Are you pleased with your output?

We can take you one step higher!

“Needs are what govern us and they start with our customers. Our business is to design & manufacture saw blades delivering cost effective cutting solutions, contributing to our customers competitiveness and profitability”

As a supplier of sawblades, this means helping our customers to achieve the right quality of cut with respect to sizing and surface quality which saves precious raw materials and costly after-working.

We know what is required and as with any kind of manufacturing the end result depends on several factors. The craftmanship and per-sonal commitment, combined with a constant effort to improve and develop ourselves provides us with the high and consistent level of quality which we are very proud of.

Better utilisation of raw materials

- Higher yields
- Improved sawing accuracy
- Improved surface finish

Improved efficiency

- Less re-sharpening = reduced maintenance
- Higher feed speed

Improved operational reliability

- Less downtime

Contact us and we will help you find a solution that fits your specific needs for optimal yield, operational time and function.

Assortment

The items covered by this catalogue represent a selection of common saw blades, divided by market segment and product group. A selection of these, marked with * in the catalogue, are kept in stock for immediate delivery while others are supplied to order. For further details concerning time of delivery please contact our sales department.

In addition to the products you find in this catalogue, we annually produce a large number of customised blades for a variety of application areas. If you do not find what you are looking for – contact us or your local representative to discuss any changes required for your specific needs. To ensure that we produce the right type of blade we recommend that you send us a drawing or alternatively use our pre-inquiry form which you can find at the end of this catalogue or as pdf for download on our website.

Order information

How to select the right sawblade?

Our range of saw blades covers cutting of most materials being processed in the wood, metal, plastic and food industries. How the blade should be designed mainly depends on the properties of the materials, how it is processed and type of machinery used. The design of the blades tips (geometry), their number, width, angle and individual distance (pitch), varies depending on the situation as well as the application.

To facilitate the process of selecting the right blade, we have developed a coding system that makes it easy to choose the right sawblade. By following our instructions you are able to design a blade which fits with your needs.

On the following pages we take you through our guidelines which eventually lead to a code for your specific blade design. As an alternative you can also use our pre-inquiry form where you can fill in all relevant informations. The more information you give us the better are our prospects to design the right blade!

Code system

10 BA 19 L - 500 - 4,2 / 3,2 - 50 Z 120

Rake angle	Tip type	Pitch	Design	Diameter	Kerf	Plate	Center hole	No of teeth

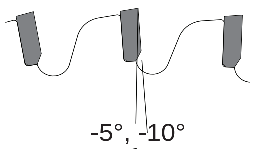
The coding system has been developed to simplify the description of the design of the blade. In this example the code indicates:

-- A positive rake angle of 10°. Negative angle would be indicated by an N before the angle
-- Tip type BA describes the tip geometry.
-- 19mm states the tooth pitch which is the distance between the tips
-- The suffix L indicates that the body has laserslots (for reduced noise level)

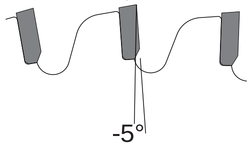
Rake angle

The rake angle depends on the material, type of cut, and in some cases the type of machine being used. The following are recommended rake angles for various materials and applications.

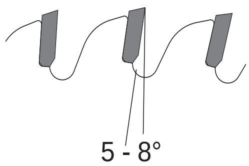
Crosscutting of wood in pendulum, chop saws, parallel cutting and edge band cutting.



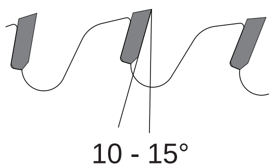
Cutting of non-ferrous metals, plastic and laminates with manual feed.



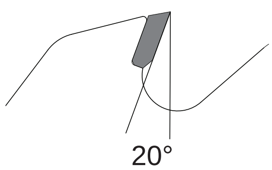
Cutting of hard plastics, veneered and laminated boards, mitrecutting of wood and non-ferrous metals.



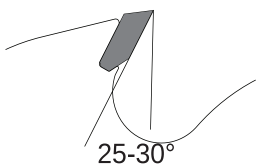
Crosscutting of wood and panel sizing of fibreboard, plasterboard, chipboard, veneered board and plywood.



Ripping of dry or green wood.

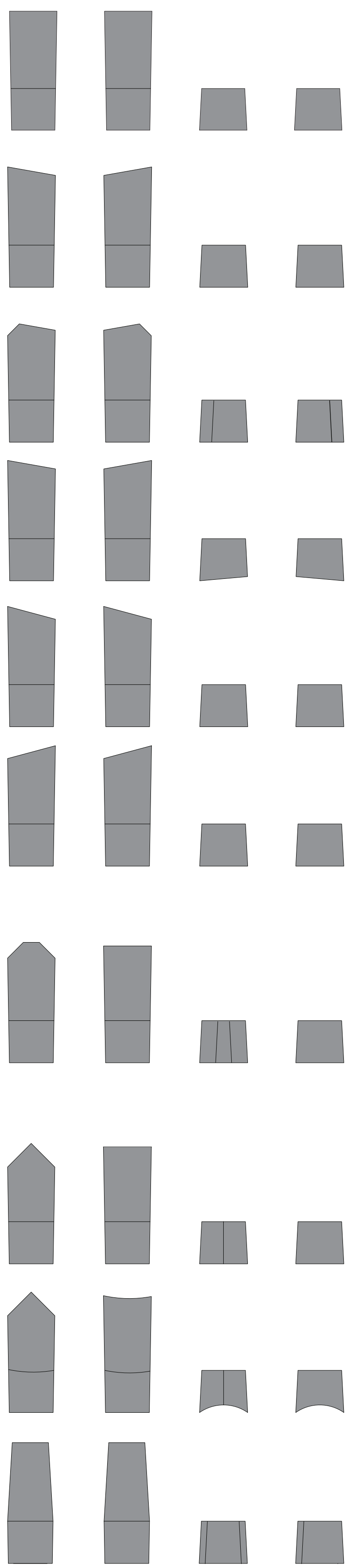


Ripping and edging of green wood.



Tip Types:

Front view Top view



AA
Straight teeth. For ripping wood, including multirip sawing. Can be used with high feed speeds where an average surface finish is required. Especially suited multi-rip sawing and edging.

BA
Teeth with alternating bevels
For ripping and crosscutting wood, board and plastics.

BAE
Teeth with alternating bevels and chamfer for thin, hard plastics.

BB
Teeth with alternating bevels and alternating face.
Specially suitable for plywood and bobbins.

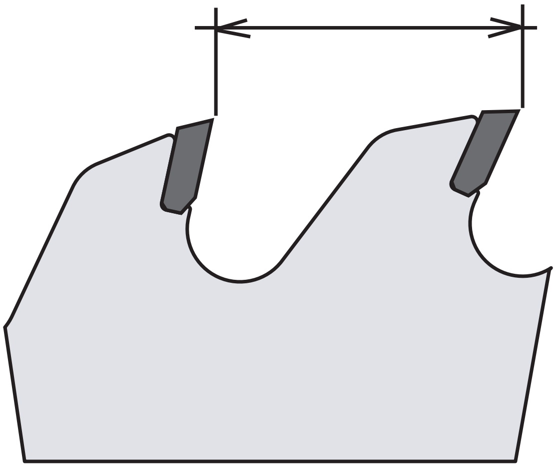
CA
Teeth with right-hand bevels.
DA
Teeth with left-hand bevels.
All teeth are bevelled in the same direction, either right or left. Used for scribing, tenoning, edge band cutting and panel sizeing of board in combination with hogging unit.

EA/EAM
Trapezoidal teeth
Roughing and finishing teeth. Teeth are cut alternately trapezoidal and straight to break chips into three pieces.
EA
For cutting laminated and non-laminated chipboard, fibreboard and MDF. Also suitable for plastic and laminates.
EAM
For cutting non-ferrous metals.

EAX
Alternate flat and inverted V tooth.
For cutting laminated board.

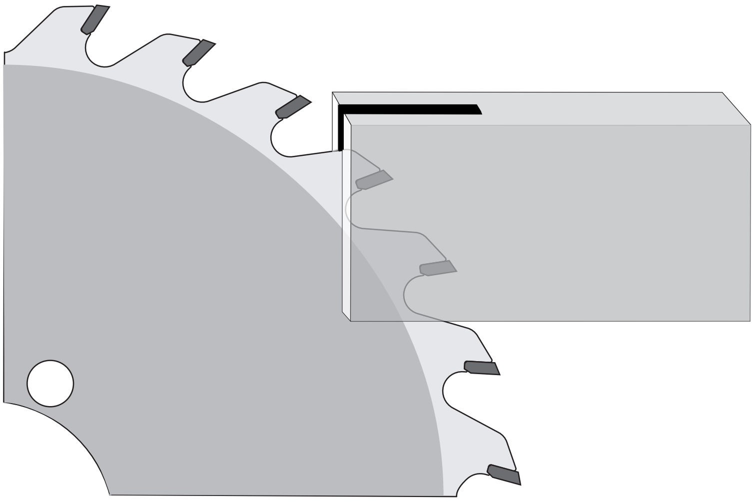
EAXH
Alternate flat and inverted V tooth, with hollow ground face.
For cutting painted and laminated board.

RA
Flat teeth with tapered sides
For scribing prior to panel sizing.



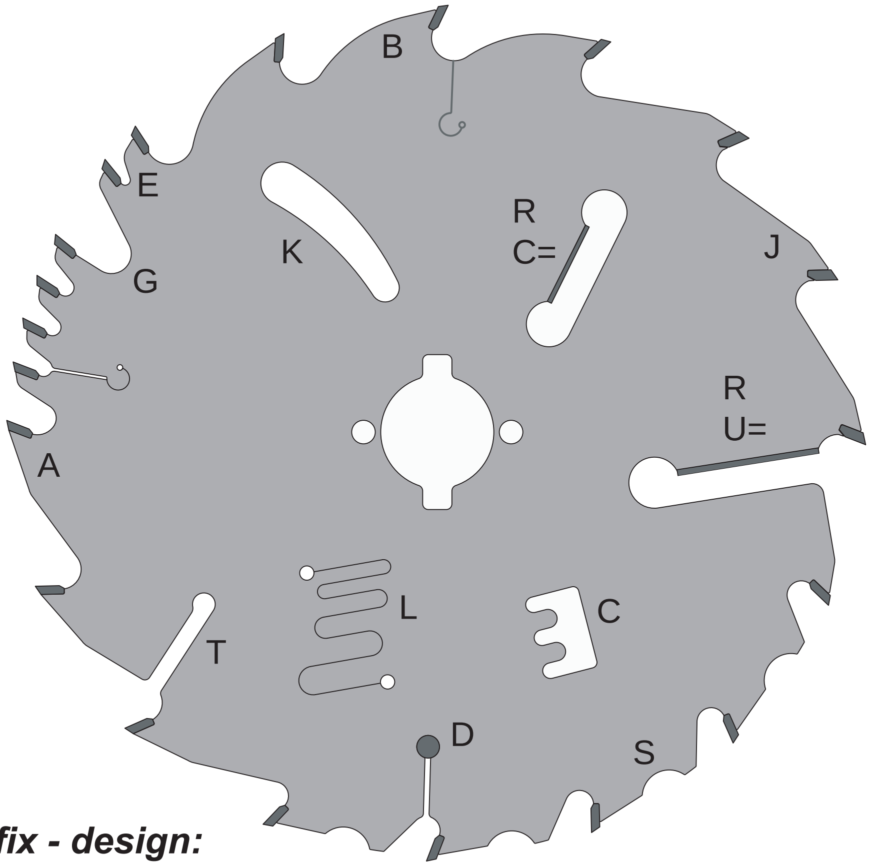
Tooth pitch:

Tooth pitch is an important factor when choosing blades for different types of work. The pitch is the distance between the front faces of adjacent teeth.



Number of teeth:

The tooth pitch is determined by the thickness of the material to be cut. Generally, the thinner the material the smaller the tooth pitch, and the thicker the material the larger the tooth pitch. At least two and no more than four teeth must be engaged at all times when cutting solid wood. For other materials two to six teeth should be engaged.



Suffix - design:

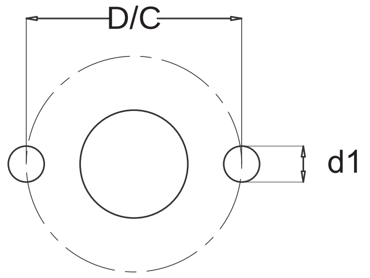
Special designs of blade are available for different cutting applications. This is indicated by the suffixes below, which appear after the tooth pitch in the code.

A = Tooth back with step
B = Curved back
C = E-cooling hole
D = Copper rivet
E = Small gullets
F = Adjustable 2 piece scribing blade
G = Grouped teeth blade
H = Stellite type
I = Differential pitch
J = Insert tooth
K = Cooling hole
L = Laser slot
M = Metal cutting blade

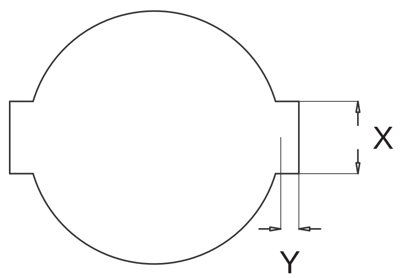
N = Blanks
O = Conical plate
P = Electric hand saw blade
Q = Minibel, Sandwichtype
R = Blade with wiper slot
S = Blade with guard teeth
T = Special slot
U = Panel saw blades
V = Teeth with chip-breaker
W = Double-sided hub
X = Blade with hub
Y = Simplified design

Blades with pin holes or keyways:

When ordering please indicate the following:



Pin holes
1 Number of pin holes (P)
2 Diameter of pin holes (d1)
3 Pitch circle (D/C)
Ex. P=2/10/60

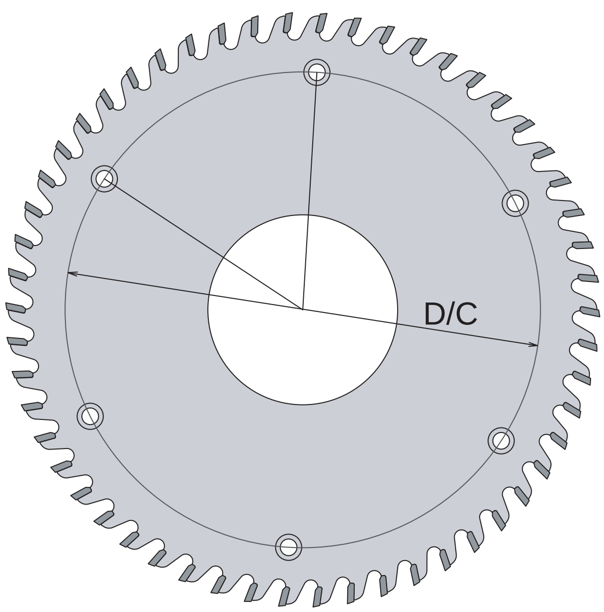


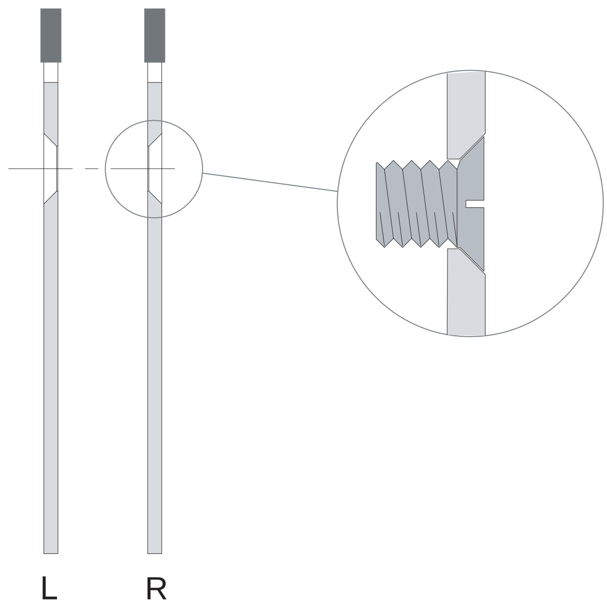
Keyways
1 Number of keyways (K)
2 Width of keyway (X)
3 Depth of keyway (Y)
Ex. K=2/20/5

