

A close-up photograph of a band saw blade, showing its sharp, serrated teeth. The blade is curved and set against a dark blue background. The lighting highlights the metallic texture and the precision of the teeth.

***Precision
band saw blades***

Precision at the cutting point

WIKUS MARAT

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*No compromise
in quality and
performance*





Innovative band saw blades made in Spangenberg

WIKUS has produced band saw blades since 1958. High-tech tools according to the individual requirements for industry and trade. WIKUS blades are used everywhere highest precision, fine cutting and maximum power are required.

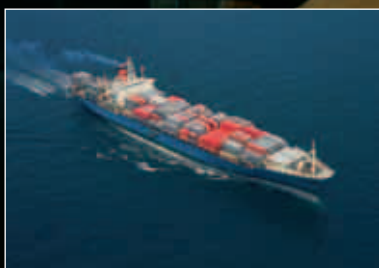
The most important principle of WIKUS' quality policy is the customer's satisfaction. That is why quality consciousness is an important part of our company management, and can be found in all our departments.

The motto "precision at the cutting point" is a concrete statement concerning WIKUS' great demands on its products. A visible sign of our high-quality standard is the certification to DIN EN ISO 9001 that has been achieved by WIKUS, the first European manufacturer of band saw blades to accomplish this.

By offering a range of more than 1400 product variants WIKUS is leading the world market when cutting metal and is Europe's largest manufacturer of band saw blades.

In order to maintain our position, we invest a great deal in research and development, because cutting is both science and philosophy for us.

*The highest
demands
are our standard*



High-quality tools for industry and trade

WIKUS band saw blades are designed specifically for the application and the material to be cut and are therefore able to supply the best results with maximum quality and profitability to our customers.

Frequent applications for our products are in the following fields:

- steel production and steel trade
- machine construction
- automotive industry
- aerospace
- building sector

Concrete blocks for house storefronts are formed, steel beams are cut to the required size, rubber tyres and whole engine blocks are cut in the automotive industry all using WIKUS band saw blades. Even granite and hardest steel or titanium alloys cannot stop our products.

Whether the smallest or finest castings require maximum surface finish or gigantic steel blocks are to be cut - you can always depend on the precision of a WIKUS band saw blade.

***Global player
in more than 60 countries***

WIKUS GIGANT M42





Worldwide close to you

At more than 60 locations WIKUS supports you with their representatives. It is our principle to be an international presence.

Direct contact to our customers helps us to understand individual requirements better and to optimally comply with them.

America:

Argentina · Brazil · Canada · Mexico · Peru · USA
· Venezuela

Africa:

Egypt · Morocco · South Africa · Tunisia · Zimbabwe

Europe:

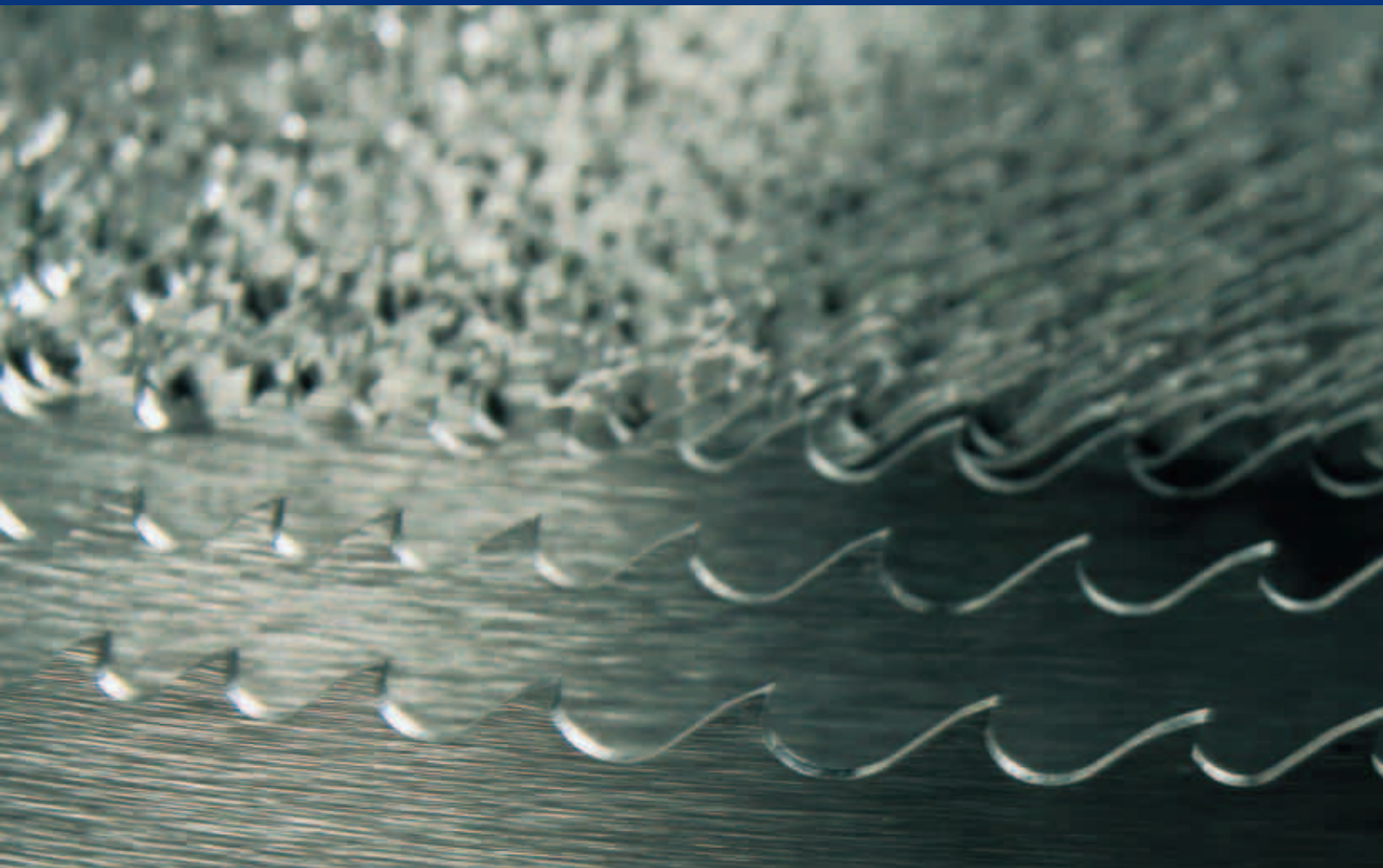
Austria · Belgium · Bosnia-Herzegovina · Bulgaria
· Czech Republic · Croatia · Denmark · Finland · France
· Great Britain · Greece · Hungary · Iceland · Ireland
· Italy · Macedonia · Malta · the Netherlands · Norway
· Poland · Portugal · Romania · Russia · Slovakia · Slovenia
· Spain · Sweden · Switzerland · Turkey · Yugoslavia

Asia:

China · Dubai · Hong Kong · India · Indonesia · Iran
· Israel · Japan · Korea · Kuwait · Malaysia · Oman
· Pakistan · Saudi Arabia · Singapore · Taiwan · Thailand

Australia:

Australia · New Zealand


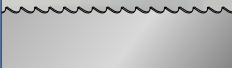
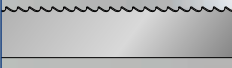
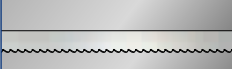
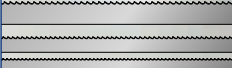




When selecting a WIKUS band saw blade you may use the following points as check list.

Selecting the right band saw blade

1. Band length

The band dimension individually depends on the used cutting machine. You will find further information in the rear of this catalogue or in the operation instructions for your machine.

Band width and smallest radius	
	20 mm - r = 140
	16 mm - r = 95
	13 mm - r = 65
	10 mm - r = 40
	8 mm - r = 30
	6 mm - r = 16
	4 mm - r = 8
	3 mm - r = 3

2. Band width

With horizontal machines the band width is specified by the manufacturer. Vertical band saw machines allow higher variations of the band width. However, the general rule is the wider the band saw blade the higher its stability.

In case of contour cuts the smallest radius to be cut is the limiting factor for the band width.

3. Cutting edge material

WIKUS offers four main groups of cutting edge materials:

Carbon steel

Hardness: approx. 850 HV
Tempering resistance: approx. 200°C

High-speed steel

Hardness: approx. 1000 HV
Tempering resistance: approx. 600°C

Carbide

Hardness: approx. 1600 HV
Tempering resistance: approx. 800°C

Diamond

Hardness: approx. 9000 HV

The machinability of the material to be cut determines the cutting edge material.

Our technical service team will gladly help you with the selection.

For extensive product recommendation we need detailed information, please see pages 61 and 62.

Constant tooth pitch

Tooth pitch	Contact length
24 tpi	up to 6 mm
18 tpi	up to 10 mm
14 tpi	up to 15 mm
10 tpi	15 - 30 mm
8 tpi	30 - 50 mm
6 tpi	50 - 80 mm
4 tpi	80 - 120 mm
3 tpi	120 - 200 mm
2 tpi	200 - 400 mm
1,25 tpi	300 - 800 mm
0,75 tpi	700 - 3000 mm

Variable tooth pitch

Tooth pitch	Contact length
10-14 tpi	up to 30 mm
8-12 tpi	20 - 50 mm
6-10 tpi	25 - 60 mm
5-8 tpi	35 - 80 mm
4-6 tpi	50 - 100 mm
4-5 tpi	70 - 120 mm
3-4 tpi	80 - 150 mm
2-3 tpi	120 - 350 mm
1,4-2 tpi	250 - 600 mm
0,75-1,25 tpi	500 - 1200 mm
0,55-0,75 tpi	1000 - 3000 mm

Cutting of tubes and profiles

Wall thickness s [mm]	Tooth pitch Tz (tpi) Outer diameter D of the tube [mm]																
	20	40	60	80	100	120	150	200	300	400	500	600	700	800	900	1000	1500
2	14	14	14	14	14	14	10-14	10-14	8-12	8-12	6-10	6-10	5-8	5-8	5-8	5-8	5-8
3	14	14	10-14	10-14	10-14	10-14	8-12	8-12	6-10	6-10	5-8	5-8	5-8	4-6	4-6	4-6	4-6
4	14	14	10-14	10-14	8-12	8-12	8-12	8-12	5-8	5-8	4-6	4-6	4-6	4-6	4-6	4-6	3-4
5	14	10-14	10-14	10-14	8-12	8-12	8-12	6-10	5-8	5-8	4-6	4-6	4-6	4-6	3-4	3-4	3-4
6	14	10-14	10-14	8-12	8-12	8-12	8-12	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4	3-4	3-4
8	14	10-14	8-12	8-12	8-12	6-10	6-10	5-8	4-6	4-6	4-6	3-4	3-4	3-4	3-4	2-3	2-3
10		8-12	6-10	6-10	6-10	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4	3-4	2-3	2-3	2-3
12		8-12	6-10	6-10	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4	3-4	2-3	2-3	2-3	2-3
15		8-12	6-10	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3	2-3	2-3	2-3	2-3
20			6-10	5-8	4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3	2-3	2-3	2-3	2-3	2-3
30				4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3	2-3	2-3	2-3	2-3	2-3	1,4-2
50						3-4	3-4	3-4	2-3	2-3	2-3	2-3	2-3	2-3	1,4-2	1,4-2	1,4-2
75								2-3	2-3	2-3	2-3	2-3	1,4-2	1,4-2	1,4-2	1,4-2	1,4-2
100									2-3	2-3	1,4-2	1,4-2	1,4-2	1,4-2	1,4-2	1,4-2	0,75-1,25
150										2-3	1,4-2	1,4-2	1,4-2	1,4-2	1,4-2	0,75-1,25	0,75-1,25
200											1,4-2	1,4-2	1,4-2	1,4-2	0,75-1,25	0,75-1,25	0,75-1,25
250												1,4-2	1,4-2	1,4-2	0,75-1,25	0,75-1,25	0,75-1,25
300													1,4-2	1,4-2	0,75-1,25	0,75-1,25	0,75-1,25
350														0,75-1,25	0,75-1,25	0,75-1,25	0,55-0,75
400															0,75-1,25	0,75-1,25	0,55-0,75
450																0,75-1,25	0,55-0,75
500																	0,55-0,75

If you have to cut two or more tubes lying side by side please use this table in consideration of the double wall thickness s.

4. Tooth pitch

At WIKUS you may choose between constant and variable tooth pitch. Here the contact length of the blade in the work piece is decisive. To give you a better overview you will also find the upper and lower limit in both given tables.

5. Tooth shape

Our different tooth shapes have been optimally combined with our cutting edge materials and band dimensions by our technologists.

- **Raker tooth (S)**
for short-chipping and brittle materials
- **Skip tooth (L)**
for flexible materials (aluminium and wood)

- **Hook tooth (K)**
for long-chipping, tough materials
- **Tooth shape (HV)**
particularly for brittle and annealed materials with large cross-sections
- **Tooth shape (VA)**
particularly for tough and long-chipping materials with large cross-sections
- **Profile tooth (P)**
for hollow profiles, angle profiles and beams
- **Trapezoid tooth (T)**
for high cutting rates and best surface quality
- **Tooth shape (TSN)**
particularly for induction hardened and chrome coated shafts

6. Type of tooth set

Our product range offers every type of tooth set that is important for you.

Carbon steel band saw blades

- SD, WS, RL, GS

Bimetal band saw blades

- SD, GS

Carbide coated band saw blades

- SD

Our carbide tipped band saw blades FUTURA, FUTURA PLUS and FUTURA SN as well as all **coated band saw blades** are not set.

Further information concerning tooth shapes, tooth pitches and types of tooth set can be found on the next page.

The geometry of a band saw blade

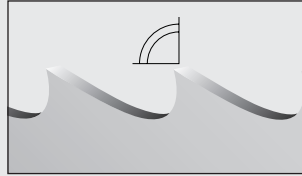
Tooth shapes

The tooth shapes of the WIKUS range differ by the rake angle of the tooth edge and by the shape of the gullet.

Raker tooth (S)

Rake angle: 0° , for:

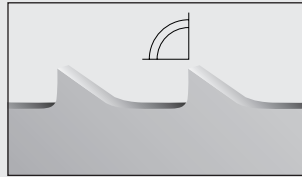
- short-chipping materials
- steels with high carbon content
- preferably tool steel and cast iron
- materials with small cross-sections
- thin-walled profiles



Skip tooth (L)

Rake angle: 0° , for:

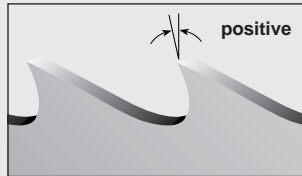
- flexible materials
(aluminium and wood)



Hook tooth (K)

Rake angle: positive, for:

- long-chipping, tough materials
- non-ferrous metals and steels with a carbon content of $< 0,8\%$
- structural steels, steels for cold extrusion, tempered steels, rust- and acid-resistant steels, exotic alloys
- large cross-sections



Tooth shape (HV)

Hook tooth (as above), rake angle: positive, for:

- brittle and annealed materials
- large cross-sections

Tooth shape (VA)

Hook tooth (as above), rake angle: positive, for:

- tough and long-chipping materials
- large cross-sections

Profile tooth (P)

Rake angle: positive, for:

- hollow and angle profiles
- beams
- bundle and layer cuts
- applications that are susceptible to vibrations



Trapezoid tooth (T)

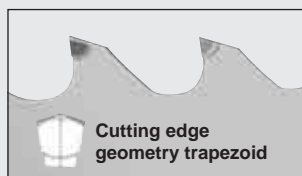
Rake angle: positive, for:

- high cutting rates with high material demands

Tooth shape (TSN)

Trapezoid tooth (as above), rake angle: negative, for:

- induction hardened and chrome coated shafts
- hardened steels up to 62 HRC, hard manganese steels, hard-chrome plated work pieces
- diameters up to 200 mm



Tooth pitch (Tz)

Tooth pitch is defined as the number of teeth per inch (tpi). 1 inch corresponds to 25,4 mm. In the WIKUS range a difference is made between constant tooth pitches with regular tooth distance and variable tooth pitches with differing tooth distance within one toothing interval.

Variable tooth pitches are marked by two measures, e.g. 2-3 tpi. With this, 2 tpi signifies the maximum tooth distance and 3 tpi signifies the minimum tooth distance in the toothing interval.





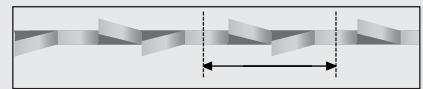
Types of tooth set

By means of the tooth set, where the teeth protrude alternately left and right beyond the blade body, free-cutting action of the band saw blade is achieved.

Standard set (SD)

The standard set is an all-purpose set for cutting thicknesses of more than 5 mm ($\frac{3}{16}$ ") of steels, castings and hard non-ferrous metals.

With constant tooth pitch the set sequence is left/right/straight.



Toothing interval



With variable tooth pitch one tooth in each toothing interval is unset. The remaining teeth in the interval are recurrently set left/right.

Group set (GS)



For band saw blades in the tooth pitch range of 4-18 tpi improved surface quality is obtained with group set.

Right-left set (RL)



With materials that are easy to cut, such as non-ferrous metals, plastics and wood, a right/left set is particularly effective.

Wavy set (WS)

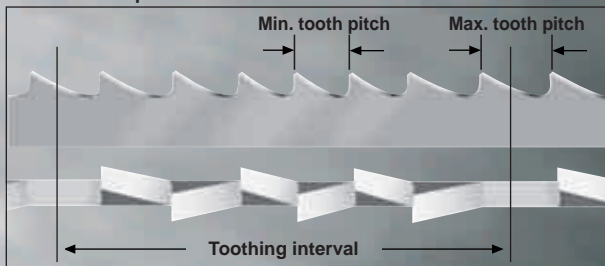


With material dimensions up to 5 mm ($\frac{3}{16}$ "), such as sheets, thin-walled tubes and profiles, we recommend wavy set.

