BUSATEC

MADE IN GERMANY

BAND SAW BLADES

Valid from 01/2025

WELCOME

MADE IN GERMANY

Your partner for high-performance band saw blades for demanding sawing tasks in metalworking. With an extensive range of Bi-Metal and Carbide Tipped Band Saw Blades, BUSATEC convinces worldwide.

Two components – inseparably connected

Our Bi-Metal Band Saw Blades consist of two essential materials. A flexible chrome-alloyed blade backer with about 50 HRC and the particularly wear-resistant HSS wire in the qualities M42 and M51. By using a special heat treatment process, it is ensured that the HSS tooth tips of the Band Saw Blades reach a hardness of about 68 HRC.

Particularly powerful – Carbide Tipped Band Saw Blades

Carbide Tipped Band Saw Blades consist of particularly wear-resistant carbide grades, which are welded onto the blade backer in a special process. Cutting geometries developed according to the sawing tasks achieve maximum cutting performance with low-vibration cuts and particularly smooth material surfaces. Carbide Tipped Band Saw Blades can only be used on sawing machines suitable for this purpose.

The choice is yours

BUSATEC Band Saw Blades are available as coilware or precisely fitting for your sawing machine as endless welded loops.

CONTENT

BREAK-IN PROCEDURE FOR LONG BLADE LIFE

Guarantee for extended blade life

Breaking in a Band Saw Blade is essential to ensure its optimal performance and longevity. This process involves gradually acclimating the blade to tension, temperature, running the machine at slower cutting rates to ensure proper functionality before full operation.

Why is Break-In important ?

- New teeth are very sharp and fragile
- Prevents premature tooth edge fracturing
- Break-in improves overall blade life and cut finish

Instructions

- Reduce band speed by 20% (if you have vibration continue to reduce)
- Reduce feed rate by 20% to 50% depending on material machinability (Harder material requires a higher feed rate reduction)
- Small adjustments to blade speed or feed rate may be necessary if noise or vibration occurs
- Gradually increase feed rate until normal cutting rate are achieved

BG OPTIONAL

BG – NEXT-GEN RAMPING TECHNOLOGY FOR PRECISION IN EVERY CUT!

Advanced ramping technology engineered for superior performance in demanding applications

Benefits

- Custom-designed software ensures maximum flexibility in ramping design
- Adapts to a wider range of material dimensions
- Newly developed system integrates coolant and filtration for higher efficiency and lower operating costs
- Optimized edge geometry reduces stress on the backer, extending blade durability
- Enhances tooth engagement without requiring additional feed pressure

TECHNICAL SPECIFICATIONS

Toothing recommendation for thin-walled profiles

Wall thickness in mm	Profile outer diameter in mm						
	20	40	60	80	100	120	150
2	14	14	14	14	14	14	10/14
3	14	14	14	14	10/14	10/14	8/11 8/12
4	14	14	10/14	10/14	8/11 8/12	8/11 8/12	6/10
5	14	10/14	10/14	8/11 8/12	8/11 8/12	6/10	6/10
6	14	10/14	8/11 8/12	8/11 8/12	6/10	6/10	5/7 5/8
8	14	8/11 8/12	6/10	6/10	5/7 5/8	5/7 5/8	5/7 5/8
10	-	6/10	6/10	5/7 5/8	5/7 5/8	5/7 5/8	-

Toothing recommendation for thick-walled profiles

Wall thickness in mm	Profile outer diameter in mm							
	80	100	120	150	200	300	500	750
10	-	-	-	4/6	4/6	4/6	3/4	2/3
15	4/6	4/6	4/6	4/6	4/6	3/4	2/3	2/3
20	4/6	4/6	4/6	4/6	3/4	3/4	2/3	2/3
30	4/6	4/6	4/6	3/4	3/4	2/3	2/3	2/3
50	-	-	3/4	3/4	2/3	2/3	2/3	1,4/2
80	-	-	-	-	2/3	2/3	1,4/2	1,4/2
100	-	-	-	-	-	2/3	1,4/2	1,4/2

Toothing recommendation for solid material

Cross section mm	Teeth per inch (tpi)
above 550	0,75/1,25
380 - 750	1/1,3
250 - 550	1,4/2
120 - 350	2/3
80 - 140	3/4
60 - 110	4/6
40 - 70	5/7 5/8
30 - 60	6/10
20 - 40	8/11 8/12
up to 25	10/14

