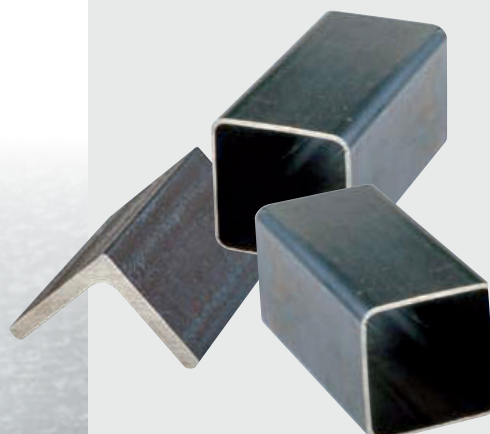
Section		Teeth per inch	
mm	inch	6	10
10 x 0.065	3/8 x 0.025	■	■
13 x 0.065	1/2 x 0.025	■	■
16 x 0.080	5/8 x 0.025	■	■
20 x 0.080	3/4 x 0.035	■	■
25 x 0.090	1 x 0.035	■	■



HCS
52 HRc



These are steels with a high carbon content. They have various levels of alloy, their mechanical properties give a better resistance to abrasion.



Problem Cause	Solutions
1 - Premature Dulling of Teeth	
• Bad break in	• Reduce speed and feed during break up to 30 %
• Teeth in wrong direction	• Flip blade inside out
• Bad steel structure not homogenous	• Check material hardness
• Hard spots an abrasive material	• Increase feed
• Cutting fluid badly used	• Check coolant mixture %
• Too high cutting speed	• Check cutting conditions
2 - Teeth Fracture	
• Bad break in	• Reduce speed and feed during break up to 30 %
• Work piece not clamped	• Check hydraulic pressure
• Incorrect tooth selection	• Check cutting condititons
• Guid arms not adjusted properly	• Adjust or replace the guide arms
• Incorrect speed or feed	• Adjust speed and feed
3 - Teeth Stripping	
• Incorrect or no break in	• Reduce speed and feed during break up to 30 %
• Parts not help properly	• Check hydraulic feed
• Incorrect tooth selection	• Check cutting conditions
• Lack of lubricant	• Check lubricant
• Feed too high	• Reduce feed and check cutting conditions
• Bad steel homogeneity	• Check hardness
• Bad chip removal	• Check the brush and chip removal
4 - Chip Weld on the Teeth	
• Cut badly cooled or/and incorrect lubricant or no coolant	• Check lubricant and coolant nozzles position
• Too high cutting speed	• Reduce speed
• Incorrect chip removal	• Check the brush and its position
5 - Blade Breakage or Cracks in Gullet	
• Too high blade tension	• Reduce tension
• Excessive feed	• Reduce feed
• Incorrect tooth selection (too coarse)	• Check cutting conditions
• No lubricant or incorrect lubricant	• Check lubricant conditions
• Guide arms too far from the work	• Readjust to the length to be cut
• Guides too tight (twisting of the blade)	• Check the blade position inside the guide
• Teeth working before starting the cut	• Allow 15 mm clearance before starting cut
6 - Wear on Back Blade	
• Incorrect tension of the blade	• Reduce tension
• Too high feed on the back	• Reduce feed
• Too high feed	• Check cutting condititons
• Blade incorrectly set up	• Check blade position
• Worn guides	• Check guides arms and rollers
• Bad set up creates cracks	• Change blade and check guide arms



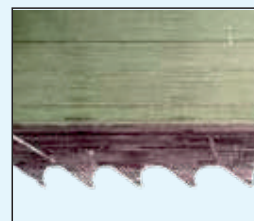
Problem Cause	Solutions
7 - Wear on the Two Sides of the Teeth	
• Incorrect set up of the blade	• Adjust guides rams width
• Teeth rubbing on the guides arms	• Adjust guides rams width
• Guide arms are too wide for the blade	• See machine operator's manual for blade
• Insufficient blade tension	• Check blade tension
• Non homogeneous material	• Check work piece hardness
• Worn out guides	• Replace guide arms



8 - Wear On One Sides of the Teeth	
• Teeth are in contact with wheels due to a rollers wear	• Check wheels surface
• Incorrect guides position	• Check guides
• The blade is twisted when cutting hard material	• Non correct blade
• The blade is rubbing on the machine	• Check blade position



9 - Blade Wear	
• Work badly cooled or/and incorrect lubricant or not lubricant	• Check lubricant and nozzles position
• Cutting speed too high	• Check cutting parameters
• Incorrect feed	• Check cutting parameters
• The blade has cut running backwards	



