PROUD MEMBER OF
THE ASSOCIATION FOR
MANUFACTURING
TECHNOLOGY

JLH
Ecosystem

***Powering the Complete Sawing Ecosystem***


ZHEJIANG JULIHUANG INDUSTRIAL TECHNOLOGY CO.,LTD

Web : www.jlhsaws.com
Email : info@jlhsaws.com
Add : No.1 Dongshan Industrial Park, Huzhen Town, Jinyun County, Zhejiang Province, China



* Due to the continuous improvement and research of our company, the above specifications, dimensions, design features and configurations are based on the actual quotation content.


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# JLH SAWING ECOSYSTEM

## Consumables Product Overview

JLH Bimetal & Carbide Band Saw Blades

JLH Circular Saw Blades



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JLH consumables are engineered specifically for metal sawing applications to improve cutting efficiency, extend tool life, and deliver stable, consistent performance under demanding production conditions.

All consumables are perfectly matched with JLH sawing machines, ensuring reliable and sustainable operation.



# 01 JLH Bi-Metal Band Saw Blade Series

## Series Overview

The JLH Bi-Metal Band Saw Blade Series is engineered to serve a wide range of industrial metal cutting applications, delivering an optimal balance of cutting performance, durability, and cost efficiency.

This series is manufactured using M51 and M42 bi-metal tooth materials, combined with optimized tooth geometry, precision grinding processes, and advanced surface treatment technologies. Multiple performance levels are available — from general-purpose cutting to heavy-duty, high-load industrial production — allowing users to select the most suitable blade based on material type, cutting conditions, and production intensity.

## Key Features

- High-speed steel (HSS) tooth edge with alloy steel backing
- Excellent fatigue resistance and tooth durability
- Stable cutting performance with reduced vibration

## Applications

- Carbon steel
- Alloy steel
- Structural steel
- Pipes, profiles, and solid bars

## Available Options

- Set tooth / Unset tooth
- Variable pitch / Constant pitch
- Coated / Uncoated

## Band Saw Blade Specifications (Length, Width, Thickness)

| Width × Thickness (mm) | 13 X 0.65 | 19 X 0.9 | 27 X 0.9 | 34 X 1.1 | 41 X 1.3 | 54 X 1.6 | 67 X 1.6 | 80 X 1.6 |
|---|---|---|---|---|---|---|---|---|
| Blade Length (Coil)(m) | 100 | 100 | 100 | 85 | 75 | 75 | 75 | 60 |

## Tooth Pitch Selection Guide for Tubing & Pipes

| Tooth Pitch (TPI) / Wall Thickness | Pipe Fitting Outer Diameter (mm) | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 15 | 20 | 40 | 60 | 80 | 100 | 120 | 150 | 200 | 300 | 400 | 500 | 600 | 600 < |
| 2 | 14/18 | 14/18 | 14/18 | 10/14 | 10/14 | 10/14 | 10/14 | 10/14 | 8/12 | 8/12 | 8/12 | 6/10 | 6/10 | 5/8 |
| 3 | 14/18 | 14/18 | 10/14 | 10/14 | 10/14 | 8/12 | 8/12 | 8/12 | 8/12 | 6/10 | 6/10 | 6/10 | 5/8 | 5/8 |
| 4 | 14/18 | 10/14 | 10/14 | 10/14 | 8/12 | 6/10 | 6/10 | 6/10 | 6/10 | 5/8 | 5/8 | 4/6 | 4/6 | 4/6 |
| 5 | 10/14 | 10/14 | 8/12 | 8/12 | 8/12 | 6/10 | 6/10 | 5/8 | 5/8 | 5/8 | 4/6 | 4/6 | 4/6 | 4/6 |
| 6 | 10/14 | 10/14 | 8/12 | 8/12 | 6/10 | 5/8 | 5/8 | 5/8 | 4/6 | 4/6 | 4/6 | 4/6 | 4/6 | 3/4 |
| 8 | | 10/14 | 8/12 | 6/10 | 6/10 | 5/8 | 5/8 | 4/6 | 4/6 | 4/6 | 4/6 | 4/6 | 4/6 | 3/4 |
| 10 | | | 6/10 | 6/10 | 5/8 | 5/8 | 5/8 | 4/6 | 4/6 | 4/6 | 4/6 | 3/4 | 3/4 | 3/4 |
| 12 | | | 6/10 | 5/8 | 5/8 | 4/6 | 4/6 | 4/6 | 4/6 | 4/6 | 3/4 | 3/4 | 3/4 | 3/4 |
| 15 | | | 6/10 | 4/6 | 4/6 | 4/6 | 4/6 | 4/6 | 3/4 | 3/4 | 3/4 | 3/4 | 3/4 | 2/3 |
| 20 | | | | 4/6 | 4/6 | 3/4 | 3/4 | 3/4 | 2/3 | 2/3 | 2/3 | 2/3 | 2/3 | 2/3 |
| 30 | | | | | 3/4 | 3/4 | 3/4 | 3/4 | 2/3 | 2/3 | 2/3 | 2/3 | 2/3 | 2/3 |
| 50 | | | | | | | 2/3 | 2/3 | 2/3 | 2/3 | 2/3 | 2/3 | 2/3 | 1.4/2.0 |
| 75 | | | | | | | | | 2/3 | 2/3 | 2/3 | 1.4/2.0 | 1.4/2.0 | 1.4/2.0 |
| 100 | | | | | | | | | | | 1.4/2.0 | 1.4/2.0 | 1.0/1.5 | 1.0/1.5 |
| 150 | | | | | | | | | | | 1.4/2.0 | 1.4/2.0 | 1.0/1.5 | 1.0/1.5 |
| 200 | | | | | | | | | | | | 1.0/1.5 | 0.85/1.30<br>0.75/1.00 | 0.85/1.30<br>0.75/1.00 |
| 250 | | | | | | | | | | | | | 0.85/1.30<br>0.75/1.00 | 0.85/1.30<br>0.75/1.00 |
| 300 < | | | | | | | | | | | | | | 0.85/1.30<br>0.75/1.00 |

