



Depuis 1933

French manufacturer,
Designer of cutting tools

SLITTING SAWS & CIRCULAR KNIVES FOR INDUSTRIAL CUTTING

Since 1933, Caleyron Industries has been designing high-precision cutting solutions for the most demanding industries.

**SHARPENING OF CIRCULAR SAW
BLADES**

**COATINGS AND SURFACE
TREATMENTS**

**SOLID CARBIDE CIRCULAR SAW
BLADES**

CIRCULAR SAW BLADES HSS/HSS-E

CUT-OFF CIRCULAR SAW BLADES

**CARBIDE-TIPPED CIRCULAR SAW
BLADES**

SPECIAL CIRCULAR SAW BLADES

CIRCULAR KNIVES

SOLID CARBIDE
CIRCULAR SAW
BLADES



Caleyron Industries manufactures a wide range of **carbide** circular saw blades, similar to **DIN standards**, from **Ø 20 to Ø 300 mm** and thicknesses **from 0.2 to 6 mm**.




A - Fine-toothed




AW - Alternating beveled teeth

One tooth beveled to the left, one tooth beveled to the right



B - Coarse-toothed



BW - Alternating beveled teeth

One tooth beveled to the left, one tooth beveled to the right



C - Alternating beveled teeth

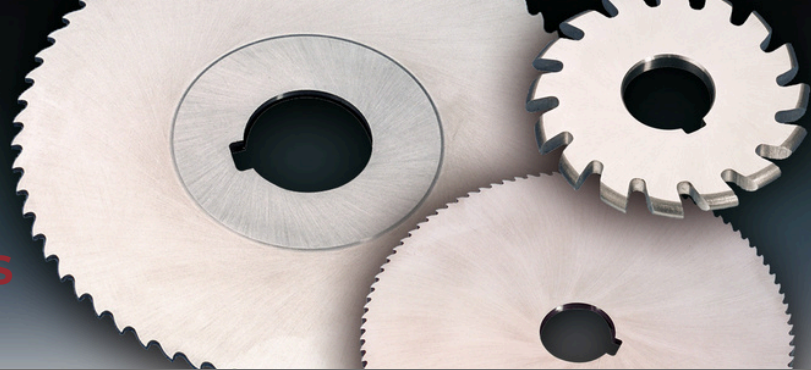
One tooth beveled to the left, one tooth beveled to the right

Depending on your requirements, we can produce teeth with **customised dimensions** (non-standard)

Thickness		0.2	0.25	0.3	0.4	0.5	0.6	0.8	1	1.2	1.6	2	2.5	3	4	5	6
Diam.	Bore	Number of teeth															
DIN 1837																	
15	5	64	64	64	64	48	48	40	40	40	40	40	40	40	24	24	24
20	5	80	64	64	64	48	48	48	40	40	40	32	32	32	24	24	24
25	8	80	80	80	64	64	64	48	48	48	40	40	40	32	32	32	24
30	8	100	100	80	80	80	64	64	64	48	48	48	40	40	40	32	32
40	10	128	128	100	100	80	80	80	64	64	64	48	48	48	40	40	40
50	13	128	128	128	100	100	100	80	80	80	64	64	64	48	48	48	40
63	16		160	128	128	128	100	100	100	80	80	80	64	64	64	48	48
80	22			160	160	128	128	128	100	100	100	80	80	80	64	64	64
100	22					160	160	128	128	128	100	100	100	80	80	80	64
125	22							160	160	128	128	128	100	100	100	80	80
150	32								150	150	150	128	128	128	128		
160	32								160	160	160	128	128	128	128		
200	32										160	160	160	128	128		

