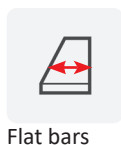
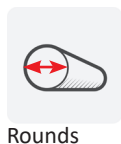
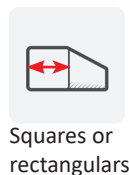


BIMETAL BANDSAW BLADES

CHOOSE THE TEETH PER INCH

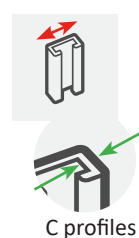
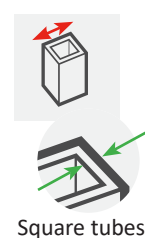
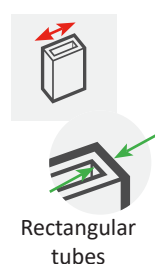
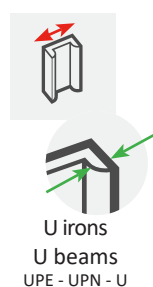
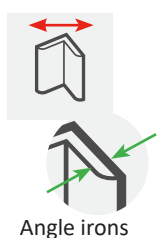
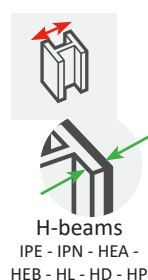
Variable toothing (e.g. 6/10TPI) reduces vibrations and extends a blade's range of use. To choose your blade's teeth, you need to know the size and shape of the pieces you will cut.

Full materials



Section	Constant teeth (non-ferrous / ALU)	Section	Variable teeth
Below 10 mm	14 TPI	Inf. à 10 mm	10/14 TPI
10 to 30 mm	10 TPI	10 à 15 mm	8/12 TPI
30 to 50 mm	8 TPI	15 à 20 mm	6/10 TPI
50 to 80 mm	6 TPI	20 à 40 mm	5/8 TPI - 5/7 TPI
80 to 120 mm	4 TPI	40 à 90 mm	4/6 TPI
120 to 200 mm	3 TPI	50 à 120 mm	3/4 TPI
200 to 400 mm	2 TPI	80 à 200 mm	2/3 TPI
300 to 700 mm	1.25 TPI	200 à 400 mm	1.5/2.0 TPI
Over 600 mm	0.8 TPI	350 à 700 mm	1.1/1.6 TPI
		Sup. à 600 mm	0.8/1.25 TPI

Beams - Tubes - Profiles



	External diameter - base - width									
thickness	20 mm	40 mm	60 mm	80 mm	100 mm	120 mm	150 mm	200 mm	300 mm	500 mm
2 mm	14 TPI	10/14 TPI	10/14 TPI	10/14 TPI	10/14 TPI	8/12 TPI ⁽¹⁾	8/12 TPI ⁽¹⁾	8/12 TPI ⁽¹⁾	8/12 TPI ⁽¹⁾	6/10 TPI
3 mm	14 TPI	10/14 TPI	10/14 TPI	8/12 TPI ⁽¹⁾	8/12 TPI ⁽¹⁾	8/12 TPI ⁽¹⁾	6/10 TPI	6/10 TPI	6/10 TPI	5/8 TPI ⁽²⁾
4 mm	10/14 TPI	10/14 TPI	8/12 TPI ⁽¹⁾	8/12 TPI ⁽¹⁾	8/12 TPI ⁽¹⁾	6/10 TPI	6/10 TPI	5/8 TPI ⁽²⁾	5/8 TPI ⁽²⁾	4/6 TPI
5 mm	10/14 TPI	10/14 TPI	8/12 TPI ⁽¹⁾	6/10 TPI	6/10 TPI	6/10 TPI	5/8 TPI ⁽²⁾	4/6 TPI	4/6 TPI	4/6 TPI
6 mm	10/14 TPI	8/12 TPI ⁽¹⁾	8/12 TPI ⁽¹⁾	6/10 TPI	6/10 TPI	5/8 TPI ⁽²⁾	5/8 TPI ⁽²⁾	4/6 TPI	4/6 TPI	4/6 TPI
8 mm	10/14 TPI	8/12 TPI ⁽¹⁾	6/10 TPI	6/10 TPI	5/8 TPI ⁽²⁾	5/8 TPI ⁽²⁾	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI
10 mm		8/12 TPI ⁽¹⁾	6/10 TPI	5/8 TPI ⁽²⁾	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI
12 mm		8/12 TPI ⁽¹⁾	6/10 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI
15 mm		8/12 TPI ⁽¹⁾	5/8 TPI ⁽²⁾	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	3/4 TPI	3/4 TPI
20 mm			4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	3/4 TPI	3/4 TPI
30 mm				4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	2/3 TPI	2/3 TPI
50 mm							3/4 TPI	3/4 TPI	2/3 TPI	2/3 TPI
80 mm			(1) : 8/12 TPI or 8/11 TPI for PROFIL-K					3/4 TPI	2/3 TPI	2/3 TPI
Over 100 mm			(2) : 5/8 TPI or 5/7 TPI for PROFIL-K						2/3 TPI	1.5/2 TPI

For bundle cuts:

Determine the appropriate toothing for a single piece. For bundle cuts, select the next larger toothing.
E.g: 6/10 for a single piece, 5/8 for a bundle.



BIMETAL BANDSAW BLADES

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See you soon!

