new

CMT ORANGE TOOLS®

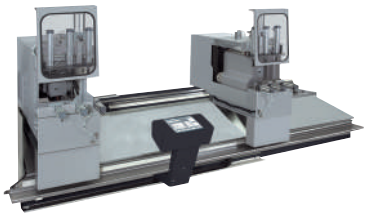
MATERIALS	COATING TYPE: CORROSION FREE VAPO HEAT TREATMENT	COATING TYPE: CORROSION FREE TiCN COATING
STEEL (<500 N/mm²)	★ ★	★ ★ ★ ★
STEEL (<800 N/mm²)	★ ★	★ ★ ★
STEEL (<1200 N/mm²)	★ ★	★ ★ ★
STAINLESS STEEL	★ ★	★ ★ ★ ★
CAST IRON	★ ★	★ ★ ★ ★
ALUMINIUM/ALLOY AL.	★ ★	★ ★ ★ ★
TITANIUM	★	★ ★
BRONZE	NOT RECOMMENDED	★ ★ ★ ★
COPPER	NOT RECOMMENDED	★ ★ ★
BRASS	NOT RECOMMENDED	★ ★ ★
TECHNICAL INFO	**VAPO**	**TiCN**
COLOR	BLACK	BROWN - RED
HARDNESS (HV)	800	3200
THICKNESS (µm)	2 - 4	2 - 4
COEFFICIENT OF FRICTION	0.6	0.2
MAX. WORKING TEMPERATURE	350°C	450°C

MATERIALS	V (m/min.) MIN. ~ MAX
STEEL (<500 N/mm²):	30 ~ 60
STEEL (<800 N/mm²):	25 ~ 40
STEEL (<1200 N/mm²):	15 ~ 30
STAINLESS STEEL:	15 ~ 30
CAST IRON:	25 ~ 50
ALUMINIUM/ALLOY AL.:	500 ~ 700
TITANIUM:	15 ~ 20
BRONZE:	200 ~ 300
COPPER:	200 ~ 400
BRASS:	400 ~ 600

SUGGESTED SPEED (BW - C/HZ)

$$RPM = \frac{1000 \times V\ (m/min.)}{3{,}14 \times D\ (mm)}$$

MANUAL,
SEMI-AUTOMATIC
& AUTOMATIC MACHINES



Suggested use with
Emulsion/Spray Oil

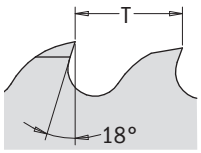
Metal & Steel

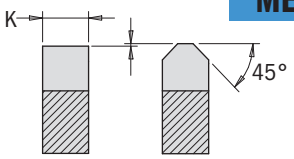
HSS
HIGH SPEED STEEL
DMo5

227 HSS LINE

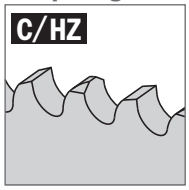
HSS

METAL & STEEL





Sharpening



Applications

SOLID PROFILE/SECTIONS
& THICK PIPES/TUBES

D mm	B mm	PIN HOLE	Z	K mm	PITCH T	β	COATING	ORDER NO.
250	32	2/8/45+2/9/50+2/11/63	128	2,0	T6	C/HZ	VAPO	**227.250.128P**
275	32	2/8/45+2/9/50+2/11/63	140	2,5	T6	C/HZ	VAPO	**227.275.140P**
300	32	2/8/45+2/9/50+2/11/63	160	2,5	T6	C/HZ	VAPO	**227.300.160P**
315	32	2/8/45+2/9/50+2/11/63	160	2,5	T6	C/HZ	VAPO	**227.315.160P**
350	32	2/8/45+2/9/50+2/11/63	180	2,5	T6	C/HZ	VAPO	**227.350.180P**