Quick Tips

- The required tooth pitch depends on the wall thickness and diameter of the profiles tobe cut. The tables apply to single cuts. If two or more profiles are cut next to each other, the tables apply taking into account two times the wall thickness with a single profile outer diameter
- Always ensure at least 3 teeth are in contact with the material for clean cuts and to avoid blade binding
- For wider material, use lower TPI to reduce strain and improve chip clearance
- For smaller materials, use higher TPI to prevent tearing or jagged edges

BI-METAL BAND SAW BLADES BUSATEC

1104 MARS EXTRA

BG OPTIONAL

- Classic tooth geometry to suit all your generalpurpose needs
- Variable tooth design for a wider range of material sizes
- M42 HSS tooth tip for long and reliable performance

Dimensions mm	Toothing										
	0,75/1,25	1,4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14	14	18
20 x 0,90					•	•	•	•	•	•	•
27 x 0,90			•	•	•	•	•	•	•	•	
34 x 1,10		•	•	•	•	•	•	•	•		
41 x 1,30		•	•	•	•	•					
54 x 1,30	•	•	•								
54 x 1,60	•	•	•								
67 x 1,60		•									
80 x 1,60	•	•									

1204 MARS EXTRA

BG OPTIONAL

- Classic tooth geometry to suit all your generalpurpose needs
- Variable tooth design for a wider range of material sizes
- M51 HSS tooth tip for improved wear resistance

Dimensions mm	Toothing					
	0,75/1,25	1,4/2	2/3	3/4	4/6	5/8
27 x 0,90			•	•	•	•
34 x 1,10		•	•	•	•	
41 x 1,30		•	•	•		
54 x 1,60	•	•	•			
67 x 1,60		•				
80 x 1,60	•	•				

1120 MARS UNIVERSAL

- Robust tooth geometry that provides excellent shock resistance
- Modified guilt design to reduce vibration
- Progressive tooth set produces a smooth workpiece surface and a cut with little burr

Dimensions mm	Toothing				
	2/3	3/4	4/6	5/7	8/11
20 x 0,90			•	•	•
27 x 0,90		•	•	•	•
34 x 1,10	•	•	•	•	
41 x 1,30	•	•	•		
54 x 1,30	•	•	•		
54 x 1,60	•	•			
67 x 1,60	•	•			

1109 MARS PROFIL

- The powerhouse for machining large profiles and beams
- Extended blade life due to robust tooth design even in bundle cutting with chip nests
- Extra wide set prevents jamming in materials with high residual stress

Dimensions mm	Toothing	
	2/3	3/4
54 x 1,60	•	•
67 x 1,90	•	•

1220 MARS UNIVERSAL

- Enhanced Wear Resistance due the M51 edge creates exceptional hardness and wear resistance
- The M51 used in MARS UNIVERSAL maintains its hardness even at higher cutting temperatures to prevent premature tip dulling
- Improved Edge Retention allows for consistent, high-quality cuts over extended periods

Dimensions mm	Toothing	
	2/3	3/4
41 x 1,30	•	•
54 x 1,30	•	•
54 x 1,60	•	•
67 x 1,60	•	•

1209 MARS PROFIL

- The extra-heavy set design, combined with M51's hardness, enhances the blade's ability to withstand higher stresses and resist wear
- Superior Heat Resistance for Heavy-Duty Cuts due to the M51 steel's high-tempera ture performance
- The MARS PROFIL extra-heavy set allows for a more aggressive cutting action, providing better chip remo-val and reducing the risk of pinching

Dimensions mm	Toothing	
	2/3	3/4
54 x 1,60	•	•
67 x 1,60	•	•

1140 GENIUS

BG OPTIONAL

- Aggressive tooth geometry to improve penetration in work-hardening applications
- Variable set and high-low tooth pattern for added penetration while reducing vibration
- High Chrome premium backer for a long blade life

Dimensions mm	Toothing				
	0,75/1,25	1/1,3	1,4/2	2/3	3/4
34 x 1,10				•	•
41 x 1,30			•	•	•
54 x 1,30		•	•	•	•
54 x 1,60		•	•	•	•
67 x 1,60	•	•	•		
80 x 1,60	•	•	•		

