

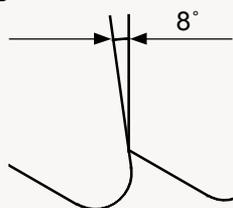
GENERAL INFORMATION

ADVANTAGES WITH BI-METAL

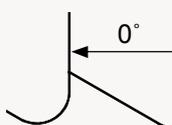
Bi-Metal blades combine the advantages of a high speed cutting edge and the features of a highly fatigue resistant steel in the body of the blade. This contributes to long blade life, faster and more uniform cutting rates.

Håkansson Sågblad world-renowned heat treating experience gives an excellent background to the development of this type of blades.

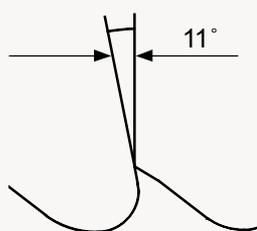
PFV/PC



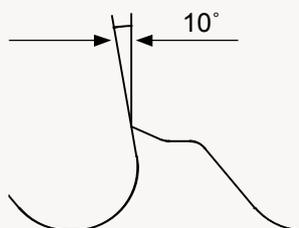
FV



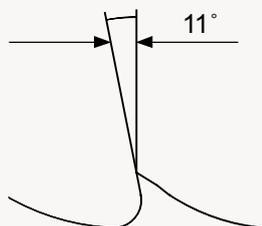
PCV3



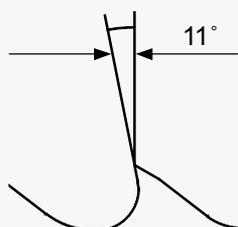
PXV



POV2



POV2 PCV3



M42 Allpower®

This is our most versatile band saw blade. It provides maximum production when cutting a variety of materials, from large profiles and solid materials to non-ferrous metals. Available in both positive and neutral tooth.

M42 Commander™

For tough and demanding production cutting of tool steels, structural steels and difficult to cut materials. With specially designed tooth for optimal chip flow and increased cutting speed when cutting solid materials.

M42 PowerMax™

The unique tooth profile is specially developed for pipes, beams, tubes and profiles. The reinforced tooth works extremely well when bundle cutting.

M42 Opimizer™

For production cutting of heavy sections in stainless, titanium and cobalt based materials. Specially designed tooth profile for maximum chip ejection.

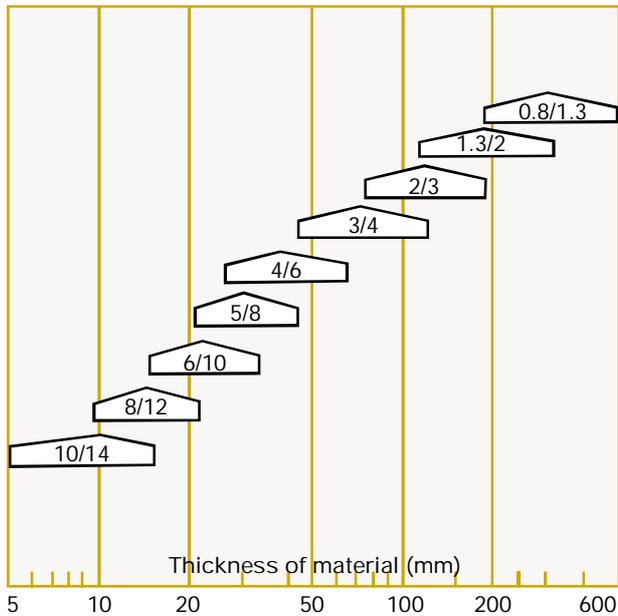
M51 Perfomer

Premium band saw blade for very difficult to cut material. Tooth tips of HSS M51 material. Extra heavy set and deep gullet provides increased cutting rate. High heat and wear resistance.

GENERAL INFORMATION

RECOMMENDED TOOTH PITCH FOR...

SOLID WORK PIECE



The adjoining diagram is a guide to your choice of tooth pitch when cutting solid work pieces.

