



METALLKREISSÄGEBLÄTTER
METAL CUTTING CIRCULAR SAW BLADES

04/07



Dress Werkzeuge
Hentschke GmbH & Co



Metallkreissägeblätter aus HSS/DMo 5 für Kreissägemaschinen, dampfbehandelt
Metal cutting circular saw blades made of HSS/DMo 5 for sawing machines, vaporized

| Abmessung/Size mm | t=Zahnteilung/t=Pitch Zähnezahl/No. of teeth Zahnform/Tooth form | | | | | | | | | | | HSS/DMo 5 € | Zuschlag/Extra charge HSS-E/EMo5 Co5 | Zuschlag/Extra charge TiN-Beschichtung/TiN-Coating € netto/net | |
|-------------------|--|---|-----|-----|-----|-----|-----|-----|-----|----|----|----------------|---|--|-------|
| | t= | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | | | | |
| 200 x | 1 | x 32 | | | | | | | | | | | 64,50 | | |
| | 1,2 | x 32 | | | | | | | | | | | 56,00 | | |
| | 1,5 | 200 | 160 | 128 | 100 | 90 | 80 | | | | | 64 | 52,00 | | |
| | 1,6 | BW | BW | C | C | C | C | | | | | C | 52,00 | + 25% | 10,15 |
| | 1,8 | x 32 | | | | | | | | | | | 52,00 | | |
| | 2 | x 32 | | | | | | | | | | | 52,00 | | |
| | 2,5 | x 32 | | | | | | | | | | | 64,00 | | |
| 210 x | 2 | Zahnteilung zwischen 3 - 20 auf Wunsch Tooth pitch between 3 - 20 on request | | | | | | | | | | | 73,00 | + 25% | 11,15 |
| 225 x | 1,2 | x 32/40 | | | | | | | | | | | 71,50 | | |
| | 1,5 | x 32/40 | | | | | | | | | | | 66,00 | | |
| | 1,6 | 220 | 180 | 144 | 120 | 100 | 90 | 80 | 72 | | | 60 | 66,00 | | |
| | 1,8 | BW | BW | C | C | C | C | C | C | | | C | 64,00 | + 25% | 11,15 |
| | 1,9 | x 32/40 | | | | | | | | | | | 59,00 | | |
| | 2 | x 32/40 | | | | | | | | | | | 59,00 | | |
| | 2,5 | x 32/40 | | | | | | | | | | | 78,50 | | |
| 250 x | 1 | x 32/40 | | | | | | | | | | | 92,50 | | |
| | 1,2 | x 32/40 | | | | | | | | | | | 74,00 | | |
| | 1,5 | x 32/40 | | | | | | | | | | | 68,00 | | |
| | 1,6 | 250 | 200 | 160 | 128 | 112 | 100 | 84 | 80 | 72 | 64 | 68,00 | | | |
| | 1,8 | BW | BW | C | C | C | C | C | C | C | C | 68,00 | + 25% | 12,10 | |
| | 2 | x 32/40 | | | | | | | | | | | 68,00 | | |
| | 2,5 | x 32/40 | | | | | | | | | | | 76,50 | | |
| | 3 | x 32/40 | | | | | | | | | | | 106,00 | | |
| 275 x | 1,6 | x 32/40 | | | | | | | | | | | 93,50 | | |
| | 1,8 | 280 | 220 | 180 | 140 | 120 | 110 | 96 | 90 | | | 70 | 89,50 | | |
| | 2 | BW | BW | C | C | C | C | C | C | | | C | 89,50 | + 25% | 14,25 |
| | 2,5 | x 32/40 | | | | | | | | | | | 93,00 | | |
| | 3 | x 32/40 | | | | | | | | | | | 124,00 | | |
| 300 x | 1,6 | x 32/40 | | | | | | | | | | | 114,50 | | |
| | 1,8 | 300 | 220 | 190 | 160 | 128 | 120 | 110 | 90 | | | 80 | 113,50 | | |
| | 2 | BW | BW | C | C | C | C | C | C | | | C | 113,50 | + 25% | 15,10 |
| | 2,5 | x 32/40 | | | | | | | | | | | 113,50 | | |
| | 3 | x 32/40 | | | | | | | | | | | 122,50 | | |
| 315 x | 1,6 | x 32/40 | | | | | | | | | | | 137,00 | | |
| | 1,8 | x 32/40 | | | | | | | | | | | 137,00 | | |
| | 2 | 320 | 250 | 200 | 160 | 140 | 120 | 110 | 100 | | | 80 | 121,50 | + 25% | 18,70 |
| | 2,5 | BW | BW | C | C | C | C | C | C | | | C | 121,50 | | |
| | 3 | x 32/40 | | | | | | | | | | | 136,00 | | |
| | 3,5 | x 32/40 | | | | | | | | | | | 143,50 | | |



