

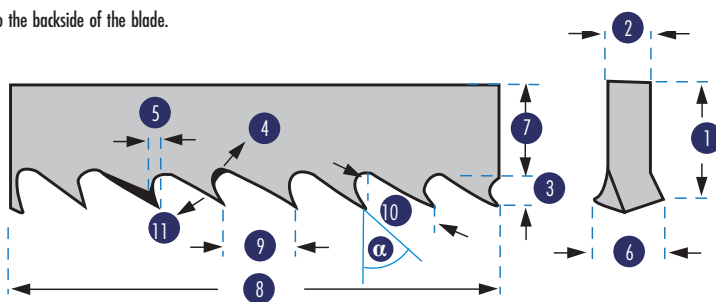
**BLUE-MASTER<sup>®</sup>**  
*by celesa*



BAND SAW  
BLADES


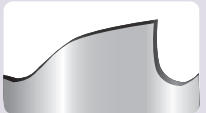


## BAND SAW BLADES TERMINOLOGY

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.

 <b>0°</b>	 <b>REINFORCED</b>	 <b>10°</b>	 <b>10°</b>
<b>USUAL TOOTH</b>	<b>REINFORCED</b>	<b>HOOK TOOTH HR</b>	<b>MASTER</b>
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 teeth with extra setting for profile and structural steel cutting. Teeth lifetime guaranteed. Specially recommended for hand use machines, with high looseness and vibrations.	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.	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 .

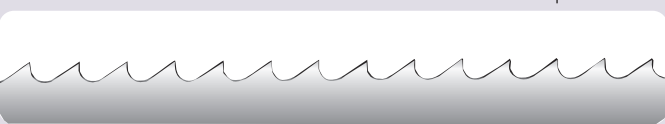

 <b>REGULAR TEETH PITCH:</b> The distance between the teeth is constant throughout the blade. Very convenient for cutting solid materials on sawing machines with efficient clamping. Very effective on high alloy steels and exotic alloys.	 <b>COMBI (VARIABLE) TEETH PITCH:</b> Combi (variable) teeth pitch 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.
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### WHEN DO I USE THE VARIABLE TEETH AND WHEN THE REGULAR?

VARIABLE (COMBI) TEETH PITCH	REGULAR TEETH PITCH
<ul style="list-style-type: none"> <li>• Steel</li> <li>• Stainless Steel</li> <li>• Bronze</li> </ul>	<ul style="list-style-type: none"> <li>• Brass</li> <li>• Aluminium</li> <li>• Copper</li> <li>• Wood</li> </ul>



### HOW TO IDENTIFY A CONCRETE TEETH ?

<b>REGULAR</b> 25,4 mm (1")  10 gullets = 10 RR	<b>VARIABLE</b> 50,8 mm (2")  10 gullets = 4/6
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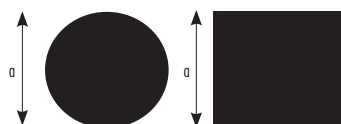
**RECOMMENDATIONS FOR CORRECT TOOTH SELECTION IN TUBES & PROFILES CUTTING**

**FOR TUBES AND STRUCTURAL PROFILES**



THICKNESS e	DIMENSION a									
	20	40	60	80	100	120	150	200	300	500
2	12/16 Reinforced	10/14 Reinforced	10/14 Reinforced	10/14 Reinforced	10/14 Reinforced	10/14 Reinforced	10/14 Reinforced	8/11	8/11	7/9
3	12/16 Reinforced	10/14 Reinforced	10/14 Reinforced	10/14 Reinforced	8/11	8/11	8/11	8/11	7/9	7/9
4	10/14 Reinforced	10/14 Reinforced	8/11	8/11	8/11	7/9	7/9	7/9	5/7	4/6 Reinforced
5	10/14 Reinforced	8/11	8/11	8/11	7/9	7/9	5/7	5/7	5/7	4/6 Reinforced
6	10/14 Reinforced	8/11	8/11	7/9	5/7	5/7	5/7	4/6 Reinforced	4/6 Reinforced	4/6 Reinforced
8	10/14 Reinforced	8/11	7/9	7/9	5/7	5/7	4/6 Reinforced	4/6 Reinforced	4/6 Reinforced	4/6 Reinforced
10		7/9	7/9	5/7	5/7	5/7	4/6 Reinforced	4/6 Reinforced	4/6 Reinforced	3/4 Reinforced
12		7/9	5/7	5/7	4/6 Reinforced	4/6 Reinforced	4/6 Reinforced	4/6 Reinforced	4/6 Reinforced	3/4 Reinforced
15		7/9	5/7	4/6 Reinforced	4/6 Reinforced	4/6 Reinforced	4/6 Reinforced	3/4 Reinforced	3/4 Reinforced	3/4 Reinforced
20			4/6 Reinforced	4/6 Reinforced	3/4 Reinforced	3/4 Reinforced	3/4 Reinforced	2/3 Reinforced	2/3 Reinforced	2/3 Reinforced
30				4/6 Reinforced	3/4 Reinforced	3/4 Reinforced	3/4 Reinforced	2/3 Reinforced	2/3 Reinforced	2/3 Reinforced
50							3/4 Reinforced	2/3 Reinforced	2/3 Reinforced	2/3 Reinforced
80								2/3 Reinforced	2/3 Reinforced	1,5/2
>100									1,5/2	1,5/2

