BIMETAL BANDSAW BLADES
CHOOSE THE TEETH PER INCH

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

Full materials



Squares or rectangulars



Rounds



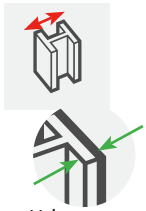
Hexagons



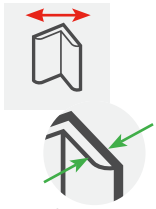
Flat bars

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

Beams - Tubes - Profiles



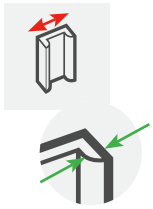
H-beams
IPE - IPN - HEA - HEB - HL - HD - HP



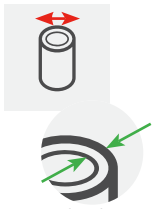
Angle irons



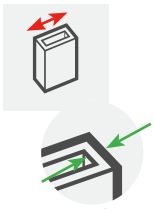
T irons



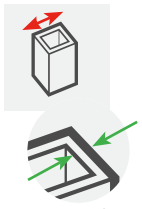
U irons
U beams
UPE - UPN - U



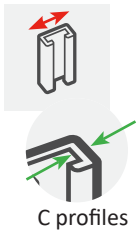
Round tubes



Rectangular tubes



Square tubes



C profiles

thickness →

External diameter - base - width ↔

	20 mm	40 mm	60 mm	80 mm	100 mm	120 mm	150 mm	200 mm	300 mm	500 mm
2 mm	14 TPI	10/14 TPI	10/14 TPI	10/14 TPI	10/14 TPI	8/12 TPI(1)	8/12 TPI(1)	8/12 TPI(1)	8/12 TPI(1)	6/10 TPI
3 mm	14 TPI	10/14 TPI	10/14 TPI	8/12 TPI(1)	8/12 TPI(1)	8/12 TPI(1)	6/10 TPI	6/10 TPI	6/10 TPI	5/8 TPI(2)
4 mm	10/14 TPI	10/14 TPI	8/12 TPI(1)	8/12 TPI(1)	8/12 TPI(1)	6/10 TPI	6/10 TPI	5/8 TPI(2)	5/8 TPI(2)	4/6 TPI
5 mm	10/14 TPI	10/14 TPI	8/12 TPI(1)	6/10 TPI	6/10 TPI	6/10 TPI	5/8 TPI(2)	4/6 TPI	4/6 TPI	4/6 TPI
6 mm	10/14 TPI	8/12 TPI(1)	8/12 TPI(1)	6/10 TPI	6/10 TPI	5/8 TPI(2)	5/8 TPI(2)	4/6 TPI	4/6 TPI	4/6 TPI
8 mm	10/14 TPI	8/12 TPI(1)	6/10 TPI	6/10 TPI	5/8 TPI(2)	5/8 TPI(2)	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI
10 mm		8/12 TPI(1)	6/10 TPI	5/8 TPI(2)	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI
12 mm		8/12 TPI(1)	6/10 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI
15 mm		8/12 TPI(1)	5/8 TPI(2)	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	3/4 TPI	3/4 TPI
20 mm			4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	3/4 TPI	3/4 TPI
30 mm				4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	4/6 TPI	2/3 TPI	2/3 TPI
50 mm							3/4 TPI	3/4 TPI	2/3 TPI	2/3 TPI
80 mm								3/4 TPI	2/3 TPI	2/3 TPI
Over 100 mm									2/3 TPI	1.5/2 TPI

(1) : 8/12 TPI or 8/11 TPI for PROFIL-K
(2) : 5/8 TPI or 5/7 TPI for PROFIL-K

For bundle cuts:

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



BIMETAL BANDSAW BLADES
APPLICATIONS AND CUTTING PARAMETERS

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See you soon!

