

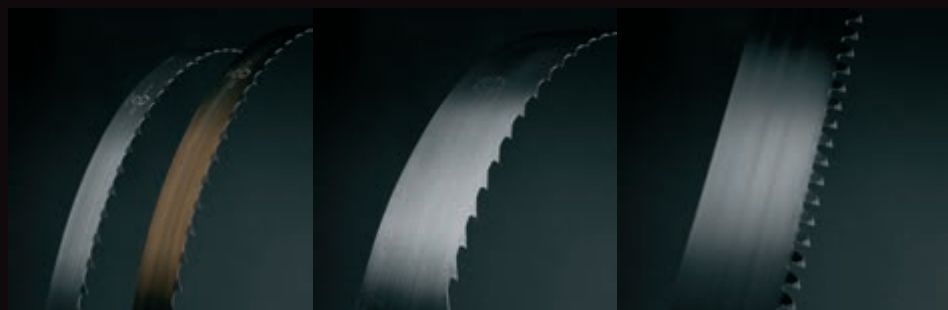


cutting tools

product catalogue

**RoMa**  
*born to be sharp*

R O - M A   M A C H I N E   C U T T I N G   T O O L S



**Mazovia.**  
heart of Poland

# index

→ <b>Operation.</b> Rules of keeping saws' high efficiency.	<b>02</b>
→ <b>Medium band saws.</b> Tytan Säge, Gold Säge, Silver Säge.	<b>04</b>
<b>Medium band saws.</b> Rules of operation.	<b>05</b>
<b>Medium band saws.</b> Solving operational problems.	<b>06</b>
→ <b>Wide band saws and gang saws.</b> Services.	<b>07</b>
→ <b>Wide band saws.</b> Raw, swaged, stellited.	<b>08</b>
<b>Wide band saws.</b> Rules of operation.	<b>09</b>
<b>Wide band saws.</b> Solving operational problems.	<b>10</b>
→ <b>Gang saws.</b> Short Trak - gang saws in mini version.	<b>11</b>
<b>Gang saws.</b> Raw, set, stellited, chromed.	<b>12</b>
<b>Gang saws.</b> Rules of operation.	<b>13</b>
→ <b>Carpenter's band saws.</b> Raw, RO, Gold, Gold HORN.	<b>14</b>
→ <b>Cutting bands.</b> Cutting polyurethane, paper and textiles.	<b>15</b>
→ <b>Abrasive disks.</b> Ro-Ma, Andre, borazone.	<b>16</b>

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→ **How useful our success is to others**  
– that's the real measure of our value...



President **Roman Stupecki**



Vice-President **Maciej Stupecki**

We have been with you since 1974 and we continuously develop and change to meet your needs. Cutting tools have become our mutual passion. We do our best to improve them all the time and you – our customers – make us face new, inspiring challenges every day, which we very much appreciate. We have ambitious plans for the future as we want to make the best use of our thorough knowledge and vast experience. The new investments will help our company to grow firmly and steadily.

We proudly present a new edition of our catalogue. You will find numerous changes in the content arrangement. Our goal was to create a useful guide to our products. Information in this catalogue is grouped by different types of saws: medium band saws, wide band saws, gang saws. We hope that this configuration will be clear and helpful in finding all the information you need.

We recommend you our products with full responsibility!

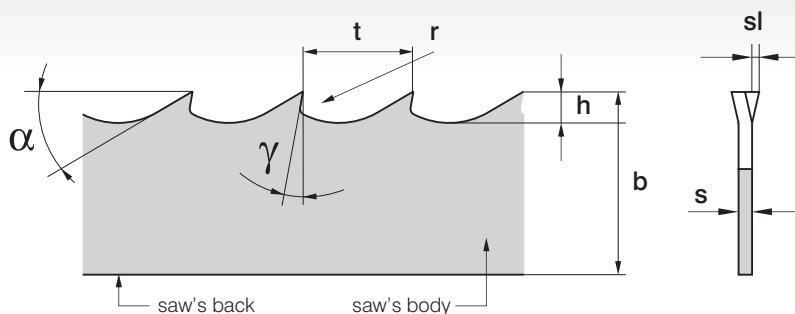
**Roman Stupecki**, President  
**Maciej Stupecki**, Vice-President

## 🔧 Saws operation

### Rules of keeping saws' high efficiency

#### → Selecting a band saw

- b** width of saw
- s** thickness of saw
- sl** value of saw's set on side
- t** tooth pitch
- h** height of tooth
- $\gamma$  tool rake angle
- $\alpha$  clearance angle
- r** gullet rounding radius



As a condition of correct sawing, the right saw has to be selected depending on the type of machine and material to be sawn.

Thickness of the saw should correspond to the machine technical specification, however, the thicker the saw, the more it is exposed to wear cracking. For hard wood thinner saws are recommended, for soft – thicker.

Width of the saw should be equal to the width of the guide pulleys adding the saw's gullet depth + (1-3) mm.

The pitch of the saw is expressed as a distance between two neighbouring teeth tips. Selecting proper pitch depends on both dimension and hardness of wood being sawn.

The tool rake angle is an angle included between the cutting edge's surface and the line perpendicular to the saw's back. An excessive tool rake angle to the feed applied causes saw's vibration, affecting the smoothness of the resulting surface. On the other hand, as the tool rake angle is insufficient, the saw end up being forced in the wood. The smaller the tool rake angle, the lower the cutting effectiveness.

#### → Material for sawing

The wood intended for sawing should be barked or cleaned thoroughly, using high-pressure stream of water. The wood should be free of any dirt, sand or metal chips.

The material for sawing should be locked in a fixed position, preventing it from moving while being cut.

**Hardness of wood** - in order to select the right saw it is helpful to divide wood into two following groups, with respect to its hardness: **soft raw wood** (aspen, poplar, willow, fir, lime-tree, birch, alder, spruce, pine-tree, larch) and **hard wood** (elm, oak, ash-tree, beach-tree, hornbeam, ebony).

