



# I.T.E.C.

Metal Cutting Solutions

Leading Through Innovation

10 | 2019

## DRYTECH<sup>®</sup> Dry - fast - burr free High-speed metal cutting saw blades

Carbide or cermet tipped saw blades are suitable for high speed stationary semi-automatic and full automatic cutting units!

- Fast cutting, burr free and without coolant of pipes and profiles made of:

**Steel, stainless steel, plastics, composite materials, aluminum and other non-ferrous metals**

The DryTech<sup>®</sup> saw blades are able to cut diverse kinds of material and shapes due to a wide range of different geometries (trims, tubes, shutter profiles, sandwich panels, window profiles and airing profiles etc.). The special tooth shape guarantees a perfect cutting surface and a long cutting life of the blade.

- Shortest cycle times due to high cutting speed
- Material saving through thin cut technology with wall thickness starting from 0,5 mm
- Flexible application in divers materials and shapes
- Very high durability
- Excellent cutting quality
- Up to 5 times resharpenable



Noise reduction due laser slots with resin



Range of Carbide-tipped Saw Blades											
Ø [mm]	Bore [mm]	Kerf [mm]	Teeth	Ref.	Application	Ø [mm]	Bore [mm]	Kerf [mm]	Teeth	Ref.	Application
160	30*	1,80	32	72016032	steel	255	25,4	2,00	60	2550600002	steel
180	30*	1,85	36	72018036	steel	255	25,4	2,00	66	2550661003	steel - thin
180	20	1,85	36	72118036	steel	305	25,4	2,20	60	3050600002	steel
180	20	1,60	48	72118048S	steel	305	25,4	2,00	72	3050720002C	steel & stainless
180	20	2,00	48	72	steel & stainless	305	25,4	3,00	72	3050720003C	cast iron
192	20	1,85	40	719240	steel	305	25,4	2,20	80	600540	steel - thin
192	20	1,85	48	719248	steel - thin	355	25,4	2,20	90	3550901004	steel & stainless - thin
192	20	1,85	48	719248A	aluminum	355	25,4	2,20	72	3550721003	steel & stainless - medium
192	20	1,85	70	719270	metal sheets	355	25,4	2,20	60	600590	steel & stainless - thick
200	30*	1,90	40	72020040	steel	355	25,4	3,40	96	3550960003	aluminum
200	30*	1,90	60	72020060	steel - thin	355	25,4	2,20	66	3550660002	steel
210	30*	2,00	42	72021042	steel	405	25,4	2,50	80	4050800002	steel
210	30*	2,00	64	72021064	steel - thin	405	25,4	2,50	102	4051021003	steel and stainless
230	30*	2,00	48	72023048	steel	455	50,0	3,40	100	4551000002	steel
230	30*	2,00	60	72023060	aluminum	455	50,0	3,40	120	4551201003	steel and stainless
230	30*	2,00	68	72023068	steel - thin	560	50,0	3,60	120	5601200002	steel
230	25,4	2,00	48	72123048	steel	560	50,0	3,60	132	5601321003	steel and stainless
230	25,4	2,00	48	72123048Y	steel & stainless	560	50,0	3,60	180	5601801004	steel and stainless
230	25,4	2,00	60	72123060	aluminum	630	60,0	4,00	140	6301400002	steel
230	25,4	2,00	68	72123068	steel - thin	630	60,0	4,00	150	6301501003	steel and stainless
230	25,4	2,00	84	72123084	metal sheets	630	60,0	3,60	210	6302100003	steel
* Reducing rings included: 30/25, 30/20, 30/16						730	60,0	4,00	210	7302100002	steel

**Special sizes on request!**

Saw blades with excellent performance in stainless steel				
Ø [mm]	Bore [mm]	Kerf [mm]	Teeth	Ref.
230	25,4	2,0	48	2300481003COA
255	25,4	2,0	66	2550661003COA
355	25,4	2,2	90	3550901004COA
405	25,4	2,5	102	4051021003COA
455	50,0	3,4	120	4551201003COA
560	50,0	3,6	132	5601321003COA

Specifications	
Saw blade diameter	125 - 730 [mm]
Cutting capacity	Ø 6 - 240 [mm]
Cutting speed	max. 1.800 [m/min]
Feed speed	max. 6.000 [mm/min]
Cutting width (kerf)	2,0 - 4 [mm]
Center hole	Customer specific
Pin holes	Customer specific

## Throw Away - Saw Blades High Tensile Tube Cutting

The choosed saw blades are one of the most important components in the preparation process of the mass production.

Therefore, very precise sawing of workpieces in the mass production request a high performance of the saw blades.

**Application:** Steel, stainless steel, non-ferrous steel, cast iron

Laser Beam Saw Blades - Product Range of High Tension				
Diameter	Kerf	Central bore	Number of teeth	Pin holes
250	2.0	32	160	63x11x4
285	2.0	32	160	63x11x4
			180	63x11x4
			200	63x11x4
Thickness from 1.2 up to 3.5 mm				

**Special pin holes on request!**

### Application examples:

- Hinges
- Gear wheels
- Cylinder barrels
- Forgings
- Ball bearings
- Bevel wheel
- Iron and steel trade



### Advantages:

- Up to 15.000 cuts
- Higher cutting life
- Better cutting surface
- Higher cutting speed