	Structural, decoiling and drawing steels	Structural steels, improvement steels
Materials	1.0037 : St37-2 : S235JR 1.0044 : St44-2 : S275JR 1.0301 : C10 1.0721 : 10S20	1.1181 : C35 : XC38 1.1191 : C45 : XC48 1.0402 : C22 : CC20 1.0501 : C35 : CC35

Blades		**STD-K / BSK / PROD-K / PROFIL-K**				**STD-K / BSK / PROD-K / PROFIL-K**			
Fluid		**SOLUKUT 10% to 15%**				**SOLUKUT 5% to 10%**			
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm³/min)	Cuitting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm³/min)	Cutting time (h:min:sec)
10 mm	6,4 mm	70	125 - 190	10 - 15	00:00:03 - 00:00:05	75	150 - 230	12 - 18	00:00:03 - 00:00:04
25 mm	6,4 mm	70	110 - 200	22 - 39	00:00:08 - 00:00:14	75	100 - 150	20 - 29	00:00:10 - 00:00:15
40 mm	9,5 mm	70	83 - 160	26 - 50	00:00:15 - 00:00:29	75	80 - 120	25 - 38	00:00:20 - 00:00:30
65 mm	9,5 mm	70	78 - 121	40 - 62	00:00:32 - 00:00:50	75	58 - 88	30 - 45	00:00:44 - 00:01:07
100 mm	12,7 mm	85	63 - 95	49 - 75	00:01:03 - 00:01:35	70	51 - 70	40 - 55	00:01:26 - 00:01:58
150 mm	19,0 mm	85	60 - 85	71 - 100	00:01:46 - 00:02:30	68	42 - 64	49 - 75	00:02:21 - 00:03:34
200 mm	27,0 mm	85	48 - 62	75 - 97	00:03:14 - 00:04:10	66	31 - 51	49 - 80	00:03:55 - 00:06:27
300 mm	34,0 mm	85	32 - 46	75 - 108	00:06:31 - 00:09:22	65	23 - 34	54 - 80	00:08:49 - 00:13:03
400 mm	41,0 mm	60	17 - 25	53 - 79	00:16:00 - 00:23:32	50	12 - 18	38 - 57	00:22:13 - 00:33:20
500 mm	41,0 mm	60	10 - 15	39 - 59	00:33:20 - 00:50:00	49	8 - 11	31 - 43	00:45:27 - 01:02:30
600 mm	54,0 mm	60	6 - 10	28 - 47	01:00:00 - 01:40:00	48	5 - 7,5	24 - 35	01:20:00 - 02:00:00
800 mm	67,0 mm	60	4,5 - 6	28 - 38	02:13:20 - 02:57:47	48	3 - 5	19 - 31	02:40:00 - 04:26:40
1000 mm	80,0 mm	45	2,5 - 4	20 - 31	04:10:00 - 06:40:00	45	2 - 3	16 - 24	05:33:20 - 08:20:00
1200 mm	80,0 mm	45	1,6 - 2,5	15 - 24	08:00:00 - 12:30:00	43	1,2 - 2	11 - 19	10:00:00 - 16:40:00
1500 mm	80,0 mm	45	1 - 1,6	12 - 19	15:37:30 - 25:00:00	41	0,8 - 1,2	9 - 14	20:50:00 - 31:15:00
2000 mm	80,0 mm	45	0,7 - 1,2	11 - 19	27:46:40 - 47:37:09	38	0,6 - 0,9	9 - 14	37:02:13 - 55:33:20

ALTINIUM

PROFIL-K and PROD-K blades are also available with a AlTiN coating.
Benefits : 30% higher productivity, optimized surface finish, longer durability (= less machine downtime / less blade stock, less waste).

	Case-hardening steels, low-alloyed for heat treatment, spring	Bearing steels
Materials	1.7131 : 16MnCr5 1.8159 : 50CrV4 1.7225 : 42CrMo4	1.3505 : 100Cr6 1.1663 : C125W