1240 GENIUS

BG OPTIONAL

- Aggressive tooth geometry to improve penetration in work-hardening applications
- Variable set and high-low tooth pattern for added penetration while reducing vibration
- M51 HSS tooth tip for im-proved wear resistance

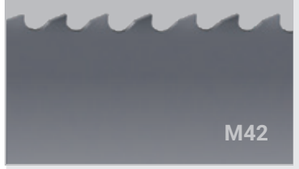
Dimensions mm	Toothing				
	0,75/1,25	1/1,3	1,4/2	2/3	3/4
41 x 1,30			•	•	•
54 x 1,30		•	•	•	•
54 x 1,60		•	•	•	•
67 x 1,60	•	•	•		
80 x 1,60	•	•	•		

1001 COSMO EXTRA

- The budget-friendly choice with a wide range of tooth profiles
- Versatile application for thin-walled profiles up to large solid material work-pieces

Dimensions mm	Toothing							
	1,4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14
6 x 0,90								•
10 x 0,90								•
13 x 0,65					•	•	•	•
13 x 0,90						•	•	•
20 x 0,90				•	•	•	•	•
27 x 0,90		•	•	•	•	•	•	•
34 x 1,10		•	•	•	•	•	•	•
41 x 1,30	•	•	•	•				
54 x 1,30			•	•				
54 x 1,60	•	•	•	•				
67 x 1,60	•	•						

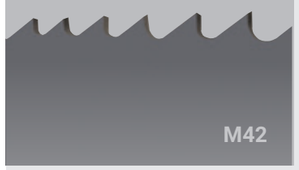
1002 COSMO UNIVERSAL



- The budget-friendly mul-titool with a robust tooth design for varying cutting tasks
- Saves inventory costs with extended tool life in mixed operations
- Reduced blade change

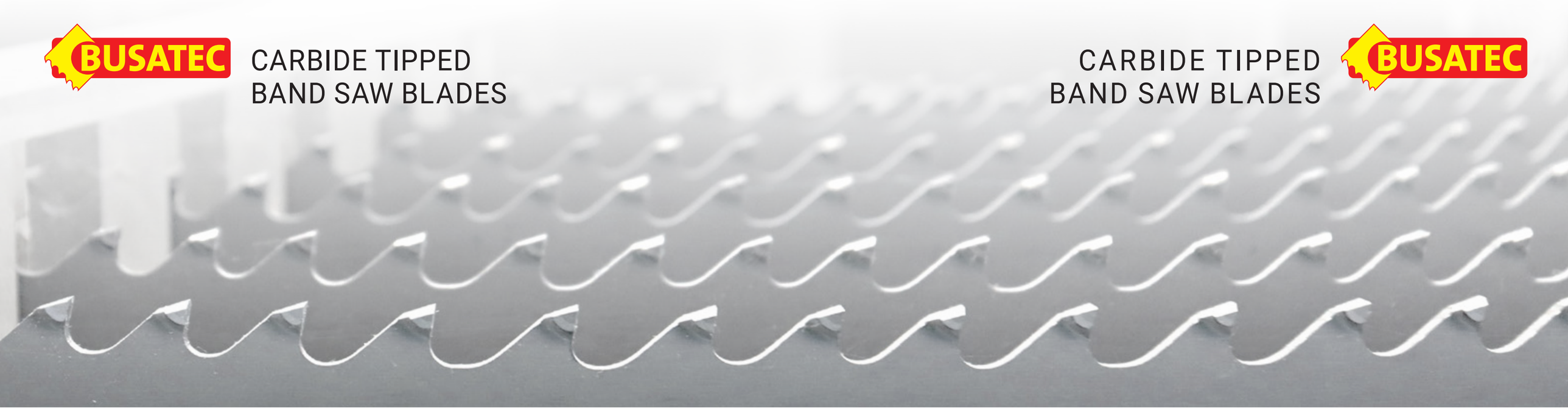
Dimensions mm	Toothing					
	2/3	3/4	4/6	5/7	8/11	12/16
20 x 0,90				•	•	•
27 x 0,90		•	•	•	•	•
34 x 1,10		•	•	•		
41 x 1,30		•	•			
54 x 1,60	•	•				
67 x 1,60	•	•				

1105 ATLAS



- The rustic for repair and dis-mantling of wooden pallets
- Special tooth geometry guarantees constant perfor-mance while sawing through nails and staples