#### → Sawing

The guide pulleys and the rolls should be cleaned of chips and resin. The guide pulleys should be set in one line. Move the guide rolls to the material sawn as close as possible. It is very important to take care of a good condition of the guide rolls. The surface of the rolls should have the same dimensions in every place, it is unacceptable to enable appearing any inequalities. Used rolls cause cracking of the saws and waviness during work.

The strain of the saw should correspond to the machine technical specification. Sawing should be started after obtaining required speed. The machine technical specification contains the information about the maximum speed. It depends on the material sawn, the harder the wood is, the lower speed is recommended. After work the saw blade should not be left strained, it is necessary to loosen the strain.



### → Working time

Working time should correspond to the recommendations given to different types of saws. It will help to avoid overheating and excessive fatigue of the saw. It is recommended to hang the saw to rest for 12 hours and to sharpen it.

### → Cooling

When high parameters are set while cutting wood, the saw's toothing tends to overheat. Accordingly, it is necessary to ensure proper cooling of the saw and, possibly, to adjust its strain, as changes in the saw's temperature can affect the value of its strain.

### → Sharpening

The saw should be sharpened in a few passes through the sharpener. The first pass should be regarded as the initial one, the second and the third as equalizing and the next as smoothing ones. The saw's sharpening should include the whole profile of the tooth (it is a common mistake to sharpen only the front cutting surface).

The sharpening of the saw, if done correctly, leaves neither burn marks in the saw's gullets of the toothing nor dapping marks left by the abrasive disk. It is important to maintain an ample saw's gullet radius. When the radius is insufficient, cracks may appear in the saw's gullet.

Frequent sharpening is beneficial to the saw's durability because it eliminates micro-cracks in the saw's gullets. Each sharpening should be carried on until micro-cracks are eliminated. After sharpening any surface irregularities left should be filed away. If left on the cutting edge, such surface irregularities tend to wrap along the tooth during cutting and the saw becomes blunt at one side.

Overheating of the cutting edges, the teeth and the saw's gullets are very frequent sharpening defects, they may be caused by:

- :: excessive feed,
- :: mis-selected abrasive disk's parameters,
- :: incorrect abrasive disk's profiling and setting with respect to the teeth.

### → Setting

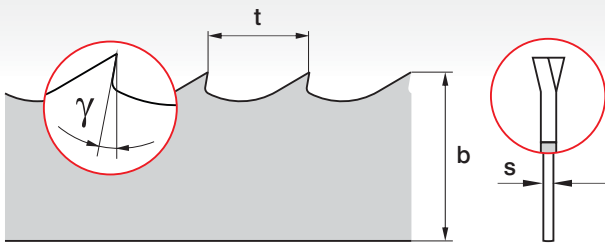
Setting is an operation which provides the saw's cutting ability. It means bending the teeth in sequence left-right-straight or left-right (in case of the gang saws) in relation to the saw's body. The saw's teeth must be set symmetrically, otherwise operational problems may appear.

Setting should begin at 1/2 or 2/3 (depending on the kind of the saw and the height of the edge) height of the tooth measured from its tip. Recommended setting values are measured to the side from the saw's body on the sharpened saw.

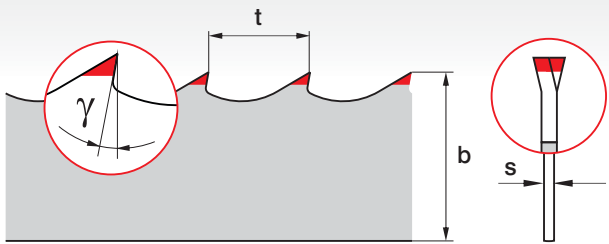


Medium band saws

Tytan Säge Gold Säge Silver Säge



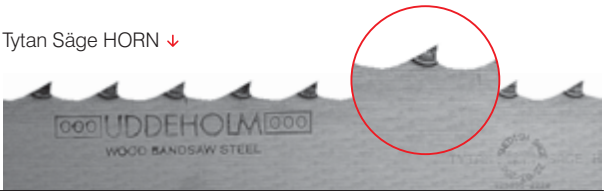
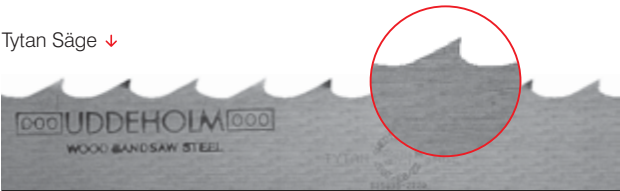
raw, RO



HORN

→ Tytan Säge | Tytan Säge HORN

b x s [mm] 35 x 1,1 40 x 1,1 (Uddeholm)



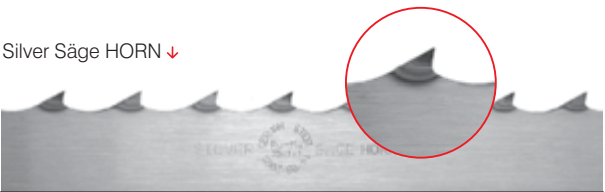
→ Gold Säge | Gold Säge HORN

b x s [mm] 32 x 1,1 33 x 1,0 35 x 0,8 35 x 0,9 35 x 1,0 35 x 1,1 38 x 1,15 40 x 1,0 40 x 1,1 42 x 1,0 50 x 1,0 60 x 1,0



→ Silver Säge | Silver Säge HORN

b x s [mm] 32 x 1,1 35 x 0,9 35 x 1,0 35 x 1,1 40 x 1,0 40 x 1,1 50 x 1,0 50 x 1,1



# tytan gold silver

Tytan Säge Gold Säge Silver Säge

General information

→ Basic information

Saws available: **raw**, **RO** (set, sharpened), **HORN** (hardened, set, sharpened).

