



BAND SAW BLADES

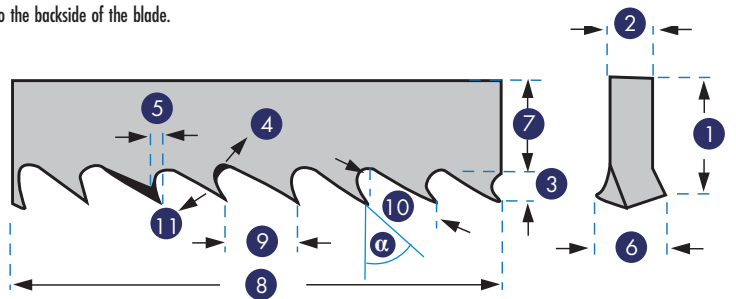
BLUE-MASTER[®]
by CELESA

BLUE-MASTER[®]
by *CELESA*

CUTTING TECHNOLOGIES

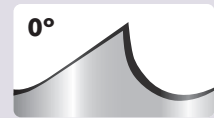
BAND SAW BLADES TERMINOLOGY

1. **WIDTH:** The nominal dimension of a bandsaw blade, which is measured from the top of the tooth to the backside of the blade.
2. **THICKNESS (gauge):** The thickness of the blade.
3. **TOOTH:** The cutting part of the saw blade.
4. **GULLET:** The curved area at the base of the tooth.
5. **CHIPPING FACE OR RAKE ANGLE:** The cutting surface of the tooth.
6. **TOOTH SET:** The bending of the teeth from right to left to allow clearance (kerf) of the blade back through the cut.
7. **BODY OF THE BANDSAW:** The body of the band saw without including the cutting teeth.
8. **TPI.:** The number of teeth per inch.
9. **TEETH PITCH:** The distance from one tip to the next tip.
10. **GULLET DEPTH:** The distance from the tip to the bottom of the gullet.
11. **TOOTH BACK OR RELIEF SURFACE:** The surface of the tooth opposite the cutting edge, or tooth face.



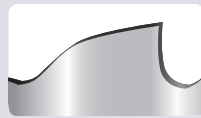
TEETH TYPES

The teeth selection is very important to work different thicknesses with band saw blades. If we don't use the correct one, we must know that performance of the band saw will be low due to teeth breaking or wearing.



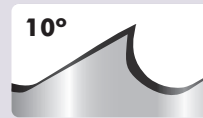
USUAL TOOTH

The usual tooth has a cutting angle of 0°. It is suitable for cutting materials with a high carbon content, such as cast iron, for materials with small cross sections and for thin-wall profiles and pipes.



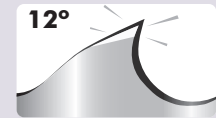
REINFORCED

Reinforced teeth with extra setting for profile and structural steel cutting. Teeth lifetime guaranteed. Specially recommended for hand use machines, with high looseness and vibrations.



HOOK TOOTH HR

The hook tooth has a positive cutting angle of 10°. This tooth form is particularly suitable for cutting solid, thick-walled tubes and all higher-grade alloy material.

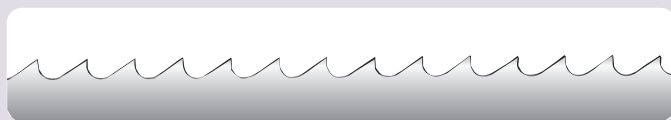


MASTER

The tooth has a cutting angle of both 10 or 16°. The master teeth is based on a high-low triple chip design recognised as one of the most efficient in engineering cutting technology. Used to cover a wide range of difficult steel and exotic alloys.

TEETH PITCH

Tooth pitch is measured in number of teeth per inch. For combi (variable) tooth pitches, the two figures represent the highest and lowest possible number of teeth.



REGULAR TEETH PITCH:

The distance between the teeth is constant throughout the blade. Very convenient for cutting solid materials on sawing machines with efficient clamping. Very effective on high alloy steels and exotic alloys.



COMBI (VARIABLE) TEETH PITCH:

Combi (variable) teeth pitch is based on groups of different tooth pitches which are repeated at regular intervals throughout the blade. Reducing vibration through resonance during cutting is the purpose of this concept. Sawing thin-walled hollow sections and material in bundles or with weak clamping are typical applications for this tooth pitch configuration.

WHEN DO I USE THE VARIABLE TEETH AND WHEN THE REGULAR?

VARIABLE (COMBI) TEETH PITCH

- Steel
- Stainless Steel
- Bronze

REGULAR TEETH PITCH

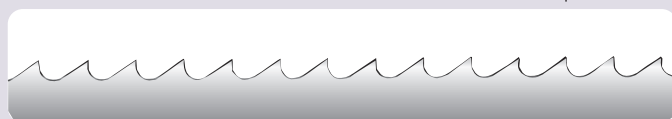
- Brass
- Aluminium
- Copper
- Wood



HOW TO IDENTIFY A CONCRETE TEETH ?

REGULAR

25,4 mm (1")



10 gullets = 10 RR

VARIABLE

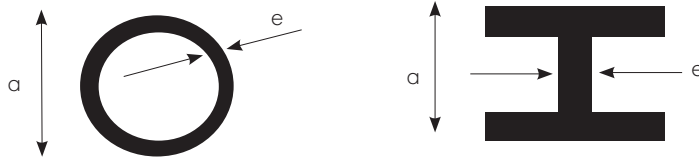
50,8 mm (2")



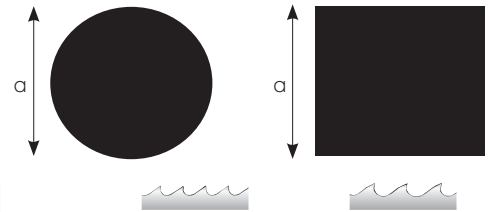
10 gullets = 4/6

RECOMMENDATIONS FOR CORRECT TOOTH SELECTION IN TUBES & PROFILES CUTTING

FOR TUBES AND STRUCTURAL PROFILES



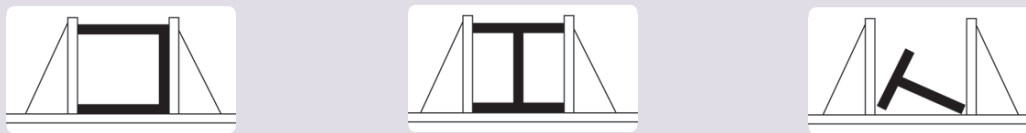
FOR SOLID WORKPIECES



		DIMENSION α									
		20	40	60	80	100	120	150	200	300	500
THICKNESS e	2	14/18	10/14	10/14	10/14	10/14	8/12	8/12	8/12	8/12	5/8
	3	14/18	10/14	10/14	8/12	8/12	8/12	8/12	6/10	6/10	5/8
	4	10/14	10/14	8/12	8/12	8/12	6/10	6/10	5/8	5/8	4/6
	5	10/14	10/14	8/12	8/12	6/10	6/10	5/8	4/6	4/6	4/6
	6	10/14	10/14	8/12	8/12	6/10	5/8	5/8	4/6	4/6	4/6
	8	10/14	8/12	8/12	6/10	5/8	5/8	4/6	4/6	4/6	4/6
	10	-	8/12	6/10	5/8	4/6	4/6	4/6	4/6	4/6	4/5
	12	-	8/12	6/10	4/6	4/6	4/6	4/6	4/6	4/6	4/5
	15	-	8/12	6/10	4/6	4/6	4/6	4/6	4/5	4/5	4/5
	20	-	-	4/6	4/6	4/6	4/6	4/5	4/5	4/5	3/4
	30	-	-	-	4/6	4/5	4/5	4/5	4/5	4/5	2/3
	50	-	-	-	-	-	-	4/5	3/4	2/3	2/3
80	-	-	-	-	-	-	-	3/4	2/3	2/3	
>100	-	-	-	-	-	-	-	-	2/3	1,5/2	