## Tooth Pitch Selection Guide for Solid Materials

| Tooth Pitch (TPI) | 14/18 | 14 | 10/14 | 8/12 | 6/10 | 8 |
|---|---|---|---|---|---|---|
| Stock Diameter/Width (mm) | 0～8 | 0～15 | 5～8 | 15～30 | 20～40 | 20～40 |
| Tooth Pitch (TPI) | 5/8 | 6 | 4/6 | 4 | 3/4 | 3 |
| Stock Diameter/Width (mm) | 30～50 | 40～70 | 50～100 | 70～120 | 80～150 | 120～150 |

| Tooth Pitch (TPI) | 2/3 | 1.4/2.0 | 1.0/1.5 | 0.75/1.00<br>0.85/1.30 | 0.75/1.00 |
|---|---|---|---|---|---|
| Stock Diameter/Width (mm) | 140～300 | 200～600 | 300～750 | ⩾700 | ⩾750 |



## JLH M51 PRO

Premium M51 Bi-Metal Band Saw Blade with Precision Ground Tooth 622204




· Premium M51 bi-metal tooth material combined with precision ground tooth geometry;

· Designed to deliver maximum cutting stability, higher efficiency, and extended blade life;

· Optimized for high-strength alloys, stainless steels, and difficult-to-cut materials;

· Ideal for heavy-duty, high-load, continuous industrial production environments.

## Key Benefit

Maximum performance and durability for the most demanding metal cutting applications.

## Lineup of Products

| Width/TPI | 5/8 | 4/6 | 3/4 | 2/3 | 1.4/2.0 | 1.0/1.5 | 0.85/1.3 | 0.75/1.25 |
|---|---|---|---|---|---|---|---|---|
| 27x0.9 | ◉ | ◉ | ◉ | ◉ | | | | |
| 34x1.1 | ◉ | ◉ | ◉ | ◉ | | | | |
| 41x1.3 | ◉ | ◉ | ◉ | ◉ | ◉ | | | |
| 54x1.6 | | | ◉ | ◉ | ◉ | ◉ | | |
| 67x1.6 | | | | ◉ | ◉ | ◉ | ◉ | ◉ |
| 80x1.6 | | | | ◉ | ◉ | ◉ | ◉ | ◉ |

## JLH M51 High-Performance M51 Bi-Metal Band Saw Blade 622108




· M51 bi-metal construction providing an excellent balance of wear resistance and toughness

· Delivers consistent and reliable cutting performance across a wide range of materials

· Suitable for medium to high-load industrial sawing applications

### Key Benefit

Reliable high-performance cutting with long service life.