Materials	Structural, decoiling and drawing steels					Structural steels, improvement steels			
	1.0037 : St37-2 : S235JR	1.0044 : St44-2 : S275JR	1.0301 : C10	1.0721 : 10S20		1.1181 : C35 : XC38	1.1191 : C45 : XC48	1.0402 : C22 : CC20	1.0501 : C35 : CC35
Blades	STD-K / BSK / PROD-K / PROFIL-K					STD-K / BSK / PROD-K / PROFIL-K			
Fluid	SOLUKUT 10% to 15%					SOLUKUT 5% to 10%			
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)
10 mm	6,4 mm	70	125 - 190	10 - 15	00:00:03 - 00:00:05	75	150 - 230	12 - 18	00:00:03 - 00:00:04
25 mm	6,4 mm	70	110 - 200	22 - 39	00:00:08 - 00:00:14	75	100 - 150	20 - 29	00:00:10 - 00:00:15
40 mm	9,5 mm	70	83 - 160	26 - 50	00:00:15 - 00:00:29	75	80 - 120	25 - 38	00:00:20 - 00:00:30
65 mm	9,5 mm	70	78 - 121	40 - 62	00:00:32 - 00:00:50	75	58 - 88	30 - 45	00:00:44 - 00:01:07
100 mm	12,7 mm	85	63 - 95	49 - 75	00:01:03 - 00:01:35	70	51 - 70	40 - 55	00:01:26 - 00:01:58
150 mm	19,0 mm	85	60 - 85	71 - 100	00:01:46 - 00:02:30	68	42 - 64	49 - 75	00:02:21 - 00:03:34
200 mm	27,0 mm	85	48 - 62	75 - 97	00:03:14 - 00:04:10	66	31 - 51	49 - 80	00:03:55 - 00:06:27
300 mm	34,0 mm	85	32 - 46	75 - 108	00:06:31 - 00:09:22	65	23 - 34	54 - 80	00:08:49 - 00:13:03
400 mm	41,0 mm	60	17 - 25	53 - 79	00:16:00 - 00:23:32	50	12 - 18	38 - 57	00:22:13 - 00:33:20
500 mm	41,0 mm	60	10 - 15	39 - 59	00:33:20 - 00:50:00	49	8 - 11	31 - 43	00:45:27 - 01:02:30
600 mm	54,0 mm	60	6 - 10	28 - 47	01:00:00 - 01:40:00	48	5 - 7,5	24 - 35	01:20:00 - 02:00:00
800 mm	67,0 mm	60	4,5 - 6	28 - 38	02:13:20 - 02:57:47	48	3 - 5	19 - 31	02:40:00 - 04:26:40
1000 mm	80,0 mm	45	2,5 - 4	20 - 31	04:10:00 - 06:40:00	45	2 - 3	16 - 24	05:33:20 - 08:20:00
1200 mm	80,0 mm	45	1,6 - 2,5	15 - 24	08:00:00 - 12:30:00	43	1,2 - 2	11 - 19	10:00:00 - 16:40:00
1500 mm	80,0 mm	45	1 - 1,6	12 - 19	15:37:30 - 25:00:00	41	0,8 - 1,2	9 - 14	20:50:00 - 31:15:00
2000 mm	80,0 mm	45	0,7 - 1,2	11 - 19	27:46:40 - 47:37:09	38	0,6 - 0,9	9 - 14	37:02:13 - 55:33:20



PROFIL-K and PROD-K blades are also available with a AlTiN coating.

Benefits : 30% higher productivity, optimized surface finish, longer durability (= less machine downtime / less blade stock, less waste).

Materials	Case-hardening steels, low-alloyed for heat treatment, spring					Bearing steels			
	1.7131 : 16MnCr5	1.8159 : 50CrV4	1.7225 : 42CrMo4			1.3505 : 100Cr6	1.1663 : C125W		
Blades	STD-K / BSK / PROD-K / PROFIL-K					BSK / PROD-K / XTREM-K			
Fluid	SOLUKUT 5% to 10%					SOLUKUT 3%			
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)
10 mm	6,4 mm	65	125 - 200	10 - 16	00:00:03 - 00:00:05	60	125 - 200	10 - 16	00:00:03 - 00:00:05
25 mm	6,4 mm	65	75 - 130	15 - 26	00:00:12 - 00:00:20	59	75 - 120	15 - 24	00:00:13 - 00:00:20
40 mm	9,5 mm	65	60 - 100	19 - 31	00:00:24 - 00:00:40	58	60 - 95	19 - 30	00:00:25 - 00:00:40
65 mm	9,5 mm	65	49 - 74	25 - 38	00:00:53 - 00:01:20	58	49 - 70	25 - 36	00:00:56 - 00:01:20
100 mm	12,7 mm	60	38 - 61	30 - 48	00:01:38 - 00:02:38	55	38 - 57	30 - 45	00:01:45 - 00:02:38
150 mm	19,0 mm	59	34 - 51	40 - 60	00:02:56 - 00:04:25	53	30 - 47	35 - 55	00:03:11 - 00:05:00
200 mm	27,0 mm	57	28 - 41	44 - 64	00:04:53 - 00:07:09	52	25 - 38	39 - 60	00:05:16 - 00:08:00
300 mm	34,0 mm	55	19 - 27	45 - 64	00:11:07 - 00:15:47	50	17 - 25	40 - 59	00:12:00 - 00:17:39
400 mm	41,0 mm	50	10 - 15	31 - 47	00:26:40 - 00:40:00	45	9 - 13	28 - 41	00:30:46 - 00:44:27
500 mm	41,0 mm	47	6 - 9	24 - 35	00:55:33 - 01:23:20	42	6 - 9	24 - 35	00:55:33 - 01:23:20
600 mm	54,0 mm	44	4 - 6	19 - 28	01:40:00 - 02:30:00	38	4 - 6	19 - 28	01:40:00 - 02:30:00
800 mm	67,0 mm	40	2,5 - 4	16 - 25	03:20:00 - 05:20:00	35	2,5 - 4	16 - 25	03:20:00 - 05:20:00
1000 mm	80,0 mm	37	1,5 - 2,5	12 - 20	06:40:00 - 11:06:40	33	1,5 - 2,5	12 - 20	06:40:00 - 11:06:40
1200 mm	80,0 mm	35	1,1 - 1,6	10 - 15	12:30:00 - 18:10:55	31	1 - 1,6	9 - 15	12:30:00 - 20:00:00
1500 mm	80,0 mm	34	0,6 - 1	7 - 12	25:00:00 - 41:40:00	29	0,6 - 1	7 - 12	25:00:00 - 41:40:00
2000 mm	80,0 mm	33	0,5 - 0,8	8 - 13	41:40:00 - 66:40:00	28	0,5 - 0,8	8 - 13	41:40:00 - 66:40:00