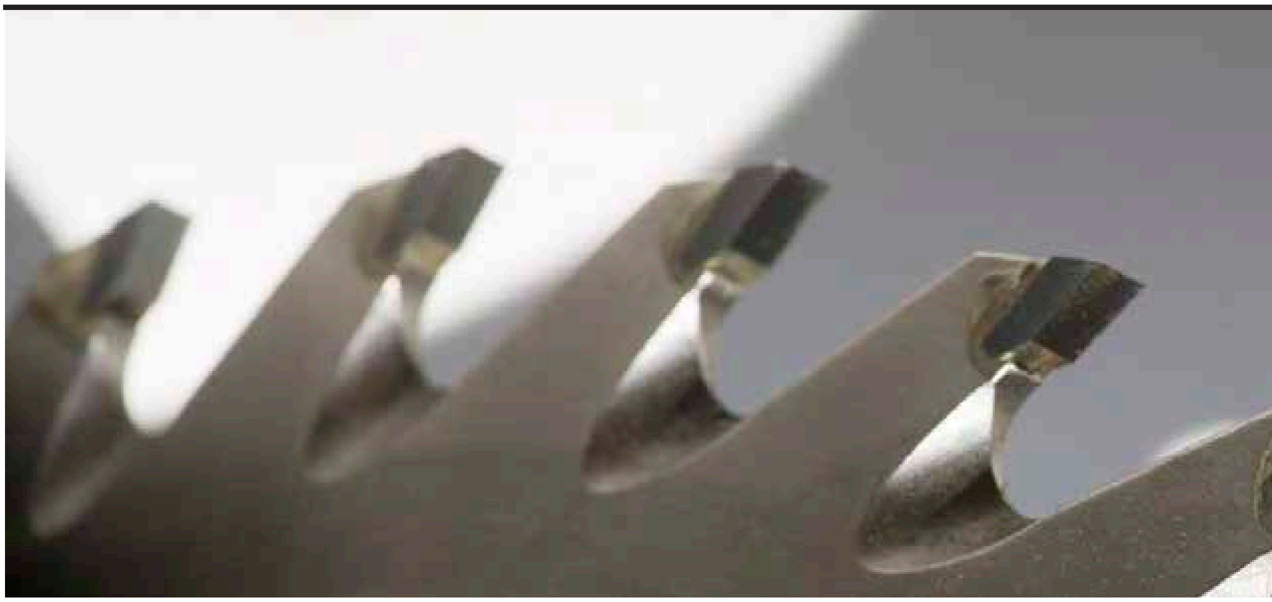
Blades with screw holes:

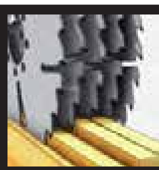
A drawing should always be enclosed when ordering these blades. If not avalible, please provide the following information:

1 Type of of hogging unit, etc.
2 Number of screw holes (S)
3 Pitch circle of screw holes (D/C)
4 Screw hole countersunk, right (R) or left (L), with the blade held so that the teeth on the top edge point towards you.
5 Screw size (e.g. M6, M8)
Ex. S=4/7/140/12/45/L









Saw mill

Increased productivity demands high quality tools

Increased productivity is essential for all businesses in the fight for market share. The sawmill industry is no exception and there are continuing efforts to achieve increased profitability through improved yield and various rationalizations in order to cut costs and shorten lead-times.

What is needed are stable saw blades with high sawing accuracy that even at higher feed rates provide a high quality cut and optimal running time to avoid unnecessary and costly downtime.

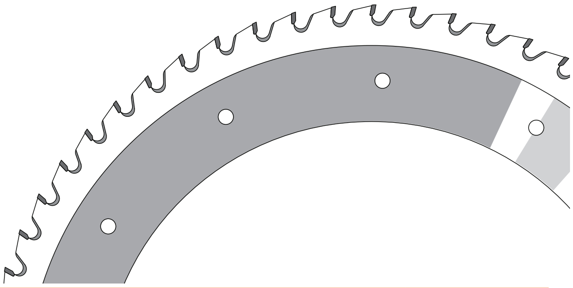
We've got what it takes!

Our range of sawmill blades are manufactured using exra durable high alloy steel. To achieve best possible cutting performance, the blades are equiped with different carbid qualities depending on application. For additional information and our recommendations see page 44 or contact us!

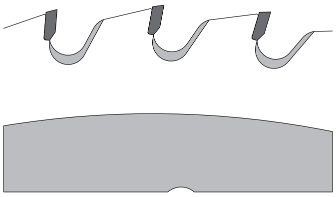
In addition to our skills in development and manufacturing, we also have extensive knowledge about the different types of machinery and the customisation necessary to achive the optimum sawing result.

Reducers / Chipper canter

With chamfered gullets for optimal chipflow

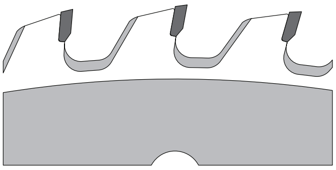


Ari



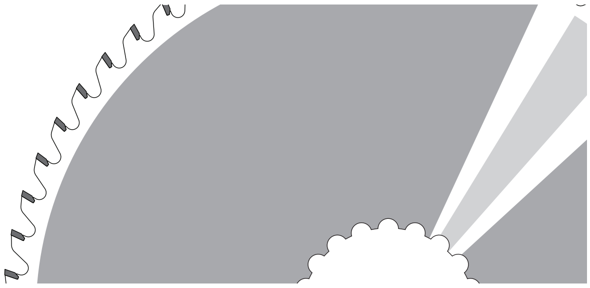
Art no	*Type*	*Info*	*Price*
33923	10AA35X-660-4,7/3,2-7,0-460	Z=60 S=12/13/530/34//R	
33924	10AA35X-660-4,7/3,5-7,0-460	Z=60 S=12/13/530/34//L	
34187	10AA38-588-8,4/7,0-460	Z=48 S=6/13/495/34//R	

Söderhamn



Art nr	*Typ*	*Info*	*Price*
33927	10AA41X-625-4,0/3,2-6,0-440	Z=48 S=16/16/505/26//R	
33928	10AA41X-625-4,0/3,2-6,0-440	Z=48 S=16/16/505/26//L	
33931	10AA43X-650-4,0/3,2-6,0-480	Z=48 H=580 S=16/16/545/26//R	
33932	10AA43X-650-4,0-3,2/6,0-480	Z=48 H=580 S=16/16/545/26//L	
33937	10AA35X-710-4,4/3,4-6,0-560	Z=64 S=16/16/605/26//R	
33938	10AA35X-710-4,4/3,4-6,0-560	Z=64 S=16/16/605/26//L	
35061	10AA31X-715-4,5/6,0-560	Z=72 S=18/16/605/26//R	
35060	10AA31X-715-4,5/3,6-6,0-560	Z=72 S=18/16/605/26//L	
33939	10AA38X-720-4,0/3,2-6,0-560	Z=60 S=16/16/605/26//R	
33940	10AA38X-720-4,0/3,2-6,0-560	Z=60 S=16/16/605/26//L	
33941	10AA38X-720-4,0/3,2-6,0-560	Z=60 S=18/16/605/26//R	
33942	10AA38X-720-4,0/3,2-6,0-560	Z=60 S=18/16/605/26//L	

Edging **-** Manufactured in special steel and equipped with extra durable tips for maximum wear resistance at high feed rates and strain, even in winter.



Catech

	Art no	Type	Info	Price
	21886	10BA(05)32AJ-500-5,0/3,5-SPL2	Z=48	
*	31092	12BA(15)26AJ-500-5,0/3,5-SPL2	Z=60	
	34490	15BA(05)36H-500-5,0/3,5-SPL2	Z=44	

Söderhamn

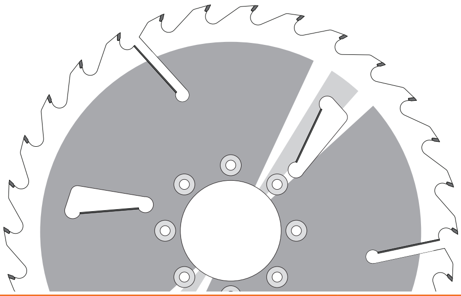
	Art no	Type	Info	Price
*	33225	22BA(05)27AJR-400-5,0/3,5-146	Z=46 P=6/13/172 U2=45 C2=40	
*	43261	22BA(05)31HJR-400-5,2/3,8-146	Z=40 P=6/13/172 U2=45 C2=45	
	42530	27BA(05)22AJR-400-5,0/3,6-72	Z=56 P=4/13/140 U2=50 C2=45	

Ahlström

Art no	Type	Info	Price
31034	18BA(05)25AJ-350-4,0/3,0-150	Z=44 P=2/11/170	

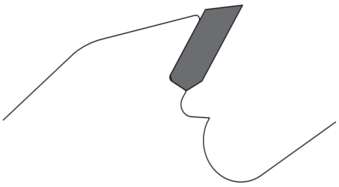
Ari / Vislanda

Canter and split saws for Ari/Vislanda Sawcommander.
Manufactured with fixed or loose hub. Also available with countersunk holes from both sides.
Can be delivered with or w/o chrome.



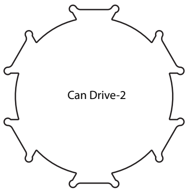
Art no	*Type*	*Info*	*Price*
39588	30BA(05)56JR-540-5,3/3,8-120-Cr	Z=30 S=8/M12/156/R+8/M12/156/L	
46590	30BA(05)56AJRX-540-5,3/3,8-6,8-120	Z=30 P=4/18/156 S=8/13/156/R	
46591	30BA(05)56AJRX-540-5,3/3,8-6,8-120	Z=30 P=4/18/156 S=8/13/156/L	

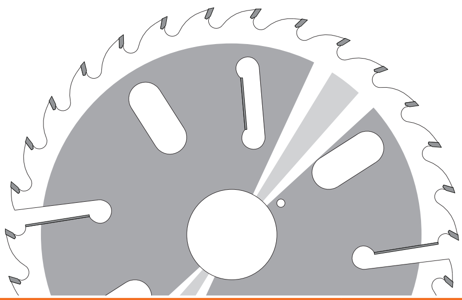
Splittingblades



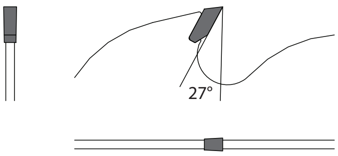
Art no	*Type*	*Info*	*Price*
30847	27AA46HV-700-4,2/2,8-SPL2	Z=48 Stellit	
33199	27BA(08)46V-700-4,4/3,0-SPL-2	Z=48	
46446	27EA46V-700-4,0/2,8-CD2	Z=48	
46514	27EA46V-700-4,2/2,8-SPL2 Spec	Z=48	
29924	27AA46HV-700-4,2/3,0-SPL2	Z=48 Stellit	
34257	27BA0546HV-700-4,4/3,0-CD-1	Z=48 Stellit	
32146	27EA46V-700-4,4/3,0-Spl2	Z=48	

Delivered with HM or equivalent to Stellite tips. Bore - Spl 2, CanDriv - or 2.

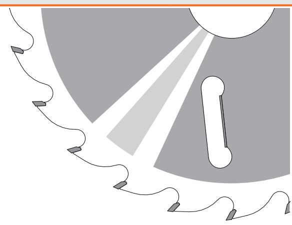




Hew/Saw, *Splittingblades*

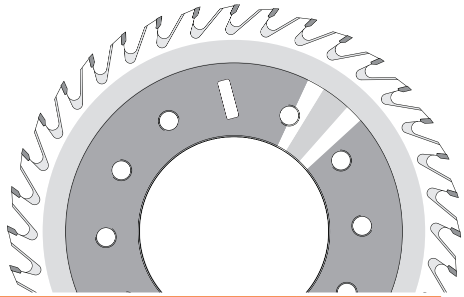


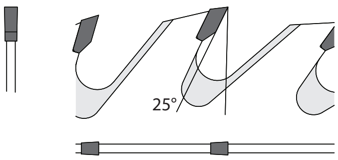
Art no	*Type*	*Info*	*Price*
22801	27AA46BJR-351-3,6/2,4-70	Z=24 U2=50	
27603	27AA46BJR-351-3,8/2,6-70	Z=24 U2=50 C2=40 P=1/6/90	
26862	27AA46BJR-351-3,8/2,6-70	Z=24 U2=50 C2=40	
44520	27AA46BJR-351-4,0/2,8-70	Z=24 U2=50 C2=40	
41929	25AA37BJR-351-3,8/2,6-70	Z=30 U2=50 C2=40 P=1/6/90	
31660	25AA37BJR-351-3,8/2,6-70	Z=30 U2=50 C2=40	



Hew Saw – Presawing

With chamfered gullets for optimal chipflow
New: Available with removable and reversible plug for reduced residue adhesion and friction which enables higher feeding rates





	Art no	Type	Info		Price
*	25680	25AA30AJX-345-3,8/2,9-144	Z=36	H=256/10,7/L	
*	25681	25AA30AJX-345-3,8/2,9-144	Z=36	H=256/10,7/R	
	34313	25AA30AJX-345-4,1/3,1-10,7-144	Z=36	H=256/10,7/L	
	34314	25AA30AJX-345-4,1/3,1-10,7-144	Z=36	H=256/10,7/R	
*	25678	25AA30AJX-345-4,7/3,8-144	Z=36	H=256/10,7/R	
*	25679	25AA30AJX-345-4,7/3,8-144	Z=36	H=256/10,7/L	
	34848	25AA30AJX-345-4,7/3,8-144	Z=36	H=256/10,7/R Plug	
	34849	25AA30AJX-345-4,7/3,8-144	Z=36	H=256/10,7/L Plug	
*	35178	25AA30AJX-345-3,8/2,9-144	Z=36	H=256/10,7/L Plug	
*	35179	25AA30AJX-345-3,8/2,9-144	Z=36	H=256/10,7/R Plug	
	43388	25AA31JW-390-4,3/3,1-8,7-190	Z=39	H=305/8,7/L	
	43389	25AA31JW-390-4,3/3,1-8,7-190	Z=39	H=305/8,7/R	

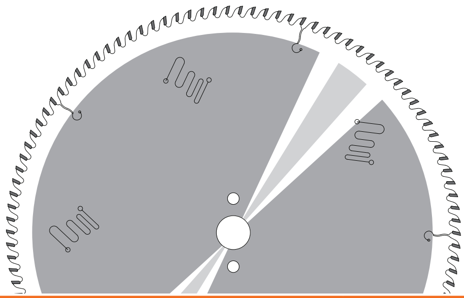
We also produce blades for Linck, EWD...........