Blades		**STD-K / BSK / PROD-K / PROFIL-K**				**BSK / PROD-K / XTREM-K**			
Fluid		**SOLUKUT 5% to 10%**				**SOLUKUT 3%**			
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm³/min)	Cuitting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm³/min)	Cutting time (h:min:sec)
10 mm	6,4 mm	65	125 - 200	10 - 16	00:00:03 - 00:00:05	60	125 - 200	10 - 16	00:00:03 - 00:00:05
25 mm	6,4 mm	65	75 - 130	15 - 26	00:00:12 - 00:00:20	59	75 - 120	15 - 24	00:00:13 - 00:00:20
40 mm	9,5 mm	65	60 - 100	19 - 31	00:00:24 - 00:00:40	58	60 - 95	19 - 30	00:00:25 - 00:00:40
65 mm	9,5 mm	65	49 - 74	25 - 38	00:00:53 - 00:01:20	58	49 - 70	25 - 36	00:00:56 - 00:01:20
100 mm	12,7 mm	60	38 - 61	30 - 48	00:01:38 - 00:02:38	55	38 - 57	30 - 45	00:01:45 - 00:02:38
150 mm	19,0 mm	59	34 - 51	40 - 60	00:02:56 - 00:04:25	53	30 - 47	35 - 55	00:03:11 - 00:05:00
200 mm	27,0 mm	57	28 - 41	44 - 64	00:04:53 - 00:07:09	52	25 - 38	39 - 60	00:05:16 - 00:08:00
300 mm	34,0 mm	55	19 - 27	45 - 64	00:11:07 - 00:15:47	50	17 - 25	40 - 59	00:12:00 - 00:17:39
400 mm	41,0 mm	50	10 - 15	31 - 47	00:26:40 - 00:40:00	45	9 - 13	28 - 41	00:30:46 - 00:44:27
500 mm	41,0 mm	47	6 - 9	24 - 35	00:55:33 - 01:23:20	42	6 - 9	24 - 35	00:55:33 - 01:23:20
600 mm	54,0 mm	44	4 - 6	19 - 28	01:40:00 - 02:30:00	38	4 - 6	19 - 28	01:40:00 - 02:30:00
800 mm	67,0 mm	40	2,5 - 4	16 - 25	03:20:00 - 05:20:00	35	2,5 - 4	16 - 25	03:20:00 - 05:20:00
1000 mm	80,0 mm	37	1,5 - 2,5	12 - 20	06:40:00 - 11:06:40	33	1,5 - 2,5	12 - 20	06:40:00 - 11:06:40
1200 mm	80,0 mm	35	1,1 - 1,6	10 - 15	12:30:00 - 18:10:55	31	1 - 1,6	9 - 15	12:30:00 - 20:00:00
1500 mm	80,0 mm	34	0,6 - 1	7 - 12	25:00:00 - 41:40:00	29	0,6 - 1	7 - 12	25:00:00 - 41:40:00
2000 mm	80,0 mm	33	0,5 - 0,8	8 - 13	41:40:00 - 66:40:00	28	0,5 - 0,8	8 - 13	41:40:00 - 66:40:00

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Materials	High-speed steels	Alloyed tool steels
	1.3343 : Z85WDCV 06-05-04-02 1.3348 : Z100WCWV 09-04-02-02	1.2080 : X210Cr12 1.2379 : X155CrVMo12 1