α mm	Regular	α mm	Variable
<5	18	<10	14/18
5-10	14	10-20	10/14
10-30	10	15-40	8/12
30-50	8	25-50	6/10
50-80	6	35-70	5/8
80-120	4	40-90	5/6
120-200	3	50-120	4/6
200-400	2	80-180	3/4
300-700	1,25	130-350	2/3
>600	0,75	150-450	1,5/2
		200-600	1,1/1,6
		>500	0,75/1,25

CORRECT WAYS TO FIX PIECES



CUTTING SPEEDS FOR SECTIONS FROM 75 to 150 mm

MATERIAL	REFERENCE H.I.A.	EQUIVALENT A.I.S.A.-S.A.E.	M.P.M.	MATERIAL	REFERENCE H.I.A.	EQUIVALENT A.I.S.A.-S.A.E.	M.P.M.
CARBON STEEL	F-111, F-112	1015-1025	95	DEFORMABLE	F-521	D-2, D-3	33
	F-113	1035	65		F-522	O-1	58
	F-114, F-115	1045-1055	60		-	D-7	25
	F-512, F-516	W-1	55	SHOCK	F-524	S-1	58
HIGH PERFORMANCE ALLOY	F-123	3435	60		F-525	-	60
	F-125	4135	70		-	S-2, S-5	40
	F-127, F-128	4340	65	HOT WORKING PIECES	F-524	H-20	60
	F-131, F-523	L-3	50		F-527	-	55
FOR SPRINGS	F-143	6150	60		F-528	L-S	55
	F-144	9225	60	F-537	H-13	58	
	CEMENTED	F-151	1010	90	CUTTING	F-531	F-3
F-153		3310	55	F-532		F-1	50
F-154		3415	58	FAST	F-550-A	M-2	40
F-155		-	62		F-550-C	M-35	20
STAINLESS STEEL	F-311, F-312	410-420	40		F-552	T-1	35
	-	430	26		F-533	T-4	30
	F-313	431	32	F-554	T-5	30	
	F-314	301-304	30	Ni ALLOY		MONEL	22
	F-321, F-322	343	32			INCONEL	20
	-	316	22			HASTELLOY	20
-	446	18			TITANIO	20	

Increase speed: 10/20% for sections under 75 mm. Reduce speed: 10/20% for sections above 150 mm.

BI-METAL BAND SAWS
6 mm x 0,65 mm (1/4" x 0,025")

QUALITY: M42 (8% Co)

LENGTH mm	€	AVAILABLE TEETH									
1.325	27,69	<table border="1"> <thead> <tr> <th>Ref.</th> <th>TPI</th> <th>α</th> </tr> </thead> <tbody> <tr> <td>560</td> <td>6 HR</td> <td>Hook 10°</td> </tr> <tr> <td>561</td> <td>10/14</td> <td>0°</td> </tr> </tbody> </table>	Ref.	TPI	α	560	6 HR	Hook 10°	561	10/14	0°
Ref.	TPI		α								
560	6 HR		Hook 10°								
561	10/14		0°								
1.425	29,14										
1.500	30,22										
1.680	32,81										
2.000	37,42										
2.370	42,13										
2.600	46,05										
2.700	47,50										
2.730	47,93										
2.760	48,38										
2.860	49,81										
2.900	50,38										
3.000	51,82										
3.100	53,26										
3.135	53,76										
3.300	56,13										
3.320	56,42										
3.353	56,90										
3.840	63,91										

6 mm x 0,90 mm (1/4" x 0,035")

QUALITY: M42 (8% Co)

LENGTH mm	€	AVAILABLE TEETH									
1.325	27,69	<table border="1"> <thead> <tr> <th>Ref.</th> <th>TPI</th> <th>α</th> </tr> </thead> <tbody> <tr> <td>501</td> <td>6 HR</td> <td>Hook 10°</td> </tr> <tr> <td>504</td> <td>10/14</td> <td>0°</td> </tr> </tbody> </table>	Ref.	TPI	α	501	6 HR	Hook 10°	504	10/14	0°
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3.135	53,76										
3.300	56,13										
3.320	56,42										
3.353	56,90										
3.840	63,91										

The reference indicates the band saw's geometry: width, thickness and tooth type.

HOW TO ORDER A BANDSAW:

Please quote the length in mm and the reference.

EXAMPLE:

1 Ut 1325 mm. Ref. 504 = 1 Ut 1325 x 6,5 x 0,90 teeth 10/14 Variable

- For intermediate lengths that do not appear on the price list, take the price of the superior length.


15 METERS COILS

QUALITY: M42 (8% Co)

	TEETH	€
560	6 HR Hook 10°	216,05
561	10/14 0°	216,05

15 METERS COILS

QUALITY: M42 (8% Co)

	TEETH	€
501	6 HR Hook 10°	216,05
504	10/14 0°	216,05

30 METERS COILS

QUALITY: M42 (8% Co)

	TEETH	€
560	6 HR Hook 10°	432,10
561	10/14 0°	432,10

30 METERS COILS

QUALITY: M42 (8% Co)

	TEETH	€
501	6 HR Hook 10°	432,10
504	10/14 0°	432,10

BI-METAL BAND SAWS

10 mm x 0,65 mm (3/8" x 0,025")

QUALITY: M42 (8% Co)											
LENGTH mm	€	AVAILABLE TEETH									
1.137	24,98	<table border="1"> <thead> <tr> <th>Ref.</th> <th>TPI</th> <th>α</th> </tr> </thead> <tbody> <tr> <td>512</td> <td>6 HR</td> <td>Hook 10°</td> </tr> <tr> <td>510</td> <td>10/14</td> <td>0°</td> </tr> </tbody> </table>	Ref.	TPI	α	512	6 HR	Hook 10°	510	10/14	0°
Ref.	TPI		α								
512	6 HR		Hook 10°								
510	10/14		0°								
1.140	25,03										
1.300	27,33										
1.325	27,69										
1.340	27,92										
1.350	28,07										
1.500	30,22										
1.580	31,36										
1.660	32,53										
2.360	42,59										
2.640	46,63										
2.720	47,80										
2.800	48,93										
2.900	50,38										
2.945	51,02										
3.250	55,41										
3.300	56,13										
3.350	56,87										
3.353	56,90										
3.400	57,59										
3.800	63,34										