The very best choice is where the tooth pitch-area is at its widest.

When cutting soft materials such as wood, plastics, aluminum etc. choose a two step coarser tooth pitch.

TOOTH SETTINGS

Raker set (RS)

One tooth is set to the right, the next to the left and the third is straight.

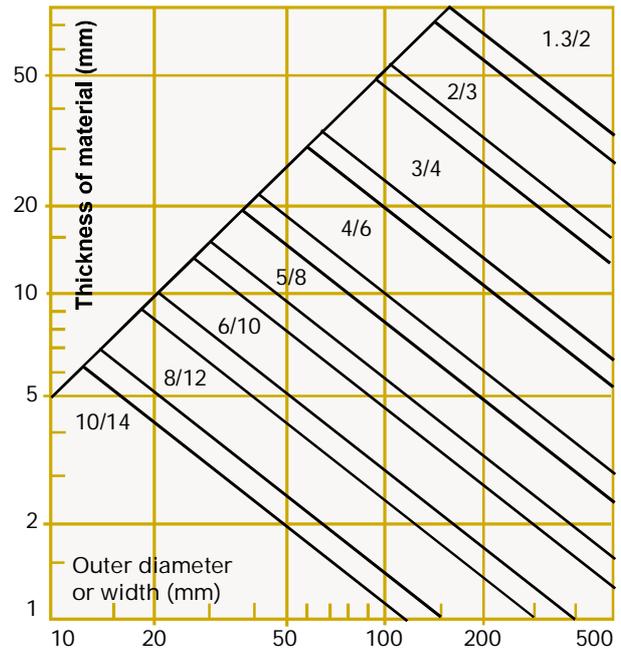
Alternet set (AS)

This setting has one tooth set to the right, the following to the left, the next to the right and so on.

Alternet rake (AR)

A group of AS set teeth is followed by a straight tooth.

PIPES AND PROFILES



The adjoining diagram is a guide to your choice of tooth pitch when cutting pipes and profiles.

The very best choice is in the area, where a line from the outer diameter crosses a line from the thickness of the material.

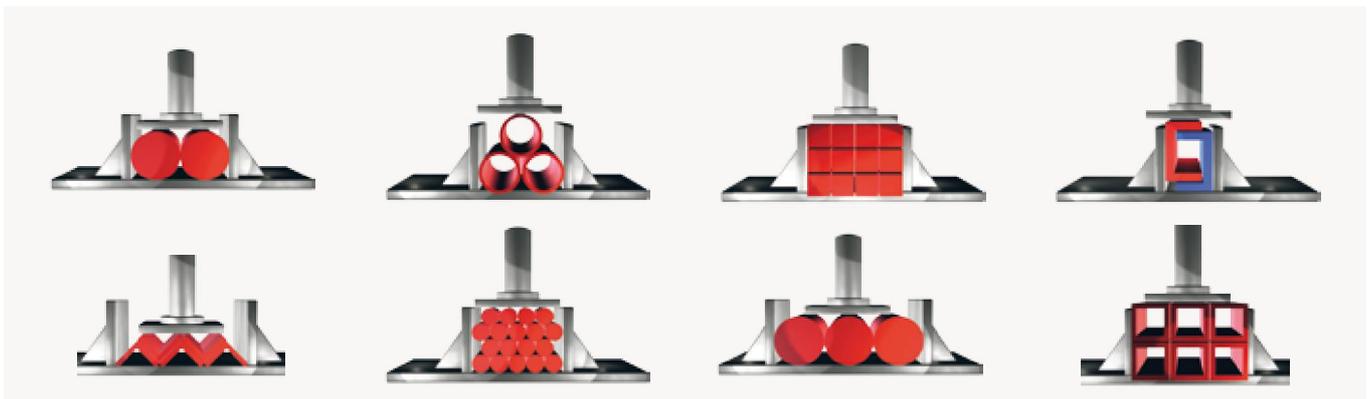
When cutting profiles, choose the tooth pitch, where the line from the width of the profile crosses the line from the material thickness of the profile.



