

MAGICUT®

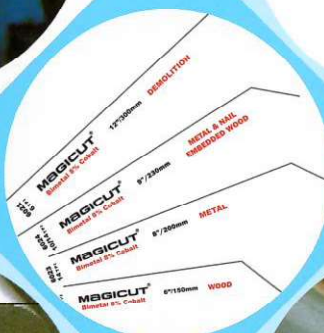
HAND TOOLS

CUTTING TOOLS

POWER TOOL ACCESSORIES



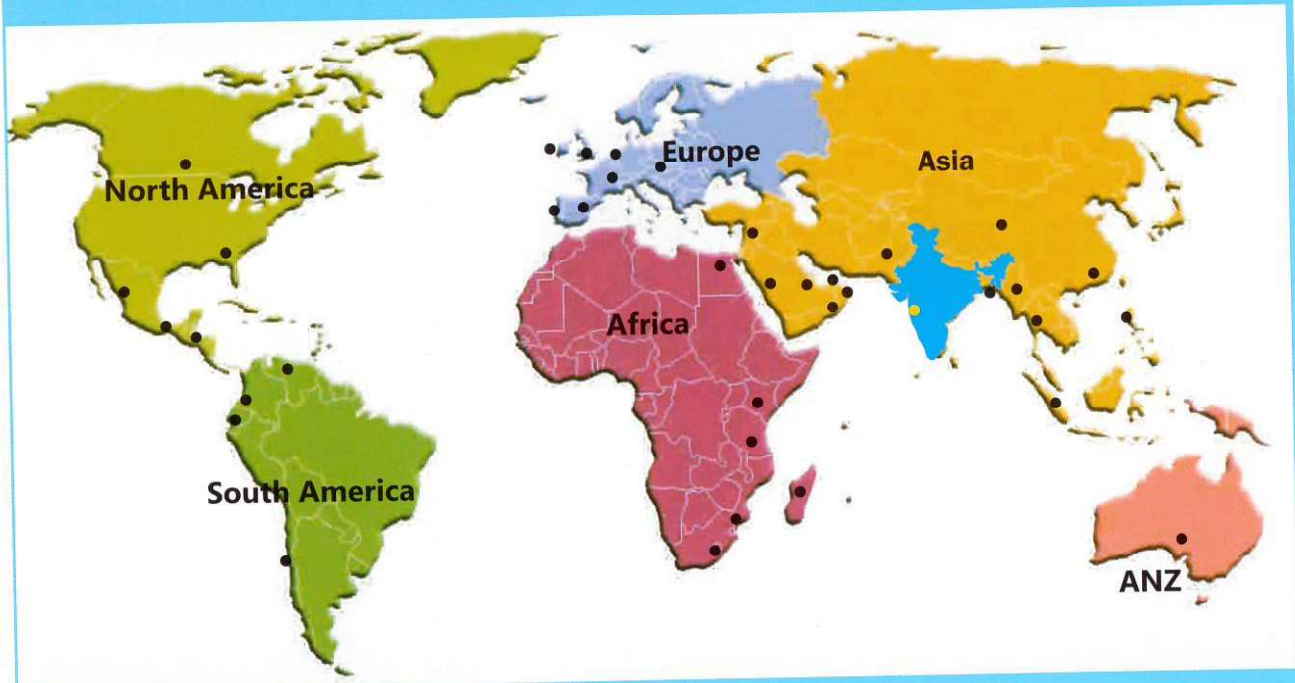
36
Years
Since 1982



"SOLUTIONS TO YOUR SAWING & CUTTING NEEDS"

Prologue

EXPORTS to 6 Continents - Spread Over 45 COUNTRIES and counting....



Exhibitions Participated



Cologne - Germany



Moscow - Russia



Guadalajara - Mexico



Las Vegas - USA



Shanghai - China

Jakarta - Indonesia

Bilbao - Spain

Ahmedabad - India

Bangalore - India



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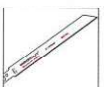
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Hand Hacksaw Blades

MAGICUT® Bimetal High Speed Steel



A Virtually unbreakable bimetal blade for superb cutting performance, wear resistance and safety. It combines the toothed high speed steel strip, laser welded to a spring steel back, resulting into a highly flexible blade

possessing extreme cutting performance that is vastly superior to all hard high speed blades or conventional flexible blades. They cut through all types of materials including alloys and stainless steels.

MAGICUT® Bimetal 8% Cobalt High Speed Steel



A Shatter proof blade for high wear resistance as compared to conventional bimetal blades. This has all attributes of bimetal with high alloy 8% cobalt tooth.

The tooth have hardness of 66 to 68 HRC with high wear resistance property. They cut through all types of materials including high alloy steels.

MAGICUT® All Hard High Speed Steel



A rigid all hard blade for highly accurate cutting that is ideal for general-purpose work around the workshop.

These blades are uniformly hardened throughout and have a fully hardened back and cutting edge.

MAGICUT® Flexible High Speed Steel



A nearly shatterproof blade with a longer life that is having a hardened edge offering higher flexibility and

safety but giving lesser wear resistance than a traditional all hard blade.

MAGICUT® High Carbon Steel

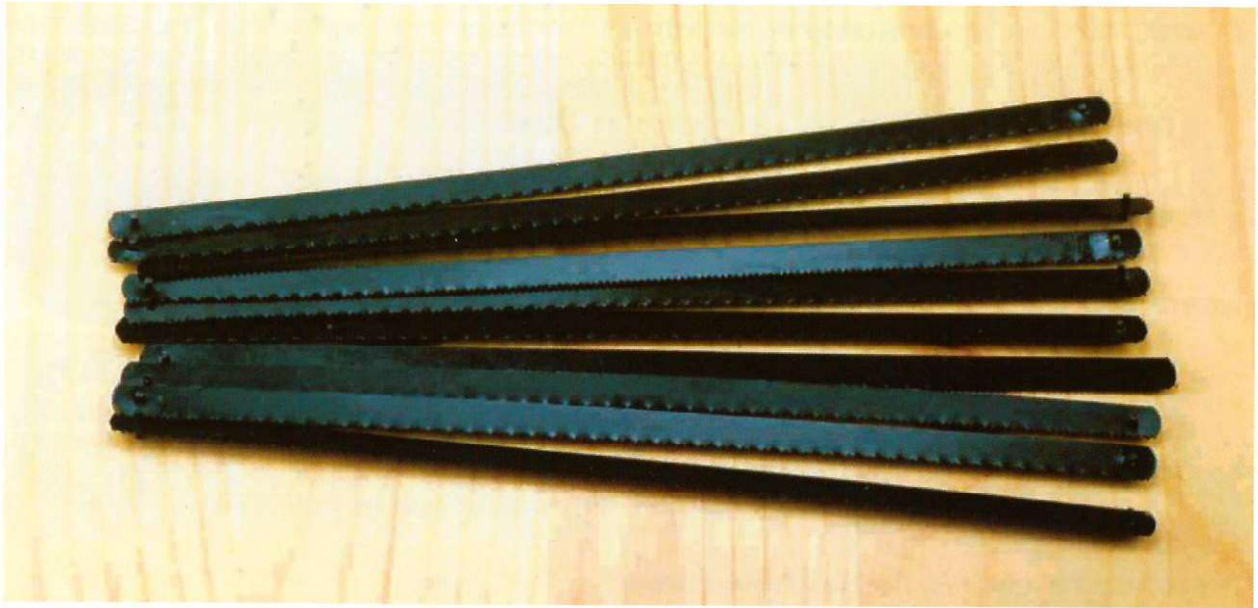


High carbon steel blades for all light duty work and are unbreakable in normal condition. They are suitable for

all relatively soft materials, such as aluminum, copper, brass, mild steel and other soft metals.