### Lineup of Products

| Width/TPI | 5/8 | 4/6 | 3/4 | 2/3 | 1.4/2.0 | 1.1/1.5 | 0.75/1.25 |
|---|---|---|---|---|---|---|---|
| 27x0.9 | ◉ | ◉ | ◉ | ◉ | | | |
| 34x1.1 | | ◉ | ◉ | ◉ | | | |
| 41x1.3 | | ◉ | ◉ | ◉ | ◉ | | |
| 54x1.6 | | | ◉ | ◉ | ◉ | ◉ | |
| 67x1.6 | | ◉ | ◉ | ◉ | ◉ | ◉ | ◉ |
| 80x1.6 | | | | | | ◉ | ◉ |



## JLH S General-Purpose M42 Bi-Metal Band Saw Blade 622201




· Versatile M42 bi-metal construction

· Stable cutting performance across common industrial metals

· Cost-effective solution for everyday production cutting

### Key Benefit

Dependable all-around performance for daily cutting operations.

### Lineup of Products

| Width/TPI | 14/18 | 12/16 | 10/14 | 8/12 | 6/10 | 5/8 | 5/7 | 4/6 | 4 | 3/4 | 3 | 2/3 | 1.4/2.0 | 1.0/1.5 | 1/1.25 | 0.75/1.25 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 13x0.65 | ◉ | | ◉ | ◉ | ◉ | | | | | | | | | | | |
| 19x0.9 | | | ◉ | ◉ | ◉ | ◉ | | ◉ | ◉ | ◉ | | | | | | |
| 27x0.9 | | ◉ | ◉ | ◉ | ◉ | ◉ | ◉ | ◉ | ◉ | ◉ | ◉ | ◉ | | | | |
| 34x1.1 | | | | ◉ | ◉ | ◉ | ◉ | ◉ | | ◉ | | ◉ | ◉ | | | |
| 41x1.3 | | | | | ◉ | ◉ | ◉ | ◉ | | ◉ | | ◉ | ◉ | | | |
| 54x1.6 | | | | | | | | ◉ | | ◉ | | ◉ | ◉ | ◉ | ◉ | ◉ |
| 67x1.6 | | | | | | | | | | ◉ | | ◉ | ◉ | ◉ | | ◉ |
| 80x1.6 | | | | | | | | | | | | | ◉ | ◉ | | ◉ |

## JLH TTR M42 Bi-Metal Raised Tooth Band Saw Blade 622703

· M42 bi-metal blade with raised tooth (TTR) design

· Enhanced impact resistance and chip evacuation

· Ideal for unstable cutting conditions or variable material profiles




### Key Benefit

Improved cutting stability under challenging operating conditions.

### Lineup of Products

| Width/TPI | 4/6 | 3/4 | 2/3 |
|---|---|---|---|
| 27x0.9 | ◉ | ◉ | |
| 34x1.1 | ◉ | ◉ | |
| 41x1.3 | ◉ | ◉ | |
| 54x1.6 | ◉ | ◉ | ◉ |
| 67x1.6 | | ◉ | |



# 02 JLH Carbide Band Saw Blade Series

### Series Overview

The JLH Carbide Band Saw Blade Series is designed for demanding metal cutting applications where conventional bi-metal blades reach their performance limits.
This series utilizes carbide-tipped tooth technology, combined with optimized tooth geometry and optional surface coatings, to deliver superior cutting stability, longer tool life, and higher productivity when cutting difficult materials.
JLH carbide band saw blades are engineered for high-strength alloys, stainless steels, and aluminum alloys, supporting both fine pitch and non-pitch configurations, as well as coated and uncoated options, allowing users to precisely match blade characteristics to specific cutting requirements.

### Key Features

· Tungsten carbide tips for extreme wear resistance

· High cutting efficiency and extended blade life

· Ideal for automated and heavy-duty sawing applications

### Applications

· Stainless steel

· High-temperature alloys

· Hardened materials

· Large solid sections

### Available Options

· Coated carbide tips

· Precision-ground tooth profiles

### Application Industries

**JLH carbide band saw blades are widely used in:**

· Aerospace and aerospace supply chains

· Energy and power generation

· Stainless steel service centers

· Aluminum extrusion and processing plants

· High-performance manufacturing environments

## JLH 718 Series

Carbide Band Saw Blades for Nickel-Based Superalloys 622302




· Engineered specifically for nickel-based superalloys such as Inconel 718

· Carbide-tipped teeth provide exceptional heat resistance and wear resistance

· Maintains stable cutting performance under high temperature and high cutting force conditions

· Suitable for aerospace, energy, and high-performance industrial applications

### Key Benefit

Reliable cutting performance for extreme materials and demanding production environments.