10 - Tooth Gullet Overloaded	
• Too fine pitch	• Select a new blade
• Too high feed	• Decrease feed
• Incorrect feed	• Check cutting parameters
• No brush or worn cut	• Check the brush and position
• Incorrect lubricant or no lubricant	



11 - Wear On Each Side of the Blade	
• Worn guides or chips between guides and blades	• Check guides and nozzles position
• Tips of the guides are too tightened	• Check the free movement of the blade
• Lack of lubricant between guides and blade	• Check lubricant
• Incorrect lubricant or no lubricant	



12 - Uneven Wear and Spot on the Sides of the Blades	
• Damaged or missing guides	• Check guides and replace/adjust as necessary
• The blade is rubbing on part of the machine	• Check for free movement of the blade
• Chips jammed in the guides	• Clear the obstruction
• Incorrect lubricant or no lubricant	



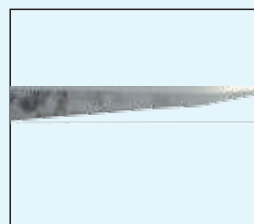
Problem Cause	Solutions
13 - Excess Wear to the Beach	
• Excessive feed	• Check cutting parameters
• Too much pressure	• Check cutting parameters, reduce pressure
• Blade badly positionned, rubbing on the wheels	• Check the wheels surface and the positioning
• Guide tips worn	• Check the tips



14 - Bowed Blade Towards Teeth	
• Excessive feed	• Check cutting conditions
• Guides too close to the work and rubbing near the teeth	• Check the blade for free movement
• Blade out of the guides	• Check the blade positioning
• Wheel bearings wear due to excessive blade tension	



15 - Bowed Blade Towards Back	
• Excessive feed	• Check cutting conditions
• Guide arms too tight, rubbing on the back	• Check the blade for free movement
• Guides too far apart compared to the piece	• Check the blade positioning
• Wheel bearings wear due to excessive blade tension	



16 - Twisted Blade	
• Excessive feed	• Check cutting conditions
• Guides too tight	• Check guides adjustments
• Work piece is loose	• Check the hydraulic vise
• No lubricant	• Check lubricant



17 - Bad Surface Finish	
• Worn out blade	• Replace the blade
• Feed and speed not correct	• Check cutting conditions
• Poor blade tension	• Check operator's manual for a correct tension
• No guides	• Check the guide
• Incorrect tooth select	



18 - Wandering Cuts-Going Off Line	
• Damage to the set of the teeth	• Check material hardness
• Over feeding	• Check cutting conditions, reduced feed force
• Insufficient blade tension	• Position arms as close to work as possible
• Guide set too far apart or not in line	• Check guides



Carbon Steels		Alloy Steels		Tool & Mold Steels	
Material	FPM	Material	FPM	Material	FPM
1008	320	150	250	A10	160
1015	320	1330	220	A2	180
1018	300	1345	210	A6	200
1020	320	4130	270	D2	90
1021	300	4140	250	H11	190
1022	300	4145	210	H12	190
1025	320	4340	220	H10	190
1026	300	5160	220	L6	190
1030	330	6150	210	M1	110
1035	310	8616	240	M42	100
1040	270	8620	240	O1	200
1042	250	8630	220	O6	190
1044	220	8640	200	P20	230
1045	220	9310	170	S1	200
1060	200	52100	160	S5	140
1095	180	300M	160	S7	120
1117	340	41L40	270	T1	100
1137	290	A242	280	T15	70
1141	280	e.t.d.	250	W1	220
1144	280	HP-9-4-20	100		
1213	380	HP 9-4-25	100		
1215	380	HY-100	160		
1513	300	HY-80	160		
1541	250				
A35	270				

Stainless Steels		Super Alloys	
Material	FPM	Material	FPM
230	150	A286	90
303	140	Astrology	60
304	120	Hastelloy	70
309	90	Incoloy 800	90
310	80	Incoloy 900	60
316	100	Inconel	60
324	100	Inconel 625	100
347	110	Monel	70
410	140	Nickel 200	80
414	110	Pyromet X15	120
416	190	Titanium	70
420	190	Waspalloy	70
430	150	WF11	60
431	90		
450	80		
502	140		
2205	80		
18-8-2	90		
22-13-5	60		
440C	80		
440F	160		
M225	90		
Nitronic 50	60		
Nitronic 60	60		
SS-PH	80		

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