Size in inches	Size in mm	TPI
10 X 1/2 X 0.025(23G)	250 X 12.50 X 0.63	14,18,24,32
12 X 1/2 X 0.025(23G)	300 X 12.50 X 0.63	14,18,24,32

Junior Hacksaw Blades



MAGICUT® Junior Hacksaw Blades

Junior Hacksaw Blades are manufactured from the finest grade of High Carbon Steel raw material. The teeth are properly hardened and tempered to get optimum blade life for Professional applications. These are available in three variants:

TPI		Recommended Use
14	Coarse teeth for cutting without much effort	Soft plastics, paperboard, hardboard, molded wood etc.
24	Medium teeth for precise sawing work	All kinds wood, gypsum, plastics, metals, aluminium, non-ferrous metals, channels, pipes etc.
32	Fine teeth for high quality sawing works	All kinds of metals, thin section non-ferrous metals, special steel, alloys, etc.

Size in inches	Size in mm	TPI
6 X 1/4 X 0.018	150 X 6 X 0.45	14, 24, 32

Hacksaw Frames

MAGICUT® Aluminum Hacksaw Frame HHF002



- Heavy Duty Aluminum Handle
- Epoxy Powder Coated Frame
- Robust and Compact
- Less Effort While Cutting
- Wide Wing Nut for Easy Tensioning
- Supplied with 12"/300mm Hand Hacksaw Blades



MAGICUT® Plastic Hacksaw Frame HHF004



- High Tensile Plastic Handle
- Epoxy Powder Coated Frame
- Light Weight for Easy Handling
- Easy Blade Change
- Wide Wing Nut for Easy Tensioning
- Supplied with 12"/300mm Hand Hacksaw Blades



MAGICUT® Economy Hacksaw Frame HHF006



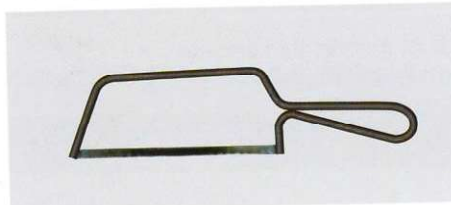
- High Quality Wooden Handle
- General Purpose Frame
- Rigid and Heavy Duty
- Wide Wing Nut for Easy Tensioning
- Supplied with 12"/300mm Hand Hacksaw Blades

MAGICUT® Mini Hacksaw Frame HHF007



- Light weight Plastic Frame
- Ideal for Cutting in Small, Hard to reach areas
- Durable and Comfortable to use
- Accepts both 10"/250mm and 12"/300mm Blades
- Supplied with 12"/300mm Hand Hacksaw Blades

MAGICUT® Junior Saw Frame JBH002



- Epoxy Powder Coated Steel Frame
- Light Weight
- Meticulous cutting in difficult-to-reach places
- Available with Epoxy Powder Coated finish in variety of Colours
- Fitted with 6"/150mm Blade

MAGICUT® Pistol Grip Junior Saw Frame JBH004



- Plastic Moulded Pistol Grip Handle
- Solid Steel Frame
- Well Balanced, Sturdy and Rigid
- Blade Tensioning End Screw for easy Blade installation
- Ideal for all Applications.
- Fitted with 6"/150mm blade

Bimetal Hole Saws

MAGICUT® Bimetal Hole Saws are toothed HSS strips laser welded to a tough alloy body and disc. These precision manufactured Hole Saws that have outstanding strength, resilience and shatter resistance are manufactured in Bimetal M3 & 8% Cobalt grades.



MAGICUT® Bimetal M3 Hole Saws are manufactured using the superior M3 quality of High Speed Steel that is better than the conventional M2 grade. The M3 cutting edge has higher alloying elements that enhances the performance considerably and is useful for cutting aluminum, bakelite, brass, bronze, cast iron, mild steel, plastic, wood, etc.

MAGICUT® Cobalt Hole Saws have 8% Cobalt in addition to normal alloying elements that can sustain higher temperatures, has more hardness and greater wear resistance. They are therefore recommended for cutting difficult materials like cast steels, duralium, hardwood, inconel, inox, non-ferrous alloys, plaster of paris, stainless steel, etc.



Salient Features & Advantages

Solid Back Disc	Ensures a smooth and precise cut
Variable Pitch with Positive Rake Teeth	- Reduces cutting vibrations - Provides extra swarf clearance while cutting thicker sections - Scoops out material from the groove more efficiently - Useful in cutting tenacious materials like copper and stainless steel - Easier bite into the object

Ø Diameter		Ø Diameter	
mm	inch	mm	inch
14	9/16	42	
15		43	1.11/16
16	5/8	44	1.3/4
17	11/16	45	
18	11/16	46	1.13/16
19	3/4	47	
20	25/32	48	1.7/8
21	13/16	49	
22	7/8	50	2
23	29/32	51	2
24	15/16	52	2.1/16
25	1	53	
26		54	2.1/8
27	1.1/16	55	
28	1.1/10	56	2.3/16
29	1.1/8	57	2.1/4
30	1.3/16	58	
31		59	2.5/16
32	1.1/4	60	2.3/8
33	1.5/16	61	2.3/8
34		62	2.4/9
35	1.3/8	63	2.4/9
36		64	2.1/2
37	1.7/16	65	2.9/16
38	1.1/2	66	
39		67	2.5/8
40	1.9/16	68	2.11/16
41	1.5/8	69	

Ø Diameter		Ø Diameter	
mm	inch	mm	inch
70	2.3/4	125	
71		127	5
72		130	
73	2.7/8	133	5.1/4
74		138	
75	2.7/8	140	5.1/2
76	3	146	5.3/4
79	3.1/8	148	
80		150	
82		152	6
83	3.1/4	160	6.5/16
84		165	
85		168	6.5/8
86	3.3/8	170	
89	3.1/2	172	
90		174	
92	3.3/8	176	
95	3.3/4	177	7
98	3.7/8	178	
100		180	
102	4	182	
105	4.1/8	183	7.3/16
108	4.1/4	188	
110		200	7.7/8
111	4.3/8	201	
114	4.1/2	210	8.9/32
117		235	
121	4.3/4		

Hole Saw Kits

MAGICUT® Hole Saw Kits are available for cutting almost any material. Each kit consist of assorted hole saws and accessories that are specifically designed for use in the electrical, plumbing, interiors decoration, etc. In addition to these special purpose kits we offer a general-purpose kit and universal kit that is suitable for a variety of applications.



The standard kits have in them Bimetal M3 Hole Saws of variable tpi however these can be supplied in Bimetal 8% Cobalt quality and in constant pitch of 10 tpi.

MAGICUT® Hole Saw Kits

Job	Hole Saws mm	Accessories
General Purpose Kit	22, 29, 35, 44, 51 & 64	HSA03 & HSA05 Arbors HSP Ejector Spring
Mini-Electrician Kit	16, 20, 25, 29, 44 & 51	HSA03 & HSA05 Arbors HSP Ejector Spring
Electrician Kit	16, 20, 22, 25, 29, 35, 44, 51, 64, 68 & 76	HSA03 & HSA06 Arbors HSP Ejector Spring
Mini-Plumber Kit	19, 22, 29, 38, 44, 51 & 57	HSA03 & HSA05 Arbor HSP Ejector Spring
Plumber Kit	16, 19, 22, 29, 35, 38, 44, 51, 57, 65 & 68	HSA03 & HSA06 Arbors HSP Ejector Spring
Plumbers and Electrician Kit	16, 20, 22, 29, 35, 38, 40, 44, 51, 57, 65 & 68	HSA03 & HSA06 Arbors HSP Ejector Spring
Automotive Kit	19, 22, 25, 29, 32 & 38	HSA03 & HSA05 Arbors
Mini-Locksmith Kit	24, 27, 32, 35, 38, 54 & 60	HSA03 & HSA05 Arbors HSP Ejector Spring
Locksmith Kit	22, 24, 25, 27, 32, 35, 38, 44, 54 & 60	HSA03 & HSA06 Arbors HSP Ejector Spring
Universal Kit	16, 20, 22, 25, 29, 32, 35, 38, 44, 51, 57, 64, 68 & 76	HSA03 & HSA06 Arbors HSP Ejector Spring