Constant tooth pitch



Variable tooth pitch



Our range at a glance

Carbon steel band saw blades

Sales units:	coils in fixed lengths and manufacturing coils up to 120 m, depending on the band width, welded-to-length band saw blades
Band widths:	2,5 to 38 mm
Constant tooth pitches:	2 to 24 teeth per inch (tpi)
Tooth shapes:	raker tooth (S), hook tooth (K), skip tooth (L)
Types of tooth set:	standard set (SD), wavy set (WS), group set (GS) right/left-set (RL)



Bimetal band saw blades

Sales units:	coils in fixed lengths and manufacturing coils up to 120 m, depending on the band width, welded-to-length band saw blades
Band widths:	4 to 125 mm
Constant tooth pitches:	0,75 to 18 teeth per inch (tpi)
Variable tooth pitches:	0,55-0,75 to 10-14 tpi
Tooth shapes:	raker tooth (S) hook tooth (K) tooth shape (HV) tooth shape (VA) profile tooth (P)
Types of tooth set:	standard set (SD) group set (GS)



Carbide band saw blades

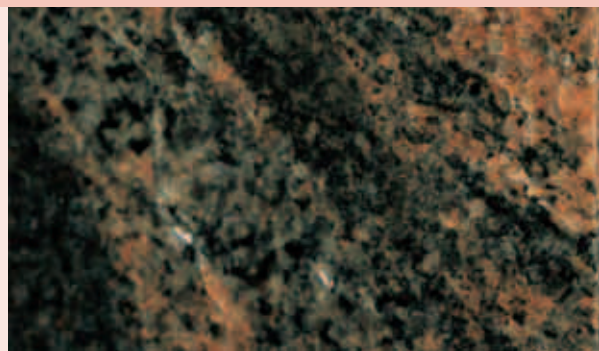
Sales units:	coils at max. 50 m, welded-to-length band saw blades
Band widths:	13 to 80 mm
Constant tooth pitches:	1,25 to 4 teeth per inch (tpi)
Variable tooth pitches:	0,55-0,75 to 3-4 tpi
Tooth shapes:	raker tooth (S), hook tooth (K)
Unset tooth shapes:	trapezoid tooth (T), tooth shape (TSN)

Sales units:	welded-to-length band saw blades
Band widths:	6 to 41 mm
Carbide coating:	constant (K), intermittent (U), with 8 to 14 mm pitch
Grit sizes:	TC181, TC301, TC356, TC525, TC700







Diamond coated band saw blades

Sales units:	welded-to-length band saw blades
Band widths:	10 to 100 mm
Diamond coating:	constant (K), segmented (S), intermittent (U), with 6 to 30 mm pitch
Grit sizes:	D91, D126, D181, D252, D356, D427, D601



* Not available with positive rake angle

Cutting edge material	Backing material	Constant tooth pitch			Variable tooth pitch			
		Rake angle 0° and positive	Rake angle 0° or negative	Rake angle positive				
	<p>Chrome-alloyed tool steel</p> <p>Tungsten-silicon-chrome-alloyed tool steel</p> <p>Silicon-chrome-alloyed tool steel</p>	<p>EXTRA* Item group 500</p> <p>DIAMANT Item group 510</p> <p>JET* Item group 515</p>						
	<p>Chrome-alloyed spring steel</p>		ECOFLEX M42 Item group 523	ECOFLEX M42 Item group 523	PROFLEX M42 Item group 524			
	<p>quenched and tempered steel with 4% chrome exclusively WIKUS</p>	BIFLEX M42 Item group 526	VARIO M42 Item group 528	MARATHON M42 Item group 529	GIGANT M42 Item group 532	VECTOR M42 Item group 534	SELEKTA VT M42 Item group 536	
HSS-M51 approx. 69 HRC approx. 1000 HV	<p>quenched and tempered steel with 4% chrome exclusively WIKUS</p>	BIFLEX M51 Item group 530			MARATHON M51 Item group 531	GIGANT M51 Item group 533	SELEKTA VT M51 Item group 538	VECTOR M51 Item group 539
	<p>quenched and tempered steel with 4% chrome exclusively WIKUS</p>	TCT Item group 540	FUTURA SN Item group 547	ECODUR Item group 542	FUTURA Item group 545	FUTURA PLUS Item group 546		
	<p>Chrome-alloyed spring steel</p>	DUROSET Item group 541						
Carbide (coated) approx. 1500 HV		FUTURA Item group 545						
		FUTURA PLUS Item group 546						
	<p>quenched and tempered steel with 4% chrome exclusively WIKUS</p>	TCgrit K Item group 550 (not toothed)						
		TCgrit U Item group 554 (not toothed)						
		DIAGRIT K Item group 570 (not toothed)						
		DIAGRIT S Item group 572 (not toothed)						
		DIAGRIT U Item group 574						

Recommendation for Use

Product group	Carbon steel										Bimetal		
Item group	EXTRA 500	DIAMANT 510	JET 515	ECOFLEX 523	PROFLEX 524	BIFLEX 526	VARIO 528	MARATHON 529	BIFLEX 530	MARATHON 531	GIGANT 532	GIGANT 533	VECTOR 534
Cutting edge material	Carbon	Carbon	Carbon	M42	M42	M42	M42	M42	M51	M51	M42	M51	M42
Structural steels Case hardened steels Machining steels	<50												
	50-400												
	>400										VA		
Unalloyed tool steel Spring steel Ball bearing steel	<50												
	50-400												VA
	>400										VA		
High-speed steels- Cold work steel	<50												
	50-400												HV
	>400										HV		
Nitriding steel Quenched and tempered steel Hot working tool steel	<50												
	50-400												VA
	>400										VA		
Stainless steels	<50												
	50-400												
	>400										VA		
High-temperature resisting steel Heat-resisting steel	<50												
	50-400												
	>400											VA	
Nickel base alloys Special alloys	<50												
	50-400												
	>400											VA	
Steels with high tensile strength >1200 N/mm²	<50												
	50-400												
	>400											HV	
Inductively hardened and chrome coated shafts	<50												
	50-400												
	>400												
Cast	<50												
	50-400												
	>400										HV		
Titanium alloy	<50												
	50-400												
	>400											VA	
Aluminium Copper	<50												
	50-400												
	>400												
Brass Bronze Red cast	<50												
	50-400												
	>400												
Aluminium bronze	<50												
	50-400												
	>400											HV	
Abrasive structural steels	<50												
	50-400												
	>400												
Carbon	soft												
	medium												
	hard												
Plastics	<50												
	50-400												
	>400												
Glass Glass fibre Marble	<50												
	50-400												
	>400												

Ideal
 Suitable
 Contingently suitable



Carbon steel band saw blades

Hardened tooth tips and a particularly flexible blade body result in high reliability.

WIKUS carbon steel program is specifically suited to basic shop for cutting of composite materials.

Sales units:

- coils in fixed lengths and manufacturing coils up to 120 m, depending on the band width
- welded-to-length band saw blades

Band widths: 2,5 to 38 mm

Constant tooth pitches:

2 to 24 teeth per inch (tpi)

Tooth shapes: raker tooth (S), hook tooth (K), skip tooth (L)

Types of tooth set:

- standard set (SD)
- wavy set (WS)
- group set (GS)
- right/left-set (RL)

Item group 500
EXTRA (approx. 65-66 HRC)

Item group 510
DIAMANT (approx. 66-67 HRC)

Item group 515
JET friction band saw blade (approx. 63-65 HRC)

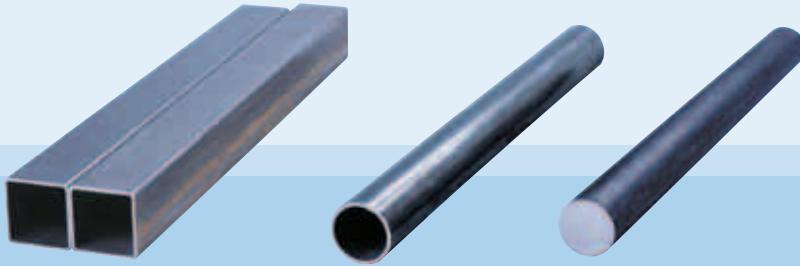
EXTRA

Features:

- Flexible band saw blade made of chrome-alloyed carbon steel
- Hardened tooth tips

- For all-purpose use

- For unalloyed steels with low tensile strength



WIKUS EXTRA

Item group 500

EXTRA (approx. 65-66 HRC)

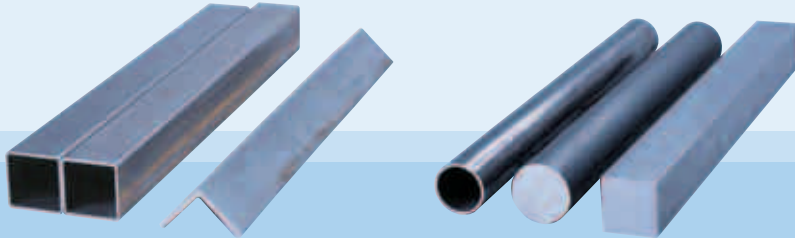
Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi)													
		Standard set (SD)						Wavy set (WS)			Right/left set (RL)	Group set (GS)			
mm	Inches	2	3	4	6	8	10	14	18	14	18	24	6	4	6
8 x 0,65	$\frac{5}{16}$ x 0,025			L	S	S	S	S	S			S	L		
10 x 0,65	$\frac{3}{8}$ x 0,025		L	S-L	S	S	S	S	S			S	L		
13 x 0,65	$\frac{1}{2}$ x 0,025		L	S-L	S	S	S	S	S			S	L		
16 x 0,80	$\frac{5}{8}$ x 0,032		L	S-L	S	S	S			S	S	S	L		
20 x 0,80	$\frac{3}{4}$ x 0,032		S-L	S-L	S	S	S			S	S	S			
25 x 0,90	1 x 0,035	L	S-L	S-L	S	S	S			S		S			
32 x 1,10	$1\frac{1}{4}$ x 0,042	L	S	S	S	S	S								
38 x 1,30	$1\frac{1}{2}$ x 0,050					S								S	S

DIAMANT

Features:

- Tungsten-silicon-chrome-alloyed blade with quenched and tempered backing material made of higher alloyed carbon steel and special hardened tooth tips
- Longer lifetime and wear resistance

- For low alloyed steels
- For steels of medium tensile strength
- For basic shop use



WIKUS DIAMANT

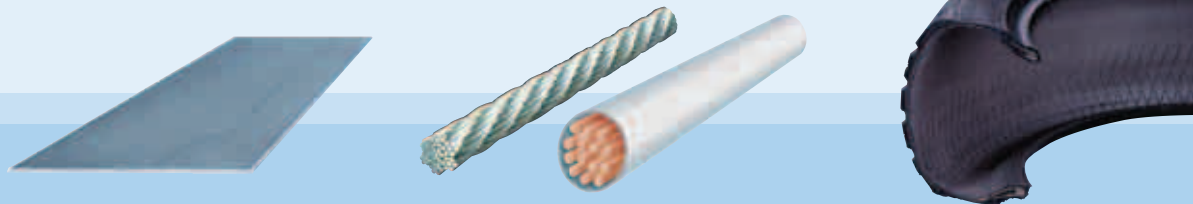
Item group 510
DIAMANT (approx. 66-67 HRC)

Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi)														
		Standard set (SD)								Wavy set (WS)			Group set (GS)			
mm	Inches	2	3	4	6	8	10	14	18	14	18	24	4	6	8	10
2,5 x 0,65	3/32 x 0,025							S	S			S				
3 x 0,65	1/8 x 0,025						S	S	S			S				
4 x 0,65	5/32 x 0,025						S	S	S			S				
5 x 0,40	3/16 x 0,016							S				S				
5 x 0,65	3/16 x 0,025						S	S	S			S				
6 x 0,40	1/4 x 0,016				K		S	S				S				
6 x 0,65	1/4 x 0,025			L	S-K	S	S	S	S			S	K			
8 x 0,65	5/16 x 0,025			S-K-L	S-K	S	S	S	S			S	K			
10 x 0,65	3/8 x 0,025		K	S-K-L	S-K	S	S	S	S			S				
13 x 0,65	1/2 x 0,025		K-L	S-K-L	S-K	S	S	S	S			S				
16 x 0,50	5/8 x 0,020					S		S								
16 x 0,65	5/8 x 0,025		K	S-K-L	S-K	S	S			S		S				
16 x 0,80	5/8 x 0,032		K	S-K	S-K	S	S			S	S	S				
20 x 0,80	3/4 x 0,032		S-K	S-K	S-K	S	S			S	S	S	S	S	S	S
25 x 0,90	1 x 0,035	K	S-K	S-K	S-K	S	S			S		S	S	S	S	S
32 x 1,10	1 1/4 x 0,042	K	S-K	S-K	S	S	S						S	S	S	S
38 x 1,30	1 1/2 x 0,050	K	K			S							S	S		

JET

Features:

- High-flexible band saw blade made of silicon-chrome-alloyed spring steel for friction cutting
 - Optimal for dynamic strain with cutting speeds of 1800-4500 m/min
 - Hardened tooth tips
- For friction cutting on special machines
 - For steels up to 30 mm thickness
 - For composite materials



WIKUS JET

Item group 515

JET friction band saw blade (approx. 63-65 HRC)



Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi)						
		Standard set (SD)			Right/left set (RL)			Group set (GS)
mm	Inches	10	14	18	6	8	10	
8 x 0,65	5/16 x 0,025		S	S				
10 x 0,65	3/8 x 0,025		S					
13 x 0,65	1/2 x 0,025	S	S	S				
16 x 0,80	5/8 x 0,032		S			S	S	
20 x 0,80	3/4 x 0,032		S			S	S	
25 x 0,90	1 x 0,035		S		S	S	S	S
32 x 1,10	1 1/4 x 0,042				S	S	S	S

Tooth pitch and cutting speed

Cutting material	Tooth pitch (tpi) material thickness in mm					Cutting speed (m/min) material thickness in mm				
	up to 2	2 - 6	6 - 10	10 - 15	15 - 30	up to 2	2 - 6	6 - 10	10 - 15	15 - 30
Structural steel	18	14	10	8	8	1800	1800	2500	3000	4000
Alloyed steel	18	14	10	10	8	1800	2500	3000	3500	4000
Austenitic steel	18	14	10	10	8	1800	2500	3000	4000	4500
Titanium	14	14	14	-	-	1200	1200	1200	-	-
Car body sheet steel			10			2000 to 3000				

Tooth shape: S = raker tooth



Bimetal band saw blades

Wear-resistant tooth edges made of HSS in M 42 and M51 qualities, combined with high tooth tip hardness are the characteristics of the extensive bimetal range.

Sales units:

- coils in fixed lengths and manufacturing coils up to 120 m, depending on the band width
- welded-to-length band saw blades

Band widths: 4 to 125 mm

Constant tooth pitches:

0,75 to 18 teeth per inch (tpi)

Variable tooth pitches:

0,55-0,75 to 10-14 tpi

Tooth shapes:

raker tooth (S), hook tooth (K), tooth shape (HV), tooth shape (VA), profile tooth (P)

Types of tooth set:

standard set (SD), group set (GS)

Item group 523
ECOFLEX M42 (68-69 HRC)

Item group 524
PROFLEX M42 (68-69 HRC)

Item group 526
BIFLEX M42 (68-69 HRC)

Item group 528
VARIO M42 (68-69 HRC)

Item group 529
MARATHON M42 (68-69 HRC)

Item group 530
BIFLEX M51 (approx. 69 HRC)

Item group 531
MARATHON M51 (approx. 69 HRC)

Item group 532
GIGANT M42 (68-69 HRC)

Item group 533
GIGANT M51 (approx. 69 HRC)

Item group 534
VECTOR M42 (68-69 HRC)

Item group 539
VECTOR M51 (approx. 69 HRC)

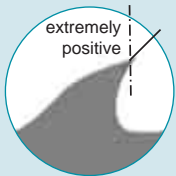
Item group 536
SELEKTA VT M42 (68-69 HRC)

Item group 538
SELEKTA VT M51 (approx. 69 HRC)

Special designs

PD-design

- Positive rake angle for aggressive cutting
- For rust- and acid-resistant steels and exotic alloys
- For medium and large cross-sections



Sales units:

- coils of 30,5 m
- manufacturing coils up to 120 m, depending on the width
- welded-to-length band saw blades

Item groups: 526, 529, 530, 531

Band widths: 27 to 125 mm

Constant tooth pitches: 0,75 to 3 tpi

Variable tooth pitches:

0,55-0,75 to 3-4 tpi

Tooth shape: K

Type of tooth set: SD

PW-design

- Excellent cutting rate and tool life
- For rust- and acid-resistant steels as well as exotic alloys
- Shorter cutting times and longer life-time with large material cross-sections



Sales units:

- coils of 30,5 m
- manufacturing coils up to 120 m, depending on the width
- welded-to-length band saw blades

Item groups: 526, 529, 530, 531, 536, 538

Band widths: 27 to 125 mm

Constant tooth pitches:

0,75 to 3 tpi

Variable tooth pitches:

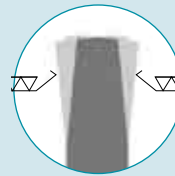
0,55-0,75 to 3-4 tpi

Tooth shape: K

Type of tooth set: SD

PE-design

- Highest possible surface finish by double-sided ground tooth faces
- Particularly suitable for cutting aluminium



Sales units:

only with welded-to-length band saw blades

Item groups: 520 to 531

Band widths: 27 to 67 mm

Constant tooth pitches:

3 to 18 tpi

Variable tooth pitches:

3-4 tpi to 10-14 tpi

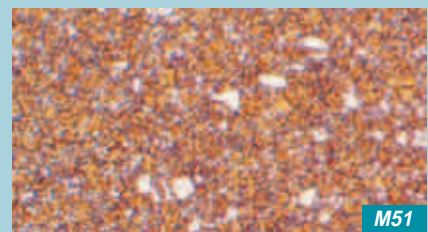
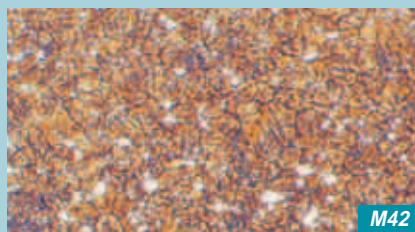
Tooth shapes: S, K

Types of tooth set: SD, GS

Bimetal qualities

M42

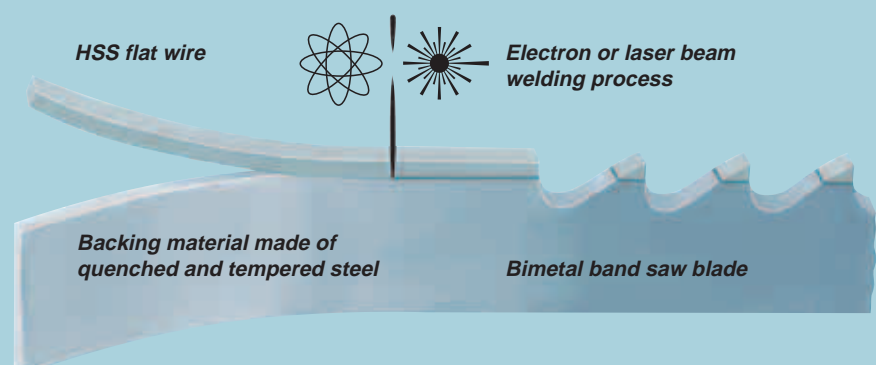
Wear resistance is the outstanding feature of the cutting edge material M42. Their decisive factors are the carbide sizes and their composition. In the shown structure the extremely hard special carbides (white) are embedded in a temperature-resistant martensitic matrix. Due to our technically fully developed heat treatment process the optimal microstructure for your purposes can be achieved.



	C	W	Mo	V	Co	Tooth hardness
M42	↑↑	2%	10%	1%	8%	68-69 HRC
M51	↑↑↑	10%	4%	3%	10%	approx. 69 HRC

M51

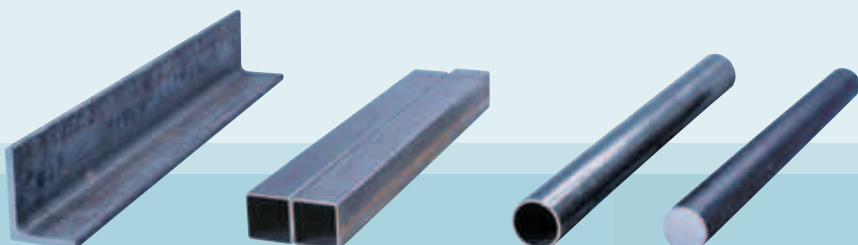
Sharp cutting edges and highest wear resistance, that's what high strength austenitic steels and exotic alloys demand from band saw blades. WIKUS is able to meet this task with its HSS-M51. The high tungsten and carbon content increases the number of carbides (right figure) and also the resistance against abrasive wear. Additionally, due to the high cobalt content the resistance of the microstructure against thermal wear is improved.



