MAXWELL
SLITTER INDUSTRIES

SINCE 1976

CERTIFIED TO
ISO 9001:2015

ROTARY SLITTER KNIVES · METAL & RUBBER SPACERS · PLASTIC SHIMS · SEPARATOR DISCS · SHEAR BLADES · MILL ROLLS

COMPANY & PRODUCT CATALOGUE

PRECISION SLITTING TOOLS, MATCHED TO YOUR LINE.

Rotary knives, spacers and shims, built to your arbor and supplied worldwide.

1976 FOUNDED, RAJPURA (IN)	**30+** COUNTRIES SERVED	**40,000+** BLADES PER YEAR	**In-house** VACUUM HT & CMM METROLOGY

www.maxwellslitters.com · info@maxwellslitters.com

17 INDUSTRIAL ESTATE, RAJPURA, PUNJAB, INDIA

Slitting-line tooling since 1976.

Maxwell Slitter Industries was founded in 1976 by the late Mr. K. B. Gupta as a pioneering manufacturer of slitting-line tooling in Rajpura, Punjab, India. Today the company manufactures rotary slitter knives, shear blades, precision spacers, plastic shims, separator discs and mill tooling for coil-processing plants in more than 30 countries.

Core processes at the Rajpura works run in-house: raw-material selection, CNC machining, vacuum heat treatment, precision grinding and final inspection, under one accountable quality system. Tooling is manufactured to your drawing, sample or OEM part number, with OEM and private-label supply available for machine builders and distributors.

Rotary slitter knives, CNC-ground and lapped at the Rajpura works.

One supplier, one quality system, for the complete slitter head.

1976	30+	40,000+	ISO 9001:2015
FOUNDED	COUNTRIES SERVED	BLADES PRODUCED / YEAR	CERTIFIED QMS

WHY PLANTS CHOOSE MAXWELL

01 Micron-level tolerances
Thickness tolerance as tight as ±0.0015 mm, subject to size and application, verified before dispatch.

02 Matched sets, not loose parts
Knives, spacers and shims built to your arbor and job list.

03 Nearly 50 years, one specialty
Slitter tooling since 1976, never a sideline.

04 Any make, matched
Supplied from a drawing, machine model or a used sample.

05 Tool-steel grades selected for wear resistance and your application
D2, M2, M35 and powder HSS, vacuum-hardened and matched to your material.

06 Global delivery, documented
Exported to 30+ countries, with documentation to suit each destination and agreed order requirements.

Rotary slitter knives, ground for clean, repeatable cuts.

Lapped to Ra 0.2 µm, polished to Ra 0.1 µm on request.

as tight as **±0.0015 mm** THICKNESS TOLERANCE · SUBJECT TO SIZE & APPLICATION

≤ 0.005 mm TIR AXIAL & RADIAL RUNOUT

Laser marking PART · BATCH · DATE · ON EVERY BLADE

DIMENSIONS & TOLERANCES

Outside diameter (OD)	**75 to 600 mm**
Inside diameter (ID)	**20 to 250 mm**
Knife thickness	**1.0 to 25 mm**
Cutting capacity*	**0.1 to 24 mm strip**
Thickness tolerance*	**as tight as ±0.0015 mm**
Flatness*	**≤ 0.001 mm**
Parallelism	**≤ 0.005 mm**
Axial & radial runout	**≤ 0.005 mm TIR**
Surface finish	**Ra 0.2 µm (Ra 0.1 µm on request)**
Keyways	**single / double, wire-EDM**
Marking	**laser: part · batch · date**

*Tolerances are capability figures. Achievable values depend on size, geometry and application, and are confirmed per order. Cutting capacity depends on strip material and hardness.

MATERIAL SELECTION GUIDE

GRADE	EQUIV.	HRC	RECOMMENDED APPLICATION
D2	SKD11 · 1.2379	60 to 62	HR / CR / GI coil slitting, general purpose
HSS M2	1.3343	62 to 64	Stainless and silicon steel, high-speed lines
HSS M35	1.3243	63 to 65	Hardened stainless & CRGO electrical steel
H11 / H13	1.2343 · 1.2344	50 to 55	Hot-rolled coil, side trimming, hot work
PM HSS	Powder HSS (ASP)	64 to 66	Premium long-life, critical applications

Grade guidance only. Final selection is confirmed against your material, line and machine.

SINGLE BEVEL | DOUBLE BEVEL | DISHED (CONCAVE) | RADIUS EDGE

Custom geometry to your drawing, sample or OEM part number.

Send a drawing, DXF or used blade: we reply with a grade recommendation, price and lead time.

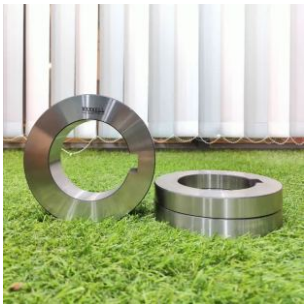
REGRIND & RE-LAP SUPPORT

Complete components for accurate stack builds.