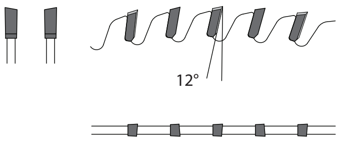
Splitting blades, Hubblades, Segments.......

when performance counts

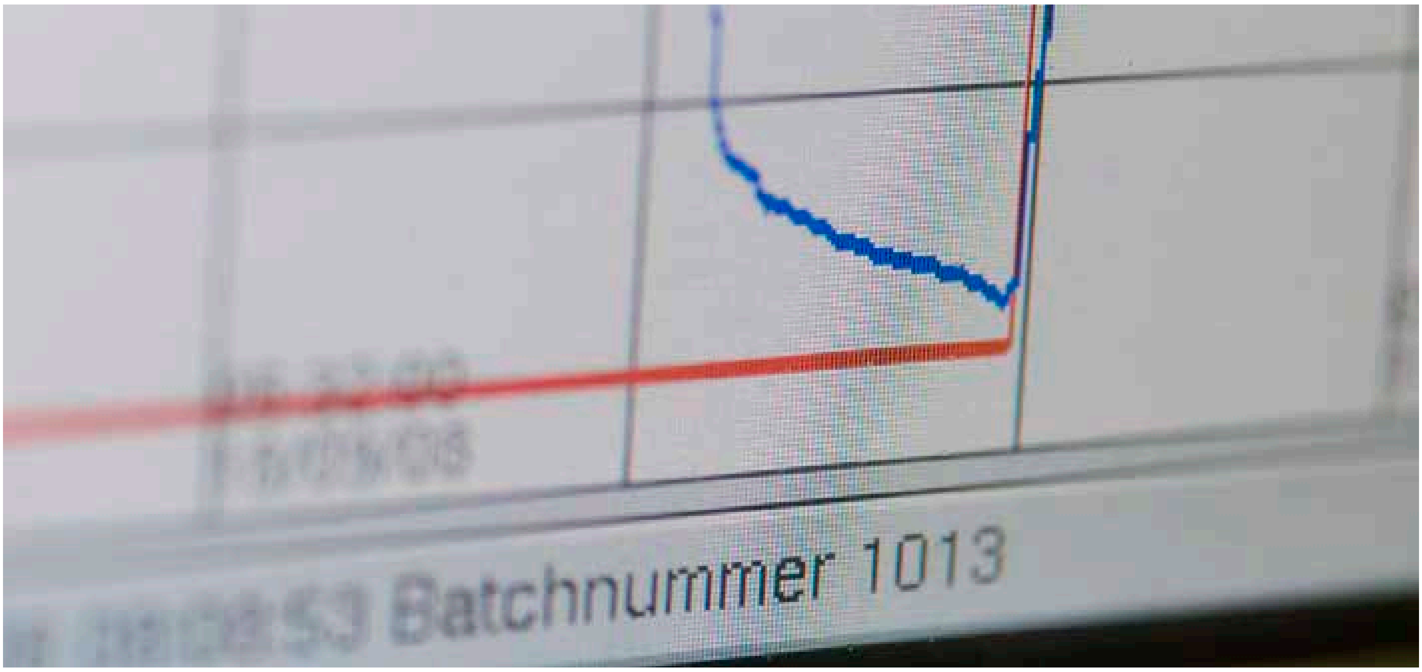
Trim and crosscutting sawblades

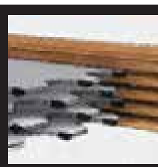
Manufactured with the highest precision for optimum cut quality and performance at high speeds. Delivered as standard with filled laserslots.





	Art no	Type	Info	Price
	45740	12BB10L-400-4,0/3,0-30	Z=120	
	45156	12BB10L-450-4,2/3,2-40	Z=140 P=4/14/95	
*	43827	12BB12L-500-4,2/3,2-50	Z=132 P=1/13/80	
	46459	12BB12L-500-4,2/3,2-90	Z=132	
*	44295	12BB13L-500-4,2/3,2-50	Z=120 P=1/13/80	
	44306	12BB16L-500-4,2/3,2-50	Z=100 P=1/13/80	





Floor & Multi rip

Cost efficient wood processing

Rip-sawing and lengthwise cutting, represents the first processing step of any solid-wood working. Faults during cutting, continue through the entire subsequent production and have a lasting negative influence on the operating result.

At Micor we have long experience in the development of saw blades which can meet these high demands on precision and performance. A good example is our high speed splitting blades Micor X-act allowing to achieve the same surface of the split wood like it was planed, which will save one processing step!

Soft and fine cuts with thin kerf blades from Micor

Thin kerf blades are most frequently used when manufacturing floor elements (top layer of parquets and planks), but are also suitable for many other applications where a thin, high quality cut is required.

With our unique manufacturing techniques, we can now produce saw blades that provides and extremly thin cut, which in some areas of application involves cutting width of down to 0,7mm!

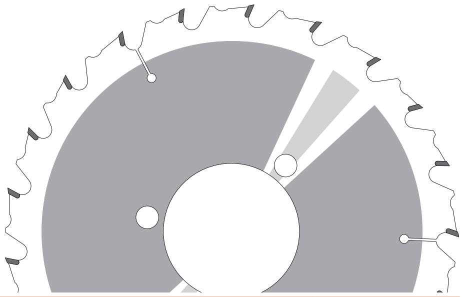
It's afterwards you notice the difference!

We can also offer a selection of carefully selected coatings, minimizing friction and reduce the problems of heat/resin build-up, leading to longer running time and improved output.

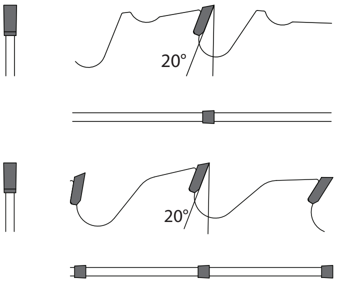
We are your partner, particularly in the development of technically demanding, customised blades - set us a challenge!
when performance counts

Multi-rip blades for wood floor industry

With a specially treated sawbody to ensure stability and cut quality also at high strain.

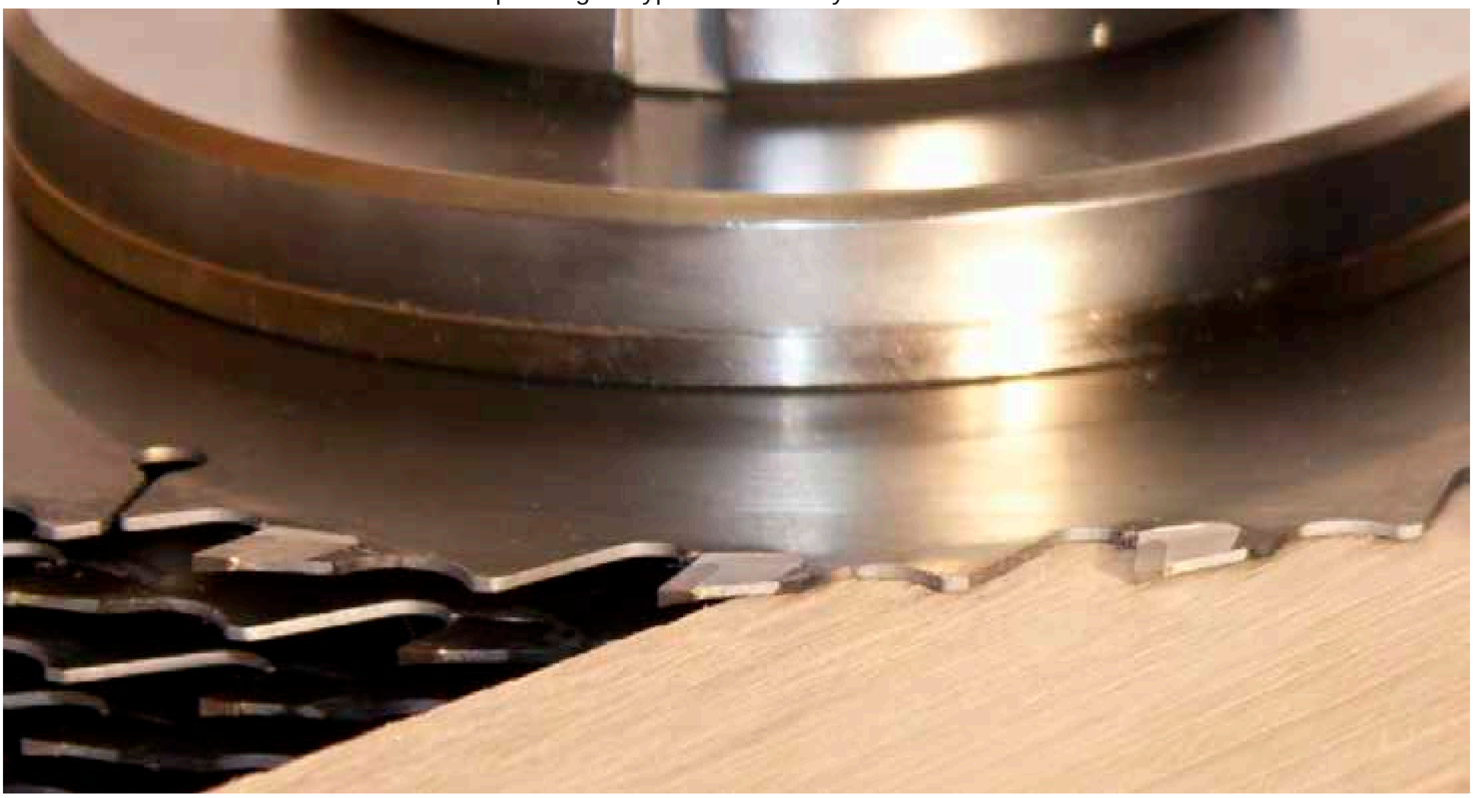


Superthin splitting blades for mounting on hydro sleeves.

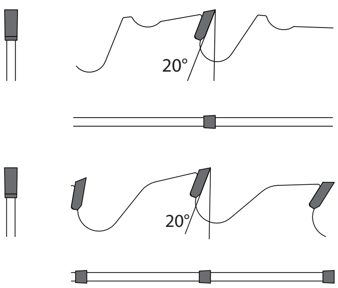


Art no	*Type*	*Info*	*Price*
42706	20AA27J-180-1,0/0,7-65	Z=21 P=3/9/80	
44817	20AA29AJ-220-1,2/0,9-65	Z=24 P=3/9/80	
42222	20AA29AJ-220-1,4/1,0-65	Z=24 P=3/9/80	
45624	20AA29AS-200-1,2/0,9-60	Z=22	
45150	20AA32R-225-1,4/1,0-70	Z=22 K=2/20/7 U2=35	
40267	20AA33IJS-200-1,2/0,9-60	Z=19	
45147	20AA35JS-200-1,3/0,8-70	Z=18 K=2/21/6	
45571	20AA35JS-200-1,4/0,9-70	Z=18 K=2/21/6	
42951	25AA29AJ-220-1,3/0,9-60	Z=24 P=3/10/76	

Can also be delivered with other bores depending on type of machinery.



Edging blades for mounting together with the splitting blades.

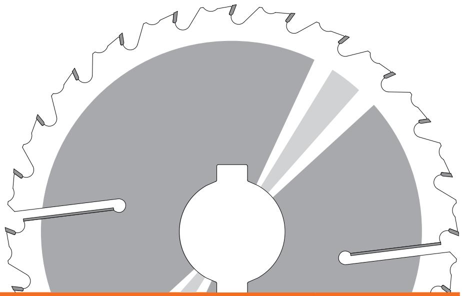


Art no	Type	Info	Price
	20AA27A-180-5,0/4,0-60	Z=21 P=3/10/74	
	20AA27AS-180-5,0/4,0-60	Z=21 P=3/10/74	
	20AA30A-200-5,0/4,0-60	Z=21 P=3/10/74	
	20AA30AS-200-5,0/4,0-60	Z=21 P=3/10/74	
	20AA30A-225-5,0/4,0-60	Z=24 P=3/10/74	
	20AA30AS-225-5,0/4,0-60	Z=24 P=3/10/74	
	20AA30A-250-5,0/4,0-60	Z=26 P=3/10/74	
	20AA30A-S250-5,0/4,0-60	Z=26 P=3/10/74	

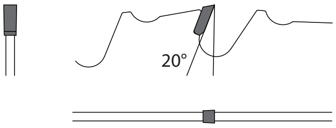
Can also be delivered with other bores depending on type of machinery.

Multi-rip blades for moulders

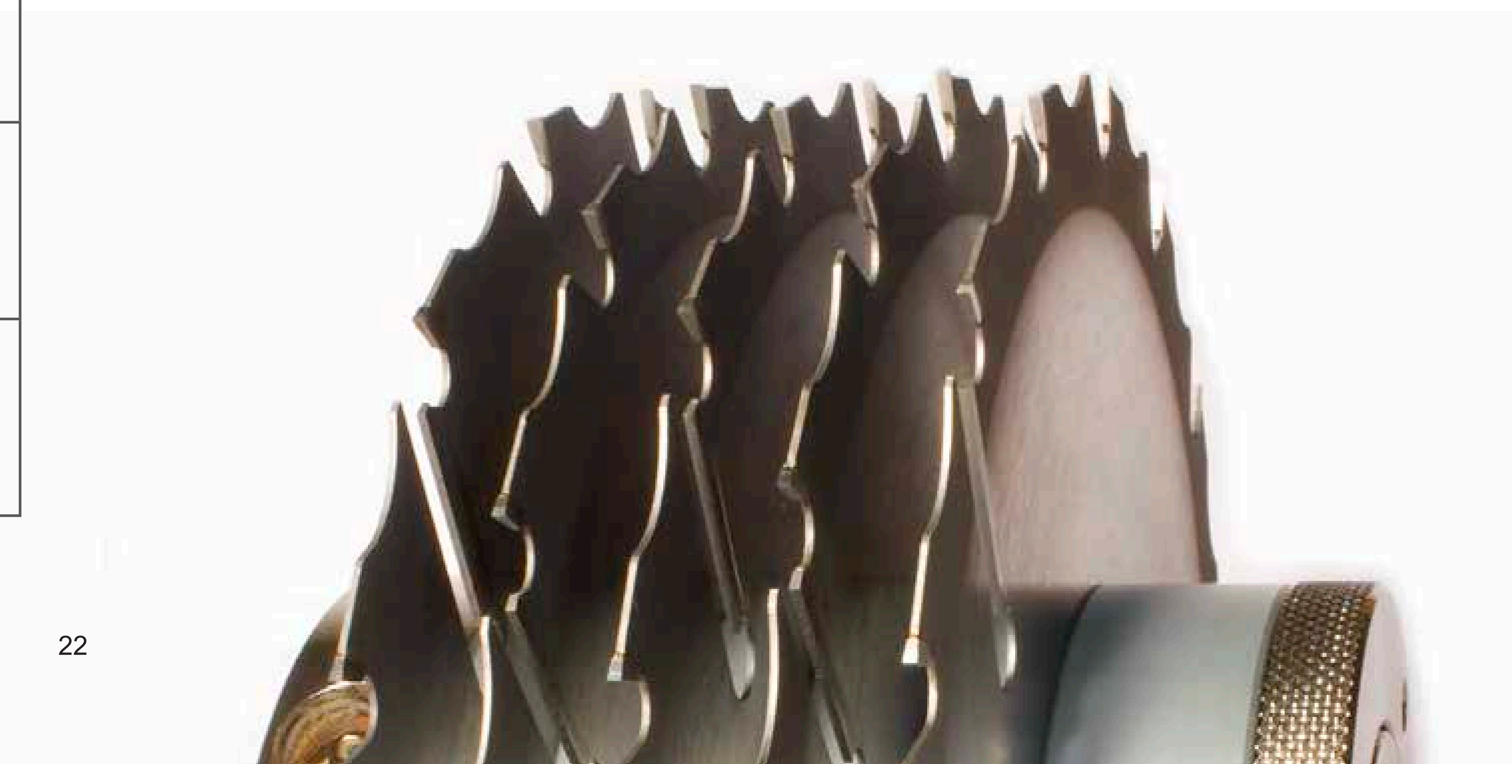
With a specially treated sawbody to ensure stability and cut quality also at high strain



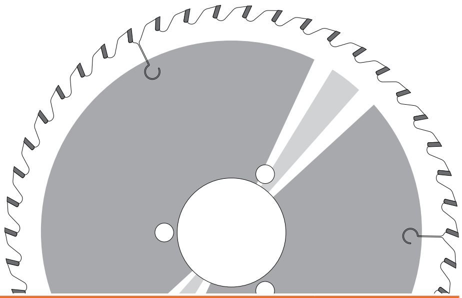
Splitting blades with wiper slots and guard teeth



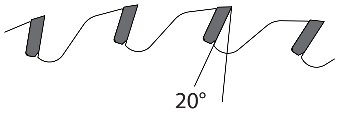
	Art no	Type	Info	Price
	16480	20AA30RS-180-1,6/1,1-60	Z=18 P=3/10,5/74 U2=25	
	43074	20AA31RS-180-2,5/1,8-60	Z=18 P=3/10,5/74 U2=25	
	43802	20BA31RS-200-2,5/1,6-50	Z=20 C2=25	
	39923	20AA30RS-250-2,0/1,4-60	Z=24 U2=50	
*	19689	20AA30RS-250-2,0/1,4-70	Z=24 K=2/20/5 U2=35	
	27963	20AA39RS-200-2,5/1,8-40	Z=16 U2=30	
*	15553	20AA39RS-200-2,5/1,8-60	Z=16 P=3/10,5/74 U2=30	
	17911	20AA39RS-225-2,5/1,8-60	Z=18 P=3/10,5/74 U2=35	
	17879	20AA49RS-225-2,5/1,8-60	Z=16 P=3/10,5/74 U2=35	
*	15375	20AA49RS-225-2,8/2,0-60	Z=16 P=3/10,5/74 U2=35	
*	18209	20AA49RS-250-2,8/2,0-60	Z=16 P=3/10,5/74 U2=35	
	20036	20AA49RS-250-2,8/2,0-60	Z=16 P=3/10/74 U2=50	
	18105	20AA49RS-300-3,2/2,2-60	Z=20 K=2/20/5 U2=60	
	18101	20AA49RS-300-3,2/2,2-70	Z=20 K=2/20/7 U2=60	



New! **X**– for high speed splitting when you need an excellent finish! With special tip geometry and coating “Ultra” for minimal friction and high resistance at high work loads. Mainly used for high speed splitting with high demands on surface finish.



