



**LEFON**  
MACHINERY & ENGINEERING GROUP

# SAW BLADE&LUBRICANT

LEFON cutting blade is made in Europe. Three class of blade are available: Economical, Durable, and Extra-Durable.

Economical Blade is made from DMO5 Bright,

Durable Blade is made from DMO5 Black HAWK,

Extra-Durable Blade is made from Co5% Black HAWK

The blades has been universally designed and developed for all kind of orbital pipe/tube cutting machine, i.e. this blade can be used on machine from other manufacturers. The blade is suitable for cutting all kind of standard metal material.



	Standard	Durable	Extra-Durable
Material	This blade is made by HSS with Mo 5% W6% Cr4% V2%	This blade is made by HSS with Mo 5% W6% Cr4% V2%,	This blade is made by HSS with Mo 5% W6% Cr4% V2%, Co 5%
Hardness	The hardness of the blade is between 63 to 65 Hrc. The outside surface hardness reaches 800 HV.	The outside surface hardness reaches 3400 HV!	HSS material can reach 66 Hrc. The outside surface hardness reaches 3400 HV!
Application	Good to cut any kind of material. The special surface grinding allows it to cut very soft materials e.g. copper, brass, aluminum	Good to cut any kind of material, stainless steel or any steel but with high performance	Good to cut any kind of material. Ideal for Ti or Inconel and stainless steel but with high performance.
Working Life	Blade working life depends on the material of pipe, the OD, and the wall thickness	Durable has 40% more life than Standard Blade, or 60% more life if cutting stainless steel.	Extra-durable blade has 50% more life than standard, and 100% more if cutting stainless steel
Instruction	This blade is NOT suitable for dry cutting, must be used with coolant or at least good quantity of cutting oil	This blade is suitable for dry cutting or misting fluid cooling.	This blade is suitable for dry cutting or misting fluid cooling.

odel	Dimension			Cutting Pipe Wall Thickness		Remarks
	OD(mm)	OD(inch)	Teeth Number	mm	inch	
L6364	63	2.48	64	1.0--2.5	0.039--0.098	most popular
L63100	63	2.48	100	0.7--1.5	0.0276--0.059	
L6844	68	2.68	44	2.0--7.0	0.079--0.276	most popular
L6872	68	2.68	72	1.0--2.5	0.039-0.098	
L8044	80	3.15	44	5.0--10.0	0.197--0.394	
L8080	80	3.15	80	1.0--2.5	0.039--0.098	small size of square pipe

**Operating Speed :**

Model	Materials of tube/pipe	Choosing speed button	Blade Rotating Speed
Lite4 R4 R6 R8 R12	High alloy steel Stainless steel	1-2	150-183
	Low alloy steel	3-4	183-216
	Plastic non-ferrous metal Carbon steel pipe Zinc coated pipe	5-6	216-250

**Non-toxic Lubricant/coolant (200 ml package)**

Direction:

Add 1-2 drops of lubricant on the top of blade teeth for every two lines of cutting.



Benefit:

Lubricant would effectively lower cutting temperature, extend blade life, and improve cutting result. For more details, please refer to LEFON's orbital cutting machine operation manual.