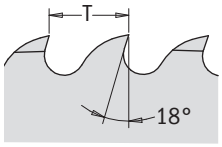
new

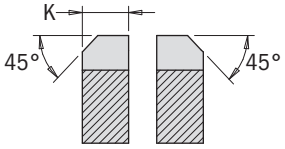
CMT ORANGE TOOLS®

227 HSS LINE

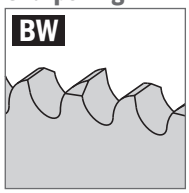
HSS

METAL & STEEL





Sharpening



Applications

D mm	B mm	PIN HOLE	Z	K mm	PITCH T	β	COATING VAPO	ORDER NO.
200	32	2/8/45+2/9/50+2/11/63	160	1,8	T4	BW	VAPO	**227.200.160P**
225	32	2/8/45+2/9/50+2/11/63	180	1,9	T4	BW	VAPO	**227.225.180P**
250	32	2/8/45+2/9/50+2/11/63	160	2,0	T5	BW	VAPO	**227.250.160P**
250	32	2/8/45+2/9/50+2/11/63	200	2,0	T4	BW	VAPO	**227.250.200P**
275	32	2/8/45+2/9/50+2/11/63	220	2,5	T4	BW	VAPO	**227.275.220P**
300	32	2/8/45+2/9/50+2/11/63	220	2,5	T4	BW	VAPO	**227.300.220P**
315	32	2/8/45+2/9/50+2/11/63	240	2,5	T4	BW	VAPO	**227.315.240P**
350	32	2/8/45+2/9/50+2/11/63	280	2,5	T4	BW	VAPO	**227.350.280P**

D mm	B mm	PIN HOLE	Z	K mm	PITCH T	β	COATING TiCN	ORDER NO.
250	32	2/8/45+2/9/50+2/11/63	200	2,0	T4	BW	TiCN	**227.250.700P**
275	32	2/8/45+2/9/50+2/11/63	220	2,0	T4	BW	TiCN	**227.275.722P**
275	32	2/8/45+2/9/50+2/11/63	220	2,5	T4	BW	TiCN	**227.275.720P**
300	32	2/8/45+2/9/50+2/11/63	220	2,0	T4	BW	TiCN	**227.300.722P**
300	32	2/8/45+2/9/50+2/11/63	220	2,5	T4	BW	TiCN	**227.300.720P**
315	32	2/8/45+2/9/50+2/11/63	240	2,5	T4	BW	TiCN	**227.315.740P**
350	32	2/8/45+2/9/50+2/11/63	280	2,5	T4	BW	TiCN	**227.350.780P**

HSS
HIGH SPEED STEEL
DMo5

227 HSS LINE

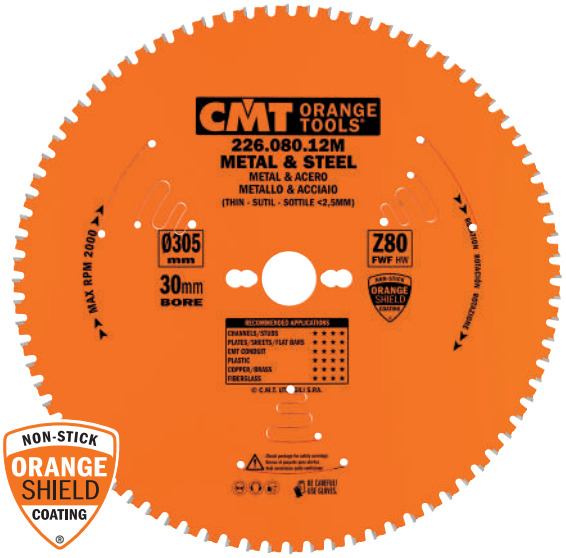
HSS

METAL & STEEL

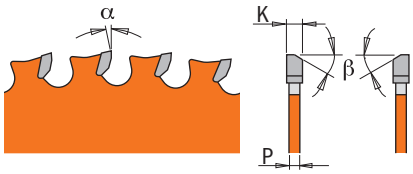
D mm	B mm	PIN HOLE	Z	K mm		β	COATING VAPO	ORDER NO.
200	32	2/8/45+2/9/50+2/11/63	0	1,8		Not Sharpened	VAPO	**227.200P**
225	32	2/8/45+2/9/50+2/11/63	0	1,9		Not Sharpened	VAPO	**227.225P**
250	32	2/8/45+2/9/50+2/11/63	0	2,0		Not Sharpened	VAPO	**227.250P**
275	32	2/8/45+2/9/50+2/11/63	0	2,5		Not Sharpened	VAPO	**227.275P**
300	32	2/8/45+2/9/50+2/11/63	0	2,5		Not Sharpened	VAPO	**227.300P**
315	32	2/8/45+2/9/50+2/11/63	0	2,5		Not Sharpened	VAPO	**227.315P**
350	32	2/8/45+2/9/50+2/11/63	0	2,5		Not Sharpened	VAPO	**227.350P**

new

CMT ORANGE TOOLS®



226 INDUSTRIAL



HW

PERFORMANCE

METAL & STEEL

Machines


CIRCULAR SAW


MITRE & CHOP MITRE SAW

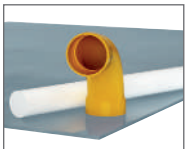
Blade diameter compatibility is contingent on machine type.