10 mm x 0,90 mm (3/8" x 0,035")

QUALITY: M42 (8% Co)																				
LENGTH mm	€	AVAILABLE TEETH																		
1.137	24,98	<table border="1"> <thead> <tr> <th>Ref.</th> <th>TPI</th> <th>α</th> </tr> </thead> <tbody> <tr> <td>511</td> <td>4 HR</td> <td>Hook 10°</td> </tr> <tr> <td>911</td> <td>6 HR</td> <td>Hook 10°</td> </tr> <tr> <td>513</td> <td>8 RR</td> <td>0°</td> </tr> <tr> <td>514</td> <td>10 RR</td> <td>0°</td> </tr> <tr> <td>516</td> <td>10/14</td> <td>0°</td> </tr> </tbody> </table>	Ref.	TPI	α	511	4 HR	Hook 10°	911	6 HR	Hook 10°	513	8 RR	0°	514	10 RR	0°	516	10/14	0°
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511	4 HR		Hook 10°																	
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3.400	57,59																			
3.800	63,34																			

The reference indicates the band saw's geometry: width, thickness and tooth type.

HOW TO ORDER A BANDSAW:

Please quote the length in mm and the reference.

EXAMPLE:

1 Ut 2720 mm. Ref.911 = 1 Ut 2720 x 10 x 0,9 teeth 6HR (hook type 10°)



- For intermediate lengths that do not appear on the price list, take the price of the superior length.

15 METERS COILS

QUALITY: M42 (8% Co)		
	TEETH	€
512	6 HR Hook 10°	216,05
510	10/14 0°	216,05

30 METERS COILS

QUALITY: M42 (8% Co)		
	TEETH	€
512	6 HR Hook 10°	432,10
510	10/14 0°	432,10

15 METERS COILS

QUALITY: M42 (8% Co)		
	TEETH	€
511	4 HR Hook 10°	216,05
911	6 HR Hook 10°	216,05
513	8 RR 0°	216,05
514	10 RR 0°	216,05
516	10/14 0°	216,05

30 METERS COILS

QUALITY: M42 (8% Co)		
	TEETH	€
511	4 HR Hook 10°	432,10
911	6 HR Hook 10°	432,10
513	8 RR 0°	432,10
514	10 RR 0°	432,10
516	10/14 0°	432,10

BI-METAL BAND SAWS
13 mm x 0,65 mm (1/2" x 0,025")
QUALITY: M42 (8% Co)

LENGTH mm	€	AVAILABLE TEETH
1.135	24,56	
1.138	24,56	
1.140	24,56	
1.300	26,89	
1.315	27,09	
1.320	27,17	
1.325	27,17	
1.330	27,24	
1.335	27,43	
1.340	27,43	
1.350	27,57	
1.360	27,73	
1.368	27,86	
1.370	27,86	
1.440	29,00	
1.450	29,00	
1.470	31,19	
1.605	31,19	
1.620	31,42	
1.625	31,56	
1.630	31,56	
1.638	31,60	
1.640	31,60	
1.645	31,69	
1.650	31,75	
1.660	31,98	
1.730	32,97	
1.735	33,18	
1.750	33,18	
1.755	33,33	
2.375	42,01	
2.390	42,32	
2.410	42,90	

Ref.	TPI	α
530	4 HR	Hook 10°
531	6 HR	Hook 10°
533	14 RR	0°
534	18 RR	0°
913	6/10	0°
535	8/12	0°
536	10/14	0°

Width 13x0,50 thickness

Ref.	TPI	A
821*	10/14	0°
822*	10 RR	0°
823*	14 RR	0°
824*	18 RR	0°
825*	24 RR	0°

* Till end of stock

13 mm x 0,90 mm (1/2" x 0,035")
QUALITY: M42 (8% Co)

LENGTH mm	€	AVAILABLE TEETH
1.130	24,89	
1.140	25,03	
1.325	27,69	
1.330	27,77	
1.460	29,64	
1.635	32,16	
1.638	32,21	
1.640	32,22	
1.645	32,31	
1.650	32,37	
1.750	33,82	
2.340	42,32	
2.375	42,83	
2.665	46,99	
3.300	56,13	
3.800	63,34	
5.445	87,04	
6.200	97,92	

Ref.	TPI	α
541	3 HR	Hook 10°
542	4 HR	Hook 10°
543	6 HR	Hook 10°
544	8 RR	0°
545	10 RR	0°
546	14 RR	0°
548	6/10	0°
829	8/12	0°
547	10/14	0°

The reference indicates the band saw's geometry: width, thickness and tooth type.

HOW TO ORDER A BANDSAW:

Please quote the length in mm and the reference.

EXAMPLE:

1Ut 1650 mm. Ref.545 = 1Ut 1650 x 13 x 0,9 teeth 10RR standard type 0°

- For intermediate lengths that do not appear on the price list, take the price of the superior length.

15 METERS COILS
QUALITY: M42 (8% Co)

	TEETH	€
541	3 HR Hook 10°	216,05
542	4 HR Hook 10°	216,05
543	6 HR Hook 10°	216,05
544	8 RR 0°	216,05
545	10 RR 0°	216,05
546	14 RR 0°	216,05
547	10/14 0°	216,05

30 METERS COILS
QUALITY: M42 (8% Co)

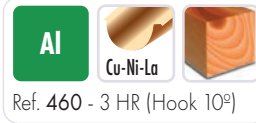
	TEETH	€
541	3 HR Hook 10°	432,10
542	4 HR Hook 10°	432,10
543	6 HR Hook 10°	432,10
544	8 RR 0°	432,10
545	10 RR 0°	432,10
546	14 RR 0°	432,10
547	10/14 0°	432,10

BI-METAL BAND SAWS

20 mm x 0,90 mm (3/4" x 0,035")

QUALITY: M42 (8% Co)

LENGTH mm	€	AVAILABLE TEETH
1.363	28,24	
1.620	31,95	
1.645	32,31	
1.765	34,02	
2.000	37,42	
2.060	38,27	
2.090	38,71	
2.100	38,85	
2.225	40,65	
2.300	41,74	
2.350	42,45	
2.362	42,63	
2.375	42,83	
2.630	46,49	
2.825	49,31	
2.850	49,66	
2.970	51,39	
3.000	51,82	
3.100	53,98	
3.350	55,75	
3.425	57,95	
3.660	61,33	
3.830	63,77	
4.525	73,79	

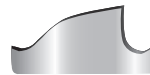


Ref. 460 - 3 HR (Hook 10°)

Ref.	TPI	α
551	3 HR	Hook 10°
552	4 HR	Hook 10°
843	10 RR	0°
908	14 RR	0°
903	4/6	5°
904	5/8	0°
910	6/8	5°
907	6/10	0°
905	8/12	0°
906	10/14	0°



Ref.	TPI	α
723	5/7	Reinforced
724	8/11	Reinforced



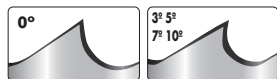
Reinforced teeth with extra setting for profile and structural steel cutting. Teeth lifetime guaranteed. Specially recommended for hand use machines, with high looseness and vibrations.