**FOR SOLID WORKPIECES**



	SOLID		ALUM./WOOD	
	<25	10/14	<10	14
15-40	8/12		10-30	10
25-50	6/10		30-50	8
35-70	5/8		50-80	6
40-90	5/6		80-120	4
50-120	4/6		120-200	3
80-180	3/4		200-400	2
130-350	2/3		300-700	1,25
150-450	1,5/2		>700	0,75
200-600	1/1,15			
>600	075/1,25			

**BI-METAL BAND SAW BLADES**
**6 mm x 0,65 mm (1/4" x 0,025")**
**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>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	48,37										
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										

**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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501	6 HR		Hook 10°								
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3.100	53,26										
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 SAW BLADES**

**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	27,91										
1.350	28,07										
1.500	30,22										
1.580	31,37										
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	57,58										
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>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°	514	10 RR	0°	516	10/14	0°
Ref.	TPI		α														
511	4 HR		Hook 10°														
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1.300	27,33																
1.325	27,69																
1.340	27,91																
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	57,58																
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
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
514	10 RR 0°	432,10
516	10/14 0°	432,10

**BI-METAL BAND SAW BLADES**
**13 mm x 0,65 mm (1/2" x 0,025")**
**13 mm x 0,90 mm (1/2" x 0,035")**
**QUALITY: M42 (8% Co)**

LENGTH mm	€	AVAILABLE TEETH		
1.135	<b>24,56</b>			
1.138	<b>24,56</b>			
1.140	<b>24,56</b>			
1.300	<b>26,88</b>			
1.315	<b>27,09</b>	Ref.	TPI	α
1.320	<b>27,17</b>	530	4 HR	Hook 10°
1.325	<b>27,17</b>	531	6 HR	Hook 10°
1.330	<b>27,24</b>	533	14 RR	0°
1.335	<b>27,43</b>	534	18 RR	0°
1.340	<b>27,43</b>	913	6/10	0°
1.350	<b>27,57</b>	713	8/11	Reinforced
1.360	<b>27,73</b>	535	8/12	0°
1.368	<b>27,86</b>	536	10/14	0°
1.370	<b>27,86</b>			
1.440	<b>29,00</b>			
1.450	<b>29,00</b>			
1.470	<b>31,19</b>			
1.605	<b>31,19</b>			
1.620	<b>31,42</b>			
1.625	<b>31,55</b>	Ref.	TPI	A
1.630	<b>31,55</b>	821*	10/14	0°
1.638	<b>31,60</b>	822*	10 RR	0°
1.640	<b>31,60</b>	823*	14 RR	0°
1.645	<b>31,69</b>	824*	18 RR	0°
1.650	<b>31,75</b>	825*	24 RR	0°
1.660	<b>31,98</b>			
1.730	<b>32,97</b>			
1.735	<b>33,18</b>			
1.750	<b>33,18</b>			
1.755	<b>33,32</b>			
2.375	<b>42,02</b>			
2.390	<b>42,32</b>			
2.410	<b>42,90</b>			