We manufacture saws for **soft wood** as well as for **hard** and/or **frozen wood**. The latter ones should be additionally **marked with T symbol while ordering**.

Pitches available: **t=22,23** mm / b=50 mm and b=60 mm: **t=22,23** mm or **t=25** mm.

Steel: **Swedish alloy steel** (Tytan Säge), **alloy steel** (Gold Säge), **alloy carbon steel** (Silver Säge).

→ Hardness of saws

Saw's name	Tytan Säge	Tytan Säge HORN	Gold Säge	Gold Säge HORN	Silver Säge	Silver Säge HORN
Saw's body	47-49 HRC	47-49 HRC	45-47 HRC	45-47 HRC	43-45 HRC	43-45 HRC
Hardened teeth	-	59-62 HRC	-	56-59 HRC	-	53-56 HRC

→ Use

Saws for sawing any kind of wood. **Tytan Säge HORN** provides highly effective performance on hard wood, frozen wood, exotic wood and wood with large density. **Tytan Säge** provides highly effective performance on hard wood and frozen wood. **Gold Säge HORN** provides highly effective performance on hard wood, frozen wood, exotic wood and wood with large density. **Silver Säge HORN** provides highly effective performance on hard wood and frozen wood.

→ Rules of usage

**Cooling** - the saw requires very abundant cooling to prevent overheating. In summer water is recommended for cooling; during winter season, however, it is recommended to use crude oil for cooling.

→ Working time (h + 12 h rest time = sharpening)

Tytan Säge **3 h** | Tytan Säge HORN **3,5 h** | Gold Säge **2,5 h** | Gold Säge HORN **3 h** | Silver Säge **1,5 h** | Silver Säge HORN **2 h**

→ Sharpening

Ro-Ma or ANDRE bakelite abrasive disk; with borazone Ro-Ma abrasive disk adapted to the geometry of the teeth (with oil cooling). The cutting edge's height of the saws should be as follows: **5,2** mm (for hard wood) or **6,5** mm (for soft wood).

→ Setting

At 2/3 height of the tooth measured from its tip. Recommended setting values are measured to the side from the saw's body on the sharpened saw. For soft raw wood they should be: **0,40** mm to **0,65** mm per side; for hard and/or frozen wood: **0,30** to **0,45** mm per side.

⋮ **Operational problems**

Tytan Säge Gold Säge Silver Säge

→ **Cracking in a saw's gullet** [possible causes]

[suggested solutions]

sharpening the part of the tooth's profile	sharpen the whole tooth's profile
burn marks in the saw's gullets after sharpening, deep scratches on the saw left after sharpening	match the abrasive disk, adapt the profile of the abrasive disk, use cooling and required feed during sharpening
dull blade	stop working, sharpen the saw
incorrect setting (too small, too big, asymmetrical)	correct the setting
saw overheated – continuous work with no rest	adhere to the recommendations given
the gullet rounding radius too small	sharpen the saw increasing the radius
incorrect saw's strain	set the strain according to the machine technical spec.
the diameter of the guide pulleys too small	use a thinner saw
the cutting edges went in contact with the material before the proper operating speed was achieved	start cutting no sooner than the proper operating speed is achieved, according to the machine technical spec.
leaving the saw strained after work	always loosen the strain after work

→ **Cracking at the back side** [possible causes]

[suggested solutions]

incorrect saw's strain	set the strain according to the machine technical spec.
excessive feed – saw overload	decrease the feed
saw overheated – continuous work with no rest	adhere to the recommendations given
the guide pulleys in poor condition, not set in one line	regulate the guide pulleys, set them in one line
worn or dirty guide rolls, not set in one line	move the rolls close to the cutting zone, clean and set them in one line
incorrect width of the guide rolls to saw's width	match the proper guide rolls
vibrations of the pulleys or the gears, axial run-out of the pulleys	replace worn out bearings

→ **Wavy motion of a saw** [possible causes]

[suggested solutions]

incorrect setting (too small, asymmetrical)	correct the setting
excessive surface irregularities left after sharpening	smoothen the sharpened surface and correct the setting
low cutting speed, excessive feed	check and correct the strain of the saw and the driving belts; decrease the feed
the cutting edge of the band wandering along the guide pulleys (decreasing the setting at one side)	use a broader saw, correct the setting's symmetry
incorrect saw's strain	set the strain according to the machine technical spec.
unstable locking of the material cut	lock the material firmly in a fixed position
worn out bearings of the pulleys, rolls, play in the saw's strain system	replace (repair)



# wide band saws, gang saws

Stelliting Swaging Chromium plating Adjusting

Services ::::

## → Stelliting [wide band saws, gang saws]

The process of stelliting consists in hardening the teeth by metal alloy called stellite (cobalt 65%, chrome 25%, tungsten 8%, other metals additions 2%). Stellite features outstanding resistance to thermal wear of toothing, retaining its cutting characteristics at temperatures up to 800°C.

Modifying the saw's teeth by stelliting increases the hardness of the cutting edge and gives users significant benefits:

- :: working time between the sharpening operations extended several times,
- :: extended saw's durability,
- :: possibility of setting an increased feed (up to 50% in relation to set saws),
- :: enhanced sawing precision (stiffness and flexibility of the saw, precision of cutting, minimum wandering of blade),
- :: high resistance to wear and overheating as well as to activity of chemical compounds contained in wood.

## → Swaging [wide band saws]

Swaging consists in upsetting part of the toothing close to the tooth's tip. During the operation of swaging equalising is also made. Equalising shapes side surfaces of the saw, ensuring equal size and identical shape on its both sides.

Modifying the saw's teeth by swaging increases the hardness of the cutting edge and gives users significant benefits:

- :: working time between the sharpening operations extended several times,
- :: extended saw's durability,
- :: possibility of setting an increased feed (up to 25% in relation to set saws),
- :: enhanced sawing precision (such saws work in more regular way, since teeth in rift work using all the edge width, increased smoothness of surfaces of materials sawn).

