

— PRECISION MANUFACTURED SINCE 1976 · ISO 9001:2015

Metal Slitting Saws, Ground to Your Slot.

HSS, cobalt (M35) and powder-metal slitting saws for slotting, parting and narrow grooving. Burr-free, custom ground to your exact slot width and bore. Solid-carbide and carbide-tipped on request. Made in-house and shipped to 30+ countries.



IN-HOUSE GROUND & HARDENED

1976

MANUFACTURING SINCE

30+

COUNTRIES SERVED

±0.005 mm

SLOT-WIDTH CAPABILITY

ISO 9001

QUALITY CERTIFIED

— A TOOLING MAKER, NOT A RESELLER

Every saw designed, cut and ground in our own plant.

Maxwell Slitter Industries has manufactured precision slitting tools since 1976. We do not badge-sell imported blanks. Each saw is produced from certified stock and finished to your drawing at our ISO 9001:2015 facility in Rajpura, India, then shipped to customers in more than thirty countries. That control is why the tolerance, edge quality and repeatability hold from the first piece to a repeat order years later.

1976

MANUFACTURING SINCE

30+

COUNTRIES SERVED

**±0.005
mm**

SLOT-WIDTH CAPABILITY

ISO 9001

2015 CERTIFIED

— WHAT YOU GET WITH MAXWELL



In-house manufacturing

Billet, CNC turning, tooth milling, hardening and grinding, all under one roof in Rajpura.



Made to your drawing

Custom outside diameter, bore, keyway, thickness, tooth form and grade, to sample or print.



CMM-verified

Dimensions, bore and runout checked on CMM, with inspection reports supplied on request.



Burr-free cut quality

Correct tooth geometry and edge prep for clean slots, tight tolerance and long tool life.



Regrinding & relife

Worn saws resharpened to original geometry to extend tool life and lower cost per cut.



Built for export

Export-grade packaging, full documentation and flexible Incoterms for overseas shipment.

Made in-house in Rajpura since 1976

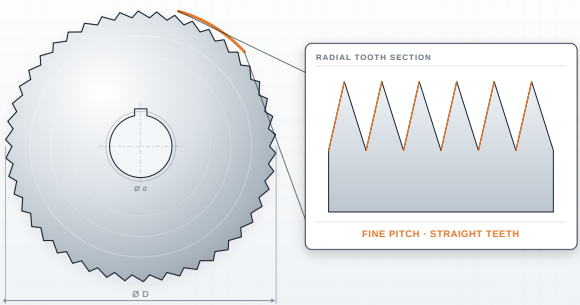
Inspected before **every shipment**

Repeatable from **first piece to reorder**

— FOUR FORMS, MATCHED TO THE CUT

The right tooth geometry for your material and depth.

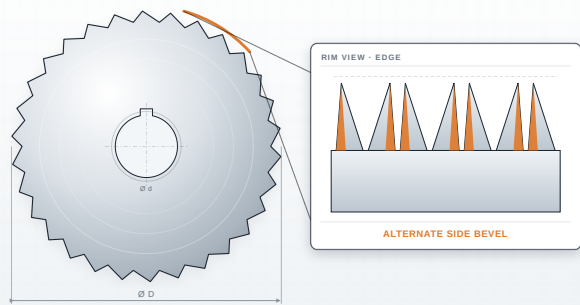
Slitting saw performance is decided at the tooth. We grind four forms as standard and to custom geometry, so the saw matches your slot depth, material and finish rather than forcing a compromise.



Plain (Fine-Tooth) **DIN 1837**

Straight peripheral teeth, hollow-ground for side clearance. The standard choice for thin, shallow, accurate slots and a fine surface finish.

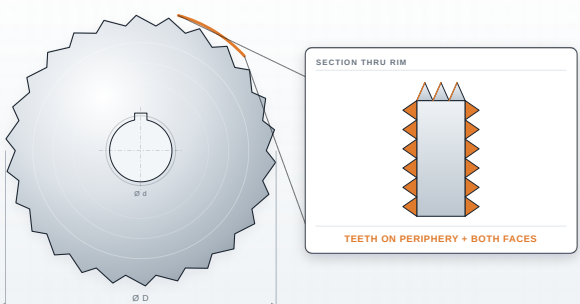
Best for: narrow slots, screw slotting, electronics, shallow cuts in steel, brass and aluminium.