### - Example Material -

#### Comparison Throw Away Saw Blades Ø 285 mm

Type	TH	TH-LBS	Performances
Specification	120T	<b>200T</b>	<b>+ 80 teeth</b>
Cutting speed [m/min]	180	180	<b>O.K.</b>
Revolution [min <sup>-1</sup> ]	200	200	<b>O.K.</b>
Feed / tooth [mm]	0.04	0.04	<b>O.K.</b>
Feed speed [mm/min]	960	<b>1.600</b>	<b>+ 67 % faster</b>
Cutting time [s]	3.1	<b>1.9</b>	<b>- 37 % shorter</b>
Cycle time [s]	5.5	<b>4.3</b>	<b>- 22 % shorter</b>
Number of cuts / [hour]	654	<b>837</b>	<b>+ 28 % [+ 183 cuts]</b>
Number of cuts / 8 [hours]	5.236	<b>6.697</b>	<b>+ 28 % [+ 1.461 cuts]</b>

## Throw away carbide Tipped saw blades for solid materials and thick walled tubes

The TH-TCT saw blades are designed for mass cutting of automobile parts and forged materials which requires severe cutting controls of section.

Saw blade diameter from 250 mm up to 460 mm

Saw blade revolution from 12 - 200 rpm

**Special sizes on request**

**Customized center and pin holes**

Teeth material	Coating for higher durability and tempered steel
Carbide: Suitable for stainless steel	

Cermet: For use in steel, non-ferrous material and cast	<b>All saw blades are in original blank. They all can be coated on request!</b>
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To be used mainly for constant length cutting of round solid bar, square solid bar, solid-drawn pipe and so on. This item is produced under the strict quality control because the users produce automobile parts and forging materials and need strict controls on cutting surface, precision and any other aspects.

**Application:** Mild steel, alloy steel, stainless steel, non-ferrous steel, corresponding to general cut-off machines.

Diameter	Kerf	Central bore	Number of teeth	Pin holes	Cutting capacity	Cermet Coated	Carbide Coated	Blank
250	2.0	32	54	63x11.5x4	Ø 40 ~ Ø 50	On request*	On request*	X
			60	63x11.5x4	Ø 30 ~ Ø 40	*	*	X
			72	63x11.5x4	Ø 15 ~ Ø 30	*	*	X
285	2.0	32/40	54	63x11.5x4	Ø 50 ~ Ø 65	*	*	X
			60	63x11.5x4	Ø 35 ~ Ø 50	*	*	X
			72	63x11.5x4	Ø 20 ~ Ø 35	*	*	X
			80	63x11.5x4	Ø 15 ~ Ø 30	*	*	X
350	2.7	50	120	80x15x4	Ø 30 ~ Ø 50	*	*	X
			140	80x15x4	Ø 15 ~ Ø 30	*	*	X
360	2.6	40/50	60	63x11x4	Ø 55 ~ Ø 100	*	*	X
			80	63x11x4	Ø 30 ~ Ø 50	*	*	X
			100	63x11x4	Ø 20 ~ Ø 30	*	*	X
425	2.7	50	60	80x15x4	Ø 50 ~ Ø 65	*	*	X
			80	80x15x4	Ø 35 ~ Ø 50	*	*	X
			100	80x15x4	Ø 20 ~ Ø 35	*	*	X
			120	80x15x4	Ø 20 ~ Ø 35	*	*	X
460	2.7	50	60	80x15x4	Ø 50 ~ Ø 65	*	*	X
			80	80x15x4	Ø 35 ~ Ø 50	*	*	X
			100	80x15x4	Ø 20 ~ Ø 35	*	*	X

**TCT DRYTECH®**

## Milling Cutters for common 5-axe Machining Center

**Application:**

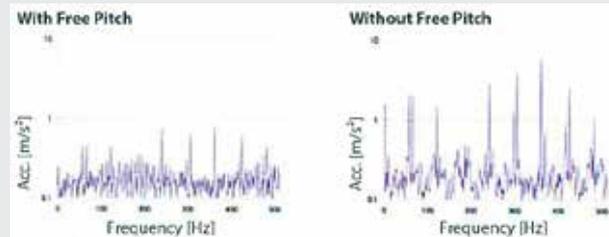
Profiles, Tubes and solid materials made of steel and aluminium

**Advantages:**

- Cost-effectiveness
- Excellent cutting surface
- Resharpenable
- High resistance



TCT saw blade for deep saw cuts, slotting or milling.  
Variable pitch to avoid vibrations, smooth cutting and higher cutting life.  
Recommend with radial feed and use of coolant.



Product Range			
Sizes in mm	a <sub>e</sub> Max	Number of teeth for steel	Number of teeth for aluminium
100 x 3	35	26	16
125 x 3	42,5	26	16
160 x 3	55	28	20

Cutting Parameters	
Aluminium v <sub>c</sub> = 320 m/min	f <sub>z</sub> = 0,029 mm
Steel v <sub>c</sub> = 125 m/min	f <sub>z</sub> = 0,029 mm
Inox v <sub>c</sub> = 125 m/min	f <sub>z</sub> = 0,029 mm



## LBS Shock resistant Metal Cutting Saw Blades

**Ideal for Cordless Tools \* and Power Tools**  
material saving • energy saving

Ideal for cutting metal grids and grates, trapezoidal sheets, metal profiles, conduits, shutter pipes and much more.