### Lineup of Products

| Width/TPI | 3/4 | 2/3 | 1.4/2.0 | 1.0/1.5 | 0.75/1.25 | 0.75/1.0 |
|---|---|---|---|---|---|---|
| 34x1.1 | ◉ | ◉ | | | | |
| 41x1.3 | ◉ | ◉ | ◉ | | | |
| 54x1.6 | | ◉ | ◉ | ◉ | | |
| 67x1.6 | | | ◉ | ◉ | | ◉ |
| 80x1.6 | | | ◉ | ◉ | | ◉ |



## JLH SS Series

Carbide Band Saw Blades for Stainless Steel Cutting 622301




· Optimized for austenitic, martensitic, and duplex stainless steels

· Carbide tooth design reduces work hardening and improves cutting consistency

· Delivers smoother cuts and extended blade life compared to bi-metal blades

· Ideal for continuous production and heavy-duty stainless steel processing

### Key Benefit

Stable, efficient cutting of stainless steel with longer service life.

### Lineup of Products

| Width/TPI | 3/4 | 2/3 | 1.4/2.0 | 1.0/1.5 | 0.75/1.25 | 0.75/1.0 |
|---|---|---|---|---|---|---|
| 34x1.1 | ◉ | ◉ | | | | |
| 41x1.3 | ◉ | ◉ | ◉ | | | |
| 54x1.6 | | ◉ | ◉ | ◉ | | |
| 67x1.6 | | | ◉ | ◉ | | ◉ |
| 80x1.6 | | | ◉ | ◉ | | ◉ |

## JLH AA Series | High-Speed Carbide Band Saw Blades for Aluminum Alloys | 622306

· Designed for high-speed cutting of aluminum and aluminum alloys

· Optimized tooth geometry ensures excellent chip evacuation at high band speeds

· Minimizes built-up edge and improves surface finish

· Suitable for extrusion, billet cutting, and high-volume aluminum processing




### Key Benefit

Maximum productivity in high-speed aluminum cutting applications.

### Lineup of Products

| Width/TPI | 3/4 | 2/3 | 1.4/2.0 | 1.0/1.5 | 0.75/1.25 | 0.75/1.0 |
|---|---|---|---|---|---|---|
| 34x1.1 | ◉ | ◉ | | | | |
| 41x1.3 | ◉ | ◉ | ◉ | | | |
| 54x1.6 | | ◉ | ◉ | ◉ | | |
| 67x1.6 | | | ◉ | ◉ | | ◉ |
| 80x1.6 | | | ◉ | ◉ | | ◉ |



# 03 JLH Circular Saw Blades

### Series Overview

The JLH Cold Saw Blade series is engineered with high-strength steel bodies and advanced cutting tip technologies, specifically designed for **high-speed, precision, low-heat metal cutting**.

With high cutting efficiency, clean cut surfaces, and long service life, these blades are widely used for cutting carbon steel, stainless steel, aluminum, and other metals.