Staggered-Tooth **DIN 1838**

Teeth bevelled alternately left and right for true side clearance and free chip flow. Cuts deeper and wider with far less rubbing and heat.

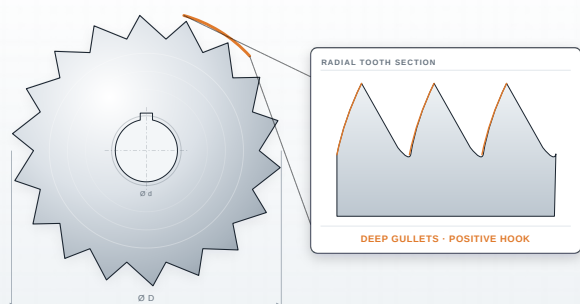
Best for: deep or wide slots, tougher and stainless steels, heavier stock removal.



Side-and-Face **CUSTOM**

Cutting edges on the periphery and both sides, supplied with a keyed bore for positive drive. Handles deep and wide slot cutting under load.

Best for: deep slotting, keyed-arbor work, ganged setups, side-trim and grooving.



Coarse-Tooth **CUT-OFF**

Fewer teeth and deep gullets for maximum chip room. The form to reach for on parting, cut-off and soft or gummy materials that load fine teeth.

Best for: parting and cut-off, aluminium, copper, plastics, deep single passes.

GRADES, RANGES & TOLERANCES

Specifications built around your slot.

Every saw is made to order. The grade is chosen for your material and cut, the geometry for your depth and finish, and the bore to fit your arbor. Ranges below cover standard capability; ask for anything outside them.

MATERIAL GRADES

GRADE	STANDARD	HARDNESS	BEST SUITED TO
HSS M2 (1.3343)	DIN 1837 / 1838	63-65 HRC	General slotting and parting in steel, brass and aluminium
HSS-Co M35 (1.3243)	DIN 1837 / 1838	64-66 HRC	Stainless, alloy and tougher steels, higher heat resistance
PM-HSS (ASP-type)	DIN 1837 / 1838	65-67 HRC	High-stress, interrupted and long-run production cuts
Solid carbide (on request)	K10 / K20	~92 HRA	Hardened steel, thin precise slots and maximum cutting speed

DIMENSIONAL RANGE

PARAMETER	RANGE
Outside diameter	25 to 315 mm (1 to 12.4 in)
Thickness	0.3 to 6 mm, ground to your slot width
Bore	To specification, H7 fit, with keyway or drive slots
Teeth & form	18 to 200+, plain, staggered or side-and-face
Hardness	63 to 66 HRC (HSS and PM), triple tempered

POPULAR SIZES (MM), ALL CUSTOM-GROUND

63 × 1.5 × 22

80 × 2 × 22

100 × 2 × 32

125 × 3 × 32

160 × 4 × 40

200 × 5 × 40

250 × 6 × 40

315 × 6 × 40

Slot-width tolerance ±0.01 mm standard, ±0.005 mm precision

Bore H7

Runout 0.02 mm TIR

Finish ground on all faces

MATERIALS, SPEEDS & FEEDS

Set up for a clean cut, first time.

Slitting saws reward the right speed far more than the right feed. The starting values below get you cutting; fine-tune to your machine, rigidity and coolant. Our team will recommend grade, geometry and parameters for your exact job.

MATERIALS WE CUT

- Carbon & alloy steel
- Stainless steel
- Tool & die steel
- Aluminium
- Brass & bronze
- Copper
- Titanium (carbide)
- Plastics & composites

STARTING CUTTING SPEEDS

MATERIAL	SPEED (SFM)	NOTE
Aluminium, brass	200-400	Flood coolant, clear chips
Mild / carbon steel	60-90	Steady feed
Alloy / stainless	40-70	M35 or PM, rigid setup
Tool / hardened	20-40	PM or carbide, light feed

Feed per tooth runs roughly **0.0005 to 0.002 in** (0.013 to 0.05 mm), lower on thin or small-diameter saws.

$$\text{RPM} = (3.82 \times \text{SFM}) \div \emptyset$$

diameter in inches · e.g. 4 in saw in mild steel at 75 SFM ≈ 72 RPM



Slitting saw in cut, arbor-mounted

RULES THAT PROTECT THE SAW

- Raise speed before feed;** heat, not force, cuts steel.
- Keep at least two teeth** engaged in the cut.
- Climb-mill** on rigid, backlash-free machines.
- Flood coolant;** clear chips from the gullet.

