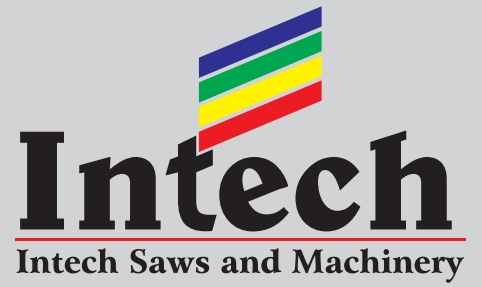
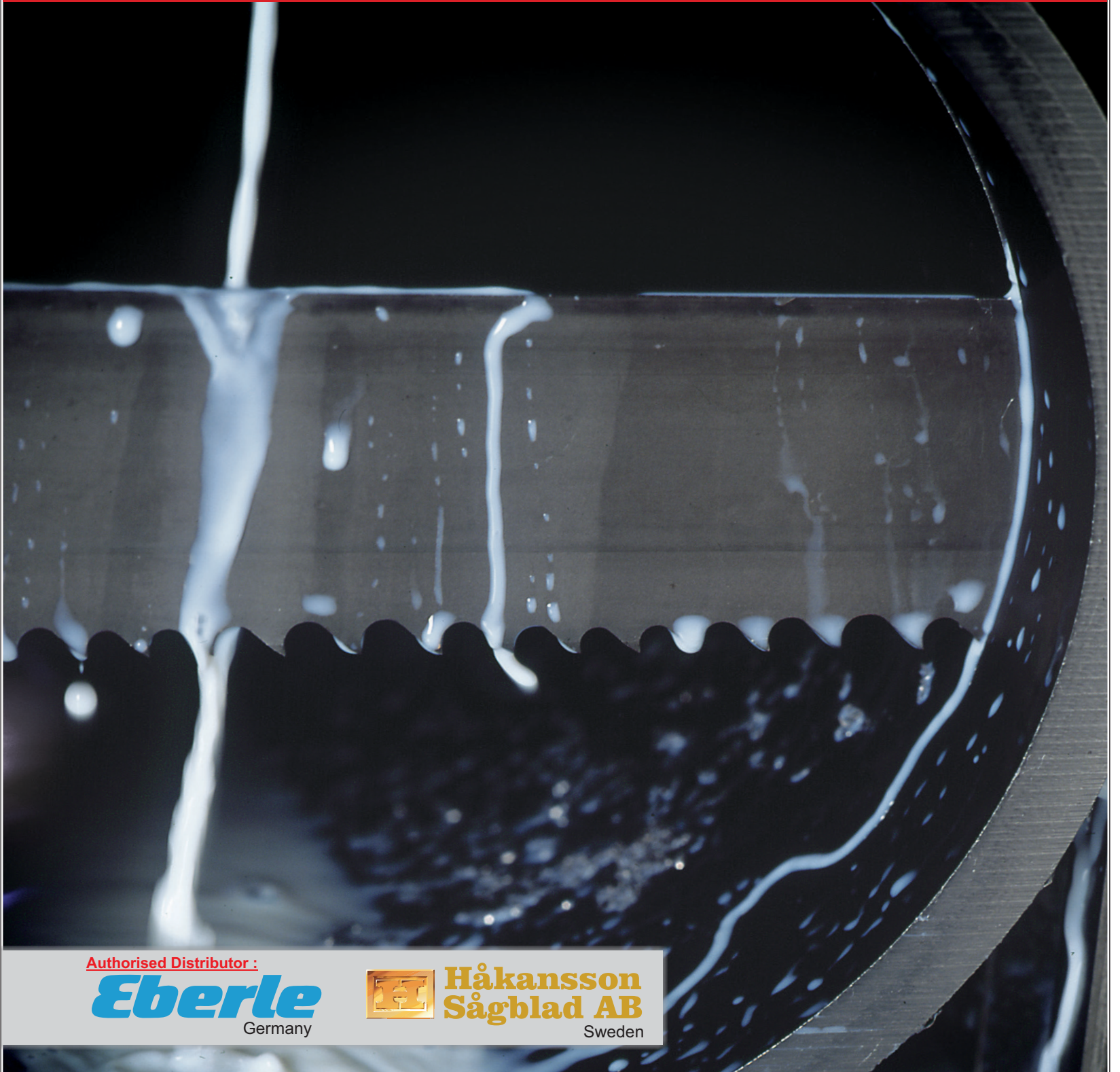