Thickness		0.2	0.25	0.3	0.4	0.5	0.6	0.8	1	1.2	1.6	2	2.5	3	4	5	6
Diam.	Bore	Number of teeth															
DIN 1838																	
15	5	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
20	5	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
25	8	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
30	8	30	30	30	30	30	30	24	24	24	24	24	24	24	24	24	24
40	10	40	40	40	40	40	40	32	32	32	32	24	24	24	20	20	20
50	13				48	48	48	40	40	40	32	32	32	24	24	24	20
63	16				64	64	64	48	48	40	40	40	32	32	32	24	24
80	22					64	64	64	48	48	48	40	40	40	32	32	32
100	22					80	80	64	64	64	48	48	48	40	40	40	32
125	22						80	80	80	64	64	64	48	48	48	40	40
150	32							80	80	80	64	64	64	64	64		
160	32							80	80	80	64	64	64	64	64		
200	32										80	80	80	64	64		

HSS & HSS-E CIRCULAR SAW BLADES



Caleyron Industries manufactures a wide range of **high speed steel** circular saw blades according to DIN standard, from **Ø 20 to Ø 600 mm** with thicknesses ranging from **0.2 to 6 mm**, for cold cutting technology.



A - Fine-toothed



AW - Alternating beveled teeth

One tooth beveled to the left, one tooth beveled to the right



B - Coarse-toothed



BW - Alternating beveled teeth

One tooth beveled to the left, one tooth beveled to the right



C - Alternating beveled teeth

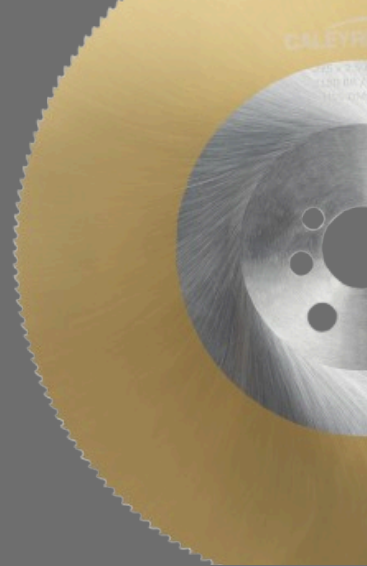
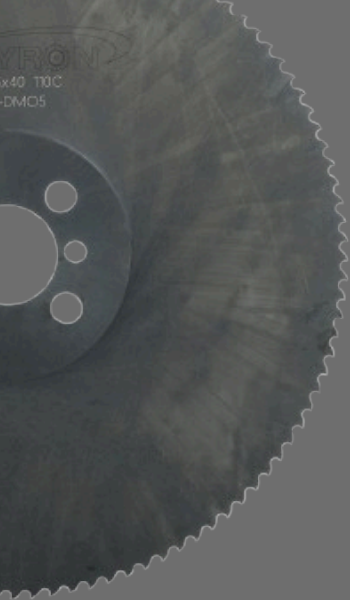
One tooth beveled to the left, one tooth beveled to the right

Made of **high-speed steel M2** or enriched with **5% cobalt (M35)** for excellent heat resistance and superior durability. They are ideal for difficult-to-machine materials such as:

- Stainless steel (INOX),
- Inconel, hard steels.

Thickness		0.2	0.25	0.3	0.4	0.5	0.6	0.8	1	1.2	1.6	2	2.5	3	4	5	6
Diam.	Bore	Number of teeth															
20	5	80	64	64	64	48	48	48	40	40	40	32	32	32	24	24	24
25	8	80	80	80	64	64	64	48	48	48	40	40	40	32	32	32	24
32	8	100	100	80	80	80	64	64	64	48	48	48	40	40	40	32	32
40	10	128	128	100	100	80	80	80	64	64	64	48	48	48	40	40	40
50	13	128	128	128	100	100	100	80	80	80	64	64	64	48	48	48	40
63	16		160	128	128	128	100	100	100	80	80	80	64	64	64	48	48
80	22			160	128	128	128	128	100	100	100	80	80	80	64	64	64
100	22					160	160	128	128	128	100	100	100	80	80	80	64
125	22						160	160	160	128	128	128	100	100	100	80	80
150	32								160	160	160	128	128	128	128	100	100
160	32								160	160	160	128	128	128	128	100	100
200	32								200	200	160	160	160	128	128	128	100
250	32										200	200	160	160	160	128	128
315	32												200	200	160	160	160