BI-METAL BAND SAWS
27 mm x 0,90 mm (1" x 0,035")
STANDARD

Most usual pattern.

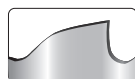
Application: General Purpose.

 For materials up to 1400 N/mm² (44 HRc)

**STRUCTURES
PROFILES/STRUCTURAL PIPES**

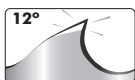
Wider and deeper set.

For all types of workpieces in high internal tension specially BEAMS.

Reinforced teeth to significantly increase its resistance.


REINFORCED
MASTER

The tooth has a cutting angle of both 10 or 16°. The master teeth is based on a high-low triple chip design recognised as one of the most efficient in engineering cutting technology. Used to cover a wide range of difficult steel and exotic alloys.

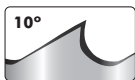


Cylindrical and squared solid workpieces

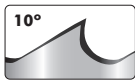
ALUMINIUM/WOOD

Special for aluminium, non-ferrous materials and wood

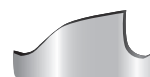
ANTI-WEAR

 High resistant steels. Chromium bars, stainless steel, (Maximum hardness 1600N/mm² 50 HRc)


Solid round, square and big structures

WOODCUT

QUALITY:
M42 (8% Co)
M42 (8% Co)

LENGTH mm	STANDARD		STRUCTURES, PROFILES STRUCTURAL PIPES																																																															
	€	AVAILABLE TEETH	€	AVAILABLE TEETH																																																														
2.000	36,83	<table border="1"> <thead> <tr> <th>Ref.</th> <th>TPI</th> <th>α</th> </tr> </thead> <tbody> <tr><td>916</td><td>2 HR</td><td>Hook 10°</td></tr> <tr><td>918</td><td>3 HR</td><td>Hook 10°</td></tr> <tr><td>914</td><td>4 HR</td><td>Hook 10°</td></tr> <tr><td>915</td><td>6 HR</td><td>Hook 10°</td></tr> <tr><td>923</td><td>8 RR</td><td>0°</td></tr> <tr><td>972</td><td>10 RR</td><td>0°</td></tr> <tr><td>973*</td><td>14 RR</td><td>0°</td></tr> <tr><td>927</td><td>2/3</td><td>10°</td></tr> <tr><td>928</td><td>3/4</td><td>10°</td></tr> <tr><td>929</td><td>4/6</td><td>7°</td></tr> <tr><td>975</td><td>5/8</td><td>3°</td></tr> <tr><td>989</td><td>6/8</td><td>5°</td></tr> <tr><td>970</td><td>6/10</td><td>0°</td></tr> <tr><td>971</td><td>8/12</td><td>0°</td></tr> <tr><td>969</td><td>10/14</td><td>0°</td></tr> </tbody> </table>	Ref.	TPI	α	916	2 HR	Hook 10°	918	3 HR	Hook 10°	914	4 HR	Hook 10°	915	6 HR	Hook 10°	923	8 RR	0°	972	10 RR	0°	973*	14 RR	0°	927	2/3	10°	928	3/4	10°	929	4/6	7°	975	5/8	3°	989	6/8	5°	970	6/10	0°	971	8/12	0°	969	10/14	0°	<table border="1"> <thead> <tr> <th>Ref.</th> <th>TPI</th> <th>α</th> </tr> </thead> <tbody> <tr><td>715</td><td>3/4</td><td>Reinforced</td></tr> <tr><td>152</td><td>4/6</td><td>Reinforced</td></tr> <tr><td>717</td><td>5/7</td><td>Reinforced</td></tr> <tr><td>719</td><td>8/11</td><td>Reinforced</td></tr> </tbody> </table>	Ref.	TPI	α	715	3/4	Reinforced	152	4/6	Reinforced	717	5/7	Reinforced	719	8/11	Reinforced
Ref.	TPI		α																																																															
916	2 HR		Hook 10°																																																															
918	3 HR		Hook 10°																																																															
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915	6 HR		Hook 10°																																																															
923	8 RR		0°																																																															
972	10 RR		0°																																																															
973*	14 RR		0°																																																															
927	2/3		10°																																																															
928	3/4		10°																																																															
929	4/6		7°																																																															
975	5/8		3°																																																															
989	6/8		5°																																																															
970	6/10		0°																																																															
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Ref.	TPI		α																																																															
715	3/4		Reinforced																																																															
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719	8/11	Reinforced																																																																
2.070	36,83	38,15	38,15																																																															
2.080	42,06	43,56	43,56																																																															
2.150	42,06	43,56	43,56																																																															
2.370	42,06	43,56	43,56																																																															
2.450	42,38	43,89	43,89																																																															
2.460	43,35	44,91	44,91																																																															
2.480	44,63	46,23	46,23																																																															
2.550	44,63	46,23	46,23																																																															
2.600	45,34	46,97	46,97																																																															
2.700	46,78	48,45	48,45																																																															
2.750	47,49	49,19	49,19																																																															
2.765	47,70	49,41	49,41																																																															
2.825	48,56	50,31	50,31																																																															
2.845	50,28	52,09	52,09																																																															
2.850	50,28	52,09	52,09																																																															
2.945	50,28	52,09	52,09																																																															
3.010	53,62	55,55	55,55																																																															
3.100	53,62	55,55	55,55																																																															
3.180	53,62	55,55	55,55																																																															
3.420	57,07	59,13	59,13																																																															
3.505	58,28	60,38	60,38																																																															
3.660	58,28	60,37	60,37																																																															
3.857	63,31	65,58	65,58																																																															
4.100	66,78	69,17	69,17																																																															
4.250	68,93	71,40	71,40																																																															
4.570	73,50	76,13	76,13																																																															
4.870	77,78	80,57	80,57																																																															
5.000	79,63	82,50	82,50																																																															



Reinforced teeth with extra setting for profile and structural steel cutting. Teeth lifetime guaranteed. Specially recommended for hand use machines, with high looseness and vibrations.

* 14RR teeth are suitable for panel Sandwich cutting.

CARBIDE TEETH BAND SAW BLADES
 €/m. welded




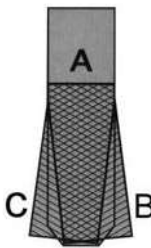
	1,4/2,0	€	2/3	€	3/4	€
27x0,90			1003	90,56	1006	111,25
34x1,10	1001	88,46	1004	99,52	1007	126,29
41x1,30	1002	91,23	1005	105,85	1008	134,44

Suitable band saw for up 700 mm sections in hard metals.