BIMETAL BANDSAW BLADES

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High-speed steels

Alloyed tool steels

Materials

1.3343 : Z85WDCV 06-05-04-02
1.3348 : Z100WCWV 09-04-02-02

1.2080 : X210Cr12
1.2379 : X155CrVMo12 1

Blades		BSK / PROD-K / XTREM-K				BSK / PROD-K / XTREM-K / REFRA-K / TITAN-K			
Fluid		NANOKUT 3% to 10%				NANOKUT 5% to 8%			
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)
10 mm	6,4 mm	50	90 - 140	7 - 11	00:00:04 - 00:00:07	35	64 - 89	5 - 7	00:00:07 - 00:00:09
25 mm	6,4 mm	49	60 - 90	12 - 18	00:00:17 - 00:00:25	34	40 - 61	8 - 12	00:00:25 - 00:00:38
40 mm	9,5 mm	48	48 - 70	15 - 22	00:00:34 - 00:00:50	33	32 - 48	10 - 15	00:00:50 - 00:01:15
65 mm	9,5 mm	47	33 - 53	17 - 27	00:01:14 - 00:01:58	32	22 - 35	11 - 18	00:01:51 - 00:02:57
100 mm	12,7 mm	45	25 - 42	20 - 33	00:02:23 - 00:04:00	30	16 - 28	13 - 22	00:03:34 - 00:06:15
150 mm	19,0 mm	43	21 - 34	25 - 40	00:04:25 - 00:07:09	28	15 - 23	18 - 27	00:06:31 - 00:10:00
200 mm	27,0 mm	42	19 - 29	30 - 46	00:06:54 - 00:10:32	26	11 - 18	17 - 28	00:11:07 - 00:18:11
300 mm	34,0 mm	40	12 - 19	28 - 45	00:15:47 - 00:25:00	25	8 - 11	19 - 26	00:27:16 - 00:37:30
400 mm	41,0 mm	36	8 - 12	25 - 38	00:33:20 - 00:50:00	24	5,5 - 9	17 - 28	00:44:27 - 01:12:44
500 mm	41,0 mm	34	5 - 8	20 - 31	01:02:30 - 01:40:00	23	3,5 - 6	14 - 24	01:23:20 - 02:22:51
600 mm	54,0 mm	31	4 - 5,7	19 - 27	01:45:16 - 02:30:00	21	2,5 - 4	12 - 19	02:30:00 - 04:00:00
800 mm	67,0 mm	29	2,4 - 3,5	15 - 22	03:48:34 - 05:33:20	20	2 - 2,5	13 - 16	05:20:00 - 06:40:00
1000 mm	80,0 mm	27	1,5 - 2,3	12 - 18	07:14:47 - 11:06:40	18	1 - 1,5	8 - 12	11:06:40 - 16:40:00
1200 mm	80,0 mm	25	1 - 1,6	9 - 15	12:30:00 - 20:00:00	17	0,7 - 1,1	7 - 10	18:10:55 - 28:34:17
1500 mm	80,0 mm	23	0,6 - 0,9	7 - 11	27:46:40 - 41:40:00	16	0,4 - 0,6	5 - 7	41:40:00 - 62:30:00
2000 mm	80,0 mm	22	0,4 - 0,7	6 - 11	47:37:09 - 83:20:00	15	0,3 - 0,5	5 - 8	66:40:00 - 111:06:40



PROD-K and PROD-K blades are also available with a AlTiN coating.

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Upgrading and nitriding steels

Stainless steels

Materials

1.2311 : 40CMD7
1.2344 : X40CrMoV51
1.2738 : 40CrMnNiMo8-6-4
1.2713 : 55NiCrMoV6

1.6582 : 34CrNiMo6

1.4308 : G-X6CrNi18 9
1.4306 : X2CrNi19 11 : 304L
1.4435 : X2CrNiMo18 12 : 316L

Blades		BSK / PROD-K / XTREM-K / REFRA-K / TITAN-K				STD-K / BSK / PROD-K / XTREM-K / REFRA-K / TITAN-K			
Fluid		NANOKUT 5% to 8%				NANOKUT 10% to 15%			
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)
10 mm	6,4 mm	65	125 - 200	10 - 16	00:00:03 - 00:00:05	40	75 - 100	6 - 8	00:00:06 - 00:00:08
25 mm	6,4 mm	65	75 - 130	15 - 26	00:00:12 - 00:00:20	39	40 - 50	8 - 10	00:00:30 - 00:00:38
40 mm	9,5 mm	65	60 - 100	19 - 31	00:00:24 - 00:00:40	38	32 - 38	10 - 12	00:01:03 - 00:01:15
65 mm	9,5 mm	65	49 - 74	25 - 38	00:00:53 - 00:01:20	37	20 - 27	10 - 14	00:02:24 - 00:03:15
100 mm	12,7 mm	60	38 - 61	30 - 48	00:01:38 - 00:02:38	35	15 - 19	12 - 15	00:05:16 - 00:06:40
150 mm	19,0 mm	59	34 - 51	40 - 60	00:02:56 - 00:04:25	34	10 - 17	12 - 20	00:08:49 - 00:15:00
200 mm	27,0 mm	57	28 - 41	44 - 64	00:04:53 - 00:07:09	33	9 - 16	14 - 25	00:12:30 - 00:22:13
300 mm	34,0 mm	55	19 - 27	45 - 64	00:11:07 - 00:15:47	32	6 - 10	14 - 24	00:30:00 - 00:50:00
400 mm	41,0 mm	50	10 - 15	31 - 47	00:26:40 - 00:40:00	28	3 - 5	9 - 16	01:20:00 - 02:13:20
500 mm	41,0 mm	47	6 - 9	24 - 35	00:55:33 - 01:23:20	26	2 - 3	8 - 12	02:46:40 - 04:10:00
600 mm	54,0 mm	44	4 - 6	19 - 28	01:40:00 - 02:30:00	24	1,5 - 2,5	7 - 12	04:00:00 - 06:40:00
800 mm	67,0 mm	40	2,5 - 4	16 - 25	03:20:00 - 05:20:00	22	1,3 - 1,5	8 - 9	08:53:20 - 10:15:23
1000 mm	80,0 mm	37	1,5 - 2,5	12 - 20	06:40:00 - 11:06:40	21	0,8 - 1	6 - 8	16:40:00 - 20:50:00
1200 mm	80,0 mm	35	1,1 - 1,6	10 - 15	12:30:00 - 18:10:55	21	0,5 - 0,7	5 - 7	28:34:17 - 40:00:00
1500 mm	80,0 mm	34	0,6 - 1	7 - 12	25:00:00 - 41:40:00	20	0,35 - 0,6	4 - 7	41:40:00 - 71:25:43
2000 mm	80,0 mm	33	0,5 - 0,8	8 - 13	41:40:00 - 66:40:00				