Thickness		0.2	0.25	0.3	0.4	0.5	0.6	0.8	1	1.2	1.6	2	2.5	3	4	5	6
Diam.	Bore	Number of teeth															
20	5					24	24	24	20	20	20						
25	8					32	32	24	24	24	20	20	20				
32	8					30	30	20	20	20	20	20	20	20	20	20	20
40	10					40	40	40	32	32	32	24	24	24	20	20	20
50	13					48	48	40	40	40	32	32	32	24	24	24	20
63	16					64	48	48	48	40	40	40	32	32	32	24	24
80	22					64	64	64	48	48	48	40	40	32	32	32	32
100	22					80	80	64	64	64	48	48	48	40	40	40	32
125	22						80	80	80	64	64	64	48	48	48	40	40
150	32								80	80	80	64	64	64	64	48	48
160	32								80	80	80	64	64	64	48	48	48
200	32								100	100	80	160	80	64	64	64	48
250	32										100	100	80	80	80	64	64
315	32												100	100	80	80	80



CUT-OFF CIRCULAR SAW BLADES HSS & HSS-E

Caleyron Industries manufactures a wide range of cut-off circular saw blades, in **HSS** and **HSS-E M35** from Ø 175 to Ø 700 mm.



BW - Tooth profile with alternating chamfers

A left chamfered tooth, a right chamfered tooth.



C - Tooth profile with alternating chamfers

A high chamfered tooth on both sides and a low non-chamfered tooth.

Ø	Thickness	Bore	HUB	Number and shape of the teeth											
				T3	T4	T5	T6	T7	T8	T10	T12	T14	T16		
175	1,2	32	75	180 BW	140 BW	100 C	90 C	80 C	70 C						
	1,5	32	76	180 BW	140 BW	100 C	90 C		70 C						
	2	32	77	180 BW	140 BW	100 C		80 C	80 C						
200	1,8	32	90	200 BW	160 BW	120 C	100 C		80 C						
	2	32	91	200 BW	160 BW	120 C	100 C		80 C						
225	1,2	32	100	220 BW	180 BW	140 C	120 C		90 C						
	1,5/1,6	32	90	220 BW	180 BW	140 C	120 C		90 C						
	2	32	90	220 BW	180 BW	140 C	120 C		90 C						
250	1	32	100	240 BW	200 BW	160 C	128 C	110 C	100 C	80 C					
	1,2	32	100	240 BW	200 BW	160 C	128 C	110 C		80 C					
	1,5/1,6	32/40	100	240 BW	200 BW	160 C	128 C	110 C	100 C	80 C					
	2	32/40	100	240 BW	200 BW	160 C	128 C		100 C	80 C					
	2,5	32/40	100	240 BW	200 BW	160 C	128 C	110 C	100 C	80 C					
275	1,2	32	100	280 BW	220 BW	180 C	140 C	120 C	110 C	90 C					
	1,6	32	100	280 BW	220 BW	180 C	140 C	120 C	110 C	90 C					
	2	32/40	100	280 BW	220 BW	180 C	140 C	120 C	110 C	90 C					
	2,5	32/40	100	280 BW	220 BW		140 C	120 C	110 C	90 C					
	3	32/40	100	280 BW	220 BW	180 C	140 C		110 C	90 C					
300	1,6	32	100	300 BW	220 BW	180 C	160 C		120 C	90 C					
	2	32/40	100	300 BW	220 BW	180 C	160 C		120 C	90 C					
	2,5	32/40	100	300 BW	220 BW	180 C	160 C		120 C	90 C					
	3	32/40	100	300 BW	220 BW	180 C	160 C		120 C	90 C					
315	1,6	32	100	320 BW	240 BW	200 C	160C		120 C	100 C	80 C				
	2	32/40	100	320 BW	240 BW	200 C	160C		120 C	100 C	80 C				
	2,5	32/40	100	320 BW	240 BW		160C		120 C	100 C	80 C				
	3	32/40	100	320 BW	240 BW	200 C	160C		120 C	100 C	80 C				