BI-METAL BAND SAWS

27 mm x 0,90 mm (1" x 0,035")

QUALITY:	 M42 (8% Co)		 M42 (8% Co)		 M51 (10% Co)																															
	MASTER		ALUMINIUM/WOOD		ANTI-WEAR																															
	LENGTH mm	€	AVAILABLE TEETH	€	AVAILABLE TEETH	€	AVAILABLE TEETH																													
2.000	44,21	<table border="1"> <thead> <tr> <th>Ref.</th> <th>TPI</th> <th>α</th> </tr> </thead> <tbody> <tr> <td>729</td> <td>2/3</td> <td>12°</td> </tr> <tr> <td>728</td> <td>3/4</td> <td>12°</td> </tr> <tr> <td>730</td> <td>4/6</td> <td>12°</td> </tr> </tbody> </table> 	Ref.	TPI	α	729	2/3	12°	728	3/4	12°	730	4/6	12°	36,83	<table border="1"> <thead> <tr> <th>Ref.</th> <th>TPI</th> <th>α</th> </tr> </thead> <tbody> <tr> <td>470</td> <td>2 HR</td> <td>Hook 10°</td> </tr> <tr> <td>471</td> <td>3 HR</td> <td>Hook 10°</td> </tr> </tbody> </table>	Ref.	TPI	α	470	2 HR	Hook 10°	471	3 HR	Hook 10°	45,49	<table border="1"> <thead> <tr> <th>Ref.</th> <th>TPI</th> <th>α</th> </tr> </thead> <tbody> <tr> <td>205</td> <td>3/4</td> <td>10°</td> </tr> <tr> <td>206</td> <td>4/6</td> <td>10°</td> </tr> </tbody> </table>	Ref.	TPI	α	205	3/4	10°	206	4/6	10°
Ref.	TPI		α																																	
729	2/3		12°																																	
728	3/4		12°																																	
730	4/6		12°																																	
Ref.	TPI		α																																	
470	2 HR		Hook 10°																																	
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Ref.	TPI		α																																	
205	3/4		10°																																	
206	4/6		10°																																	
2.070	44,21		36,83	45,49																																
2.080	50,46		42,06	51,92																																
2.150	50,46		42,06	51,92																																
2.370	50,46		42,06	51,92																																
2.450	50,85		42,38	52,32																																
2.460	52,02		43,35	53,52																																
2.480	53,55		44,63	55,09																																
2.550	53,55		44,63	55,09																																
2.600	54,41		45,34	55,97																																
2.700	56,13	46,78	57,75																																	
2.750	56,99	47,49	58,63																																	
2.765	57,24	47,70	58,89																																	
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3.010	64,36	53,62	66,21																																	
3.100	64,36	53,62	66,21																																	
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4.570	88,18	73,50	90,73																																	
4.870	93,33	77,78	96,03																																	
5.000	95,56	79,63	98,32																																	

34 mm x 0,90 mm (1-1/4" x 0,035")

QUALITY:	M2 (HSS)										
LENGTH mm	 WOOD CUT										
	€	AVAILABLE TEETH									
	3.505	65,40	<table border="1"> <thead> <tr> <th>Ref.</th> <th>TPI</th> <th>α</th> </tr> </thead> <tbody> <tr> <td>939</td> <td>1,14</td> <td>10°</td> </tr> <tr> <td>940</td> <td>2</td> <td>10°</td> </tr> </tbody> </table>	Ref.	TPI	α	939	1,14	10°	940	2
Ref.	TPI	α									
939	1,14	10°									
940	2	10°									
4.530	84,53										
4.600	85,84										
4.680	87,33										
5.150	96,10										
5.200	97,03										
5.220	97,41										
5.430	101,32										
5.620	104,87										
5.780	107,85										
6.110	114,01										
6.140	114,57										
6.170	115,13										
6.200	115,69										
6.300	117,56										
7.140	133,23										
7.200	134,35										
7.300	136,22										
7.800	145,55										

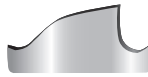
What is important for the price of a bandsaw is just the length in mm, its width and its quality.

* Instructions for stainless steel cutting:

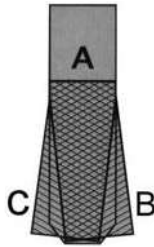
- 1- Select the appropriate blade type (Rectified 10° or Anti-wear for example)
- 2- Adapt tooth geometry according to the material section to be cut
- 3- Reduce the cutting speed to the minimum 28 to 30 meters/min

BI-METAL BAND SAWS
34 mm x 1,10 mm (1-1/4" x 0,042")

QUALITY: M42 (8% Co)
M42 (8% Co)

LENGTH mm	STANDARD		STRUCTURES																																																	
	€	AVAILABLE TEETH	€	AVAILABLE TEETH																																																
3.180	71,47	<table border="1"> <thead> <tr> <th>Ref.</th> <th>TPI</th> <th>α</th> </tr> </thead> <tbody> <tr> <td>944</td> <td>1,14 HR</td> <td>Hook 10°</td> </tr> <tr> <td>947</td> <td>1,25 HR</td> <td>Hook 10°</td> </tr> <tr> <td>949</td> <td>2 HR</td> <td>Hook 10°</td> </tr> <tr> <td>960</td> <td>2/3</td> <td>10°</td> </tr> <tr> <td>961</td> <td>3/4</td> <td>10°</td> </tr> <tr> <td>962</td> <td>4/6</td> <td>7°</td> </tr> <tr> <td>966</td> <td>5/8</td> <td>0°</td> </tr> <tr> <td>967</td> <td>6/10</td> <td>0°</td> </tr> <tr> <td>948</td> <td>8/12</td> <td>0°</td> </tr> </tbody> </table>	Ref.	TPI	α	944	1,14 HR	Hook 10°	947	1,25 HR	Hook 10°	949	2 HR	Hook 10°	960	2/3	10°	961	3/4	10°	962	4/6	7°	966	5/8	0°	967	6/10	0°	948	8/12	0°	71,47	<table border="1"> <thead> <tr> <th>Réf.</th> <th>TPI</th> <th>α</th> </tr> </thead> <tbody> <tr> <td>160</td> <td>2/3</td> <td>Reinforced</td> </tr> <tr> <td>161</td> <td>3/4</td> <td>Reinforced</td> </tr> <tr> <td>162</td> <td>4/6</td> <td>Reinforced</td> </tr> <tr> <td>727</td> <td>5/7</td> <td>Reinforced</td> </tr> <tr> <td>725</td> <td>8/11</td> <td>Reinforced</td> </tr> </tbody> </table> <p>  Reinforced teeth with extra setting for profile and structural steel cutting. Teeth lifetime guaranteed. Specially recommended for hand use machines, with high looseness and vibrations. </p>	Réf.	TPI	α	160	2/3	Reinforced	161	3/4	Reinforced	162	4/6	Reinforced	727	5/7	Reinforced	725	8/11	Reinforced
Ref.	TPI		α																																																	
944	1,14 HR		Hook 10°																																																	
947	1,25 HR		Hook 10°																																																	
949	2 HR		Hook 10°																																																	
960	2/3		10°																																																	
961	3/4		10°																																																	
962	4/6		7°																																																	
966	5/8		0°																																																	
967	6/10		0°																																																	
948	8/12		0°																																																	
Réf.	TPI		α																																																	
160	2/3		Reinforced																																																	
161	3/4		Reinforced																																																	
162	4/6		Reinforced																																																	
727	5/7		Reinforced																																																	
725	8/11		Reinforced																																																	
3.505	77,89		77,89																																																	
3.720	82,13		82,13																																																	
4.100	89,65	89,65																																																		
4.115	89,94	89,94																																																		
4.520	97,94	97,94																																																		
4.570	98,93	98,93																																																		
4.640	100,33	100,33																																																		
4.800	103,47	103,47																																																		
4.860	104,66	104,66																																																		
4.990	107,25	107,25																																																		
5.070	108,82	108,82																																																		
5.145	110,30	110,30																																																		
5.240	112,18	112,18																																																		
5.270	112,77	112,77																																																		
5.334	114,04	114,04																																																		
5.400	115,33	115,33																																																		
5.620	119,69	119,69																																																		
5.734	121,93	121,93																																																		
5.970	129,59	129,59																																																		
6.070	131,56	131,56																																																		
6.750	145,02	145,02																																																		
6.900	147,99	147,99																																																		