GENERAL INFORMATION

HOW TO CLAMP

Recommendations for material clamping. The correct clamping of the material will considerably contribute to the performance of the sawing operation. Please note the difference in clamping when using conventional bandsaw and double column horizontal machines.



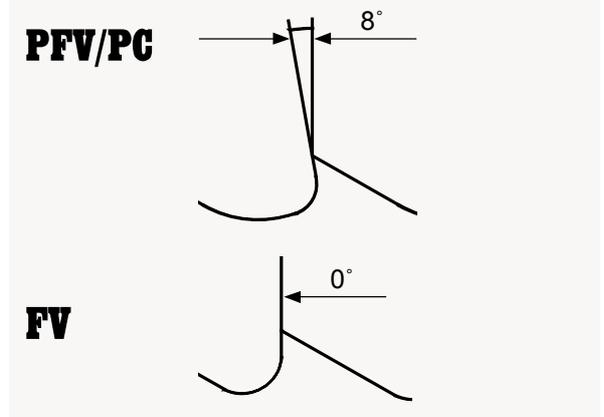
BREAKING-IN A BAND SAW BLADE

Bi-Metal band saw blade: To achieve a long blade life the breaking-in of the blade is important. A new band saw blade should operate with 50 % of full feed rate, for about 15 minutes. After that the feed rate may be increased slowly up to the full rate.

Carbide tipped band saw blade: This type of blade should operate with 75 % of the cutting speed and 50 % of the feed rate during breaking-in, about 15 minutes. The cutting speed and feed rate can then slowly be increased up to the full rate.

BI-METAL BAND SAW BLADE

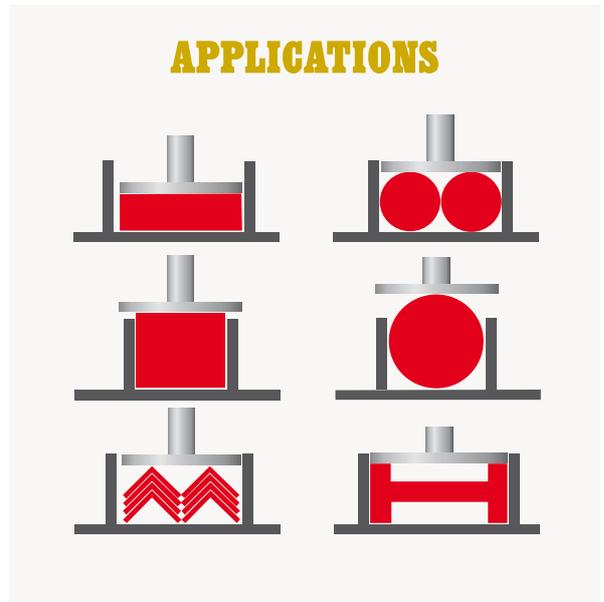
ALLPOWER®



M42 ALLPOWER® A VERSATILE BLADE

- Our most popular allround blade
- Suitable for production as well as non-production cutting
- Produced from HSS M42 edge and known for its consistency
- The popular choice from workshops to heavy industrial cutting
- A large variety of pitches available
- Tooth set AR

APPLICATIONS



SPECIFICATIONS

	3	4	6	2/3	3/4	4/6	5/8	6/10	8/12	10/14	
10 x 0.9		●								○	3/8 x .035
12 x 0.6	●	●	●					○	○	○	1/2 x .025
12 x 0.9	●	●								○	1/2 x .035
19 x 0.9	●	●				●	○	○	○	○	3/4 x .035
27 x 0.9				●	●	●	●	○	○	○	1 x .035
34 x 1.1				●	●	●	●	○	○		1 1/4 x .042
41 x 1.3				●	●	●	●	○			1 1/2 x .050
54 x 1.6				●	●	●	●				2 x .063
67 x 1.6				●	●	●					2 5/8 x .063

● Positive tooth

○ Neutral tooth