## → Chromium plating [gang saws]

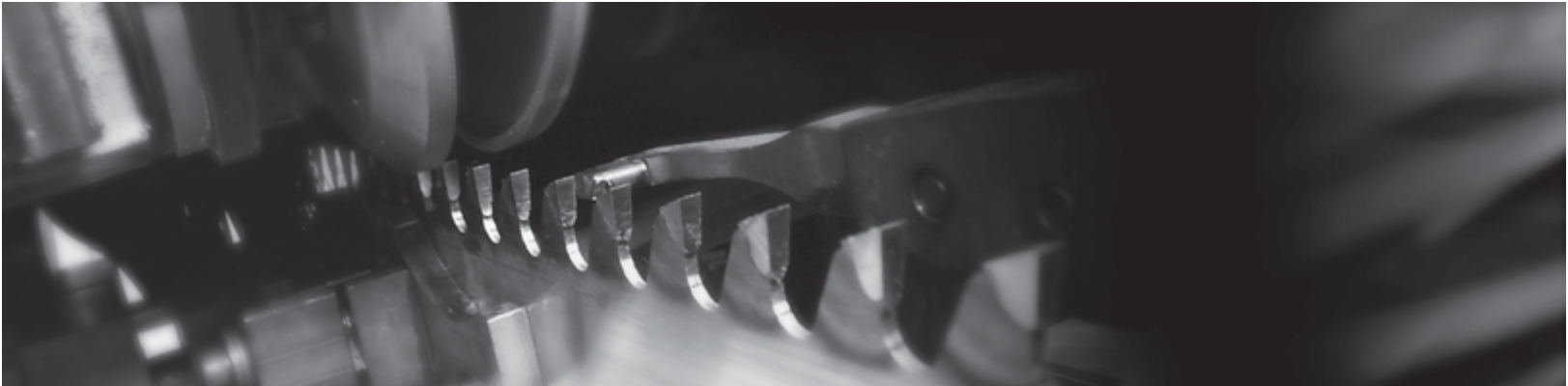
Gang saws are subject to galvanising in order to harden their surface layer, improve their wear resistance and anti-corrosion properties. Chrome is a hard, silver-bluish metal featuring melting temperature of 1857°C. It is resistant to organic acids (as well as to nitrogen acid and hydrosulphuric acid).

Chromium plating increases the hardness of the cutting saw and gives users significant benefits:

- :: working time between the sharpening operations extended several times,
- :: extended saw's durability,
- :: possibility of setting an increased feed (up to 20% in relation to set saws),
- :: enhanced resistance to corrosion, high temperatures and dirt or foreign objects in wood,
- :: enhanced sawing precision (smoother surface of wood cut),
- :: the chrome layer decreases adhesion of the saw, resulting in less chips adhering to its working surfaces.

## → Adjusting [wide band saws]

The operations of adjusting include levelling, tensioning and straightening. Levelling means elimination of any irregularities on the surface of the saw's body. Tensioning is achieved through rolling, straightening is an equalization of the saw's back. The information about the width of the sawing machine's guide pulleys and the amount of the crown is very important. The Ro-Ma's offer includes both symmetric (1/2 of the saw's width) and asymmetric (1/3 of the saw's width) tensioning and others depending on our Customer's needs. The operation of adjusting is crucial for the wide saws' proper work. It improves stiffness of the saw during work and ensures its proper fit on the pulleys. Working with the saw without adjustment or with incorrect adjustment causes problems with its exploitation and damages in the sawing machine.