Blades		BSK / PROD-K / XTREM-K				BSK / PROD-K / XTREM-K / REFRA-K / TITAN-K			
Fluid		NANOKUT 3% to 10%				NANOKUT 5% to 8%			
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm³/min)	Cuitting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm³/min)	Cutting time (h:min:sec)
10 mm	6,4 mm	50	90 - 140	7 - 11	00:00:04 - 00:00:07	35	64 - 89	5 - 7	00:00:07 - 00:00:09
25 mm	6,4 mm	49	60 - 90	12 - 18	00:00:17 - 00:00:25	34	40 - 61	8 - 12	00:00:25 - 00:00:38
40 mm	9,5 mm	48	48 - 70	15 - 22	00:00:34 - 00:00:50	33	32 - 48	10 - 15	00:00:50 - 00:01:15
65 mm	9,5 mm	47	33 - 53	17 - 27	00:01:14 - 00:01:58	32	22 - 35	11 - 18	00:01:51 - 00:02:57
100 mm	12,7 mm	45	25 - 42	20 - 33	00:02:23 - 00:04:00	30	16 - 28	13 - 22	00:03:34 - 00:06:15
150 mm	19,0 mm	43	21 - 34	25 - 40	00:04:25 - 00:07:09	28	15 - 23	18 - 27	00:06:31 - 00:10:00
200 mm	27,0 mm	42	19 - 29	30 - 46	00:06:54 - 00:10:32	26	11 - 18	17 - 28	00:11:07 - 00:18:11
300 mm	34,0 mm	40	12 - 19	28 - 45	00:15:47 - 00:25:00	25	8 - 11	19 - 26	00:27:16 - 00:37:30
400 mm	41,0 mm	36	8 - 12	25 - 38	00:33:20 - 00:50:00	24	5,5 - 9	17 - 28	00:44:27 - 01:12:44
500 mm	41,0 mm	34	5 - 8	20 - 31	01:02:30 - 01:40:00	23	3,5 - 6	14 - 24	01:23:20 - 02:22:51
600 mm	54,0 mm	31	4 - 5,7	19 - 27	01:45:16 - 02:30:00	21	2,5 - 4	12 - 19	02:30:00 - 04:00:00
800 mm	67,0 mm	29	2,4 - 3,5	15 - 22	03:48:34 - 05:33:20	20	2 - 2,5	13 - 16	05:20:00 - 06:40:00
1000 mm	80,0 mm	27	1,5 - 2,3	12 - 18	07:14:47 - 11:06:40	18	1 - 1,5	8 - 12	11:06:40 - 16:40:00
1200 mm	80,0 mm	25	1 - 1,6	9 - 15	12:30:00 - 20:00:00	17	0,7 - 1,1	7 - 10	18:10:55 - 28:34:17
1500 mm	80,0 mm	23	0,6 - 0,9	7 - 11	27:46:40 - 41:40:00	16	0,4 - 0,6	5 - 7	41:40:00 - 62:30:00
2000 mm	80,0 mm	22	0,4 - 0,7	6 - 11	47:37:09 - 83:20:00	15	0,3 - 0,5	5 - 8	66:40:00 - 111:06:40

ALTINIUM

PROFIL-K and PROD-K blades are also available with a AlTiN coating.
Benefits : 30% higher productivity, optimized surface finish, longer durability (= less machine downtime / less blade stock, less waste).

Materials	Upgrading and nitriding steels	Stainless steels
	1.2311 : 40CMD7 1.2344 : X40CrMoV51 1.2738 : 40CrMnNiMo8-6-4 1.2713 : 55NiCrMoV6 1.6582 : 34CrNiMo6	1.4308 : G-X6CrNi18 9 1.4306 : X2CrNi19 11 : 304L 1.4435 : X2CrNiMo18 12 : 316L

Blades		BSK / PROD-K / XTREM-K / REFRA-K / TITAN-K				STD-K / BSK / PROD-K / XTREM-K / REFRA-K / TITAN-K			
Fluid		NANOKUT 5% to 8%				NANOKUT 10% to 15%			
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm³/min)	Cuitting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm³/min)	Cutting time (h:min:sec)
10 mm	6,4 mm	65	125 - 200	10 - 16	00:00:03 - 00:00:05	40	75 - 100	6 - 8	00:00:06 - 00:00:08
25 mm	6,4 mm	65	75 - 130	15 - 26	00:00:12 - 00:00:20	39	40 - 50	8 - 10	00:00:30 - 00:00:38
40 mm	9,5 mm	65	60 - 100	19 - 31	00:00:24 - 00:00:40	38	32 - 38	10 - 12	00:01:03 - 00:01:15
65 mm	9,5 mm	65	49 - 74	25 - 38	00:00:53 - 00:01:20	37	20 - 27	10 - 14	00:02:24 - 00:03:15
100 mm	12,7 mm	60	38 - 61	30 - 48	00:01:38 - 00:02:38	35	15 - 19	12 - 15	00:05:16 - 00:06:40
150 mm	19,0 mm	59	34 - 51	40 - 60	00:02:56 - 00:04:25	34	10 - 17	12 - 20	00:08:49 - 00:15:00
200 mm	27,0 mm	57	28 - 41	44 - 64	00:04:53 - 00:07:09	33	9 - 16	14 - 25	00:12:30 - 00:22:13
300 mm	34,0 mm	55	19 - 27	45 - 64	00:11:07 - 00:15:47	32	6 - 10	14 - 24	00:30:00 - 00:50:00
400 mm	41,0 mm	50	10 - 15	31 - 47	00:26:40 - 00:40:00	28	3 - 5	9 - 16	01:20:00 - 02:13:20
500 mm	41,0 mm	47	6 - 9	24 - 35	00:55:33 - 01:23:20	26	2 - 3	8 - 12	02:46:40 - 04:10:00
600 mm	54,0 mm	44	4 - 6	19 - 28	01:40:00 - 02:30:00	24	1,5 - 2,5	7 - 12	04:00:00 - 06:40:00
800 mm	67,0 mm	40	2,5 - 4	16 - 25	03:20:00 - 05:20:00	22	1,3 - 1,5	8 - 9	08:53:20 - 10:15:23
1000 mm	80,0 mm	37	1,5 - 2,5	12 - 20	06:40:00 - 11:06:40	21	0,8 - 1	6 - 8	16:40:00 - 20:50:00
1200 mm	80,0 mm	35	1,1 - 1,6	10 - 15	12:30:00 - 18:10:55	21	0,5 - 0,7	5 - 7	28:34:17 - 40:00:00
1500 mm	80,0 mm	34	0,6 - 1	7 - 12	25:00:00 - 41:40:00	20	0,35 - 0,6	4 - 7	41:40:00 - 71:25:43
2000 mm	80,0 mm	33	0,5 - 0,8	8 - 13	41:40:00 - 66:40:00				