CUT-OFF CIRCULAR SAW BLADES
HSS & HSS-E

325	2.5	32/40	120	320 BW	250 BW	200 C	170 C	128 C	100 C			
	3	32/40	120	320 BW	250 BW	200 C	170 C	128 C	100 C			
350	1.8	32/40	120	350 BW	280 BW	220 C	180 C	160 C	140 C	110 C	90 C	
	2	32/40	120	350 BW	280 BW	220 C	180 C	160 C	140 C	110 C	90 C	
	2.5	32/40/50		350 BW	280 BW	220 C	180 C	160 C	140 C	110 C	90 C	
	3	32/40/50	120	350 BW	280 BW	220 C	180 C	160 C	140 C	110 C	90 C	
370	2	32/40/50	120	380 BW	280 BW	220 C	190 C	160 C	140 C	110 C	100 C	
	2.5	32/40/50	120	380 BW	280 BW	220 C	190 C	160 C	140 C	110 C	100 C	
	3	32/40/50		380 BW	280 BW	220 C	190 C	160 C		110 C	100 C	
400	2	32/40/50	120		310 BW	250 C	200 C	160 C	120 C	100 C		
	2.5		120		310 BW	250 C	200 C	160 C	120 C	100 C		
	3	32/40/50	120		310 BW	250 C	200 C	160 C	120 C	100 C		
	3.5	40/50	120		310 BW	250 C	200 C	160 C	120 C	100 C		
	4	40/50	120		310 BW	250 C	200 C	160 C	120 C	100 C		
425	2.5	40/50	120		320 BW	260 C	220 C	160 C	130 C	100 C		
	3	40/50	120		320 BW	260 C	220 C	160 C	130 C	100 C		
	3.5	40/50	120		320 BW	260 C	220 C	160 C	130 C	100 C		
	4	40/50	120		320 BW	260 C	220 C	160 C	130 C	100 C		
450	2.5	40/50	130		350 BW350 BW	280 C	230 C	180 C	140 C	120 C	90 C	
	3	40/50	130		350 BW	280 C	230 C	180 180 CC	140 C	120 C	90 C	
	3.5	40/50	130		350 BW	280 C	2230 C30 C	180 C	140 C	120 C	90 C	
	4	40/50	130		350 BW	280 C	230 C	180 C	140 C	120 C	90 C	
500	3	40/50	130		390 BW	310 C	260 C	200 C	160 C			
	3.5	40/50	130		390 BW	310 C	260 C	200 C	160 C			
	4	40/50	130		390 BW	310 C	260 C	200 C	160 C			
525	3.5	50	140		410 BW	330 C	270 C	210 C	164 C			
	4	50	140		410 BW	330 C	270 C	210 C	164 C			
550	3.5	50/90/140	200/225			340 C	280 C	250 C	220 C	170 C	140 C	120 C
	4	50/90/140	200/225			340 C	280 C		220 C	170 C	140 C	120 C
570	3.5	50	180			360 C	300 C	220 C	180 C			
	4	50	180				300 C	220 C	190 C			
600	3.5	50/90/140	200/225			380 C	320 C	240 C	190 C	160 C	130 C	
	4	50/90/140	200/225			380 C	320 C	240 C	190 C	160 C	130 C	
625	4	50/90/140	200/225			390 C	320 C	280 C	240 C	190 C	160 C	140 C
650	4	80	225				340 C	250 C	200 C	170 C	150 C	
700	4	80	225				360 C	260 C	200 C	180 C	160 C	

Cut-off saw blades are commonly used in industries where cutting precision and speed are critical.