Contact us for additional informations.



	Art no	Type	Info	Price
	44620	20SPEC22AJ-225-3,2/2,2-60 Ultra	Z=32 P=3/10,5/74	
*	44622	20SPEC22AJ-250-3,4/2,4-60 Ultra	Z=36 P=3/10,5/74	
*	44621	20SPEC17AJ-250-3,4/2,4-60-Ultra	Z=46 P=3/10,5/74	

Company info
Assortment & ordering info.
How to choose the right blade
Saw mill
Floor & Multi rip
Panel sizing
Metal cutting
Cut- & Ripping
Technical info

Panel sizing

A panel sizing blade from Micor will give you:

- Optimal cutting quality
- Guaranteed precision and performance
- Design optimized for application and machinery
- Enhanced operational times
- Higher meter yield per sharpen

The difference can be noticed in the result and if taken together all these factors will have a large impact on your yield and total production economy.

A demanding material

Processing of various types of board materials puts high demands on the tools used. This can largely be explained by large variations in the board material composition and properties combined with very high demands on quality of the cut.

For example, chipboard can contain significant amounts of impurities which create excessive wear and strain on the tools.

The demands on the quality of the cut may vary, but in most cases no after-processing is made. The need for a fine, high quality cut without ‘chipping’ is required. In the furniture industry for example, the demands are extra high as the surface must be very smooth to allow mounting of the edge bands.

In turn this requires optimized tooth geometry and a saw body which can withstand the high strain and minimise the risk of vibration leading to ‘chipping’ of the edges.

Its afterwards you notice the difference!

At Micor we have many years experience in development and manufacture of customized saw blades that can meet these high demands.

An important step in this process, and a contributing fac¬tor why we consider ourselves to be a bit sharper than our competitors, is the unique stability of our sawbodies which ensures the blade performance even at high strain.

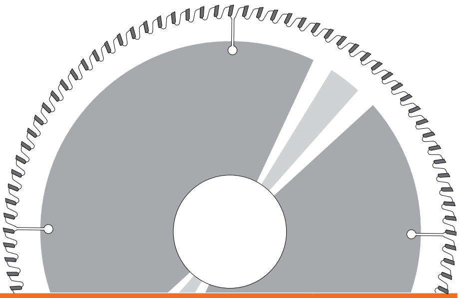
Another factor we would like to highlight is our in-house de-veloped grinding technology, which gives the tips an extra sharp and resistant surface.

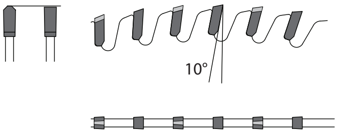
Our range also covers blade with a specially developed saw body which combined with optimized cutting geometry, reduces the sound level with up to 50%!

We are your partner, particularly in the development of technically demanding, customized blades **when performance counts** – set us a challenge!

Formex 3000+ -

Small pitch panel sizing blades for horisontal or vertical saws. Delivered as standard with a new kind of hardmetal tips with high degree of wear resistance for high cut quality and extended running time betwee resharpening, also when cutting harder board like HDF.

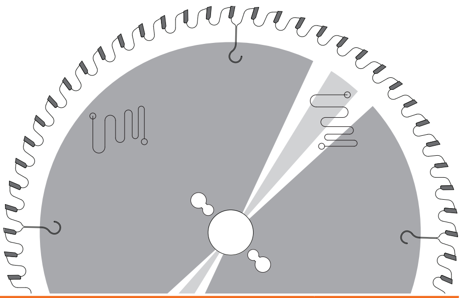


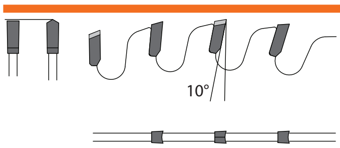


Art no	Type	Info	Price
23871	10EA10U-250-3,2/2,2-30	Z=80 P=2/7/42	
20630	10EA10U-300-3,2/2,2-30	Z=96 P=2/10/60	
33325	10EA10U-300-4,4/3,2-75	Z=96	
30260	10EA13U-300-4,2/3,2-30	Z=72	
17326	10EA13U-300-4,4/3,2-30	Z=72	
19575	10EA13U-300-3,2/2,2-35	Z=72	
31816	10EA13U-300-4,4/3,2-75	Z=72	
28651	10EA13U-300-4,4/3,2-80	Z=72 P=2/6,5/110	
31813	10EA10U-303-3,2/2,2-30	Z=96 P=2/7/42+2/10/60	
31818	10EA13U-303-3,2/2,2-30	Z=72 P=2/7/42+2/10/60	
23872	10EA10U-350-3,5/2,5-30	Z=108 P=2/10/60	
15715	10EA13U-350-4,4/3,2-75	Z=84	
32971	10EA10U-380-4,8/3,5-60	Z=118	
31819	10EA14U-380-4,8/3,5-60	Z=84 P=2/14/100	

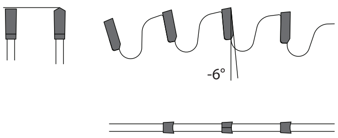
FormeX 3000S+

With in-house developed variant of hollow grinding (EAXH) with minimal chipping of the edges when cutting coated or laminated board.



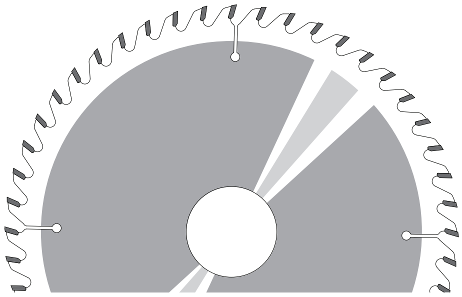


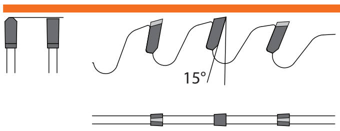
Art no	Type	Info	Price
* 24777	10EAXH16-303-3,2/2,2-30	Z=60 P=2/10/60+2/7/42+2/9/46	
15936	N06EAXH16-303-3,2/2,2-30	Z=60 P=2/10/60	
28441	N06EAXH16-303-3,2/2,2-32	Z=60 P=2/10/60	
35787	10EAXH16-303-3,2/2,2-35	Z=60	

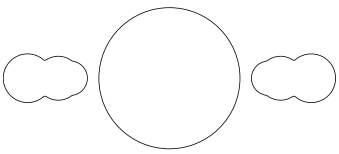


when performance counts

For hortizontal saws - EA tip form for laminated board.

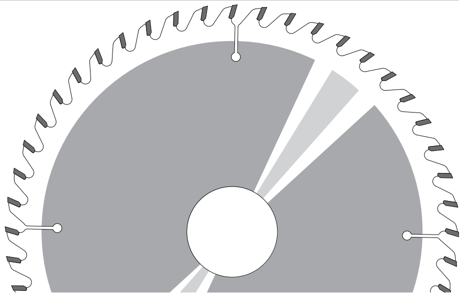


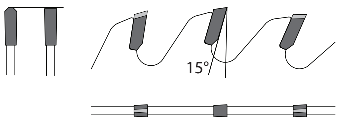



P=Sammansatt

Art no	Type	Info		Price
40708	15EA16U-300-4,4/3,2-30	Z=60		
15255	15EA16U-300-4,4/3,2-30	Z=60	P=2/10/60	
25415	15EA16U-300-4,4/3,2-75	Z=60		
31833	15EA16U-300-4,4/3,2-80	Z=60	P=2/14/110	
11786	15EA19U-300-4,4/3,2-30	Z=48		
31834	15EA16U-303-3,2/2,2-30	Z=60	P=Sammansatt	
31836	15EA16U-305-3,2/2,2-30	Z=60	P=Sammansatt	
31835	15EA16U-305-4,0/2,8-30	Z=60		
31837	15EA16U-305-4,4/3,2-30	Z=60		
29673	15EA16U-305-4,0/2,8-80	Z=60		
15919	15EA16U-350-4,4/3,2-30	Z=72		
28166	15EA16U-350-4,4/3,2-40	Z=72		
35053	15EA16U-350-4,4/3,2-60	Z=72	P=2/14/100	
20939	15EA16U-350-4,4/3,2-75	Z=72		
22138	15EA16U-350-4,4/3,5-75	Z=72		
23164	15EA16U-350-4,4/3,2-80	Z=72	P=2/7/110 + 4/9/	
29191	15EA16U-350-4,4/3,2-80	Z=72	P=2/9/130	
30399	15EA19U-350-4,4/3,2-30	Z=54	P=2/10/60	
17738	15EA20U-350-4,4/3,2-75	Z=54		
22572	15EA20U-350-4,4/3,2-80	Z=54		
28930	15EA26U-350-4,4/3,2-30	Z=42		
39128	15EA15U-355-4,2/3,2-30	Z=72		
39127	15EA15U-355-4,4/3,2-30	Z=72		
28372	15EA19U-365-4,4/3,2-75	Z=60		
31838	15EA16U-370-4,4/3,2-30	Z=72	P=2/10/60	
35045	15EA16U-380-4,8/3,5-40	Z=72		
34004	15EA16U-380-3,8/3,5-60	Z=72	P=2/13/115	
31840	15EA17U-380-4,4/3,2-60	Z=72		
28601	15EA17U-380-4,8/3,5-60	Z=72	P=2/14/100	
31841	15EA17U-400-4,25/3,2-30	Z=72		
15861	15EA17U-400-4,4/3,2-30	Z=72		
21244	15EA17U-400-4,4/3,2-60	Z=72		
25260	15EA17U-400-4,4/3,2-75	Z=72	P=4/15/105	
30047	15EA17U-400-4,4/3,2-80	Z=72	P=2/7/110+4/9/100	
29136	15EA17U-400-4,4/3,2-80	Z=72	P=4/19/120+2/9/130	
31489	15EA17U-400-4,4/3,2-80	Z=72	P=2/14/110+2/9/130	
29853	15EA21U-400-4,4/3,2-30	Z=60	P=4/19/100+2/14/110	
15812	15EA21U-400-4,4/3,2-30	Z=60		
31839	15EA16U-420-4,8/3,5-60	Z=84	P=2/10/80	
30787	15EA18U-420-4,8/3,5-60	Z=72		
29707	15EA19U-430-4,4/3,2-30	Z=72		
31854	15EA19U-430-4,4/3,2-60	Z=72	P=1/11/85	
11849	15EA19U-430-4,4/3,2-75	Z=72	P=4/15/105	
29603	15EA19U-430-4,4/3,2-80	Z=72	P=2/10/130+4/19/120	

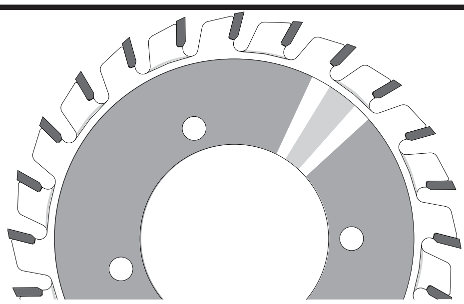
For hortizontal saws - EA tip form for laminated board.



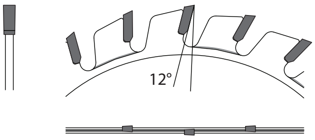


Art no	Type	Info	Price
31831	15EA15U-450-4,4/3,2-80	Z=96 P=2/9/130+4/19/120	
31842	15EA17U-450-4,8/3,5-30	Z=84	
31858	15EA20U-450-4,4/3,2-30	Z=72 P=2/10/60	
29532	15EA20U-450-4,8/3,5-60	Z=72 P=2/14/125	
31232	15EA20U-450-4,4/3,2-80	Z=72 P=2/9/130+4/19/120	
29731	15EA20U-450-4,8/3,5-80	Z=72 P=2/9/130+4/19/12	
31861	15EA20U-460-4,4/3,2-30	Z=72 P=2/14/94	
37680	15EA15U-470-4,4/3,2-75	Z=96 P=4/15/105	
31857	15EA19U-480-4,4/3,2-30	Z=80	
30604	15EA22U-500-4,8/3,5-60	Z=72 P=2/11/115	
11791	15EA19U-500-4,4/3,2-80	Z=72 P=2/9/110	
18556	15EA26U-500-4,4/3,2-30	Z=60	
31865	15EA26U-500-4,8/3,5-60	Z=60 P=1/11/85+2/11/115	
15914	15EA26U-500-4,4/3,2-80	Z=60	
31867	15EA27U-520-4,8/3,5-60	Z=60 P=2/11/115+2/19/120	
31863	15EA24U-550-5,0/3,5-100	Z=72	
31864	15EA24U-550-5,2/3,5-40	Z=72	
11864	15EA29U-550-5,0/3,5-80	Z=60	
27583	15EA26U-565-5,0/3,5-100	Z=72	
11807	15EA30U-570-4,8/3,5-60	Z=60	
31866	15EA26U-600-5,8/4,0-60	Z=72 P=2/11/115+2/19/1	
37045	15EA31U-600-5,8/4,0-30	Z=60	
37679	15EA31U-600-5,8/4,0-60	Z=60 P=2/11/115+2/19/12	
37541	15EA35U-670-6,5/5,0-80	Z=60 P=2/10,5/130	
38160	15EA35U-670-7,0/4,9-80	Z=60 P=2/10,5/130	

