

NACHI MOTHERSON
TOOL TECHNOLOGY LIMITED

Bi-Metal Band Saw Blades

a member of SAMVARDHANA MOTHERSON GROUP



Samvardhana Motherhood Group is one of the most diversified groups in the Indian auto ancillary industry with a continuously increasing global presence. Today the Group has more than 80 facilities in 21 countries across the globe.

The Group has a diversified product range to serve multiple industries, with automotive industry being the main industry served. The business portfolio comprises electrical distribution systems (wiring harnesses), automotive rearview mirrors, polymer processing, injection molding tools, elastomer processing, modules and systems, machined metal products, cutting tools, IT services, design engineering, CAE services, sunroofs, vehicle air conditioning systems, lighting systems, cabins for off-highway vehicles, cutting tools and tyre film coating plants.

The Group has invested in technologies that provide manufacturing support, including compressors, paint coating equipment, auxiliary equipment for injection molding machines, sales, installation and servicing of industrial robots and automotive manufacturing engineering services.

The Group offers total solutions - starting with designing from basic data to prototyping; to tooling, molding, assembly and finally production of integrated, fully engineered higher level modules. The Group has collaborated with global technology leaders and adopted backward integration in key areas.

NACHI MOTHERSON TOOL TECHNOLOGY LIMITED

Nachi Motherson Tool Technology Ltd. (NMTTL) a joint venture between Samvardhana Motherhood Group, India and Nachi Fujikoshi Corporation, Japan is located in Noida, India.

NMTTL is the first manufacturing facility Nachi has established in India, to manufacture Bimetal Band Saw Blades. Nachi Fujikoshi Corporation is a global major in manufacturing of Engineering Steels, Cutting Tools, Machine Tools, Precision Machineries, Robots, Bearings, Hydraulic Equipments, Seismic Isolation Systems, Coating & Industrial Furnaces etc.

“Introducing a blade suitable for materials ranging from aluminum to hard to cut steels. Full lineup of metal band saw blades from NACHI Motherhood handles your jobs from high-speed to high-quality cutting.”

Selection Chart

For Cut-off Machines					
Type					
Features		For Hard To Cut Materials	High Accuracy Cutting For Molds And SUS	High Speed Cutting For Molds And SUS	Difficult Cutting Materials/General Usage
Product Name		TORNADO FAX	TORNADO SWORD-MD	TORNADO SWORD-H	TORNADO SWORD
Tooth Material		FAX	FMX		
Wear Resistant		○	○	○	○
Chipping Resistant		○	○	○	○
Page		4	5	5	5
Structural Tubing	SS, SM, SN light gauge steels H.C.L. Section steels Thin pipe, Steel sheet	-	-	-	○
	SS, SM, SN Section steels H section steels Thick pipe	-	-	-	○
Solids	SS, SC, SM Structural steels			○	○
	SC Carbon steels	○	○	○	○
	SCr, SCM Alloy steels	○	○	○	○
	SKS, NAK Alloy tool steels	○	○	○	○
	Pre-hardened steels	○	○	○	○
	Mold steels High speed steels	○	○	○	○
	Stainless steels	○	○	○	○
	Heat resistant alloys	○	○	○	○
	Aluminum alloys Copper alloys Carbon			○	○

○ Best Suitable
○ Suitable

Selection Teeth

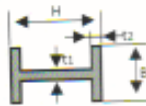
Solids

Size of Material mm	Pitch														
	(1.25)	(2)	(3)	(4)	5	6	8	10	12	14	16	18	20	22	24
~4															
~10															
~20															
~40															
~60															
~100															
~150															
~200															
~300															
~400															
~600															
~800															
800+															
Application Machines	For Cut Off Machine														
	For Rotary Machine														
	For Contour Machine														

Note: Bundle cutting, please select the size that one pitch is large when cutting length is equal to or less than 100mm (3.94inch).