| Abmessung/Size mm | t=Zahnteilung/t=Pitch Zähnezahl/No. of teeth Zahnform/Tooth form | | | | | | | | | | | HSS/DMo 5 € | Zuschlag/Extra charge HSS-E/EMo5 Co5 | Zuschlag/Extra charge TiN-Beschichtung/TiN-Coating € netto/net | |
|-------------------|--|--|-----|-----|-----|-----|-----|-----|-----|--------|--------|----------------|---|--|-------|
| | t= | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | | | | |
| 325 x 2 | x 32/40 | | | | | | | | | | | 137,00 | | | |
| | 2,5 x 32/40 | Zahnteilung zwischen 3 - 20 auf Wunsch | | | | | | | | | | | 143,00 | + 25% | 18,70 |
| | 3 x 32/40 | Tooth pitch between 3 - 20 on request | | | | | | | | | | | 159,50 | | |
| 350 x 1,8 | x 32/40/50 | | | | | | | | | | | 173,50 | | | |
| | 2 x 32/40/50 | | | | | | | | | | | 149,00 | | | |
| | 2,5 x 32/40/50 | 280 | 220 | 180 | 160 | 140 | 120 | 110 | 100 | 90 | 147,50 | + 25% | 25,70 | | |
| | 3 x 32/40/50 | BW | BW | C | C | C | C | C | C | C | 166,00 | | | | |
| | 3,5 x 32/40/50 | | | | | | | | | | 185,50 | | | | |
| 370 x 2,5 | x 40/50 | | | | | | | | | | 202,50 | | | | |
| | 3 x 40/50 | 280 | 220 | 200 | 160 | 140 | 120 | 110 | 100 | 90 | 198,50 | + 25% | 33,00 | | |
| | 3,5 x 40/50 | BW | BW | C | C | C | C | C | C | C | 221,00 | | | | |
| 400 x 2,5 | x 40/50 | | | | | | | | | | 246,50 | | | | |
| | 3 x 40/50 | 250 | 200 | 180 | 160 | 140 | 128 | 114 | 100 | 242,50 | + 25% | | | | |
| | 3,5 x 40/50 | BW | C | C | C | C | C | C | C | 255,50 | | | | | |
| | 4 x 40/50 | | | | | | | | | | 292,00 | | | | |
| 425 x 2,5 | x 40/50 | | | | | | | | | | 297,50 | | | | |
| | 3 x 40/50 | 260 | 220 | 180 | 160 | 140 | 128 | 120 | 110 | 278,00 | + 25% | | | | |
| | 3,5 x 40/50 | BW | C | C | C | C | C | C | C | 301,50 | | | | | |
| | 4 x 40/50 | | | | | | | | | | 325,00 | | | | |
| 450 x 2,5 | x 40/50 | | | | | | | | | | 375,00 | | | | |
| | 3 x 40/50 | Zahnteilung zwischen 3 - 20 auf Wunsch | | | | | | | | | | | 359,00 | + 25% | |
| | 3,5 x 40/50 | Tooth pitch between 3 - 20 on request | | | | | | | | | | | 383,50 | | |
| | 4 x 40/50 | | | | | | | | | | | 417,00 | | | |
| 500 x 3 | x 40/50 | | | | | | | | | | 457,00 | | | | |
| | 3,5 x 40/50 | Zahnteilung zwischen 3 - 20 auf Wunsch | | | | | | | | | | | 501,50 | + 25% | |
| | 4 x 40/50 | Tooth pitch between 3 - 20 on request | | | | | | | | | | | 541,50 | | |
| | 5 x 40/50 | | | | | | | | | | | 594,00 | | | |

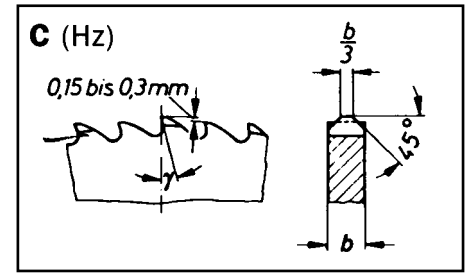
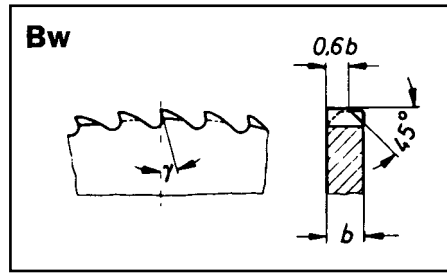
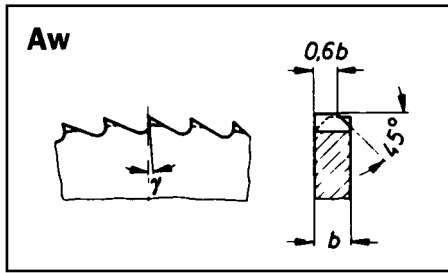


Metallkreissägeblätter für GF Maschinen aus HSS-E/EMo5 Co5

Metal cutting circular saw blades for GF machines made of HSS-E/EMo5 Co5

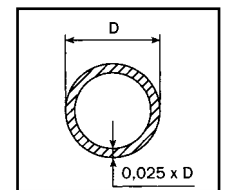
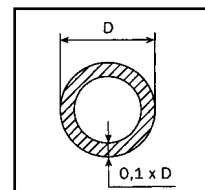
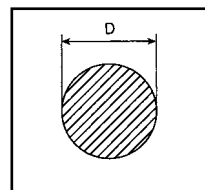
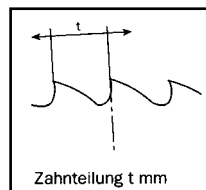
| Abmessung Size mm | Zähnezahl/Zahnform No. of teeth/Tooth form | Preis/Price € |
|----------------------|---|------------------|
| 63 x 1,6 x 16 | 64 BW | 20,50 |
| 63 x 1,6 x 16 | 44 BW | 20,50 |
| 68 x 1,6 x 16 | 64 BW | 21,50 |
| 68 x 1,6 x 16 | 44 BW | 21,50 |