Hole Saw Accessories

Arbor is the link between the hole saw and the drilling machine

Code No	Description	Suitable For	
HSA01	Round Shank – 6mm (1/4")	14 to 30mm (9/16 – 1.3/16")	
HSA02	Hex Shank – 6mm (1/4")	14 to 30mm (9/16 – 1.3/16")	
HSA03	Hex Shank – 9mm (3/8")	14 to 30mm (9/16 – 1.3/16")	
HSA04	Hex Shank - 11mm (7/16")	14 to 30mm (9/16 – 1.3/16")	
HSA05	Quick Release, Hex Shank - 9mm (3/8")	32 to 110 mm (1.1/4 – 8.1/4")	
HSA06	Quick Release, Hex Shank - 11mm (7/16")	110 to 210mm (1.1/4 – 8.1/4")	
HSA07	SDS Shank – 10mm (3/8")	14 to 30mm (9/16 – 1.3/16")	
HSA08	Quick Release, SDS Shank - 10mm (3/8")	32 to 210mm (1.1/4 – 8.1/4")	

Pilot Drill made of High Speed Steel is held by a set screw in the arbor body

Code No	Description	
HSD01	Pilot Drill - 80mm (3.1/8")	
HSD02	Pilot Drill - 102mm (4")	

Extension Bar is used for lengthening the reach of the drilling machine.

Code No	Description	Suitable For	
HSE01	Extension Bar	HSA03, HSA04, HSA06	

Ejector Spring fits over pilot drill and pushes the core out of hole saw once cut is over.

Code No	Description	
HSP	Ejector Spring	

Arbor Adaptor fits over small arbors to allow use of hole saws up to 6"/ 152mm diameter.

Code No	Description	Suitable For	
HSD	Adaptor	HSA01, HSA02, HSA03, HSA07	

Set Screw locks the drill tightly in the arbor.

Code No	Description	
HSL	Grub Screw	

Cordless Hole Saws



MAGICUT® Extra Magicut Cordless Hole Saws are fast cutting hole saw with 8% Cobalt, designed for drilling through sheet metal. These precision manufactured Hole Saws have outstanding strength, resilience and shatter resistance.

Salient Features & Advantages

- HSS Cutting edge with 8% Cobalt for extra durability
- Ultra thin kerf for fast drilling
- Small, sharp and durable tooth design
- Suitable for up to 1.6mm materials
- Internal spring for continuous drilling without clogging
- Can be used in an Impact Driver
- Suitable for use in Stainless Steel, Metal & Mild Steel and Aluminium

mm	Ø Diameter	inch
16		5/8
19		3/4
20		25/32
22		7/8
25		1
27		1.1/6
29		1.1/8
30		1.3/16
32		1.1/4
35		1.3/8
38		1.1/2

mm	Ø Diameter	inch
40		1.9/16
44		1.3/4
51		2
60		2.3/8
67		2.5/8
70		2.3/4
76		3
83		3.1/4
89		3.1/2
95		3.3/4
102		4

Mini Hole Saws



MAGICUT® Bimetal Mini Hole Saws are toothed HSS Strips welded to a tough alloy body and disc. These precision manufactured Hole Saws have outstanding strength, resilience and shatter resistance

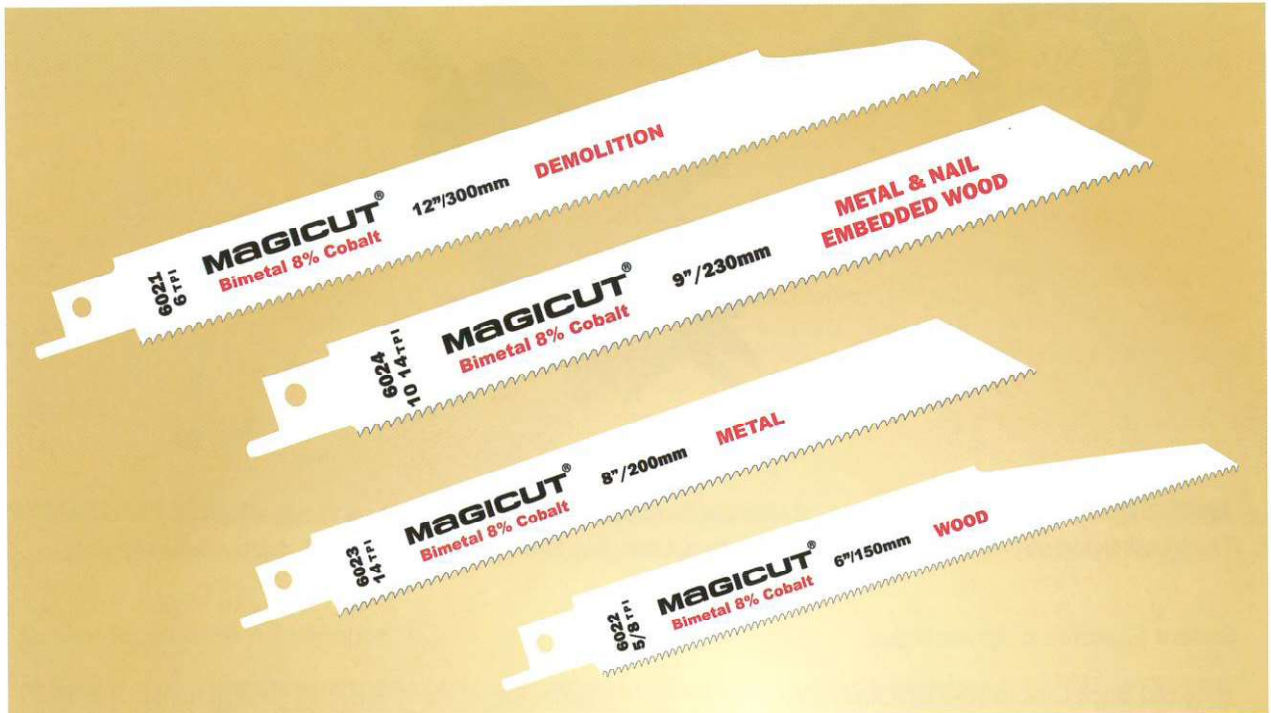
Salient Features & Advantages

- Solid Back Disc for Smooth and Precise Cut
- Single Piece Construction
- Precise Tool Geometry
- More Cutting Depth compare to conventional Holesaws
- Smooth Cutting Operation
- Better Rigidity
- Longer Life

Ø Diameter			
mm	inch	mm	inch
8	5/16	32	1.1/4
12	1/2	34	
14	9/16	35	1.3/8
16	5/8	37	1.7/16
17	11/16	38	1.1/2
19	3/4	40	1.9/16
20	25/32	41	1.5/8
22	7/8	42	1.21/32
25	1	44	1.3/4
27	1.1/16	45	
29	1.1/8	47	
30	1.3/16	48	1.7/8

Ø Diameter			
mm	inch	mm	inch
50	2	75	2.7/8
51	2	76	3
54	2.1/8	80	
57	2.1/4	83	3.1/4
60	2.3/8	84	3.5/16
64	2.1/2	86	3.3/8
65	2.9/16	89	3.1/2
67	2.5/8	90	
68	2.11/16	95	3.3/4
70	2.3/4	98	3.7/8
73		100	3.15/16
74		102	4

Reciprocating Saw Blades



MAGICUT® Reciprocating Saw Blades

- Top Quality Bimetal Blades
- Higher Productivity & longer life with 8% Cobalt cutting edge.
- Available in 3 different thickness to meet the flexibility & stiffness requirement is for various applications.