Structurals, Tubing

• H section steels



• Light gauge steels



• Tube



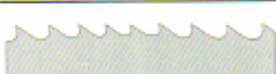
Size of Material	H	B	t1	t2	TPI
mm	300	150	6	9	5/7
mm	400	200	8	13	3/8
mm	500	250	10	16	3/4
mm	600	300	11	17	3/4
mm	700	350	13	24	3/4
mm	800	400	14	28	3/4, 3/8
mm	900	450	16	28	2/3

Size of Material	L	A	T	TPI
mm	60	20	1.5	14
mm	75	25	1.6	12
mm	100	30	2.0	8/12
mm	125	35	2.2	8/12
mm	150	40	2.2	8/12
mm	200	50	2.5	6/10
mm	250	60	2.5	6/10

Ø	t	TPI							
		20	40	60	80	120	160	200	240
mm	2	14	14	14	14	14	14	14	14
mm	4	14	14	14	14	14	14	14	14
mm	6	14	14	14	14	14	14	14	14
mm	8	14	14	14	14	14	14	14	14
mm	10	14	14	14	14	14	14	14	14
mm	12	14	14	14	14	14	14	14	14

Please select a TPI in such a way that at any time of cutting at least two teeth are engaged in the section.

Selection Tooth Form

Type	Tooth Form	Features
STD		Suitable for Alloy steels, Tubes, Structure and Solids.
H		For high-speed cutting with extra sharp teeth and larger gullet.
MD		For best surface finish. High & Low tooth form. Compound Depression tooth set.
K		To cut structures, Sections and tubes. Resulting Low noise & Low vibrations.

TORNADO G-FAX

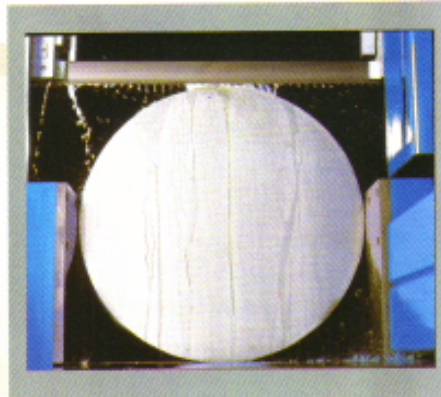
It shows long life when cutting hardened steel and structural and tubing having difficult machinability.



Unit: mm

Width	Thickness	TPI		
		2/3	3/4	4/5
27	0.95	▲	▲	▲
34	1.07	▲	▲	▲
41	1.3	▲	▲	
54	1.6	▲	▲	
67	1.6	▲		

▲ Ready stock
▲ Made on request



TORNADO SWORD

It is suitable for most applications. Structures, Tubes, Solids etc.



(Unit) : mm

Width	Thickness	TPI						
		1.6/2	2/3	3/4	4/6	5/7	6/10	8/12
27	0.95		▲	▲	▲	▲	▲	▲
34	1.07		▲	▲	▲	▲	▲	
41	1.3	▲	▲	▲	▲	▲	▲	
54	1.6	▲	▲	▲	▲	▲		
67	1.6	▲	▲					

TORNADO SWORD-MD

Offers minimal cutting resistance and best surface finish. Suitable for SS, Die Steel and Hard Steel.



(Unit) : mm

Width	Thickness	TPI			
		1.6/2	2/3	3/4	4/6
27	0.95		▲	▲	▲
34	1.07		▲	▲	▲
41	1.3		▲	▲	
54	1.6		▲	▲	
67	1.6	▲	▲		

TORNADO SWORD-H

For high speed cutting with sharper teeth and larger gullet.



(Unit) : mm

Width	Thickness	TPI			
		0.7/1	1.6/2	2/3	3/4
27	0.95			▲	▲
34	1.07			▲	▲
41	1.3			▲	▲
54	1.6			▲	▲
67	1.6	▲		▲	

TORNADO SWORD CNC P

For best cutting results in high speed cutting. Long tool life. Suitable for SS and Forging Steel.



(Unit) : mm

Width	Thickness	TPI			
		2/3	3/4	4/6	5/7
27	0.95	▲	▲	▲	▲
34	1.07	▲	▲	▲	
41	1.3	▲	▲	▲	▲



- ▲ Ready stock
- ▲ Made on request