QUALITY: M42 (8% Co)
M51 (10% Co)

LENGTH mm	MASTER		ANTI-WEAR																						
	€	AVAILABLE TEETH	€	AVAILABLE TEETH																					
3.180	85,75	<table border="1"> <thead> <tr> <th>Ref.</th> <th>TPI</th> <th>α</th> </tr> </thead> <tbody> <tr> <td>761</td> <td>3/4</td> <td>12°</td> </tr> <tr> <td>784</td> <td>4/6</td> <td>12°</td> </tr> </tbody> </table> <p>  </p>	Ref.	TPI	α	761	3/4	12°	784	4/6	12°	88,22	<table border="1"> <thead> <tr> <th>Ref.</th> <th>TPI</th> <th>α</th> </tr> </thead> <tbody> <tr> <td>201</td> <td>2/3</td> <td>10°</td> </tr> <tr> <td>202</td> <td>3/4</td> <td>10°</td> </tr> <tr> <td>203</td> <td>4/6</td> <td>10°</td> </tr> </tbody> </table>	Ref.	TPI	α	201	2/3	10°	202	3/4	10°	203	4/6	10°
Ref.	TPI		α																						
761	3/4		12°																						
784	4/6		12°																						
Ref.	TPI		α																						
201	2/3		10°																						
202	3/4		10°																						
203	4/6		10°																						
3.505	93,45		96,15																						
3.720	98,54		101,38																						
4.100	107,58		110,68																						
4.115	107,94		111,06																						
4.520	117,53		120,92																						
4.570	118,72		122,15																						
4.640	120,38		123,85																						
4.800	124,16		127,74																						
4.860	125,58		129,20																						
4.990	128,68		132,40																						
5.070	130,58		134,35																						
5.145	132,37	136,19																							
5.240	134,62	138,50																							
5.270	135,31	139,22																							
5.334	136,85	140,79																							
5.400	138,40	142,39																							
5.620	143,62	147,76																							
5.734	146,32	150,54																							
5.970	155,52	160,00																							
6.070	157,88	162,44																							
6.750	174,01	179,03																							
6.900	177,58	182,71																							

BI-METAL BAND SAWS

41 mm x 1,30 mm (1-1/2" x 0,050")



QUALITY: M42 (8% Co)

LENGTH mm	STANDARD																			
	€	AVAILABLE TEETH																		
4.115	124,61	<table border="1"> <thead> <tr><th>Ref.</th><th>TPI</th><th>α</th></tr> </thead> <tbody> <tr><td>941</td><td>1,14HR</td><td>10°</td></tr> <tr><td>977</td><td>2/3</td><td>10°</td></tr> <tr><td>978</td><td>3/4</td><td>10°</td></tr> <tr><td>979</td><td>4/6</td><td>7°</td></tr> <tr><td>998</td><td>5/8</td><td>3°</td></tr> </tbody> </table>	Ref.	TPI	α	941	1,14HR	10°	977	2/3	10°	978	3/4	10°	979	4/6	7°	998	5/8	3°
Ref.	TPI		α																	
941	1,14HR		10°																	
977	2/3		10°																	
978	3/4		10°																	
979	4/6		7°																	
998	5/8		3°																	
4.170	126,17																			
4.570	137,45																			
4.670	140,26																			
4.870	145,92																			
5.030	150,40																			
5.040	150,70																			
5.070	151,55																			
5.145	153,66																			
5.334	159,01																			
5.400	160,85																			
5.450	162,27																			
5.734	170,26																			
5.800	172,12																			
5.920	175,55																			
6.096	178,75																			
6.200	183,41																			
6.300	186,24																			
6.480	191,31																			
6.600	194,69																			
6.700	197,50																			
6.900	203,14																			
7.100	208,79																			

54 mm x 1,30 mm (2" x 0,050")



QUALITY: M42 (8% Co)

LENGTH mm	STANDARD													
	€	AVAILABLE TEETH												
6.000	237,95	<table border="1"> <thead> <tr><th>Ref.</th><th>TPI</th><th>α</th></tr> </thead> <tbody> <tr><td>994</td><td>2/3</td><td>10°</td></tr> <tr><td>995</td><td>3/4</td><td>10°</td></tr> <tr><td>599</td><td>4/6</td><td>7°</td></tr> </tbody> </table>	Ref.	TPI	α	994	2/3	10°	995	3/4	10°	599	4/6	7°
Ref.	TPI		α											
994	2/3		10°											
995	3/4		10°											
599	4/6		7°											
7.200	283,01													
7.239	284,48													
7.400	290,53													
7.545	295,97													
7.600	298,04													
7.830	306,66													
7.940	310,81													
8.077	315,95													
8.128	317,86													
8.325	325,27													
8.800	343,12													
9.080	353,61													
9.398	365,57													

54 mm x 1,60 mm (2" x 0,063")



QUALITY: M42 (8% Co)

LENGTH mm	STANDARD																
	€	AVAILABLE TEETH															
6.000	265,74	<table border="1"> <thead> <tr><th>Ref.</th><th>TPI</th><th>α</th></tr> </thead> <tbody> <tr><td>523</td><td>1,4/2</td><td>10°</td></tr> <tr><td>996</td><td>2/3</td><td>10°</td></tr> <tr><td>997</td><td>3/4</td><td>10°</td></tr> <tr><td>525</td><td>4/6</td><td>7°</td></tr> </tbody> </table>	Ref.	TPI	α	523	1,4/2	10°	996	2/3	10°	997	3/4	10°	525	4/6	7°
Ref.	TPI		α														
523	1,4/2		10°														
996	2/3		10°														
997	3/4		10°														
525	4/6		7°														
7.200	316,21																
7.239	317,83																
7.400	324,56																
7.545	330,60																
7.600	332,91																
7.830	342,49																
7.940	347,10																
8.077	352,81																
8.128	354,93																
8.325	363,16																
8.800	383,01																
9.080	394,67																
9.398	407,95																



BI-METAL BAND SAWS
67 mm x 1,60 mm (2-5/8" x 0,063")
80 mm x 1,60 mm (3" x 0,063")