Dimensions mm	Toothing
	5/8
34 x 1,10	•



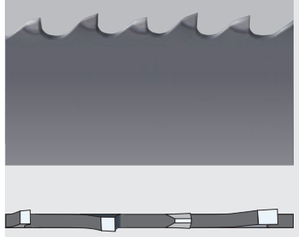
CARBIDE TIPPED
BAND SAW BLADES

1411 TRITON-GP

- Robust Triple chip geometry for consistent performance
- Positive tooth angle with high-low tooth design for increased penetration
- Carbide grade with high resistance

Dimensions mm	Toothing				
	0,75/1,25	1/1,3	1,4/2	2/3	3/4
27 x 0,90				•	•
34 x 1,10				•	•
41 x 1,30			•	•	
54 x 1,30			•	•	•
54 x 1,60		•	•	•	•
67 x 1,60	•	•			
80 x 1,60	•	•			

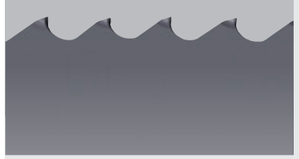
1406 HYDRA



- Modified triple chip geometry combined with set teeth
- Wide kerf to create excellent cut stability
- Robust performance in all machine types

Dimensions mm	Toothing			
	1,4/2	2/3	3	3/4
20 x 0,90			•	
27 x 0,90		•	•	•
34 x 1,10		•		•
41 x 1,30	•	•		
54 x 1,60	•	•		
67 x 1,60	•	•		

1403 ORION



- Multi-chip design
- Developed for fast band speeds
- High positive rake angle to increase penetration

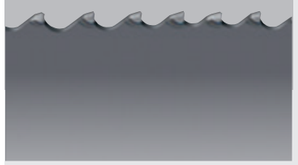
Dimensions mm	Toothing			
	1/1,3	1,4/2	2/3	3/4
34 x 1,10			•	•
41 x 1,30		•	•	•
54 x 1,30			•	•
54 x 1,60		•	•	•
67 x 1,60	•	•		
80 x 1,60		•		

1412 LOTUS

- High performance chrome backer with enhanced carbide grade for maximum performance
- Multi-chip geometry to provide faster cutting times
- High positive rake angle to increase penetration

Dimensions mm	Toothing			
	0,75/1,25	1/1,3	1,4/2	2/3
41 x 1,30			•	•
54 x 1,60		•	•	•
67 x 1,60	•	•	•	
80 x 1,60	•	•		

1404 ORION SUPER



- The expert for surface hardened workpieces
- Special blade with negative rake angle
- Multi chip geometry for highest cutting performance

Dimensions mm	Toothing	
	2/3	3/4
27 x 0,90		•
34 x 1,10		•
41 x 1,30	•	•

1408 NEPTUN

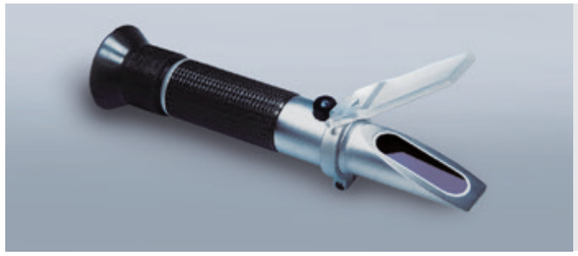
- Triple chip design
- Carbide grade designed for high abrasion
- Developed for high-speed nonferrous applications

Dimensions mm	Toothing					
	0,65/0,95	0,75/1,25	1,4/2	2/3	3	3/4
20 x 0,90					•	
27 x 0,90				•	•	•
34 x 1,10			•	•		•
41 x 1,30			•	•		
54 x 1,30			•	•		
54 x 1,60		•	•			
67 x 1,60		•	•			
80 x 1,60	•	•				

ACCESSORIES

Tension measuring device

The wrong tension of a Band Saw Blade can be the reason for crooked cuts and cause blade breakage. Therefore, the tension should be checked at regular intervals.
Detailed instructions explain how to selectand control the right band tension.



Refractometer

The correct concentration of cooling liquid is important for optimum service life time of Band Saw Blades.
To check the right concentration of liquid while operating it is recommended to use the BUSATEC-Refractometer.

Application case

Making sure your blade runs under perfect conditions.
Featuring: Tension measuring device, refractometer, tachometer and more accessories.