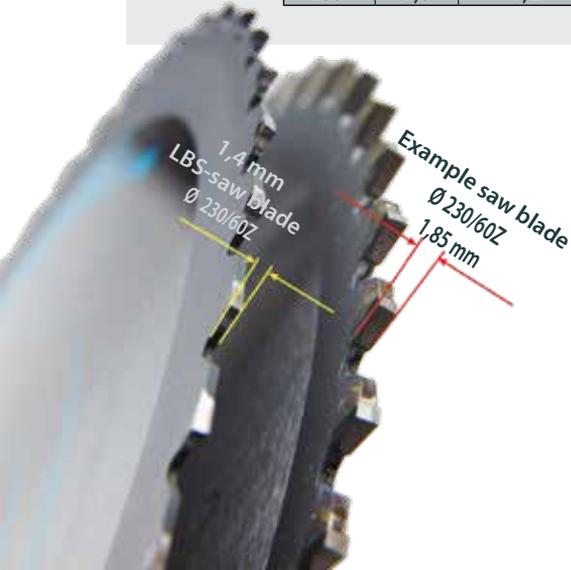
With **1.0** up to **1.5** mm LBS-blades are **much thinner** than conventional saw blades.

Therefore sawing with LBS-saw blades will become material saving, more efficient and faster.



Universal use also on all conventional cordless tools!

Range of LBS-Saw Blades						
Ø [mm]	Kerf [mm]	Blade body width [mm]	Bore [mm]	Teeth	Reference	For Machine
137 *	1,0	0,8	20	30	72213730	Bosch, Makita, Milwaukee, Panasonic etc.
165 *	1,2	0,94	20	40	72216540	Dewalt, Hilti, Metabo, Milwaukee etc.
165*	1,2	0,94	16	40	72216540M	Metabo
180	1,2	0,94	20	48	72218048	Flex, Hitachi, Makita, Rexon etc.
192	1,2	0,94	20	48	72219248	JEPSON Power, Makita etc.
200	1,2	0,94	25,4	48	72220048	AEG, Bosch, JEPSON Power, Mafell etc.
230	1,4	1,2	25,4	60	72223060	JEPSON Power HDC8230N
255	1,5	1,2	25,4	66	72225566	JEPSON Power DMC9410ND



**DRYTECH®**

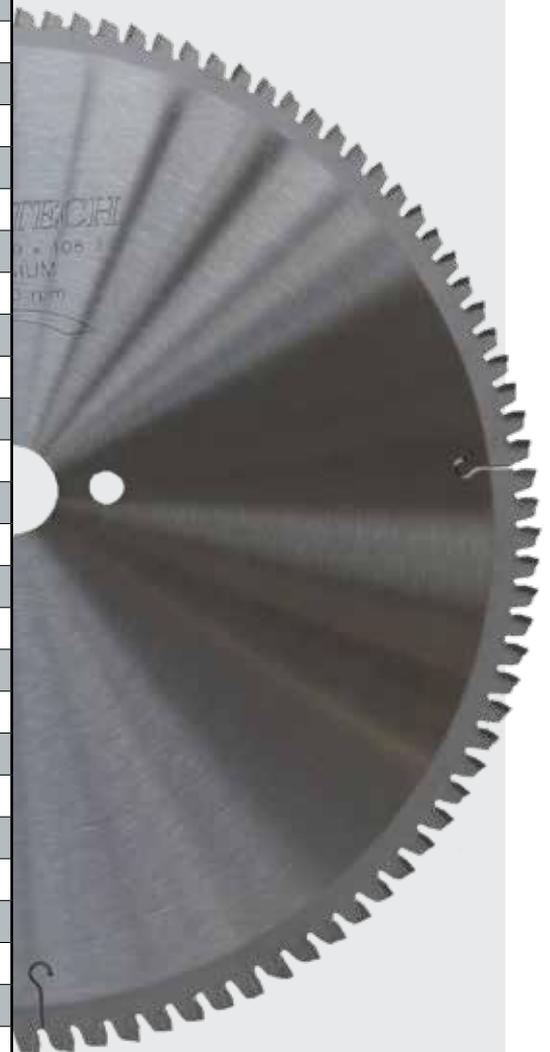
**TCT Saw Blades for Aluminum**

**Mass Cutting  
Aluminium + NF-METALS,  
Tubes, profiles and  
Solid Materials**

**Saw blade diameter  
from Ø 200 mm  
up to 600 mm  
Saw blade revolution: 3.000 rpm**

**Special sizes on request!  
Customized center and pin holes  
Resharping services**

Reference	Ø [mm]	Kerf / Body [mm]	Body [mm]	Teeth
AL20030060	200	3.0 / 2.0	30	60
AL21630060	216	3.0 / 2.0	30	60
AL25030060	250	3.2 / 2.2	30	60
AL25032060	250	3.2 / 2.2	32	60
AL25030080	250	3.2 / 2.2	30	80
AL25032080	250	3.2 / 2.2	32	80
AL30030072	300	3.2 / 2.4	30	72
AL30032072	300	3.2 / 2.4	32	72
AL30030084	300	3.2 / 2.4	30	84
AL30032084	300	3.2 / 2.4	32	84
AL30030096	300	3.2 / 2.4	30	96
AL30032096	300	3.2 / 2.4	32	96
AL35030084	350	3.4 / 2.8	30	84
AL35032084	350	3.4 / 2.8	32	84
AL35030096	350	3.4 / 2.8	30	96
AL35032096	350	3.4 / 2.8	32	96
AL35030108	350	3.4 / 2.8	30	108
AL35032108	350	3.4 / 2.8	32	108
AL40030096	400	3.4 / 2.8	30	96
AL40032096	400	3.4 / 2.8	32	96
AL40030120	400	3.4 / 2.8	30	120
AL40032120	400	3.4 / 2.8	32	120
AL42030108	420	3.8 / 3.0	30	108
AL42032108	420	3.8 / 3.0	32	108
AL45030096	450	3.8 / 3.0	30	96
AL45032096	450	3.8 / 3.0	32	96
AL45030108	450	3.8 / 3.0	30	108
AL45032108	450	3.8 / 3.0	32	108
AL50030120	500	4.0 / 3.2	30	120
AL50032120	500	4.0 / 3.2	32	120
AL55030132	550	4.2 / 3.5	30	132
AL55032132	550	4.2 / 3.5	32	132
AL60030144	600	4.2 / 3.5	30	144
AL60032144	600	4.2 / 3.5	32	144