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

Blades		**XTREM-K / REFRA-K / TITAN-K**				**XTREM-K / REFRA-K / TITAN-K**			
Fluid		**NANOKUT 15%**				**NANOKUT 15% to 20%**			
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm²/min)	Cuitting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm²/min)	Cutting time (h:min:sec)
10 mm	6,4 mm	30	40 - 60	3 - 5	00:00:10 - 00:00:15	18	25 - 38	2 - 3	00:00:16 - 00:00:24
25 mm	6,4 mm	29	25 - 35	5 - 7	00:00:43 - 00:01:00	17	15 - 20	3 - 4	00:01:15 - 00:01:40
40 mm	9,5 mm	28	19 - 25	6 - 8	00:01:36 - 00:02:06	16	10 - 16	3 - 5	00:02:30 - 00:04:00
65 mm	9,5 mm	27	11 - 15	6 - 8	00:04:20 - 00:05:55	15	6 - 10	3 - 5	00:06:30 - 00:10:50
100 mm	12,7 mm	25	7 - 11	5 - 9	00:09:05 - 00:14:17	15	5 - 6,35	4 - 5	00:15:45 - 00:20:00
150 mm	19,0 mm	24	6 - 8	7 - 9	00:18:45 - 00:25:00	15	3 - 5	4 - 6	00:30:00 - 00:50:00
200 mm	27,0 mm	23	5 - 7	8 - 11	00:28:34 - 00:40:00	14	3 - 5	5 - 8	00:40:00 - 01:06:40
300 mm	34,0 mm	22	3 - 4	7 - 9	01:15:00 - 01:40:00	14	2 - 3,4	5 - 8	01:28:14 - 02:30:00
400 mm	41,0 mm	20	1,5 - 2	5 - 6	03:20:00 - 04:26:40	12	1,3 - 1,9	4 - 6	03:30:32 - 05:07:42
500 mm	41,0 mm	18	1 - 2	4 - 8	04:10:00 - 08:20:00	11	1 - 1,3	4 - 5	06:24:37 - 08:20:00
600 mm	54,0 mm	17	1 - 1,5	5 - 7	06:40:00 - 10:00:00	10	0,6 - 0,8	3 - 4	12:30:00 - 16:40:00
800 mm	67,0 mm	16	0,5 - 0,7	3 - 4	19:02:51 - 26:40:00	10	0,3 - 0,6	2 - 4	22:13:20 - 44:26:40
1000 mm	80,0 mm	15	0,3 - 0,5	2 - 4	33:20:00 - 55:33:20	10	0,3 - 0,4	2 - 3	41:40:00 - 55:33:20
1200 mm	80,0 mm								
1500 mm	80,0 mm								
2000 mm	80,0 mm								

PROFIL-K and PROD-K blades are also available with a AlTiN coating.
Benefits : 30% higher productivity, optimized surface finish, longer durability (= less machine downtime / less blade stock, less waste).