Wood Cutting

- Fast cutting for wood, composition materials and plastic
- Use with materials 3/16" (5mm) and thicker

Our Code	Size in inches	Size in mm	TPI
6025	6 x 3/4 x 0.035	150 x 19 x 0.9	6
6022	6 x 3/4 x 0.05	150 x 19 x 1.25	5/8
6006	6 x 3/4 x 0.05	150 x 19 x 1.25	6
6005	9 x 3/4 x 0.05	230 x 19 x 1.25	6
6009	12 x 3/4 x 0.05	300 x 19 x 1.25	6

Reciprocating Saw Blades

Metal & Nail Embedded Wood Cutting

- Roughing-in work and nail embedded wood
- Use with materials 3/16" (5mm) and thicker

Our Code	Size in inches	Size in mm	TPI
6002	6 x 3/4 x 0.035	150 x 19 x 0.9	10
6004	8 x 3/4 x 0.035	200 x 19 x 0.9	10/14
6024	9 x 3/4 x 0.035	230 x 19 x 0.9	10/14

Metal Cutting

- Cuts all means including nonferrous pipe conduit, stainless and sheet metals
- Use with materials 1/8" (3.2 mm) and thicker

Our Code	Size in inches	Size in mm	TPI
6001	6 x 3/4 x 0.035	150 x 19 x 0.9	14
6011	6 x 3/4 x 0.035	150 x 19 x 0.9	18
6010	6 x 3/4 x 0.035	150 x 19 x 0.9	24
6023	8 x 3/4 x 0.035	200 x 19 x 0.9	14
6003	8 x 3/4 x 0.035	200 x 19 x 0.9	18

Demolition

- For heavy duty and demolition application in wood and metal
- Use with materials 3/16" (5mm) and thicker

Our Code	Size in inches	Size in mm	TPI
6020	6 x 7/8 x 0.062	150 x 22 x 1.6	10
6017	9 x 7/8 x 0.062	230 x 22 x 1.6	6
6018	9 x 7/8 x 0.062	230 x 22 x 1.6	10
6021	12 x 7/8 x 0.062	300 x 22 x 1.6	6
6019	12 x 7/8 x 0.062	300 x 22 x 1.6	10

Air Saw Blades

8000 Series



Our Code	Similar To	Length x Pitch mm x mm inch x TPI	Recommended Use
8001	-	90 x 1.8	Sandwich Material
BIM/Milled/ Raker		3 9/16 x 14	
8002	Pneutec	90 x 1.4	Plastics, Aluminium
BIM/Milled/ Raker	10 700 735	3 9/16 x 18	
8003	Pneutec	90 x 1.1	Sheet, Sheet Metal
BIM/Milled/Wavy	10 700 734	3 9/16 x 24	
8004	Pneutec	90 x 0.8	Sheet, Sheet Metal
BIM/Milled/Wavy	10 700 733	3 9/16 x 32	

8100 Series



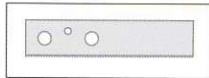
Our Code	Similar To	Length x Pitch mm x mm inch x TPI	Recommended Use
8101	SIG 1150	96 x 1.8	Sandwich Material
BIM/Milled/ Raker		3 3/4 x 14	
8102	-	96 x 1.4	Plastics, Aluminium
BIM/Milled/ Raker		3 3/4 x 18	
8103	SIG 1152	96 x 1.1	Sheet, Sheet Metal
BIM/Milled/Wavy		3 3/4 x 24	
8104	SIG 1153	96 x 0.8	Sheet, Sheet Metal
BIM/Milled/Wavy		3 3/4 x 32	
8105	SIG 1151	70 x 1.4	Plastics, Aluminium
BIM/Milled/Wavy		2 3/4 x 18	
8106	-	70 x 1.1	Sheet, Sheet Metal
BIM/Milled/Wavy		2 3/4 x 24	
8107	-	70 x 0.8	Sheet, Sheet Metal
BIM/Milled/Wavy		2 3/4 x 32	

8200 Series



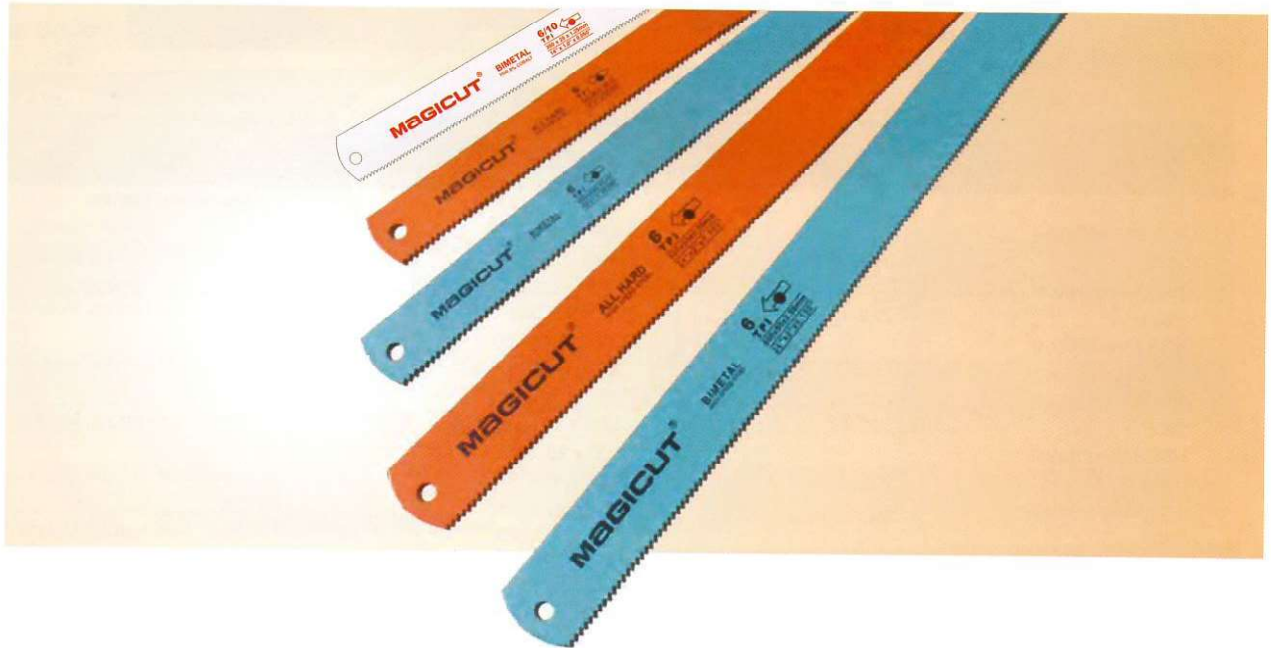
Our Code	Similar To	Length x Pitch mm x mm inch x TPI	Recommended Use
8201	-	90 x 1.8	Sandwich Material
BIM/Milled/ Raker		3 9/16 x 14	
8202	-	90 x 1.4	Plastics, Aluminium
BIM/Milled/ Raker		3 9/16 x 18	
8203	-	90 x 1.1	Sheet, Sheet Metal
BIM/Milled/Wavy		3 9/16 x 24	
8204	-	90 x 0.8	Sheet, Sheet Metal
BIM/Milled/Wavy		3 9/16 x 32	

