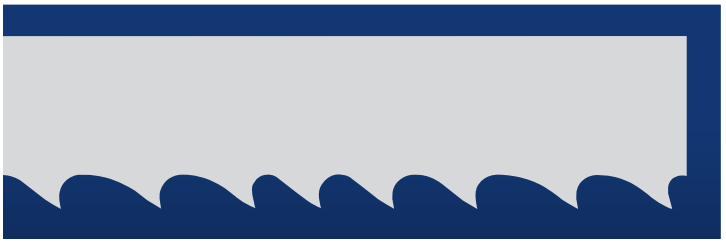
WIKUS®

Precision at the cutting point

2008/09



PRECISION-
BAND SAW BLADES

PRECISION
AT THE CUTTING POINT

Since 1958 WIKUS has produced high-tech tools for industry and trade. WIKUS blades are used where the highest precision, finest cutting and maximum power are required.

Hence, customer satisfaction is our top priority. Highest quality of our products is our maxim, which is clearly shown by our motto “precision at the cutting point”.

Even more complex production methods such as in the automotive industry require reliable products, which we can assure with the outstanding quality of our band saw blades.

We have intentions and visions – hence, we make high investments in Research and Development for you and for our future. Experienced engineers in our technical service department are closely cooperating with our cutting specialists of science.

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ISO 9001:2000 CERTIFIED

WIKUS®

Precision at the cutting point

BAND SAW BLADES 2008/09
CONTENTS

HIGH-
PERFORMANCE TOOLS
SPECIFICALLY
MATCHED TO
OUR CUSTOMER'S
DEMANDS

Advice and service are very important for us to optimally match our band saw blades to your cutting task. This means best results with maximum quality and economic use.

The application fields of our band saw blades are as diverse as our products. Whether steel production or steel trade, machine construction or automotive industry – WIKUS products are used everywhere.

Even the hardest materials such as granite or steel and titanium alloys can be easily cut with our band saw blades.

Gigantic steel blocks or the smallest and finest castings – you may rely on a WIKUS band saw blade even with extreme dimensions.

WORLDWIDE
BY YOUR SIDE

We are proud of the fact that we are still producing our band saw blades in Germany. This is achieved by consistent investments at our Spangenberg headquarters and by optimizations in structure and strategy.

The continuously increasing demand in our band saw blades worldwide shows that our more than 65 distributors promote for you as well.

Hence it is even more important for us to strengthen and extend our international presence to react to your individual demands.

SELECTING THE RIGHT BAND SAW BLADE

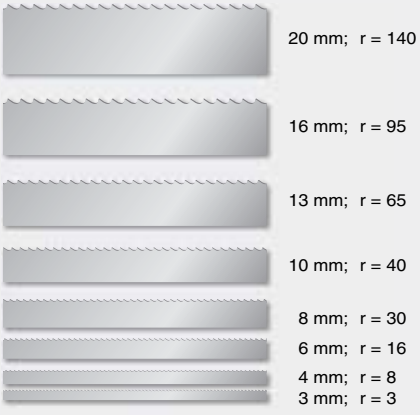
1. Band length

The band dimension individually depends on the cutting machine. You will find further information in the back of this catalog or in the operation instructions for your machine.

2. Band width

With horizontal machines the band width is specified by the manufacturer.
Vertical band saw machines allow higher variations of the band width. However, the general rule is the wider the band saw blade the greater its stability.
In case of contour cuts the smallest radius to be cut is the limiting factor for the band width.

Band widths and smallest radius



3. Cutting edge material

WIKUS offers four main groups of cutting edge materials:
- **Carbon steel**
- **Bimetal**
- **Carbide**
- **Diamond**

The machinability of the material to be cut determines the cutting edge material.

4. Tooth pitch

At WIKUS you may choose between constant and variable tooth pitch. Here the contact length of the blade in the work piece is decisive. Both tables on the right show the limit values.

5.Tooth shape

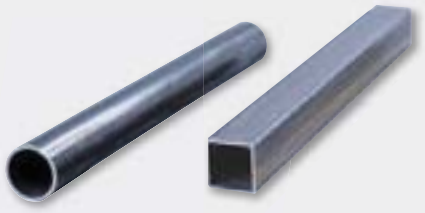
Our different tooth shapes have been optimally combined with our cutting edge materials and band saw dimensions by our technologists.