**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

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

LENGTH mm	€	AVAILABLE TEETH		
1.130	<b>24,90</b>			
1.140	<b>25,03</b>			
1.325	<b>27,70</b>			
1.330	<b>27,77</b>			
1.460	<b>29,64</b>			
1.635	<b>32,16</b>	Ref.	TPI	α
1.638	<b>32,21</b>	541	3 HR	Hook 10°
1.640	<b>32,22</b>	542	4 HR	Hook 10°
1.645	<b>32,30</b>	543	6 HR	Hook 10°
1.650	<b>32,38</b>	546	14 RR	0°
1.750	<b>33,82</b>	548	6/10	0°
2.340	<b>42,33</b>	712	8/11	Reinforced
2.375	<b>42,83</b>	829	8/12	0°
2.665	<b>47,00</b>	547	10/14	0°
3.300	<b>56,13</b>			
3.800	<b>63,34</b>			
5.445	<b>87,04</b>			
6.200	<b>97,92</b>			

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°	<b>216,05</b>
542	4 HR Hook 10°	<b>216,05</b>
543	6 HR Hook 10°	<b>216,05</b>
546	14 RR 0°	<b>216,05</b>
547	10/14 0°	<b>216,05</b>

**30 METERS COILS**
**QUALITY: M42 (8% Co)**

	TEETH	€
541	3 HR Hook 10°	<b>432,10</b>
542	4 HR Hook 10°	<b>432,10</b>
543	6 HR Hook 10°	<b>432,10</b>
546	14 RR 0°	<b>432,10</b>
547	10/14 0°	<b>432,10</b>

**BI-METAL BAND SAW BLADES**

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






**M42 (8% Co)**

**STANDARD M42**


LENGTH mm	€	AVAILABLE TEETH
1.363	28,24	
1.620	31,95	
1.645	32,30	
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	




**Al**

Ref. 460 - 3 HR (Hook 10°)

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



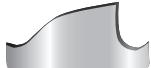




**M42 (8% Co)**


**PROFILES**

LENGTH mm	€	AVAILABLE TEETH
1.363	28,24	
1.620	31,95	
1.645	32,30	
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.	TPI	α
732	4/6	Reinforced
723	5/7	Reinforced
724	8/11	Reinforced
733	12/16	Reinforced

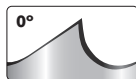
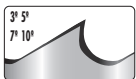


Reinforced teeth with extra setting for profile and structural steel cutting. Teeth lifetime guaranteed. Specially recommended for hand use machines, with high looseness and vibrations.



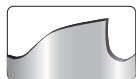
**STANDARD M42**

Multipurpose Quality Saws for all types of SOLIDS.

**PROFILES**

REINFORCED TEETH Saws for Structures, Profiles, Tubes and SOLIDS.





**BI-METAL BAND SAW BLADES**

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



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

**M51 (10% Co)**

**M42 (8% Co)**

**STANDARD M42**

**TOP PERFORMANCE M51**

**PROFILES**

LENGTH mm	€	AVAILABLE TEETH
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€	AVAILABLE TEETH
---	-----------------

€	AVAILABLE TEETH
---	-----------------

2.000	36,83
2.070	36,83
2.080	42,06
2.150	42,06
2.370	42,06
2.450	42,38
2.460	43,35
2.480	44,63
2.550	44,63
2.600	45,34
2.700	46,78
2.750	47,49
2.765	47,70
2.825	48,56
2.845	50,28
2.850	50,28
2.945	50,28
3.010	53,62
3.100	53,62
3.180	53,62
3.420	57,07
3.505	58,28
3.660	58,28
3.857	63,31
4.100	66,78
4.250	68,93
4.570	73,50
4.870	77,78
5.000	79,63

Ref.	TPI	α
916	2 HR	Hook 10°
918	3 HR	Hook 10°
914	4 HR	Hook 10°
915	6 HR	Hook 10°
973*	14 RR	0°
927	2/3	10°
928	3/4	10°
929	4/6	10°
975	5/8	10°
970	6/10	0°
971	8/12	0°
969	10/14	0°



45,49
45,49
51,92
51,92
51,92
52,31
53,52
55,09
55,09
55,97
57,75
58,63
58,89
59,94
62,07
62,07
62,07
66,21
66,21
66,21
70,46
71,96
71,96
78,15
82,44
85,09
90,73
96,03
98,32

Ref.	TPI	α
207	2/3	10°
205	3/4	10°
206	4/6	10°

**High Performance**



38,15
38,15
43,56
43,56
43,56
43,89
44,91
46,23
46,23
46,97
48,45
49,19
49,41
50,30
52,09
52,09
52,09
55,55
55,55
55,55
59,13
60,37
60,37
65,58
69,17
71,40
76,13
80,57
82,50

Ref.	TPI	α
715	3/4	Reinforced
152	4/6	Reinforced
717	5/7	Reinforced
721	7/9	Reinforced
719	8/11	Reinforced
722	10/14	Reinforced
731	12/16	Reinforced

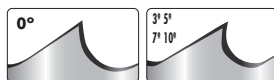
Reinforced teeth with extra setting for profile and structural steel cutting. Teeth lifetime guaranteed. Specially recommended for hand use machines, with high looseness and vibrations.