ECOFLEX M42

Features:

- Ideal for cutting small and medium work pieces
- Vibration damping, variable tooth pitch
- Tooth tips made of particularly wear-resistant quality
- For small and medium work piece dimensions
- For profiles and solid materials
- For demanding shop operations
- For all steels up to 45 HRC



WIKUS ECOFLEX M42

Item group 523
ECOFLEX M42 (68-69 HRC)

Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi) Standard set (SD)						
mm	Inches	2 - 3	3 - 4	4 - 6	5 - 8	6 - 10	8 - 12	10 - 14
20 x 0,90	$\frac{3}{4}$ x 0,035			K	S	S	S	S
27 x 0,90	$1\frac{1}{16}$ x 0,035		K	K	S	S	S	S
34 x 1,10	$1\frac{3}{8}$ x 0,042	K	K	K	S	S	S	
41 x 1,30	$1\frac{5}{8}$ x 0,050	K	K	K				

Item group 523
ECOFLEX M42 NE (68-69 HRC) with extra wide set for treating non-ferrous metals

Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi) Extra wide set	
mm	Inches	3	4
20 x 0,90	$\frac{3}{4}$ x 0,035	K	K
27 x 0,90	$1\frac{1}{16}$ x 0,035	K	K
34 x 1,10	$1\frac{3}{8}$ x 0,042	K	

PROFLEX M42

Features:

- Tooth geometry especially developed for cutting profiles and tubes

- For hollow profiles

- For angle profiles

- For beams

- For layer and bundle cuts



WIKUS PROFLEX M42

Item group 524

PROFLEX M42 (68-69 HRC)

Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi)				
mm	Inches	2 - 3	3 - 4	4 - 6	5 - 7	8 - 11
20 x 0,90	$\frac{3}{4} \times 0,035$				P	P
27 x 0,90	$1\frac{1}{16} \times 0,035$		P	P*	P	P
34 x 1,10	$1\frac{3}{8} \times 0,042$	P**	P**	P*	P	P
41 x 1,30	$1\frac{5}{8} \times 0,050$	P**	P**	P*	P	P
54 x 1,30	$2\frac{1}{8} \times 0,050$	P**	P**	P*	P	
54 x 1,60	$2\frac{1}{8} \times 0,063$	P**	P**	P*	P	

Tooth shape: P = profile tooth

* Tooth pitch will be discontinued

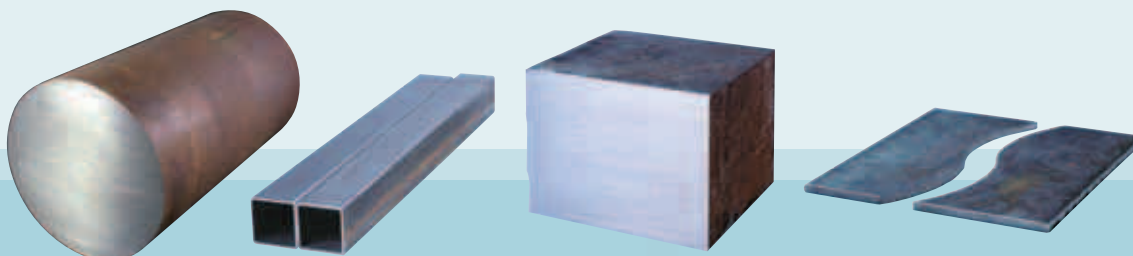
** Also available in wider set for profiles with extreme residual stress

BIFLEX M42

Features:

- Optimal wear resistance due to high cobalt and molybdenum content of the tooth tips
- Resistant against highest dynamic strain

- For all steels up to 45 HRC
- For all work piece dimensions
- For non-ferrous metals
- For contour cuts



WIKUS BIFLEX M42

Item group 526
BIFLEX M42 (68-69 HRC)

Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi) Standard set (SD)									Group set (GS)	
mm	Inches	0,75*	1,25	2	3	4	6	8	10	14	14	18
4 x 0,90	5/32 x 0,035								S	S		
6 x 0,65	1/4 x 0,025						K			S		
6 x 0,90	1/4 x 0,035					K	K		S	S		
10 x 0,90	3/8 x 0,035					K	K	S	S	S		
13 x 0,50	1/2 x 0,020									S		
13 x 0,65	1/2 x 0,025					K	K		S	S		S
13 x 0,90	1/2 x 0,035				K	K	S-K	S	S	S		
20 x 0,90	3/4 x 0,035				K	S-K	S-K	S	S	S	S	S
27 x 0,90	1 1/16 x 0,035			K	S-K	S-K	S-K	S	S	S	S	S
27 x 1,10	1 1/16 x 0,042			K	K	S	S					
34 x 1,10	1 3/8 x 0,042		K	K	S-K	S-K	S	S	S		S	
41 x 1,30	1 5/8 x 0,050		K	K	S-K	S-K	S					
54 x 1,30	2 1/8 x 0,050		K	K	K							
54 x 1,60	2 1/8 x 0,063		K	K	K							
67 x 1,60	2 5/8 x 0,063	K*	K	K								
80 x 1,60	3 1/8 x 0,063	K*	K									

Tooth shapes: S = raker tooth, K = hook tooth

* Only available in special design PD (see page 22)

VARIO M42

Features:

- Particularly suitable for vibration-susceptible cutting tasks in serial cuts
- Variable tooth pitch
- Wear-resistant tooth tips
- For profile and bundle cuts
- For serial cuts
- For small and medium work piece dimensions
- For all steels up to 45 HRC



WIKUS VARIO M42

Item group 528
VARIO M42 (68-69 HRC)

Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi) Standard set (SD)					
mm	Inches	3 - 4	4 - 6	5 - 8	6 - 10	8 - 12	10 - 14
6 x 0,65	1/4 x 0,025				S		S
6 x 0,90	1/4 x 0,035						S
10 x 0,90	3/8 x 0,035						S
13 x 0,50	1/2 x 0,020					S	S
13 x 0,65	1/2 x 0,025				S	S	S
13 x 0,90	1/2 x 0,035				S	S	S
20 x 0,90	3/4 x 0,035		S	S	S	S	S
27 x 0,90	1 1/16 x 0,035	S	S	S	S	S	S
27 x 1,10	1 1/16 x 0,042		S				
34 x 1,10	1 3/8 x 0,042	S	S	S	S	S	
41 x 1,30	1 5/8 x 0,050	S	S	S	S		
54 x 1,30	2 1/8 x 0,050		S		S		

Tooth shape: S = raker tooth

MARATHON M42

Features:

- Tooth tips with high cobalt and molybdenum content
- Highest cutting rates
- Longer lifetime
- For layer and bundle cuts of large work piece dimensions
- For large profiles and solid materials
- For all steels up to 45 HRC
- For non-ferrous metals



WIKUS MARATHON M42

Item group 529
MARATHON M42 (68-69 HRC)

Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi) Standard set (SD)						
mm	Inches	0,55 - 0,75	0,75 - 1,25	1,4-2	2-3	3-4	4-5	4-6
27 x 0,90	1 ¹ / ₁₆ x 0,035				K	K	K	K
27 x 1,10	1 ¹ / ₁₆ x 0,042				K	K		K
34 x 1,10	1 ³ / ₈ x 0,042			K	K	K	K	K
38 x 1,30**	1 ¹ / ₂ x 0,050				K*	K		K
41 x 1,30	1 ⁵ / ₈ x 0,050			K	K	K	K	K
54 x 1,30	2 ¹ / ₈ x 0,050		K	K	K	K	K	K
54 x 1,60	2 ¹ / ₈ x 0,063		K*	K	K	K	K	K
67 x 1,60	2 ⁵ / ₈ x 0,063	K*	K*	K	K	K		K
80 x 1,60	3 ¹ / ₈ x 0,063	K*	K*	K	K	K		
100 x 1,60	4 x 0,063		K*					
125 x 2,00	5 x 0,079		K*					

Tooth shape: K = hook tooth

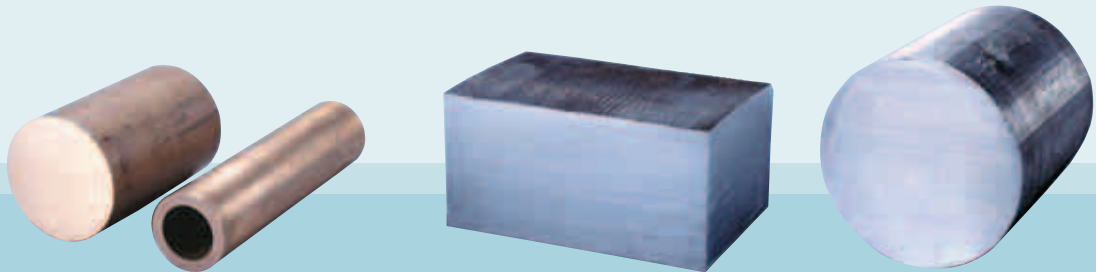
* Only available in special design PD (see page 22)

** Dimension in light print will be discontinued

BIFLEX M51

Features:

- Developed for cutting austenitic steels and exotic alloys
- Extreme tooth tip hardness due to high tungsten and cobalt content
- For rust- and acid-resistant steels of medium and large cross-sections
- For nickel base alloys (such as Inconel, Hastelloy, Nimonic) of medium and large cross-sections
- For titanium and special bronze
- For steels up to 50 HRC



WIKUS BIFLEX M51

Item group 530
BIFLEX M51 (approx. 69 HRC)

Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi) Standard set (SD)				
mm	Inches	0,75	1,25	2	3	4
27 x 0,90	1 ¹ / ₁₆ x 0,035				K	S
34 x 1,10	1 ³ / ₈ x 0,042			K	K	
41 x 1,30	1 ⁵ / ₈ x 0,050		K	K	K	
54 x 1,60	2 ¹ / ₈ x 0,063		K	K	K	
67 x 1,60	2 ⁵ / ₈ x 0,063	K*	K	K		

Tooth shapes: S = raker tooth, K = hook tooth

* Only available in special design PD (see page 22)

MARATHON M51

Features:

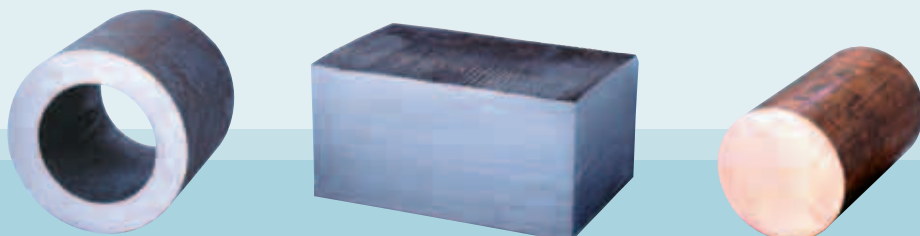
- Even in interrupted cuts austenitic steels and exotic alloys can be cut

- For rust- and acid-resistant steels of medium and large bundle and profile dimensions

- For nickel base alloys (such as Inconel, Hastelloy, Nimonic) of medium and large bundle and profile dimensions

- For titanium and special bronze

- For steels up to 50 HRC



WIKUS MARATHON M51

Item group 531

MARATHON M51 (approx. 69 HRC)

Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi) Standard set (SD)				
mm	Inches	0,75 - 1,25	1,4 - 2	2 - 3	3 - 4	4 - 6
27 x 0,90	1 ¹ / ₁₆ x 0,035				K	K
34 x 1,10	1 ³ / ₈ x 0,042			K	K	K
41 x 1,30	1 ⁵ / ₈ x 0,050		K	K	K	K
54 x 1,60	2 ¹ / ₈ x 0,063	K*	K	K	K	
67 x 1,60	2 ⁵ / ₈ x 0,063	K*	K	K		
80 x 1,60	3 ¹ / ₈ x 0,063	K*	K			

Tooth shape: K = hook tooth

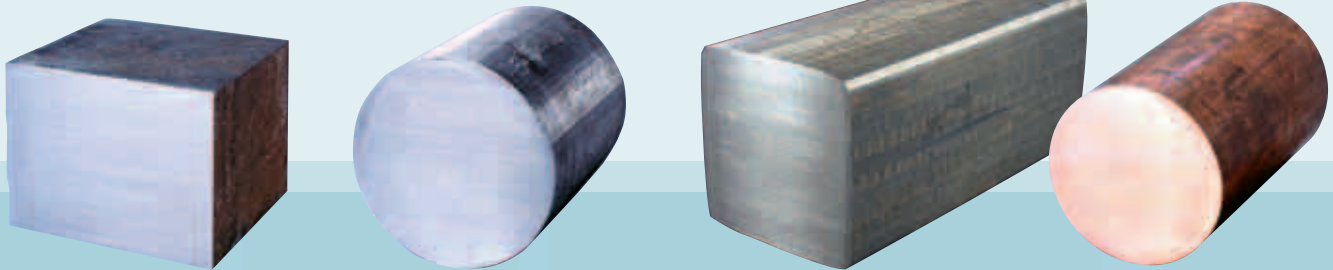
* Only available in special design PD (see page 22)

GIGANT M42 / M51

Features:

- New developed tooth shapes, especially for the following applications:
Tooth shape HV: brittle and annealed materials
Tooth shape VA: tough and long-chipping materials
- Clear cutting rate increase and optimal tool life with extreme large cross-sections

- For gigantic large work pieces
- For rust- and acid-resistant steels
- For steels with high tensile strength
- For nickel base alloys (such as Inconel, Hastelloy, Nimonic)



WIKUS GIGANT M42

Item group 532 GIGANT M42 (68-69 HRC)
Item group 533 GIGANT M51 (approx. 69 HRC)

Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi) Variable tooth pitch	
mm	Inches	0,75 - 1,25	1,4 - 2
54 x 1,30	2 ¹ / ₈ x 0,050		HV*, VA*
54 x 1,60	2 ¹ / ₈ x 0,063	HV, VA	HV, VA
67 x 1,60	2 ⁵ / ₈ x 0,063	HV, VA	HV, VA
80 x 1,60	3 ¹ / ₈ x 0,063	HV, VA	HV, VA

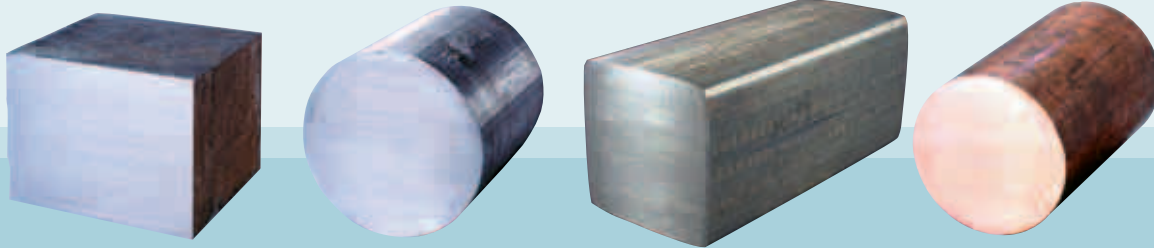
Tooth shape HV = annealed materials with high tensile strength
Tooth shape VA = stainless steels, tough and long-chipping materials
* Only available in M42

VECTOR M42 / M51

Features:

- New developed tooth shapes especially for the following applications:
Tooth shape HV: brittle and annealed materials
Tooth shape VA: tough and long-chipping materials
- Clear cutting rate increase and optimal tool life with large cross-sections

- For large work pieces
- For rust- and acid-resistant steels
- For steels with high tensile strength
- For nickel base alloys (such as Inconel, Hastelloy, Nimonic)



WIKUS VECTOR M42

Item group 534 VECTOR M42 (68-69 HRC)
Item group 539 VECTOR M51 (approx. 69 HRC)

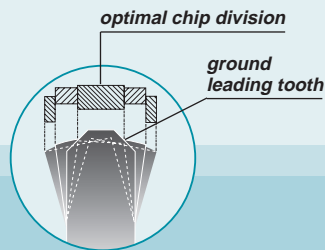
Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi) Variable tooth pitch	
mm	Inches	2 - 3	3 - 4
34 x 1,10	1 ³ / ₈ x 0,042	HV, VA	HV, VA
41 x 1,30	1 ⁵ / ₈ x 0,050	HV, VA	HV, VA
54 x 1,30	2 ¹ / ₈ x 0,050	HV*, VA*	HV*, VA*
54 x 1,60	2 ¹ / ₈ x 0,063	HV, VA	HV, VA

Tooth shape HV = annealed materials with high tensile strength
 Tooth shape VA = stainless steels, tough and long-chipping materials
 * Only available in M42

SELEKTA VT M42 / VT M51

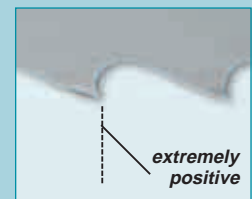
Features:

- High-performance band saw blade
- Extremely positive rake angle for optimal chip division
- Variable set sequence
- For long-chipping materials
- For rust- and acid-resistance steels
- For nickel base alloys
- For special bronze and copper
- For titanium alloys



WIKUS SELEKTA VT M51

Item group 536 SELEKTA VT M42 (68-69 HRC)
Item group 538 SELEKTA VT M51 (approx. 69 HRC)



Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi) Variable tooth pitch			
mm	Inches	0,75 - 1,25	1,4 - 2	2 - 3	3 - 4
27 x 0,90	1 ¹ / ₁₆ x 0,035				K
34 x 1,10	1 ³ / ₈ x 0,042			K	K
41 x 1,30	1 ⁵ / ₈ x 0,050		K	K	K
54 x 1,30	2 ¹ / ₈ x 0,050		K*	K*	
54 x 1,60	2 ¹ / ₈ x 0,063	K	K	K	K
67 x 1,60	2 ⁵ / ₈ x 0,063	K	K	K	
80 x 1,60	3 ¹ / ₈ x 0,063	K	K		

Tooth shape: K = hook tooth
* Only available in M42



Carbide band saw blades

Carbide tipped band saw blades

Specially ground tooth geometries with a tooth tip hardness of 1600 HV makes the WIKUS carbide range interesting for highest demands.

Sales units:

- coils of max. 50 m
- welded-to-length band saw blades

Band widths: 13 to 80 mm

Constant tooth pitches:

1,25 tpi to 4 tpi

Variable tooth pitches:

0,55-0,75 tpi to 3-4 tpi

Tooth shapes:

Raker tooth (S), hook tooth (K)

Unset tooth shapes:

Trapezoid tooth (T), tooth shape (TSN)

Item group 540

TCT (approx. 1600 HV)

Item group 541

DUROSET (approx. 1600 HV)

Item group 542

ECODUR (approx. 1600 HV)

Item group 545

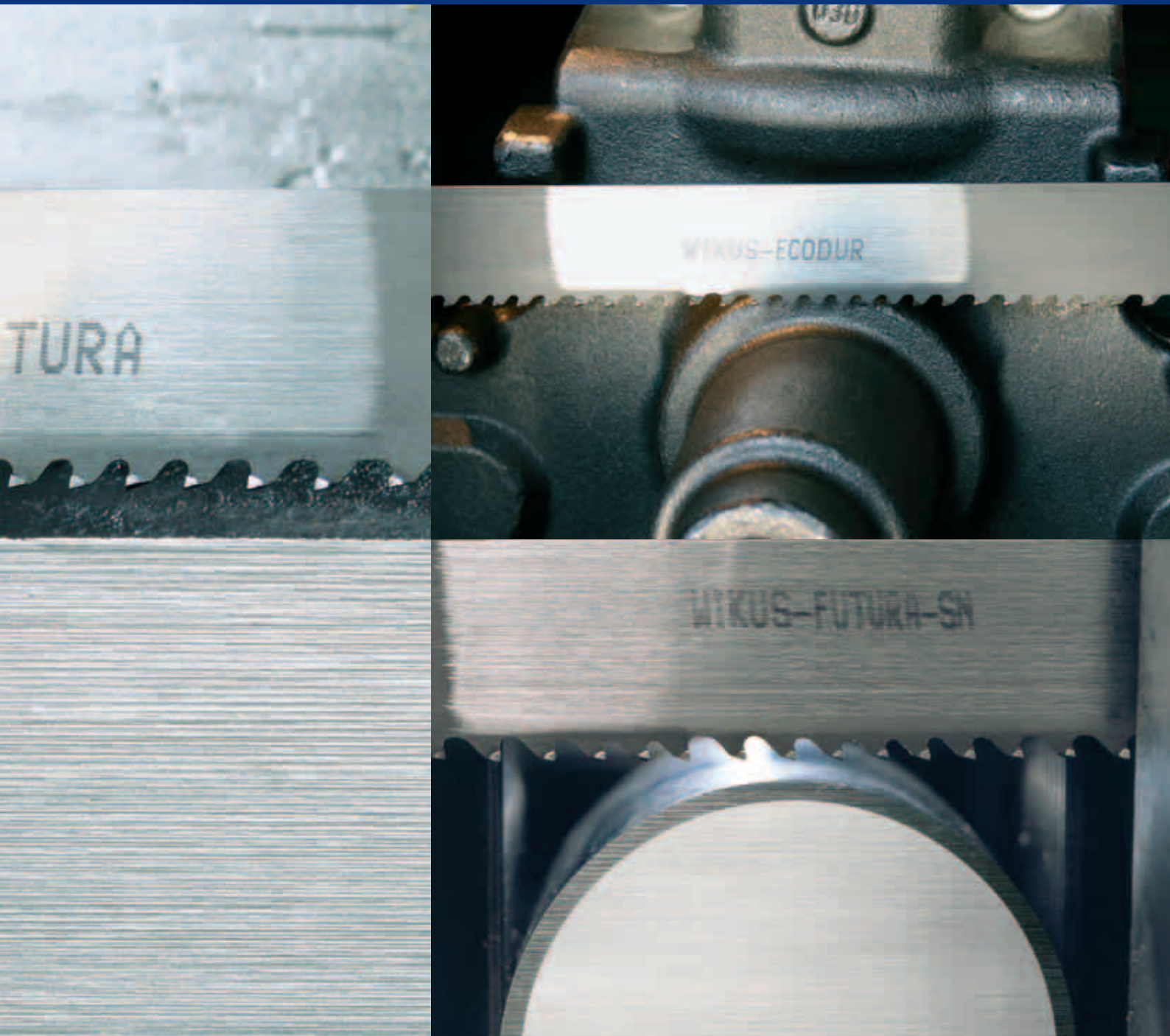
FUTURA (approx. 1600 HV)

Item group 546

FUTURA PLUS (approx. 1600 HV)

Item group 547

FUTURA SN (approx. 1700 HV)



Carbide coated band saw blades

For cutting hard materials of small dimensions the use of carbide coated band saw blades is particularly optimal.