BIMETAL BANDSAW BLADES

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	Refractory steels	Nickel-based alloy
Materials	1.4845 : X12CrNi25 21 1.4828 : X15CrNiSi20 12 1.4864 : X12NiCrSi36 16	2.4668 : NiCr19Fe19NbMo : Inconel 718 2.4632 : NiCr20Co18Ti : Nimonic 90 2.4665 : NiCr22Fe18Mo : Hastelloy X

Blades	XTREM-K / REFRA-K / TITAN-K					XTREM-K / REFRA-K / TITAN-K				
Fluid	NANOKUT 15%					NANOKUT 15% to 20%				
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)	
10 mm	6,4 mm	30	40 - 60	3 - 5	00:00:10 - 00:00:15	18	25 - 38	2 - 3	00:00:16 - 00:00:24	
25 mm	6,4 mm	29	25 - 35	5 - 7	00:00:43 - 00:01:00	17	15 - 20	3 - 4	00:01:15 - 00:01:40	
40 mm	9,5 mm	28	19 - 25	6 - 8	00:01:36 - 00:02:06	16	10 - 16	3 - 5	00:02:30 - 00:04:00	
65 mm	9,5 mm	27	11 - 15	6 - 8	00:04:20 - 00:05:55	15	6 - 10	3 - 5	00:06:30 - 00:10:50	
100 mm	12,7 mm	25	7 - 11	5 - 9	00:09:05 - 00:14:17	15	5 - 6,35	4 - 5	00:15:45 - 00:20:00	
150 mm	19,0 mm	24	6 - 8	7 - 9	00:18:45 - 00:25:00	15	3 - 5	4 - 6	00:30:00 - 00:50:00	
200 mm	27,0 mm	23	5 - 7	8 - 11	00:28:34 - 00:40:00	14	3 - 5	5 - 8	00:40:00 - 01:06:40	
300 mm	34,0 mm	22	3 - 4	7 - 9	01:15:00 - 01:40:00	14	2 - 3,4	5 - 8	01:28:14 - 02:30:00	
400 mm	41,0 mm	20	1,5 - 2	5 - 6	03:20:00 - 04:26:40	12	1,3 - 1,9	4 - 6	03:30:32 - 05:07:42	
500 mm	41,0 mm	18	1 - 2	4 - 8	04:10:00 - 08:20:00	11	1 - 1,3	4 - 5	06:24:37 - 08:20:00	
600 mm	54,0 mm	17	1 - 1,5	5 - 7	06:40:00 - 10:00:00	10	0,6 - 0,8	3 - 4	12:30:00 - 16:40:00	
800 mm	67,0 mm	16	0,5 - 0,7	3 - 4	19:02:51 - 26:40:00	10	0,3 - 0,6	2 - 4	22:13:20 - 44:26:40	
1000 mm	80,0 mm	15	0,3 - 0,5	2 - 4	33:20:00 - 55:33:20	10	0,3 - 0,4	2 - 3	41:40:00 - 55:33:20	
1200 mm	80,0 mm									
1500 mm	80,0 mm									
2000 mm	80,0 mm									



PROFIL-K and PROD-K blades are also available with a AlTiN coating.

Benefits : 30% higher productivity, optimized surface finish, longer durability (= less machine downtime / less blade stock, less waste).

	Fonts	Titanium and Alloys, Aluminum Bronze
Materials	0.6025 : GG25 EN-JL : 1040 0.6030 : GG30 EN-JL : 1050 0.7040 : GGG40 EN-JS : 1030 0.7050 : GGG50 EN-JS : 1050	1.8273 : Al99,5Ti Ampco 18 Ampco 21

Lames	BSK / PROD-K / XTREM-K					XTREM-K / REFRA-K / TITAN-K				
Fluide	NANOKUT 10% to 12%					NANOKUT 10%				
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)	
10 mm	6,4 mm	57	190 - 300	15 - 24	00:00:02 - 00:00:03	35	50 - 90	4 - 7	00:00:07 - 00:00:12	
25 mm	6,4 mm	56	100 - 150	20 - 29	00:00:10 - 00:00:15	34	30 - 50	6 - 10	00:00:30 - 00:00:50	
40 mm	9,5 mm	55	95 - 125	30 - 39	00:00:19 - 00:00:25	33	22 - 35	7 - 11	00:01:09 - 00:01:49	
65 mm	9,5 mm	53	75 - 95	38 - 48	00:00:41 - 00:00:52	32	15 - 23	8 - 12	00:02:50 - 00:04:20	
100 mm	12,7 mm	50	60 - 90	47 - 71	00:01:07 - 00:01:40	30	12 - 16	9 - 13	00:06:15 - 00:08:20	
150 mm	19,0 mm	48	50 - 65	59 - 77	00:02:18 - 00:03:00	29	8 - 12	9 - 14	00:12:30 - 00:18:45	
200 mm	27,0 mm	47	38 - 57	60 - 90	00:03:31 - 00:05:16	28	9 - 11	14 - 17	00:18:11 - 00:22:13	
300 mm	34,0 mm	45	20 - 34	47 - 80	00:08:49 - 00:15:00	27	4 - 6	9 - 14	00:50:00 - 01:15:00	
400 mm	41,0 mm	40	12 - 22	38 - 69	00:18:11 - 00:33:20	25	3 - 4	9 - 13	01:40:00 - 02:13:20	
500 mm	41,0 mm	38	9 - 15	35 - 59	00:33:20 - 00:55:33	23	2 - 3	8 - 12	02:46:40 - 04:10:00	
600 mm	54,0 mm	35	6 - 11	28 - 52	00:54:33 - 01:40:00	22	1,5 - 2,4	7 - 11	04:10:00 - 06:40:00	
800 mm	67,0 mm	32	4 - 6	25 - 38	02:13:20 - 03:20:00	20	1 - 1,6	6 - 10	08:20:00 - 13:20:00	
1000 mm	80,0 mm	30	2,5 - 4	20 - 31	04:10:00 - 06:40:00	18	0,5 - 0,9	4 - 7	18:31:07 - 33:20:00	
1200 mm	80,0 mm	28	1,5 - 2,5	14 - 24	08:00:00 - 13:20:00					
1500 mm	80,0 mm	26	1,3 - 1,7	15 - 20	14:42:21 - 19:13:51					
2000 mm	80,0 mm	25	0,8 1,1	13 17	30:18:11 - 41:40:00					