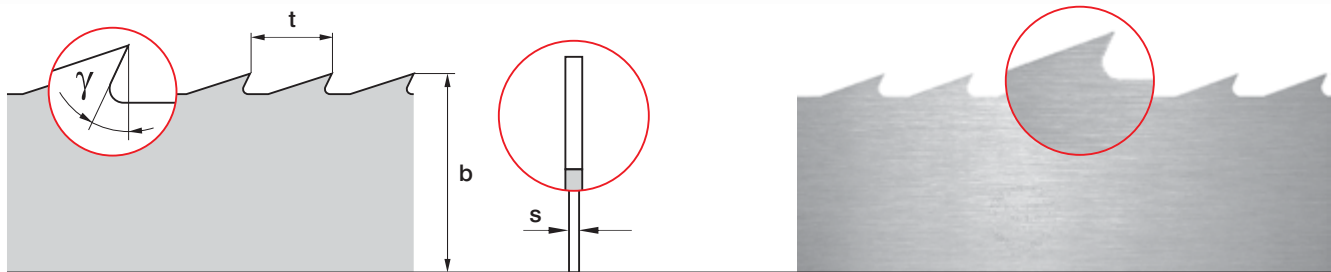


Wide band saws

Raw Swaged Stellited

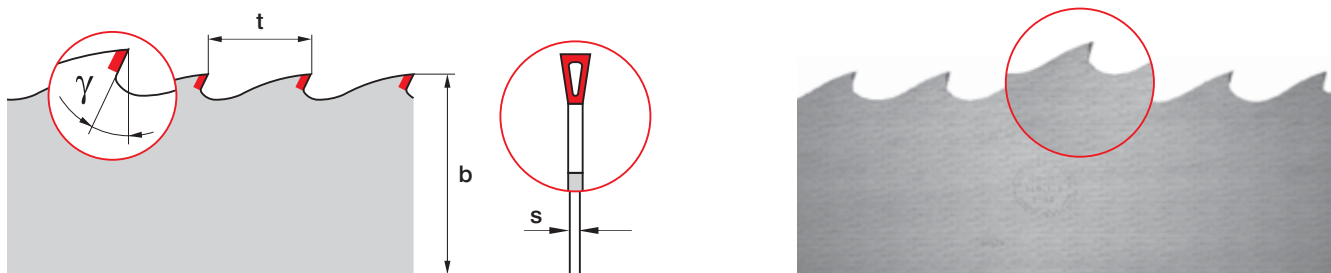
Raw

R - for setting



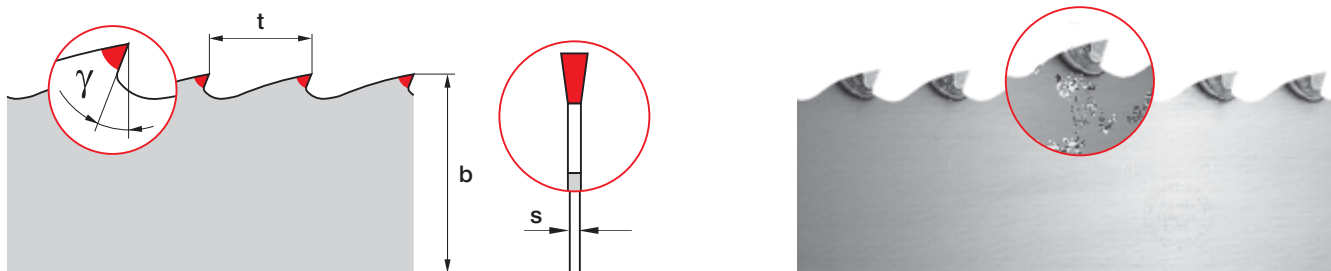
Swaged

Z - for swaging



Stellited

S - for stelliting



Parameters/ Steel

German Steel	b x s [mm]	80 x 1,0	80 x 1,1	100 x 1,0	100 x 1,1	100 x 1,2	100 x 1,6	104 x 1,25
		110 x 1,1	120 x 1,1	130 x 1,2	130 x 1,3	140 x 1,2	150 x 1,3	160 x 1,3
		180 x 1,4	200 x 1,4	206,4 x 1,47	230 x 1,4	230 x 1,5	230 x 1,6	
Uddeholm	b x s [mm]	100 x 1,0	110 x 1,1	130 x 1,2	140 x 1,1	160 x 1,3	180 x 1,47	206,4 x 1,47
		260,4 x 1,83						

# wide band saws

## Wide band saws

## General information

### → Basic information

Saws available: **raw**, **swaged**, **stellite**.

Teeth available: **R** (for setting), **Z** (for swaging), **S** (for stellite).

Pitches available: **t=25-50 mm**. For the following widths of the saws (**b**) we recommend the following pitches (**t**):

b	80 - 90	100 - 120	130 - 140	150 - 160	180 - 260
t	25	30	35	40	50

### → Hardness of saws

Saw's body **44-46 HRC** | Swaged teeth **46-48 HRC** | Stellite teeth **49-51 HRC**

### → Use

Saws for sawing round wood and for flitching. **Set wide band saws** provide highly effective performance on soft and fresh wood. **Swaged wide band saws** provide highly effective performance on hard and frozen wood. **Stellite wide band saws** provide highly effective performance on some types of exotic wood, featuring mineral inclusions such as makore or azobe. Foreign objects in the form of chips up to 1 mm wide present no risk of damaging the cutting edge.

### → Rules of usage

**Cooling** - the saw requires very abundant cooling to prevent overheating.

### → Working time (h + 12 h rest time = sharpening)

Set saws **1-2 h** | Swaged saws **2-3 h** | Stellite saws **3-4 h**

### → Sharpening, setting, swaging, stellite

During sharpening you must work according to the instructions of the sharpener's manufacturer. Setting, swaging – at 1/2 or 2/3 height of the tooth measured from its tip, depending on its height. We recommend the following values per side [mm]:

thickness of saw	type of wood	setting values	swaging, stellite values
1,0 - 1,25	fresh, soft	0,60 - 0,75	0,60 - 0,65
	hard, frozen	0,50 - 0,65	0,50 - 0,55
1,3 - 1,47	fresh, soft	0,70 - 0,85	0,65 - 0,70
	hard, frozen	0,60 - 0,75	0,55 - 0,60
1,5 - 1,83	fresh, soft	0,80 - 0,95	0,65 - 0,80
	hard, frozen	0,70 - 0,85	0,55 - 0,70

- i** We adjust wide band saws. Adjustment includes: leveling, tensioning and straightening. It is necessary to inform about the amount of the crown (usually it is 1/2 or 1/3 of the saw's width).  
We recondition wide band saws. Reconditioning includes: preparation, stellite tipping and sharpening of saw.



⚙️ **Operation problems**

**Wide band saws**

→ **Cracking in a saw's gullet** [possible causes]

[suggested solutions]

sharpening the part of the tooth's profile	sharpen the whole tooth's profile
burn marks in the saw's gullets after sharpening, deep scratches on the saw left after sharpening	match the abrasive disk, adapt the profile of the abrasive disk, use cooling and required feed during sharpening
dull blade	stop working, sharpen the saw
the gullet rounding radius too small	sharpen the saw increasing the radius
saw overheated – continuous work with no rest	adhere to the recommendations given
incorrect saw's strain	set the strain according to the machine technical spec.
the cutting edges went in contact with the material before the proper operating speed was achieved	start cutting no sooner than the proper operating speed is achieved, according to the machine technical spec.
leaving the saw strained after work	always loosen the strain after work
irregular back of the saw	correct by adjusting
incorrect setting (too small, too big, asymmetrical)	correct the setting
overworked surface of the guide pulleys	grind the surface of the guide pulleys regularly
irregularities of the guide pulleys' surface	grind the guide pulleys
sawdust and chips between the saw and the guide pulleys	keep the working surface of the guide pulleys clean

→ **Irregular cut** [possible causes]