Machinery and Equipment Manufacturing:

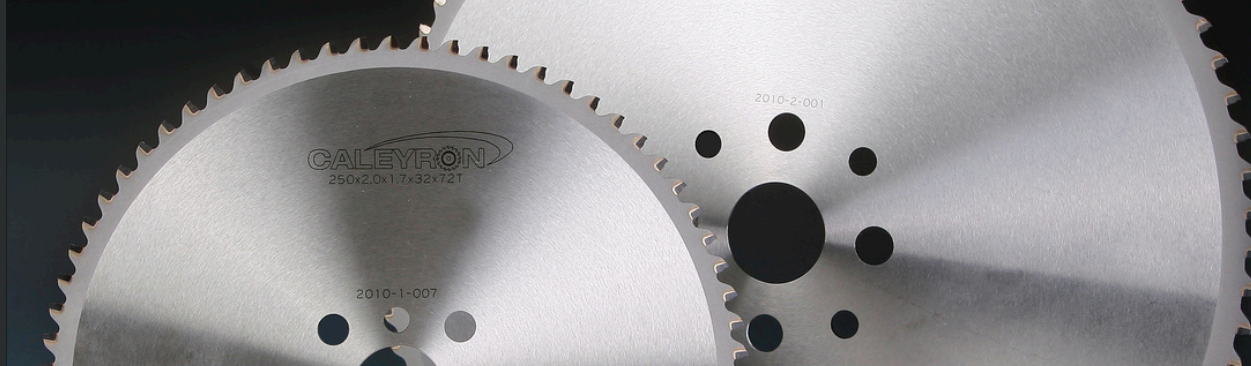
Cutting various metals (steel, aluminum, copper), metal profiles, tubes, bars...

They are also essential in production lines where metals and hard materials are processed into specific parts or components.

- **Non-ferrous metals** such as copper, brass, and aluminum
- **Steel and Stainless Steel:** Designed for cutting hard steels

Our cut-off blades can be customized in terms of diameter, thickness, and coating to perfectly match the requirements of each application.

TCT & CERMET



Caleyron Industries offers a complete range of **TCT saw blades in carbide and cermet**, suitable for all applications, with diameters ranging from **250 to 700 mm**.

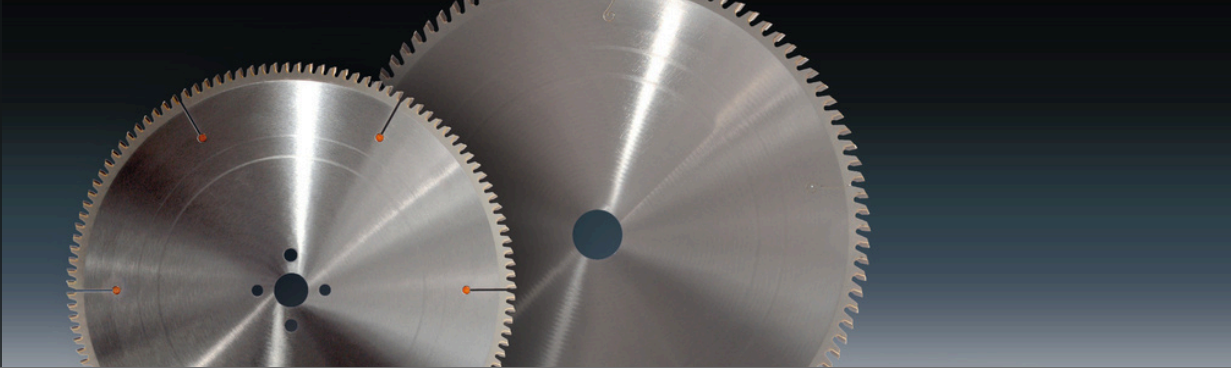


Blade Type	Materials Machined	Machines	Industries
TCT	Cutting medium to high carbon steel or stainless steel, in solid bars or thick-walled tubes	Amada, Tsune, Noritake, Nishijima, Kasto, Behringer-Eisele, Bewo, Exact-cut, Kaltenback, Sinico, Everising, Rattunde	Aéronautique, automobile, mécanique, nucléaire, etc.
Cermet	Cutting low to medium carbon steel, in solid bars or thick-walled tubes		