Andere Abmessungen auf Anfrage/other sizes on request



Empfohlene Zahnteilung t
(Richtwert) für Stahlbearbeitung

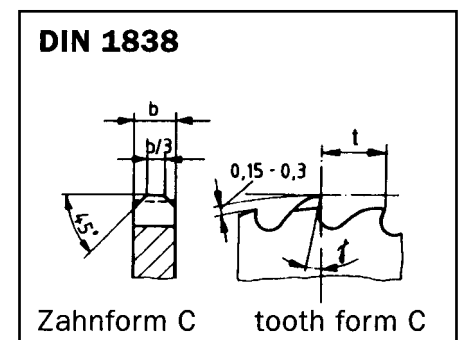
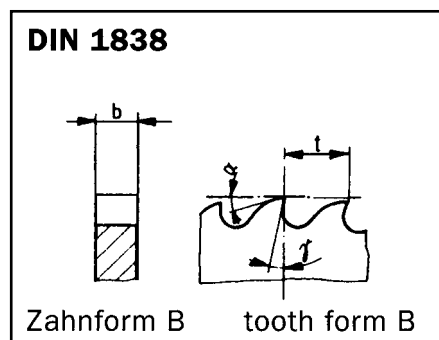
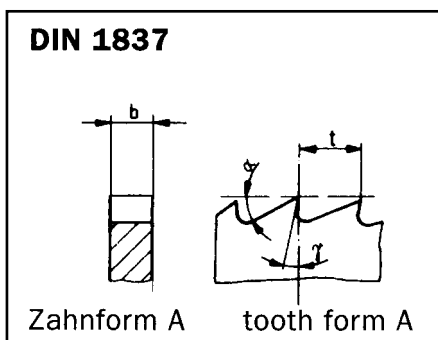
Reference Values for Toothing



| | | | |
|----|-------|--------|-----|
| 3 | 10-15 | 15 | 40 |
| 4 | 15-20 | 20 | 50 |
| 5 | 20-25 | 25 | 60 |
| 6 | 25-30 | 30 | 70 |
| 8 | 30-50 | 40 | 140 |
| 9 | 50-60 | 60 | 150 |
| 10 | 60-80 | 50-70 | 160 |
| 12 | 80-90 | 60-100 | - |
| 14 | 100 | 90-140 | - |

Für Aluminium ist je nach Trennquerschnitt die Zahnteilung um ca. 2-4 mm größer zu wählen, während wir für rostfreie VA-Stähle eine um 2-3 mm kleinere Zahnteilung empfehlen. Bei Sägeblättern für Leichtmetalle oder Kunststoffe bitten wir um Angabe der Drehzahl der Maschine.

According to the cutting section the tooth pitch has to be increased by 2-4 mm for aluminium, whereas for cutting stainless steels we propose to reduce the tooth pitch by approx. 2-3 mm. For saw blades working non-ferrous metals or plastics we should know r.p.m. of the machine.



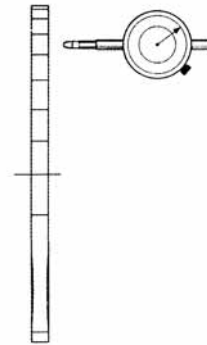


Bohrungen/Seitenschlag/Stahlqualitäten Bore/Run-out/Steel qualities

| Bohrungen (Standard) Bore (Standard) | Nebenlöcher (Standard) Pin holes (Standard) |
|---|---|
| 32 mm | 2/8/45+2/11/63 mm oder/or 4/9/50 mm |
| 40 mm | 2/8/55+4/12/64 mm oder/or 2/8/55+4/12/64+2/15/80 mm |
| 50 mm | 4/15/80+4/14/85 mm |

Seitenschlag Run-out

| Ø | Standard |
|-----------|----------|
| 175 - 275 | 0,20 |
| 300 - 400 | 0,25 |
| 425 - 500 | 0,30 |



Stahlqualitäten Steel qualities

| | AISI | DIN |
|-----------|------|--------|
| HSS DMo5 | M2 | 1.3343 |
| HSS-E Co5 | M35 | 1.3243 |

HSS/DMo 5 dampfbehandelt

Dampfbehandelte Metallkreissägeblätter haben eine Oberflächenvergütung, wobei eine Oxydschicht aufgedampft wird. Diese zeichnet sich durch gute Gleitfähigkeit und höhere Saugfähigkeit zur Aufnahme des Kühl-Schmiermittels aus und vermeidet Aufbauschneiden.

HSS-E/EMo 5 Co 5 dampfbehandelt

Für das Sägen sehr harter Stähle und für extreme Arbeitsbedingungen stehen Sägeblätter aus kobaltlegiertem Hochleistungs-Schnellstahl zur Verfügung.

HSS/DMo 5 vaporized

Vaporized circular saw blades do have a surface treatment by applying an oxide coating by steam. The special advantages are sliding ability and increased absorptive capacity for reception of the cooling liquid and avoiding the sticking up of material.