Materials

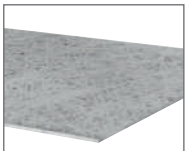

CHANNELS/STUDS/ANGLES


PLATES/SHEETS/FLAT BARS


EMT CONDUIT


PLASTIC


COPPER/BRASS

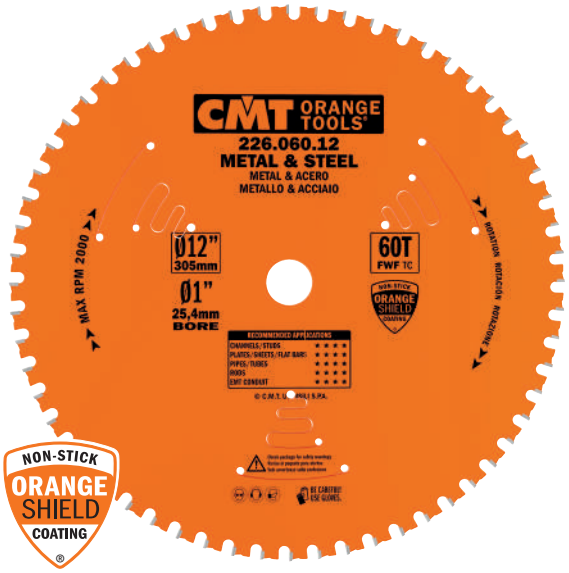

FIBERGLASS

D mm	B mm	PIN HOLE	Z	K mm	P mm	α	β	MAX RPM		ORDER NO.
136	20 (+10)	-	56	1,5	1,2	0°	8° FWF	6000	10	**226.136.56H**
150	20	-	60	1,6	1,2	0°	8° FWF	6000	10	**226.150.60H**
160	20 (+16)	2/6/32	60	2,0	1,6	0°	8° FWF	6000	10	**226.160.60H** ●
165	20	2/6/32	60	1,6	1,2	0°	8° FWF	6000	10	**226.165.60H**
184	30 (+16+20)	2/7/42	64	2,0	1,6	0°	8° FWF	6000	10	**226.184.64M**
190	30 (+20)	2/7/42	64	2,0	1,6	0°	8° FWF	6000	10	**226.190.64M**
210	30	2/7/42	64	2,2	1,8	0°	8° FWF	4500	10	**226.210.64M** ●
216	30	2/7/42	64	2,2	1,8	0°	8° FWF	3500	10	**226.216.64M** ●
254	15,87	-	60	2,2	1,8	0°	8° FWF	3000	5	**226.060.10**
254	30	COMBI3	60	2,2	1,8	0°	8° FWF	3000	5	**226.060.10M**
305	25,4	-	80	2,2	1,8	0°	8° FWF	2000	5	**226.080.12**
305	30	COMBI3	80	2,2	1,8	0°	8° FWF	2000	5	**226.080.12M**
355	25,4	-	90	2,2	1,8	0°	8° FWF	2000	5	**226.090.14**
355	30	COMBI3	90	2,2	1,8	0°	8° FWF	2000	5	**226.090.14M**

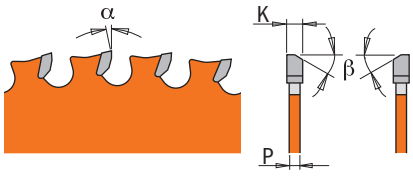
● Ideal for FESTOOL®

new

CMT ORANGE TOOLS®



226 INDUSTRIAL



HW

PERFORMANCE

METAL & STEEL

Machines


CIRCULAR SAW


MITRE & CHOP MITRE SAW

Blade diameter compatibility is contingent on machine type.

