



Features

- M-42 cobalt high speed steel edge
- Hardness of HRC 68-69
- Specially designed tooth form
- 7 degree positive rake angle


Advantages


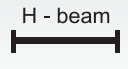





























- High heat resistance
- High wear resistance
- Better tooth penetration

Benefits

- Long life on moderate to difficult to cut materials
- Fast cutting rates
- Low cost per cut
- High production rate

Applicability

 = Break-in area/1000 cm²

Structural Steel	Bundled small diameter material	Mild steel, Non-ferrous metal			Tool steel Prehardened steel			Hot work die steel, Stainless Steel			Super heat resisting alloy		
		Small ~ 100mm	Medium 100 ~ 400mm	Large 400mm ~	Small ~ 100mm	Medium 100 ~ 400mm	Large 400mm ~	Small ~ 100mm	Medium 100 ~ 400mm	Large 400mm ~	Small ~ 100mm	Medium 100 ~ 400mm	Large 400mm ~
Thick wall  H - beam 	~ 100 mm 												
													
													
<ul style="list-style-type: none"> • A36 • 50, 55, A, B, C, D, • 1012, 1008 • 30, 33, 40, 45, 50, 55 • A569 • 1005-1095, 1513-1536 • 1541-1572, • 5015 - 5150 • 4118 - 4161 • 1330 - 1345 • 3115 - 3315 • 4012 - 4047, 4419, 4422, 4427 • 4615-4626, 4815-4820 • 4320-4720, 8115-9430 • 1108-1215 • 1100-7075 • C10200, C12000, C21000 		<ul style="list-style-type: none"> • W-1, W-2, W-5 • P-2, P-3, P-4, P-5, P-6, P-20, P-21 • S-1, S-2, S-4, S-5, S-6, S-7 • L-2, L-6, • 5155, 5160 • A-2, O-1, O-2, O-6, D-2, D-3, CPM 10V • T-1, T-2, T-3, T-4, M-1, M-2, M-5, M-15 • 50100, 51100, 52100 			<ul style="list-style-type: none"> • H-10, H-13, H-21, H-22, H-24, H-25 • 210, 202, 302, 303, 304, 308 • 314, 316, 317, 321, 330, 347 • 410, 416, 420, 430, 440C • 15-5PH, 17-4PH, 15-7 			<ul style="list-style-type: none"> • 309, 409, 600 • MONEL, K-MONEL, INCONEL718, HASTELLOY A, B, C • A286, INCOLOY 800, RA330 • ASTROLOGY WF-11 • Monel400, K-500 • Ti-6Al-4v 					

Line-up of Products

Band width (mm)	Band thickness (mm)	Pitch										
		0.75/1	1.1/1.5	1.5/2	2/3	2/3 WS	3/4	3/4 WS	4/6	5/7	6/10	8/12
19	0.9						●		●	●		
27	0.9				●		●		●	●	●	●
34	1.1		●		●		●		●	●	●	●
41	1.3		●	●	●	○	●	○	●	●		
54	1.6	●	●	●	●	○	●	○	●			
67	1.6	●	●	●	●	○	●	○	●			
80	1.6	●	●	●	●				●			

o: The WS (Wide Set) type blade is a special saw blade with a measure against pinching which occurs easily when cutting the roll formed size H-beam whose width is over 400mm and mainly intended for that of 600mm or more width.
 Note) Using of WS type blade for cutting the material where no pinching would occur may shorten the service life of the blade.

Note: Specifications may change without notice at the sole discretion of Amada's Engineering Department.



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