[suggested solutions]

incorrect saw's strain	set the strain according to the machine technical spec.
the guide pulleys in poor condition, not set in one line	regulate the guide pulleys, set them in one line
incorrect tool rake angle	correct the tool rake angle by sharpening
incorrect pitch chosen	choose the correct pitch
asymmetrical setting	correct the setting
asymmetrical swaging, stelliting	correct the swaging, the stelliting by grinding sides

→ **Saw wandering along guide pulleys** [possible causes]

[suggested solutions]

incorrect amount of the crown	adjust the band saw again (according to the amount of the crown on the guide pulleys)
incorrect tool rake angle	correct the tool rake angle by sharpening
incorrect saw's strain	set the strain according to the machine technical spec.
overworked surface of the guide pulleys	grind the surface of the guide pulleys regularly
irregularities of the guide pulleys' surface	grind the guide pulleys



# gang saws

Gang saws in mini version **Short Trak**

**Gang saws** ::::

## → **Short Trak** Raw | Set | Stellite



## → **Stellite Short Trak** For narrow kerf cutting | For comminution



## → **Parameters**

Widths of saws available: **b** [mm] 35 to 80 | Thicknesses of saws available: **s** [mm] 0,8 to 2,45

## → **Use**

Saws for sawing every kind of wood. **Stellite Short Traks for narrow kerf cutting** are recommended for cutting thin boards. The saws are effective in sawing soft wood, wood of deciduous trees. **Stellite Short Traks for comminution** are recommended for cutting wood into the timber and for stiffening the frame (they are placed in the saw frame between the saws for narrow kerf cutting).

## → **Benefits**

- :: high precision of cutting,
- :: minimum cutting kerf which enables better use of wood (up to 20% wood saving),
- :: very economical,
- :: saws allow further processing of lamellas without any additional work stages,
- :: clean surfaces after sawing, ready to glue.

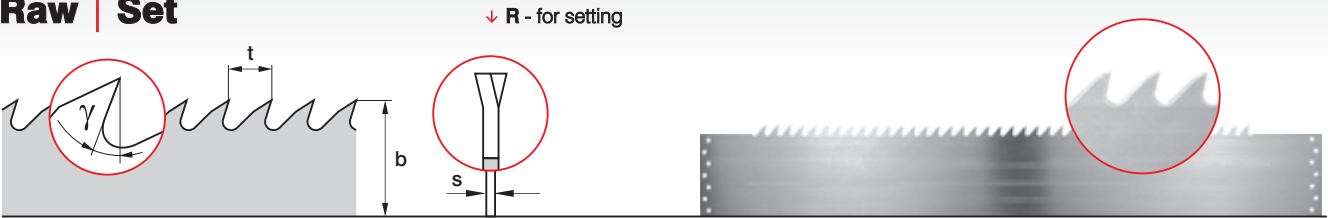
These saws are cut using laser that enables wide range of performance depending on the Customer's needs. Ro-Ma offers various materials, dimensions and methods of performance. The final product we supply fits all the specific of application.

- ❗ Short Trak saws are produced on special orders. The order should include exact parameters of the saw, drawing and kind of material.

**Gang saws**

Raw Set Stellited Chromed

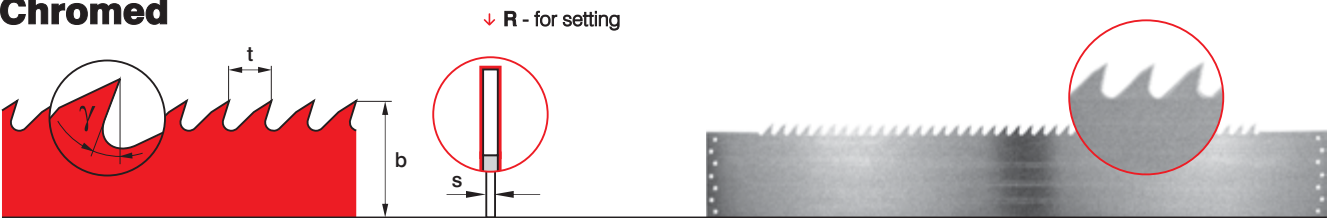
→ **Raw | Set**



→ **Stellited**



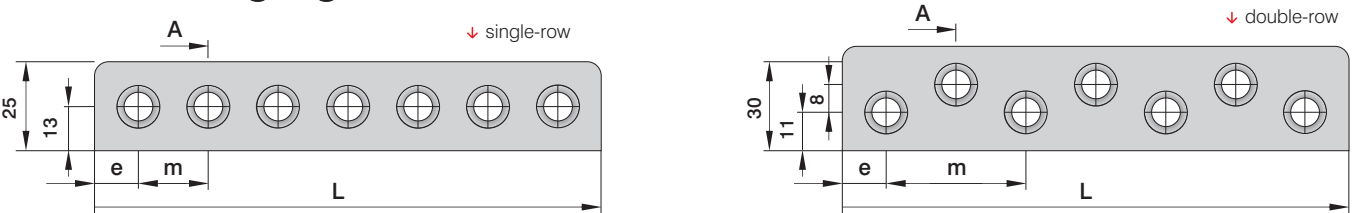
→ **Chromed**



→ **Parameters/ Steel**

German Steel	b x s [mm]	140 x 2,2	160 x 2,2	180 x 2,45
Uddeholm	b x s [mm]	140 x 2,2	160 x 2,2	

→ **Borders for gang saws**



→ **Parameters**

Width of border 25 mm	e [mm]	12,5	m [mm]	20	L [mm]	125   145   165
Width of border 30 mm	e [mm]	10,0	m [mm]	35	L [mm]	125
	e [mm]	12,5	m [mm]	40	L [mm]	145
	e [mm]	16,5	m [mm]	44	L [mm]	165

# gang saws

## Gang saws

## General information

### → Basic information

Saws available: **raw, set, stellited, chromed.**

Teeth available: **R** (for setting), **S** (for stelliting).