## HSS Circular Saw Blades

### Standard Range

Ø	Thick-ness	Central bore	Hub	Side run out	Number of teeth [toothpitch] and toothform														
					T2,5	T3	T4	T4,5	T5	T5,5	T6	T7	T8	T9	T10	T12	T14	T16	T18
[mm]	[mm]	[mm]	[mm]	[mm]	A	BW	BW	BW	BW	BW	BW	HZ							
250	1,5 [1,6]	32	100	0,25	320	240	200	180	160	140	128	110	100	90	80	66			
250	2,0	25,4 / 32 / 40	100	0,25	320	240	200	180	160	140	128	110	100	90	80	66			
250	2,5	25,4 / 32 / 40	100	0,25	320	240	200	180	160	140	128	110	100	90	80	66			
275	1,6	32 / 40	100	0,25	340	280	220	200	180	160	140	120	110	96	90	70	60		
275	2,0	32 / 40	100	0,25	340	280	220	200	180	160	140	120	110	96	90	70	60		
275	2,5	25,4 / 32 / 40	100	0,25	340	280	220	200	180	160	140	120	110	96	90	70	60		
300	2,0	32 / 40	100	0,25	380	300	220	210	180	170	160	140	120	104	94	80	68		
300	2,5	32 / 38 / 40	100	0,25	380	300	220	210	180	170	160	140	120	104	94	80	68		
315	2,0	32 / 40	100	0,30	400	300	240	220	200	180	160	140	120	110	100	80	70	60	
315	2,5	32 / 40	100	0,30	400	300	240	220	200	180	160	140	120	110	100	80	70	60	
315	3,0	32 / 40	100	0,30	400	300	240	220	200	180	160	140	120	110	100	80	70	60	
325	2,5	32 / 40	100	0,30	410	320	250	220	200	190	170	146	128	110	100	80	72	64	
130	2,0	32 / 40	120	0,30	440	350	280	240	220	200	180	160	140	120	110	90	80	70	60
130	2,5	32 / 40 / 50	120	0,30	440	350	280	240	220	200	180	160	140	120	110	90	80	70	60
130	3,0	32 / 40 / 50	120	0,30	440	350	280	240	220	200	180	160	140	120	110	90	80	70	60
370	2,5	32 / 40 / 50	120	0,30		380	280	260	220	210	190	160	140	120	110	100	80	70	64
370	3,0	32 / 40 / 50	120	0,30		380	280	260	220	210	190	160	140	120	110	100	80	70	64
400	2,5	32 / 40 / 50	120	0,30			310	280	250	230	200	180	160	140	120	110	96	80	70
400	3,0	32 / 40 / 50	120	0,30			310	280	250	230	200	180	160	140	120	110	96	80	70
400	3,5	40 / 50	120	0,30			310	280	250	230	200	180	160	140	120	110	96	80	70
400	4,0	40 / 50	120	0,30			310	280	250	230	200	180	160	140	120	110	96	80	70
425	3,0	32 / 40 / 50	130	0,35			320	300	260	240	220	190	160	150	130	110	96	84	70
425	3,5	32 / 40 / 50	130	0,35			320	300	260	240	220	190	160	150	130	110	96	84	70
425	4,0	32 / 40 / 50	130	0,35			320	300	260	240	220	190	160	150	130	110	96	84	70
450	3,0	40 / 50	130	0,35			350	320	280	260	230	200	180	160	140	120	100	90	80
450	3,5	40 / 50	130	0,35			350	320	280	260	230	200	180	160	140	120	100	90	80
450	4,0	40 / 50	130	0,35			350	320	280	260	230	200	180	160	140	120	100	90	80

Available in Co5 and DMo5 TiAlN Steamed and Coated  
Customized pin holes, bore and hub on request!

### Tooth Shape

<b>Bw</b>	Standard tooth shape for the pipe cutting	<b>A</b>	Best tooth shape for small tooth pitch [T < 3 mm]
<b>B</b>	For blades with thin thickness [< 1,3 mm] as an alternative of Bw	<b>HZ</b>	For solid cutting or thicker pipes [> 3 mm]
<b>Br</b>	Best tooth shape for automatic pipe cutting machines	<b>VP</b>	Variable pitch for irregular sections

### DRYTECH®

### TCT Saw Blades

**Applicable on:**

- Robots, Milling Centres, 5-Axe CNC Machining Centres or Common Aluminium and Wood Working Machines

**Suitable for:**

- CFRP, CFRTP, Aramid Fibre Reinforced Plastics, GF, Prepreg
- Pipes, profiles, plates

**Advantages:**

- Clean cutting face
- Prevent delamination due to finest pitch
- No delamination against different direction
- Less chip volume in comparison
- Material saving through thin cut technology
- Less heat processing due to lower cutting resistance