### Key Features

· Precision-ground teeth for clean and accurate cuts

· Excellent dimensional accuracy and surface finish

· Long service life with stable performance

### Applications

· Aluminum and non-ferrous metals

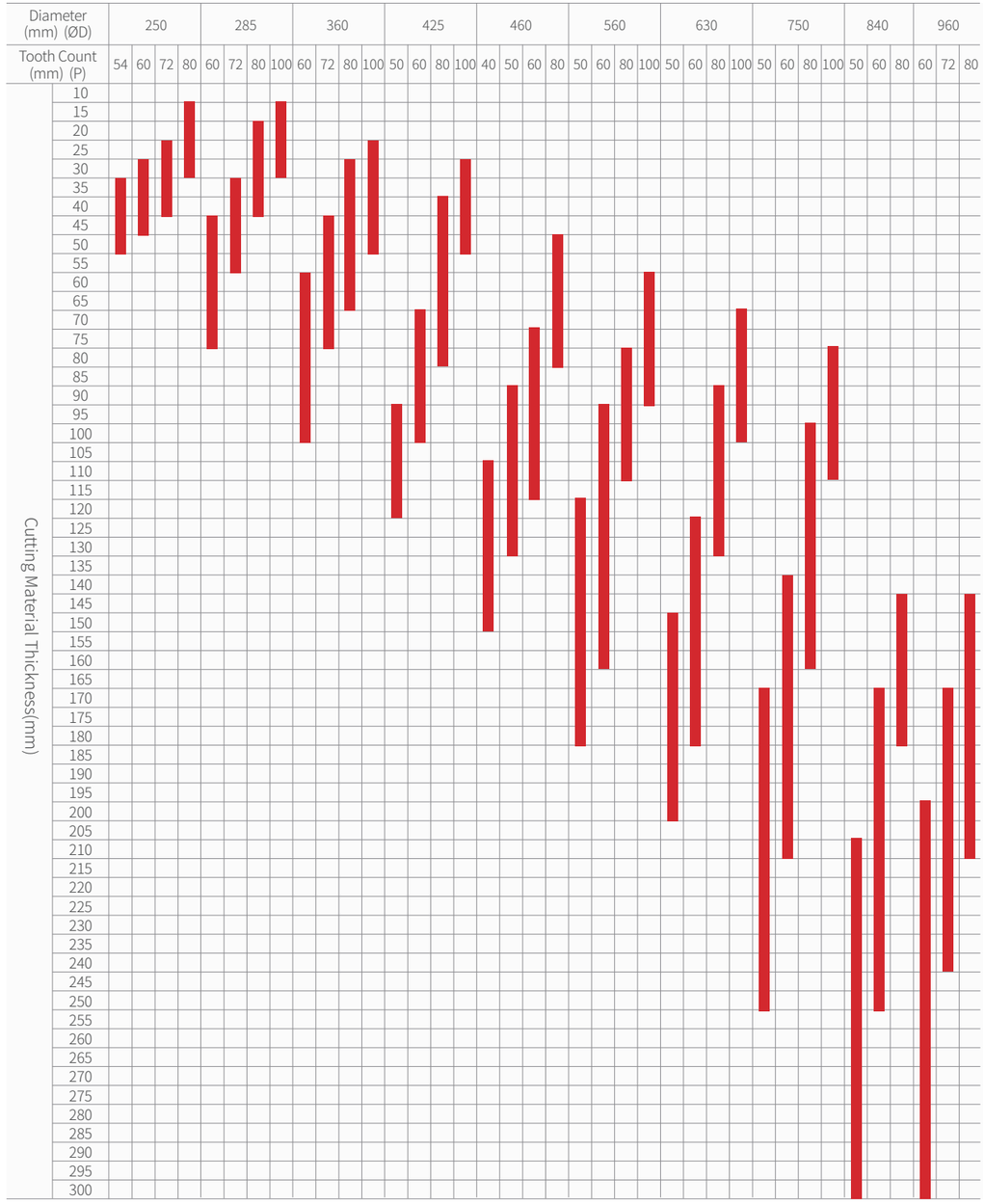
· Carbon steel and alloy steel

· Tube and profile cutting

### Saw Blade Parameters

| Bore | Positioning Hole |
|---|---|
| 32 | 4/9/50 4/11/63 |
| 40 | 4/11/63 4/11/90 2/12/65 2/15/80 |
| 50 | 4/11/90 4/16/80 4/21/90 |
| 80 | 4/23/120 4/23/160 4/23/180 4/26/150 4/26/200 |

## The reference for selecting the number of teeth




## Reference for Chip Load per Tooth and Cutting Speed

### Chip Load (per Tooth) (Fz)

$$Fz(mm/tooth) = \frac{V_f}{NxZ}$$

Fz: Chip Load per Tooth
$V_f$: Feed Rate (mm/min)
N: Spindle Speed (rpm)
Z: Number of Teeth

### Cutting Speed (V)

$$V(m/min) = \frac{\pi xDxN}{1000}$$

V: Cutting Speed (m/min)
D: Tool Diameter (mm)
N: Spindle Speed (rpm)

**Recommended Chip Load (Fz):**

For Bar Stock: Fz = 0.04 - 0.07 mm/tooth
For Tubing/Pipe: Fz = 0.03 - 0.05 mm/tooth