HSS-E/EMo 5 Co 5 vaporized

For the sawing of very hard steels and for extreme working conditions we recommend sawblades made of cobalt alloyed high speed steel.



Metallkreissägeblätter aus HSS/DMo 5 nach DIN
Metal slitting saws made of HSS/DMo 5 acc.to DIN

| Ø Dia. mm j15 | Breite Thickness mm j 11 | Bohrung Bore mm H 7 | DIN 1837 A | Art.-Nr. | Zähnezahlen - No. of teeth | | | | Preis - Price EURO Zahnform DIN 1840 tooth form DIN 1840 | |
|---------------------|--------------------------------|---------------------------|---------------|----------|----------------------------|----------|---------------|----------|--|-------------|
| | | | | | DIN 1838 B | Art.-Nr. | DIN 1838 C | Art.-Nr. | A-B | C |
| 20 | 0,2 | 5 | 80 | 8020011 | - | - | - | - | 10,00 | Auf Anfrage |
| | 0,25 | | 64 | 8020021 | - | - | - | - | 10,00 | |
| | 0,3 | | 64 | 8020031 | - | - | - | - | 9,00 | |
| | 0,4 | | 64 | 8020041 | - | - | - | - | 9,00 | |
| | 0,5 | | 48 | 8020051 | - | - | - | - | 9,00 | |
| | 0,6 | | 48 | 8020061 | - | - | - | - | 9,00 | |
| | 0,8 | | 48 | 8020071 | - | - | - | - | 9,00 | |
| | 1 | | 40 | 8020081 | - | - | - | - | 9,00 | |
| | 1,2 | | 40 | 8020091 | - | - | - | - | 10,00 | |
| | 1,6 | | 40 | 8020101 | - | - | - | - | 11,00 | |
| | 2 | | 32 | 8020111 | - | - | - | - | 11,50 | |
| | 2,5 | | 32 | 8020121 | - | - | - | - | 12,50 | |
| | 3 | | 32 | 8020131 | - | - | - | - | 13,50 | |
| | 4 | | 24 | 8020141 | - | - | - | - | 15,00 | |
| | 5 | | 24 | 8020151 | - | - | - | - | 18,00 | |
| 6 | 24 | 8020161 | - | - | - | - | 20,50 | | | |
| 25 | 0,2 | 8 | 80 | 8025011 | - | - | - | - | 10,50 | on request |
| | 0,25 | | 80 | 8025021 | - | - | - | - | 10,50 | |
| | 0,3 | | 80 | 8025031 | - | - | - | - | 9,50 | |
| | 0,4 | | 64 | 8025041 | - | - | - | - | 9,50 | |
| | 0,5 | | 64 | 8025051 | - | - | - | - | 9,50 | |
| | 0,6 | | 64 | 8025061 | - | - | - | - | 9,50 | |
| | 0,8 | | 48 | 8025071 | - | - | - | - | 9,50 | |
| | 1 | | 48 | 8025081 | - | - | - | - | 9,50 | |
| | 1,2 | | 48 | 8025091 | - | - | - | - | 10,50 | |
| | 1,6 | | 40 | 8025101 | - | - | - | - | 11,50 | |
| | 2 | | 40 | 8025111 | - | - | - | - | 12,00 | |
| | 2,5 | | 40 | 8025121 | - | - | - | - | 13,00 | |
| | 3 | | 32 | 8025131 | - | - | - | - | 14,00 | |
| | 4 | | 32 | 8025141 | - | - | - | - | 17,00 | |
| | 5 | | 32 | 8025151 | - | - | - | - | 19,50 | |
| 6 | 24 | 8025161 | - | - | - | - | 22,00 | | | |
| 32 | 0,2 | 8 | 100 | 8032011 | - | - | - | - | 11,00 | Auf Anfrage |
| | 0,25 | | 100 | 8032021 | - | - | - | - | 11,00 | |
| | 0,3 | | 80 | 8032031 | - | - | - | - | 10,00 | |
| | 0,4 | | 80 | 8032041 | - | - | - | - | 10,00 | |
| | 0,5 | | 80 | 8032051 | - | - | - | - | 9,50 | |
| | 0,6 | | 64 | 8032061 | - | - | - | - | 9,50 | |
| | 0,8 | | 64 | 8032071 | - | - | - | - | 9,50 | |
| | 1 | | 64 | 8032081 | - | - | - | - | 9,50 | |
| | 1,2 | | 48 | 8032091 | - | - | - | - | 11,50 | |
| | 1,6 | | 48 | 8032101 | - | - | - | - | 12,00 | |
| | 2 | | 48 | 8032111 | - | - | - | - | 13,00 | |
| | 2,5 | | 40 | 8032121 | - | - | - | - | 14,00 | |
| | 3 | | 40 | 8032131 | - | - | - | - | 14,50 | |
| | 4 | | 40 | 8032141 | - | - | - | - | 18,50 | |
| | 5 | | 32 | 8032151 | - | - | - | - | 21,00 | |
| 6 | 32 | 8032161 | - | - | - | - | 23,00 | | | |
| 40 | 0,2 | 10 | 128 | 8040011 | - | - | - | - | 12,00 | on request |
| | 0,25 | | 100 | 8040021 | - | - | - | - | 12,00 | |
| | 0,3 | | 100 | 8040031 | - | - | - | - | 11,50 | |
| | 0,4 | | 100 | 8040041 | - | - | - | - | 11,50 | |
| | 0,5 | | 80 | 8040051 | - | - | - | - | 11,00 | |
| | 0,6 | | 80 | 8040061 | - | - | - | - | 11,00 | |