BIMETAL BANDSAW BLADES

APPLICATIONS AND CUTTING PARAMETERS

These data are indicative, valid for materials in annealed, untempered condition.

They provide a good basis to define a new application.

In practice, you'll need to take into account your machines, your materials and your operating methods. We're here to help you, share our experience and know-how to keep improving your sawing station.



For personalized recommendations,

Flash this QR-code.

We will contact you.

See you soon!

Materials	Aluminium, Aluminium alloys Horizontal machine	Aluminium, Aluminium alloys Vertical machine
	EN AW 1090 : Al 99.9 EN AW 5083 : AlMg4.5Mn EN AW 6082 : AlSi1MgMn	EN AW 1090 : Al 99.9 EN AW 5083 : AlMg4.5Mn EN AW 6082 : AlSi1MgMn

Blades		ALU-K / BSK / STD-K				ALU-K / BSK			
Fluid		NANOKUT 10% to 25%				NANOKUT 25% to 0%			
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)
10 mm	6,4 mm	120	450 - 1000	35 - 79	00:00:01 - 00:00:01	2500	7500 - 15000	589 - 1178	00:00:00 - 00:00:00
25 mm	6,4 mm	120	250 - 600	49 - 118	00:00:02 - 00:00:06	2500	4000 - 8000	785 - 1571	00:00:00 - 00:00:00
40 mm	9,5 mm	120	230 - 500	72 - 157	00:00:05 - 00:00:10	2500	3750 - 6250	1178 - 1963	00:00:00 - 00:00:01
65 mm	9,5 mm	120	190 - 400	97 - 204	00:00:10 - 00:00:21	2500	3000 - 4600	1532 - 2348	00:00:01 - 00:00:01
100 mm	12,7 mm	120	160 - 330	126 - 259	00:00:18 - 00:00:38	2500	2250 - 3250	1767 - 2553	00:00:02 - 00:00:03
150 mm	19,0 mm	120	130 - 250	153 - 295	00:00:36 - 00:01:09	2350	1800 - 2500	2121 - 2945	00:00:04 - 00:00:05
200 mm	27,0 mm	120	95 - 190	149 - 298	00:01:03 - 00:02:06	2250	1250 - 1750	1963 - 2749	00:00:07 - 00:00:10
300 mm	34,0 mm	120	60 - 125	141 - 295	00:02:24 - 00:05:00	2100	760 - 1050	1791 - 2474	00:00:17 - 00:00:24
400 mm	41,0 mm	120	45 - 95	141 - 298	00:04:13 - 00:08:53	2000	500 - 750	1571 - 2356	00:00:32 - 00:00:48
500 mm	41,0 mm	120	35 - 70	137 - 275	00:07:09 - 00:14:17	2750	300 - 550	1178 - 2160	00:00:55 - 00:01:40
600 mm	54,0 mm	120	27 - 55	127 - 259	00:10:55 - 00:22:13	2550	200 - 330	942 - 1555	00:01:49 - 00:03:00
800 mm	67,0 mm	120	10 - 40	63 - 251	00:20:00 - 01:20:00	2300	110 - 185	691 - 1162	00:04:19 - 00:07:16
1000 mm	80,0 mm	120	12 - 30	94 - 236	00:33:20 - 01:23:20	1110	65 - 12	511 - 94	01:23:20 - 00:15:23
1200 mm	80,0 mm	120	10 - 20	94 - 188	01:00:00 - 02:00:00	850	42 - 83	396 - 782	00:14:27 - 00:28:34
1500 mm	80,0 mm	120	7 - 15	82 - 177	01:40:00 - 03:34:17	750	26 - 46	306 - 542	00:32:37 - 00:57:42
2000 mm	80,0 mm	120	5 - 12	79 - 188	02:46:40 - 06:40:00	600	15 - 20	236 - 314	01:40:00 - 02:13:20

Materials	Brass	Copper
	2.0321 : CuZn37 2.0402 : CuZn40Pb2 2.1025 : CuSn7 2.1170 : CuPb5Sn	2.0050 : KE-Cu 2.0060 : Cu57