Portable Power Hacksaw Blades


3000 Series


Our Code	Fein Code	Size in inch Size in mm	TPI	Recommended Use
3001 HSS/Milled/Raker	Z22-9	8 x 1 x 0.062 200 x 25 x 1.60	8	Aluminum, Plastic
3002 HSS/Milled/Raker	Z22-10	8 x 1 x 0.062 200 x 25 x 1.60	14	Steel, Non-ferrous Metals
3003 HSS/Milled/Raker	Z22-11	8 x 1 x 0.062 200 x 25 x 1.60	21	Steel, Non-ferrous Metals
3004 HSS/Milled/Raker		12 x 1 x 0.062 300 x 25 x 1.60	8	Steel, Non-ferrous Metals
3005 HSS/Milled/Raker	Z22-31	12 x 1 x 0.062 300 x 25 x 1.60	10	Steel, Non-ferrous Metals
3006 HSS/Milled/Raker	Z22-6	12 x 1 x 0.062 300 x 25 x 1.60	14	Steel, Non-ferrous Metals
3007 HSS/Milled/Raker		12 x 1 x 0.020 300 x 25 x 2.00	14	Steel, Non-ferrous Metals
3008 HSS/Milled/Raker		13 x 1 x 0.020 325 x 25 x 2.00	10	Steel, Non-ferrous Metals
3009 HSS/Milled/Raker		13 x 1.1/8 x 0.020 325 x 28 x 2.00	8	Aluminum, Plastic
3010 HSS/Milled/Raker	Z22-29	16 x 1 x 0.062 400 x 25 x 1.60	8	Aluminum, Plastic
3011 HSS/Milled/Raker	Z22-7	16 x 1 x 0.062 400 x 25 x 1.60	14	Steel, Non-ferrous Metals
3012 HSS/Milled/Raker		16 x 1 x 0.020 400 x 25 x 2.00	14	Steel, Non-ferrous Metals
3013 HSS/Milled/Raker		20 x 1 x 0.062 500 x 25 x 1.60	14	Steel, Non-ferrous Metals
3014 HSS/Milled/Raker		20 x 1 x 0.020 500 x 25 x 2.00	14	Steel, Non-ferrous Metals
3015 HSS/Milled/Raker	Z22-72	20 x 1.1/8 x 0.020 500 x 28 x 2.00	14	Steel, Non-ferrous Metals
3016 HSS/Milled/Raker	Z22-3	21 x 1.1/8 x 0.062 525 x 28 x 1.60	10	Steel, Non-ferrous Metals
3017 HSS/Milled/Raker	Z22-30	22 x 1 x 0.062 550 x 25 x 1.60	10	Steel, Non-ferrous Metals
3018 HSS/Milled/Raker	Z22-74	24 x 1.1/8 x 0.020 600 x 28 x 2.00	8	Aluminum, Plastic
3019 HSS/Milled/Raker	Z22-73	24 x 1.1/8 x 0.020 600 x 28 x 2.00	14	Steel, Non-ferrous Metals
3020 HSS/Milled/Raker		28 x 1.1/8 x 0.020 700 x 28 x 2.00	6	Aluminum, Plastic
3021 HSS/Milled/Raker		28 x 1.1/8 x 0.020 700 x 28 x 2.00	14	Steel, Non-ferrous Metals

Power Hacksaw Blades



MAGICUT® Bimetal High Speed Steel

Are flexible, tough power hacksaw blade of bimetal material, with a toothed strip of high speed steel and a backing strip of of spring steel that are able to withstand heavy feed pressures, giving economical and high cutting rates. These bimetal high speed steel edge blades are the best for tough materials and conditions of all types. The cutting edge of high speed steel gives them unparalleled cutting efficiency and the tough alloy steel back resists breakage when used under less than ideal conditions. Blades will handle irregular shapes and interrupted cuts with ease.



MAGICUT® Bimetal Cobalt

Are manufactured using a combination of bimetal 8% cobalt high speed steel along with spring steel backing material making it both flexible and tough at the same time. The cobalt bimetal high speed steel gives the hacksaw blades hot hardness, resulting it to withstand heavier feed pressure for faster and better cutting compared to other types of hacksaw blades. The additional alloys give it a hardened cutting edge and that along with the precise teeth setting and advance heat treatment ensures a high level of quality. These blades are ideal for long life and top performance in sawing a wide range of material without breakage.



MAGICUT® All Hard High Speed Steel

Are traditional high speed steel all hard power hacksaw blades having a fully hardened back and cutting edge. Each blade is precisely hardened throughout its entire width to give a strong, rigid back. It is recommended to be used for high productions applications. These solid high speed steel blades will withstand heavier feed pressure for faster, better cutting that other types of hacksaw blades.

Power Hacksaw Blades

Size in inch	Size in mm	TPI
12 x 5/8 x 0.032	300 X 16 X 0.80	10,14,18,24
12 x 3/4 x 0.032	300 X 20 X 0.80	10,14,18
12 X 3/4 X 0.050	300 X 20 X 1.25	10,14,24
12 X 1 X 0.050	300 X 25 X 1.25	4,6,10,14,18,24
12 X 1 X 0.062	300 X 25 X 1.60	6,8,10,14,24
12 X 1.1/4 X 0.062	300 X 32 X 1.60	8,10,14,24
12 X 1.1/4 X 0.062	300 X 32 X 1.60	K 6,8,10,14,18
12 X 1.1/4 X 0.080	300 X 32 X 2.00	4,6,8,10,14,18
12 X 1.1/4 X 0.080	300 X 32 X 2.00	K 4,6,8,10,14
13 X 1.1/4 X 0.062	325 X 32 X 1.60	6,8,10,14
13 X 1.1/4 X 0.062	325 X 32 X 1.60	K 6,8,10,14,18
14 X 5/8 X 0.032	350 X 16 X 0.80	10,14,18,24
14 X 3/4 X 0.032	350 X 20 X 0.80	10,14,18
14 X 1 X 0.050	350 X 25 X 1.25	6,8,10,14,18
14 X 1 X 0.062	350 X 25 X 1.60	6,10,14
14 X 1.3/16 X 0.080	350 X 30 X 2.00	4,6,8,10,14
14 X 1.1/4 X 0.062	350 X 32 X 1.60	4,6,8,10,14
14 X 1.1/4 X 0.062	350 X 32 X 1.60	K 4,6,8,10,14
14 X 1.1/4 X 0.080	350 X 32 X 2.00	4,6,8,10,14
14 X 3/8 X 0.080	350 X 35 X 2.00	3,4,6,8,10,14
14 X 1.1/2 X 0.062	350 X 40 X 1.60	4,6,8,10
14 X 1.1/2 X 0.080	350 X 40 X 2.00	4,6,8,10,14
14 X 1.1/4 X 0.080	350 X 32 X 2.00	K 4,6,8,10,14
14 X 1.7/16 X 0.062	350 X 36 X 1.60	K 4,6,8,10,14
14 X 1.7/16 X 0.080	350 X 36 X 2.00	K 4,6,8,10,14
14 X 1.3/4 X 0.88	350 X 45 X 2.25	4,6,8,10
16 X 1 X 0.050	400 X 25 X 1.25	6,8,10,14,18
16 X 1 X 0.062	400 X 25 X 1.60	6,10,14
16 X 1.3/16 X 0.062	400 X 30 X 1.60	8,10,14
16 X 1.3/16 X 0.080	400 X 30 X 2.00	3,4,6,8,10,14
16 X 1.1/4 X 0.062	400 X 32 X 1.60	4,6,8,10,14
16 X 1.1/4 X 0.080	400 X 32 X 2.00	4,6,10,14
16 X 1.1/4 X 0.080	400 X 32 X 2.00	K 4,6,10,14
16 X 1.3/8 X 0.080	400 X 35 X 2.00	4,6,8,10,14
16 X 1.3/8 X 0.080	400 X 35 X 2.00	K 3,4,6,8,10,14
16 X 1.1/2 X 0.062	400 X 40 X 1.60	4,6,8,10
16 X 1.1/2 X 0.080	400 X 40 X 2.00	4,6,8,10
16 X 1.1/2 X 0.080	400 X 40 X 2.00	K 4,6,8,10,14
16 X 1.1/2 X 0.080	400 X 40 X 2.00	4,6,8,10,14
16 X 1.3/4 X 0.088	400 X 45 X 2.25	4,6,8,10
17 X 1 X 0.050	425 X 25 X 1.25	8,10,14
17 X 1.1/4 X 0.062	425 X 32 X 1.60	4,6,8,10
17 X 1.3/16 X 0.080	425 X 30 X 2.00	4,6,8,10,14