TCT and Cermet circular saw blades **for ferrous metals**

DIAMETER	THICKNESS	BORE	NUMBER OF TEETH	PINHOLES
mm				
250	2,0/1,75	32	54 / 60	4/9/1950
250	2,0/1,75	32	72 / 80	4/9/1950
250	2,0/1,75	40	54 / 60	4/11/1963
250	2,0/1,75	40	72 / 80	4/11/1963
285	2,0/1,75	32	54 / 60	4/9/1950
285	2,0/1,75	32	72 / 80	4/9/1950
285	2,0/1,75	40	54 / 60	4/11/1963
285	2,0/1,75	40	72 / 80	4/11/1963
315	2,3/2,0	32	54 / 60	4/9/1950
315	2,3/2,0	32	72 / 80	4/9/1950
315	2,3/2,0	40	54 / 60	4/9/1950
315	2,3/2,0	40	72 / 80	4/9/1950
360	2,6/2,25	40	60 / 72	4/11/1990
360	2,6/2,25	40	80 / 100	4/11/1990
360	2,6/2,25	50	60 / 72	4/16/80
360	2,6/2,25	50	80 / 100	4/16/80
425	2,6/2,25	40	60 / 72	4/11/1990
425	2,6/2,25	40	80 / 100	4/11/1990
425	2,6/2,25	50	60 / 72	4/16/80
425	2,6/2,25	50	80 / 100	4/16/80
460	2,6/2,25	40	40 / 50	4/11/1990
460	2,6/2,25	40	60 / 72	4/11/1990
460	2,6/2,25	50	40 / 50	4/16/80
460	2,6/2,25	50	60 / 72	4/16/80

CARBIDE-TIPPED CIRCULAR SAW BLADES



Blade Type	Matériaux usinés	Machines	Industries
Carbide-tipped circular saw blades	Light alloys, aluminum, zinc, copper, brass, bronze, cutting of tubes, window profiles, and solid materials		
Dry-cut blades (for dry steel cutting)	Steel, light alloys, plastics, PVC, Plexiglass, composite materials, fiberboard, insulating materials, multiplex panels, solid wood, laminated wood, particle boards, wood layers, wood with nails or metal clips, etc.	Bosch, Makita, Jepson, Hitachi	Construction, Automotive, Manufacturing, Aerospace, Woodworking, Metalworking ...

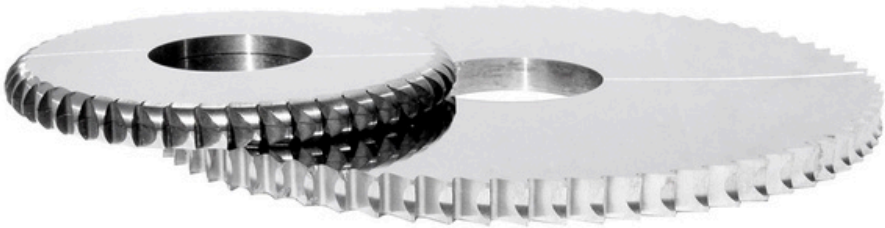
Carbide-tipped circular saw blades for non-ferrous metals

Positive cutting angle				
DIAMETER	THICKNESS	BORE	NUMBER OF TEETH	PINHOLES
mm				
250	3,2/2,6	30 / 40	60	2/9/55 + 4/12/64
300	3,2/2,6	30 / 40	96	2/9/55 + 4/12/64
350	3,2/2,6	30 / 40	84	2/9/55 + 4/12/64
400	3,8/3,2	30 / 40	96	4/12/64 + 2/12/80
400	3,8/3,2	40 / 50	96	4/12/64 + 2/12/80
450	4,4/3,8	30 / 40	96	4/12/64 + 2/12/80
450	4,4/3,8	30 / 40	108	4/12/64 + 2/12/80
500	4,2/3,8	30 / 40	120	4/12/64 + 2/12/80
Negative cutting angle				
250	3,2/2,6	30 / 40	60	2/9/55 + 4/12/64
300	3,2/2,6	30 / 40	72	2/9/55 + 4/12/64
300	3,2/2,6	30 / 40	96	2/9/55 + 4/12/64
350	3,2/2,6	30 / 40	84	2/9/55 + 4/12/64
350	3,2/2,6	30 / 40	108	2/9/55 + 4/12/64
400	3,8/3,2	30 / 40 / 50	96	4/12/64 + 2/12/80
450	4,4/3,8	30 / 40	108	4/12/64 + 2/12/80
500	4,4/3,8	30 / 40	120	4/12/64 + 2/12/80