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

Lames		**BSK / PROD-K / XTREM-K**				**XTREM-K / REFRA-K / TITAN-K**			
Fluide		**NANOKUT 10% to 12%**				**NANOKUT 10%**			
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm²/min)	Cuitting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm²/min)	Cutting time (h:min:sec)
10 mm	6,4 mm	57	190 - 300	15 - 24	00:00:02 - 00:00:03	35	50 - 90	4 - 7	00:00:07 - 00:00:12
25 mm	6,4 mm	56	100 - 150	20 - 29	00:00:10 - 00:00:15	34	30 - 50	6 - 10	00:00:30 - 00:00:50
40 mm	9,5 mm	55	95 - 125	30 - 39	00:00:19 - 00:00:25	33	22 - 35	7 - 11	00:01:09 - 00:01:49
65 mm	9,5 mm	53	75 - 95	38 - 48	00:00:41 - 00:00:52	32	15 - 23	8 - 12	00:02:50 - 00:04:20
100 mm	12,7 mm	50	60 - 90	47 - 71	00:01:07 - 00:01:40	30	12 - 16	9 - 13	00:06:15 - 00:08:20
150 mm	19,0 mm	48	50 - 65	59 - 77	00:02:18 - 00:03:00	29	8 - 12	9 - 14	00:12:30 - 00:18:45
200 mm	27,0 mm	47	38 - 57	60 - 90	00:03:31 - 00:05:16	28	9 - 11	14 - 17	00:18:11 - 00:22:13
300 mm	34,0 mm	45	20 - 34	47 - 80	00:08:49 - 00:15:00	27	4 - 6	9 - 14	00:50:00 - 01:15:00
400 mm	41,0 mm	40	12 - 22	38 - 69	00:18:11 - 00:33:20	25	3 - 4	9 - 13	01:40:00 - 02:13:20
500 mm	41,0 mm	38	9 - 15	35 - 59	00:33:20 - 00:55:33	23	2 - 3	8 - 12	02:46:40 - 04:10:00
600 mm	54,0 mm	35	6 - 11	28 - 52	00:54:33 - 01:40:00	22	1,5 - 2,4	7 - 11	04:10:00 - 06:40:00
800 mm	67,0 mm	32	4 - 6	25 - 38	02:13:20 - 03:20:00	20	1 - 1,6	6 - 10	08:20:00 - 13:20:00
1000 mm	80,0 mm	30	2,5 - 4	20 - 31	04:10:00 - 06:40:00	18	0,5 - 0,9	4 - 7	18:31:07 - 33:20:00
1200 mm	80,0 mm	28	1,5 - 2,5	14 - 24	08:00:00 - 13:20:00				
1500 mm	80,0 mm	26	1,3 - 1,7	15 - 20	14:42:21 - 19:13:51				
2000 mm	80,0 mm	25	0,8 1,1	13 17	30:18:11 - 41:40:00				

BIMETAL BANDSAW BLADES
APPLICATIONS AND CUTTING PARAMETERS

These data are indicative, valid for materials in annealed, untempered condition.
They provide a good basis to define a new application.
In practice, you'll need to take into account your machines, your materials and your operating methods. We're here to help you, share our experience and know-how to keep improving your sawing station.

For personalized recommendations,
Flash this QR-code.
We will contact you.
See you soon!