Sales unit:
welded-to-length band saw blades

Band widths: 6 to 41 mm

Carbide coating:
constant (K)
intermittent (U)
in 8 to 14 mm pitch

Grit sizes:
TC181, TC301, TC356, TC525,
TC700

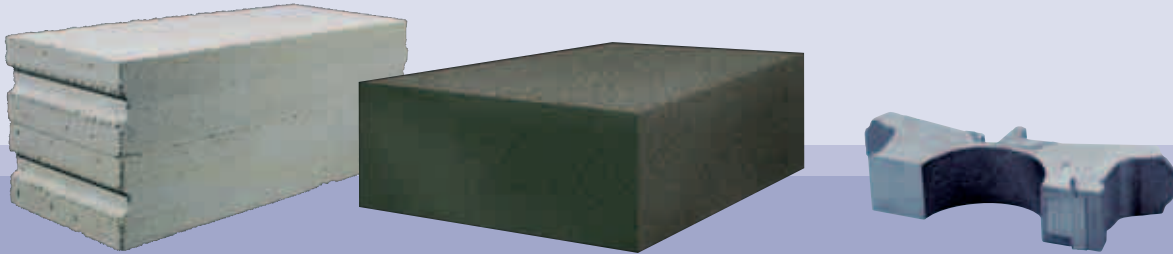
Item group 550
TCgrit K (approx. 1500 HV)

Item group 554
TCgrit U (approx. 1500 HV)

TCT

Features:

- Ideal tool for cutting abrasive materials
- Tooth tips made of particularly wear-resistant carbide
- For mineral building materials
- For graphite
- For sanded grey cast iron



WIKUS TCT

Item group 540
TCT (approx. 1600 HV)

Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi) Standard set (SD)			
mm	Inches	1,25	2	3	4
13 x 0,80	1/2 x 0,032				S-K
20 x 0,80	3/4 x 0,032			S-K	S-K
27 x 0,90	1 1/16 x 0,035		S-K	S-K	S-K
34 x 1,10	1 3/8 x 0,042	K	S-K	S-K	
41 x 1,30	1 5/8 x 0,050	K	K	S-K	

DUROSET

Features:

- Set carbide tipped band saw blade
 - Bevelled, straight leading tooth
 - Special division of the cutting channel
 - Carbide with high wear resistance and toughness
- For treating steels and non-ferrous metals
 - For universal use on all band sawing machines



WIKUS DUROSET

Item group 541
DUROSET (approx. 1600 HV)

Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi)	
mm	Inches	2	3
20 x 0,80	$\frac{3}{4}$ x 0,032		K
27 x 0,90	$1\frac{1}{16}$ x 0,035		K
34 x 1,10	$1\frac{3}{8}$ x 0,042	K	K
41 x 1,30	$1\frac{5}{8}$ x 0,050	K	

ECODUR

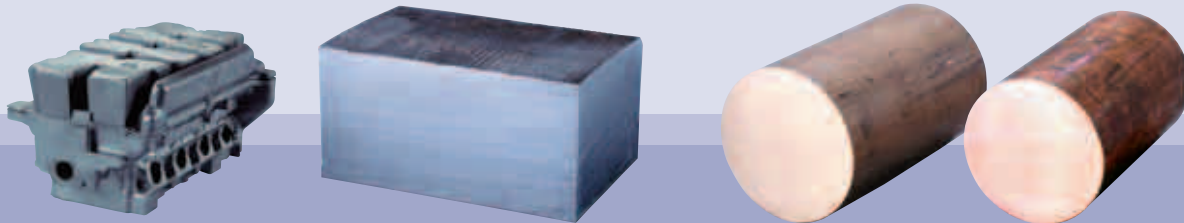
Features:

- Economic alternative to start using carbide

- For aluminium and other materials that tend to form built-up edges

- For cross-sections up to 600 mm

- For materials up to a hardness of 60 HRC



WIKUS ECODUR

Item group 542
ECODUR (approx. 1600 HV)



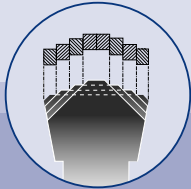
Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi)			
mm	Inches	0,85 - 1,15	1,4 - 2	2 - 3	3 - 4
20 x 0,80	³ / ₄ x 0,032				T
27 x 0,90	1 ¹ / ₁₆ x 0,035			T	T
34 x 1,10	1 ³ / ₈ x 0,042		T	T	T
41 x 1,30	1 ⁵ / ₈ x 0,050		T	T	T
54 x 1,30	2 ¹ / ₈ x 0,050		T	T	
54 x 1,60	2 ¹ / ₈ x 0,063	T	T	T	
67 x 1,60	2 ⁵ / ₈ x 0,063	T	T	T	
80 x 1,60	3 ¹ / ₈ x 0,063	T	T		

FUTURA

Features:

- Extreme running smoothness even with high cutting speeds / cutting rates
- With patented special grinding of the tooth edges, we were able to achieve a more favourable division of the cutting channel into 7 chip sections

- For increasing the cutting rate
- For zirconium and molybdenum
- For hardened steels up to max. 62 HRC
- For aluminium bronze and Ampco
- For titanium alloys



WIKUS FUTURA

Item group 545 FUTURA (approx. 1600 HV)



Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi)						
mm	Inches	0,55 - 0,75	0,85 - 1,15	1,4 - 2	2	2 - 3	3	3 - 4
20 x 0,80	$\frac{3}{4}$ x 0,032						T	T
27 x 0,90	$1\frac{1}{16}$ x 0,035						T	T
34 x 1,10	$1\frac{3}{8}$ x 0,042				T	T	T	T
41 x 1,30	$1\frac{5}{8}$ x 0,050			T	T	T	T	T
54 x 1,30	$2\frac{1}{8}$ x 0,050		T	T		T		
54 x 1,60	$2\frac{1}{8}$ x 0,063		T	T		T		
67 x 1,60	$2\frac{5}{8}$ x 0,063		T	T		T		
80 x 1,60	$3\frac{1}{8}$ x 0,063	T	T	T				

FUTURA PLUS

Features:

- Unique combination due to its sophisticated geometry: coarse cutting in the centre of the cutting channel as well as plain machining on both cutting surfaces
- Best surface finish

- For the best surface finish
- For sanded aluminium and magnesium cast



WIKUS FUTURA PLUS

Item group 546
 FUTURA PLUS (approx. 1600 HV)

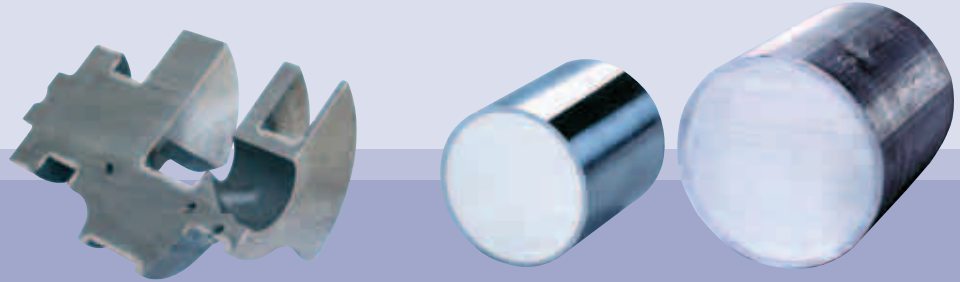
Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi)						
mm	Inches	0,55 - 0,75	0,85 - 1,15	1,4 - 2	2	2 - 3	3	3 - 4
20 x 0,80	³ / ₄ x 0,032						T	
27 x 0,90	1 ¹ / ₁₆ x 0,035						T	T
34 x 1,10	1 ³ / ₈ x 0,042			T	T	T	T	T
41 x 1,30	1 ⁵ / ₈ x 0,050			T	T	T	T	T
54 x 1,30	2 ¹ / ₈ x 0,050		T	T		T		
54 x 1,60	2 ¹ / ₈ x 0,063		T	T		T		
67 x 1,60	2 ⁵ / ₈ x 0,063		T	T				
80 x 1,60	3 ¹ / ₈ x 0,063	T	T					

FUTURA SN

Features:

- The tooth shape TSN, already tested and steadily improved over many years, is based on the proven tooth edge geometry of FUTURA. This gives incomparable stability to the precisely ground trapezoid teeth of FUTURA SN.
- FUTURA geometry with specially aligned rake angle

- For induction hardened and chrome coated shafts
- For hardened steel up to 62 HRC
- For hard manganese steel
- For hard-chrome plated work pieces
- For diameters up to 200 mm



WIKUS FUTURA SN

Item group 547
FUTURA SN (approx. 1700 HV)



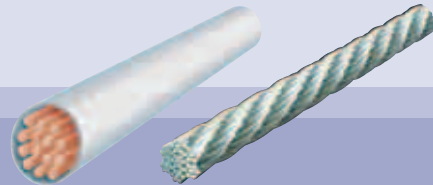
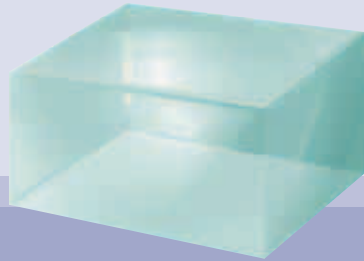
Dimensions Width x thickness		Tooth pitch Tz in teeth per inch (tpi)			
mm	Inches	2 - 3	3	3 - 4	4
20 x 0,80	$\frac{3}{4}$ x 0,032			TSN	TSN
27 x 0,90	$1\frac{1}{16}$ x 0,035			TSN	TSN
34 x 1,10	$1\frac{3}{8}$ x 0,042	TSN	TSN	TSN	TSN
41 x 1,30	$1\frac{5}{8}$ x 0,050	TSN	TSN	TSN	
54 x 1,30	$2\frac{1}{8}$ x 0,050	TSN			
54 x 1,60	$2\frac{1}{8}$ x 0,063	TSN			
67 x 1,60	$2\frac{5}{8}$ x 0,063	TSN			

TCgrit K

Features:

- Band saw blade with continuous carbide coating
- Especially for cutting work pieces of small dimensions

- For car tyres
- For ceramic plates
- For cables and wires
- For fibreglass



WIKUS TCgrit K

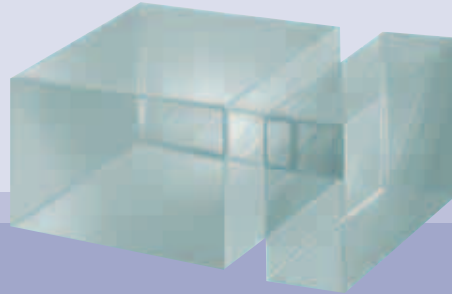
Item group 550
TCgrit K (approx. 1500 HV)

Dimensions Width x thickness		Grit sizes			
mm	Inches	TC 181	TC 301	TC 356	TC 525
6 x 0,50	1/4 x 0,020		K		
10 x 0,65	3/8 x 0,025		K		
13 x 0,50	1/2 x 0,020		K	K	
13 x 0,65	1/2 x 0,025	K	K		
20 x 0,80	3/4 x 0,032		K	K*	K
25 x 0,90	1 x 0,035	K*	K	K	K
32 x 0,90	1 1/4 x 0,035				K
32 x 1,10	1 1/4 x 0,042				K

TCgrit U

Features:

- Intermittent carbide coating
- Advantageous chip flow with work pieces of larger cross-sections
- For car tyres
- For fibreglass
- For high surface finish with large cross-sections



WIKUS TCgrit U

Item group 554
TCgrit U (approx. 1500 HV)



Dimensions Width x thickness		Grit sizes				Gap pitch T
mm	Inches	TC 301	TC 356	TC 525	TC 700	mm
6 x 0,50	1/4 x 0,020	U				8
10 x 0,65	3/8 x 0,025	U	U			12
13 x 0,50	1/2 x 0,020	U	U			12
13 x 0,65	1/2 x 0,025	U	U			12
20 x 0,80	3/4 x 0,032	U	U	U		12
25 x 0,90	1 x 0,035	U*	U	U		12
25 x 1,10	1 x 0,042		U*			12
32 x 0,90	1 1/4 x 0,035		U	U		14
32 x 1,10	1 1/4 x 0,042		U	U	U*	14
38 x 1,10	1 1/2 x 0,042			U	U	14
41 x 1,30	1 5/8 x 0,050			U		14

Coating: U = intermittent carbide coating, alternative dimensions on request

* Sizes will be discontinued



Diamond coated band saw blades

Because it is the hardest material, diamond is able to cut all materials and alloys.

Independent of the material we recommend a cutting speed of 1200 m/min or 20 m/sec. The special features of the backing material exclusively developed and patent-protected for WIKUS easily ensure the necessary fatigue strength.

Sales units:
welded-to-length band saw blades

Band widths: 10 to 100 mm

Diamond coating:
constant (K)
segmented (S)
intermittent (U)
in 6 to 30 mm pitch

Grit sizes:
D91, D126, D181, D252, D356,
D427, D601

Item group 570
DIAGRIT K (approx. 9000 HV)

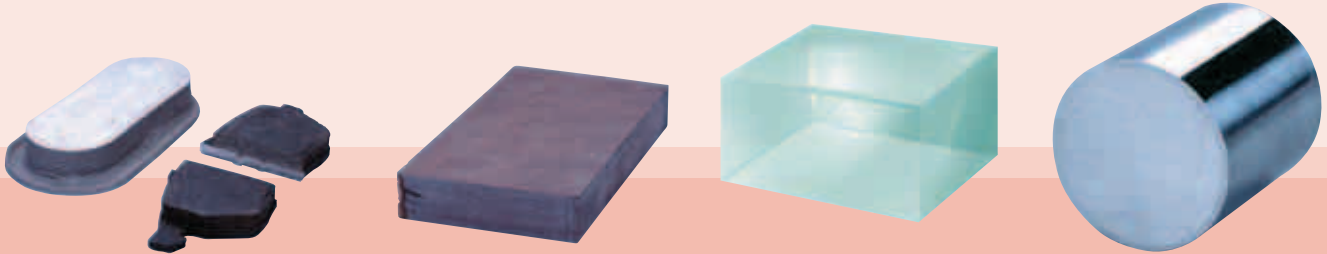
Item group 572
DIAGRIT S (approx. 9000 HV)

Item group 574
DIAGRIT U (approx. 9000 HV)

DIAGRIT K / DIAGRIT S

Features:

- Diamond coated band saw blades by WIKUS will surely cut every material
 - Continuous coating (K)
 - Segmented coating (S)
 - Backing material exclusively developed for WIKUS
- For aluminium with hard particle inclusions
 - For hardened and chromed steel shafts
 - For carbide
 - For brake pads
 - For glass
 - For GRP



WIKUS DIAGRIT K

WIKUS DIAGRIT S

Item group 570 DIAGRIT K (approx. 9000 HV)

Item group 572 DIAGRIT S (approx. 9000 HV)

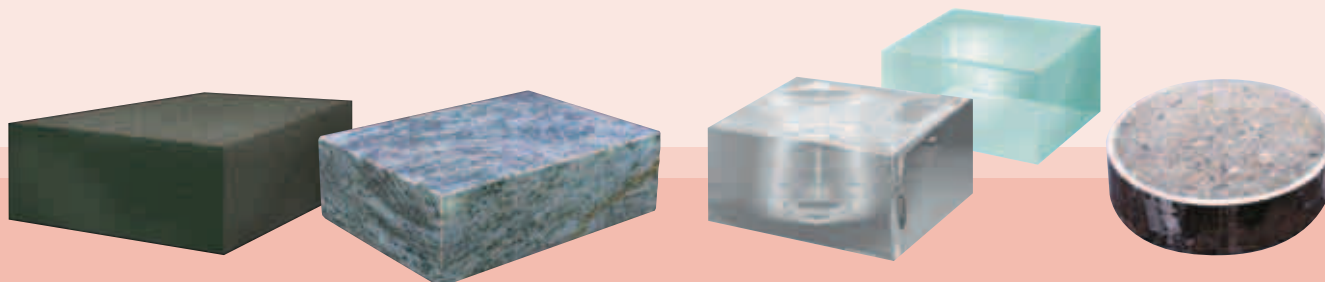
Width x thickness		Band dimension		Width x thickness	
mm	Inches	mm	Inches	mm	Inches
10 x 0,50	$\frac{3}{8} \times 0,020$	20 x 0,50	$\frac{3}{4} \times 0,020$	34 x 1,10	$1\frac{3}{8} \times 0,042$
10 x 0,65	$\frac{3}{8} \times 0,025$	20 x 0,80	$\frac{3}{4} \times 0,032$	38 x 0,70	$1\frac{1}{2} \times 0,028$
13 x 0,50	$\frac{1}{2} \times 0,020$	25 x 0,65	$1 \times 0,025$	40 x 0,50	$\frac{9}{16} \times 0,020$
13 x 0,65	$\frac{1}{2} \times 0,025$	27 x 0,50	$1\frac{1}{16} \times 0,020$	40 x 0,80	$\frac{9}{16} \times 0,032$
13 x 0,80	$\frac{1}{2} \times 0,032$	27 x 0,70	$1\frac{1}{16} \times 0,028$	41 x 1,30	$1\frac{5}{8} \times 0,050$
16 x 0,50	$\frac{5}{8} \times 0,020$	27 x 0,90	$1\frac{1}{16} \times 0,035$	50 x 0,90	$2 \times 0,035$
16 x 0,65	$\frac{5}{8} \times 0,025$	34 x 0,90	$1\frac{3}{8} \times 0,035$	54 x 1,10	$2\frac{1}{8} \times 0,042$

DIAGRIT U

Features:

- To be used with extremely hard work pieces and larger dimensions
- Intermittent coating
- Recommended cutting speed of 1200 m/min or 20 m/sec, independent of the material

- For aluminium with hard particle inclusions
- For high fired graphite
- For silicon mono and multi crystals
- For marble / granite
- For quartz



WIKUS DIAGRIT U

Item group 574

DIAGRIT U (approx. 9000 HV)

Width x thickness		Gap pitch T	Band dimension		Gap pitch T	Width x thickness		Gap pitch T
mm	Inches		mm	Inches		mm	Inches	
10 x 0,50	$\frac{3}{8} \times 0,020$	6	25 x 0,65	1 x 0,025	8	41 x 1,30	$1\frac{5}{8} \times 0,050$	20
10 x 0,65	$\frac{3}{8} \times 0,025$	6	27 x 0,50	$1\frac{1}{16} \times 0,020$	12	50 x 0,90	2 x 0,035	20
13 x 0,50	$\frac{1}{2} \times 0,020$	8	27 x 0,70	$1\frac{1}{16} \times 0,028$	12	54 x 1,10	$2\frac{1}{8} \times 0,042$	20
13 x 0,65	$\frac{1}{2} \times 0,025$	8	27 x 0,90	$1\frac{1}{16} \times 0,035$	12	54 x 1,60	$2\frac{1}{8} \times 0,063$	20
13 x 0,80	$\frac{1}{2} \times 0,032$	8	34 x 0,90	$1\frac{3}{8} \times 0,035$	20	67 x 1,60	$2\frac{5}{8} \times 0,063$	30
16 x 0,50	$\frac{5}{8} \times 0,020$	8	34 x 1,10	$1\frac{3}{8} \times 0,042$	20	80 x 1,10	$3\frac{1}{8} \times 0,042$	12
16 x 0,65	$\frac{5}{8} \times 0,025$	8	38 x 0,70	$1\frac{1}{2} \times 0,028$	20	100 x 1,10	4 x 0,042	12 / 30
20 x 0,50	$\frac{3}{4} \times 0,020$	8	40 x 0,50	$\frac{9}{16} \times 0,020$	20			
20 x 0,80	$\frac{3}{4} \times 0,032$	8	40 x 0,80	$\frac{9}{16} \times 0,032$	20			



Band saw blade dimensions and machine types

On the following pages you will find an overview of the most popular band sawing machines including the appropriate band saw blade dimensions for WIKUS blades.

The machine manufacturers are listed in alphabetical order. The machine types are sorted in ascending order according to the band dimension.