Scoring blades

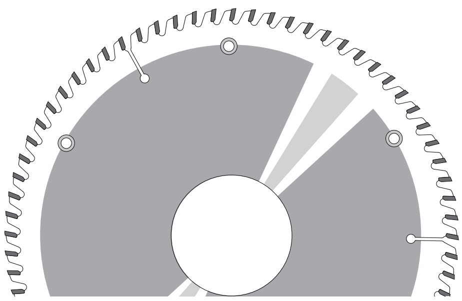


Split scoring blades

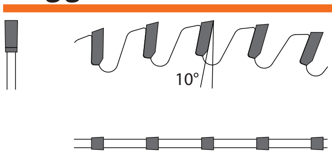


	Art no	Type	Info	Price
	15072	12AA16FW-100-2,8-3,6-20	Z=2X12	
	11866	12AA16FW-100-2,8-3,6-22	Z=2X12	
	11867	12AA16FW-105-2,8-3,6-20	Z=2X12	
	25758	12AA16FW-105-2,8-3,6-22	Z=2X12	
*	42923	12BA(05)16FW-120-2,8-3,6-20	Z=2X12	
	42924	12BA(05)16FW-120-2,8-3,6-22	Z=2X12	
	23565	12AA16FW-120-2,8-3,6-30	Z=2X12	
	42364	12AA16FW-120-1,9/1,0-2,2-50	Z=2X12 S=4+4/6/62/9,5//L+R	
	25566	12AA16FW-125-2,8-3,6-20	Z=2X12	
	12007	12AA16FW-125-2,8-3,6-22	Z=2X12	

With tip in microstructure for extra long life



Hogger blades

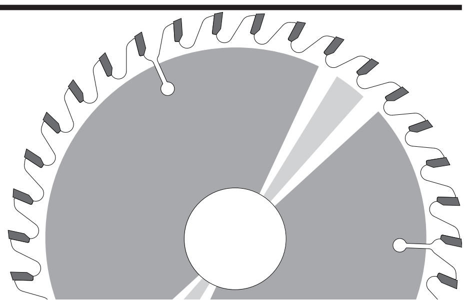


Art no	Type	Info	Price
41273	12CA(20)13-180-3,2/2,2-65	Z=42 S=6/6,5/90/11/45/L	
41274	12DA(20)13-180-3,2/2,2-65	Z=42 S=6/6,5/90/11/45/R	
37059	10CA(20)10-250-6,4/5,0-80	Z=76 S=6/6,5/170/14,5//L	
37060	10DA(20)10-250-6,4/5,0-80	Z=76 S=6/6,5/170/14,5//R	

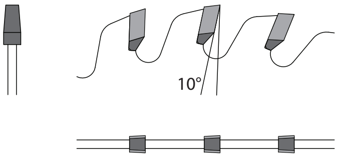
With tip in microstructure for extra long life

when performance counts

Scoring blades



Conical scoring blades with straight top

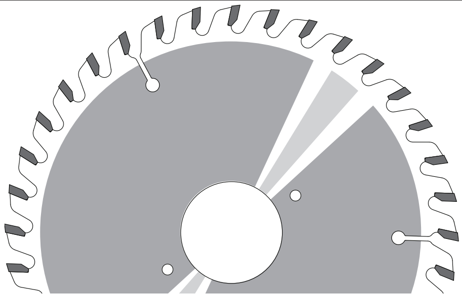


	Art no	Type	Info	Price
	15200	10RA16-105-3,2-4,2/2,2-20	Z=20	
*	15977	10RA16-120-3,2-4,2/2,2-20	Z=24	
*	21291	10RA16-120-3,2-4,2/2,2-22	Z=24	
	16089	10RA19-120-2,8-3,6/2,2-20	Z=20	
	15984	10RA16-125-3,2-4,2/2,2-20	Z=24	
	15980	10RA16-125-4,4-5,4/3,2-20	Z=24	
	36682	10RA16-125-3,8-4,8/2,8-45	Z=24	
	15976	10RA16-125-4,4-5,4/3,2-45	Z=24	
	38874	10RA19-125-4,2-5,2/3,2-45	Z=20	
	15989	10RA16-150-4,4-5,4/3,2-30	Z=28	
	35034	10RA16-180-4,4-5,4/3,5-45	Z=36	
	29832	10RA16-180-4,8-5,8/3,5-45	Z=36	
	32463	10RA19-180-4,2-5,2/3,2-30	Z=30	
	29655	10RA19-180-3,8-4,8/3,5-20	Z=28	
	35463	10RA19-180-4,4-5,4/3,2-30	Z=28 P=2/10/60	
	35189	10RA19-180-4,4-5,4/3,5-45	Z=28	
	20899	10RA19-180-4,8-5,8/3,5-45	Z=28	
	31794	10RA17-200-4,4-5,4/3,2-45	Z=36	
	37716	10RA17-200-5,8-6,8/3,5-45	Z=36	
	17423	10RA17-200-4,8-5,8/3,5-45	Z=36	
	35459	10RA17-200-4,4-5,4/3,5-65	Z=36 P=2/9/110 + P=2/9/100	
*	15987	10RA19-200-4,4-5,4/3,2-20	Z=34	
	39158	10RA19-200-4,4-5,4/3,2-30	Z=34 P=2/6/60	
	26065	10RA19-200-3,2-4,2/3,2-30	Z=34	
	16005	10RA19-200-4,4-5,4/3,2-30	Z=34	
	26708	10RA19-200-3,2-4,2/2,2-65	Z=34 P=2/9/110	
	21649	10RA19-200-4,2-5,2/3,2-45	Z=32	

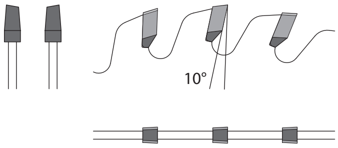
With tip in microstructure for extra long life

when performance counts

Scoring blades



Conical scoring blades
with alternate bevels



Art no	Type	Info		Price
36464	10RABA16-120-3,2-4,2/2,2-20	Z=24		
29586	10RABA16-125-4,4-5,4/3,5-45	Z=24		
29284	10RABA19-125-4,4-5,4/3,5-45	Z=20		
29301	10RABA20-125-4,4-5,4/3,2-45	Z=20		
34815	10RABA20-150-4,4-5,4/3,2-40	Z=24		
28863	10RABA20-150-4,4-5,4/3,2-45	Z=24		
30048	10RABA14-160-4,4-5,4/3,5-55	Z=36	P=3/7/66	
31804	10RABA18-160-4,4-5,4/3,2-45	Z=28	P=3/11/70	
29533	10RABA16-180-4,8-5,8/3,5-45	Z=36		
30123	10RABA19-180-4,4-5,4/3,5-20	Z=30		
30054	10RABA19-180-4,4-5,4/3,5-30	Z=30	P=2/10/60	
30055	10RABA19-180-4,4-5,4/3,5-45	Z=30		
31800	10RABA10-200-3,2-4,2/3,2-30	Z=60		
35107	10RABA17-200-4,3-5,3/3,5-20	Z=36		
26117	10RABA17-200-4,8-5,8/3,5-45	Z=36		
29190	10RABA17-200-4,4-5,4/3,5-65	Z=36	P=2/9/110	
29230	10RABA18-200-4,4-5,2/3,2-30	Z=34		
21794	10RABA18-200-4,8-5,8/3,5-45	Z=34		
36807	10RABA18-200-3,5-4,5/2,5-80	Z=34	P=2/14/110	

With tip in microstructure for extra long life

High speed, extreme demands

The development in the metal working industry resembles many other industries where an increasing number of operations must be performed at higher speeds. The requirements on the cut surface quality can vary with application, but in most cases there is no finishing which calls for a fine cut with very high surface quality. In turn this requires optimized tooth geometry and a saw body which can withstand the high strain and minimise the risk of vibration leading to burrs of the edges.

Its afterwards you notice the difference!

We have extensive experience in the design and manufacturing of customized cutting solutions for profiles and a wide variety of other applications in aluminium and non-ferrous metals. Apart from solutions for cutting non-ferrous metals, we can also offer dedicated solutions for stainless steel as well as various sandwich materials like garage doors and wall fixtures containing steel, plate and foam materials.

Guidelines when choosing non-ferrous saw blades

The tooth pitch is choosen on the basis of the thickness of the material to be cut. As a rule, thin materials are cut using a blade with small tooth pitch, and thick materials with a larger tooth pitch. Our range are manufactured with positive or negative rake angles where positive angle is used for automatic feed and negative for manual feed.

Hardmetal and tooth geometry

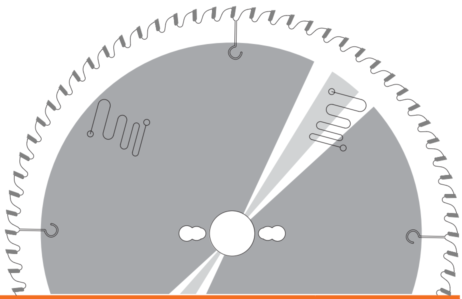
High feeding speeds puts high demands on the tooth geometry which needs to be optimized depending on type and thickness of the material to be cut. With regards to hardmetal, sawblades for non-ferrous metals are as standard delivered with **Pro** tips while blades for steel/stainless steel are equipped with NFM-super (see section/hardmetal, page 44).

Contact us

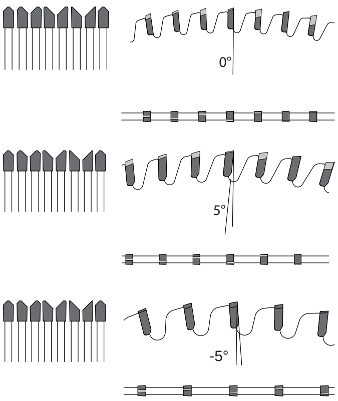
-and we will help to find the best solution for optimal yield, durability and function!

when
performance
counts

Sawblades for non-ferrous metals

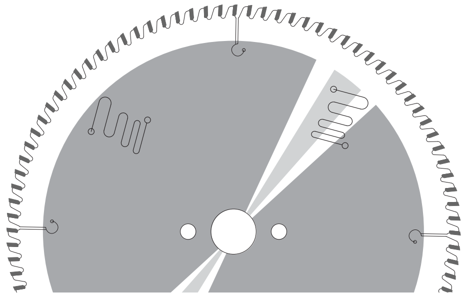


For cuts & mitres of coated/ anodized profile/plastic.

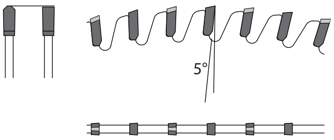


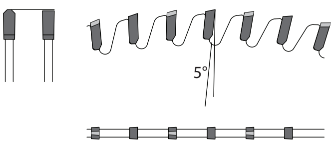
Art no	Type	Info	Price
34963	00BOM08-250-2,4/1,8-30	Z=100/10	
38940	00BOM08-250-2,4/1,8-32	Z=100/10	
34965	00BOM08-300-2,4/1,8-30	Z=120/10	
37282	00BOM08-300-2,4/1,8-32	Z=120/10 P=2/7/42+2/10/60	
34966	05BOM10L-250-3,2/2,6-30	Z=80 P=2/7/42+2/10/60	
34967	05BOM10L-300-3,2/2,6-30	Z=96/8 P=2/10/60	
45089	05BOM10L-300-3,2/2,6-30	Z=96/8 P=2/10/60	
37990	05BOM10L-400-4,0/3,4-32	Z=120/10 P=2/11/63	
43830	05BOM10L-500-3,0/2,5-32	Z=160	
34973	05BOM10L-500-4,0/3,4-30	Z=160/10 P=2/7/42+2/10/60	
44693	05BOM10L-550-3,2/2,7-32	Z=170	
45861	05BOM10L-550-3,2/2,7-35	Z=170	
36285	05BOM10L-550-4,0/3,4-32	Z=170/10 K=1/10/5 P=2/11/63	
46716	05BOM10L-550-4,0/3,4-80	Z=170 P=6/9/100	
45697	05BOM13L-650-4,4/3,4-40	Z=160/10 P=2/12/63	
45840	N05BOM10L-216-3,2/2,6-30	Z=64/8	
37098	N05BOM11L-335-3,1/2,8-30	Z=100	
37099	N05BOM11L-335-3,1/2,8-30	Z=100	
37097	N05BOM11L-350-3,2/2,6-30	Z=100	

when performance counts



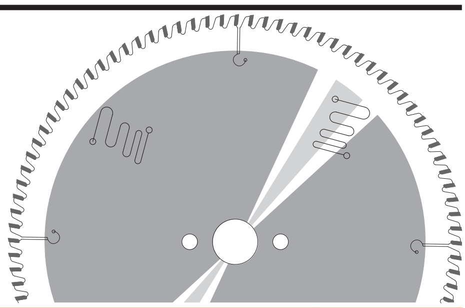
For cuts & mitres of profile.





	Art no	Type	Info	Price
	45816	N05EAM10L-200-2,8/2,2-30	Z=64	
	45374	N05EAM10L-216-3,2/2,6-30	Z=64	
	45330	N05EAM10L-250-3,2/2,6-30	Z=80 P=2/10/60+2/7/42+2/9/46	
	16217	N05EAM11L-250-3,2/2,6-32	Z=72	
	45366	N05EAM10L-300-3,2/2,6-30	Z=96 P=2/10/60+2/7/42+2/9/46	
	45366	N05EAM10L-300-3,2/2,6-30	Z=96 P=2/10/60+2/7/42+2/9/46	
	45366	N05EAM10L-300-3,2/2,6-30	Z=96 P=2/10/60+2/7/42+2/9/46	
	45366	N05EAM10L-300-3,2/2,6-30	Z=96 P=2/10/60+2/7/42+2/9/46	
	45811	N05EAM10L-300-3,2/2,6-32	Z=96 P=2/8/45 + 2/11/63	
	45817	N05EAM13L-300-3,2/2,6-30	Z=72 P=2/10/60+2/7/42+2/9/46	
	21605	N05EAM10L-330-3,6/3,0-30	Z=104 P=2/10/60+2/7/42	
	16273	N05EAM10L-330-3,6/3,0-32	Z=104 P=2/8/54 + 2/12/64	
	45797	N05EAM13L-350-3,6/3,0-32	Z=84 P=2/8/54 + 2/12/64	
	45397	N05EAM10L-350-3,6/3,0-30	Z=108 P=2/12/64 + 2/8/50	
	45375	N05EAM10L-350-3,6/3,0-32	Z=108 P=2/8/45 + 2/11/63	
	45812	N05EAM10L-380-4,0/3,4-32	Z=116	
	45838	N05EAM10L-400-4,0/3,4-30	Z=120	
	45839	N05EAM10L-400-4,0/3,4-32	Z=120 P=2/8/45 + 2/11/63	
	45815	N05EAM13L-400-4,0/3,4-30	Z=96 P=2/10/60+2/7/42+2/9/4	
	45809	N05EAM13L-420-4,0/3,4-30	Z=100	
	45822	N05EAM13L-450-4,0/3,4-30	Z=108	
	45810	N05EAM13L-500-4,0/3,4-30	Z=120	
	16936	00EAM08-250-2,4/1,8-30	Z=100	
	17015	00EAM08-300-2,4/1,8-30	Z=120	
*	43660	05EAM10L-200-2,8/2,2-32	Z=64 P=2/11/63+2/11/60	
*	47156	05EAM10L-250-3,2/2,6-30	Z=80 P=2/10/60+2/7/42	
*	45837	05EAM10L-300-3,2/2,6-30	Z=96 P=2/7/42+2/10/60+2/9/46	
	16885	05EAM13L-300-3,2/2,6-30	Z=72 P=2/7/42+2/10/60+2/9/46	
*	45406	05EAM10L-350-3,6/3,0-30	Z=108	
	45798	05EAM10L-400-4,0/3,4-30	Z=120	
*	45346	05EAM13L-400-4,0/3,4-30	Z=96	
	16823	05EAM10L-420-4,0/3,4-30	Z=130	
	15816	05EAM13L-420-4,0/3,4-30	Z=100	
	45801	05EAM10L-450-4,0/3,4-30	Z=144	
	45818	05EAM13L-450-4,0/3,4-30	Z=108	
*	19412	05EAM10L-500-4,0/3,4-30	Z=160 P=2/8/45+2/11/63	
	45396	05EAM13L-500-4,0/3,4-30	Z=120	
*	16886	05EAM13L-550-4,0/3,4-30	Z=136	
	21289	10EAM32L-610-4,0/3,4-32	Z=60	

Company info.
Assortment & ordering info.
How to choose the right blade
Saw mill
Floor & Multi rip
Panel sizing
Metal cutting
Cut- & Ripping
Technical info



For cuts & mitres of profile.