Blades		ALU-K / BSK / STD-K				ALU-K / BSK / STD			
Fluid		NANOKUT 3% to 5%				NANOKUT 10% to 15%			
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm ² /min)	Cutting time (h:min:sec)
10 mm	6,4 mm	120	300 - 750	24 - 59	00:00:01 - 00:00:02	120	230 - 380	18 - 30	00:00:02 - 00:00:03
25 mm	6,4 mm	120	180 - 430	35 - 84	00:00:03 - 00:00:08	120	120 - 240	24 - 47	00:00:06 - 00:00:13
40 mm	9,5 mm	120	150 - 300	47 - 94	00:00:08 - 00:00:16	120	110 - 190	35 - 60	00:00:13 - 00:00:22
65 mm	9,5 mm	120	120 - 230	61 - 117	00:00:17 - 00:00:33	120	94 - 140	48 - 71	00:00:28 - 00:00:41
100 mm	12,7 mm	120	90 - 200	71 - 157	00:00:30 - 00:01:07	110	75 - 120	59 - 94	00:00:50 - 00:01:20
150 mm	19,0 mm	120	80 - 160	94 - 188	00:00:56 - 00:01:52	110	63 - 100	74 - 118	00:01:30 - 00:02:23
200 mm	27,0 mm	120	75 - 150	118 - 236	00:01:20 - 00:02:40	110	60 - 90	94 - 141	00:02:13 - 00:03:20
300 mm	34,0 mm	120	50 - 100	118 - 236	00:03:00 - 00:06:00	110	42 - 55	99 - 130	00:05:27 - 00:07:09
400 mm	41,0 mm	120	38 - 80	119 - 251	00:05:00 - 00:10:32	1000	28 - 38	88 - 119	00:10:32 - 00:14:17
500 mm	41,0 mm	120	30 - 60	118 - 236	00:08:20 - 00:16:40	92	20 - 25	79 - 98	00:20:00 - 00:25:00
600 mm	54,0 mm	120	25 - 45	118 - 212	00:13:20 - 00:24:00	86	14 - 19	66 - 90	00:31:35 - 00:42:51
800 mm	67,0 mm	120	15 - 30	94 - 188	00:26:40 - 00:53:20	80	7 - 10	44 - 63	01:20:00 - 01:54:17
1000 mm	80,0 mm	120	11 - 22	86 - 173	00:45:27 - 01:30:55	75	4 - 6,4	31 - 50	02:36:15 - 04:10:00
1200 mm	80,0 mm	120	6 - 13	57 - 123	01:32:18 - 03:20:00	70	3 - 4,2	28 - 40	04:45:43 - 06:40:00
1500 mm	80,0 mm	120	5 - 9	59 - 106	02:46:40 - 05:00:00	65	1,9 - 3	22 - 35	08:20:00 - 13:09:28
2000 mm	80,0 mm	120	3,2 - 6	50 - 94	05:33:20 - 10:25:00	60	1,1 - 1,9	17 - 30	17:32:38 - 30:18:11

BIMETAL BANDSAW BLADES

ERKO STD-K :

THE MULTI-USE BAND
STEEL, STAINLESS STEEL, NON-FERROUS

ERKO STD-K

Technology :	BIMETAL HSS M42				
Cuts hardness up to :	43,4 HRC / 140 kg				
Versatility	x	x	x	x	
Surface finish	x	x	x		
Productivity	x	x	x		

Available tooththing (TPI)

Height x Thickness	Positive angle KH 5°	Angle KZ 0°
12.7 x 0.64 mm		6/10T - 8/12T - 10/14T - 14/18T
19 x 0.90 mm	4/6T	5/8T - 6/10T - 8/12T - 10/14T
27 x 0.90 mm	3/4T - 4/6T	5/8T - 6/10T - 8/12T - 10/14T
34 x 1.10 mm	2/3T - 3/4T - 4/6T	5/8T
41 x 1.30 mm	2/3T - 3/4T - 4/6T	
54 x 1.6 mm	2/3T - 3/4T - 4/6T	



Applications :

- Mild steel
- Low-alloy steel
- Stainless steel
- Non-ferrous

Teeth shapes :

- impact-resistant teeth, even on manual machines
- thin teeth (from 14/18 to 5/8 included) = 0° angle, for thin walls, small sections
- big teeth (from 4/6 to 2/3 included) = slightly positive angle 5°, universal use, profiles and full materials.

ERKO BSK :

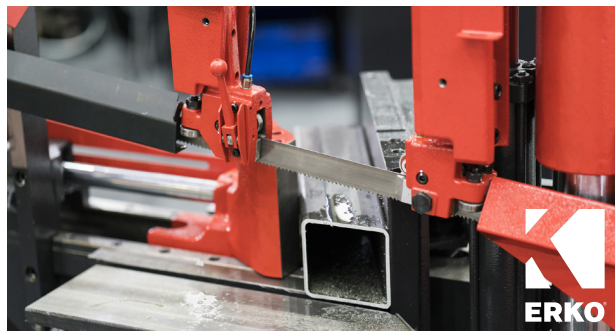
THE INTENSE MULTI-USE BAND
STEEL, STAINLESS STEEL, NON-FERROUS

ERKO BSK

Technology :	BIMETAL HSS M42				
Cuts hardness up to :	43,4 HRC / 140 kg				
Versatility	x	x	x	x	x
Surface finish	x	x	x	x	
Productivity	x	x	x	x	

Available tooththing (TPI)

Height x Thickness	Positive angle KH 10°	Angle KZ 0°
6.4 x 0.64 mm	6T	10/14T
6.4 x 0.90 mm	6T	10/14T
9.5 x 0.64 mm	6T	10/14T
9.5 x 0.90 mm	4T - 6T - 10T	10/14T
12.7 x 0.64 mm	6T - 10T - 14T - 18T	6/10T - 8/12T - 10/14T
12.7 x 0.90 mm	3T - 4T - 6T	6/10T - 10/14T
19 x 0.90 mm	4/6T - 14T - 18T	5/8T - 6/10T - 8/12T - 10/14T
27 x 0.90 mm	2/3T - 3/4T - 4/6T	5/8T - 6/10T - 8/12T - 10/14T
34 x 1.10 mm	2/3T - 3/4T - 4/6T	5/8T - 6/10T - 8/12T
41 x 1.30 mm	2/3T - 3/4T - 4/6T	5/8T - 6/10T
54 x 1.30 mm	2/3T - 3/4T - 4/6T	
54 x 1.60 mm	0.7/1.2T - 1.5/2T - 1.1/1.6T - 2/3T - 3/4T - 4/6T	
67 x 1.60 mm	0.7/1.2T - 1.5/2T - 1.1/1.6T - 2/3T - 3/4T	



Applications :

- Mild steel
- Alloy steel
- Stainless steel
- Non-ferrous
- Tool steels
- Beams
- Wood

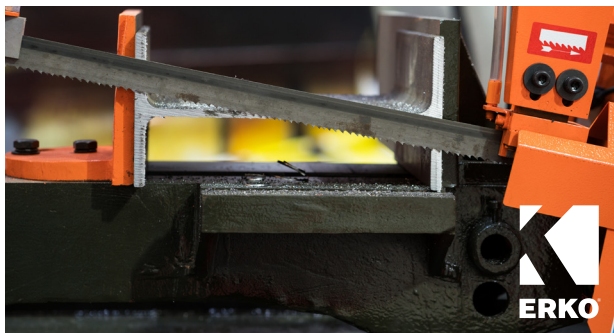
Teeth shapes :

- on small teeth, angle KZ 0° to resist tearing of hollow pieces.
- On large teeth and constant teeth, angle KH 10° to lift more material (full section applications on semi-auto and auto machines).