M42 (8% Co)
STANDARD

 AVAILABLE
TEETH

Ref.	TPI	α
932	1,25 HR	Hook 10°
933	2 HR	Hook 10°
934	0,75/1,25	10°
935	1,1/1,6	10°
936	1,5/2	10°
937	2/3	10°
938	3/4	10°

 PRICE x METER **55,33 €**

 PRICE x WELDING **23,27 €**

M42 (8% Co)
STANDARD

 AVAILABLE
TEETH

Ref.	TPI	α
985	0,75	Hook 10°
987	0,75/1,25	10°
988	1,1/1,6	10°
999	1,5/2	10°
993	2/3	10°

 PRICE x METER **66,97 €**

 PRICE x WELDING **37,16 €**
TO PLACE AN ORDER:

indicate the total length in mm and the reference

HOW TO CALCULATE THE GROSS PRICE OF A BAND SAW:

Total length in meters x (price x meter) + (Price x welding) = Gross price

HIGH CARBON STEEL BAND SAW COILS
30 METERS COILS

APPLICATIONS:

 Wood
 Non ferrous metals, aluminium, copper, brass
 Very soft steels

TEETH PER INCH

DIMENSIONS	TPI	3	4	6	8	10	14	18	24	€
	REFERENCE									
6 x 0,65			436	401	402	403	404	405	406	127,89*
8 x 0,65			440	408	409	410	411	412	413	130,66*
10 x 0,65	477		414	415	416	417	418	419	439	131,10*
13 x 0,65			420	421	422	423	424	425	476	140,69*
16 x 0,65			426		427					183,85*
16 x 0,80	448		449	450	481	482	451			246,33*
20 x 0,80			442	485	486	487	488	489		266,10*
25 x 0,90	496		491	437	493	452	495			275,67*

* Till end of stock

Only whole coils

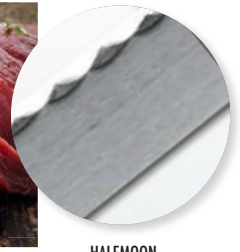
STAINLESS STEEL BAND SAWS FOR FRESH FOOD INDUSTRY



For fresh meat with bones and frozen meal cutting

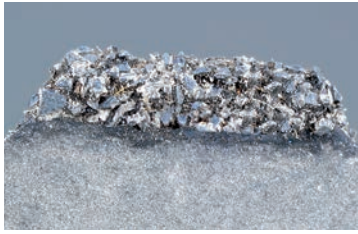


For fresh meat without bones cutting



HALFMOON

LENGTH mm	13 x 0,50		16 x 0,50		16 x 0,55		19 x 0,50		19 x 0,55	
	€		€		€		€		€	
1.500	22,17		22,17		22,17		23,77		23,77	
1.550	22,55		22,55		22,55		24,20		24,20	
1.600	22,92		22,92		22,92		24,63		24,63	
1.625	23,13		23,13		23,13		24,90		24,90	
1.650	23,35		23,35		23,35		25,11		25,11	
1.750	24,09		24,09		24,09		25,96		25,96	
1.830	24,73	Ref. TPI 600 4RR	24,73	Ref. TPI 610 3RR 611 4RR	24,73	Ref. TPI 613 3RR 614 4RR	26,65	Ref. TPI 620 3RR 621 4RR	26,65	Ref. TPI 623 3RR 624 4RR
1.985	25,91		25,91		25,91		28,04		28,04	
2.000	26,01		26,01		26,01		28,14		28,14	
2.040	26,33		26,33		26,33		28,52		28,52	
2.120	26,92		26,92		26,92		29,21		29,21	
2.200	27,56		27,56		27,56		29,91		29,91	
2.350	28,68		28,68	HALFMOON 632	28,68	HALFMOON 634	31,19		31,19	
2.450	29,48		29,48		29,48		32,09		32,09	
2.500	29,85		29,85		29,85		32,51		32,51	
2.750	31,77		31,77		31,77		34,71		34,71	
2.920	33,05		33,05		33,05		36,20		36,20	
3.150	34,86		34,86		34,86		38,22		38,22	
3.250	35,61		35,61		35,61		39,08		39,08	
3.500	37,52		37,52		37,52		41,26		41,26	
3.690	38,97		38,97		38,97		42,91		42,91	

REMGRIT GRIT-EDGE CARBIDE GRIT BAND SAW COILS


REMGRIT GRIT EDGE BAND SAW BLADES ARE THE ANSWER FOR TODAY'S TOUGH CUTTING PROBLEMS

SPECIAL FOR GRAPHITE, TITANIUM ALLOYS, ETC.


CHARACTERISTICS

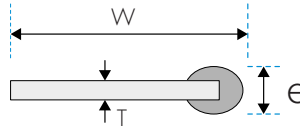
- *Tungsten carbide grit is permanently bonded to tough alloy steel.
- *Extremely long life cutting edge that does not snag or strip.
- *Exceptional life and cutting performance in tough, hard and abrasive materials.
- *The reversible blade lasts 25% longer.
- *Continuous edge band should be used on machines with carrier wheels at least 600 mm in diameter.
- *Smaller diameter wheels will give proportionally less band life due to fatigue.

EDGE TYPES

G: Gulleted
C: Continuous

GRIT SIZE

M: Medium 200-300μ
C: Coarse 425-600μ


GULLETED EDGE

	DIMENSIONS		e	Edge	Grit	€
	WxT"	WxT mm				Welding meter
308	1/4x0,020"	6x0,51	1,30	G	M	43,57 *
322	3/8x0,025"	10x0,64	1,45	G	M	43,57 *
335	1/2x0,020"	13x0,51	1,30	G	M	43,57 *
330	1/2x0,025"	13x0,64	1,45	G	M	43,57 *
341	3/4x0,032"	19x0,81	1,60	G	M	53,22
350	1"x0,035"	25x0,89	1,95	G	M	53,22
351	1"x0,035"	25x0,89	2,30	G	C	53,22
362	1 1/4"x0,035"	32x0,89	2,30	G	C	61,98 *
374	1 1/2"x0,042"	38x1,07	2,50	G	C	61,98 *

* Till end of stock

CONTINUOUS EDGE

	DIMENSIONS		e	Edge	Grit	€
	WxT"	WxT mm				Welding meter
310	1/4x0,020"	6x0,51	1,30	C	M	43,57 *
328	3/8x0,025"	10x0,64	1,45	C	M	43,57 *
337	1/2x0,020"	13x0,51	1,30	C	M	43,57 *
333	1/2x0,025"	13x0,64	1,45	C	M	43,57 *
346	3/4x0,032"	19x0,81	1,60	C	M	53,22 *
356	1x0,035"	25x0,89	1,68	C	M	53,22 *
363	1 1/4"x0,035"	32x0,89	2,50	C	C	61,98 *

* Till end of stock

CUTTING RECOMMENDATIONS

1. If a specific material is not listed, select conditions for a similar material.
2. Start cutting at low speed; increase band speed until optimum cutting performance is achieved.
3. Large cross-sectioned workpieces require lower speeds, higher feed pressure.
4. Small cross-sectioned workpieces should be cut at higher speeds with moderate pressure.
5. In metals, a fine stringy chip is evidence of proper speed and feed rates.
6. Coolant is essential for metal cutting and it is also recommended for ceramics, glass and similar materials.