	Art no	Type	Info	Price
*	45083	N05EAM10-216-3,2/2,5-30 Basic	Z=64	
*	45085	N05EAM10-250-3,2/2,5-30 Basic	Z=80 P=2/10/60+2/11/63+2/11/64	
*	46792	N05EAM10-250-3,2/2,6-32 Basic	Z=80 P=2/8/45	
*	45084	N05EAM10-300-3,2/2,5-30 Basic	Z=96 P=2/10/60+2/11/63+2/11/64	
*	45080	N05EAM10-350-3,6/3,0-30 Basic	Z=108 P=2/10/60+2/11/63	
*	45081	N05EAM10-350-3,6/3,0-32 Basic	Z=108 P=2/10/60+2/11/63	
*	45082	05EAM13-400-4,0/3,4-30 Basic	Z=96 =2/10/60+2/11/63+2/11/64	
*	45104	05EAM10-450-4,0/3,4-30 Basic	Z=144	

00BAE.....
For cutting of non hardened steel.

10BAE........
For cutting of stainless steel.
Note: stainless steel is very abrasive, why resharpe-ning needs to be done more frequently.

	Art nr	Typ	Info	Pris
*	45546	00BAE16M-305-2,2/1,8-25,4	Z=60	
*	38780	00BAE16M-355-2,2/1,8-25,4	Z=72	
*	38342	10BAE12M-305-2,2/1,8-25,4	Z=80	
*	38341	10BAE12M-355-2,2/1,8-25,4	Z=90	

Crosscutting & Ripping

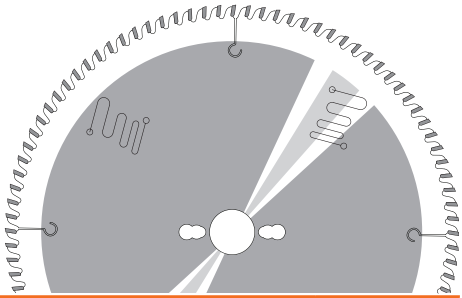
On the market today, there is a wide range of crosscutting and ripping blades with very large variations in quality and performance. In many cases made of lowquality steel and minimal carbide size. One of the effects of these shortcomings is that it creates vibrations when the blade is under strain, which in turn affects both performance and lifespan.

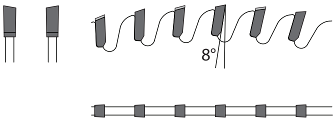
Professional use puts extra high demands on cut quality as there is limited time for post-processing or frequent changes of tools that do not work or deliver the required quality.

Our range of standard ripping and crosscutting blades are manufactured to high standards and tolerances, ensuring optimum performance and durability.You can therefore feel confident that the blade does its job and retain its sharpness and performance, also after resharpening and long use.

Company info
Assortment & ordering info..
How to choose the right blade
Saw mill
Floor & Multi rip
Panel sizing
Metal cutting
Cut- & Ripping
Technical info

Crosscutting

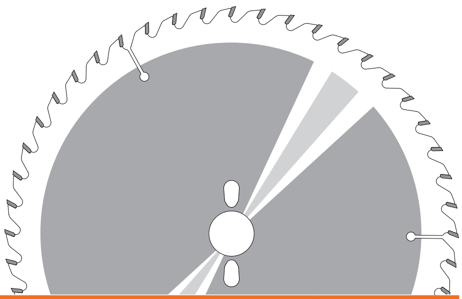


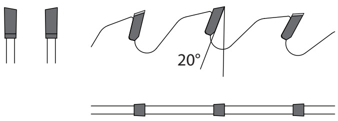


	Art no	Type	Info		Price
	28106	08BA10-200-2,8/2,0-30	Z=64		
	45820	08BA10L-250-3,2/2,2-30	Z=80	P=2/10/60+2/7/42+2/9/46	
	45378	08BA10L-300-3,2/2,2-30	Z=96	P=2/10/60+2/7/42+2/9/46	
	45823	08BA10L-350-3,5/2,5-30	Z=108	P=2/10/60+2/7/42+2/9/46	
	45824	08BA10L-400-3,5/2,5-30	Z=120	P=2/10/60+2/7/42+2/9/46	
	28074	08BA13-200-2,8/2,0-30	Z=48		
	45799	08BA13L-250-3,2/2,2-30	Z=60	P=2/10/60+2/7/42+2/9/46	
	45377	08BA13L-300-3,2/2,2-30	Z=72	P=2/10/60+2/7/42+2/9/46	
	45369	08BA13L-350-3,5/2,5-30	Z=84	P=2/10/60+2/7/42	
	45368	08BA13L-400-3,5/2,5-30	Z=96	P=2/10/60+2/7/42+2/9/46	
	45394	08BA13L-450-4,0/2,8-30	Z=108		
	45398	08BA13L-450-4,0/2,8-35	Z=108		
*	45349	08BA13L-500-4,0/2,8-30	Z=120		
	29249	08EA10-200-2,8/2,0-30	Z=64		
	45367	08EA10L-250-3,2/2,2-30	Z=80	P=2/7/42+2/10/60+2/9/46	
	45347	08EA10L-300-3,2/2,2-30	Z=96	P=2/10/60+2/7/42+2/9/46	
	45376	08EA10L-350-3,5/2,5-30	Z=108	P=2/10/60+2/7/42	
	29253	08EA13L-250-3,2/2,2-30	Z=60	P=2/7/42+2/10/60+2/9/46	
	45408	08EA13L-300-3,2/2,2-30	Z=72	P=2/10/60+2/7/42+2/9/46	
	45405	08EA13L-350-3,5/2,5-30	Z=84	P=2/10/60+2/7/42	
	10904	10BA16-250-3,2/2,2-30	Z=50	P=2/10/60+2/7/42+2/9/46	
*	10905	10BA16-300-3,2/2,2-30	Z=60	P=2/10/60+2/7/42+2/9/46	
	15741	10BA16-350-3,5/2,5-30	Z=72	P=2/10/60+2/7/42	
*	11957	10BA16-400-3,5/2,5-30	Z=80	P=2/10/60+2/7/42	
	11975	10BA16-450-4,0/2,8-30	Z=90		
	15240	10BA16-500-4,0/2,8-30	Z=100		
*	45350	10BA16L-500-4,0/2,8-50	Z=100	P=1/13/80	
	10906	10BA19-250-3,2/2,2-30	Z=40	P=2/10/60+2/7/42+2/9/46	
	16144	10BA19-350-3,5/2,5-30	Z=56	P=2/10/60+2/7/42	
*	15606	10BA19-400-3,5/2,5-30	Z=64	P=2/10/60+2/7/42	
*	15102	10BA19-450-4,0/2,8-30	Z=72		
*	16808	10BA19-500-4,0/2,8-30	Z=80		
	17947	10BA19-560-4,4/3,0-30	Z=88		
	16744	10BA19-610-4,4/3,0-30	Z=96		
*	25855	10BA19L-500-4,0/3,0-50	Z=80	P=1/13/80	
*	15095	10BA20-300-3,2/2,2-30	Z=48	P=2/10/60+2/7/42+2/9/46	
*	45348	N05BA16L-400-3,5/2,5-30	Z=80	P=2/10/60+2/7/42	

when performance counts

Ripping blade

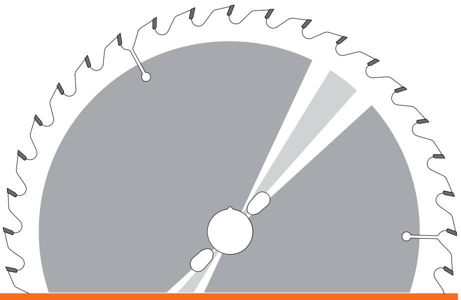




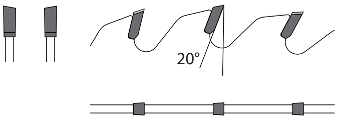
	Art no	Type	Info		Price
	24857	20AA30A-250-2,4/1,6-30	Z=24		
*	22946	20AA30A-300-3,2/2,2-30	Z=30	P=2/10/60	
	22948	20AA30A-350-3,5/2,5-30	Z=36	P=2/10/60+2/7/42	
	17743	20AA39-250-3,2/2,2-70	Z=20	K=2/20/5	
*	21592	20AA39A-300-3,2/2,2-30	Z=24	P=2/10/60+2/7/42+2/9/46	
*	21614	20AA39A-350-3,5/2,5-30	Z=28	P=2/10/60+2/7/42	
*	21615	20AA39A-400-3,5/2,5-30	Z=32	P=2/10/60+2/7/42	
	23071	20AA39A-450-4,0/2,8-30	Z=36		
	22847	20AA39A-500-4,0/2,8-30	Z=40		
	21616	20AA39A-610-4,4/3,0-30	Z=48		
	18738	20BA19-200-2,0/1,4-30	Z=32		
	11984	20BA19-250-2,8/2,0-30	Z=40	P=2/10/60+2/7/42+2/9/46	
	10907	20BA19-250-3,2/2,2-30	Z=40	P=2/10/60+2/7/42+2/9/46	
*	15230	20BA19-300-2,4/1,6-30	Z=48		
*	21599	20BA19-300-2,8/2,0-30	Z=48	P=2/10/60+2/7/42+2/9/46	
	15686	20BA19-350-3,2/2,2-30	Z=56	P=2/10/60+2/7/42	
*	16146	20BA19-350-3,5/2,5-30	Z=56	P=2/10/60+2/7/42	
*	15687	20BA19-400-3,5/2,5-30	Z=64	P=2/10/60+2/7/42	
	15118	20BA20-300-2,8/2,0-20	Z=48	P=2/7/42+2/10/60	
*	16475	20BA20-300-3,2/2,2-30	Z=48	P=2/10/60+2/7/42+2/9/46	
	22398	20BA30A-300-2,4/1,6-30	Z=30		
*	21596	20BA30A-300-3,2/2,2-30	Z=30	P=2/10/60+2/7/42+2/9/46	
*	29827	20BA30A-350-3,5/2,5-30	Z=36	P=2/10/60	
*	26954	20BA30A-400-3,5/2,5-30	Z=40	P=2/10/60+2/7/42	
	23086	20BA39A-250-3,2/2,2-30	Z=20	P=2/7/42	
	21617	20BA39A-300-3,2/2,2-30	Z=24	P=2/10/60	
	43193	20BA39A-350-3,5/2,5-31,75	Z=28		
	21620	20BA39A-400-3,5/2,5-30	Z=32	P=2/10/60+2/7/42	
	22280	20BA39A-450-4,0/2,8-30	Z=36		

when
performance
counts

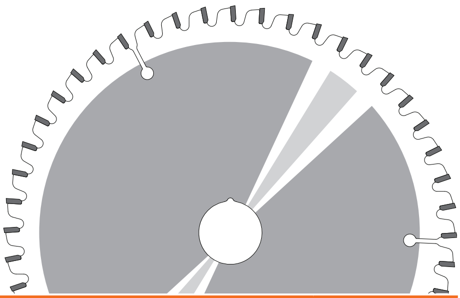
Construction blades



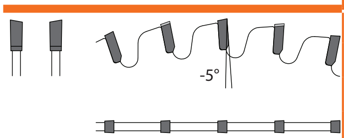
Manufactured from high alloy steel and equipped with carbide of the highest quality, can be re-sharpened 10 - 15 times depending on the use.

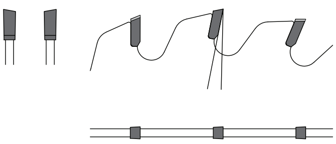


Art no	*Type*	*Info*		*Price*
32518	20BA21Y-315-3,0/2,0-30	Z=48	P=2/10/60	
17026	20BA26Y-300-2,8/2,0-20	Z=36		
23885	20BA26Y-300-2,8/2,0-30	Z=36	P=2/10/60+2/7/42	
22142	20BA26Y-350-3,2/2,2-30	Z=42	P=2/10/60+2/7/42	
22142	20BA26Y-350-3,2/2,2-30	Z=42	P=2/10/60+2/7/42	
17703	20BA26Y-400-3,2/2,2-25	Z=48	P=2/10/60+2/7/42	
28325	20BA26Y-400-3,2/2,2-30	Z=48		
32519	20BA26Y-400-3,5/2,5-30	Z=48	P=2/10/60	
23098	20BA30Y-250-2,8/2,0-30	Z=24	P=2/10/60+2/7/42+2/9/46	
23099	20BA30Y-300-3,2/2,2-30	Z=30	P=2/10/60+2/7/42+2/9/46	
23100	20BA30Y-315-3,2/2,2-30	Z=30	P=2/10/60+2/7/42+2/9/46	
23101	20BA30Y-350-3,5/2,2-30	Z=36	P=2/10/60+2/7/42	
17707	20BA30Y-400-3,5/2,2-25	Z=40	P=2/10/60+2/7/42	
22057	20BA30Y-400-3,5/2,2-30	Z=40	P=2/10/60+2/7/42	
19576	20BA30Y-450-4,0/2,8-30	Z=44		



Manufactured from high alloy steel and equipped with carbide of the highest quality, can be re-sharpened 10 - 15 times depending on the use.





Art no	*Type*	*Info*	*Price*
23900	10BA20P-210-2,8/1,8-30	Z=32	
24088	10BA20P-235-2,8/1,8-30	Z=36	
22528	20BA28P-152-2,5/1,5-20	Z=16	
22986	20BA28P-160-2,5/1,5-20	Z=16	
22585	20BA28P-190-2,5/1,5-30	Z=24	
23472	20BA28P-210-2,8/1,8-30	Z=24	
23209	20BA28P-235-2,8/1,8-30	Z=28	
18606	N05BA10P-216-2,8/2,0-30	Z=64	
16603	N05BA13P-216-2,8/2,0-30	Z=48	
20135	N08BA26P-216-2,8/1,8-30	Z=24	

Basic

When cutting any material to produce a component, the required quality of finish depends on the final use of the material being processed. This in turn affects the choice of saw blades required to achieve the desired result. It is against this background, we have chosen to develop a range of standard blades that despite its reasonable price has a very high and consistent quality.

Basic has a slightly simplified design compared to a blade from our standard range. The body is made from high alloy, hardended steel that withstands high torsional stress and ensures a straight cut.

No compromises have been made that would affect the key important areas in blade life such as tip size which is common for competing products in the same price category. Overall, the Basic range is a highly affordable alternative, ideally suited for todays workshop needs.