BIMETAL BANDSAW BLADES

ERKO PROFIL - K : FOR BEAMS, TUBES, PROFILES AND BUNDLES



Applications :

- Building steel (IPE, IPN, HBE, HBA, UPE, UPN ...)
- Steel and stainless steel tubes and profiles
- Bundle cuts of all tubes and profiles

Teeth shapes :

- Reinforced profile to reduce vibrations, noise and withstand successive shocks in beams and bundle cuts of all tubes and profiles.
- Positive angle 6°.
- Special teeth setting and eXtra Large teeth setting (AXL) to prevent large beams from tightening on the blade.

ERKO PROFIL-K

Technology :	BIMETAL HSS M42				
Cuts hardness up to :	43,4 HRC / 140 kg				
Versatility	x	x	x	x	
Surface finish	x	x	x	x	
Productivity	x	x	x	x	

Available toothing (TPI)

Height x Thickness	
19 x 0.90 mm	5/7T - 8/11T - 14/18T
27 x 0.90 mm	3/4T - 4/6T - 5/7T - 8/11T - 14/18T
34 x 1.10 mm	2/3T AXL - 3/4T AXL - 4/6T - 5/7T - 8/11T
41 x 1.30 mm	2/3T AXL - 3/4T AXL - 4/6T - 5/7T - 8/11T
54 x 1.30 mm	2/3T AXL - 3/4T AXL - 4/6
54 x 1.60 mm	2/3T AXL - 3/4T AXL - 4/6 - 5/7
67 x 1.60 mm	2/3T AXL - 3/4T AXL - 4/6T AXL

ERKO PROD - K : THE MULTI-USE BAND HIGH PRODUCTIVITY



Applications :

- Mild steel
- Alloy steel
- Stainless steel
- Non-ferrous
- Tool steels

For large and medium-section of full, tubes and profiles. For high-yield production.

Teeth shapes :

- large swarf chamber,
- very positive teeth KH 10°

ERKO PROD-K

Technology :	BIMETAL HSS M42				
Cuts hardness up to :	43,4 HRC / 140 kg				
Versatility	x	x	x	x	
Surface finish	x	x	x	x	
Productivity	x	x	x	x	x

Available toothing (TPI)

Height x Thickness	
27 x 0.90 mm	2/3 - 3/4 - 4/6 - 5/8
34 x 1.10 mm	1.4/2.0 - 2/3 - 3/4 - 4/6 - 5/8
41 x 1.30 mm	1.4/2.0 - 2/3 - 3/4 - 4/6 - 5/8
54 x 1.30 mm	1.4/2.0 - 2/3 - 3/4 - 4/6
54 x 1.60 mm	1.0/1.4 - 1.4/2.0 - 2/3 - 3/4 - 4/6
67 x 1.60 mm	0.7/1.1 - 1.0/1.4 - 1.4/2.0 - 2/3 - 3/4 - 4/6
80 x 1.60 mm	0.7/1.1 - 1.0/1.4 - 1.4/2.0 - 2/3 - 3/4



BIMETAL BANDSAW BLADES



ERKO PROFIL - K **ALTIUM** : VERY HIGH PRODUCTIVITY FOR BEAMS AND PROFILES

ERKO PROFIL-K

Technology :	BIMETAL HSS M42 + AlTiN coating				
Cuts hardness up to :	43,4 HRC / 140 kg				
Versatility	x	x	x	x	
Surface finish	x	x	x	x	x
Productivity	x	x	x	x	x

Available toothing (TPI)

Height x Thickness	
34 x 1.10 mm	3/4T - 4/6T
41 x 1.30 mm	2/3T AXL - 3/4T AXL
54 x 1.30 mm	3/4T AXL
54 x 1.60 mm	2/3T AXL - 3/4T AXL
67 x 1.60 mm	2/3T AXL - 3/4T AXL

Applications :

- Structural steels (IPE, IPN, HBE, HBA, UPE, UPN ...)
- Steel and stainless steel tubes and full materials
- Bundle cuts of all tubes and full materials

Teeth shapes :

- Reinforced profile to reduce vibrations, noise and withstand successive shocks in beams and bundle cuts of all tubes and profiles.
- Positive angle 6°.
- Special teeth setting and eXtra Large teeth setting (AXL) to prevent large beams from tightening on the blade.



ERKO PROD - K **ALTIUM** : VERY HIGH PRODUCTIVITY IN BIG SECTIONS

ERKO PROFIL-K

Technology :	BIMETAL HSS M42 + revêtement AlTiN				
Cuts hardness up to :	43,4 HRC / 140 kg				
Versatility	x	x	x	x	
Surface finish	x	x	x	x	x
Productivity	x	x	x	x	x

Available toothing (TPI)

Height x Thickness	
27 x 0.90 mm	2.5/3.4
34 x 1.10 mm	1.8/2.5 - 2.5/3.4
41 x 1.30 mm	1.8/2.5 - 2.5/3.4
54 x 1.60 mm	1.2/1.6 - 1.4/1.8 - 1.8/2.5
67 x 1.60 mm	1.0/1.4 - 1.2/1.6 - 1.4/1.8

Applications :

- Mild steel
- Alloy steel
- Stainless steel
- Non-ferrous
- Tool steels

For large and medium-section of full, tubes and profiles. For high-yield production.