Precision, Quality Innovation



# BAND SAW BLADES



Authorised Distributor :

**Eberle**  
Germany



**Håkansson**  
**Sågblad AB**  
Sweden

# BI-METAL BAND SAW BLADES

## CUTTING DATA



Material	DIN	USA	JIS	Speed m/min	Cutting rate cm <sup>2</sup> /min
1.0060	St 60-2	A 572 Gr.65	SM 58	40-70	20-40
1.0401	C15	1016	S 15C	40-70	20-40
1.0503	C45	1045	S 45C	40-74	20-45
1.0570	St 52-3	A 572 Gr.50	SM 490	40-74	20-45
1.1158	Ck25	1025	S25C	40-74	20-45
1.1221	Ck60	1060	S58C	35-74	15-45
1.2080	X210Cr12	D3	SKD 1	15-37	5-18
1.2312	40CrMnMoS 8-6			25-59	10-30
1.2343	X38CrMoV5-1	H11	SKO 6	22-45	10-24
1.2363	X100CrMoV5-1	A2	SKD12	20-42	8-20
1.2379	X155CrVMo12-1	2	SKO 11	15-37	5-18
1.2510	100 MnCr 4	1	SKS 3	26-46	12-24
1.2606	X37CrMo 5-1	H12	SKD 62	20-46	8-24
1.2714	56 NiCrMoV7	L6	SKT 4	26-46	12-26
1.2842	90 MnCrV 8	2		24-45	12-24
1.3343	s 6-5-2	M2	SKH 51	26-40	12-20
1.3247	S2-20-1-8	M42	SKH 59	26-40	12-20
1.3965	X8CrMnNi 18-8	Nitronic 50		12-32	4-12
1.4006	X10Cr13	410	SUS410	20-34	8-16
1.4028	X20Cr13	420	sus 420J1	26-38	6-20
1.4125	X105CrMo17	440	C SUS 440C	16-37	6-18
1.4301	X5CrNi 18-10	304	sus 304	16-38	6-20
1.4401	X5CrNiMo 17-12-2	316	sus 316	16-36	6-18
1.4462	X2CrNiMoN 22-5-3	2205	SUS 329J3L	16-34	6-14
1.4571	X6 CrNiMoTi17-12 -2	316 Ti	SUS316	16-34	6-14
1.4841	X15CrNiSi 25-20	314	SUH 310	14-32	4-12
1.4864	X12NiCrSi 36-16	330	SUH 330	14-32	4-12
1.4923	X22 CrMoV 12 -1			14-32	4-12
1.4980	X5 NiCrTi 26-15	A286	SUH 660	14-32	4-12
1.5710	36 NiCr6	(X)3140		26-52	12-28
1.5755	31 NiCr14	3415	SNC 815	30-54	14-30
1.6310	20 MnMoNi-5			26-52	12-28
1.6523	20 NiCrMo2	8620	SNCM 220	26-54	14-30
1.6546	40 NiCrMo 2-2	8640	SNCM 240	30-54	10-30
1.6562	40 NiCrMo7	E4340	SNB24-1-5	30-54	10-30
1.6749	23 CrNiMo 7- 4-7			30-54	10-28
1.6985	28 CrMoNiV 4-9			36-58	16-34
1.7147	20 MnCr5	5120	SMnC420H	38-62	18-36
1.7225	42 CrMo4	4140	SCM 440	36-58	16-34
1.7228	50 CrMo4	4150	SCM 445	34-60	16-36
1.7335	13CrMo 4-4	A387 Gr. 12	SFVA F 12	40-64	18-38
1.7707	30 CrMoV9			28-58	16-34
1.8159	50 CrV4	6150	SUP10	32-54	12-30
1.8509	41 CrAlMo 7	A 355 Cl. A	SACM 645	18-45	8-24

## GENERAL INFORMATION

# SAW ADJUSTING

## BEFORE OPERATING THE SAW, CHECK THE FOLLOWING

Consult our cutting chart for recommended feed and speed.

Teeth must be pointing in the right direction.

Check guides of band saw machine, also clearance between the guides and blade.

Hold material securely.

Consult our cutting chart for recommended coolant.

## TENSION METER

Correct band tension is essential for straight cut and prolonged blade life.