**Recommended Cutting Speed (V):**

For Low and Medium Carbon Steels: V = 100 - 130 m/min
For High Carbon and Alloy Steels: V = 70 - 100 m/min

## Blade Pitch Recommendation for Pipes

| Outer Diameter | Kerf Width | Plate(mm) | Bore | Number of Teeth |
|---|---|---|---|---|
| 250 | 2 | 1.7/1.75 | 32 | 54/60/72/80/100/120 |
| 285 | 2 | 1.7/1.75 | 32 | 54/60/72/80/100/120/140 |
| 300 | 2 | 1.7/1.75 | 32 | 50/54/60/72/80/100/120 |
| 305 | 2 | 1.7/1.75 | 32 | 60/80/100/120 |
| 315 | 2.25 | 2 | 32 | 60/72/80/100/120/130 |
| 330 | 2.3 | 2 | 32 | 60/72/80/100/120 |
| 360 | 2.6 | 2.25 | 40 | 60/72/80/100/120 |
| 380 | 2.6 | 2.25 | 40 | 60/72/80/100/120 |
| 400 | 2.6 | 2.25 | 40 | 50/60/72/80/100 |
| 420 | 2.6 | 2.25 | 40 | 60/80/100 |
| 425 | 2.7 | 2.25 | 50 | 50/60/72/80/100/120 |
| 460 | 2.7 | 2.25 | 50 | 40/50/60/72/80/100/120 |
| 480 | 2.7 | 2.25 | 50 | 50/60/72/80/100/120 |
| 520 | 3 | 2.5 | 50 | 60/72/80/100 |
| 560 | 3 | 2.5 | 50 | 50/60/72/80 |
| 580 | 3.2 | 2.5 | 80 | 60/80/100 |
| 630 | 3.4 | 2.7 | 80 | 50/60/80/100/120 |
| 660 | 3.7 | 3 | 80 | 60/80/100/120 |
| 750 | 3.8 | 3.2 | 80 | 50/60/80/100/120 |
| 840 | 4 | 3.2 | 80 | 50/60/80/100/120 |
| 930 | 4 | 3.2 | 80 | 60 |

## JLH 5-01 Flying Cold Saw (Cutting for pipe)

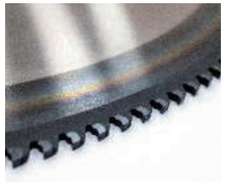
### Product Positioning

Using pipe cutting tip (imported), special tension dealing. Grinded with unique grinding machine, special coating, ensure using life.

Suitable for cold-cutting flying saw equipment, for high-speed online cutting in tube/pipe production.

The tooth profile is designed for sawing tubes with un-scarfed internal weld beads. The teeth offer high sharpness, delivering clean cuts without burrs.











### Description

| Diameter | Kerf | Arbor | Teeth |
|---|---|---|---|
| 350 | 3.2 | 50 | 100T / 110T / 120T |
| 400 | 3.2 | 50 | 110T / 120T / 130T / 140T / 150T |
| 450 | 3.6 | 50 | 130T / 140T / 150T / 160T |
| 500 | 3.6 | 80 | 140T / 150T / 160T / 170T |
| 560 | 3.6 | 80 | 140T / 150T / 160T / 170T / 180T |
| 600 | 3.6 | 80 | 140T / 150T / 160T / 170T / 180T / 200T |
| 630 | 3.6 | 80 | 140T / 150T / 160T / 170T / 180T / 200T |



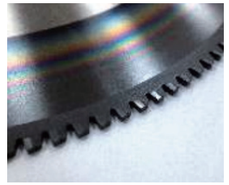
## JLH 5-02 Flying Cold Saw (Cutting for pipe)

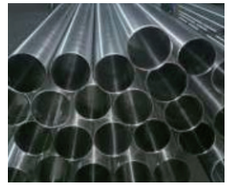
### Product Positioning

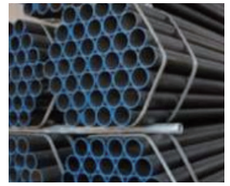
Using pipe cutting tip (imported), special tension dealing. Grinded with unique grinding machine, special coating, ensure using life.

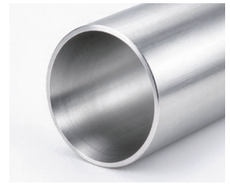
Suitable for cold-cutting flying saw equipment, for high-speed online cutting in tube/pipe production. This is a specially designed saw blade. It delivers excellent cutting performance on tubes without internal weld beads. The tooth profile and tooth back design provide strong impact resistance, excellent cutting capability, and chip resistance, resulting in long tool life.