Teeth shapes :

- large swarf chamber,
- very positive teeth KH 10°



BIMETAL BANDSAW BLADES



ERKO XTREM-K : M51 BAND FOR VERY HARD STEELS WITH DIFFICULT MACHINABILITY

ERKO XTREM-K

Technology :	BIMETAL HSS M51				
Cuts hardness up to :	45 HRC / 147 kg				
Versatility	x	x	x	x	
Surface finish	x	x	x	x	x
Productivity	x	x	x	x	

Available toothing (TPI)

Height x Thickness	Positive angle KH 15°	Positive angle KH 10°
27 x 0.90 mm	2/3T	3/4T - 4/6T - 5/8T
34 x 1.10 mm	2/3T - 3/4T	4/6T
41 x 1.30 mm	1.5/2.0T - 2/3T	3/4T - 4/6T
54 x 1.60 mm	1.1/1.6T - 1.5/2.0T 2/3T	3/4T
67 x 1.60 mm	0.75/1.1T - 1.1/1.6T 1.5/2.0T	2/3T
80 x 1.60 mm	0.75/1.1T - 1.1/1.6T	

Applications :

- Alloy steels
- Stainless steel
- Acier fortement allié
- Tool steels
- Nickel-base alloy
- Titanium-base alloy

Up to 45HRC

Teeth shapes :

- Aggressive angle KH 10° and super-positive angle KH 15° to lift more material.
- Large swarf chambers for high-productivity applications..



ERKO ALU-K : FOR ALUMINUM

ERKO PROD-K

Technology :	BIMETAL HSS M42				
Cuts hardness up to :	43,4 HRC / 140 kg				
Versatility	x	x			
Surface finish	x	x	x	x	
Productivity	x	x	x	x	

Available toothing (TPI)

Height x Thickness	
12.7 x 0.90 mm	3T - 4T
19 x 0.90 mm	3T
27 x 0.90 mm	2T - 3T - 4T
34 x 1.10 mm	1.25T - 2T - 3T
41 x 1.30 mm	3T

Applications :

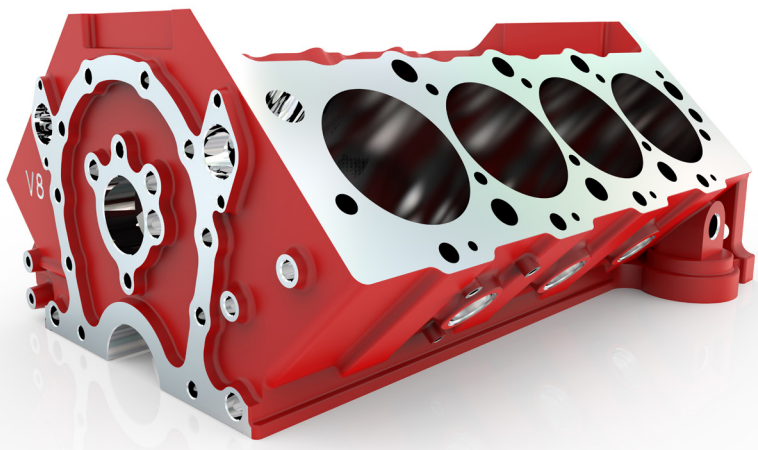
- Aluminium (Silicon content less than 7%.)
- Slitting
- Spruing

Fluide advice :

ERKO NANOKUT to 10% - SOLUKLEAN cleaner, dosed at 3% in the bath, also helps remove sticky aluminum swarf.

Teeth shapes :

- Aggressive KH 10° angle for aluminum and non-ferrous metals.
- Wide, aluminum-specific teeth setting.



BIMETAL BANDSAW BLADES



Applications :

- Alloy steels
- Stainless steel
- High-alloy steel
- Tool steels
- Nickel-based alloy
- Titanium-base alloy
- Refractory alloy

Need of excellent finish and high-production.

Up to 45HRC

Teeth shapes :

- KH 15° super-positive angle to lift more material.
- Large swarf chambers for high-productivity applications.
- Geometry for swarf breaking and elimination.

ERKO REFRA-K: PRODUCTION AND FINISHING IN STAINLESS AND HEAT-RESISTANT STEELS

ERKO REFRA-K

Technology :	BIMETAL HSS M42 + CARBIDE HD powder				
Cuts hardness up to :	45 HRC / 147 kg				
Versatility	x	x	x		
Surface finish	x	x	x	x	x
Productivity	x	x	x	x	x

Available toothing (TPI)

Height x Thickness	
27 x 0.90 mm	2/3T - 3/4T - 4/6T
34 x 1.10 mm	2/3T - 3/4T - 4/6T
41 x 1.30 mm	1.4/2.0T - 2/3T - 3/4T - 4/6T
54 x 1.60 mm	1.4/2.0T - 1.0/1.4T - 2/3T - 3/4T
67 x 1.60 mm	0.7/1.0T - 1.0/1.4T - 1.4/2.0T - 2/3T - 3/4T
80 x 1.60 mm	0.7/1.0T - 1.0/1.4T



Applications :

- Titanium-base alloy - Nickel-base alloy
- Need of excellent finish and high-production.

Up to 45HRC

Teeth shapes :

- KH 15° super-positive angle to lift more material.
- Large swarf chambers for high-productivity applications.
- Geometry for swarf breaking and elimination.

ERKO TITAN-K FOR CUTTING TITANIUM ALLOYS

ERKO REFRA-K

Technology :	BIMETAL HSS M42 + CARBIDE HD powder				
Cuts hardness up to :	45 HRC / 147 kg				
Versatility	x	x			
Surface finish	x	x	x	x	
Productivity	x	x	x	x	x

Available toothing (TPI)

Height x Thickness	
27 x 0.90 mm	2.5/3.4T
34 x 1.10 mm	2.5/3.4T - 1.8/2.5T
41 x 1.30 mm	2.5/3.4T - 1.8/2.5T - 1.4/1.8T
54 x 1.60 mm	2.5/3.4T - 1.8/2.5T - 1.4/1.8T - 1.2/1.6T - 1.0/1.4T
67 x 1.60 mm	1.8/2.5T - 1.4/1.8T - 1.2/1.6T - 1.0/1.4T - 0.7/1.0T
80 x 1.60 mm	1.4/1.8T - 1.2/1.6T - 1.0/1.4T - 0.7/1.0T