Carbide, extremely hard and wear-resistant material, gives the blades exceptional hardness and rigidity, even at high temperatures, making it ideal for cutting high-alloy steels.

Cermet, hybrid material composed of ceramics, silicon carbide, and high-performance metals (such as chromium, cobalt, titanium, etc.), stands out for its extreme hardness and resistance to high temperatures. It provides a flawless finish, long service life, and optimal efficiency for intensive machining operations.

**SPECIAL
CIRCULAR SAW
BLADES**



TYPE OF SPECIAL CIRCULAR SAWS

SPECIFICATIONS

Alternate tooth bevel (ATB)

Conical (30°, 45°, 60°)

Triple chip grind (TCG)

Isosceles tooth profile

Half-round convex

Half-round concave

Helical tooth profile

Surfacing, contouring, grooving,
deburring

Chamfering, turning,
countersinking

Fine cutting and precision
machining

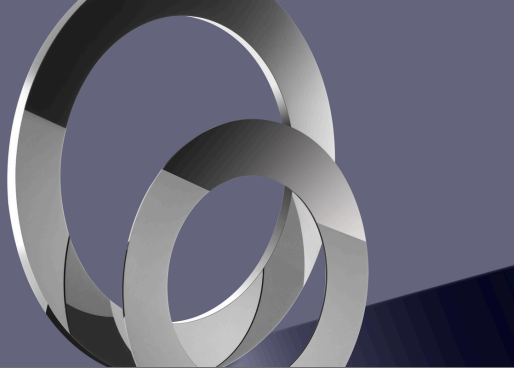
Chamfering, V-grooving, finishing
angular surfaces, weld
preparation

Rounding, surface finishing,
deburring, molding

Rounding, surface finishing,
deburring, molding





Grooving

CIRCULAR
KNIVES



Caleyron Industries manufacture a wide range of **circular knives** in **HSS M2**, **HSS-E M35**, and **solid carbide**.

The circular knives are made with a **single bevel** (1) or a **double bevel** (2), and in some cases with a **pre-bevel** (3-4).

Form	Machined Materials	Material
	Foam	
	Leather	
	Food-grade	
	Cardboard and plastic tubes	HSS M2
	Corrugated cardboard	
	Glass	
	Pneumatic tubes	HSS-E M 35
	Aluminium foil	
	Adhesive rolls	
	Paper tissues	
	Bandages	CARBURE
	Cardboard tubes	
	Toilet paper	
	Rubber profiles	
	Polypropylene film	

SHARPENING OF CIRCULAR SAW BLADES AND CIRCULAR KNIVES



What types of blades can we sharpen?

- HSS/HSS-E circular saw blades
- Solid carbide circular saw blades
- Cut-off circular saw blades
- Carbide-tipped circular saw blades
- Half-round convex/concave circular saw blades
- Isosceles tooth profile circular saw blades
- Alternate tooth bevel (ATB) circular saw blades
- Radius circular saw blades
- Conical circular saw blades
- Circular knives