| Ø Dia. mm j15 | Breite Thickness mm j 11 | Bohrung Bore mm H 7 | DIN 1837 A | Art.-Nr. | Zähnezahlen - No. of teeth | | | | Preis - Price EURO Zahnform DIN 1840 tooth form DIN 1840 | |
|---------------------|---|---------------------------|---------------|----------|----------------------------|----------|---------------|----------|--|-------------|
| | | | | | DIN 1838 B | Art.-Nr. | DIN 1838 C | Art.-Nr. | A-B | C |
| 40 | 0,8 1 1,2 1,6 2 2,5 3 4 5 6 | 10 | 80 | 8040071 | - | - | - | - | 11,00 | Auf Anfrage |
| | | | 64 | 8040081 | - | - | - | - | 11,00 | |
| | | | 64 | 8040091 | - | - | - | - | 11,50 | |
| | | | 64 | 8040101 | - | - | - | - | 12,50 | |
| | | | 48 | 8040111 | - | - | - | - | 13,50 | |
| | | | 48 | 8040121 | - | - | - | - | 14,50 | |
| | | | 48 | 8040131 | - | - | - | - | 17,00 | |
| | | | 40 | 8040141 | - | - | - | - | 20,00 | |
| | | | 40 | 8040151 | - | - | - | - | 25,00 | |
| 40 | 8040161 | - | - | - | - | 27,00 | | | | |
| 50 | 0,2 0,25 0,3 0,4 0,5 0,6 0,8 1 1,2 1,6 2 2,5 3 4 5 6 | 13 | 128 | 8050011 | - | - | - | - | 14,00 | on request |
| | | | 128 | 8050021 | - | - | - | - | 14,00 | |
| | | | 128 | 8050031 | - | - | - | - | 13,00 | |
| | | | 100 | 8050041 | - | - | - | - | 13,00 | |
| | | | 100 | 8050051 | 48 | 8050052 | - | - | 12,50 | |
| | | | 100 | 8050061 | 48 | 8050062 | - | - | 12,50 | |
| | | | 80 | 8050071 | 40 | 8050072 | - | - | 12,50 | |
| | | | 80 | 8050081 | 40 | 8050082 | - | - | 12,50 | |
| | | | 80 | 8050091 | 40 | 8050092 | 40 | 8050093 | 13,00 | |
| | | | 64 | 8050101 | 32 | 8050102 | 32 | 8050103 | 14,00 | |
| | | | 64 | 8050111 | 32 | 8050112 | 32 | 8050113 | 15,00 | |
| | | | 64 | 8050121 | 32 | 8050122 | 32 | 8050123 | 16,50 | |
| | | | 48 | 8050131 | 24 | 8050132 | 24 | 8050133 | 18,50 | |
| | | | 48 | 8050141 | 24 | 8050142 | 24 | 8050143 | 21,50 | |
| | | | 48 | 8050151 | 24 | 8050152 | 24 | 8050153 | 28,00 | |
| 40 | 8050161 | 20 | 8050162 | 20 | 8050163 | 32,00 | | | | |
| 63 | 0,25 0,3 0,4 0,5 0,6 0,8 1 1,2 1,6 2 2,5 3 4 5 6 | 16 | 160 | 8063011 | - | - | - | - | 15,50 | Auf Anfrage |
| | | | 128 | 8063021 | - | - | - | - | 14,50 | |
| | | | 128 | 8063031 | - | - | - | - | 14,50 | |
| | | | 128 | 8063041 | 64 | 8063042 | - | - | 14,00 | |
| | | | 100 | 8063051 | 48 | 8063052 | - | - | 14,00 | |
| | | | 100 | 8063061 | 48 | 8063062 | - | - | 14,00 | |
| | | | 100 | 8063071 | 48 | 8063072 | - | - | 14,00 | |
| | | | 80 | 8063081 | 40 | 8063082 | 40 | 8063083 | 14,50 | |
| | | | 80 | 8063091 | 40 | 8063092 | 40 | 8063093 | 16,50 | |
| | | | 80 | 8063101 | 40 | 8063102 | 40 | 8063103 | 17,50 | |
| | | | 64 | 8063111 | 32 | 8063112 | 32 | 8063113 | 18,50 | |
| | | | 64 | 8063121 | 32 | 8063122 | 32 | 8063123 | 20,50 | |
| | | | 64 | 8063131 | 32 | 8063132 | 32 | 8063133 | 26,00 | |
| | | | 48 | 8063141 | 24 | 8063142 | 24 | 9063143 | 32,50 | |
| | | | 48 | 8063151 | 24 | 8063152 | 24 | 8063153 | 36,50 | |
| 80 | 0,3 0,4 0,5 0,6 0,8 1 1,2 1,6 2 2,5 3 4 5 6 | 22 | 160 | 8080011 | - | - | - | - | 17,50 | on request |
| | | | 160 | 8080021 | - | - | - | - | 17,50 | |
| | | | 128 | 8080031 | - | - | - | - | 17,00 | |
| | | | 128 | 8080041 | 64 | 8080042 | - | - | 17,00 | |
| | | | 128 | 8080051 | 64 | 8080052 | - | - | 17,00 | |
| | | | 100 | 8080061 | 48 | 8080062 | - | - | 17,00 | |
| | | | 100 | 8080071 | 48 | 8080072 | 48 | 8080073 | 17,50 | |
| | | | 100 | 8080081 | 48 | 8080082 | 48 | 8080083 | 18,50 | |
| | | | 80 | 8080091 | 40 | 8080092 | 40 | 8080093 | 20,50 | |
| | | | 80 | 8080101 | 40 | 8080102 | 40 | 8080103 | 24,00 | |
| | | | 80 | 8080111 | 40 | 8080112 | 40 | 8080113 | 26,50 | |
| | | | 64 | 8080121 | 32 | 8080122 | 32 | 8080123 | 32,00 | |
| | | | 64 | 8080131 | 32 | 8080132 | 32 | 8080133 | 39,50 | |
| | | | 64 | 8080141 | 32 | 8080142 | 32 | 8080143 | 44,00 | |