Ø [mm]	Kerf [mm]	Body [mm]	Bore [mm]	Teeth	Reference
70	1	0,9	22,2H	60	AURDTS07060
80	1	0,9	22,2H	68	AURDTS08068
115	1	0,9	22,2H	100	AURDTS115100
120	1	0,9	22,2H	60	AURDTS120060
120	1	0,9	22,2H	80	AURDTS120080
120	1	0,9	22,2H	100	AURDTS120100
150	1	0,94	25,4H	80	AURDTS150080
150	1	0,94	25,4H	100	AURDTS150100
150	1	0,94	25,4H	120	AURDTS150120
192	1	0,94	20,0H	160	AURDTS192160
200	1,2	0,94	30,0H	180	AURDTS200180
255	1,4	1,2	25,4H	220	AURDTS255220
305	1,6	1,4	25,4H	260	AURDTS305260
355	2,0	1,7	25,4H	300	AURDTS355300
405	2,5	2,25	30,0H	280	AURDTS405280
<b>Customized pin holes and bore on request!</b>					

<b>Recommended Cutting Parameters</b>	
Cutting speed	3.000 m/min
Feed speed	4.000 - 15.000 mm/min
<b>Dry Cutting!</b>	

Ø [mm]	Kerf [mm]	Body [mm]	Bore [mm]	Teeth	Reference
250	4	3,0	30,0H	80	AURDTS250080
305	4	3,0	30,0H	100	AURDTS305100
355	4	3,0	30,0H	120	AURDTS355120
<b>Wall thickness over 10 mm</b>					
Customized pin holes and bore on request!					

## PVD Coatings

PVD Coating	Surface Hardness	Oxidation temperature	Friction Coefficient	Description	Application	Processing	Line
<b>Bronze</b>	3500	800	0,2	Nanostructure shock resistant	steel, stainless steel	dry cutting	DRYTECH
<b>Silver</b>	3000	600	0,4	Abraison resistance	stainless steel, non-ferrous	dry cutting	DRYTECH
<b>Gold</b>	2800	600	0,5	Nanostructure Abraison resistant	aluminum with higher silicium content	micro lubrication	DRYTECH - ALU
<b>Grey</b>	3500	900	0,7	Nanostructure Anti-Oxydation resistance	steel, stainless steel, high tensile	micro lubrication	TH - LBS
<b>Black</b>	3900	900	0,7	Nanostructure Anti-Oxydation resistance	steel, stainless steel	dry cutting	DRYTECH



### BRONZE

The natural substitute of BRONZE, is a multipurpose coating giving you a clear upgrade than a TIN coating due to the higher (HV) hardness and a lower friction coefficient.



### SILVER

Best coating to cut stainless steels on semiautomatic and fully automatic machines. Can not be used on manual machines.



### GOLD

Classic technology coating used to cut aluminum-silicium-compounds. Can not be used on Copper, Brass and Bronze.



### GREY

Best coating to cut solids and pipes with oil mist. Can not be used to cut soft steels with abundant coolant.



### BLACK

Best coating to cut hard materials with dry cutting. Also applicable to cut pipes and profiles.



## Industrial Saw Blades for Metal and Composite Materials

### Please fill out the questionnaire

Company						
Company Name						
Cutt-off Machine						
Machine maker			Machine type			
Machine Spec.	<input type="checkbox"/> Stationary cutt-off machine		<input type="checkbox"/> Flying cutt-off machine			
Number of Saw Blades	<input type="checkbox"/> 1	<input type="checkbox"/> 2	<input type="checkbox"/> 3	<input type="checkbox"/> 4	<input type="checkbox"/> Others:	
Circumferential speed		m/min	Feed per stroke (SZ)		mm/min	
Cutting time		sec.	Other conditions			
Workpiece						
Material			High tensile pipe	N/mm <sup>2</sup>		
Shape of material	<input type="checkbox"/> Pipe		<input type="checkbox"/> Solid bar		<input type="checkbox"/> Others:	
Size of pipe in mm	<input type="checkbox"/> Round ~		<input type="checkbox"/> Square ~			
Wall thickness of pipe in mm	~					
Saw Blade						
Type of Saw Blade	<input type="checkbox"/> Friction saw blade		<input type="checkbox"/> TCT saw blade		<input type="checkbox"/> Milling	<input type="checkbox"/> Others:
Diameter		mm	Inner hole diameter		mm	
Kerf		mm	Saw plate thickness		mm	
Number of teeth			Tooth form			
Pin holes			Coating	<input type="checkbox"/> Yes <input type="checkbox"/> No		
Re-sharpening	<input type="checkbox"/> Yes ( ) tms		<input type="checkbox"/> No		Current supplier	
Price per blade			Consumption		per	
Current cutting life		m <sup>2</sup>	Target cutting life		m <sup>2</sup>	
Do you have problems with weld beads during the cutting process?						
Yes:				<input type="checkbox"/> No.		
Remarks:						



# General Payment and Delivery Conditions

## 1. General

These General Terms and Conditions of Sale (these "Terms") govern the sale and delivery of all products (the "Products"), and all transactions incidental there to, by or on behalf of I.T.E.C. to any of its customers ("Customer").

No other terms or conditions shall be of any force or effect unless otherwise specifically agreed upon by I.T.E.C. in a writing duly executed by I.T.E.C.. Any additional or different terms or conditions contained in Customer's order or response to I.T.E.C.'s confirmation shall be deemed objected to by I.T.E.C. and shall not be binding on I.T.E.C.. No general terms and conditions of Customer shall at any time form a part of any agreement between the Customer and I.T.E.C., even if such terms and conditions are not expressly rejected by I.T.E.C..

These Terms supersede any and all prior oral quotations, communications, agreements or understandings of the parties in respect of the sale and delivery of the Products and shall supersede any and all other terms and conditions contained in any Order (as defined below) placed by Customer or otherwise communicated by Customer.

I.T.E.C.'s failure to object to terms and conditions communicated by Customer shall in no event be construed as an acceptance of any other terms and conditions. Any communication or conduct of Customer which confirms an agreement for the delivery of Products by I.T.E.C., as well as acceptance in whole or in part by Customer of any delivery of Products from I.T.E.C., shall be construed as Customer's acceptance of these Terms.