— ONE ROOF, SIX CONTROLLED STAGES

How every Maxwell saw is made.

Controlling the whole process is what keeps tolerance and edge quality repeatable. Nothing is outsourced blind: stock is certified, geometry is cut to your drawing, hardening is triple tempered, and every saw is inspected before it ships. Solid-carbide saws are ground from carbide blank rather than hardened.

01

Billet & blank

Certified HSS, cobalt or PM stock, cut and prepared to size.

02

CNC turning

Outside diameter, bore and faces machined true and concentric.

03

Tooth milling

Plain, staggered or side-and-face geometry cut to specification.

04

Vacuum hardening

HSS and PM hardened and triple tempered to 63-66 HRC.

05

Precision grinding

Sides, bore and cutting edges ground to final tolerance.

06

Inspection

Dimensions, runout and hardness verified, CMM report on request.

— DOCUMENTATION SUPPLIED ON REQUEST

Material test certificate

Dimensional inspection report

Hardness record

Batch traceability

Quality system ISO 9001:2015 certified

Verification CMM, hardness tester, optical & micrometer

Since 1976

SIMPLE TO SPECIFY, BUILT FOR EXPORT

From your drawing to your dock.

Send a drawing, a sample, or just the slot you need to make. We quote in your currency, confirm geometry and grade, then manufacture and ship worldwide with full export documentation.

1

Send drawing or sample

2

We quote in USD, EUR or INR

3

You approve first article

4

We manufacture & inspect

5

We ship worldwide

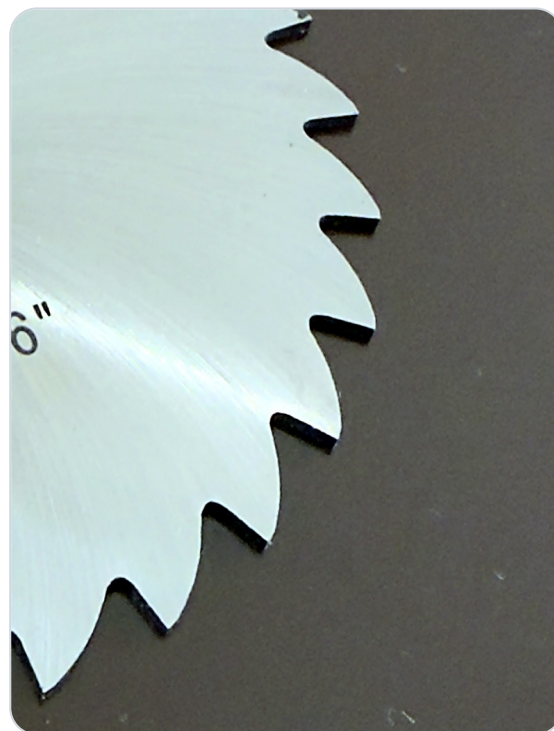
COMMERCIAL TERMS

TERM	DETAIL
Lead time	4 weeks standard, 2-week rush on many sizes
Incoterms	EXW, FOB, CIF or DAP
Payment	30% advance, balance against shipping documents (negotiable)
Packaging	Individually protected, export-grade cartons
Documents	Invoice, packing list, certificates, HS 8202.31 / 8207.70*
Samples	Available for qualification before a production run

*HS classification confirmed per shipment.

WHAT WE NEED FROM YOU

- Outside diameter
- Bore + keyway / drive
- Thickness / slot width
- Tooth form (or we advise)
- Material grade (or we advise)
- Material being cut & depth
- Quantity



Ground tooth edges, Maxwell slitting saw

REQUEST A QUOTE

Send us your slot. We will build the saw for it.

A drawing, a sample, or a slot width and material is all we need. Quoted in your currency, ground to your tolerance, and shipped in four weeks.

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MAXWELL
SLITTER INDUSTRIES

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EXPORTING TO 30+ COUNTRIES