Size in inch	Size in mm	TPI
17 X 1.3/16 X 0.80	425 X 30 X 2.00	4,6,8,10,14
17 X 1.3/8 X 0.80	425 X 35 X 2.00	4,6,8,10,14
17 X 1.1/2 X 0.062	425 X 40 X 1.60	4,6,10
18 X 1 X 0.050	450 X 25 X 1.25	10,14
18 X 1.3/16 X 0.080	450 X 30 X 2.00	4,6,8,14
18 X 1.1/4 X 0.062	450 X 32 X 1.60	4,6,8,10,14
18 X 1.1/4 X 0.080	450 X 32 X 2.00	4,6,8,10,14
18 X 1.1/2 X 0.062	450 X 40 X 1.60	4,6,10
18 X 1.3/8 X 0.080	450 X 35 X 2.00	4,6,8,10,14
18 X 1.1/2 X 0.080	450 X 40 X 2.00	K 4,6,8,10
18 X 1.3/4 X 0.080	450 X 45 X 2.00	3,4,6,8,10,14
18 X 1.3/4 X 0.088	450 X 45 X 2.25	4,6,10
19 X 1.3/8 X 0.080	475 X 35 X 2.00	3,4,6,8,10,14
19 X 1.3/4 X 0.088	475 X 45 X 2.25	4,6,8,10
20 X 1.1/4 X 0.062	500 X 32 X 1.60	4,6,10
20 X 1.1/4 X 0.80	500 X 32 X 2.00	4,6,10
20 X 1.1/2 X 0.062	500 X 40 X 1.60	4,6,10
20 X 1.1/2 X 0.080	500 X 40 X 2.00	4,6,8,10,14
20 X 1.1/2 X 0.100	500 X 40 X 2.50	3,4,6,8,10
20 X 1.3/4 X 0.080	500 X 45 X 2.00	4,6,8,10
20 X 1.7/8 X 0.100	500 X 48 X 2.50	K 3,4,6,8
20 X 2 X 0.100	500 X 50 X 2.50	3,4,6,8,10
21 X 1.1/2 X 0.080	525 X 40 X 2.00	4,6,10
21 X 1.1/2 X 0.080	525 X 40 X 2.00	4,6,8,10
21 X 1.3/4 X 0.080	525 X 45 X 2.00	4,6,8,10,14
21 X 1.3/4 X 0.088	525 X 45 X 2.25	4,6,8,10
21 X 2 X 0.100	525 X 50 X 2.50	3,4,6,8,10
22 X 1.1/2 X 0.080	550 X 40 X 2.00	3,4,6,8,10
22 X 1.3/4 X 0.100	550 X 45 X 2.50	3,4,6,8,10
22 X 1.3/4 X 0.080	550 X 45 X 2.00	K 4,6,8,10
22 X 2 X 0.100	550 X 50 X 2.50	3,4,6,8
22 X 2 X 0.100	550 X 50 X 2.50	K 3,4,6,8
23 X 1.3/4 X 0.088	575 X 45 X 2.25	4,6,10
23 X 1.3/4 X 0.100	575 X 45 X 2.50	3,4,6,8
23 X 2 X 0.100	575 X 50 X 2.50	4,6,8
23 X 2 X 0.100	575 X 50 X 2.50	K 4,6,8
24 X 1.1/2 X 0.080	600 X 40 X 2.00	4,6,10
24 X 1.1/2 X 0.080	600 X 40 X 2.50	4,6,10
24 X 1.3/4 X 0.088	600 X 45 X 2.25	4,6,10
24 X 2 X 0.080	600 X 50 X 2.00	4,6,10
24 X 2 X 0.100	600 X 50 X 2.50	4,6,8
24 X 2 X 0.100	600 X 50 X 2.50	K 3,4,6,8

K - Kasto Saw Blade with offset clamping holes

High Speed Steel Tool Bits & Cut-Off Blades



MAGICUT® HSS M - 2 Tool Bits

Made from High Speed Steel bearing tungsten-molybdenum grade for use on relatively soft material.

MAGICUT® HSS M - 35 Tool Bits

Made from High Speed Steel bearing 5% Cobalt. It is an economical grade for general purpose use in workshop and is best suited for applications involving interrupted cuts and roughing operation.

MAGICUT® HSS M - 42 Tool Bits

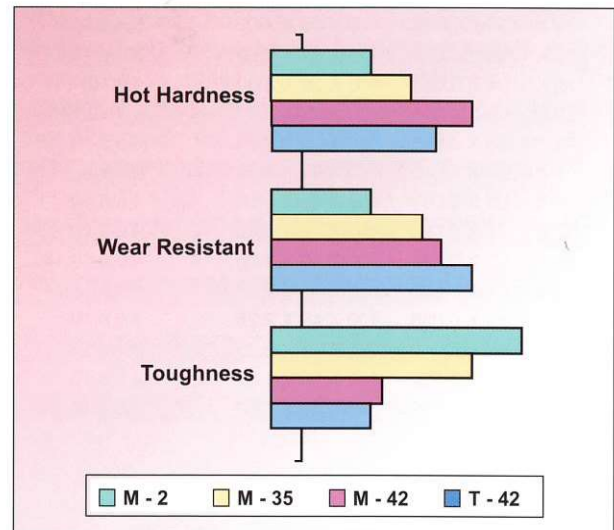
Have a high degree of hot hardness and wear-resistance. Made from High Speed Steel bearing 8% Cobalt, these offer top efficiency on difficult-to-machine alloys and high strength steels.

MAGICUT® HSS T - 42 Tool Bits

Have exceptional wear resistance property. Made of 10% Cobalt bearing High Speed Steel, these have high hot hardness, edge-holding ability in addition to ample toughness for all types of cutting tool applications including those at high temperatures and speeds. They are especially adopted for roughing or finishing operations where maximum tool life is required; for large-batch automatic lathe work and all types of lathe and boring operations.

Relative Properties Of Magicut Grades

Depending on the nature of cutting operation like ease of cutting, hardness of job, machineability of the job, speed of cutting and heat generated at the cutting action the right grade of tool is to be selected. The relative hot hardness, wear resistance and toughness of various grades are indicated in the chart to serve as a general guide.



Tool Bits can be supplied with Cryogenic Treatment

High Speed Steel Tools Bits

Correct Grinding

The heat generated while grinding the cutting edges reduces the hardness at the cutting edges, thereby lowering the cutting efficiency of a sharpened tool. Therefore, when grinding tool bits:

- ▶ Use a soft wheel, appropriately dressed.
- ▶ Apply light pressure and constantly rotate the tool bit surface to avoid discolouration or burning of the cutting edge.

- ▶ Avoid sudden change of temperature DO NOT dip the hot tool in cold water (otherwise the tool will develop surface cracks, which reduce the tool efficiency and life)
- ▶ Hand stoning of the finish ground faces lengthens life between regrinds and enhances surface finish achieved with finishing cuts.