Basic

	Art no	Type	Info	Price
Crosscutting - Intended for wood, veneered and laminated board.				
*	42903	08BA10-250-3,2/2,2-30 Basic	Z=80 P=2/10/60+2/7/42+2/9/46	
*	42904	08BA10-300-3,2/2,2-30 Basic	Z=96 P=2/10/60+2/7/42+2/9/46	
*	42905	08BA10-350-3,5/2,5-30 Basic	Z=108 P=2/10/60+2/7/42	
*	42907	08BA13-250-3,2/2,2-30 Basic	Z=60 P=2/10/60+2/7/42+2/9/46	
*	42908	08BA13-300-3,2/2,2-30 Basic	Z=72 P=2/10/60+2/7/42+2/9/46	
*	42909	08BA13-350-3,5/2,5-30 Basic	Z=84 P=2/10/60+2/7/42	
*	42910	08EA10-250-3,2/2,2-30 Basic	Z=80 P=2/7/42+2/10/60+2/9/46	
*	42911	08EA10-300-3,2/2,2-30 Basic	Z=96 P=2/10/60+2/7/42+2/9/46	
*	42912	08EA10-350-3,5/2,5-30 Basic	Z=108 P=2/10/60+2/7/42	
*	42913	08EA13-300-3,2/2,2-30 Basic	Z=72 P=2/10/60+2/7/42+2/9/46	
Universal - Intended for ripping hard wood or soft of medium to heavy sections. Can also be used for crosscutting.				
*	42914	10BA16-350-3,5/2,5-30 Basic	Z=72 P=2/10/60+2/7/42	
*	42915	10BA19-250-3,2/2,2-30 Basic	Z=40 P=2/10/60+2/7/42+2/9/46	
*	42916	10BA19-300-3,2/2,2-30 Basic	Z=48 P=2/10/60+2/7/42+2/9/46	
*	42917	10BA19-350-3,5/2,5-30 Basic	Z=56 P=2/10/60+2/7/42	
Ripping - Intended for ripping hard and soft wood.				
*	42920	20BA19-250-2,8/2,0-30 Basic	Z=40 P=2/10/60+2/7/42+2/9/46	
*	42921	20BA19-300-2,8/2,0-30 Basic	Z=48 P=2/10/60+2/7/42+2/9/46	
Construction blades -				
-- For statiionery site circular sawbenches --				
*	42997	20BA26Y-300-2,8/2,0-30 Basic	Z=36 P=2/10/60+2/7/42	
*	42998	20BA30Y-300-3,2/2,2-30 Basic	Z=30 P=2/10/60+2/7/42+2/9/46	
*	42999	20BA30Y-350-3,5/2,2-30 Basic	Z=36 P=2/10/60+2/7/42	
*	43000	20BA30Y-400-3,5/2,2-30 Basic	Z=40 P=2/10/60+2/7/42	
*	43001	20BA30Y-450-4,0/2,8-30 Basic	Z=44 P=2/10/60+2/7/42	
-- For portable saws --				
*	42994	10BA20P-165-2,5/1,5-30 Basic	Z=24	
*	42995	N05BA10P-216-2,8/2,0-30 Basic	Z=64	
*	42996	N05BA13P-216-2,8/2,0-30 Basic	Z=48	

Basic for aluminium, see page 36

Company info
Assortment & ordering info.
How to choose the right blade
Saw mill
Floor & Multi rip
Panel sizing
Metal cutting
Cut- & Ripping
Technical info

when
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counts

Technical Information

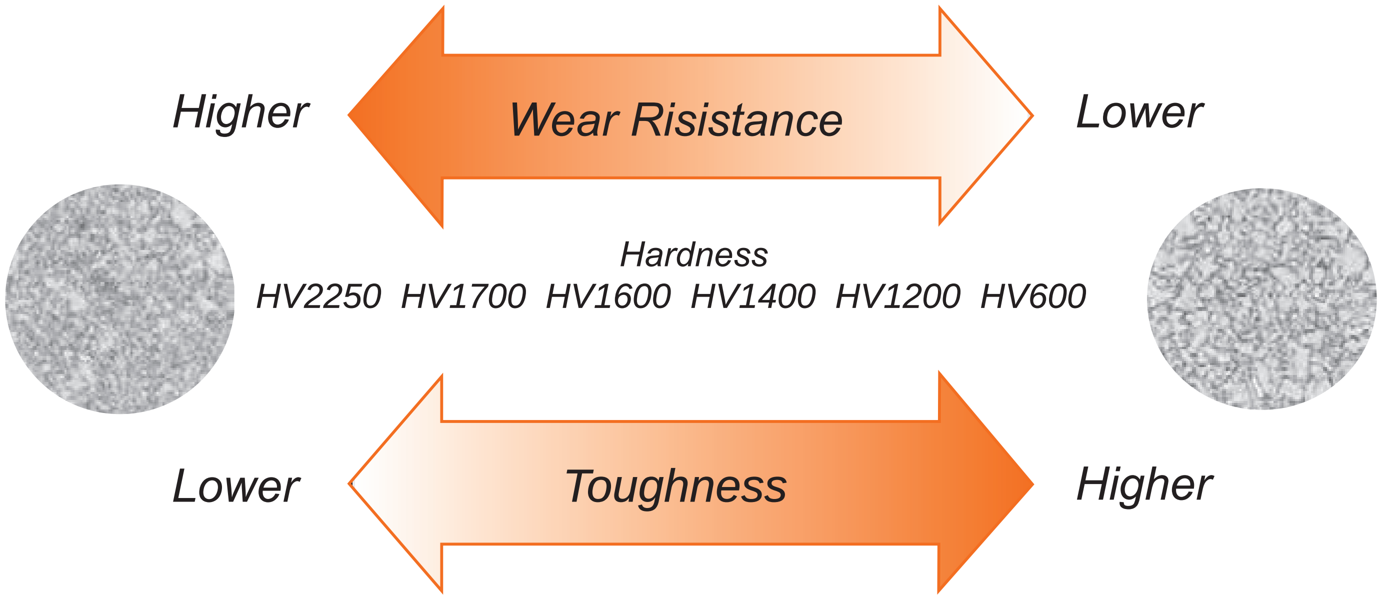
Steel

Choosing the right grade of steel for saw blades that are used in a variety of applications requires a lot of experience. We currently use three different grades of steel.

Carbide tips

Carbide tips are made from a metallic material that consists of hard grains of carbide held together by a binding agent. The most common carbide is tungsten carbide (WC) and the most common binding agent is cobalt (Co). For some applications Nickel is also used. To improve toughness, the binding agent is often alloyed with other metallic elements.
Carbides are chemical alloys of one or more metals and come in the form of very small grains. Grain size may vary from 0.5 to around 7 microns (1 micron = 0.001 mm).

Carbide tips for cutting wood contain 69-97% carbide and the rest is binding agent. Certain cutting tasks require wear resistance, others toughness. Carbides give the tip wear resistance, while the binding agent gives it toughness. Generally, small grains and low proportion of binding agent give hardness and wear resistance, while large grains and a high proportion of binding agent gives toughness.

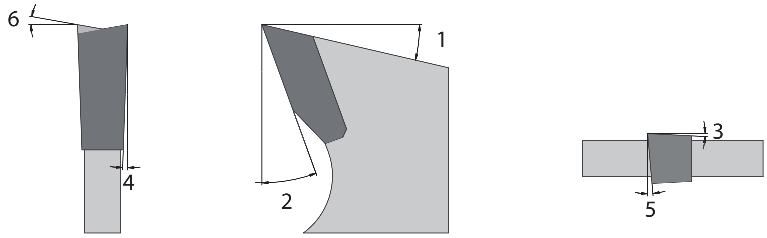


The type of carbide is chosen to suit the application. For example, high hardness where high abrasion resistance is required. Generally the following applies to our types of carbide tip.

Type	*Recommended application*
SM1000	Standardtip used on sawmill blades with excellent cutting properties also at high speeds, summer and winter.
SM1000 +	Specialtip with extra high resistance for tough applications. Used as standard on all presawing blades. Also recommended for cutting frozen wood.
SM2000	Specialtip used when optimal running time is the primary objective. Used as standard on splitting blades and Multix ripping blades.
Pro +	Standardtip for trim and planer/moulder blades.
XT +	New specialtip for splitter/planer blade Xact.
M3000 +	New specialtip with very high resistance for exended running time and quality cuts. Used as standard on format and scoring blades.
NFM Super	Standardtip for steel and various sandwish materials.
Pro	New specialtip for excellent cuts of non-ferrous metals.

Angle designations

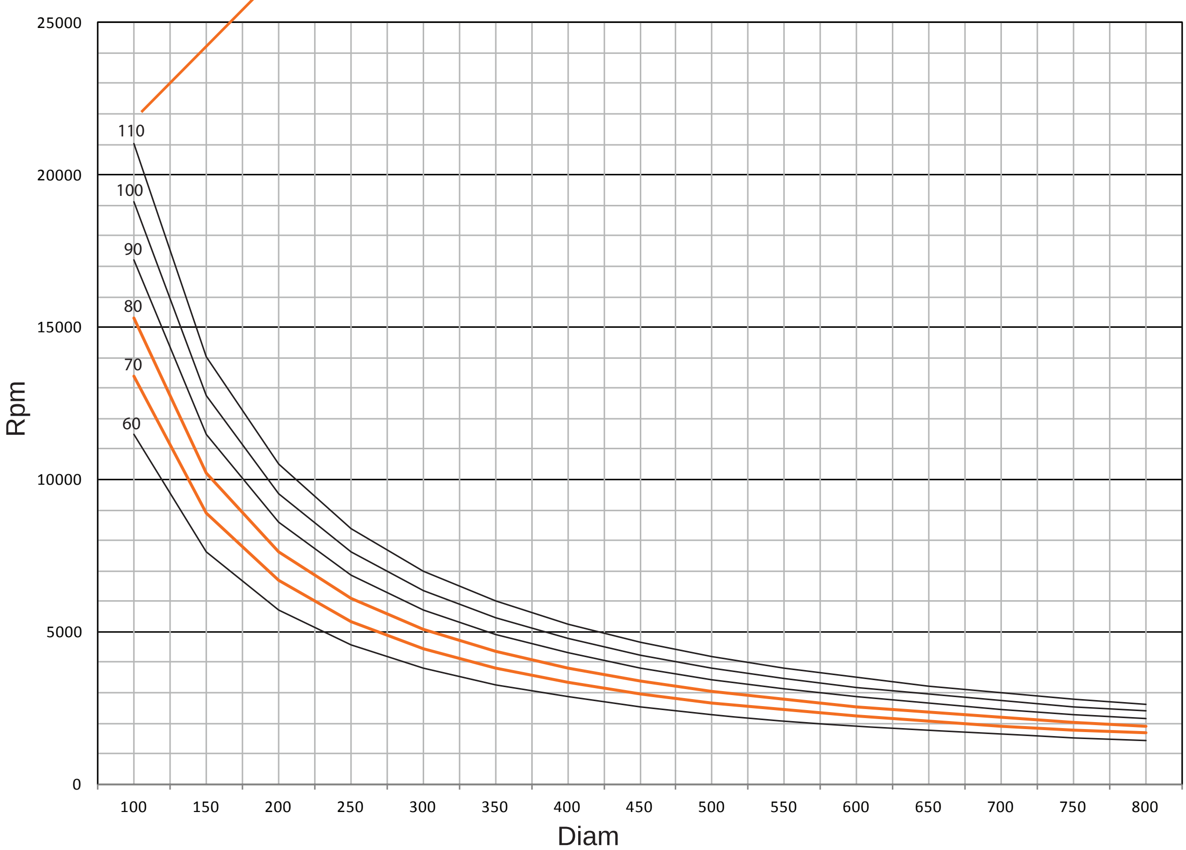
1 = clearance angle
2 = rake angle
3 = tangential clearance angle
4 = radial clearance angle
5 = front bevel angle
6 = back bevel angle



Cutting speed m/s

As a rule you should choose a blade with the smallest diameter possible, to maximize stability and minimize the kerf, but at the same time the diameter must be matched to the speed of the machine so that the blade runs at the most suitable cutting speed. Carbide tipped blades require relatively high cutting speeds. The recommended speed for working in wood-based materials is 70 m/sec, and for non-ferrous materials 50-95 m/sec.

$$\text{Cutting speed} = \frac{\text{Diameter} \times \pi \times \text{Rpm}}{60 \times 1000}$$



The table shows the relationship between blade diameter, peripheral speed and rpm. Contact our technicians if you intend using speeds outside this range.

Feed per tooth Sz mm

To achieve long life and good cutting performance it is important to use a correct feed per tooth. Too slow feed speed causes rapid wear to the cutting edge, while too fast feed speed may mean that chips do not clear the gullet and this could cause teeth to break.

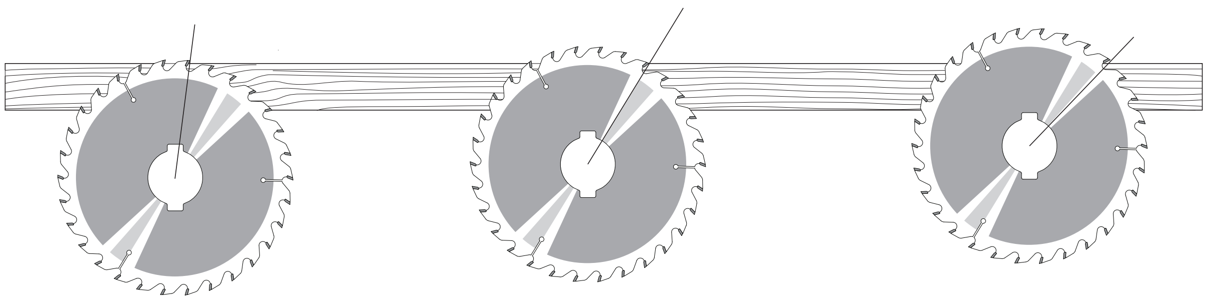
The table shows the recommended feed per tooth (Sz in mm) for different materials.

Solid wood,	
crosscutting	0,10-0,35
ripping, dry	0,10-0,20
ripping, green	0,20-0,80
saw mill	0,70-1,50
Plastics	0,04-0,08
Pure aluminium	0,05-0,12
Al alloy	0,03-0,08
Mg alloy	0,03-0,08
Cu alloy	0,03-0,08
Chipboard	0,08-0,25
Plywood	0,08-0,25
MDF	0,08-0,12
Hard fibreboard	0,08-0,12
Veneered board	0,08-0,12
Laminated board	0,08-0,12

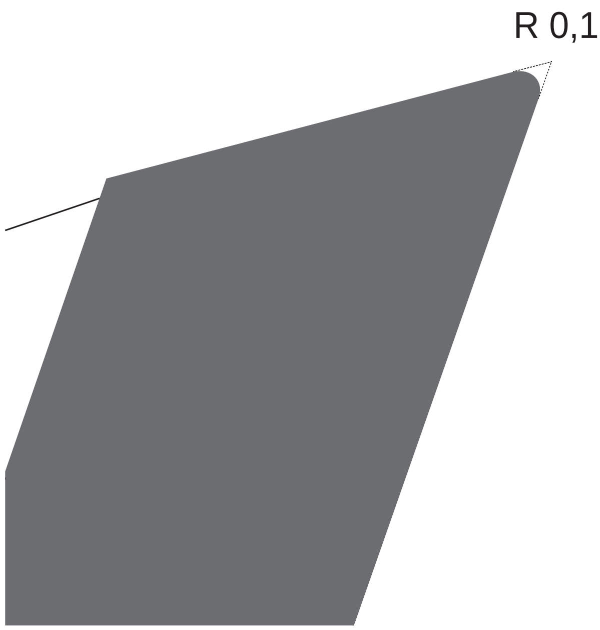
$$\text{Feed / tooth} = \frac{\text{Feedspeed x 1000}}{\text{Rpm x Z}}$$

Height of blade above work piece

Tool and machine manufacturers recommend a certain rake angle for the material to be cut. Blades are usually designed for a stadard working height of 10-25 mm above the material to be cut.
The sketches show that the rake angle varies with the cutting set-up. If the working height is increased significantly the rake angle must be modified.



Maintenance



A carbide tipped blade is a precision tool and requires careful maintenance to ensure a long service life and good performance throughout its life. Blades must be re-sharpened at the right time, i.e. when the surface of the tip becomes unacceptable, when the tip edge radius exceeds 0.1 mm, or when the cutting edge becomes chipped. Normally a carbide tipped blade can be re-sharpened 20-30 times depending on the size of the carbide tips.
During servicing shims should always be placed between blades. Teeth are very sensitive to knocks and impacts.