Article No: 97 100 200



## TACHOMETER

Digital tachometer showing the band speed in feet/min as well as m/min

Article No: 97 100 300



## REFRACTOMETER

Proper concentration of the cooling lubricants is of utmost importance for the teeth.

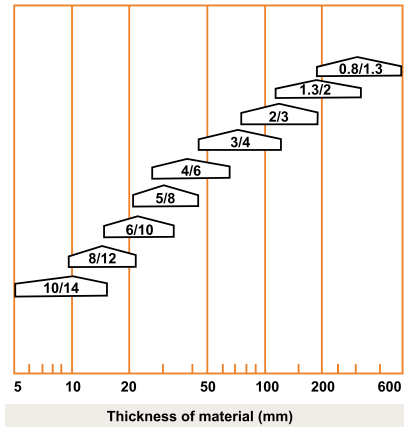
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## GENERAL INFORMATION

# RECOMMENDED TOOTH PITCH FOR...

### SOLID WORK PIECE

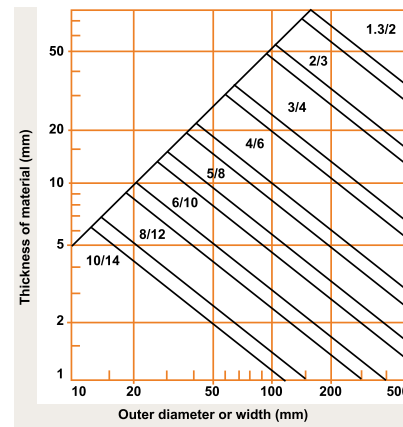


The adjoining diagram is a guide to your choice of tooth pitch when cutting solid work pieces.

The very best choice is where the tooth pitch-area is at its widest.

When cutting soft materials such as wood, plastics, aluminum etc. choose a two step coarser tooth pitch.

### PIPES AND PROFILES

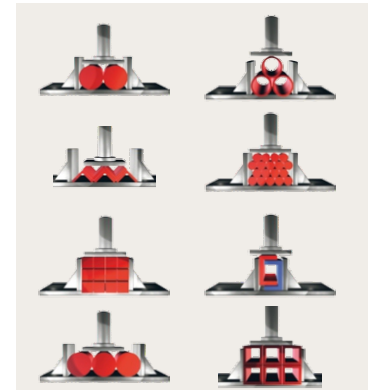
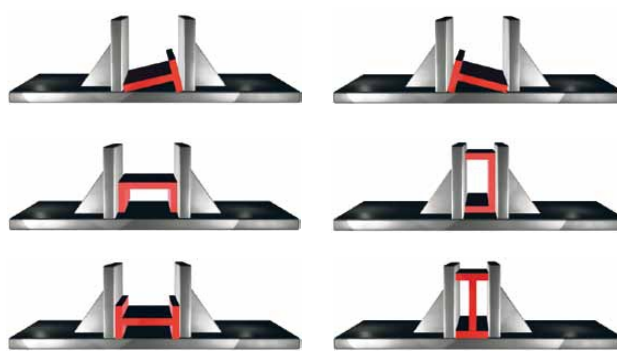
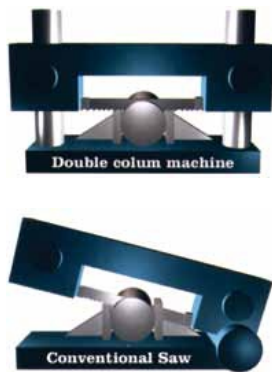


The adjoining diagram is a guide to your choice of tooth pitch when cutting pipes and profiles.

The very best choice is in the area, where a line from the outer diameter crosses a line from the thickness of the material.

When cutting profiles, choose the tooth pitch, where the line from the width of the profile crosses the line from the material thickness of the profile.

## HOW TO CLAMP



## BREAKING-IN A BAND SAW BLADE

**Bi-Metal band saw blade:** To achieve a long blade life the breaking-in of the blade is important. A new band saw blade should operate with 50 % of full feed rate, for about 15 minutes. After that the feed rate may be increased slowly up to the full rate.

**Carbide tipped band saw blade:** This type of blade should operate with 75 % of the cutting speed and 50 % of the feed rate during breaking-in, about 15 minutes. The cutting speed and feed rate can then slowly be increased up to the full rate.