\* 14RR teeth are suitable for panel Sandwich cutting.

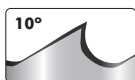
**STANDARD M42**

Multipurpose Quality Saws for all types of SOLIDS.



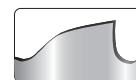
**TOP PERFORMANCE M51**

TOP Quality Saws for Alloyed and STAINLESS SOLIDS.



**PROFILES**

REINFORCED TEETH Saws for Structures, Profiles, Tubes and SOLIDS.



**REINFORCED**



**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		

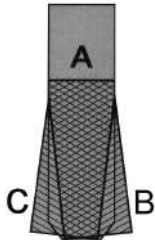
Suitable band saw for up 700 mm sections in hard metals.

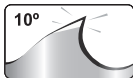
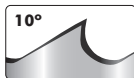
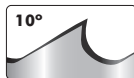


**BI-METAL BAND SAW BLADES**

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

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

QUALITY:		M42 (8% Co)		M42 (8% Co)		QUALITY:		M2 (HSS)																															
LENGTH mm	MASTER		ALUMINIUM/WOOD		LENGTH mm	WOOD CUT		€	AVAILABLE TEETH																														
	€	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>10°</td> </tr> <tr> <td>728</td> <td>3/4</td> <td>10°</td> </tr> <tr> <td>730</td> <td>4/6</td> <td>10°</td> </tr> </tbody> </table> 	Ref.	TPI	α	729	2/3	10°	728	3/4	10°	730	4/6	10°	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°	3.505	68,02	<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	10°	4.530	87,91
Ref.	TPI		α																																				
729	2/3		10°																																				
728	3/4		10°																																				
730	4/6		10°																																				
Ref.	TPI		α																																				
470	2 HR		Hook 10°																																				
471	3 HR		Hook 10°																																				
Ref.	TPI		α																																				
939	1,14		10°																																				
940	2		10°																																				
2.070	44,21		36,83	4.600	89,27																																		
2.080	50,46		42,06	4.680	90,82																																		
2.150	50,46		42,06	5.150	99,94																																		
2.370	50,46		42,06	5.200	100,91																																		
2.450	50,85		42,38	5.220	101,30																																		
2.460	52,02		43,35	5.430	105,38																																		
2.480	53,55		44,63	5.620	109,06																																		
2.550	53,55		44,63	5.780	112,17																																		
2.600	54,40		45,34	6.110	118,57																																		
2.700	56,13	46,78	6.140	119,16																																			
2.750	56,99	47,49	6.170	119,74																																			
2.765	57,24	47,70	6.200	120,32																																			
2.825	58,26	48,56	6.300	122,26																																			
2.845	60,33	50,28	7.140	138,56																																			
2.850	60,33	50,28	7.200	139,73																																			
2.945	60,33	50,28	7.300	141,67																																			
3.010	64,36	53,62	7.800	151,37																																			
3.100	64,36	53,62																																					
3.180	64,36	53,62																																					
3.420	68,48	57,07																																					
3.505	69,94	58,28																																					
3.660	69,94	58,28																																					
3.857	75,96	63,31																																					
4.100	80,13	66,78																																					
4.250	82,71	68,93																																					
4.570	88,18	73,50																																					
4.870	93,33	77,78																																					
5.000	95,56	79,63																																					

MASTER	ALUMINIUM/WOOD	WOODCUT
<p>MASTER saws have been manufactured in M42 with alternating ground teeth for faster cutting in SOLIDS.</p> 	<p>Special for Aluminium, non-ferrous materials and wood.</p> 	<p>WOODCUT saws have been manufactured in M42 with teeth suitable for repeated resharpening.</p> 

\* The only parameter that defines the price is the length of the band. Therefore, the price of each tooth within each family is the same for a specific length.