Materials


CHANNELS/STUDS/ANGLES


PLATES/SHEETS/FLAT BARS


PIPES/TUBES


RODS


EMT CONDUIT

D mm	B mm	PIN HOLE	Z	K mm	P mm	α	β	MAX RPM		ORDER NO.
136	10	-	30	1,5	1,2	0°	8° FWF	6000	10	**226.030.05**
136	20	-	30	1,5	1,2	0°	8° FWF	6000	10	**226.030.05H**
150	20	-	32	1,6	1,2	0°	8° FWF	6000	10	**226.032.06H**
160	20	2/6/32	30	2,0	1,6	0°	8° FWF	6000	10	**226.030.06H** ●
165	15,87	-	36	1,6	1,2	0°	8° FWF	6000	10	**226.036.06**
165	20	2/6/32	36	1,6	1,2	0°	8° FWF	6000	10	**226.036.06H**
165	30	2/7/42	36	1,6	1,2	0°	8° FWF	6000	10	**226.036.06M**
184	15,87	-	48	2,0	1,6	0°	8° FWF	6000	10	**226.048.07**
190	30	2/7/42	40	2,0	1,6	0°	8° FWF	6000	10	**226.040.07M**
203	15,87	-	48	2,2	1,8	0°	8° FWF	4500	10	**226.048.08**
210	30	2/7/42	48	2,2	1,8	0°	8° FWF	4500	10	**226.048.08M** ●
216	30	2/7/42	48	2,2	1,8	0°	8° FWF	3500	10	**226.047.09M** ●
235	30	2/7/42	48	2,2	1,8	0°	8° FWF	3500	10	**226.048.09M**
254	15,87	-	48	2,2	1,8	0°	8° FWF	3000	5	**226.048.10**
305	25,4	-	60	2,2	1,8	0°	8° FWF	2000	5	**226.060.12**
355	25,4	-	72	2,2	1,8	0°	8° FWF	2000	5	**226.072.14**

● **Ideal for FESTOOL®**

new

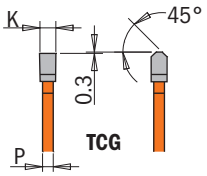
CMT ORANGE TOOLS®

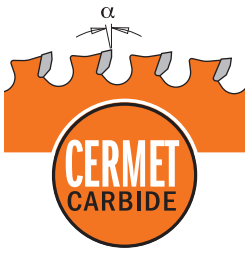
226 INDUSTRIAL

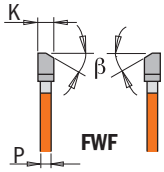
HW LONG LIFE

PERFORMANCE

METAL & STEEL







Machines


CIRCULAR SAW


MITRE & CHOP MITRE SAW

Blade diameter compatibility is contingent on machine type.

Materials


CHANNELS/STUDS/ANGLES


PLATES/SHEETS/FLAT BARS


PIPES/TUBES


RODS


EMT CONDUIT

Suggested for Stainless steel of common use, such as 302, 303 and 304.
With higher degrees of hardness, performance is not guaranteed (e.g. 316)

D mm	B mm	PIN HOLE	Z	K mm	P mm	α	β	MAX RPM		ORDER NO.
160	20	2/6/32	40	1,8	1,4	0°	TCG	6000	10	**226.540.06H** ●
184	15,87	-	48	2,0	1,6	0°	TCG	6000	10	**226.548.07**
190	30	2/7/42	48	1,8	1,4	0°	TCG	6000	10	**226.548.07M**
216	30	2/7/42	56	1,8	1,4	0°	TCG	3500	10	**226.556.09M** ●
250	30	COMBI3	72	2,2	1,8	0°	10° FWF	3000	5	**226.572.10M**
254	15,87	-	72	2,2	1,8	0°	10° FWF	3000	5	**226.572.10**
300	30	COMBI3	80	2,2	1,8	0°	10° FWF	2000	5	**226.580.12M**
305	25,4	-	80	2,2	1,8	0°	10° FWF	2000	5	**226.580.12**
355	25,4	-	90	2,2	1,8	0°	10° FWF	2000	5	**226.590.14**
355	30	COMBI3	90	2,2	1,8	0°	10° FWF	2000	5	**226.590.14M**

● Ideal for FESTOOL®