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

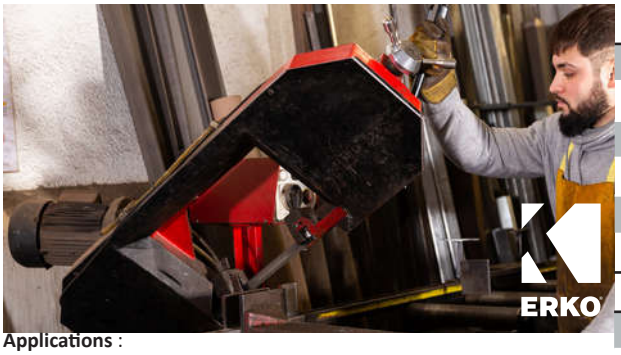
Blades		**ALU-K / BSK / STD-K**				**ALU-K / BSK**			
Fluid		**NANOKUT 10% to 25%**				**NANOKUT 25% to 0%**			
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm²/min)	Cuitting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm²/min)	Cutting time (h:min:sec)
10 mm	6,4 mm	120	450 - 1000	35 - 79	00:00:01 - 00:00:01	2500	7500 - 15000	589 - 1178	00:00:00 - 00:00:00
25 mm	6,4 mm	120	250 - 600	49 - 118	00:00:02 - 00:00:06	2500	4000 - 8000	785 - 1571	00:00:00 - 00:00:00
40 mm	9,5 mm	120	230 - 500	72 - 157	00:00:05 - 00:00:10	2500	3750 - 6250	1178 - 1963	00:00:00 - 00:00:01
65 mm	9,5 mm	120	190 - 400	97 - 204	00:00:10 - 00:00:21	2500	3000 - 4600	1532 - 2348	00:00:01 - 00:00:01
100 mm	12,7 mm	120	160 - 330	126 - 259	00:00:18 - 00:00:38	2500	2250 - 3250	1767 - 2553	00:00:02 - 00:00:03
150 mm	19,0 mm	120	130 - 250	153 - 295	00:00:36 - 00:01:09	2350	1800 - 2500	2121 - 2945	00:00:04 - 00:00:05
200 mm	27,0 mm	120	95 - 190	149 - 298	00:01:03 - 00:02:06	2250	1250 - 1750	1963 - 2749	00:00:07 - 00:00:10
300 mm	34,0 mm	120	60 - 125	141 - 295	00:02:24 - 00:05:00	2100	760 - 1050	1791 - 2474	00:00:17 - 00:00:24
400 mm	41,0 mm	120	45 - 95	141 - 298	00:04:13 - 00:08:53	2000	500 - 750	1571 - 2356	00:00:32 - 00:00:48
500 mm	41,0 mm	120	35 - 70	137 - 275	00:07:09 - 00:14:17	2750	300 - 550	1178 - 2160	00:00:55 - 00:01:40
600 mm	54,0 mm	120	27 - 55	127 - 259	00:10:55 - 00:22:13	2550	200 - 330	942 - 1555	00:01:49 - 00:03:00
800 mm	67,0 mm	120	10 - 40	63 - 251	00:20:00 - 01:20:00	2300	110 - 185	691 - 1162	00:04:19 - 00:07:16
1000 mm	80,0 mm	120	12 - 30	94 - 236	00:33:20 - 01:23:20	1110	65 - 12	511 - 94	01:23:20 - 00:15:23
1200 mm	80,0 mm	120	10 - 20	94 - 188	01:00:00 - 02:00:00	850	42 - 83	396 - 782	00:14:27 - 00:28:34
1500 mm	80,0 mm	120	7 - 15	82 - 177	01:40:00 - 03:34:17	750	26 - 46	306 - 542	00:32:37 - 00:57:42
2000 mm	80,0 mm	120	5 - 12	79 - 188	02:46:40 - 06:40:00	600	15 - 20	236 - 314	01:40:00 - 02:13:20