Band saw blade dimensions and machine types

Manufacturer Machine type	band dimension in mm length x width x thickness
AMADA	
H-250 SA, HA-250, HDA-250, HFA-250	3505 x 27 x 0,90
HA-250 W, HFA-250 W	3505 x 34 x 1,10
HA-250 II, HA-253	3505 x 34 x 1,10
CRH-300S, CAH-300S	3660 x 27 x 0,90
HK-400	3885 x 34 x 1,10
HFA-330	4115 x 34 x 1,10
HA-400, HFA-400	4570 x 34 x 1,10
HA-400 W, HFA-400 W	4570 x 41 x 1,30
H-450 H	4670 x 41 x 1,30
VM-1200, VM-2500	4670 x 41 x 1,30
CTB-400	4715 x 41 x 1,30
HFA-400 S, HFA-400 CNC	4995 x 41 x 1,30
HFA-400 LUL	4995 x 41 x 1,30
H-650 H, H-650 HD	5040 x 41 x 1,30
HA-500, HFA-500	5300 x 41 x 1,30
CTB-400 / 700 W	5630 x 41 x 1,30
HFA-500 S, HFA-500 CNC	5820 x 54 x 1,60
alternatively	5820 x 54 x 1,30
HBK-6050	5890 x 54 x 1,30
VM-3800	6430 x 54 x 1,60
HK-700 FR	6460 x 54 x 1,30
HK-800, HKA-800	6650 x 41 x 1,30
H-600, H-700	7600 x 54 x 1,60
HA-700, HFA-700	7600 x 54 x 1,60
H-900 HD	8000 x 54 x 1,60
HFA-700 II	8000 x 54 x 1,60
H-1080	8800 x 67 x 1,60
H-1080 / 1100 W	9700 x 80 x 1,60
HFA-1000	9700 x 80 x 1,60
H-1300	11880 x 67 x 1,60
H-1600	14425 x 80 x 1,60
H-2000	17600 x 125 x 2,00
BAUER	
200 G	2060 x 20 x 0,90
230 DG, 230 DGH	2830 x 27 x 0,90
MS 170 L, MS 170 G	
400 V, 400 VS, HVB 230	3000 x 20 x 0,90
230 G, 270 G, 270 GH, S 280 G, S 280 DG, HS 280 GZA, HS 280 GLZA	3000 x 27 x 0,90
VG 320, VG 320 ST	3400 x 27 x 0,90
S 260, S 260 G, HS 260 A, HS 260 ZA, S 320 G	3660 x 27 x 0,90
500 V, 500 VS, S 300 L, S 300 LG, S 320 GL, S 320 DG	3900 x 27 x 0,90
HS 320 ZA, HS 320 GLZA, S 350, S 350 G, SA 320 ST	3900 x 34 x 1,10
VG 450, VG 450 ST, VG 450 ZA, SA 320 ZA	4150 x 34 x 1,10
S 380, HS 380 A, VG 450 L, VG 450 L-ST, VG 450 L-ZA, S 380 G	4450 x 34 x 1,10
S 500, S 500 G, SA 400 ZA	5200 x 34 x 1,10
BEHRINGER	
SLB 230 G, SLB 230 DG, SLB 230 DG Semi automatic	2700 x 27 x 0,90
SLB 240 A, SLB 240 A/G, SLB 240 G-Semi automatic	3180 x 27 x 0,90
HBP 220, HBP 220 A	3720 x 27 x 0,90
alternatively	3720 x 34 x 1,10
HBP 260 A	4100 x 34 x 1,10
HBP 263 G, HBP 260/403 G, HBP 263, HBP 263 A, HBP 263 AG	4640 x 34 x 1,10
HBP 303, HBP 303 A	4640 x 41 x 1,30

Manufacturer Machine type	band dimension in mm length x width x thickness
HBP 320, HBP 320 A, HBP 340, HBP 340 A, HBP 340 G	4860 x 34 x 1,10
HBP 313 G, HBP 310/523 G, HBP 310/403 GA	5000 x 34 x 1,10
HBP 360, HBP 360 A, HBP 360 G	5400 x 41 x 1,30
LPS40-2, LPS40-3, LPS40-4, LPS 40 T	5400 x 41 x 1,30
HBP 340-700 G, HBP 400, HBP 400 A, HBP 413, HBP 413 A, HBP 420, HBP 420 A	5800 x 41 x 1,30
LPS40-6	5800 x 41 x 1,30
HBP 430, HBP 430 A, HBP 430 G	5800 x 54 x 1,30
LPS60-2, LPS40-3, LPS40-4	5800 x 54 x 1,30
HBBS65/40-2F3, HBBS65/40-2F4, HBBS65/40-2F6	6000 x 54 x 1,60
HBP 360/704 G	6300 x 41 x 1,30
HBM 370 A	6600 x 34 x 1,10
alternatively	6600 x 41 x 1,30
HBM 440 A	6600 x 34 x 1,10
alternatively	6700 x 54 x 1,30
HBP 500, HBP 500 A	6900 x 41 x 1,30
HBBS65/80-2F3, HBBS65/80-2F4, HBBS65/80-2F6	6900 x 67 x 1,60
HBM 540 A	7000 x 54 x 1,60
alternatively	7000 x 41 x 1,30
HBM 540 ALU	7000 x 34 x 1,10
HBP 430/854 G	7200 x 54 x 1,30
HBP 530, HBP 530 A, HBP 530/700 G	7200 x 54 x 1,60
HBBS110/60-3F3, HBBS110/60-3F4, HBBS110/60-3F6	7200 x 67 x 1,60
HBP 530/4S, HBP 530 A/4S, HBP 530/704 G, HBP 534 A 1000, HBP 530 A/4 HM	7300 x 54 x 1,60
HBBS110/100-3F3, HBBS110/100-3F4, HBBS110/100-3F6	7900 x 67 x 1,60
HBP 530/1104 G	8800 x 54 x 1,60
HBP 650, HBP 650 A, HBP 650/1050, HBP 650/1050 A, HBP 800, HBP 800 A, HBP 800/1050, HBP 800/1050 A	8800 x 67 x 1,60
HBP 650/850 A, HBP 800/850 A	
HBBS 160/80-3F3, HBBS 160/80-3F4, HBBS 160/80-3F6	9400 x 67 x 1,60
HBP 800/1204, HBP 800/1004, HBP 800/1004 G	10000 x 67 x 1,60
HBP 800/1304 G	10600 x 67 x 1,60
HBP 1080, HBP 1080A, HBP 1080T, HBP1300, HBP 1300A, HBP 1300 T	12300 x 80 x 1,60
HBP 1300	12300 x 80 x 1,60
HBP 1080/1700 A, HBP 1300/1700	13100 x 80 x 1,60
HBP 1080-1700, HBP 1080-1700 A, HBP 1080-1700 T, HBP1300-1700, HBP 1300-1700 T	13100 x 80 x 1,60
HBP 1300 Gantry	13360 x 80 x 1,60
HBP 1080/2100, HBP 1080/2100 A, HBP 1300/2100	13900 x 80 x 1,60
HBP 1800 Gantry	14150 x 80 x 1,60
HBP 1800 T	14300 x 80 x 1,60
BERG & SCHMID	
MBS 85	1335 x 13 x 0,65
TBS 102	1440 x 13 x 0,65

Manufacturer Machine type	band dimension in mm length x width x thickness
MBS 130/150 / TBS 150	1735 x 13 x 0,90
MBS 160	2000 x 20 x 0,90
MBS 170	2140 x 20 x 0,90
MBS 210, manually, AutoCut	2465 x 20 x 0,90
GBS 220 Basic, manually, AutoCut	2530 x 20 x 0,90
GBS 230 Eco, GBS 230 Super each manually, AutoCut, Semi automatic, Fully automatic	2765 x 27 x 0,90
GBS 280/305 AutoCut, Semi automatic, Fully automatic	3375 x 27 x 0,90
VGS 500 Semi automatic	4140 x 34 x 1,10
SBS 320 Fully automatic	4240 x 34 x 1,10
SBS 380 Fully automatic	4570 x 41 x 1,30
SBS 410 Fully automatic	4770 x 41 x 1,30
SBS 520 Fully automatic	5815 x 54 x 1,30
Futuro 410	6175 x 41 x 1,30

BIANCO

Minibianco	1325 x 13 x 0,65
170 M 45°	2000 x 20 x 0,90
200 M 60°	2450 x 20 x 0,90
250 M 45°	2450 x 27 x 0,90
270 M 60°	2450 x 27 x 0,90
270 M DS	2450 x 27 x 0,90
270 SA 60°	2450 x 27 x 0,90
280 M 60°	2450 x 27 x 0,90
280 M DS	2450 x 27 x 0,90
280 SA 60°	2450 x 27 x 0,90
330 M 60°	3010 x 27 x 0,90
330 SA 60	3010 x 27 x 0,90
330 A 60°	3010 x 27 x 0,90
350 M 45°	3010 x 27 x 0,90
350 M DS	3010 x 27 x 0,90
350 SA DS 45°	3010 x 27 x 0,90
350 SA 45°	3010 x 27 x 0,90
350 AF	3010 x 27 x 0,90
370 M 60°	3120 x 27 x 0,90
370 M DS	3120 x 27 x 0,90
370 M DS MS	3120 x 27 x 0,90
370 SA 60°	3120 x 27 x 0,90
370 SA DS	3120 x 27 x 0,90
370 SA DS MS	3120 x 27 x 0,90
370 AF	3120 x 27 x 0,90
370 A 60	3120 x 27 x 0,90
370 ADS CNC 1R	3120 x 27 x 0,90
400 SA 45	3120 x 27 x 0,90
420 M 60	3270 x 27 x 0,90
420 SA 60	3270 x 27 x 0,90
420 A 60 CNC	3270 x 27 x 0,90
350 HFA CNC	3980 x 34 x 1,10
51.31 SA DS	4750 x 34 x 1,10
51.31 SA 90	4750 x 34 x 1,10
450 HFA CNC	4880 x 41 x 1,30
31.41 SA DS	5200 x 34 x 1,10
61.41 SA 90	5200 x 34 x 1,10
61.41 A 60 DS CNC	5200 x 34 x 1,10
71.51 SA DS	5800 x 41 x 1,30
71.51 SA 90	5800 x 41 x 1,30
520 HFA CNC	5800 x 41 x 1,30

BTM

30.15B CNC- 60°/60° Dx/Sx	3750 x 27 x 0,90
30.15B CNC - 60°/60° Dx/Sx	3750 x 27 x 0,90
Flash 300 CNC/60°	3850 x 27 x 0,90
46.32 CNC 90°	4750 x 34 x 1,10
46.32 CNC 90°	4750 x 34 x 1,10

Manufacturer Machine type	band dimension in mm length x width x thickness
46.32B SA/60°	4750 x 34 x 1,10
46.32B SA/60°/60° Dx-Sx	4750 x 34 x 1,10
46.32B CNC /60°	4750 x 34 x 1,10
46.32B CNC 60°	4750 x 34 x 1,10
46.32B CNC 90°/60°Sx	4750 x 34 x 1,10
50.45 SA 90°	5300 x 34 x 1,10
320 CNC 90° PA	5300 x 34 x 1,10
410 CNC 90° PA	5300 x 34 x 1,10
50.32 SA 45/60° Dx/Sx	5300 x 34 x 1,10
60.40/I CNC-60°/60° DX/Sx	5700 x 34 x 1,10
60.40/I CNC- 60°/60°Dx/Sx	5700 x 34 x 1,10
60.40/I SA 60°/60° Dx-Sx	6340 x 34 x 1,10
70.50/I CNC 60°/60° Dx/Sx	6500 x 41 x 1,30
460 CNC 90° PA	6570 x 34 x 1,10
70.50/I SA 60°/60° Dx-Sx	6870 x 41 x 1,30
610 CNC 90° PA	6880 x 41 x 1,30
610 SA 90°	6880 x 41 x 1,30
100.60 SA 90°	7070 x 41 x 1,30
100.60 SA 45/60° Dx/Sx	7070 x 41 x 1,30
560CNC 90° PA	8020 x 54 x 1,60
560 SA 90°	8020 x 54 x 1,60
800x600 SA 90°	8020 x 54 x 1,60
800x600 CNC .PA	8700 x 54 x 1,60
800x600 SA 90°	8700 x 54 x 1,60
800x600 CNC /I.PA	8700 x 54 x 1,60
720 SA 90°.PA	9360 x 67 x 1,60
720 SA 90°/ I.PA	9360 x 67 x 1,60
720 CNC 90°.PA	9360 x 67 x 1,60
120.70 /I SA 60°/60° Dx-Sx	9500 x 54 x 1,60
120.70 CNC Dx/Sx 60°/60°	9500 x 54 x 1,60
860 SA 90°/ I.PA	10100 x 67 x 1,60
860 CNC 90°/I.PA	10100 x 67 x 1,60
700x700 CNC/I.PA	10500 x 54 x 1,60
1000 CNC 90°/I.PA	12500 x 80 x 1,60
1000 SA 90°/I.PA	14400 x 80 x 1,60

CARIF

260 BM	2450 x 27 x 0,90
260 BSA	2450 x 27 x 0,90
260 BA	2450 x 27 x 0,90
320 BSA	3025 x 27 x 0,90
320 BA	3025 x 27 x 0,90
450 BSA	3660 x 34 x 1,10
450 BA	3660 x 34 x 1,10

COSEN

MH-812 LC, MHV-180 AE	2720 x 27 x 0,90
AH-1010 Jay, MH/SH-1016 JA, MH-916 JRP, MH-916 JK, MH-1016 KAM; SH-1016 JYM	3350 x 27 x 0,90
AH-250 H, C-250 NC	3505 x 27 x 0,90
NC-250 H	3505 x 34 x 1,10
AH-300 H, C-300 NC	3660 x 34 x 1,10
NC-300 H	3820 x 34 x 1,10
AH-360C, SH-360 C	4115 x 34 x 1,10
MH-330 ER, SH 330 ER	4150 x 27 x 0,90
AH-320 H, C-320 NC	4242 x 34 x 1,10
C-4038 NC, AH-400 H, C-400 NC, NC-400 H	4570 x 41 x 1,30
SV-510DM	4570 x 34 x 1,10
C-460 NC	4670 x 41 x 1,30
SH-650M, C-650MNC	5300 x 34 x 1,10
SH-2028 M, SH-2028 F	5450 x 41 x 1,30
SV-4060	5588 x 54 x 1,60
C-5040 NC, C-7652 NC, SH-6550, NC-7652 H	5815 x 54 x 1,30

Band saw blade dimensions and machine types

Manufacturer Machine type	band dimension in mm length x width x thickness	Manufacturer Machine type	band dimension in mm length x width x thickness
C-520/560 NC, SH-7550	6040 x 54 x 1,30	CP-100.80	9190 x 67 x 1,60
	alternatively 6040 x 54 x 1,60	VT-60/150 (A)	9260 x 54 x 1,60
SV-20130	6200 x 41 x 1,30	VL-110/110	9260 x 80 x 1,60
SH-800DM, C-800DMNC	6600 x 54 x 1,30	CPI-120.50 DI	9330 x 54 x 1,30
C-7656NC	6666 x 54 x 1,60	VLR-110/110 A	9420 x 54 x 1,30
C-620NC	7200 x 54 x 1,60	VL-40/250 (A)	9620 x 41 x 1,30
SH-2640 DM	7800 x 54 x 1,60	VL-70/200 (A)	9760 x 54 x 1,60
SV-60110	7440 x 67 x 1,60	VT-60/200 (A)	9870 x 54 x 1,60
SH-800 P, C-800 NC	7800 x 67 x 1,60	CP-1000 T	10415 x 67 x 1,60
SH-1311 P	11000 x 80 x 1,60	CP-1000 T	10415 x 80 x 1,60
SH-1300 S	11880 x 80 x 1,60	VT-60/250 (A)	10480 x 54 x 1,60
SH-1313	12300 x 80 x 1,60	VL-70/250 (A)	10820 x 54 x 1,60
SH-1713	13000 x 80 x 1,60	VL-70.250	10820 x 54 x 1,60
SH-2020	15980 x 100 x 1,60	CP-1100 A	11100 x 67 x 1,60
		VLTA-60/250	11140 x 41 x 1,30
DAITO		VLTA-60.250.8	11140 x 41 x 1,30
GA 260, GAll 260, S 260,		CP-12.11, CP-12.11 T	11300 x 67 x 1,60
LTA 2630, LT 2630	3505 x 27 x 0,90	CP-13.11, CP-13.11 T	11500 x 80 x 1,60
GA 260 W, GAll 260 W	3505 x 34 x 1,10	CP-15.12	12415 x 80 x 1,60
GA 330, GAll 330, S 360 B, ST 3540	4120 x 34 x 1,10	CP-15.12	12416 x 80 x 1,60
GA 330 W, GAll 330 W	4120 x 41 x 1,30	G-12.11 HV	12600 x 80 x 1,60
GA 410, GAll 410	4570 x 34 x 1,10	G-15.15 HV	14470 x 80 x 1,60
GA 410 W, GAll 410 W	4570 x 41 x 1,30	G-20.15 HV	15470 x 80 x 1,60
S 4560, ST 4565, STII 4565	5040 x 41 x 1,30	G-20.20 HV	17040 x 80 x 1,60
GA 5070, S 5570, ST 5070	5450 x 41 x 1,30		
STII 5080	5890 x 41 x 1,30	DELTA	
GA 660	6705 x 54 x 1,60	MOD-280	2460 x 27 x 0,90
GT 5080 CNC	6860 x 41 x 1,30	SFA-320 R	3010 x 27 x 0,90
GA 6090, S 6090, ST 6090	7600 x 54 x 1,60	SFA-300, SFA-320	3820 x 34 x 1,10
GA 8010, ST 8010	8300 x 54 x 1,60	HFA-350	3980 x 34 x 1,10
V 2120, V 6020, GT 6510,		V-3015, V-3024	4560 x 41 x 1,30
GTA 6510, GT 7010 CNC	8800 x 54 x 1,60	HFA-380	4570 x 34 x 1,10
S 1011	8840 x 67 x 1,60	V-500	4670 x 41 x 1,30
ST 8013	9350 x 67 x 1,60	HFA-450, SFA-450	4880 x 41 x 1,30
ST 8015	10670 x 67 x 1,60	HFA-520	5800 x 41 x 1,30
V 7530	11000 x 54 x 1,60	HFA-600, HFT-7302	6800 x 54 x 1,60
		HFA-750	7600 x 54 x 1,60
DANOBAT		HFA-1070	8200 x 54 x 1,60
CR-260, CR-260 I,		HFA-1000	9500 x 67 x 1,60
CR-260 A, CR-260 AI	4090 x 27 x 0,90	HFT-1310	11000 x 67 x 1,60
CR-260 AL	4520 x 27 x 0,90	HFA-1311	11880 x 80 x 1,60
CR-260 F, CR-260 AF	4520 x 34 x 1,10	V-1300	11880 x 80 x 1,60
CR-330, CR-330 A,		HFA-1370	13000 x 80 x 1,60
CR-330 AI, CR-330I	4970 x 34 x 1,10		
CR-330 AL	4970 x 27 x 0,90	DOALL	
VP-50.50.100, VP-50.50.210	5265 x 41 x 1,30	CJ-260	3505 x 34 x 1,10
CPS-440 A, CPS-440 AI, CP 420 N		C-10, C-10 M, C-41, C-41 A, C-55, C-56,	
CP-420 AN, CPI-54.40 DI	5920 x 41 x 1,30	C-57, C-58, C-67, C-68, C-69, C-70,	
CPS-440 AL, CP-420 ALN	5920 x 34 x 1,10	C-79, C-80, C-81, C-82, C-8015,	
VPL(A)-50/70	6040 x 41 x 1,30	C-167, C-169, C-170, C-179, C-180,	
CPA 350ADU	6300 x 41 x 1,30	C-270, C-280	3660 x 27 x 0,90
VT-30/60 (A)	6420 x 54 x 1,30	C-1213 M/A	3660 x 27 x 0,90
CP-520 I, CP-520 AI, CPI-70.50 DI	6585 x 41 x 1,30		alternatively 3660 x 34 x 1,10
VL-40/110 (A)	6800 x 54 x 1,30	CJ-1213, C-305 M/A/NC	3660 x 34 x 1,10
VT-40/100 (A)	7240 x 54 x 1,30	C-912 M/A	3735 x 27 x 0,90
CPI-100.50 DI	7545 x 54 x 1,30	C-1212 M/A	4010 x 27 x 0,90
CP-520 AF	7690 x 54 x 1,60		alternatively 4010 x 34 x 1,10
VL 70/110 (A)	7930 x 54 x 1,60	C-916 M/S/A, MCS 275	4010 x 27 x 0,90
CP-650, CP-650 A	8015 x 67 x 1,60	C-7, C-8, C-9, C-9 A	4050 x 27 x 0,90
VLAT 60/150	8420 x 54 x 1,60	HC-35, HC-35 A	4064 x 27 x 0,90
VL-40/200 (A)	8540 x 41 x 1,30	C-3300 NC	4090 x 34 x 1,10
CP-100.65, CP 800 A	8700 x 67 x 1,60	CJ-1216	4100 x 34 x 1,10
VL-150/90	8740 x 80 x 1,60	C-916 SA/DS	4318 x 27 x 0,90
VLR 50/110 A	8840 x 41 x 1,30	TF-14/H/HA	4370 x 27 x 0,90
CPI-100.70 DI	8930 x 54 x 1,60	C-330 M/NC	4450 x 34 x 1,10
VLTA-30/200	9170 x 54 x 1,30	TF-20	4572 x 34 x 1,10