Thorough Inspection

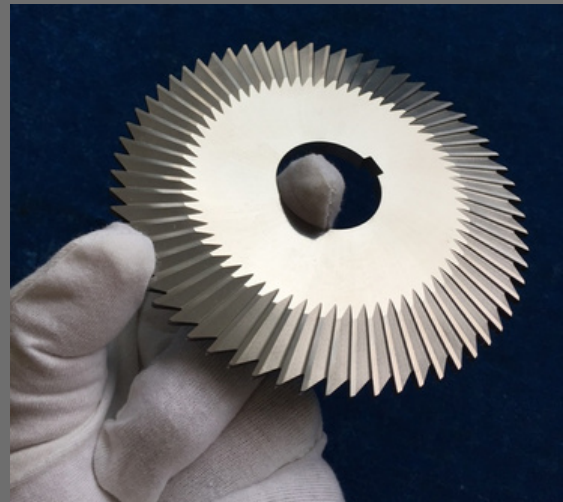
Our team performs a meticulous inspection of circular saw blades and circular knives. This evaluation aims to detect any irregularities, roughness, or deformation, while ensuring that these tools are suitable for the sharpening process.

Wear Correction

Any wear and alterations detected are rectified using a highly precise sharpening machine. This step is crucial to restore the geometry and sharpness of the blades.

Tooth Restoration

The restoration of the teeth on circular saw blades and circular knives is carried out with extreme precision. This ensures their efficiency and longevity. We make sure that each tooth is perfectly sharpened. This phase undergoes rigorous quality checks to maintain high standards.



Sharpening your saw blades and circular knives regularly is essential to maintain their optimal performance and extend their lifespan.

1. Loss of cutting efficiency;
2. Poor surface finish on the machined part;
3. Your tools cause burns on the material you're cutting or generate chips;
4. Regular use of your saw blades and circular knives.

CUTTING TOOLS COATINGS AND SURFACE TREATMENTS



Performance, durability and quality : the coating makes the difference

Quality improvement

- Improved surface quality
- Compliance with dimensional tolerances
- Reduced production scrap

Productivity improvement

- Optimized cutting conditions
- Possibility of high-speed machining
- Dry machining for certain applications
- Reduced heat build-up and material adhesion to the tool

Increased tool life

Reduced tool changes, machine downtime and tool inventories.

Solution	Material	Coating	Advantages
GOLD	Steel	TiN	Versatile, wear-resistant, reduces abrasion and adhesive wear in various applications
PERFORM	Steel	AlCrN	<ul style="list-style-type: none">• Superior wear resistance and increased hardness• Enhanced performance with improved toughness Better coating adhesion due to reduced internal compressive stresses <ul style="list-style-type: none">• Reduced crater wear on HSS tools due to lower thermal conductivity• More resharpening cycles per tool
VOLCAN	Stainless Steel	TiAlN	<ul style="list-style-type: none">• Suitable for tough conditions• Highly resistant to crater wear and oxidation• Ideal for both lubricated and dry machining
COBRA	Titanium	AlTiSiN	<ul style="list-style-type: none">• Revolutionary smooth coating, no post-treatment (polishing) required• Exceptional wear and oxidation resistance• Resists thermal stress• Superior results in hard machining• Maximum tool precision
SUPRA	Cast Iron	AlCrN	<ul style="list-style-type: none">• Optimal layer adhesion• High stability under thermal shocks• Perfect for heavily stressed cutting edges
RAINBOW	Copper / Brass / Bronze / Silica-charged Aluminum (6 to 12%)	ta-C	<ul style="list-style-type: none">• Ultra-thin coating maintains sharp cutting edges• Superior smoothness prevents material adhesion• Extreme hardness for increased wear resistance



SPIRIT OF QUALITY SINCE 1933

For over 90 years, Caleyron Industries has been designing and manufacturing circular saw blades and circular knives to meet the needs of manufacturers in a wide variety of industries.

Thanks to close collaboration with our customers and a constant spirit of innovation, we have become a preferred partner for manufacturers worldwide.

Our strength lies in our ability to anticipate market needs and meet our customers' most demanding requirements, while maintaining a constant commitment to operational excellence.

Because your productivity depends on the precision and speed of your cutting operations, we work with you to design reliable, durable, tailor-made tools.



Made in **France**



Custom design

Tools tailored to your machining conditions and challenges



Quality certified
ISO 9001



A **family-owned business** with over **90 years'** experience



50% of our revenue is generated from international sales



A high-performance machinery park that meets your challenges and our standards