If Customer finds any provision in these Terms not acceptable, Customer must so notify I.T.E.C. immediately and must reject the Products delivered under these Terms. Deviations from these Terms require I.T.E.C.'s prior written approval.

## 2. Offers, Orders and Confirmation

I.T.E.C. shall sell and deliver to Customer, and Customer shall purchase and accept from I.T.E.C., the Products described in any order, agreement or quotation, or any combination thereof (an "Order"). All offers made by I.T.E.C. are revocable at any time and subject to change without prior notice to Customer. I.T.E.C. may refuse an Order for any or no reason. Information on the Products, such as specifications, measurements and descriptions, contained in catalogs, advertisements, handouts, solicitation letters, or other materials are not binding on I.T.E.C., and may be changed by I.T.E.C. at any time without any liability to Customer. No Order is binding upon I.T.E.C. until the earlier of acceptance of I.T.E.C.'s acceptance of the Order in writing or the delivery of the Products to the Customer (a "Confirmed Order"). Notwithstanding any prior written confirmation of an Order by I.T.E.C., I.T.E.C. shall have no obligation to deliver Products to Customer or otherwise perform any of its obligations set forth in a Confirmed Order or herein if Customer is (i) in breach of any of its obligations hereunder or such Confirmed Order, (ii) insolvent or I.T.E.C. has reason to believe that Customer lacks the ability to pay its debts as they become due.

Each Confirmed Order shall be considered a separate agreement between the parties to purchase and sell Products, and any failure to deliver Products under any Confirmed Order shall have no consequences for other deliveries.

## 3. Prices

The price of the Products shall be as published in I.T.E.C.'s current price list in effect at the time of the Order unless otherwise quoted in writing by I.T.E.C.. A price list is available on request. Unless otherwise agreed by I.T.E.C. in writing, all prices set forth in such price list are subject to change without prior notice to Customer.

The price of Products shall not include packaging, sales or use tax or any other similar applicable federal, state or foreign taxes, duties, levies or charges in any jurisdiction in connection with the sale or deliver of the Products ("Taxes"). Such Taxes shall be payable by Customer and, if I.T.E.C. is responsible for the collection thereof, such Taxes shall either be added to the price invoiced or be separately invoiced by I.T.E.C. to Customer. Should any unforeseeable increases in I.T.E.C.'s cost of materials or labor occur after the date of any Confirmed Order, I.T.E.C. shall, in its sole discretion, be entitled to increase the agreed prices accordingly.

## 4. Payment Terms

Unless otherwise agreed in writing by I.T.E.C., the purchase price for the Products to be delivered under a Confirmed Order and all other amounts due in connection therewith shall be due and payable in US dollars within thirty (30) days following the date of I.T.E.C.'s invoice for such Products without any discount, deduction or offset whatsoever. In no event shall any loss, damage, injury or destruction, force majeure events or any other event beyond I.T.E.C.'s control release Customer from its obligation to make the payments required herein. Payment of all amounts due hereunder shall be made by check, wire transfer, or credit card in the manner set forth on I.T.E.C.'s invoice.

Time is of the essence for the payment of all amounts due to I.T.E.C. under any Confirmed Order. If Customer fails to make payment of any amount when due, Customer shall pay interest to I.T.E.C. at the rate of one and one-half percent (1.5%) per month or such lesser amount as may be permitted by applicable law starting from the due date until payment of such amount in full. If Customer fails to comply with these Terms or the terms of any agreement between I.T.E.C. and Customer, or if Customer becomes insolvent, all balances then due and owing to I.T.E.C. shall become due immediately, notwithstanding any agreed-upon payment periods. All costs and expenses incurred by Jepson with respect to the collection of overdue payments (including, without limitation, reasonable attorney's fees, expert fees, and other expenses of litigation) shall be borne by Customer. Every payment by Customer shall first be applied to pay for Jepson's cost of collection, then interest owed by Customer, and then to the oldest outstanding claim. If I.T.E.C. extends credit to Customer for the purchase price for any Products or any other amounts due to I.T.E.C., Customer hereby grants to I.T.E.C. as security for the timely payment and performance of all Customer's payment obligations to I.T.E.C., a first priority security interest (the "Security Interest") in all Products heretofore or in the future delivered to Customer for as long as such Products shall not have been sold by Customer in the ordinary course of business (the "Collateral"). I.T.E.C. shall be entitled to file any and all financing, continuation or similar statements under the Uniform Commercial Code in any jurisdiction, and take any and all other action necessary or desirable, in I.T.E.C.'s sole and absolute discretion, to perfect its security interest in the Collateral and to establish, continue, preserve and protect I.T.E.C.'s security interest in the Collateral. Customer agrees to take any and all actions and provide Customer with all information necessary to enable I.T.E.C. to perfect and enforce this security interest in all jurisdictions and vis-à-vis any of Customer's creditors. This security interest shall remain in force until payment in full of the entire purchase price for such Products and any other amounts due to I.T.E.C. by Customer. I.T.E.C. may, without notice, change or withdraw extensions of credit at any time.

## 5. Delivery and Acceptance

Unless otherwise agreed in writing by I.T.E.C., all deliveries of Products shall be made EX WORKS I.T.E.C.'s warehouse at Ernst-Abbe-Straße 5, 52249 Eschweiler, Germany and title to and risk of loss for the Products shall pass to Customer upon delivery thereof to Customer's common carrier. If Customer requests that I.T.E.C. organize transportation on Customer's behalf, I.T.E.C. or its agent may select, without any liability to Customer, any commercial air, ship, motor or rail carrier or any combination thereof for the transportation of the Products and will notify Customer thereof in the Order Confirmation. I.T.E.C. shall not be responsible for any acts or omissions of any such carrier.