Manufacturer Machine type	band dimension in mm length x width x thickness
C-4100 M/A/NC/CNC, CJ-410 M/A/NC, CJ-1220 A/NC	4720 x 41 x 1,30
TF-2021	4875 x 34 x 1,10
MCS-375	5000 x 34 x 1,10
TF-24	5230 x 34 x 1,10
TF-36	5230 x 41 x 1,30
TF-25	5285 x 41 x 1,30
TF-2025 M/NC	5309 x 34 x 1,10
TF-2525	5321 x 41 x 1,30
C-430 M/NC	5450 x 41 x 1,30
C-520 M/NC, C-530 M/NC	6400 x 54 x 1,30
	alternatively 6400 x 54 x 1,60
C-650 M/NC	7620 x 54 x 1,60
C-3232	7722 x 67 x 1,60
C-1000 x 500 S	8200 x 54 x 1,60
C-650 S/SNC	8300 x 54 x 1,60
C-670 M/NC	8450 x 54 x 1,60
C-820 M/NC	9150 x 67 x 1,60
C-1020 M/NC	9700 x 67 x 1,60
C-4048	9805 x 67 x 1,60
C-1350	13600 x 80 x 1,60
EISELE	
HBT 240	2835 x 27 x 0,90
HB 280 N, HB 280 S, HB 360 S, HB 360 SE	4020 x 27 x 0,90
HBG 325	4020 x 34 x 1,10
HB 450 N, HB 450 S, HB 620 N, HB 620 S	5620 x 34 x 1,10
EVERISING	
S-250 HA, SA	3505 x 27 x 0,90
S-260 HA	3660 x 27 x 0,90
S-12T.A., AA, S-300 HA	3820 x 27 x 0,90
H-260 HA, S-330 HA	3820 x 27 x 0,90
S-300 HB, S-300 SA, S-330 HB	3820 x 34 x 1,10
H-260 HB	3930 x 34 x 1,10
S-4633 M	4115 x 27 x 0,90
S-300 HC, S-330 HC	4115 x 34 x 1,10
H-360 HA, H-360 SA	4420 x 34 x 1,10
S-400 HA, S-400 SA	4570 x 34 x 1,10
S-460 HA, HB, SA	4670 x 41 x 1,30
VB0405-12, (15), (25)	4670 x 41 x 1,30
H-5550, H-5550 FII	4880 x 41 x 1,30
VBS 0505-20	4880 x 41 x 1,30
VB0405-25 (long)	4880 x 54 x 1,60
H-320A	4900 x 34 x 1,10
HA-4033 NC	5060 x 34 x 1,10
H-7050, H-460 HA, NC-460 HA	5450 x 41 x 1,30
H-550 HA	5800 x 41 x 1,30
VBS 0407-30, (45), (60)	6000 x 41 x 1,30
HA-5545 NC	6430 x 41 x 1,30
HK-700	6460 x 54 x 1,30
H-560 HA	6600 x 54 x 1,60
VB-070715, VB-070725	6800 x 54 x 1,60
VBS-0707	6800 x 54 x 1,60
H-7056, VBS0707-60, (25)	6800 x 54 x 1,60
HW 350/700	7000 x 41 x 1,30
VBS 0710-45, (60)	7140 x 54 x 1,60
HA 7056	7400 x 54 x 1,60
HA-7056 NC	7430 x 54 x 1,60
V0615	7500 x 41 x 1,30
H-8070, H-650 HA	7600 x 54 x 1,60
VBS0615	7890 x 41 x 1,30
H-700 HA, H-700II	8000 x 54 x 1,60
H-1060	8300 x 54 x 1,60

Manufacturer Machine type	band dimension in mm length x width x thickness
HFA-700 CII, H-8276	8300 x 67 x 1,60
VBS 1013-45, (60)	8800 x 67 x 1,60
H-1010	8800 x 67 x 1,60
HW 500/1000	8840 x 54 x 1,60
VBS0415-35, VBS0425	9610 x 41 x 1,30
HW 650/1300	9755 x 67 x 1,60
V0625	9900 x 41 x 1,30
VBS 1316-45, (60)	10000 x 80 x 1,60
H-1000 II	11100 x 80 x 1,60
H-1300	12300 x 80 x 1,60
HW 800/1600	12400 x 67 x 1,60
H-1613	13000 x 80 x 1,60
H-1816	15000 x 80 x 1,60
H-2110	16500 x 80 x 1,60
FMB	
MINOR	1470 x 13 x 0,65
140	2020 x 20 x 0,90
150 DS	2400 x 20 x 0,90
	alternatively 2400 x 27 x 0,90
PHOENIX	
170, 200 A, 200 D, 200 DS	
240 D, 240 DP, 240 SA	
250 D, 250 DP, 250 SA, 250 SA Piping	
PULSAR	2450 x 27 x 0,90
TRITON, ANTLIA, ANTARES, ORION	
URANUS, CENTAURO, SIRIUS	
CYGNUS, CALIPSO, OMEGA	2700 x 27 x 0,90
MAJOR, ZEUS, JUPITER, TITAN	
300 SAV, 240 AV, 240 AVD, 300 D	3180 x 27 x 0,90
GALACTIC, 400 SAV	3420 x 27 x 0,90
COPERNICO	3470 x 3-20 x 0,65-0,90
HERCULES, PEGASUS	4120 x 34 x 1,10
APOLLO	4140 x 34 x 1,10
SCORPIO	4250 x 34 x 1,10
POLARIS	4300 x 34 x 1,10
POLARIS (from 1999)	4500 x 34 x 1,10
1200 SAV	4900 x 27 x 0,90
ATLANTA	4900 x 41 x 1,30
PLUTON 1	4980 x 27 x 0,90
PLUTON 2	5020 x 34 x 1,10
OLIMPUS 1, OLIMPUS 2, OLIMPUS 3	5450 x 41 x 1,30
PLUTON (from 1999)	5600 x 34 x 1,10
<i>Bold printed band saws are currently produced</i>	
FORTE	
Piccolo (only replacement)	1215 x 13 x 0,65
F 200/S (only replacement)	2740 x 20 x 0,90
F 250	3660 x 27 x 0,90
Fortemat BA 321/SIP, BA 321/SIP-CNC (only replacement)	3660 x 34 x 1,10
Fortemat SBA 241/S, SBA 241/S/M-CNC	4100 x 34 x 1,10
Uniforte 500 (only replacement)	4300 x 34 x 1,10
F 320/SI-GBS (only replacement)	4350 x 34 x 1,10
F 360/S (Only replacement)	4870 x 27 x 0,90
F 420/SI, Fortemat SBA 341/S (o.replacem.)	4870 x 34 x 1,10
Fortemat SBA 361/S, SBA 361/S-CNC	4870 x 41 x 1,30
Fortemat SBA 421/S, SBA 421/S-CNC	6050 x 41 x 1,30
Fortemat SBA 531/S, SBA 531/S-CNC	6270 x 54 x 1,60
Fortemat SBA 681/S, SBA 681/S-CNC	7400 x 54 x 1,60
Fortemat SBS 801/S (only replacement)	9000 x 67 x 1,60
Fortemat SBS 1001/S (only replacement)	10270 x 67 x 1,60

Band saw blade dimensions and machine types

Manufacturer Machine type	band dimension in mm length x width x thickness
FRIGGI	
1 MF 320	4550 x 41 x 1,30
FP 280 ACN	4650 x 34 x 1,10
AST 650 x 400	5500 x 34 x 1,10
1 MF 420	5550 x 41 x 1,30
2 MF 520 N ACN	6750 x 54 x 1,30
AST 1200 x 400	6890 x 34 x 1,10
VAS H 4000 x 650 x 900	6900 x 54 x 1,60
alternatively	6900 x 67 x 1,60
VAS H 2500 x 650 x 900	6920 x 54 x 1,60
2 MF 520	7260 x 54 x 1,60
VAS H 3000 x 1000 x 900	7900 x 54 x 1,60
alternatively	7900 x 67 x 1,60
VTS 3000, VTS 4000	8270 x 41 x 1,30
ONL 560 x 600 ACN	8470 x 54 x 1,60
2 MF 650	8530 x 54 x 1,60
2 MF 650	8530 x 54 x 1,60
AST 1500 x 600	8550 x 41 x 1,30
AST 1500 x 600	8600 x 54 x 1,60
ONL 660 x 700 ACN	8660 x 41 x 1,30
VAS H 3000 x 1500 x 900	9080 x 54 x 1,60
alternatively	9080 x 67 x 1,60
2 MF 800	9820 x 67 x 1,60
AST 2500 x 400	10500 x 41 x 1,30
2 MF 1000	11550 x 67 x 1,60
2 MF 1000 F ACN	11900 x 67 x 1,60
2 MF 1500	13500 x 80 x 1,60
2 MF GANTRY 1500 x 1500	14000 x 80 x 1,60
2 MF GANTRY 1500 x 2000	14500 x 80 x 1,60
2 MF GANTRY 2000 x 2000	15600 x 80 x 1,60
2 MF GANTRY 2500 x 2500	17600 x 80 x 1,60
HEM	
Sidewinder	3450 x 27 x 0,90
CT2000 HA-DC	3640 x 34 x 1,10
V100 LM-3	3810 x 34 x 1,10
V100 LA-3	3810 x 34 x 1,10
H101 A-2	3810 x 34 x 1,10
H90 A, H100 M, H100 A	3910 x 27 x 0,90
VT120 HM, VT120 HA	4090 x 34 x 1,10
VT125 HA-1 Smart	4090 x 34 x 1,10
V100 LM-2, V100 LA-2	4340 x 34 x 1,10
H101 A-1	4420 x 34 x 1,10
V130 HM, V130 HA	4470 x 41 x 1,30
TWISTER, H105 M, H105 A	4570 x 34 x 1,10
H105 LM, H105 LA, H120 LM, H120 LA	4770 x 34 x 1,10
VT130 HM, VT130 HA	4830 x 41 x 1,30
VT150 A Smart	4830 x 41 x 1,30
V120 HM, V120 HA, V125 HA-1 Smart	4880 x 34 x 1,10
FP120 HM, FP120 HA	5180 x 34 x 1,10
H 130 HM-1, H130 HA-1	5180 x 41 x 1,30
WF130 HA-DC	5330 x 41 x 1,30
V150 M, V150 A, V150 A Smart	5640 x 41 x 1,30
H130 HM-DC, H130 HA-DC	5790 x 41 x 1,30
PM25-96, PM25-120, PM25-144	6040 x 41 x 1,30
alternatively	6040 x 54 x 1,30
V200 A Smart	6710 x 54 x 1,30
H160 M-DC, H160 A-DC,	
V200 M, V200 A	6710 x 54 x 1,60
F130 HM-DC, F130 HA-DC	6760 x 41 x 1,30
WF160 LA-DC	6830 x 54 x 1,60
H160 LM-DC, H160 LA-DC	7010 x 54 x 1,60
WF140 HM-DC	7260 x 54 x 1,60
H160 XL-DC, H160 XLA-DC	7310 x 54 x 1,60
H3236 M-DC, H3236 A-DC	8230 x 54 x 1,60
WF190 M-DC, WF-190 A-DC	8690 x 54 x 1,60

Manufacturer Machine type	band dimension in mm length x width x thickness
WF190 LM-DC, WF190 LA-DC	
WF190 XLM-DC	8840 x 54 x 1,60
WF190 XLM-DC	9140 x 54 x 1,60
HESKA	
HES-250 DGH	2750 x 27 x 0,90
HES-250 DGH - starting with feb. 2001 of man.	2800 x 27 x 0,90
HES-260	3660 x 27 x 0,90
HES-320	3660 x 27 x 0,90
HES-260 HL	3660 x 27 x 0,90
HYD MECH	
S-10, V-14, V-14 A, V-14 P	3660 x 27 x 0,90
S-20, S-20 P, S-20 A	4115 x 27 x 0,90
H-10 A	4115 x 27 x 0,90
H-12 A, H-12 P	4115 x 34 x 1,10
V-18, V-18 A, V-18 P, V-18 APC	4546 x 34 x 1,10
H-14 A	4674 x 34 x 1,10
S-23, S-23 P, S-23 A	4724 x 34 x 1,10
VW-18	4876 x 27 x 0,90
V-18 Extended Head	5030 x 34 x 1,10
M-16 A, M-16 P	5639 x 34 x 1,10
H-16 A, H-16 P	5740 x 41 x 1,30
H-18 A	5842 x 41 x 1,30
alternatively	5842 x 34 x 1,10
M-20 A, M-20 P	6248 x 41 x 1,30
H-20 A, H-20 P	6760 x 54 x 1,30
alternatively	6760 x 54 x 1,60
H-22 A	6858 x 54 x 1,60
V-30	7370 x 41 x 1,30
alternatively	7370 x 54 x 1,30
alternatively	7370 x 54 x 1,60
H-26 A, H-26 P	7620 x 54 x 1,60
H-28 A	7620 x 54 x 1,60
S-35 P	9040 x 54 x 1,60
H-32 A, H-32 P	9246 x 67 x 1,60
H-26 /42	10058 x 54 x 1,60
alternatively	10058 x 67 x 1,60
H 40/40	11300 x 67 x 1,60
H 40/60	12293 x 80 x 1,60
H 40/80	13360 x 80 x 1,60
INDORE	
210 DC	3760 x 27 x 0,90
220 DCTV/DCA	3760 x 27 x 0,90
300 DCTV/DCA/DCNC	4100 x 34 x 1,10
200 VTR VERTICAL	4860 x 34 x 1,10
340 DCTV/DCA	4860 x 41 x 1,30
420 DCTV/DCA	5800 x 41 x 1,30
460 DCTV/DCA/DCNC	5800 x 41 x 1,30
300 V3 VERTICAL	6300 x 41 x 1,30
530 DCTV/DCTA	6900 x 54 x 1,60
650 DCTV/DCTA	8000 x 67 x 1,60
800 DCTV/DCTA	8800 x 67 x 1,60
6024 DCTV	9700 x 80 x 1,60
1000 DCTV	12300 x 67 x 1,60
1000 DCTA	12300 x 80 x 1,60
1250 x 1500 DCTV/DCTA	13300 x 80 x 1,60
1500 x 1500 DCTV	16080 x 80 x 1,60
JAESPA	
W 150 G	2000 x 20 x 0,90
W 160 G	2300 x 20 x 0,90
W 180 DG	2450 x 20 x 0,90
W 220 DG/DGH/DGA	2940 x 27 x 0,90
Concept 240 GT/GTH/GTA	2940 x 27 x 0,90
Concept 260 GT/GTH	3340 x 27 x 0,90

Manufacturer Machine type	band dimension in mm length x width x thickness
Classic 302 DGH (formerly V 302 DGH)	3660 x 27 x 0,90
W 260 DG/DGH, W 260 M, W 320,	3660 x 27 x 0,90
W 270 A	3900 x 27 x 0,90
W 270 A 34mm blade	3900 x 34 x 1,10
W 320 G, W 320 GH	4120 x 27 x 0,90
W 320 G, W 320 GH 34mm b. W 320 GA	4120 x 34 x 1,10
V 325 DGH/DGHS	
V 380 DG/DGH	4250 x 34 x 1,10
Classic 420 DGH	4490 x 34 x 1,10
W 400 A, W 400 HA	4570 x 34 x 1,10
W 280 / 320 AZ	4570 x 34 x 1,10
W 322 AZP	4820 x 34 x 1,10
Classic 500 DGH/DGA (formerly V 500 DGH/DGA)	4870 x 34 x 1,10
W 340 AZP	5100 x 34 x 1,10
W 402 AZP	5100 x 41 x 1,30
W 323 AZP	5300 x 34 x 1,10
W 300 AZP, W 302 AZP	5390 x 34 x 1,10
W 400 AZP	5500 x 34 x 1,10
W 400 HAP	6100 x 34 x 1,10
W 420 AZP	6400 x 41 x 1,30
W 500 HAP	6700 x 41 x 1,30
W 501 AZP	7250 x 54 x 1,60
W 500 HAP/G	7500 x 54 x 1,60
W 800 HAP/G	8500 x 54 x 1,60
W800 HAP	9400 x 67 x 1,60

JJ MACHINE TOOLS

JJ-220	3705 x 27 x 0,90
JJ-220	3720 x 34 x 1,10
JJ-260	4100 x 34 x 1,10
JJ-340	4860 x 41 x 1,30
JJ-420	5800 x 54 x 1,30
JJ-530	6900 x 54 x 1,60
JJ-650, JJ-800	8800 x 67 x 1,60
JJ-1000, JJ-1000X1250	12300 x 80 x 1,60
JJ-1250, JJ1250X1800	13100 x 80 x 1,60
JJ-1500	13900 x 80 x 1,60
JJ-1250X1800	14425 x 80 x 1,60
JJ-1250X2000	17600 x 80 x 1,60

KALTENBACH

UMB 250	3200 x 27 x 0,90
KB 360 G, KB 360 NA-G	3830 x 27 x 0,90
KBR 280 NA	3800 x 34 x 1,10
KBR 500 G	4600 x 34 x 1,10
KBR 610 DG	5620 x 34 x 1,10
KB 305 H, KB 305 NA,	5620 x 34 x 1,10
alternatively	5620 x 41 x 1,30
KB 380 H, KB 380 NA	5620 x 34 x 1,10
alternatively	5620 x 41 x 1,30
KBS 400 DG	5730 x 34 x 1,10
KBR 370 H, KBR 370 NA	5730 x 41 x 1,30
KBR 371 H, KBR 371 NA	5920 x 41 x 1,30
KBS 620 DG	6175 x 41 x 1,30
KB 455 H, KB 455 NA	6200 x 41 x 1,30
alternatively	6200 x 54 x 1,30
KBS 750 DG, KBS 860	6990 x 41 x 1,30
KBS 920 DG	7290 x 41 x 1,30
KBR 460 H, KBR 460 NA	7470 x 54 x 1,30
KB 550 H, KB 550 NA	7820 x 54 x 1,30
KBR 550 H, KBR 550 NA	7820 x 54 x 1,60
KBS 851 DG	7980 x 54 x 1,30
alternatively	7980 x 54 x 1,60
KBS 1001 DG	8250 x 54 x 1,60
KB 700 H, KB 700 NA	8920 x 54 x 1,60

Manufacturer Machine type	band dimension in mm length x width x thickness
KBS 1301 DG	9800 x 67 x 1,60
KBS 1551 DG	10300 x 67 x 1,60

KASTO

KASTObsm E 2	2825 x 27 x 0,90
KASTObsm U 2	2825 x 27 x 0,90
Funktional M/U/A	2910 x 27 x 0,90
Diagonal	3350 x 8 x 0,65
alternatively	3350 x 27 x 0,90
SBA 220 AU, SBL 280 U, BSM 220 BA, SBA 260 AU, BSM 260 BA	3830 x 27 x 0,90
KASTOcut E 2, KASTOsba A 2	3830 x 27 x 0,90
SSB 260 VA	- up to series 106 3912 x 34 x 1,10
	- from series 107 4115 x 34 x 1,10
	- from series 113 4115 x 38 x 1,30
	- from series 114 4115 x 41 x 1,30
KASTOssb A 2	- up to series 106 3912 x 34 x 1,10
	- from series 107 4115 x 34 x 1,10
	- from series 113 4115 x 38 x 1,30
	- from series 114 4115 x 41 x 1,30
SBA 260/400 U/G, BSM 260/400 B/G	4310 x 27 x 0,90
PBA 320 / 460 U / AU	4623 x 41 x 1,30
SBA 280 AU, SBA 280 AU-G, SBA 320 AU, SBA 320 AU-G, SBL 320 G, SBL 320 GH	4930 x 34 x 1,10
KASTOpos A 2, KASTOpos GA 2, KASTOpos A 3, KASTOpos GA 3, KASTOcut GE 3, KASTOcut GU 3	4930 x 34 x 1,10
KASTOtwinn A 2 / A 3 + L 2 / L 3	- up to series 103 4930 x 41 x 1,30
	- from series 104 4930 x 34 x 1,10
KASTOplate U 3	- up to series 101 4930 x 41 x 1,30
optional	4930 x 54 x 1,30
SBA 320/500 DG-U/AU	5090 x 34 x 1,10
KASTOprofil 3	5090 x 34 x 1,10
SBA 400 AU, SBA 400 AU-G, SBL 400 G, SBL 400 GH	5090 x 34 x 1,10
KASTO cut GE 3	5090 x 34 x 1,10
KASTO cut GU 3	5090 x 34 x 1,10
KASTOpos A 4, KASTOpos GA 4, KASTOcut GE 4, KASTOcut GU 4	5090 x 34 x 1,10
KASTOtwinn A 4 / U 4	- up to series 103 5090 x 41 x 1,30
	- from series 104 5700 x 41 x 1,30
SBL 380 U	5232 x 34 x 1,10
BBS 360 / 600	5290 x 41 x 1,30
alternatively	5290 x 54 x 1,30
KASTObsb U 3x6	5290 x 41 x 1,30
alternatively	5290 x 54 x 1,30
HBA 340 AU / 360 AU	- up to series 107 5334 x 34 x 1,10
HBA 360 AU	- from series 108 5334 x 41 x 1,30
PBA 460 U / AU	5334 x 41 x 1,30
KASTOplate U 3	- from series 102 5450 x 41 x 1,30
optional	5450 x 54 x 1,30
KASTObloc U 5	5450 x 41 x 1,30
optional	5450 x 54 x 1,30
HBA 360 / 600 U	- up to series 107 5734 x 34 x 1,10
	- from series 108 5734 x 41 x 1,30
PBA 520 / 620 U / AU	6096 x 41 x 1,30
HBA 420 AU	6300 x 41 x 1,30
alternatively	6300 x 54 x 1,30
KASTOturn D 4	6775 x 41 x 1,30
KASTOtec U / A 3	6830 x 41 x 1,30
Option	6830 x 54 x 1,30
KASTOtec U / A 4	6830 x 41 x 1,30
Option	6830 x 54 x 1,30