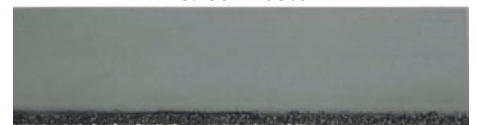
* CAUTION: Use dust collectors and respirators when cutting these and similar materials.

G: Gulleted



* Gulleted type cutting edge, for cutting operations in materials thicker than 6mm. Perfect for non ferrous materials like rubber, Fiber Glass...

C: Continuous



* Continuous type cutting edge for finishing cutting operations in materials thinner than 6mm. Perfect for very hard hardness tile, hardened metals, stainless steel, titanium and nickel alloys

REMGRIT GRIT-EDGE BAND SAW BLADE SELECTION AND APPLICATION

CUTTING CHART

GROUP	MATERIAL	SPEED m. /min.	COOLING	EDGE	TYPE OF GRAIN	
					MEDIUM	COARSE
STEELS	HARDENED STEEL	45-90	YES	C		●
	HASTELLOY™	36-106	YES	C		●
	STAINLESS STEEL	45-150	YES	C	●	●
	CAST IRON	45-106	YES	D		●
	TITANIUM	45-120	YES	C		●
BUILDING, INDUSTRY	LOW DENSITY CERAMICS	150-450	NO	C	●	
	HIGH DENSITY CERAMICS	60-360	NO	C	●	
	CARBON AND GRAPHITE	1000-1200	NO	C		●
	TILE	45-180	NO	C	●	●
	MARBLE	90-150	YES	C	●	●
	GLASS	150-300	YES	C	●	
PLASTICS, RUBBERS & COMPOSITES	METHACRYLATE	300-900	NO	C	●	
	FOAM	90-210	NO	D	●	
	FIBER GLASS /CARBON (FIBER)	1200-1800	NO	D	●	
	REINFORCED PLASTICS	300-900	NO	D	●	
	REINFORCED RUBBER (TIRES)	360-900	YES	D		●

MINIMUM RADIUS PER WIDTH

Blade width	Minimum radius (mm.)
1/4 - 6	12,70
3/8 - 10	27
1/2 - 12	44,50
3/4 - 19	102
1" - 25	140
1 1/4 - 32	240
1 1/2 - 38	318

Radius limits vary with material type, thickness, feed force and pivot point. This table is based on cutting 25 mm. metal.

● Recommended grain

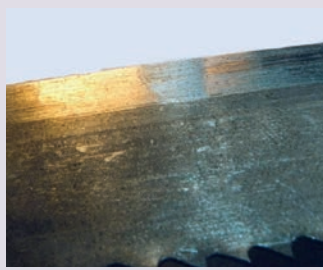

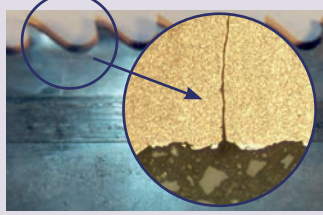
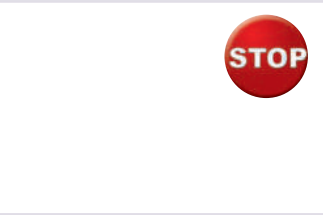
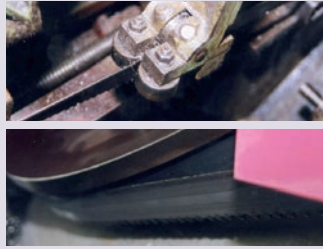


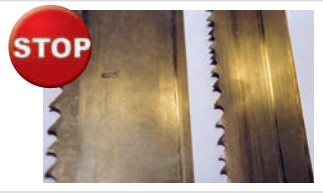
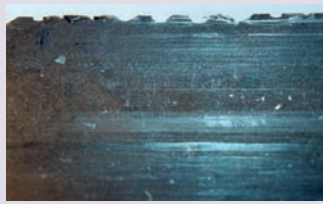



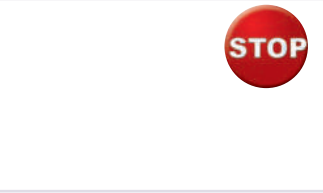


HOW TO CLEAN THE GRIT EDGE BANDSAW

* If we use the band saw to cut snaggy materials with tendency to snag the cutting edge, we must clean it with a metal brush, while the bandsaw turns slowly at the machine.

* You can use also solvent for cleaning.

TROUBLESHOOTER AND CLAIM ACCEPTANCE

	<p>CRACKS ORIGINATING FROM THE BACK EDGE</p>	<p>Causes:</p> <ul style="list-style-type: none"> • Guides are faulty (crushing the back). • The back edge of the blade is touching the rolling guides. • Blade to tightly fitted in the machine's arm guide when mounted. <p>NON-ACCEPTABLE CLAIM</p>	
	<p>CRACKS ORIGINATING FROM THE TOOTH</p>	<p>Causes:</p> <ul style="list-style-type: none"> • Tooth pitch is too short: chips get stuffed. • Tooth pitch is too large: excessive vibrations. • Feeding is too high in comparison with cutting speed. <p>NON-ACCEPTABLE CLAIM</p>	
	<p>STREAK ON THE BACK</p>	<p>Causes:</p> <ul style="list-style-type: none"> • Back rolling guide is faulty. • The back edge of the blade is touching the rolling guides. <p>NON-ACCEPTABLE CLAIM</p>	
	<p>DEEP SCRATCH ON THE SIDES OF THE BLADE</p>	<p>Causes:</p> <ul style="list-style-type: none"> • Lateral guides are faulty. • Tooth pitch is too large: excessive vibrations. • Cutting speed is not adapted to the material (too high). • The work piece isn't sufficiently fastened during the cutting operation. <p>NON-ACCEPTABLE CLAIM</p>	
	<p>BROKEN OR CRUSHED TOOTH</p>	<p>Causes:</p> <ul style="list-style-type: none"> • Tooth pitch is too short: chips get stuffed. • Tooth pitch is too large: excessive vibrations. • Cutting speed is not adapted to the material (too high). • The work piece isn't sufficiently fastened during the cutting operation. <p>NON-ACCEPTABLE CLAIM</p>	
<p>CLEAR BREACH AT WELDING POINT</p>	<p>Causes:</p> <ul style="list-style-type: none"> • Manufacturing default: faulty welding. <p>ACCEPTABLE CLAIM</p>		
	<p>BROKEN BLADE, TOOTH IN OPPOSITE DIRECTION</p>	<p>Causes:</p> <ul style="list-style-type: none"> • Lateral guides too tight. • Saw guide arms too far apart from piece. • Wheels and groups of guides are not aligned. <p>NON-ACCEPTABLE CLAIM</p>	
<p>UNSTRAIGHT CUT</p>	<p>Causes:</p> <ul style="list-style-type: none"> • Normal tooth wear. • Cutting speed and feed are not adapted to the material. • The tooth pattern is rubbing against the guide side. <p>NON-ACCEPTABLE CLAIM</p>	