| Ø Dia. mm j15 | Breite Thickness mm j 11 | Bohrung Bore mm H 7 | DIN 1837 A | Art.-Nr. | Zähnezahlen - No. of teeth | | | | Preis - Price EURO Zahnform DIN 1840 tooth form DIN 1840 | |
|---------------------|--------------------------------|---------------------------|---------------|----------|----------------------------|----------|---------------|----------|--|-------------|
| | | | | | DIN 1838 B | Art.-Nr. | DIN 1838 C | Art.-Nr. | A-B | C |
| 100 | 0,5 | 22 | 160 | 8100011 | - | - | - | - | 19,50 | Auf Anfrage |
| | 0,6 | | 160 | 8100021 | 80 | 8100022 | - | - | 19,50 | |
| | 0,8 | | 128 | 8100031 | 64 | 8100032 | - | - | 19,50 | |
| | 1 | | 128 | 8100041 | 64 | 8100042 | - | - | 19,50 | |
| | 1,2 | | 128 | 8100051 | 64 | 8100052 | 64 | 8100053 | 20,50 | |
| | 1,6 | | 100 | 8100061 | 48 | 8100062 | 48 | 8100063 | 24,50 | |
| | 2 | | 100 | 8100071 | 48 | 8100072 | 48 | 8100073 | 26,50 | |
| | 2,5 | | 100 | 8100081 | 48 | 8100082 | 48 | 8100083 | 30,00 | |
| | 3 | | 80 | 8100091 | 40 | 8100092 | 40 | 8100093 | 32,50 | |
| | 4 | | 80 | 8100101 | 40 | 8100102 | 40 | 8100103 | 44,00 | |
| 5 | 80 | 8100111 | 40 | 8100112 | 40 | 8100113 | 49,50 | | | |
| 6 | 64 | 8100121 | 32 | 8100122 | 32 | 8100123 | 57,50 | | | |
| 125 | 0,6 | 22 | 160 | 8125011 | - | - | - | - | 29,50 | on request |
| | 0,8 | | 160 | 8125021 | 80 | 8125022 | - | - | 29,50 | |
| | 1 | | 160 | 8125031 | 80 | 8125032 | - | - | 29,50 | |
| | 1,2 | | 128 | 8125041 | 64 | 8125042 | 64 | 8125043 | 29,50 | |
| | 1,6 | | 128 | 8125051 | 64 | 8125052 | 64 | 8125053 | 31,00 | |
| | 2 | | 128 | 8125061 | 64 | 8125062 | 64 | 8125063 | 32,50 | |
| | 2,5 | | 100 | 8125071 | 48 | 8125072 | 48 | 8125073 | 34,50 | |
| | 3 | | 100 | 8125081 | 48 | 8125082 | 48 | 8125083 | 38,50 | |
| | 4 | | 100 | 8125091 | 48 | 8125092 | 48 | 8125093 | 57,00 | |
| | 5 | | 80 | 8125101 | 40 | 8125102 | 40 | 8125103 | 66,50 | |
| 6 | 80 | 8125111 | 40 | 8125112 | 40 | 8125113 | 74,50 | | | |
| 160 | 1 | 32 | 160 | 8160011 | 80 | 8160012 | - | - | 41,50 | Auf Anfrage |
| | 1,2 | | 160 | 8160021 | 80 | 8160022 | 80 | 8160023 | 41,50 | |
| | 1,6 | | 160 | 8160031 | 80 | 8160032 | 80 | 8160033 | 42,50 | |
| | 2 | | 128 | 8160041 | 64 | 8160042 | 64 | 8160043 | 44,00 | |
| | 2,5 | | 128 | 8160051 | 64 | 8160052 | 64 | 8160053 | 49,50 | |
| | 3 | | 128 | 8160061 | 64 | 8160062 | 64 | 8160063 | 56,00 | |
| | 4 | | 100 | 8160071 | 48 | 8160072 | 48 | 8160073 | 79,00 | |
| | 5 | | 100 | 8160081 | 48 | 8160082 | 48 | 8160083 | 93,00 | |
| 6 | 100 | 8160091 | 48 | 8160092 | 48 | 8160093 | 106,00 | | | |
| 200 | 1 | 32 | 200 | 8200011 | - | - | - | - | 57,00 | on request |
| | 1,2 | | 200 | 8200021 | 100 | 8200022 | 100 | 8200023 | 57,00 | |
| | 1,6 | | 160 | 8200031 | 80 | 8200032 | 80 | 8200033 | 61,50 | |
| | 2 | | 160 | 8200041 | 80 | 8200042 | 80 | 8200043 | 65,50 | |
| | 2,5 | | 160 | 8200051 | 80 | 8200052 | 80 | 8200053 | 74,00 | |
| | 3 | | 128 | 8200061 | 64 | 8200062 | 64 | 8200063 | 82,50 | |
| | 4 | | 128 | 8200071 | 64 | 8200072 | 64 | 8200073 | 117,00 | |
| | 5 | | 128 | 8200081 | 64 | 8200082 | 64 | 8200083 | 139,00 | |
| 6 | 100 | 8200091 | 48 | 8200092 | 48 | 8200093 | 160,00 | | | |
| 250 | 1,6 | 32 | 200 | 8250011 | 100 | 8250012 | 100 | 8250013 | 82,50 | Auf Anfrage |
| | 2 | | 200 | 8250021 | 100 | 8250022 | 100 | 8250023 | 90,50 | |
| | 2,5 | | 160 | 8250031 | 80 | 8250032 | 80 | 8250033 | 103,00 | |
| | 3 | | 160 | 8250041 | 80 | 8250042 | 80 | 8250043 | 114,00 | |
| | 4 | | 160 | 8250051 | 80 | 8250052 | 80 | 8250053 | 165,00 | |
| | 5 | | 128 | 8250061 | 64 | 8250062 | 64 | 8250063 | 195,00 | |
| | 6 | | 128 | 8250071 | 64 | 8250072 | 64 | 8250073 | 230,50 | |
| 315 | 2,5 | 40 | 200 | 8315011 | 100 | 8315012 | 100 | 8315013 | 161,00 | on request |
| | 3 | | 200 | 8315021 | 100 | 8315022 | 100 | 8315023 | 181,00 | |
| | 4 | | 160 | 8315031 | 80 | 8315032 | 80 | 8315033 | 233,00 | |
| | 5 | | 160 | 8315041 | 80 | 8315042 | 80 | 8315043 | 284,00 | |
| | 6 | | 160 | 8315051 | 80 | 8315052 | 80 | 8315053 | 337,00 | |