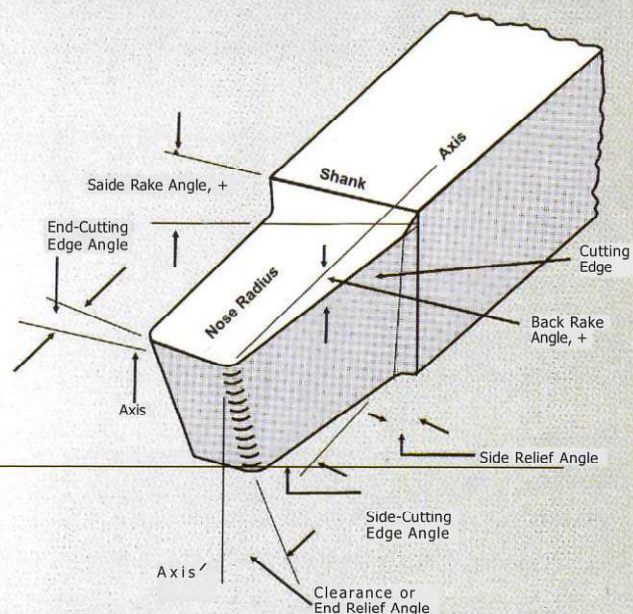
Correct Form

To get high cutting efficiency it is vital that correct tool geometry (profile) is maintained when regrinding the tool. Correct grinding of various angles of a tool can greatly improve the tool bit's performance. Please refer to the **MAGICUT** chart for details of correct angles for cutting different materials.

Recommended Tool Geometry

Nose Radius	As large as possible
Front Relief (Clearance)	4 to 8
Side Relief (Clearance)	6 to 10
Side Rake - hard and / or abrasive work	2 to 10
- soft and / or gummy work	10 to 22
Back Rake - hard / or abrasive work	Negative to 0
- soft and / or gummy work	0 to 10 Positive

Material	Top Rake	Side Clearance
Aluminium	15° - 20°	10° - 15°
Brass	10° - 12°	8° - 10°
Mild Steel	8° - 10°	7° - 9°
Stainless Steel	6° - 7°	6° - 7°
Cast Iron	7° - 9°	7° - 9°

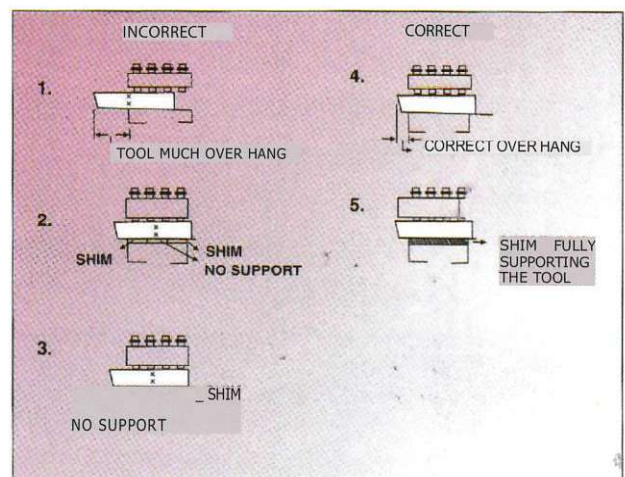


Tool Clamping

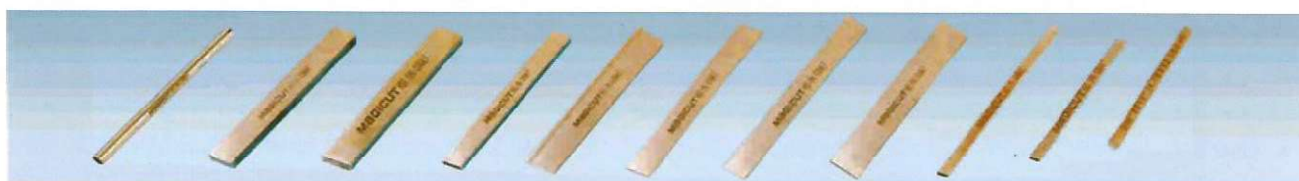
Tool Bits should be fitted in the tool post or tool holder with a minimum of overhang as shown below (in the ratio of 1:1 of the tool size or less). The base of the tool bit should be flush with the tool post. When shims are used they should cover the entire length of the tool bit that rests on the tool post.

It is not advisable to use a bent shim.

Tool bits can break at section XX as shown in figures 1, 2 & 3



High Speed Steel Tool Bits & Cut-Off Blades



Square & Round Tool Bits

Forms		Measures	
		W	L
Size in inches			
W/d	L		
1/8	2 1/2	3	4
3/16	2 1/2	3	4
1/4	2 1/2	3	4
5/16	2 1/2	3	4
3/8	3	4	4
7/16	3 1/2	4	4
1/2	3	4	4
5/8	4 1/2	6	8
3/4	4	5	6
7/8	6	8	10
1	6	7	8
1.1/8		8	10
1.1/4		8	10
1.1/2		8	10

Forms		Measures	
		d	L
Corresponding Size in mm			
W/d	L		
3	65	75	100
5	65	75	100
6	65	75	100
8	65	75	100
10	75	100	150
11	90	100	150
12	75	100	150
16	115	150	200
20	100	125	150
22		150	200
25		150	175
30		200	250
35		200	250
40		200	250

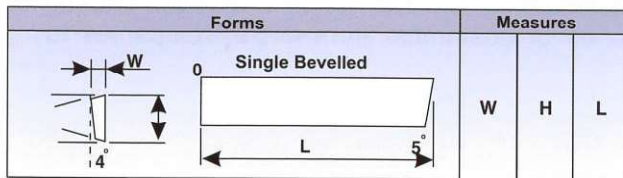
Rectangular / Flat Tool Bits

Forms		Measures		
		W	H	L
Size in inches				
W	H	L		
1/8	1/2	4		
1/4	3/8	4		6
1/4	1/2	3	4	6
1/4	3/4	4	5	6
1/4	1			6
5/16	3/8	4		
5/16	7/16	3		
5/16	1/2	4		
5/16	3/4	4		
5/16	1			6
3/8	1/2	3	4	
3/8	5/8	4	5	6
3/8	3/4	4	5	6
3/8	1			6
1/2	3/4	4	5	6
1/2	1			6
1/2	1 1/4			7
1/2	1 1/2			7
5/8	3/4	5	6	
5/8	7/8			6
5/8	1	4	6	7
5/8	1 1/4	4	6	7
5/8	1 1/2			6
3/4	1			6
3/4	1 1/2			7
1	1 1/4			6

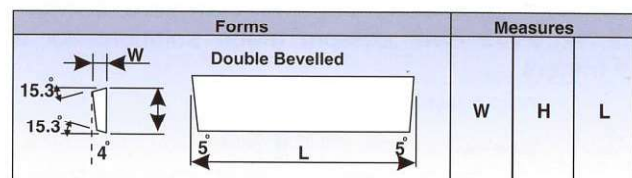
Corresponding Size in mm				
W	H	L		
3	12	100		
6	10	100		150
6	12	75	100	150
6	20	100	125	150
6	25			150
8	10	100		
8	11	75		
8	12	100		
8	20	100		
8	25			150
10	12	75	100	
10	16	100	125	150
10	20	100	125	150
10	25			150
12	20	100	125	150
12	25			150
12	32			175
12	38			175
16	20	125	150	
16	22			150
16	25	100	150	175
16	32	100	150	175
16	38			150
20	25			150
20	38			175
25	32			150

High Speed Steel Tool Bits & Cut-Off Blades

Single & Double Bevelled Tapered Ground Cut-Off Blades

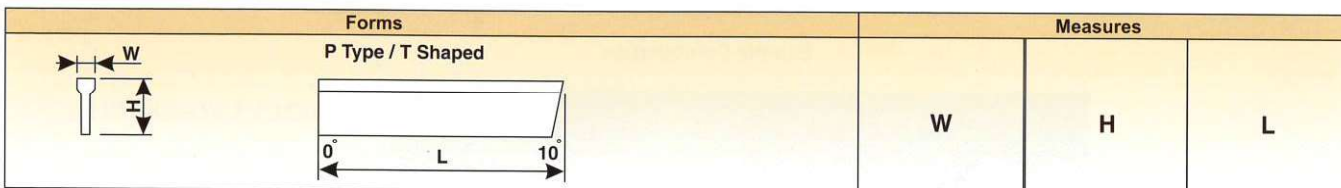


Size in inches			
H	L		
1/2	4 1/2		
1 1/16	5		
1/2	4 1/2		
5/8	5		
1/2	4 1/2		
3/4	5		
7/8	6		
3/4	6		
1	6 1/2		
1 1/8		7	
1 1/8		7	
1 1/4		7	