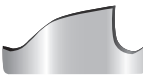
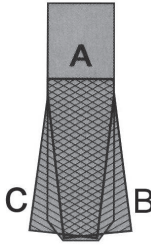
**BI-METAL BAND SAW BLADES**
**34 mm x 1,10 mm (1-1/4" x 0,042")**

**INOX**

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

LENGTH mm	STANDARD		TOP PERFORMANCE M51																																								
	€	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>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>7°</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	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	7°	967	6/10	0°	948	8/12	0°	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																																								
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		7°																																								
967	6/10		0°																																								
948	8/12		0°																																								
Ref.	TPI		α																																								
201	2/3		10°																																								
202	3/4		10°																																								
203	4/6		10°																																								
3.505	77,89		96,15																																								
3.720	82,13		101,38																																								
4.100	89,65		110,68																																								
4.115	89,94		111,06																																								
4.520	97,94		120,92																																								
4.570	98,93	122,15																																									
4.640	100,33	123,85																																									
4.800	103,47	127,74																																									
4.860	104,66	129,20																																									
4.990	107,25	132,40																																									
5.070	108,82	134,35																																									
5.145	110,30	136,19																																									
5.240	112,18	138,50																																									
5.270	112,77	139,22																																									
5.334	114,04	140,79																																									
5.400	115,33	142,39																																									
5.620	119,69	147,76																																									
5.734	121,93	150,54																																									
5.970	129,59	160,00																																									
6.070	131,59	162,44																																									
6.750	145,02	179,03																																									
6.900	147,98	182,71																																									


**M42 (8% Co)**
**M42 (8% Co)**

LENGTH mm	STRUCTURES		MASTER																												
	€	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>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> 	Ref.	TPI	α	160	2/3	Reinforced	161	3/4	Reinforced	162	4/6	Reinforced	727	5/7	Reinforced	725	8/11	Reinforced	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>10°</td> </tr> <tr> <td>784</td> <td>4/6</td> <td>10°</td> </tr> </tbody> </table> 	Ref.	TPI	α	761	3/4	10°	784	4/6	10°
Ref.	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																												
761	3/4		10°																												
784	4/6		10°																												
3.505	77,89		93,45																												
3.720	82,13		98,54																												
4.100	89,65		107,58																												
4.115	89,94		107,94																												
4.520	97,94		117,53																												
4.570	98,93		118,72																												
4.640	100,33		120,38																												
4.800	103,47		124,16																												
4.860	104,66		125,58																												
4.990	107,25	128,68																													
5.070	108,82	130,58																													
5.145	110,30	132,37																													
5.240	112,18	134,62																													
5.270	112,77	135,31																													
5.334	114,04	136,85																													
5.400	115,33	138,40																													
5.620	119,69	143,62																													
5.734	121,93	146,32																													
5.970	129,59	155,52																													
6.070	131,59	157,88																													
6.750	145,02	174,01																													
6.900	147,98	177,58																													

**BI-METAL BAND SAW BLADES**

**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>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> <tr><td>163</td><td>5/7</td><td>3°</td></tr> </tbody> </table>	Ref.	TPI	α	977	2/3	10°	978	3/4	10°	979	4/6	7°	998	5/8	3°	163	5/7	3°
Ref.	TPI		α																	
977	2/3		10°																	
978	3/4		10°																	
979	4/6		7°																	
998	5/8		3°																	
163	5/7		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 SAW BLADES**
**67 mm x 1,60 mm (2-5/8" 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 €**
**80 mm x 1,60 mm (3" x 0,063")**

**M42 (8% Co)**
**STANDARD**
**AVAILABLE  
TEETH**

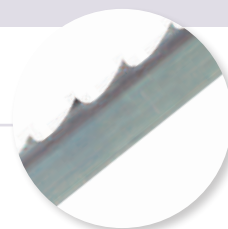
Ref.	TPI	α
985	0,75	Hook 10°
987	0,75/1,25	10°
988	1,1/1,6	10°
999	1,5/2	10°
993	2/3	10°

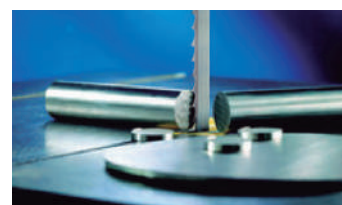
**PRICE x METER 66,97 €**
**PRICE x WELDING 37,16 €**
**TO PLACE AN ORDER:**