Spanwinkel (γ)/Feinwinkel (α)
Rake angle (γ)/Free angle (α)

| | (γ) | (α) |
|--|--------------|--------------|
| Stahl/steel 350-900 N/mm ² | 18° | 12° |
| Stahl/steel 900-1200 N/mm ² | 12° | 6° |
| Rostfreier Stahl/stainless steel | 12° | 6° |
| Guß/cast iron | 12° | 8° |
| Aluminium und Alu-Legierungen/alu and alu alloys | 16°-22° | 10°-18° |
| Kupfer /copper | 16°-20° | 10°-18° |
| Bronze/bronze | 12° | 8° |
| Messing/brass | 15° | 15° |
| Titan/titanium | 2° | 15° |

Richtwerte für Schnittgeschwindigkeit V_c
Approx. values for cutting speed V_c

| Werkstoff material | Schnittgeschwindigkeit cutting speed v _c m/min | Werkstoff material | Schnittgeschwindigkeit cutting speed v _c m/min |
|---|---|---|---|
| Baustahl structural steel | 25 – 50 | Kupfer copper | 100 – 400 |
| Stahl steel | 15 – 30 | Phosphor-Bronze phosphorus-bronze | 100 – 400 |
| Stähle mit hoher Festigkeit steel with high tenacity | 10 – 20 | Hartbronze bronze, hard | 40 – 120 |
| Extraharte Stähle steel extra hard | 10 – 15 | Messing brass | 400 – 600 |
| Warmarbeitsstähle hot working steel | 5 – 10 | Messing legiert brass alloyed | 150 – 500 |
| Austenitische Stähle steel, mild | 10 – 20 | Grauguss cast grey | 15 – 25 |
| Aluminium unlegiert aluminium unalloyed | 1000 – 2000 | Titan-Legierungen titanium alloys | 25 – 50 |
| Alu-Legierung mit Cu-Mg-Zn Al-alloys with Cu-Mg-Zn | 500 – 1000 | Träger und Rohre Wanddicke = 0,1 D beams and pipes wall thickness = 0,1 D | 15 – 20 |
| Aluminium mit max. 5% Si-Anteil Al with max. 5% Si-components | 120 – 200 | Profileisen und Rohre Wanddicke = 0,025 D profiles and pipes wall thickness = 0,025 D | 25 – 50 |

Aufpreise

z.B. für Zwischenbreiten, Keilnuten, Nebenlöcher, extra feine Zahnung, extra starken Hohlschliff und engere Maßtoleranzen als nach DIN teilen wir Ihnen gern auf Anfrage mit.

Sonderanfertigungen

bedingen bis zu einem Netto-Auftragswert von EURO 400,- pro Abmessung einen Rüstzeit-zuschlag von EURO 75,- netto.

Sonderbeschichtungen

Alle Sägen können auch mit Sonderbeschichtungen (z.B. TiCN, TiALN, CrN, etc.) geliefert werden.