Corresponding Size in mm			
W	H	L	
1.50	12	115	
1.50	18	125	
2.50	12	115	
2.50	16	125	
3	12	115	
3	20	125	
3	22	150	
5	20	150	
5	25	165	
5	28	175	
6	28	175	
6	32	175	

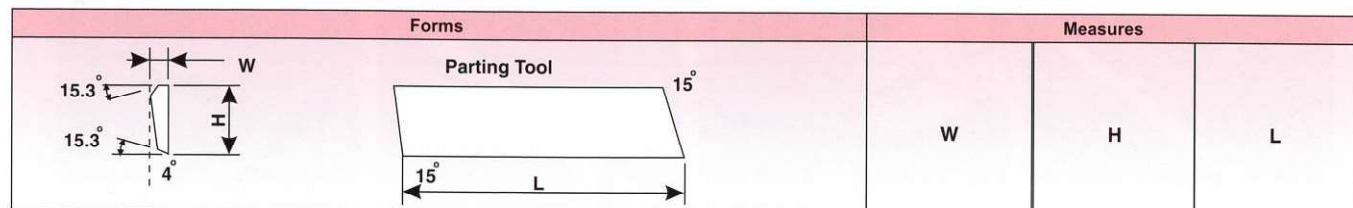
P - Type / T - Shaped Cut-Off Blades



Size in inches			
Ref. No.	W	H	L
P1N	0.40	1/2	3.1/2
	1/16	1/2	4 1/2
P2N	5/64	1/2	4 1/2
	3/32	1/2	4 1/2
P3S	1/8	1/2	4 1/2
P3N	3/32	1 1/16	5
P3W	1/8	1 1/16	5
P4W	5/32	1 1/16	5
	3/16	1 1/16	5
P5X	1/8	3/4	5
P5N	5/32	3/4	5
	3/16	3/4	5
	1/8	7/8	6
P8N	5/32	7/8	6
	3/16	7/8	6
	1/4	7/8	6

Corresponding Size in mm			
Ref. No.	W	H	L
P1N	1		90
P1	1.50	12	115
P2N	2	12	115
P2	2.50	12	115
P3S	3	12	115
P3N	2.50	18	125
P3W	3	18	125
P4W	4	18	125
P52	5	18	125
P5X	3	20	125
P5N	4	20	125
P5	5	20	125
P8	3	22	150
P8N	4	22	150
P8	5	22	150
P9	6	22	150

Parting Tools



Size in inches		
W	H	L
3/32	1/2	4
3/32	5/8	5
1/8	3/4	6
1/8	7/8	6
3/16	1	6

Corresponding Size in mm		
W	H	L
2.50	12	100
2.50	16	125
3	20	150
3	22	150
5	25	150

Private Label

Along with the sale of MAGICUT branded products we sell Private Label Tools as well where we offer all products manufactured by us with the required brand, colour, printing, packaging, etc. We have our in house team that can offer the complete service required including the design of the logo, packaging labels, etc. We have custom made solutions for all categories of customers from larger companies to small traders.

WE PRINT YOUR LOGO

Colour options

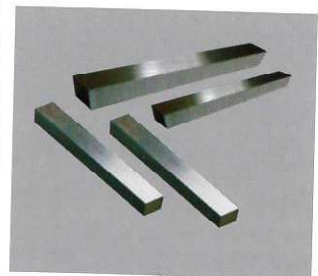
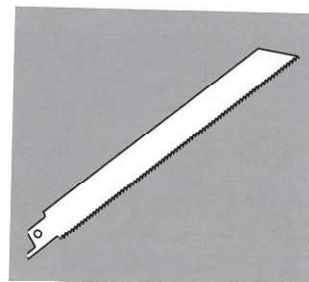
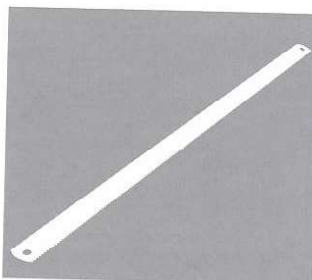
	Turkish Blue		Orange
	Black		Green
	Red		Yellow
	White		Light Blue

Ink options

	White
	Red
	Black
	Orange

Sample Combination

We	Print	your	Logo
We	Print	your	Logo
We	Print	your	Logo
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Packaging

- Segregated by Colour

Bimetal HSS



All Hard HSS



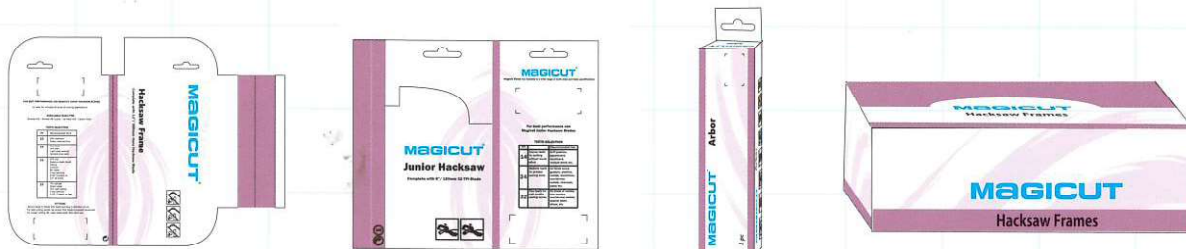
Bimetal 8% Cobalt



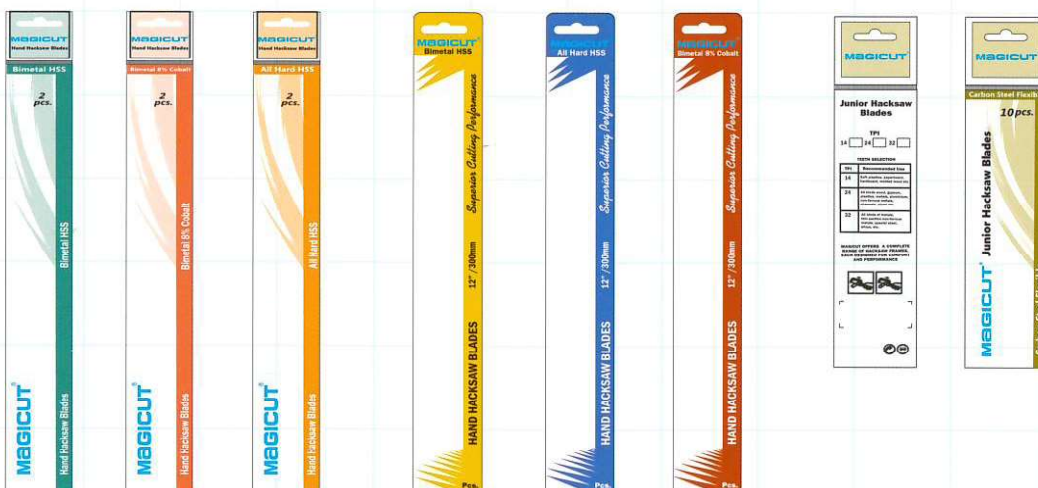
Carbon Steel



Hacksaw Frames & Arbors



Retail Pack





MAGICUT[®]

ULTRA TOOLS

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Tel: (022) 4970 7474 / 4973 0505 Email : sales@ultratools.in

Due to continuous products development and improvement, ULTRA TOOLS reserves the right to modify product design, specification and material without prior notice. E & O.E.

MAGICUT19