TECHNICAL RECOMMENDATIONS

for Bi-Metal Band Saw Blades

Material groups	Material specification DIN	Material no.	Cutting speed V_c (m/min)	Cooling fluids	
			Bi-Metal	Cutting oil	Emulsion
Structural steels	St 37 – 2 St 50 – 2 St 60 – 2	1.0037 1.0050 1.0060	80-100 60-85 50-70		x x x
Case-hardening steels	C 10 14 NiCr 14 21 NiCrMo 2 16 MnCr 5	1.0301 1.5752 1.6523 1.7131	80-100 40-55 50-60 40-60	x x x x	
Free machining steelse	9 S 20 45 S 20	1.0711 1.0727	80-120 80-120		x x
Heat treatable steels	C 45 40 Mn 4 36 NiCr 6 34 CrNiMo 6 42 CrMo 4	1.0503 1.1157 1.5710 1.6582 1.7225	60-70 60-70 60-70 50-65 50-65		x x x x x
Ball bearing steels	100 Cr 6 100 CrMn 6	1.3505 1.3520	35-50 35-50		x x
Spring steels	65 Si 7 50 CrV 4	1.5028 1.8159	45-60 45-60		x x
Unalloyed tool steels	C 125 W C 75 W	1.1663 1.1750	40-60 40-60		x x
Cold-work tool steels	125 Cr 1 X 210 Cr 12 X 155 CrVMo 12 1 X 42 Cr 13 X 165 CrV 12 100 CrMo 5 X 32 CrMoV 3 3 45 WCrV 7	1.2002 1.2080 1.2379 1.2083 1.2201 1.2303 1.2365 1.2542	40-50 30-40 30-40 35-45 30-45 30-50 45-60 40-50	x x dry x x x x x	x x x x x x x
Hot-work tool steels	56 NiCrMoV 7	1.2714	40-50	x	x
High speed steels	S 6-5-2-5 (E Mo5 Co5) S 2-10-1-8 (M 42) S 6-5-2 (DMo5)	1.3243 1.3247 1.3343	35-45 35-45 35-45		x x x
Valve steels	X 45 CrSi 9 3 X 45 CrNiW 18 9	1.4718 1.4873	30-45 30-40	x x	x x
High temperature steels	X 20 CrMoV 12 1 X 5 NiCrTi 26 15	1.4922 1.4980	10-30 10-30	x x	x x
Heat-resistant steels	X 10 CrSi 6 X 10 CrAl 18 X 15 CrNiSi 25 20	1.4712 1.4742 1.4841	15-25 15-25 15-25	x x x	x x x
Stainless steels	X 5 CrNi 18 10 (V2A) X 6 CrNiMoTi 17 12 2 (V4A)	1.4301 1.4571	30-40 30-40	x x	x x
Steel castings	GS-38 GS-60	1.0420 1.0558	40-60 40-60		x x
Cast irons	GG-15 GG-30 GGG-50 GTW-40 GTS-65	0.6015 0.6030 0.7050 0.8040 0.8165	30-60 30-60 30-60 30-60 30-60	dry dry dry dry dry	
Copper	KE-Cu Elektrolyt-Copper	2.0050	100-400 100-400	x x	x x
Brass (copper-zinc alloys)	CuZn 10 CuZn 31 Si 1	2.0230 2.0490	100-400 100-400		x x
Aluminium bronze (copper-aluminium alloys)	CuAl 8 CuAl 10 Fe 3 Mn 2	2.0920 2.0936	35-50 35-50		x x
Bronze (copper-tin alloys)	CuSn 6 CuSn 6 Zn 6	2.1020 2.1080	80-150 80-150		x x
Red brass (copper-cast alloys)	CuSn 10 Zn CuSn 5 ZnPb	2.1086 2.1096	50-100 50-100		x x
Nickel base alloys	NiCr 20 TiAl NiCr 22 FeMo	2.4631 2.4972	10-25 10-25	x x	x x
Aluminium and aluminium alloys	Al 99.5 AlMgSiPb G-AlSi 5 Mg	3.0255 3.0615 3.2341	80-800 80-800 80-800		x x x
Titanium and titanium alloys	Ti Grade 1 TiAl 6 V 4	3.7025 3.7164	10-20 10-20	x x	x x
Thermoplastic plastics	PVC Teflon, Hostalen		100-400 100-400	dry dry	
Plastics with fibre inlays	Resitex Novotex		50-300 50-300	dry dry	