Spezialausführung

Alle Sägen können auch mit Spanteiler-Rillen geliefert werden.

Extra charges

e.g. for in-between thickness, keyways, auxiliary holes, extra fine toothing, extra-deep concave grinding, narrower size tolerances than those acc. to DIN will be indicated to you upon request.

Special versions

will be subject to a set up time extra of EURO 75,- net per size for orders having a net value of EURO 400,- or less.

Special coatings

All blades can also be delivered with special coatings (p.ex. TiCN, TiALN, CrN, etc.).

Special execution

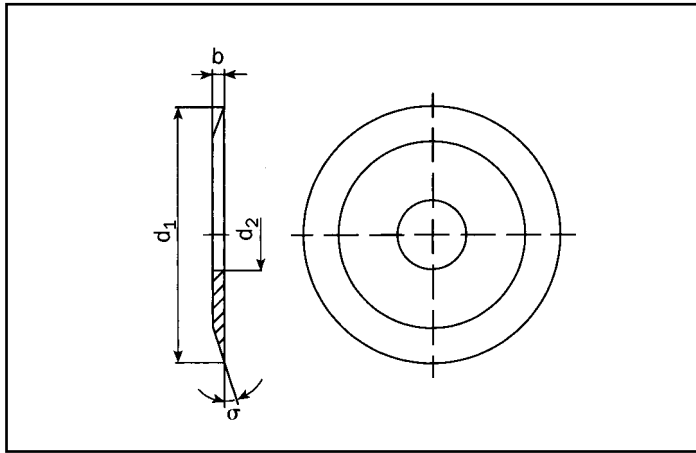
All blades can also be delivered with chip-breaker.



Auf Anfrage bieten wir gerne an:
On request we would like to offer:

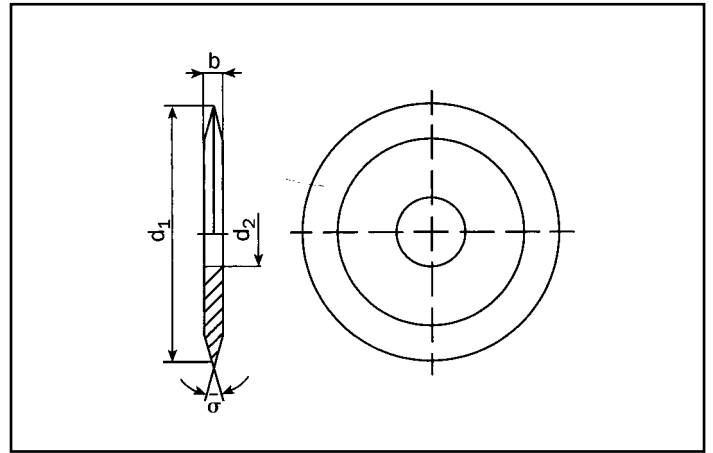
Kreismesser

mit ein- oder doppelseitiger Fase und gezahnt

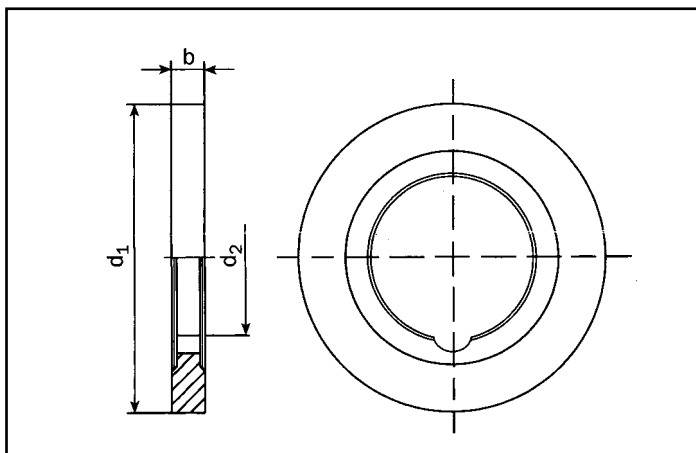


Circular knives

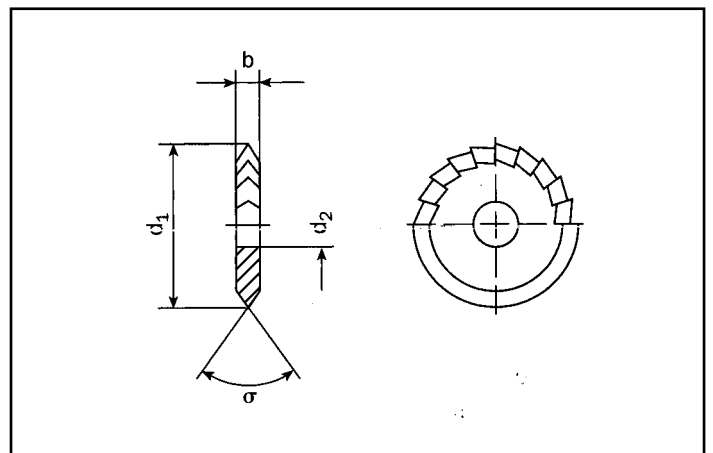
with single or double bevel and toothed



Rollscherenmesser Shear knives



Glimmerfräser Zahnung mit Dreieckprofil Mica cutters V shaped tooth profile



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