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:**

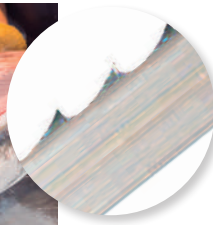
 Wood  
 Non ferrous metals, aluminium, copper, brass  
 Very soft steels

**TEETH PER INCH**

DIMENSIONS	TPI	3	4	6	8	10	14	18	24	€
	REFERENCE									
6 x 0,65				401	402	403		405		127,89*
8 x 0,65			440	408	409		411	412	413	130,66*
10 x 0,65	477			415	416	417		419	439	131,10*
13 x 0,65			420		422	423		425	476	140,69*
16 x 0,80	448	449	450			482	451			246,33*
20 x 0,80		442	485	486	487	488	489			266,10*
25 x 0,90			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

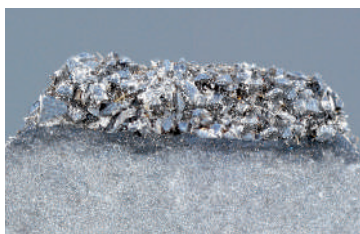
HALFMOON

Band saws

Yellow

LENGTH mm	13 x 0,50		16 x 0,50		19 x 0,50	
	€		€		€	
1.500	22,17		22,17		23,77	
1.550	22,55		22,55		24,20	
1.600	22,92		22,92		24,62	
1.625	23,13		23,13		24,90	
1.650	23,35		23,35		25,11	
1.750	24,09		24,09		25,96	
1.830	24,73	Ref. TPI 600 4RR	24,73	Ref. TPI 610 3RR 611 4RR	26,65	Ref. TPI 620 3RR 621 4RR
1.985	25,91		25,91		28,04	
2.000	26,01		26,01		28,14	
2.040	26,33		26,33		28,52	
2.120	26,92		26,92		29,21	
2.200	27,56		27,56		29,91	
2.350	28,68		28,68	HALFMOON 632	31,19	
2.450	29,48		29,48		32,09	
2.500	29,85		29,85		32,51	
2.750	31,76		31,76		34,71	
2.920	33,05		33,05		36,20	
3.150	34,86		34,86		38,22	
3.250	35,60		35,60		39,08	
3.500	37,52		37,52		41,25	
3.690	38,97		38,97		42,91	

## REMGRIT GRIT-EDGE CARBIDE BAND SAW BLADE COILS



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

SPECIAL FOR GRAPHITE, TITANIUM ALLOYS, ETC.



## CHARACTERISTICS

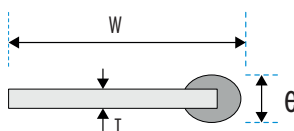
- \*Tungsten carbide grit is permanently bonded to tough alloy steel.
- \*Extremely long life cutting edge that does not snag or strip.
- \*Exceptional life and cutting performance in tough, hard and abrasive materials.
- \*The reversible blade lasts 25% longer.
- \*Continuous edge band should be used 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 200-300 $\mu$
- C: Coarse 425-600 $\mu$



## GULLETED EDGE

	DIMENSIONS		e	Edge	Grit	€ Welding meter
	WxT"	WxT mm				
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
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
374	1 1/2"x0,042"	38x1,07	2,50	G	C	61,98 *

\* Till end of stock

G: Gulleted



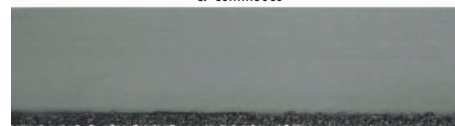
\* Gulleted type cutting edge, for cutting operations in materials thicker than 6mm. Perfect for non ferrous materials like rubber, Fiber Glass...

## CONTINUOUS EDGE

	DIMENSIONS		e	Edge	Grit	€ Welding meter
	WxT"	WxT mm				
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 1/4x0,035"	32x0,89	2,50	C	C	61,98 *

\* Till end of stock

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

## 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.

## 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 & COM- POSITES	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