Band saw blade dimensions and machine types

Manufacturer Machine type	band dimension in mm length x width x thickness	Manufacturer Machine type	band dimension in mm length x width x thickness
HBA 520 U / 520 AU, PBA 660 U / AU	7239 x 54 x 1,30	MARVEL	
alternatively	7239 x 54 x 1,60	V10, V10APC	4115 x 27 x 0,90
HBA 520 / 620 U / AU	7439 x 54 x 1,30	8 Mark II	4420 x 27 x 0,90
KASTObbs U 5x10	7440 x 54 x 1,60	81, 81APC	4420 x 34 x 1,10
alternatively	7440 x 67 x 1,60	15, 15APC	4720 x 34 x 1,10
BBS 860 / 1060	7440 x 54 x 1,60	MV460, MV460APC	4775 x 34 x 1,10
alternatively	7440 x 67 x 1,60	MV525, MV525APC	5330 x 41 x 1,30
KASTObbs U 8x10	7440 x 54 x 1,60	25, 25APC	5740 x 41 x 1,30
alternatively	7440 x 67 x 1,60		
KASTOtec U / A 5	7675 x 54 x 1,30	MEBA	
optional	7675 x 54 x 1,60	200	2490 x 20 x 0,90
optional	7675 x 67 x 1,60	220 G	2450 x 27 x 0,90
KASTObbs U 10	7772 x 54 x 1,60	230 G / DG / DG-P / GA-P / GA-H / GA-NC	2720 x 27 x 0,90
alternatively	7772 x 67 x 1,60	220 DG	2825 x 27 x 0,90
BBS 460 / 1660 U / AU, BBS 660 / 1660 U / AU	8350 x 54 x 1,60	180	3020 x 27 x 0,90
alternatively	8350 x 67 x 1,60	225	3350 x 27 x 0,90
KASTObbs U / A 4x16	8350 x 54 x 1,60	260 AP	3350 x 27 x 0,90
KASTObbs U / A 6x16	8350 x 67 x 1,60	260 GP	3350 x 27 x 0,90
KASTOturn D 6	8400 x 54 x 1,30	251	3660 x 27 x 0,90
HBA 660 U / AU	8585 x 67 x 1,60	251 A	3660 x 27 x 0,90
KASTOhba U / A 6	8585 x 67 x 1,60	301 G / 301 GA	3660 x 27 x 0,90
BBS 360 / 2060 U / AU	8686 x 41 x 1,30	305 G / DG / GA	3800 x 27 x 0,90
alternatively	8686 x 54 x 1,30	250 A / 250 / 320	3800 x 27 x 0,90
KASTObbs U / A 3x20	8686 x 41 x 1,30	310 G / GA	3800 x 34 x 1,10
	8686 x 54 x 1,30	300 A	3800 x 34 x 1,10
HBA 660 / 1060 U / AU	9385 x 67 x 1,60	320 / 320 A	3800 x 34 x 1,10
KASTOhba U / A 6x10	9385 x 67 x 1,60	325	3800 x 34 x 1,10
PBA 800 / 1060 U / AU	9398 x 54 x 1,60	310 DG	4200 x 27 x 0,90
alternatively	9398 x 67 x 1,60	ECO 320 G standard	4200 x 27 x 0,90
PBA 800 / 1060 U / AU	9398 x 54 x 1,60	ECO 320 GA standard	4200 x 27 x 0,90
alternatively	9398 x 67 x 1,60	280 / 280 A	4200 x 34 x 1,10
BBS 1260 / 1560, HBA 860 / 1060 AU-CNC	10260 x 67 x 1,60	320 DG	4200 x 34 x 1,10
alternatively	10260 x 80 x 1,60	310 G-L, 310 GA-L	4200 x 34 x 1,10
KASTObbs U 12x15	10260 x 67 x 1,60	ECO 320 G stepless drive / HSS	4200 x 34 x 1,10
KASTOhba A 8x10	10260 x 80 x 1,60	ECO 320 GA stepless drive / S	4200 x 34 x 1,10
HBA 1060 / 1260 U / AU	11430 x 80 x 1,60	ECO 320 DG / DGA	4400 x 34 x 1,10
KASTOhba U / A 10x12	11430 x 80 x 1,60	ECO-S 335 / 335 A / G / GA / DG / DGA	4400 x 34 x 1,10
KASTOhba U / A 13	11430 x 80 x 1,60	330 / 330 A	4471 x 34 x 1,10
BBS 1860 / 1560	11430 x 100 x 1,60	(after machine card)	4471 x 41 x 1,30
alternatively	11430 x 125 x 2,00	340 / 340 A	4623 x 34 x 1,10
KASTObbs 18x15	11430 x 100 x 1,60	(after machine card)	4623 x 41 x 1,30
alternatively	11430 x 125 x 2,00		4640 x 34 x 1,10
PBA 1060 / 1260 U	13360 x 67 x 1,60		4640 x 41 x 1,30
alternatively	13360 x 80 x 1,60		
HBA 1060 / 1660 U / AU	13460 x 80 x 1,60	280 A	4670 x 41 x 1,30
KASTOhba U / A 13x17	13460 x 80 x 1,60	407 A	5120 x 41 x 1,30
PBA 1060 / 1660 U	14148 x 67 x 1,60	420 / 420 A	5334 x 41 x 1,30
alternatively	14148 x 80 x 1,60	380, 380 A	5334 x 41 x 1,30
PBA 1060 / 2060 U	14960 x 67 x 1,60	- up to '94 year of manufacture	5400 x 34 x 1,10
alternatively	14960 x 80 x 1,60	400	5400 x 34 x 1,10
PBA 1360 / 1360 U	15980 x 80 x 1,60	300 G / DG / GA / DGA - 500	5400 x 34 x 1,10
PBA 1660 / 1660 U - Gantry	17960 x 80 x 1,60	440	5400 x 41 x 1,30
		380, 380 A	5800 x 41 x 1,30
KLAEGER		420 G / 420 GA	5800 x 41 x 1,30
HBS 220, HBS 220 G, HBS 220 DG, HBA 220, HBA 220 G, HBA S220	2890 x 27 x 0,90	430 / 430 A	5800 x 41 x 1,30
HBS 265, HBS 265 G, HBS 256 DG		ECO-Serie 410 / A / DG / DGA	5800 x 41 x 1,30
HBA 265, HBA 265 G	3280 x 27 x 0,90	620 DGP	5800 x 41 x 1,30
HBS 325, HBS 325 G, HBA 325, HBA 325 G	3770 x 27 x 0,90	400 G-700	6000 x 41 x 1,30
HBA S 265, HBA S 325, HBA S 325 G	4150 x 34 x 1,10	- up to '94 year of manufacture	6080 x 41 x 1,30
HBA S400, HBA S500	4400 x 34 x 1,10	435 G / 435 GA	6310 x 41 x 1,30
HBA S500G, HBA S500DG	4700 x 34 x 1,10	400 G-700	6310 x 41 x 1,30
		- starting with '94 year of manufacture	6310 x 41 x 1,30
		400 GA-700	6354 x 41 x 1,30
		- up to '97 year of manufacture	6450 x 54 x 1,30
		520	6760 x 41 x 1,30
		420 G-800 / 420 GA-800	6760 x 41 x 1,30
		400 GA-700	6760 x 41 x 1,30
		- starting with '97 year of manufacture	6760 x 41 x 1,30
		400 DG / DGA-700	6760 x 41 x 1,30
		560 / 560 A / 660 / 660 A	7830 x 54 x 1,60
		- up to '94 y. of man.	

Manufacturer Machine type	band dimension in mm length x width x thickness
560 / 560 A / 660 / 660 A	8500 x 54 x 1,60
560 G / DG / GA-700	8500 x 54 x 1,60
650 -700 G / DG / GA / DGA	8500 x 54 x 1,60
800-510	9000 x 67 x 1,60
560 G / DG / GA / DGA-1000	9300 x 54 x 1,60
650-1000 G / DG / GA / DGA	9300 x 54 x 1,60
1000 DGP / 1140-510 / 1250-510	9800 x 67 x 1,60

MEGA

H-260 A, H-260 GA	3660 x 27 x 0,90
BS-250 HAS, BS-250 GA	3660 x 34 x 1,10
BS-300 HAS, BS-300 GA	3820 x 34 x 1,10
H-330 A, H-330 GA, H-330	3920 x 34 x 1,10
BS-400 HAS, BS-400 GA, BS-400 HA,	
BS-360 GA, BS-360 HA, BS-450 M,	
BS-360 SA, BS-360 A	4115 x 34 x 1,10
H-400 A, H-400 GA, H-400	4570 x 34 x 1,10
BS-450 SA	4670 x 41 x 1,30
BS-450 HAAS, BS 450 GAAS	4880 x 41 x 1,30
H-5042 A	5100 x 41 x 1,30
H-460 A, H-460 GA, H-460,	
BS-1830 (H-1830)	5300 x 41 x 1,30
BS-760 M	5500 x 41 x 1,30
H-550 A, H-550 GA, H-550	5800 x 41 x 1,30
H-600, S-600	7600 x 54 x 1,60
H-700 A, H-700 GA, H-700, H-800, S-800	8128 x 54 x 1,60
MH-800 S	8500 x 54 x 1,60
H-1080, S-1080	8800 x 67 x 1,60
MH-1080 S	9070 x 54 x 1,60
MH-1865 S	10600 x 67 x 1,60
MH-1190 S	10818 x 67 x 1,60
H-1100	10820 x 80 x 1,60
MH-1690 S	10980 x 67 x 1,60
MH-1385 S, H-1300	12300 x 80 x 1,60
H-1613	12900 x 80 x 1,60

MEP

PH 100	1138 x 13 x 0,65
SH 200 & SH 200/2	2375 x 20 x 0,90
SH 260 & SH 270	2750 x 27 x 0,90
SH 280 / SH 280 SX / SH 280 SXI	2950 x 27 x 0,90
SH 320 SX / SH 320 SXI	
SH 320 AX / SH 320 AXI	
SH 320 CNC FE	3150 x 27 x 0,90
SH 330 HH / SH 330 AXI S /	
SH 330 CNC FE	3320 x 27 x 0,90
SH 400 CNC FE S	4400 x 34 x 1,10

METALIN

320 SA, 320 ST, 320 VA	3660 x 27 x 0,90
420 SA, 420 ST, 420 VA	4360 x 34 x 1,10
420 ST V	4570 x 34 x 1,10

METORA

UMB 250	3200 x 27 x 0,90
MB 300, 300 RR	3660 x 27 x 0,90
VMB 280	3800 x 34 x 1,10
Geromat 360	3830 x 27 x 0,90
MBL 300, MB 320	4000 x 27 x 0,90
VMB 230 DS	4100 x 34 x 1,10
MB 330 ERGONOMIC	4600 x 34 x 1,10
HMB/VMB 305 DS	4900 x 34 x 1,10
	alternatively 4900 x 41 x 1,30
HMB 405 R	5620 x 34 x 1,10
HMB/VMB 380 DS	5620 x 41 x 1,30
	alternatively 5620 x 34 x 1,10

Manufacturer Machine type	band dimension in mm length x width x thickness
HMB/VMB 455 DS	6200 x 54 x 1,60
HMB 705 G	6800 x 41 x 1,30
HMB/VMB 550 DS	7820 x 54 x 1,60
HMB/VMB 700 DS	8920 x 54 x 1,60

MISSLER

DEB 280 CE	4100 x 34 x 1,10
ACM 600	4570 x 34 x 1,10
DEB 340 CE	5000 x 34 x 1,10
DEB 410 CE	5940 x 41 x 1,30
DEB 420 CE	6200 x 54 x 1,30
	alternatively 6200 x 54 x 1,60
DEB 540 CE	7460 x 54 x 1,30
	alternatively 7460 x 54 x 1,60
DEB 650 CE	9400 x 67 x 1,60
DEB 720 CE	9520 x 67 x 1,60

MISTRY LAXMAN KADVA & CO.

LK-O	2510 x 20 x 0,90
LK-1.STD.	2540 x 20 x 0,90
LK-1.HS.	3000 x 27 x 0,90
LK-150.DCA.	3760 x 27 x 1,10
LK-2.HS.	3810 x 27 x 0,90
LK-210.DC.	4100 x 34 x 1,10
LK-3.HS.	4100 x 34 x 1,10
LK-4.HS.	4420 x 34 x 1,10
LK-300.DCA.	4570 x 41 x 1,30
LK-400.DC.	5450 x 41 x 1,30
LK-500.DC.	6900 x 54 x 1,60
LK-600.DC.	8000 x 67 x 1,60
LK-700.DC.	8800 x 67 x 1,60
LK-1000.DC.	12300 x 80 x 1,60
LK-1500.DC.	13200 x 80 x 1,60

MÖSSNER

320	2550/2630 x 3-13 x 0,65-0,90
420	3160/3260 x 3-13 x 0,65-0,90
1050 (2 wheels)	3920/4050 x 6-27 x 0,65-0,90
520	4100/4200 x 6-27 x 0,65-0,90
520 (heightened)	4500/4600 x 6-27 x 0,65-0,90
630	5100/5180 x 10-34 x 0,65-1,10
1050 (3 wheels)	5250/5350 x 6-27 x 0,65-0,90
630 (250 heightened)	5600/5680 x 10-34 x 0,65-1,10
801	6250/6400 x 13-34 x 0,65-1,10
1600	6575/6635 x 6-27 x 0,65-0,90
VB 801 F	6670/6730 x 34-41 x 1,10-1,30
1600 (270 heightened)	6980/7040 x 6-27 x 0,65-0,90

MÜLLER

Kamu 150 G	1470 x 13 x 0,65
Kamu 210 G, Kamu 220 G	2450 x 20 x 0,90
HBS 220 G	2450 x 27 x 0,90
HBS 230 G-M, HBS 230 G-MA,	
HBS 230 G-LR-M, HBS 230 G-LR-MA	
HBS 230 G-LR-HA	2700 x 27 x 0,90
Kamu 260 G-M, Kamu 260 G-SC,	
Kamu 280 DG-M, Kamu 280 DG-SC	
Kamu 280 G-HHS, Kamu 280 DG-HHS	
Kamu 310 G-HA, Kamu DG-HA	2700 x 27 x 0,90
HBA 240, HBA 240 G	3180 x 27 x 0,90
Kamu 270 A, Kamu 300 G-A	3180 x 27 x 0,90
SBS 410, SBS 420, SBS 430,	3400 x 13 x 0,65
SBS 450, SBS 460	alternatively 3400 x 20 x 0,90
HBS 275 G	3460 x 27 x 0,90
	alternatively 3460 x 34 x 1,10

Band saw blade dimensions and machine types

Manufacturer Machine type	band dimension in mm length x width x thickness
HBS 280, HBS 300, HBA 320 G, HBS 321 G, HBS 260, HBA 260, HBA 280	alternatively 3660 x 27 x 0,90 3660 x 34 x 1,10
Kamu 500 G-HA	4120 x 34 x 1,10
Kamu 450 G-A	4140 x 34 x 1,10
HBS 320, HBS 320 G-LR, HBS 322 G HBA 320, HBA 500 G, HBA 320 SG	alternatively 4150 x 27 x 0,90 4150 x 34 x 1,10
HBS 320 SG	4150 x 34 x 1,10
Kamu 380 VDG-HA	4250 x 34 x 1,10
HBA 400 S, HBA 500 SG, HBS 500 SG	
HBS 400 S	4400 x 34 x 1,10
Kamu 400 A	4500 x 34 x 1,10
SBS 650, SBS 660	4750 x 13 x 0,65
SBS 1150, SBS 1160	5000 x 20 x 0,90
	alternatively 5000 x 13 x 0,65
HBS 450, HBS 450 G	5060 x 34 x 1,10
Kamu 700 HA, Kamu 700 DG-HA	5450 x 41 x 1,30
Kamu 1200	5600 x 34 x 1,10

MULTICUT MACHINE TOOLS

BDC-200	3760 x 27 x 0,90
BDC-300	4100 x 34 x 1,10
BDC-360	4860 x 41 x 1,30
BDC-420	5800 x 41 x 1,30
BDC-550	6900 x 67 x 1,60
BDC-650	6900 x 67 x 1,60
BDC-800	8800 x 67 x 1,60
BDC-1000	12300 x 80 x 1,60
BDC-1200	13900 x 80 x 1,60

PEDRAZZOLI

SN 255	2500 x 27 x 0,90
SN 275	2825 x 27 x 0,90
SN 300	2825 x 27 x 0,90
SN 350	3150 x 27 x 0,90
SN 365	3150 x 27 x 0,90
SN 380	3634 x 34 x 1,10

PEHAKA

HS 300 GBS, HS 300 GBS-AU	3660 x 27 x 0,90
HS 260, HSL 260, HS 260 Super, Pehakamat 250 SL, PEHAKAMAT 250 Super	3700 x 27 x 0,90
Pehakamat 260 ZP	4850 x 34 x 1,10
HS 340 GBS	5000 x 34 x 1,10
HS 420, Pehakamat 420-R	5300 x 34 x 1,10
HS 340/500, PEHAKAMAT 360 ZP	5600 x 41 x 1,30
HS 440/560	6100 x 41 x 1,30
HS 540/710	6700 x 54 x 1,60
HS 310/600 GBS	6850 x 34 x 1,10
Pehakamat 440 ZP	7200 x 41 x 1,30
Pehakamat 540/610 ZP	7900 x 54 x 1,60
HS 650/800	8000 x 67 x 1,60
HS 400/800 GBS	8100 x 41 x 1,30
Pehakamat 650/800 ZP	8800 x 67 x 1,60
HS 540/1100 GBS	10260 x 54 x 1,60
HS 820/820, Pehakamat 820 ZP	10880 x 67 x 1,60
HS 820/1050	11350 x 67 x 1,60
HS 1700/1700	11880 x 54 x 1,60
HS 1070/1250	12700 x 67 x 1,60
HS 1500/1500	13520 x 67 x 1,60
HS 1250/1350	14000 x 67 x 1,60
	alternatively 14000 x 80 x 1,60

Manufacturer Machine type	band dimension in mm length x width x thickness
RES	
CAR 4	1640 x 13 x 0,65
TR 6 M	2000 x 20 x 0,90
CAR 5	2360 x 20 x 0,90
TR 8 M	2450 x 27 x 0,90
TR 7 SA/A	2650 x 20 x 0,90
TR 8 A	2650 x 27 x 0,90
TR 9 M/SA, TR 10 SA/A	3000 x 27 x 0,90
300 M - SA	4020 x 27 x 0,90
260 CNC - AL	4100 x 34 x 1,10
300 M/45	4250 x 34 x 1,10
320 CNC - SA - AL	4450 x 34 x 1,10
320/45 CNC	4950 x 34 x 1,10
420 M - MSA	5100 x 34 x 1,10
420 CNC - SA - AL	5250 x 41 x 1,30
520 SA	6400 x 41 x 1,30
520 CNC - AL	6400 x 54 x 1,60
1000 VS	7530 x 54 x 1,60
650 CNC - SA, 1500 VS	8450 x 54 x 1,60
850 SG	9200 x 67 x 1,60
850 A/SA	9700 x 67 x 1,60
650 SAS	9850 x 67 x 1,60
1050 SG	11700 x 67 x 1,60
1350 SA - SA	13600 x 67 x 1,60
1650 SA - SG	16100 x 80 x 1,60

RÜSCH

TOP SAW 320	2825 x 27 x 0,90
HBS 260, 320/450 G, 275 A, 260/320 AF	3660 x 27 x 0,90
280 A	4500 x 34 x 1,10
340 A, 400/600 SA	5250 x 34 x 1,10
420 A	5420 x 41 x 1,30
420/700, 420/700 G, 420/700 GS	5740 x 34 x 1,10
520 A	5890 x 41 x 1,30
520/700, 520/700 G, 520/700 GS	6380 x 41 x 1,30
600 A	8800 x 67 x 1,60

SABI

BR 150/210	2315 x 20 x 0,90
BR 160/220	2400 x 20 x 0,90
BR 230/300, BR 230/280 A CN	2720 x 27 x 0,90
BR 240/320, BR 240/280 A-NC	2925 x 27 x 0,90
PBS 250/400, PBS 250 A	3660 x 27 x 0,90
BR 260/410	3800 x 27 x 0,90
BR 230/510	4335 x 34 x 1,10
PSR 320/400, PSR 320 A	4570 x 27 x 0,90
PBS 320 A, PBS 320/450	4570 x 34 x 1,10
BR 440/610	5200 x 34 x 1,10
PB 360 A, PB 360/500	5330 x 34 x 1,10
PSR 320/600	5500 x 34 x 1,10
PB 450 A-NC	6000 x 41 x 1,30
PB 450/700, PBR 450/700, PB 450 A	6775 x 41 x 1,30
PB 550 A-NC	7360 x 54 x 1,60
PB 550 A	7600 x 54 x 1,60
PBR 550/1000	8400 x 54 x 1,30
PB 550/1000	8400 x 54 x 1,60
PB 650 A	8400 x 54 x 1,60
PB 800/1000, PB 800 A	9500 x 67 x 1,60
PB 1000/1200	11000 x 67 x 1,60
PB 1000 A	11000 x 80 x 1,60