A slit width is only as accurate as the stack behind it. Maxwell manufactures the knives, spacers, shims and separators mounted on the slitter arbor as one matched, traceable tooling system.

TYPICAL ARBOR STACK · SCHEMATIC

SLITTER KNIFE METAL SPACER RUBBER-BONDED SPACER PLASTIC SHIM



MXS 04 **Metal spacers**

EN 31 / EN 19 tool steel, hardened · Thickness 3 to 100 mm
Precision-ground to the tolerance agreed against the approved drawing

Lapped, ground and polished faces support square, stable stacks and accurate strip width.

MXS 05 **Rubber-bonded spacers**

Polyurethane / Nitrile on a steel core · 60 to 95 Shore A · Colour-coded
Precision-ground to the tolerance agreed against the approved drawing

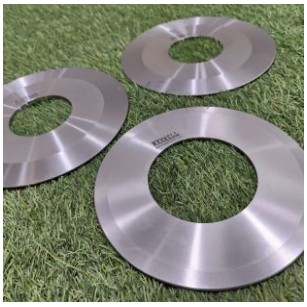
Carry the strip without scratching, protecting coated and bright surfaces through the cut.

MXS 09 **Plastic shims**

Sizes 0.012 to 1.50 mm · Colour-coded · Wear- and oil-resistant polymer
Designed to maintain thickness under normal clamping pressure

Fine clearance and stack-width correction, fitted by cutting and sliding on the arbor, so recurring jobs set up faster with less trial and error.

OptiStack computes the shim combination to your selected setup tolerance (page 7).



MXS 06 **Separator discs**

EN 31 / EN 19 · single-angle and double-angle profiles
Optional chrome plating (low friction)

Overarm discs keep slit strips cleanly separated and guided into recoiling.

Cutting and mill tooling beyond the slitter head.

Guillotine & CTL shear blades to 6000 mm.

MXS 03

Shear blades & guillotine knives

For hydraulic guillotines, cut-to-length lines and heavy shearing. Uniform in-house vacuum hardening along the blade length helps prevent the soft spots that chip edges mid-shift; 2-edge and 4-edge configurations let operators rotate a fresh edge instead of changing blades.

Grades	**D2 · D3 · H13 · H11**	Hardness	**58 to 62 HRC**
Length	**100 to 6000 mm, one piece**	Grinding tolerance	**±0.01 mm**
Types	**flat, slotted, custom**	Edges	**1 / 2 / 4 (rotatable)**

Circular knives

Hardened round precision blades
Custom profiles to drawing

Long-running sharpness for trimming, scoring and converting duties across metal, paper and plastics.

Work rolls

Forged / cast steel · 60 to 105 HSD
Diameter 150 to 700 mm · L 500 to 3500 mm
Finish Ra 0.2 to 1.0 µm

Hard shell over a tough core for skin-pass, tension-levelling and coil-finishing duty; chrome, tungsten-carbide or ceramic coatings to suit mill conditions.

Tube mill rolls MXS 12

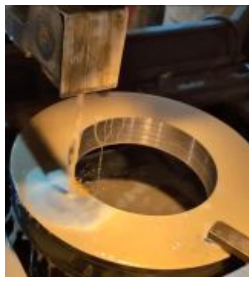
D2 · H13 · EN 31 · 55 to 62 HRC
Breakdown / finpass / weld / sizing
Carbide-inserted options

Profiled for square, round, rectangular and oval sections; high concentricity supports seam-true forming at speed.

Also available on request: top & bottom cutters, crush cutter knives & score blades, metal slitting saws and paper cutters. Ask about additional tooling options or send your tooling list for a consolidated quotation.

Controlled manufacturing, verified dimensions.

Six tightly controlled stages, carried out in-house at the Rajpura works and photographed on our own shop floor. In-house vacuum heat treatment gives close control over hardness, distortion and batch consistency.



STEP 01
Raw material cut
D2 / HSS billets with material documentation.

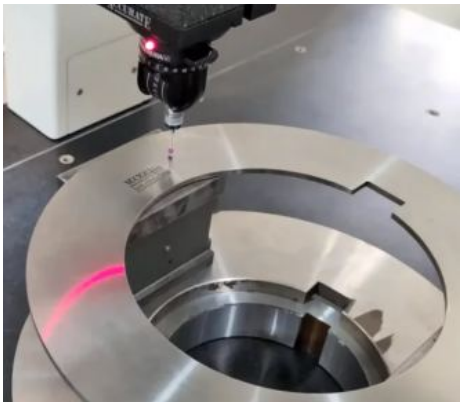
STEP 02
CNC turning
Blanks faced and turned to near-net size.

STEP 03
Vacuum hardening
Multi-stage hardening and tempering to spec.

STEP 04
Precision grinding
Bore and surface ground; faces lapped.

STEP 05
Keyway wire-EDM
Cut to width and depth without distortion.

STEP 06
Laser marking
Part, batch and date etched for traceability.



Coordinate measurement before dispatch.

Every blade inspected. Every certificate documented.

OD, ID, thickness, parallelism and runout are verified by coordinate measurement against your drawing, providing confidence before tooling reaches the slitting line.