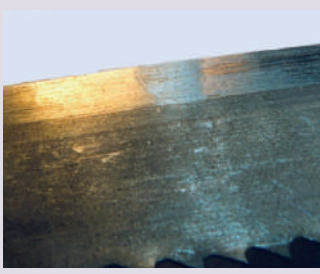



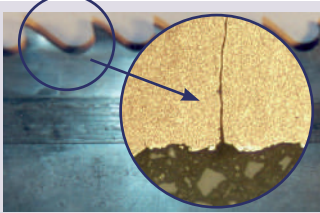

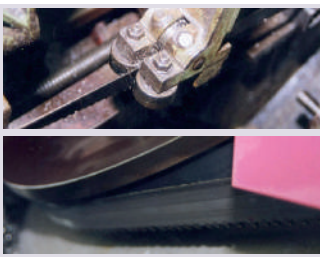

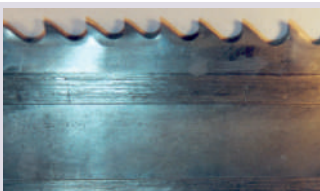

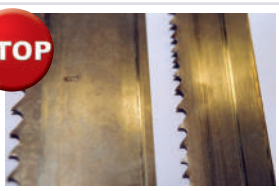
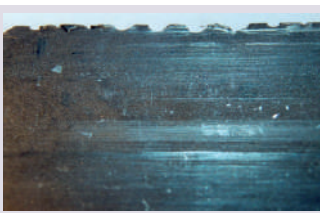






### HOW TO CLEAN THE GRIT EDGE BANDSAW

\* 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><b>CRACKS ORIGINATING FROM THE BACK EDGE</b></p>	<p>Causes:</p> <ul style="list-style-type: none"> <li>• Guides are faulty (crushing the back).</li> <li>• The back edge of the blade is touching the rolling guides.</li> <li>• Blade too tightly fitted in the machine's arm guide when mounted.</li> </ul> <p><b>NON-ACCEPTABLE CLAIM</b></p>	  
	<p><b>CRACKS ORIGINATING FROM THE TOOTH</b></p>	<p>Causes:</p> <ul style="list-style-type: none"> <li>• Tooth pitch is too short: chips get stuffed.</li> <li>• Tooth pitch is too large: excessive vibrations.</li> <li>• Feeding is too high in comparison with cutting speed.</li> </ul> <p><b>NON-ACCEPTABLE CLAIM</b></p>	
	<p><b>STREAK ON THE BACK</b></p>	<p>Causes:</p> <ul style="list-style-type: none"> <li>• Back rolling guide is faulty.</li> <li>• The back edge of the blade is touching the rolling guides.</li> </ul> <p><b>NON-ACCEPTABLE CLAIM</b></p>	
	<p><b>DEEP SCRATCH ON THE SIDES OF THE BLADE</b></p>	<p>Causes:</p> <ul style="list-style-type: none"> <li>• Lateral guides are faulty.</li> <li>• Tooth pitch is too large: excessive vibrations.</li> <li>• Cutting speed is not adapted to the material (too high).</li> <li>• The work piece isn't sufficiently fastened during the cutting operation.</li> </ul> <p><b>NON-ACCEPTABLE CLAIM</b></p>	 
	<p><b>BROKEN OR CRUSHED TOOTH</b></p>	<p>Causes:</p> <ul style="list-style-type: none"> <li>• Tooth pitch is too short: chips get stuffed.</li> <li>• Tooth pitch is too large: excessive vibrations.</li> <li>• Cutting speed is not adapted to the material (too high).</li> <li>• The work piece isn't sufficiently fastened during the cutting operation.</li> </ul> <p><b>NON-ACCEPTABLE CLAIM</b></p>	
<p><b>CLEAR BREACH AT WELDING POINT</b></p>	<p>Causes:</p> <ul style="list-style-type: none"> <li>• Manufacturing default: faulty welding.</li> </ul> <p><b>ACCEPTABLE CLAIM</b></p>		
	<p><b>BROKEN BLADE, TOOTH IN OPPOSITE DIRECTION</b></p>	<p>Causes:</p> <ul style="list-style-type: none"> <li>• Lateral guides too tight.</li> <li>• Saw guide arms too far apart from piece.</li> <li>• Wheels and groups of guides are not aligned.</li> </ul> <p><b>NON-ACCEPTABLE CLAIM</b></p>	
<p><b>NO STRAIGHT CUT</b></p>	<p>Causes:</p> <ul style="list-style-type: none"> <li>• Normal tooth wear.</li> <li>• Cutting speed and feed are not adapted to the material.</li> <li>• The tooth pattern is rubbing against the guide side.</li> </ul> <p><b>NON-ACCEPTABLE CLAIM</b></p>	