Pitches available: **t=25 mm / t=26 mm / t=30 mm.**

### → Hardness of saws

Saw's body **45-47 HRC; 48-49 HRC** (Uddeholm) | Stellited teeth **49-51 HRC** | Chromium coating **15-20 mm**

### → Use

Saws for sawing every kind of wood. **Set gang saws** provide highly effective performance on soft and fresh wood. **Stellited gang saws** provide highly effective performance on some types of exotic wood, featuring mineral inclusions such as makore or azobe. Foreign objects in the form of chips up to 1 mm wide present no risk of damaging the cutting edge. **Chromed gang saws** provide highly effective performance on hard wood, frozen wood and wood rich in resin.

### → Working time (h + 12 h rest time = sharpening)

Set saws **2-3 h** | Stellited saws **5-7 h** | Chromed saws **3-5 h**

### → Sharpening, setting, stelliting

During sharpening you must work according to the instructions of the sharpener's manufacturer.  
Setting gang saws at 1/2 height of the tooth measured from its tip.  
We recommend the following values per side [mm]:

thickness of saw	type of wood	setting values	stelliting values
2,2	fresh, soft	0,90 - 0,95	0,85 - 0,90
	hard, frozen	0,80 - 0,85	0,75 - 0,80
2,45	fresh, soft	0,95 - 1,00	0,90 - 0,95
	hard, frozen	0,85 - 0,90	0,80 - 0,85

- ⓘ Gang saws are cut using laser.
- Gang saws are tensioned.
- We do special orders.
- We cut compensatory holes in saws.
- We recondition gang saws. Reconditioning includes: preparation, stellite tipping and sharpening of saw.

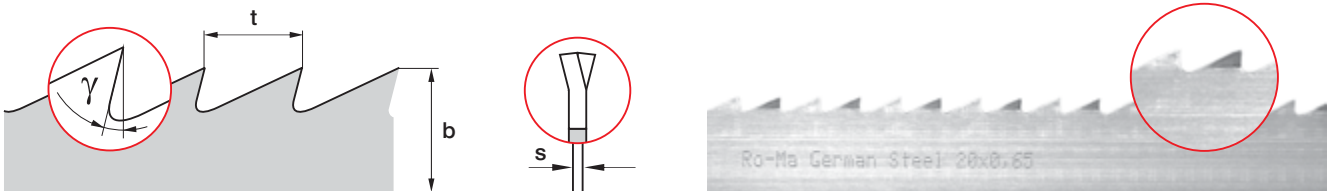
# carpenter's saws

## ⋮ Carpenter's band saws

Raw RO Gold Gold HORN

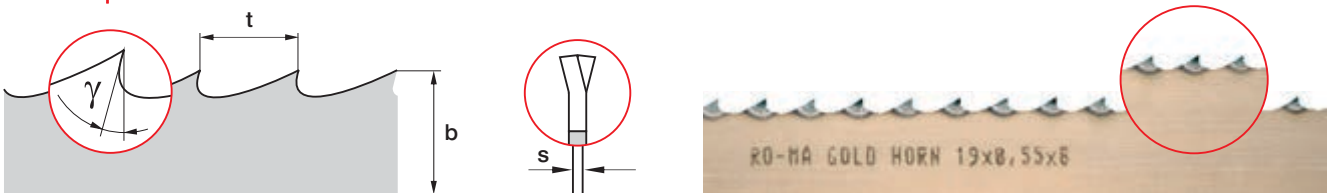
### → Raw | RO [set, sharpened]

↓ type A



### → Gold | Gold HORN

↓ type B



### → Parameters

rounded back of saw	b x s x t [mm]	6 x 0,5 x 4	8 x 0,5 x 5	10 x 0,6 x 6	12 x 0,6 x 6	15 x 0,65 x 7	16 x 0,55 x 8*
		19 x 0,55 x 8*	20 x 0,65 x 8	25 x 0,65 x 8	30 x 0,7 x 9	40 x 0,8 x 10	
not rounded back of saw	b x s x t [mm]	10 x 0,65 x 6	10 x 0,7 x 6	15 x 0,5 x 7	15 x 0,7 x 7	20 x 0,7 x 8	25 x 0,7 x 8
		30 x 0,8 x 9	35 x 0,8 x 9	50 x 0,9 x 12,5			
Gold   Gold HORN	b x s x t [mm]	16 x 0,55 x 8*	19 x 0,55 x 8*	35 x 0,8 x 9	35 x 0,9 x 9		

Saws available: **raw**, **RO** (set, sharpened), **Gold** (raw, RO), **Gold HORN** (hardened, set, sharpened).

Steel: **alloy carbon steel**, **alloy steel** (Gold and Gold HORN).

### → Hardness of saws

Saw's body **42-44 HRC**; **45-47 HRC** (Gold) | Hardened teeth **56-59 HRC** (Gold HORN)

### → Use

Saws for dry wood, chipboards, flaxboards, fibreboard, laminated board, plywood, plastics, wood derived materials.

### → Sharpening and setting

Sharpening - with ANDRE abrasive disk. Setting at 2/3 height of the tooth measured from its tip, 1/2 of width of the saw per side [mm].

❗ Toothing available: **type A**; for sizes marked with the star **type B** is also available.