SPM

MCB 250	3435 x 27 x 0,90
DCA 160	3505 x 27 x 0,90
HBM 250	3505 x 27 x 0,90

Manufacturer Machine type	band dimension in mm length x width x thickness
DCA 160	3550 x 27 x 0,90
DCA-340	3920 x 34 x 1,10
DCA-260	4100 x 34 x 1,10
HB-260-CNC	4100 x 34 x 1,10
DCM-340	4860 x 41 x 1,30
DCM-421	5800 x 41 x 1,30
DCA-421, DCA-500, DCM-550	6270 x 41 x 1,30
DCM-650	7600 x 54 x 1,60
DCM-800	8800 x 67 x 1,60
DCM-1000	10400 x 67 x 1,60

TRENNJÄGER

TEBA 100	1350 x 13 x 0,65
TEBA 110	1620 x 13 x 0,65
TEBA 160	1730 x 13 x 0,65
TEBA 160 L	2080 x 13 x 0,65
TEBA 200	2490 x 20 x 0,90
TEBA 200 L	2570 x 27 x 0,90
TEBA 240 bis NC	2710 x 27 x 0,90
TEBA 250 DGHA	3110 x 27 x 0,90
TEBA 290 bis NC	3110 x 27 x 0,90
TEBA 260 bis NC	3110 x 27 x 0,90
TEBA 361-362	3660 x 27 x 0,90
TEBA 330 GA	3810 x 27 x 0,90
TEBA 400	4300 x 34 x 1,10
TEBA 431-432 / 501	4400 x 34 x 1,10
TEBA 450 DGHA	5150 x 34 x 1,10
TEBA 502 DGHA	5370 x 41 x 1,30
TEBA 602 DGHA	5370 x 41 x 1,30
TEBA 750 DGHA	5370 x 41 x 1,30

UZAY MAKINA

UMS 150 DG	2080 x 20 x 0,90
UMS-Y 220 DG	3000 x 27 x 0,90
UMS-Y-O 280 H	3660 x 27 x 0,90
UMSY-O 350 G/DG	4260 x 34 x 1,10
UMSY-O 350	4570 x 34 x 1,10
UMSY-O 420	5040 x 34 x 1,10
UMSY 420 H	5150 x 41 x 1,30
UMSY-O 350 LG	5400 x 41 x 1,30
UMSY-O 540	6100 x 41 x 1,30
UMSY 540 H	6250 x 41 x 1,30
UMSY 800	7250 x 41 x 1,30
UMSY 540 DG	7400 x 41 x 1,30
UMSO 540 DGH	7400 x 54 x 1,60
UMSO 800 H	8300 x 54 x 1,60
UMSY 1010	9400 x 54 x 1,60
UMSY 1300	12000 x 67 x 1,60
UMSY 1600	13500 x 80 x 1,60

WAGNER

WPB 340 A	5270 x 34 x 1,10
	alternatively 5270 x 41 x 1,30
WPB 420 A	6280 x 41 x 1,30
WPB 520 A	7350 x 41 x 1,30
	alternatively 7350 x 54 x 1,60

WAY TRAIN

UE-100 S	1470 x 13 x 0,65
WE 225 S	2265 x 20 x 0,90
UE-712 C, UE-712 G, UE-180 AH, UE-712SG	2360 x 20 x 0,90
WE 270 DS / WE 270	
DSA / WE 260 S	2460 x 27 x 0,90
UE-916 V, UE-916 A	3035 x 27 x 0,90
WE 330 DSA	3080 x 27 x 0,90

Manufacturer Machine type	band dimension in mm length x width x thickness
UE-250 A, UE-250 V, UE-250 SSA	3300 x 27 x 0,90
UE-918 HAV, UE-918 HA, UE-918 SSA, UE-918 S	3345 x 27 x 0,90
LX-250	3505 x 34 x 1,10
UE 330 SA / 330 SSA / 330 A	4100 x 34 x 0,90
UE-350	4700 x 34 x 1,10

WOO SUNG

H-200	2460 x 27 x 0,90
HANC-3300, HA-330	3820 x 34 x 1,10
HANC-430, HA-400	4570 x 34 x 1,10
HANC-450, HA-450	4670 x 41 x 1,30
HANC-480	5040 x 41 x 1,30
HANC-500	5450 x 41 x 1,30
H-500MA, HANC-580	5800 x 41 x 1,30
HA-700, H-700	7600 x 41 x 1,30
HA-1000MA, H-1100	9500 x 67 x 1,60
H-1300	11880 x 67 x 1,60

Recommended cutting speed and cooling lubricant

Material group	DIN	Material number	USA	JIS
Structural steels	St 37/42	1.0037/1.0042	A 570	STKM 12 A/SM 400 A
	St 52/60	1.0050/1.0060	A 572	SS 490/SM 570
Case hardened steels	C10/C15	1.0301/1.0401	1010/1016	S 10 C/S 15 C
	16 MnCr 5	1.7131	5115	-
	20 CrMo 5	1.7264	-	SCM 420 H
	21 NiCrMo 2	1.6523	8620	SNCM 22
Nitriding steels	34 CrAlNi 7	1.8550	-	-
	34 CrAlMo 5	1.8507	A 355 Cl.D	-
Machining steels	9 S 20	1.0711	1212	SUM 21
Quenched and tempered steels	C 35/45	1.0501/1.0503	1035/1045	S35C/S45 C
	42 CrMo 4	1.7225	4140	SCM 440
	34 CrNiMo 6	1.6582	4340	SNCM 447
Ball bearing steels	100 Cr 6	1.3505	52100	SUJ 2
Spring steels	65 Si 7	1.5028	9260 H	SUP 6
	50 CrV 4	1.8159	6150	SUP 10
Unalloyed	C 125 W	1.1663	W 112	SK 2
Tool steels	C 80 W 1	1.1525	W 108	-
Tool steels for cold work	125 Cr 1	1.2002	-	-
	X 210 Cr 12	1.2080	D 3	SKD 1
	X 155 CrVMo 12 1	1.2379	D 2	SKD 11
	100 MnCrW 4	1.2510	O 1	-
	90 MnCrV 8	1.2842	O 2	-
	40 CrMnMo 7	1.2311	-	-
Tool steels for hot work	X 40 CrMoV 5 1	1.2344	H 13	SKD 61
	56 NiCrMoV 7	1.2714	L 6	SKT 4
	40 CrMnNiMo 8 6 4	1.2738	-	-
High-speed steels	S 6-5-2	1.3343	M 2	SKH 51
	S 3-3-2	1.3333	-	-
	S 2-10-1-8	1.3247	M 42	SKH 59
	S 10-4-3-10	1.3207	-	SKH 57
	S 18-0-1	1.3355	T 1	SKH 2
Stainless steels	X 5 CrNi 18 10	1.4301	304	SUS 304
	X 6 CrNiMoTi 17 12 2	1.4571	316 Ti	SUS 316
	X 20 Cr 13	1.4021	420	SUS 420 J1
Valve steels	X 45 CrSi 9 3	1.4718	HNV 3	SUH 1
	X 45 CrNiW 18 9	1.4873	-	SUH 31
High-temperature resisting steels	X 12 CrCoNi 21 20	1.4971	HEV 1	SUH 661
	X 20 CrMoWV 12 1	1.4935	HNV 8	SUH 616
Heat-resistant steels	X 15 CrNiSi 25 20	1.4841	314	SUH 310
	X 12 NiCrSi 36 16	1.4864	330	SUH 330
Special alloys	NiCr 19 NbMo	2.4668	Inconel 718	-
	NiMo 30	2.4810	Hastelloy B	-
	NiCr 13 Mo 6 Ti 3	2.4662	Nimonic 901	-
	NiCo 20 Cr 20 MoTi	2.4650	Nimonic 263	-
	X 8 CrNiAlTi 20 20	1.4847	Incoloy 840	-
Tempered steels				
1000-1200 N/mm ²	-	-	-	-
1200-1400 N/mm ²	-	-	-	-
1400-1600 N/mm ²	-	-	-	-
Hardened steels				
50 HRC	-	-	-	-
55 HRC	-	-	-	-
60 HRC	-	-	-	-
Cast steel	GS-38	1.0420	-	-
	GS-60	1.0558	-	-
Cast iron	GG-30	0.6030	A48-45B	-
	GGG-50	0.7050	65-45-12	-
- alloyed	(NiCrMo)	-	-	-
Titanium	Ti 1	3.7025	CP Titanium	-
- alloyed	G-TiAl 6 V 4	3.7164	Ti-6Al-4V	-
Zirconium	-	-	-	-

	Extra/Diamant	Cutting speed (m/min)			Carbide	Cooling lubricant (oil content)
		Bimetal Ø < 100 mm	Bimetal Ø 100-500 mm	Bimetal Ø > 500 mm		
	40 - 60	90 - 100	70 - 90	50 - 70	100 - 130	10 %
	35 - 50	70 - 90	50 - 70	40 - 50	90 - 120	10 %
	50 - 70	95 - 110	80 - 95	60 - 80	110 - 140	15 %
	35 - 45	65 - 75	55 - 65	40 - 55	80 - 100	10 %
	35 - 45	65 - 75	55 - 65	40 - 55	80 - 100	10 %
	35 - 45	55 - 65	45 - 55	35 - 45	70 - 90	10 %
	-	40 - 45	30 - 40	20 - 30	45 - 60	5 %
	-	40 - 45	30 - 40	20 - 30	45 - 60	5 %
	50 - 70	100 - 130	80 - 120	60 - 80	100 - 160	15 %
	40 - 60	75 - 90	60 - 75	40 - 60	90 - 120	5 %
	35 - 45	60 - 70	50 - 60	40 - 50	70 - 90	5 %
	35 - 45	60 - 70	50 - 60	40 - 50	70 - 90	5 %
	25 - 35	65 - 75	55 - 65	30 - 50	70 - 90	3 %
	30 - 40	60 - 70	40 - 60	30 - 40	65 - 85	3 %
	30 - 40	60 - 70	40 - 60	30 - 40	65 - 85	3 %
	30 - 40	50 - 65	40 - 50	30 - 40	65 - 80	3 %
	30 - 40	55 - 70	45 - 55	35 - 45	70 - 85	3 %
	30 - 40	50 - 65	40 - 50	30 - 40	65 - 80	3 %
	20 - 30	30 - 40	20 - 30	15 - 20	40 - 50	dry/2 %
	20 - 30	30 - 40	20 - 30	15 - 20	40 - 50	dry/2 %
	20 - 30	50 - 60	40 - 50	30 - 40	60 - 80	3 %
	20 - 30	35 - 45	30 - 35	20 - 30	45 - 55	3 %
	-	25 - 35	20 - 25	15 - 20	70 - 90	5 %
	-	22 - 30	18 - 22	12 - 18	60 - 80	5 %
	-	30 - 40	25 - 30	20 - 25	50 - 70	5 %
	-	25 - 35	20 - 25	15 - 20	35 - 50	5 %
	20 - 30	45 - 50	35 - 45	25 - 35	50 - 60	3 %
	20 - 30	50 - 55	40 - 50	30 - 40	55 - 65	3 %
	20 - 30	40 - 45	30 - 40	20 - 30	45 - 60	3 %
	20 - 30	40 - 45	30 - 40	20 - 30	45 - 60	3 %
	20 - 30	40 - 45	30 - 40	20 - 30	45 - 60	3 %
	-	40 - 50	30 - 40	20 - 30	70 - 80	10 %
	-	40 - 50	30 - 40	20 - 30	65 - 75	10 %
	-	40 - 50	30 - 40	25 - 35	80 - 100	10 %
	-	45 - 55	35 - 45	25 - 35	50 - 60	5 %
	-	40 - 50	30 - 40	20 - 30	40 - 50	5 %
	-	25 - 30	20 - 25	15 - 20	30 - 40	10 %
	-	35 - 40	30 - 35	25 - 30	80 - 100	10 %
	-	20 - 25	15 - 20	10 - 15	30 - 40	15 %
	-	20 - 25	15 - 20	10 - 15	30 - 40	15 %
	-	15 - 20	10 - 15	8 - 12	20 - 30	20 %
	-	20 - 25	15 - 20	10 - 15	22 - 35	12 %
	-	15 - 20	10 - 15	8 - 12	20 - 30	20 %
	-	17 - 22	12 - 17	10 - 14	22 - 35	15 %
	-	18 - 23	13 - 18	11 - 15	22 - 35	15 %
	-	30 - 35	25 - 30	20 - 25	35 - 50	~ 5 %
	-	25 - 30	20 - 25	15 - 20	30 - 45	~ 5 %
	-	20 - 25	15 - 20	10 - 15	25 - 35	~ 5 %
	-	-	-	-	15 - 20	~ 5 %
	-	-	-	-	10 - 15	~ 5 %
	-	-	-	-	8 - 12	~ 5 %
	30 - 40	60 - 70	50 - 60	40 - 50	70 - 100	~ 3 %
	25 - 35	50 - 60	40 - 50	35 - 40	60 - 85	~ 3 %
	30 - 40	50 - 60	40 - 50	30 - 40	60 - 80	dry/2 %
	25 - 35	45 - 55	35 - 45	25 - 35	55 - 75	dry/2 %
	-	30 - 40	20 - 30	15 - 25	40 - 50	dry/2 %
	-	35 - 45	20 - 35	15 - 20	80 - 100	10 %
	-	-	-	-	65 - 90	10 %
	-	-	-	-	50 - 70	12 %

Recommended cutting speed and cooling lubricant

Material group	DIN	Mat.-No.	Cutting speed for Bimetal (m/min)		Cooling lubricant (oil content)
			Horizontal machine	Vertical machine	
Copper	Cu 99.0	2.0050	60 - 100	100 - 200	10 %
	Cu Be 2	2.1247	60 - 80	60 - 80	10 %
Brass	CuZn 40	2.0360	80 - 120	200 - 300	3 %
	CuZn 40 Pb 2	2.0402	80 - 120	200 - 300	3 %
	CuZn 15 Si 4	2.0492	80 - 120	200 - 300	3 %
Bronzes					
Tin bronze	CuSn 6	2.1020	80 - 120	100 - 160	3 %
	CuSn 8	2.1030	80 - 120	100 - 160	3 %
Red cast	CuSn 5 ZnPb	2.1096	60 - 100	80 - 150	3 %
	CuSn 10 Zn	2.1086	60 - 100	80 - 150	3 %
Aluminium bronze*	CuAl 8	2.0920	40 - 60	40 - 60	15 %
	CuAl 10 Fe	2.0940	30 - 40	30 - 40	15 %
	Ampco 18		40 - 65	40 - 60	15 %
	Ampco 25		30 - 50	30 - 40	15 %
Tin lead bronze	CuPb 20 Sn 5	2.1818	80 - 120	100 - 160	3 %
Aluminium Forging alloy	Al 99,8	3.0285	80 - 120	1000 - 2500	25 %
	AlMg 3	3.3535	80 - 120	1000 - 2500	25 %
	AlMg 4,5 Mn	3.3547	80 - 120	1000 - 2500	25 %
Cast alloy	G-AlSi 5 Mg	3.2341	80 - 120	1000 - 2000	25 %
	G-AlSi 9 Cu 3	3.2163	80 - 120	800 - 1500	25 %
	G-AlSi 12	3.2581	80 - 120	800 - 1500	25 %
Piston alloy*	AlSi 21 CuNiMg		80 - 120	400 - 800	25 %
Plastics					
- thermoplastic	PVC		80 - 120	200 - 400	dry
	polystyrene (PS)		80 - 120	200 - 400	dry
	polyethylene (PE)		80 - 120	200 - 400	dry
	polyamide (PA)		80 - 120	200 - 400	dry
- thermosetting	polyurethane (PUR)		80 - 120	800 - 1200	dry
	epoxide (EP)		80 - 120	800 - 1200	dry
	polyester resin (UP)		80 - 120	600 - 1000	dry
	fabric reinforced*/**		80 - 120	200 - 300	dry
	GRP */**		50 - 80	50 - 80	dry
Gas-aerated concrete*				300 - 500	dry
Graphite carbon*			80 - 120*	400 - 600	dry
High-fired graphite**			-	300 - 500	dry
Fibre-cement*/**			-	-	dry

* Carbide tipped band saw blades are strongly recommended

** We recommend diamond coated band saw blades

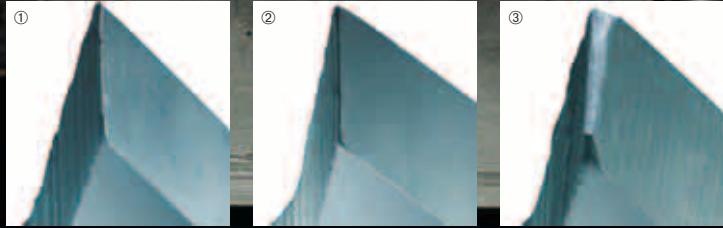
Practical help: the WIKUS cutting data slide rule

Only with optimal cutting conditions and exact cutting parameters a high tool life and a long blade life can be guaranteed.

The extensive cutting data slide rule has been developed to help you. It shows 16 different material groups with altogether 40 of the most important materials to be cut.

Correct break-in procedure guarantees long blade life

- ① New cutting edge with very small edge radius
- ② Proper break-in of the band saw blade creates a stable cutting edge
- ③ Excessive strain due to improper breaking-in leads to micro-breakages of the cutting edge



Breaking-in a band saw blade

Sharp cutting edges with extremely small edge radii are required for high cutting capacity. WIKUS blades are predestined for that. To achieve the optimal tool life we recommend to break-in the blade accordingly.

The correct cutting speed (m/min) is determined by the material being cut and its dimensions. The tables on the previous pages may help you.

Examine apart from the tape tension, which should be with 300 N/mm², also the oil rate of the cooling lubricant. Hand refractometer and band tension meter are available at WIKUS. It is very important

that the new blade is first used with only 50% of the determined feed rate. This will avoid micro-breakages because of too large chip thicknesses can be avoided. New band saw blades may tend towards vibrations and vibration sounds. In this case a slight reduction of the cutting speed is also helpful.

With small work piece dimensions approx. 300 cm² of the material should be cut for breaking-in. If large work piece dimensions are to be cut we recommend a breaking-in period of about 15 minutes. After breaking-in you may slowly increase the feed rate up to the determined value.

Maintenance

Bimetal band saw blades of 0,75 tpi to 6 tpi can be re-sharpened or re-set. Variable tooth pitches cannot be re-set.

With carbide tipped band saw blades all tooth pitches can be re-sharpened and re-set, if necessary.

However, changing the band saw blade in time is a condition of maintenance.

Please observe that also re-sharpened band saw blades need a breaking-in!

Customer service

For questions about our product range or individual solutions for your application, please contact us. Our specialists have extensive experience with most applications and are glad to help you.

If needed, our technicians will be there for you on the spot - assisting you in the best possible use of our band saw blades.

For extensive product recommendation we require the following information:

1. Exact description of the material to be cut, if possible including material number and tensile strength.
2. Cross-sections of the material (for tubes diameter and wall thickness) and shape of the material (round, square, tube, profile etc.).
3. Surface condition (forged, rolled, cast, drawn, bare etc.)
4. Type of cut (single, layer, bundle cut). When layer and bundle cutting please indicate the number of layers or bars. With flat, square or profile material, please specify whether the material is clamped flat or on edge.
5. Band saw blade dimensions (length, width, thickness) as well as the machine type. In case of contour cuts please indicate the smallest radius to be cut.



View of the WIKUS head office in Spangenberg, Germany

How to inquire and order

On this page you see an example of how to make an inquiry or to order by fax. Please help us to handle your

questions and orders as quickly as possible by giving us detailed information.



Company:	Contact person:	
Street:		
Country:	Postal code:	City:
Customer number:	Phone:	

Technical advice

1. Material:	possibly tensile strength	[N/mm ²]
2. Cross-section:	[mm]. Diameter and wall thickness in case of tubes	
3. Surface conditions:	<input type="checkbox"/> forged	<input type="checkbox"/> rolled
	<input type="checkbox"/> cast	<input type="checkbox"/> drawn
	<input type="checkbox"/> bare	
4. Clamping:	<input type="checkbox"/> individually	<input type="checkbox"/> number of layers
	<input type="checkbox"/> number of bundles	
5. Dimension of band saw blade:	<input type="checkbox"/> mm length	<input type="checkbox"/> mm width
	<input type="checkbox"/> mm thickness	
6. Machine type:		

Inquiry Order

In case of an inquiry or an order please indicate the following data:

Quantity	Product description including Item group	Band dimension (in mm) length x width x thickness			Tooth pitch	Tooth shape	Set type	Grit size
10 pieces	MARATHON M42 Item No. 529	3660	27	0,90	3-4 tpi	K	SD	-
10 pieces	DIAGRIT U Item No. 574	5200	34	1,10	20 mm	-	-	D601

Place:	Date:	Signature / stamp:
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