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

Blades		**ALU-K / BSK / STD-K**				**ALU-K / BSK / STD**			
Fluid		**NANOKUT 3% to 5%**				**NANOKUT 10% to 15%**			
Section	Band height mini recommended	Speed (m/min)	Descent (mm/min)	Flow rate (cm²/min)	Cuitting time (h:min:sec)	Speed (m/min)	Descent (mm/min)	Flow rate (cm²/min)	Cutting time (h:min:sec)
10 mm	6,4 mm	120	300 - 750	24 - 59	00:00:01 - 00:00:02	120	230 - 380	18 - 30	00:00:02 - 00:00:03
25 mm	6,4 mm	120	180 - 430	35 - 84	00:00:03 - 00:00:08	120	120 - 240	24 - 47	00:00:06 - 00:00:13
40 mm	9,5 mm	120	150 - 300	47 - 94	00:00:08 - 00:00:16	120	110 - 190	35 - 60	00:00:13 - 00:00:22
65 mm	9,5 mm	120	120 - 230	61 - 117	00:00:17 - 00:00:33	120	94 - 140	48 - 71	00:00:28 - 00:00:41
100 mm	12,7 mm	120	90 - 200	71 - 157	00:00:30 - 00:01:07	110	75 - 120	59 - 94	00:00:50 - 00:01:20
150 mm	19,0 mm	120	80 - 160	94 - 188	00:00:56 - 00:01:52	110	63 - 100	74 - 118	00:01:30 - 00:02:23
200 mm	27,0 mm	120	75 - 150	118 - 236	00:01:20 - 00:02:40	110	60 - 90	94 - 141	00:02:13 - 00:03:20
300 mm	34,0 mm	120	50 - 100	118 - 236	00:03:00 - 00:06:00	110	42 - 55	99 - 130	00:05:27 - 00:07:09
400 mm	41,0 mm	120	38 - 80	119 - 251	00:05:00 - 00:10:32	1000	28 - 38	88 - 119	00:10:32 - 00:14:17
500 mm	41,0 mm	120	30 - 60	118 - 236	00:08:20 - 00:16:40	92	20 - 25	79 - 98	00:20:00 - 00:25:00
600 mm	54,0 mm	120	25 - 45	118 - 212	00:13:20 - 00:24:00	86	14 - 19	66 - 90	00:31:35 - 00:42:51
800 mm	67,0 mm	120	15 - 30	94 - 188	00:26:40 - 00:53:20	80	7 - 10	44 - 63	01:20:00 - 01:54:17
1000 mm	80,0 mm	120	11 - 22	86 - 173	00:45:27 - 01:30:55	75	4 - 6,4	31 - 50	02:36:15 - 04:10:00
1200 mm	80,0 mm	120	6 - 13	57 - 123	01:32:18 - 03:20:00	70	3 - 4,2	28 - 40	04:45:43 - 06:40:00
1500 mm	80,0 mm	120	5 - 9	59 - 106	02:46:40 - 05:00:00	65	1,9 - 3	22 - 35	08:20:00 - 13:09:28
2000 mm	80,0 mm	120	3,2 - 6	50 - 94	05:33:20 - 10:25:00	60	1,1 - 1,9	17 - 30	17:32:38 - 30:18:11

BIMETAL BANDSAW BLADES





ERKO STD-K :
THE MULTI-USE BAND
STEEL, STAINLESS STEEL, NON-FERROUS

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

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

ERKO STD-K

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

Available toothing (TPI)

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





ERKO BSK :
THE INTENSE MULTI-USE BAND
STEEL, STAINLESS STEEL, NON-FERROUS

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

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

ERKO BSK

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

Available toothing (TPI)

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



BIMETAL BANDSAW BLADES





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

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

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

ERKO PROFIL-K

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

Available toothing (TPI)

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





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

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

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

Teeth shapes :
- large swarf chamber,
- very positive teeth KH 10°

ERKO PROD-K

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

Available toothing (TPI)

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



BIMETAL BANDSAW BLADES



ERKO PROFIL - K ALTINIUM :

VERY HIGH PRODUCTIVITY FOR BEAMS AND PROFILES

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

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

ERKO PROFIL-K

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

Available toothing (TPI)

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



ERKO PROD - K ALTINIUM :

VERY HIGH PRODUCTIVITY IN BIG SECTIONS

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

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

Teeth shapes :
- large swarf chamber,
- very positive teeth KH 10°

ERKO PROFIL-K

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

Available toothing (TPI)

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



BIMETAL BANDSAW BLADES



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

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

Up to 45HRC

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

ERKO XTREM-K

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

Available toothing (TPI)

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



ERKO ALU-K :
FOR ALUMINUM

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

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

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

ERKO PROD-K

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

Available toothing (TPI)

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



BIMETAL BANDSAW BLADES



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

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

Need of excellent finish and high-production.
Up to 45HRC

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

ERKO REFRA-K

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

Available toothing (TPI)

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



ERKO TITAN-K
FOR CUTTING TITANIUM ALLOYS

Applications :
- Titanium-base alloy - Nickel-base alloy

Need of excellent finish and high-production.
Up to 45HRC

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



ERKO REFRA-K

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

Available toothing (TPI)

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