### Description

| Diameter | Kerf | Arbor | Teeth |
|---|---|---|---|
| 350 | 3.2 | 50 | 100T / 110T / 120T |
| 400 | 3.2 | 50 | 110T / 120T / 130T / 140T / 150T |
| 450 | 3.6 | 50 | 130T / 140T / 150T / 160T |
| 500 | 3.6 | 80 | 140T / 150T / 160T / 170T |
| 560 | 3.6 | 80 | 140T / 150T / 160T / 170T / 180T |
| 600 | 3.6 | 80 | 140T / 150T / 160T / 170T / 180T / 200T |
| 630 | 3.6 | 80 | 140T / 150T / 160T / 170T / 180T / 200T |

## JLH 6 General Carbon Steel Type (Ceramic Tips)

### Product Positioning

A cost-effective solution for carbon steel cutting, ideal for high-efficiency processing of small-diameter workpieces.



### Applicable Materials

- Carbon steel
- Bearing steel
- Alloy steel

### Key Features

- High anti-deformation steel plate design for enhanced rigidity and extended blade life
- Ceramic alloy cutting tips with surface hardening to significantly reduce heat transfer
- Excellent thermal insulation enables fast cutting with smooth, burr-free finishes
- Stable cutting performance with low maintenance cost, suitable for batch production

## JLH 7 High-Performance Carbon Steel Type(Ceramic Tips · Large Gullet Design · AlTiN Coated)

### Product Positioning

A high-efficiency, long-life solution for carbon steel cutting, designed for high-load and continuous production environments.



### Applicable Materials

- Carbon steel
- Bearing steel
- Alloy steel

### Key Features

- Custom ultra anti-deformation steel plates for extended service life
- Large gullet tooth design reduces cutting stress and supports high-speed cutting
- Custom ceramic alloy tips with hardened surfaces for excellent thermal insulation
- Fast cutting speed with flat, burr-free cut surfaces
- Extremely long tool life, commonly referred to as a “cold saw” solution



## JLH 8 Stainless Steel Type(Carbide Tips + Customized Coating)

### Product Positioning

A premium cutting solution designed for stainless steel and difficult-to-machine materials.



### Applicable Materials

- Stainless steel
- Titanium alloy steels

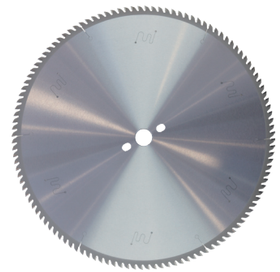
### Key Features

- Custom ultra anti-deformation steel plates for stability under high-load conditions
- High-performance carbide cutting tips with surface hardening
- Special functional gold coating on tips to effectively block heat transfer
- Delivers high efficiency, long service life, and smooth, burr-free cut surfaces
- Ideal for precision cutting of small-diameter stainless steel materials

## JLH 9 Aluminum Cutting Type (Carbide Tips)

### Product Positioning

A high-efficiency cutting solution for aluminum and non-ferrous metals.



### Applicable Materials

- Aluminum profiles
- Aluminum bars
- Copper materials

### Key Features

- Manufactured with imported high-quality steel plates for superior rigidity and longevity
- Carbide cutting tips with surface hardening
- Excellent heat dissipation and chip evacuation for fast, stable cutting
- Clean, burr-free cut surfaces suitable for precision applications
- Ideal for continuous production environments

# 04 Coolants & Cutting Fluids

## Key Features

- Excellent cooling and lubrication performance
- Reduces heat, friction, and tool wear
- Improves cutting stability and surface finish




## Benefits

- Extended blade life
- Improved cutting accuracy
- Reduced machine maintenance

# 05 Machine Wear Parts & Accessories

## Includes

- Guide blocks and guide bearings
- Hydraulic seals
- Feed rollers and clamping components

## Advantages

- Perfect compatibility with JLH machines
- Reduced downtime
- Consistent long-term performance



# 06 Why Choose JLH Consumables

- Engineered specifically for metal sawing applications
- Tested under real industrial cutting conditions
- Compatible with JLH and major international sawing machines
- Reliable supply with consistent quality

## Manufacturing Equipment