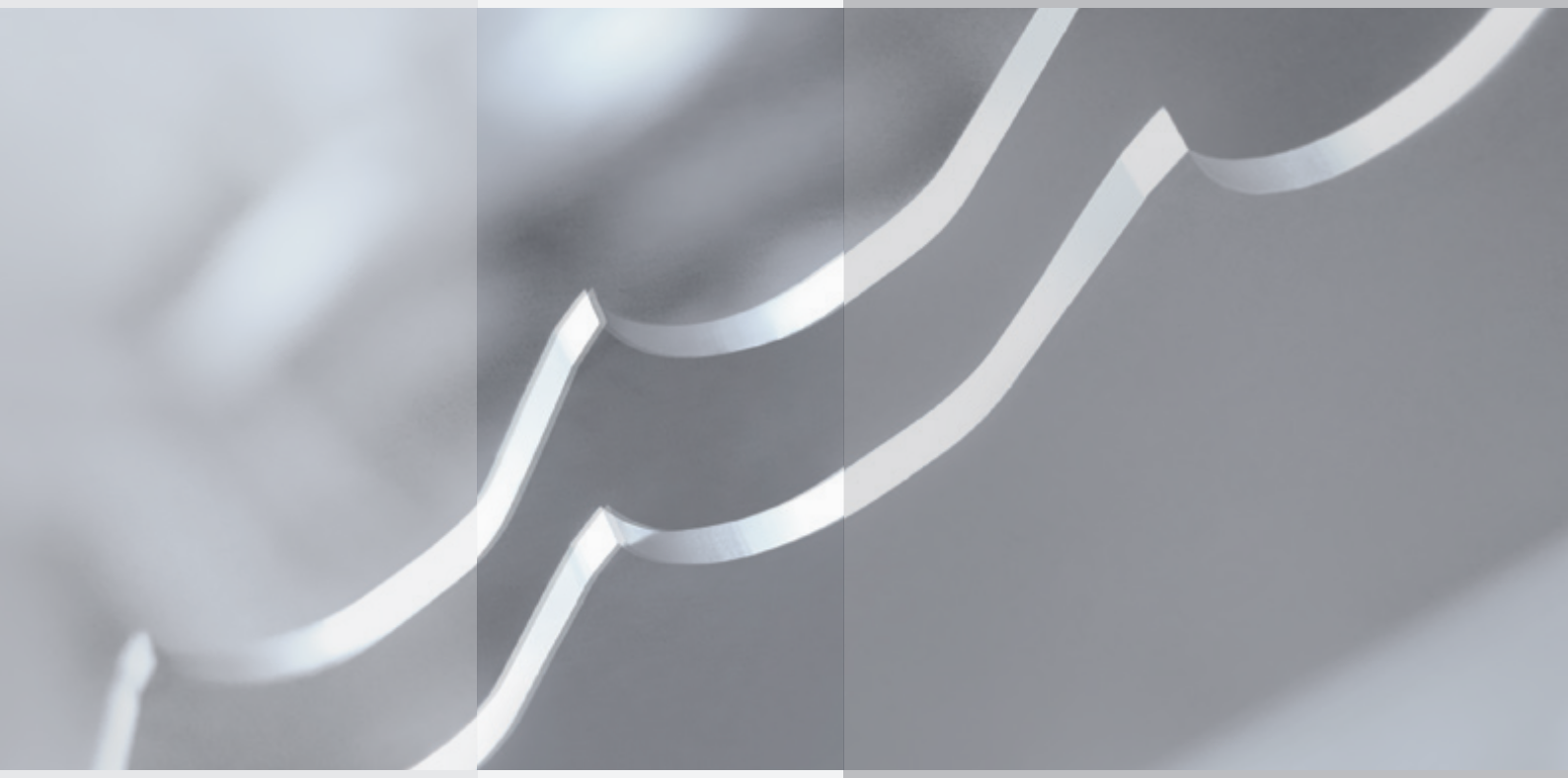
TECHNICAL RECOMMENDATIONS

For Carbide Band Saw Blades (for cutting steel)