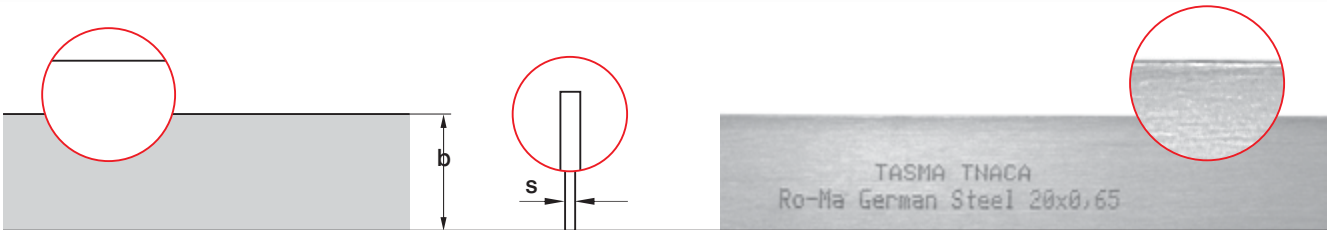


# cutting bands

Cutting **Polyurethane Paper Textiles**

Cutting bands 

→ **Cutting bands**



→ **Parameters**

<b>rounded back of band</b>	<b>b x s [mm]</b>	<b>10 x 0,6</b>	<b>12 x 0,6</b>	<b>15 x 0,65</b>	<b>20 x 0,65</b>	<b>25 x 0,65</b>	<b>30 x 0,7</b>	<b>40 x 0,8</b>
<b>not rounded back of band</b>	<b>b x s [mm]</b>	<b>10 x 0,65</b>	<b>10 x 0,7</b>	<b>15 x 0,5</b>	<b>15 x 0,7</b>	<b>20 x 0,7</b>	<b>25 x 0,7</b>	<b>30 x 0,8</b>
		<b>35 x 0,8</b>	<b>50 x 0,9</b>					

Cutting bands are available **unsharpened**.

Steel: **alloy carbon steel**.

→ **Use**

Bands for cutting polyurethane foam, paper and textiles.

→ **Hardness of bands**

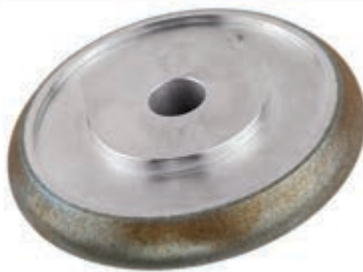
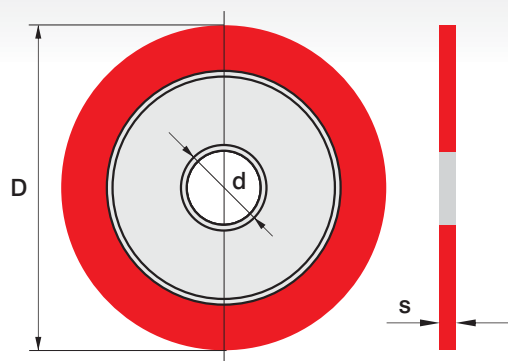
Hardness of band **42 - 44 HRC**



# abrasive disks

## ⋮ Abrasive disks

Ro-Ma Andre Borazone



↑ borazone



↑ bakelite

### → Abrasive disks for sharpening medium band saws / Parameters

Abrasive disk Andre	D x d x s [mm]	127 x 12,7 x 6	150 x 20,0 x 6	150 x 32,0 x 6
Abrasive disk Ro-Ma	D x d x s [mm]	127 x 12,7 x 5	150 x 20,0 x 5	150 x 32,0 x 5

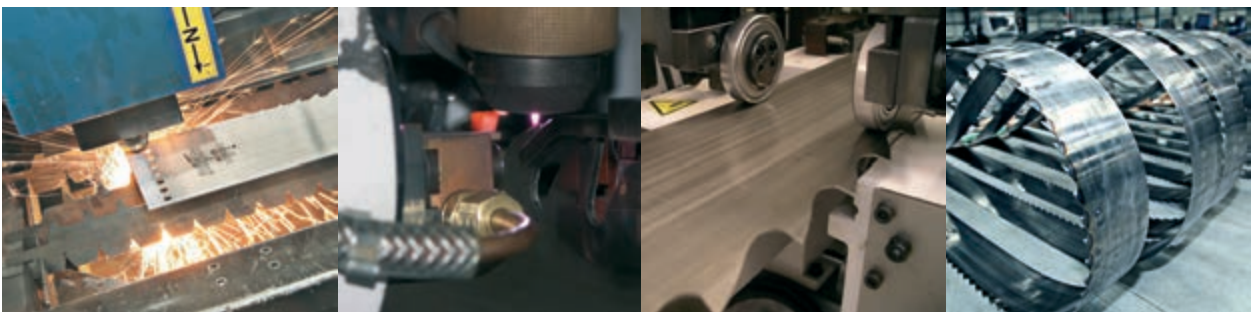
### → Abrasive disks for sharpening gang saws / Parameters

Abrasive disk Andre	D x d x s [mm]	200 x 32,0 x 8	200 x 32,0 x 10	250 x 32,0 x 10
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### → Borazone abrasive disks for sharpening medium band saws / Parameters

Borazone abrasive disk Ro-Ma	D x d [mm]	127 x 12,7	203 x 32,0
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❗ Borazone abrasive disk is adapted to the geometry of Ro-Ma blades.



# more

We encourage you to buy other products from our offer:

→ **Circular saws**

Circular saws for wood and wood derived materials ripping and cross-cutting. The bodies of the circular saws are made of high-quality alloy steel, available in HM-tipped type. The saws are produced on the Customer's request according to the dimension asked.

→ **Food-cutting band saws**

Band saws are recommended for cutting meat, meat with bones, cheese. Saws available: Silver Säge (RO: set, sharpened) and Silver Säge HORN (hardened, set, sharpened). They are available in the following dimensions: 16x0,55x8 and 19x0,55x8 (single tooth); 16x0,55x10 and 19x0,55x10 (with intertoothing). We have obtained the Health Quality Certificate given by the National Hygiene Organization.

→ **Metal-cutting band saws**

Resistant bimetallic band saws are made of fast-cutting steel (M42) mixed with fatigue resistant tool steel. The blades are effective in cutting solids and heavy-walled structures made of constructional steel, carbon steel, alloy steel. There is a variety of the dimensions available.



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Ro-Ma Co. Ltd. reserves the right to change the technical specifications.



# cutting tools

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