- CMM dimensional verification, certificate per batch
- Hardness verified (Equotip)
- Thickness & flatness: Mitutoyo micrometers, granite plate
- Surface roughness checked after lapping (Ra 0.2 µm)

On request, at no extra cost: mill test certificates and dimensional inspection reports. REACH / RoHS declarations also available.

Regrinding to extend usable tooling life.

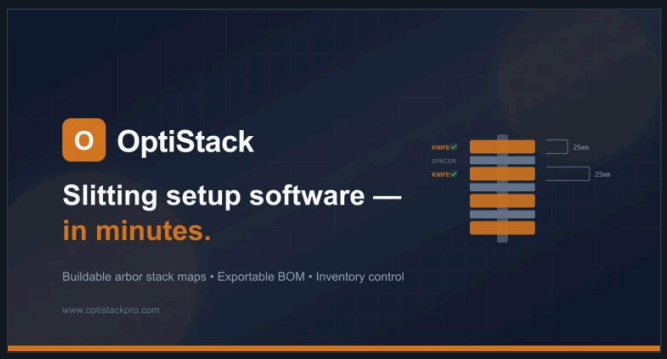
Worn blades reground and re-lapped to the achievable tolerance confirmed after inspection, at a fraction of new-blade cost. Turnaround quoted per order.

REGRIND & RE-LAP SERVICE
RE-INSPECTED BEFORE RETURN
FAST TURNAROUND

OPTISTACK, BY MAXWELL SLITTER INDUSTRIES

From physical tooling to digital setup optimisation.

OptiStack turns a slit order into a buildable arbor stack map and bill of materials, computed from the knives and spacers actually in your crib. It does not replace an experienced operator; it removes the arithmetic between the order book and a correct stack, helping reduce setup errors, spacer guesswork and avoidable trim loss.



Arbor stack map with per-pocket spacer build, output as a printable shop-floor sheet.

HOW IT WORKS

1. Enter coil width, slit pattern and machine preset.
2. Solver checks your real knife and spacer inventory.
3. Stack map + BOM generated for top and bottom arbors.
4. Print the build sheet: the crew loads it as written.

< 60 s	12+	Inventory-based
TYPICAL SETUP CALC	COUNTRIES IN USE	CALCULATED FROM YOUR ENTERED TOOLING

WHAT IT DOES

- **Inventory-only solves.** Works from the knives and spacers actually in stock, so the build sheet matches what is on the shelf.
- **Blocking checks.** Unbuildable jobs return a reason and a missing-tools list to order against.
- **Shop-floor output.** Top and bottom arbor build sheets with spacer widths, quantities and load order, exportable to PDF.
- **Plastic Shim Mode.** Solves in metal first, then computes the shim combination to close the remaining gap within your selected setup tolerance.
- **Shimless option.** Fraction kits (F-0.10 / F-0.01 spacers) support decimal-accurate builds from metal inventory alone.
- **Burr-aware modes.** Alternating knife-engagement modes for consistent thin-gauge setup.
- **Per-machine presets.** Arbor dimensions, clamp reserves and clearance rules stored once and applied per job; edge-quality logging on a 1 to 8 scale.

Reduces setup time and spacer guesswork between the order book and a loaded arbor.

FOR OPERATORS

A printed build sheet in hand reduces manual arithmetic and avoidable setup errors at the arbor.

FOR PLANT MANAGERS

Repeatable setups that depend on the system, not on which operator is on shift, with edge quality logged per job.

FOR PROCUREMENT

OptiStack generates clear, job-specific purchase lists for missing knives and spacers.

Try it on your own inventory: free 14-day trial, no card required.

Free slitting calculator available with no sign-up. Live demos on request.

www.optistackpro.com

Send us your drawing, sample or slitting requirement.

WHAT TO SEND US FOR A QUOTE

01 **Machine make & model** nameplate photo is enough

02 **Outside diameter (OD)**

03 **Inside diameter / bore (ID)**

04 **Knife thickness**

05 **Strip material & thickness** grade, temper, coating

06 **Quantity / sets** one set, annual program or OEM

07 **Drawing or used sample** PDF, DXF or the part itself

08 **Keyway details** if any

HOW ORDERING WORKS

1 **Send** your drawing, sample or machine details.

2 **Receive** a quote and lead time.

3 **Approve,** and we manufacture and ship.

INDUSTRIES SERVED

Steel service centres · Coil processors · Tube & pipe mills · Transformer lamination / CRGO · Aluminium processors · Stainless steel processors · Copper & brass strip · Packaging, paper & converting · OEM machine builders

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EXPORT TERMS

EXW · FOB · CIF · DAP · DDP

Export documentation supplied according to destination and agreed order requirements.

COMMERCIAL TERMS

HS Code 8208.10. FOB Mundra / JNPT. Payment 30% advance, 70% against shipping documents, or L/C at sight. Invoicing in INR, USD, EUR, GBP. Sea freight 12 to 18 days to USA, EU, GCC; air 4 to 6 days.