Material group	Material specifications DIN	Material no.	Cutting speed	Recommended tooth pitch Material dimensions			
			V_c (m/min)	75 - 140 mm	100 - 350 mm	300 - 550 mm	≥ 540 mm
Structural steels	St 37/42 St 52/60	1.0037/1.0042 1.0050/1.0060	100-130 90-120	3/4 3/4	3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2	0,75/1,25 0,75/1,25
Case-hardening steels	C10/C15 16 MnCr 5 20 CrMo 5 21 NiCrMo 2	1.0301/1.0401 1.7131 1.7264 1.6523	110-140 80-100 80-100 70-90	3/4 3/4 3/4 3/4	3 tpi 2/3 3 tpi 2/3 3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2 1,4/2 1,4/2	0,75/1,25 0,75/1,25 0,75/1,25 0,75/1,25
Nitridee steels	34 CrAlNi 7 34 CrAlMo 5	1.8550 1.8507	45-60 45-60	3/4 3/4	3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2	0,75/1,25 0,75/1,25
Free machining steels	9 S 20	1.0711	100-160	3/4	3 tpi 2/3	1,4/2	0,75/1,25
Heat treatable steels	C 35/45 42 CrMo 4 34 CrNiMo 6	1.0501/1.0503 1.7225 1.6582	90-120 70-90 70-90	3/4 3/4 3/4	3 tpi 2/3 3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2 1,4/2	0,75/1,25 0,75/1,25 0,75/1,25
Ball bearing steels	100 Cr 6 100 CrMo 7 3	1.3505 1.3536	70-90 65-85	3/4 3/4	3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2	0,75/1,25 0,75/1,25
Spring steels	65 Si 7 50 CrV 4	1.5028 1.8159	65-85 65-85	3/4 3/4	3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2	0,75/1,25 0,75/1,25
Unalloyed tool steels	C 125 W C 80 W 1	1.1663 1.1525	65-80 70-85	3/4 3/4	3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2	0,75/1,25 0,75/1,25
Cold-work tool steels	125 Cr 1 X 210 Cr 12 X 155 CrVMO 12 1 90 MnCrV 8	1.2002 1.2080 1.2379 1.2842	65-80 40-50 40-50 45-55	3/4 3/4 3/4 3/4	3 tpi 2/3 3 tpi 2/3 3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2 1,4/2 1,4/2	0,75/1,25 0,75/1,25 0,75/1,25 0,75/1,25
Hot-work tool steels	40 CrMnMo 7 X 40 CrMoV 5 1 56 NiCrMoV 7 40 CrMnNiMo 8 6 4	1.2311 1.2344 1.2714 1.2738	70-90 60-80 50-70 35-50	3/4 3/4 3/4 3/4	3 tpi 2/3 3 tpi 2/3 3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2 1,4/2 1,4/2	0,75/1,25 0,75/1,25 0,75/1,25 0,75/1,25
High speed steels	S 6-5-2 S 3-3-2 S 2-10-1-8 S 10-4-3-10 S 18-0-1	1.3343 1.3333 1.3247 1.3207 1.3355	50-60 55-65 45-60 45-60 45-60	3/4 3/4 3/4 3/4 3/4	3 tpi 2/3 3 tpi 2/3 3 tpi 2/3 3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2 1,4/2 1,4/2 1,4/2	0,75/1,25 0,75/1,25 0,75/1,25 0,75/1,25 0,75/1,25
Stainless steels	X 5 CrNi 18 10 X 6CrNiMoTi 17 12 2 X 20 Cr 13	1.4301 1.4571 1.4021	70-80 65-75 80-100	3/4 3/4 3/4	3 tpi 2/3 3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2 1,4/2	0,75/1,25 0,75/1,25 0,75/1,25
Valve steels	X 45 CrSi 9 3 X 45 CrNiW 18 9	1.4718 1.4873	50-60 40-50	3/4 3/4	3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2	0,75/1,25 0,75/1,25
High temperature steels	X 12 CrCoNi 21 20 X 20 CrMoWV 12 1	1.4971 1.4935	30-40 80-100	3/4 3/4	3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2	0,75/1,25 0,75/1,25
Heat-resistant steels	X 15 CrNiSi 25 20 X 12 NiCrSi 36 16	1.4841 1.4864	30-40 30-40	3/4 3/4	3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2	0,75/1,25 0,75/1,25
Special alloys	NiCr 19 NbMo NiMo 30 NiCr 13 Mo 6 Ti 3 NiCo 20 Cr 20 MoTi X 8 CrNiAlTi 20 20	2.4668 2.4810 2.4662 2.4650 1.4847	20-30 22-35 20-30 22-35 22-35	3/4 3/4 3/4 3/4 3/4	3 tpi 2/3 3 tpi 2/3 3 tpi 2/3 3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2 1,4/2 1,4/2 1,4/2	0,75/1,25 0,75/1,25 0,75/1,25 0,75/1,25 0,75/1,25
Heat treated steels 1000 - 1200 N/mm² 1200 - 1400 N/mm² 1400 - 1600 N/mm²			 35-50 30-45 25-35	 3/4 3/4 3/4	 3 tpi 2/3 3 tpi 2/3 3 tpi 2/3	 1,4/2 1,4/2 1,4/2	 0,75/1,25 0,75/1,25 0,75/1,25
Hardened steels 50 HRC 55 HRC 60 HRC			 15-20 10-15 8-12	 3/4 3/4 3/4	 3 tpi 2/3 3 tpi 2/3 3 tpi 2/3	 1,4/2 1,4/2 1,4/2	 0,75/1,25 0,75/1,25 0,75/1,25
Steel castings	GS-38 GS-60	1.0420 1.0558	70-100 60-85	3/4 3/4	3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2	0,75/1,25 0,75/1,25
Cast irons	GG-30 GGG-50	0.6030 0.7050	60-80 55-75	3/4 3/4	3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2	0,75/1,25 0,75/1,25