Any delivery times or dates communicated by or on behalf of I.T.E.C. are estimates and shall not be binding on I.T.E.C.. I.T.E.C. may make partial delivery of Products to be delivered under any Confirmed Order and invoice Customer separately for such partial deliveries. In no event shall I.T.E.C. be liable for any delay in delivery, and no delay in delivery of any Products shall relieve Customer of its

obligation to accept delivery thereof and make payment of any amounts due in accordance with these Terms. I.T.E.C. shall not be liable for any delays in delivery if such delay was caused by Customer's failure to provide the specifications required to manufacture the Product. Customer's failure to accept delivery of any Products pursuant to a Confirmed Order shall not release or excuse Customer from its obligation to timely pay all amounts due in connection with such Confirmed Order. If Customer rejects or revokes acceptance of Products or fails to pay any amounts when due, I.T.E.C., in its sole and absolute discretion, may extend the period of delivery by such period as I.T.E.C. may deem reasonable, or withhold or cancel delivery of any Products, or cancel any or all Confirmed Orders without any further obligations to Customer whatsoever. In such event Customer shall be responsible for any and all costs and expenses incurred or damages or losses suffered by I.T.E.C. in connection with any such delay notwithstanding any action or inaction by I.T.E.C. with regard to such delay. In the event I.T.E.C. delivers Products to Customer for export, Customer shall deliver exclusively to countries agreed with I.T.E.C. in writing. Upon I.T.E.C.'s request, Customer shall provide I.T.E.C. with written documentation regarding the export of the Products including but not limited to information about the delivery location. Customer represents and warrants that it has obtained the necessary permits and authorization to use and resell the Products in the respective jurisdictions.

## 6. Examination and Conformity to Order

Promptly upon receipt of any Products, Customer shall conduct a full and complete inspection of such Products as to any defects and to confirm compliance with all requirements of the applicable Confirmed Order. Customer shall notify I.T.E.C. or any authorized I.T.E.C. dealer in writing of any apparent defects or non-compliance of such Products with the applicable Confirmed Order that Customer has or could reasonably have discovered during such inspection within fourteen (14) days from the date of receipt of such Products, and Customer shall notify I.T.E.C. in writing within fourteen (14) days of the date on which Customer shall first have become aware of any hidden defect or non-compliance which could not reasonably have been discovered during Customer's initial inspection of the Products. Notwithstanding anything to the contrary contained herein, any and all claims for defective or non-compliant Products under this Section 6 must be received by I.T.E.C. within six (6) months of the earlier to occur of (a) the delivery of the Products pursuant to these Terms or (b) I.T.E.C.'s notification of Customer that the Products are ready for delivery. Such complaint shall include a copy of the invoice or bill of sale issued to Customer for the sale of the defective Product. If Customer fails to timely notify I.T.E.C. of any defects or other non-compliance of any Products delivered or Customer uses, destroys or modifies any Products that Customer knows or should have known to be defective or non-compliant without I.T.E.C.'s prior written consent, Customer shall be deemed to have unconditionally accepted such Products and waived all of its claims for breach of warranty or otherwise in respect of such Products. Products that I.T.E.C. consents or directs Customer in writing to be returned shall be returned to I.T.E.C. at Customer's risk to the destination directed by I.T.E.C.. Unless otherwise agreed in writing by I.T.E.C., all equipment, samples to support the sales provided by I.T.E.C. to Customer to enable Customer to use the Products shall remain the sole property of I.T.E.C..

## 7. Limited Warranty

With respect to the Products, I.T.E.C. warrants to Customer that the Products will be free of defects in material and workmanship and conform with the requirements set forth in the applicable Confirmed Order for a period of one (1) year from the date of delivery (the "Warranty Period"); provided that the Products are used for the purpose intended and are maintained, handled, serviced and operated in accordance with I.T.E.C.'s written instructions and manuals and are not altered, modified or repaired unless such alteration, modification or repair shall have been authorized by I.T.E.C. in writing (the "Limited Warranty"). Except for the Limited Warranty, I.T.E.C. makes no other warranties with respect to the Products, and no person is authorized to make any warranties on behalf of I.T.E.C. that are inconsistent with such Limited Warranty.

ANY AND ALL OTHER WARRANTIES, WHETHER EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE OR NON-INFRINGEMENT, ARE HEREBY EX-PRESSELY EXCLUDED AND DISCLAIMED.

Except as otherwise set forth herein, if any Product defect entitles Customer to a claim under the Limited Warranty, I.T.E.C. will, at its sole option, repair, replace or issue a refund for the defective Product. In no event shall any warranty claims be made after expiration of the Warranty Period. The refund amount shall be the amount paid by the Customer for the defective Product less a processing fee of twenty dollars (\$20) or such higher amount as I.T.E.C. deems appropriate. All warranty claims shall be void and I.T.E.C. shall have no responsibility to repair or replace Products damaged as a result of (a) misuse, improper storage, handling, operation, or maintenance or unauthorized alteration, modification or repair of Products (including without limitation, the use of sawblades or other parts on the Products contrary to written instructions and/or recommendations of I.T.E.C., overloading of the Product beyond its capacity, or repair of the Products by persons other than a service center authorized by I.T.E.C.), (b) acts or omissions of Customer or third parties following delivery of the Product, acts of nature or government, abuse, or other events beyond I.T.E.C.'s control, (c) normal wear and tear. Unless expressly warranted in writing in any Confirmed Order, I.T.E.C. makes no warranty that the Products comply with applicable law, regulations or specifications in any jurisdiction in which the Products may be sold or marketed. Any governmental or other approvals necessary in connection with the sale, marketing, distribution or use of the Products shall be Customer's sole responsibility. Customer shall not be authorized to make any warranties that are inconsistent with the foregoing warranty, and any and all such warranties shall in no event be binding on I.T.E.C..