Clean blades regularly to remove the residue of chips and resin that sticks to cutting edges, gullets and the sides of the blade. This residue increases friction and makes the blade run hot and twist or lose tension. Increased wear may also cause the blade to crack.

Regrinding

The standard procedure for regrinding carbide and stellite tipped blades is as follows:

1. Cleaning the blade

Start by cleaning the blade thouroughly. Use a cleaning agent that will remove resin. Do not scrape the blade with a sharp object as this can cause burrs and accelerate coating of the blade. Instead wipe the blade clean and dry with a soft rag.

2. Replace damaged carbide tips

Check if any of the teeth are damaged or missing. Replace them with teeth of the same type. If several damaged teeth are close together they should not be brazed in sequence. Instead you should braze alternate teeth (1, 3, 5) and then go back (2, 4, 6, etc.)

The procedure for brazing carbide tips is briefly as follows:

A Remove any particles of carbide by heating and grind all traces of braze from the seat.

B If necessary to degrease, wash with acetone or the like.

C Brush the tooth seat with flux.

D Place the braze on the tooth seat using pliers and brush with flux.

E Line up the tooth with the seat using pliers.

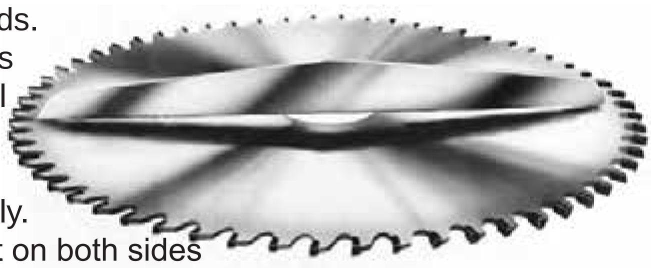
F Hold the tooth on the seat during brazing.

G Wash off any traces of flux in warm water.

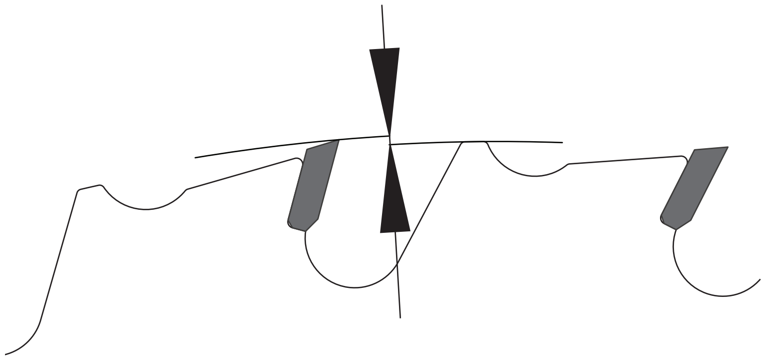
If using high frequency brazing we recommend a temperature of 730°C. If gas brazing, heat gently with a flame until the braze melts. We recommend a silver braze of the 3 layer type with a paste type flux. It is recommended that you use a fume extractor during brazing.

3. Levelling and tensioning

Check that the blade is flat and correctly tensioned. Levelling is easier if you have a well organised work area and accurate measuring tools. Make sure the light is coming from directly ahead. If the blade is correctly tensioned you should see a gap across the full diameter.



A higher tension is required at higher cutting speeds. The blade should be uniformly tensioned across its full diameter. Check with a steel rule roughly equal in length to the radius of the blade. Remove any high or low spots using a roundhead hammer. Otherwise they will cause the blade to run unevenly. Place the blade on an anvil and check that it is flat on both sides using a long rule. If the blade has high spots or is uneven it should be levelled using a cross-faced hammer.



4. Grinding edge of tooth

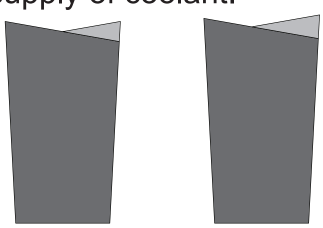
Blades with guard teeth (S) must be ground as follows:

x = 0,5-0,6 if kerf <= 2,5 mm
x = 0,7-1,0 if kerf > 2,5 mm

5. Grinding carbide tips

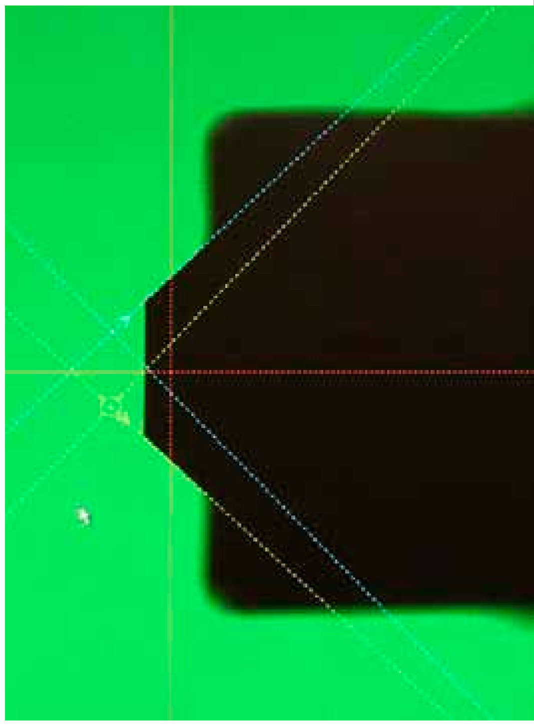
These are the most important factors for achieving good results:

- A stable grinding machine with good bearings.
- The blade must be properly secured in the mach ine and gripped as close to the point of grinding as possible.
- Right choice of grinding wheel.
- Right grinding data.
- Good supply of coolant.



Right Wrong

When grinding, ensure blade is mounted centrally!



A. Side grinding of replaced carbide tips.

Grind to the same radial and tangential clearance angles as the original carbide tips. Check that the replaced teeth have the same kerf and clearance as original teeth. Recommended grit size of diamond wheel for side grinding is D91 or D126.
When grinding, ensure blade is mounted centrally!

B. Front grinding

Grind no more than necessary, usually 0,05-0,1 mm. Do not change the original rake angle and grind the whole tip. Recommended grit size of diamond wheel for front grinding is D76 or D64 for normal standards of finish, and D54 or D46 where a better surface finish is required. *When grinding, ensure blade is mounted centrally!*

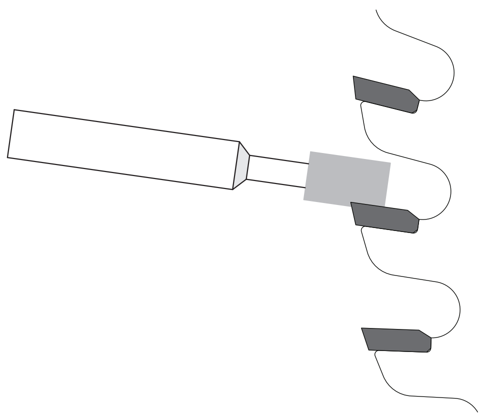
C. Top grinding

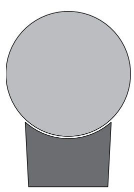
Grind the blade to maintain the original tooth shape and clearance angle. Check that both teeth are of the same height (tooth shape BA). The maximum allowable difference is 0,05 mm. In the case of tooth shapes EA, EAX and EAXH there must be a difference of 0,3 mm between straight and trapezoidal teeth. In the case of EAM shape teeth the difference should be 0,2 mm. Recommended grit size of diamond wheel for top grinding is D54 for single wheel, or D126/D46 for a twin rim wheel. If the blade is used to cut perspex we recommend D20B. *When grinding, ensure blade is mounted centrally!*

7. Grinding hollow ground carbide tips

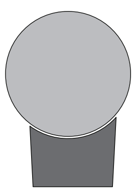
Use a grinding tool with a diameter suitable for the kerf of the blade.

Kerf:	3,0 mm
Tool diameter:	7,0 mm
Kerf:	3,6 mm





Right



Wrong

When grinding, ensure blades is mounted centrally

Important when grinding carbide tips!

For best results we recommend the following grinding times:

- front grinding 8-10 seconds, depending on length of tip
- top grinding 5-6 seconds

NOTE! These times are grinding times.

Longer grinding times give a better surface finish and extend tooth life.

Always use automatic grinding machines!

Use plenty of coolant!

Troubleshooting chart

Type of problem	Cause
Blade vibrating - poor cut.	Blade incorrectly tensioned. Faulty spindle bearings. Warped flanges or spacers. Centre hole out of centre. Unbalanced blade.
Burn marks on blade; -- single spot.	 Flanges warped. Spindle off centre.
-- circle of spots.	Blade incorrectly tensioned. Faulty riving knife.
Blade cuts well initially but veers in one direction after a few seconds.	Blade incorrectly tensioned Feed not parallel.
Cracks in gullet or slots.	Blade is blunt. Incorrect feed per tooth
Blade gives a straight cut but cut surface is rough.	Blade is blunt. Feed rate too high.
Blade leaves stripes on work piece.	Blade incorrectly tensioned. Flanges warped. Side grinding.
Blade cuts slowly.	Cutting speed to slow. Blade is blunt. Incorrect rake angle.
Blade pulls itself into work piece..	Incorrect rake angle.
Coating of resin, etc. on blade	Gullet too small Too many teeth.

when performance counts

Quote / Order form.

Customer numberr:

Company:

Street:

Post code:

Country:

Phone / fax:

Contact person:

☐ Quote ☐ Order

Date:

Quote / Order no:

No. of pieces:

Workpiece material:

Quality:

Machining method:

Cutting height: mm

Cutting method: ☐ single piece ☐ in stack

Cutting quality: ☐ rough ☐ fine ☐ ultra fine

Solid wood: ☐ along grain ☐ across grain

Panel material: ☐ sizing ☐ square-cutting

Machine:

Manufacturer:

Type

Model:

Rpm: n/min

Type of feed: ☐ Man ☐ Mec

Feed rate: m/min

Flange diameter: mm

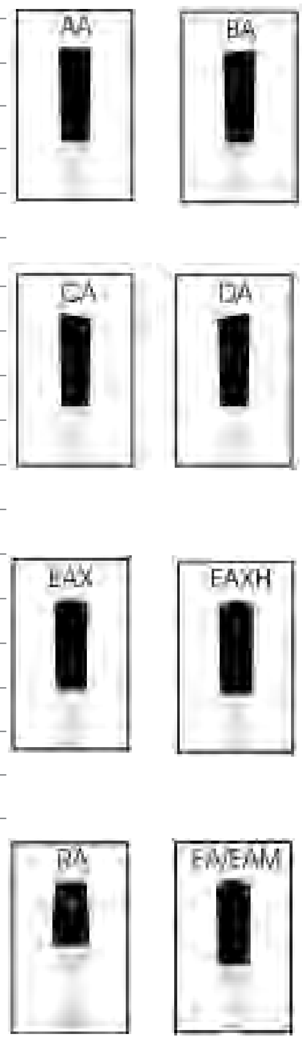
Cutting direction: ☐ against feed ☐ with feed

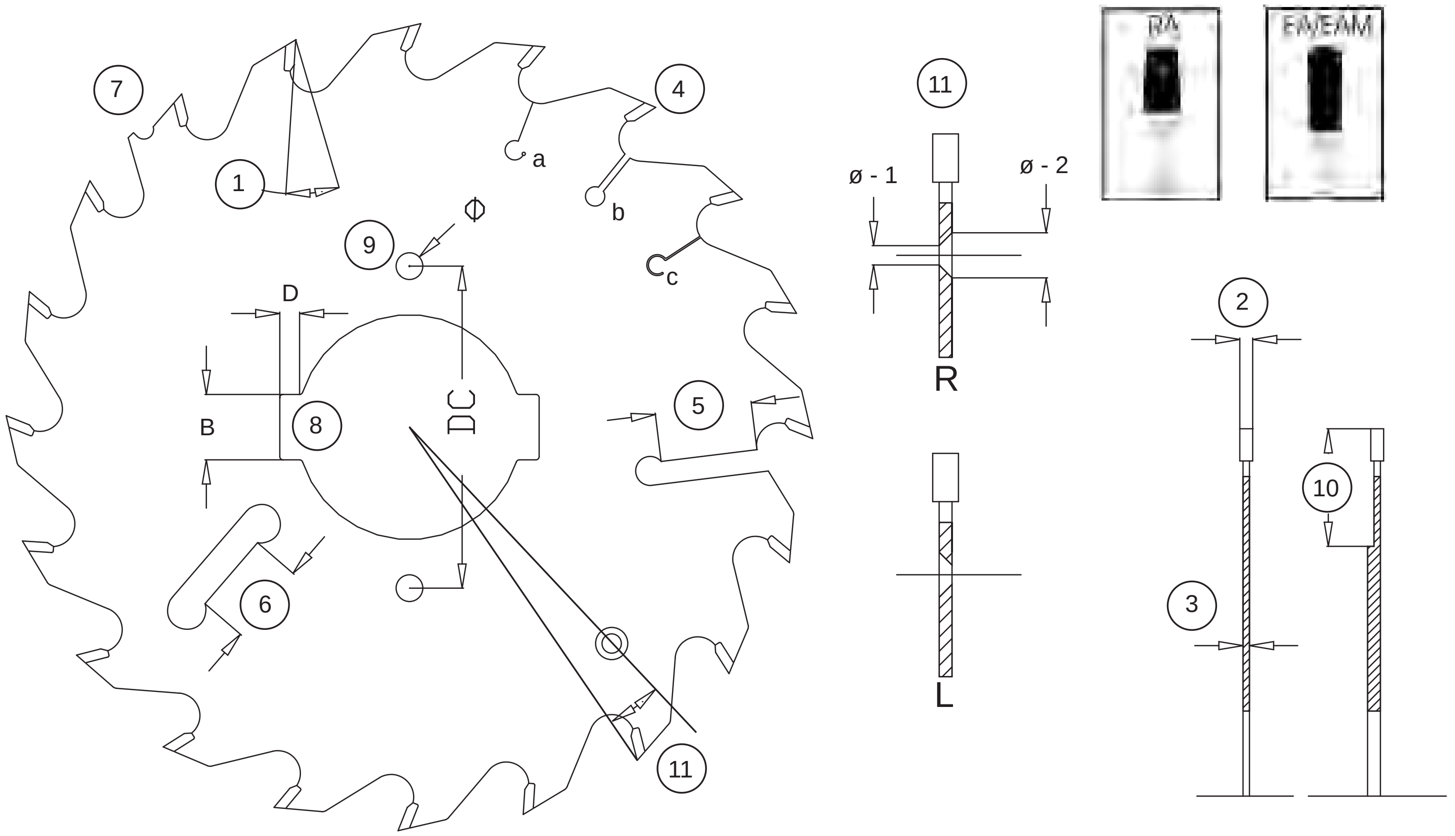
Technical Specification

Company info.
Assortment & ordering info.
How to choose the right blade
Saw mill
Floor & Multix rip
Panel sizing
Metal cutting
Cut & Ripping
Technical info

	Code:				
	Diameter:		mm		
	Bore:		mm		
1.	Rake angle:		°		
2.	Kerf:		mm		
3.	Plate:		mm		
	No. of tips:		qty		
4.	Expansion slots:		qty		mm
5.	Open wiperslots:		qty		mm
6.	Closed wiperslots:		qty		mm
	Flange diameter:		mm		
7.	Guard tooth:	Yes ☐		No ☐	
8.	Keyways:		qty	B:	mm
				D:	mm
9.	Pinhole:		qty	ø:	mm
				C/C:	mm
10.	Sawdepth:		mm	Hub thickness:	mm
11.	Screwhole:	R ☐ L ☐	qty	ø-1:	mm
	angle:	C/C:	mm	ø-2:	mm
	Further information:				

Type of tip.





If not specified, the Micor standard is applicable.