For Carbide Band Saw Blades (for cutting non ferrous metals)

Material group	Material specifications DIN	Material no.	Cutting speed	Recommended tooth pitch Material dimensions			
			V_c (m/min)	75 - 140 mm	100 - 350 mm	300 - 550 mm	≥ 540 mm
Aluminium and aluminium alloys	Al 99,5 AlMg 1 AlMg 3 AlMg 4.5Mn AlMgSi 1	3.0255 3.3315 3.3535 3.3547 3.2315	to 3000 to zu 3000 to zu 3000 to zu 3000 to zu 3000	3/4 3/4 3/4 3/4 3/4	3 tpi 2/3 3 tpi 2/3 3 tpi 2/3 3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2 1,4/2 1,4/2 1,4/2	0,75/1,25 0,75/1,25 0,75/1,25 0,75/1,25 0,75/1,25
Copper	KE-Cu E-Cu	2.0050 2.0060	100-200 100-200	3/4 3/4	3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2	0,75/1,25 0,75/1,25
Brass (copper-zinc alloys)	CuZn 39 Pb 3 VuZn 31 Si	2.0401 2.0230	150-250 150-250	3/4 3/4	3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2	0,75/1,25 0,75/1,25
Bronze	CuSn 6	2.1020	90-130	3/4	3 tpi 2/3	1,4/2	0,75/1,25
Red brass	CuSn 5 ZnPb CuSn 10 Zn	2.1096 2.1086	90-130 90-130	3/4 3/4	3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2	0,75/1,25 0,75/1,25
Aluminium-bronze	CuAl 8 CuAl 8 Fe 38 CuAl 10 Ni 5 Fe 4	2.0920 2.0920.60 2.0966	60-80 52-65 50-70	3/4 3/4 3/4	3 tpi 2/3 3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2 1,4/2	0,75/1,25 0,75/1,25 0,75/1,25
Titanium and titanium alloys	Ti Grade 1 TiAl 6 V 4	3.7025 3.7164	80-100 60-90	3/4 3/4	3 tpi 2/3 3 tpi 2/3	1,4/2 1,4/2	0,75/1,25 0,75/1,25



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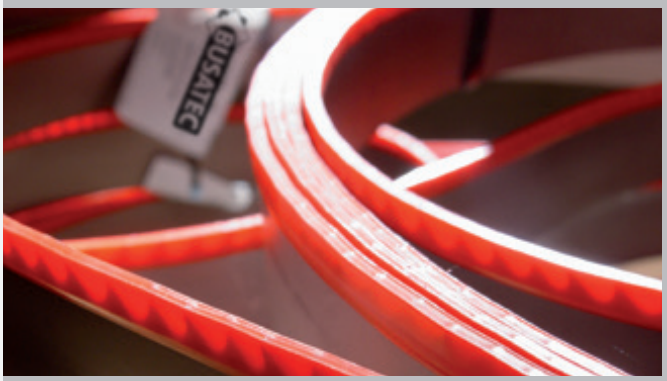

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