## 8. Limitation of Liability

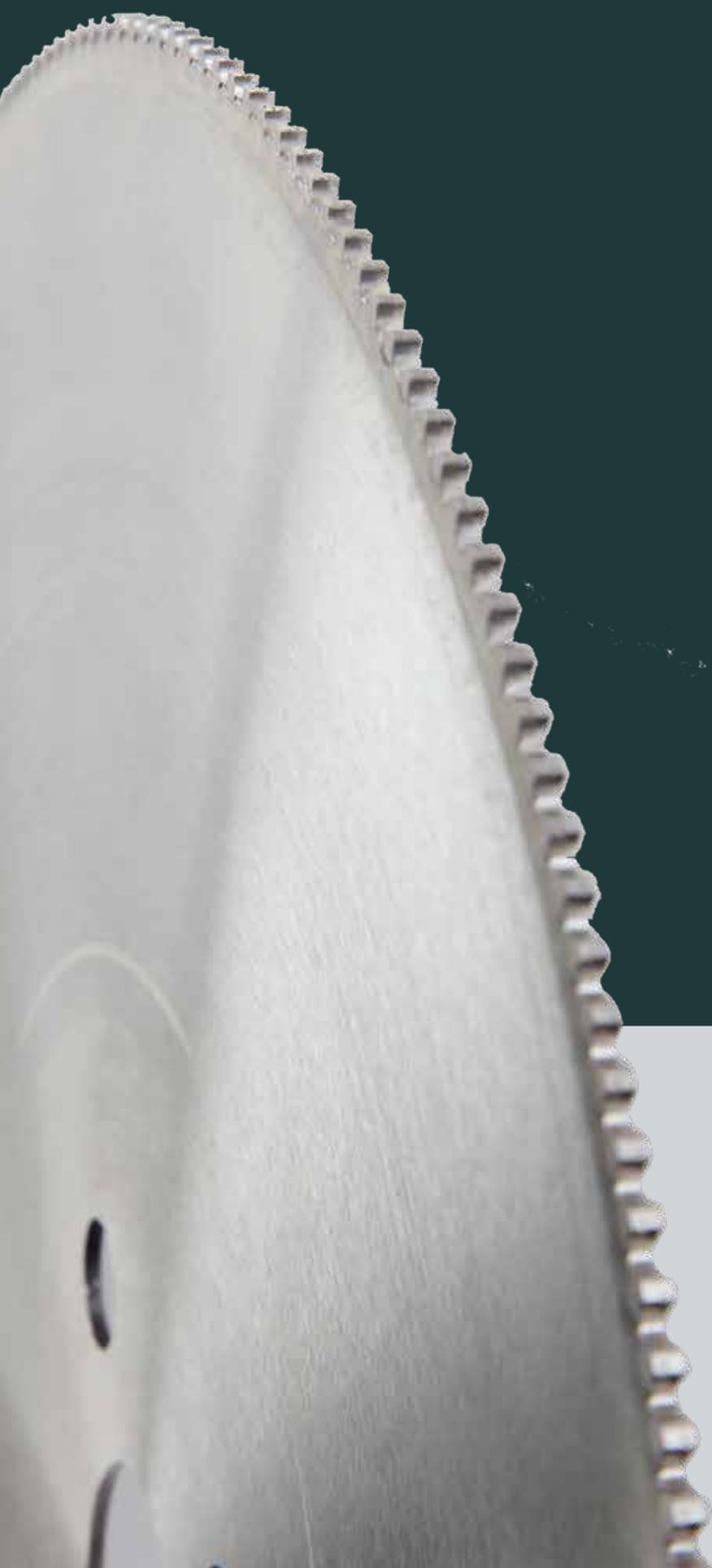
In no event shall I.T.E.C. be liable to Customer for any indirect, incidental, punitive, special or consequential damages, including but not limited to, damages for loss of profits, revenue, goodwill or use, whether in an action in contract, tort, strict liability, or imposed by statute, or otherwise, even if Customer was advised of the possibility of such damages.

## 9. Miscellaneous

If any provision contained in these Terms or any Confirmed Order is held by final judgment of a court of competent jurisdiction to be invalid, illegal or unenforceable, such invalid, illegal or unenforceable provision shall be severed from the remainder of these Terms or such Confirmed Order, and the remainder of these Terms or such Confirmed Order shall be enforced. In addition, the invalid, illegal or unenforceable provision shall be deemed to be automatically modified, and, so modified, to be included in these Terms, such modification being made to the minimum extent necessary to render such provision valid, legal and enforceable.

## 10. Entire Agreement; Conflicts

These Terms, including the applicable Confirmed Order, constitute the entire and exclusive agreement of the parties regarding the subject matter hereof and supersedes any and all prior or contemporaneous agreements, communications, and understandings (both written and oral) regarding such subject matter. In the event of a conflict between the provisions of these Terms and the provisions of a Confirmed Order, the provisions of the Confirmed Order will govern and control. These Terms may only be modified or any rights under it waived by a written document executed by both parties.



# **I.T.E.C.**

## **Metal Cutting Solutions**

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