Constant tooth pitch	Contact length (mm)	
tpi	from	to
24		6
18		10
14		15
10	15	30
8	30	50
6	50	80
4	80	120
3	120	200
2	200	400
1,25	300	800

Variable tooth pitch	Contact length (mm)	
tpi	from	to
10-14		30
8-12	20	50
6-10	25	60
5-8	35	80
4-6	50	100
4-5	70	120
3-4	80	150
2-3	120	350
1,4-2	250	600
1,0-1,4	400	1000
0,75-1,25	700	1400
0,7-1,0	900	3000

6. Types of tooth set

Our product range offers every type of tooth set that is important for you. Our carbide tipped band saw blades ECODUR, TCTYRE, FUTURA, FUTURA PLUS, FUTURA SN, FUTURA PREMIUM as well as all coated band saw blades are not set.



Cutting of tubes and profiles

S	**Outer diameter of the tube (**mm) / Tooth pitch Tz in tpi																
mm	**20**	**40**	**60**	**80**	**100**	**120**	**150**	**200**	**300**	**400**	**500**	**600**	**700**	**800**	**900**	**1000**	**1500**
2	14	14	14	14	14	14	10-14	10-14	8-12	8-12	6-10	6-10	5-8	5-8	5-8	5-8	5-8
3	14	14	10-14	10-14	10-14	10-14	8-12	8-12	6-10	6-10	5-8	5-8	5-8	4-6	4-6	4-6	4-6
4	14	14	10-14	10-14	8-12	8-12	8-12	8-12	5-8	5-8	4-6	4-6	4-6	4-6	4-6	4-6	3-4
5	14	10-14	10-14	10-14	8-12	8-12	8-12	6-10	5-8	5-8	4-6	4-6	4-6	4-6	3-4	3-4	3-4
6	14	10-14	10-14	8-12	8-12	8-12	8-12	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4	3-4	3-4
8	14	10-14	8-12	8-12	8-12	6-10	6-10	5-8	4-6	4-6	4-6	3-4	3-4	3-4	3-4	2-3	2-3
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12		8-12	6-10	6-10	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4	3-4	2-3	2-3	2-3	2-3
15		8-12	6-10	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3	2-3	2-3	2-3	2-3
20			6-10	5-8	4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3	2-3	2-3	2-3	2-3	2-3
30				4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3	2-3	2-3	2-3	2-3	2-3	1,4-2
50						3-4	3-4	3-4	2-3	2-3	2-3	2-3	2-3	2-3	1,4-2	1,4-2	1,4-2
75								2-3	2-3	2-3	2-3	2-3	1,4-2	1,4-2	1,4-2	1,4-2	1,4-2
100									2-3	2-3	1,4-2	1,4-2	1,4-2	1,4-2	1,4-2	1,4-2	1,4-2
150										2-3	1,4-2	1,4-2	1,4-2	1,4-2	1,0-1,4	1,0-1,4	1,0-1,4
200											1,4-2	1,4-2	1,4-2	1,0-1,4	1,0-1,4	1,0-1,4	0,75-1,25
250												1,4-2	1,0-1,4	1,0-1,4	1,0-1,4	0,75-1,25	0,75-1,25
300													1,0-1,4	1,0-1,4	0,75-1,25	0,75-1,25	0,75-1,25
350														1,0-1,4	0,75-1,25	0,75-1,25	0,7-1,0
400															0,75-1,25	0,75-1,25	0,7-1,0
450																0,7-1,0	0,7-1,0
500																	0,7-1,0

s = Wall thickness
If you have to cut two or more tubes lying side by side please use this table in consideration of the double wall thickness (s).

TOOTH SHAPES

Skip tooth (L)

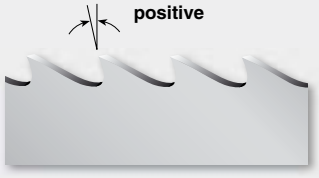
Rake angle: 0°, for:
- flexible materials (aluminium and wood)
- only available in carbon steel

Raker tooth (S)

Rake angle: 0°, for:
- short-chipping materials
- steels with high carbon content
- preferably tool steel and cast iron
- materials with small cross-sections
- thin-walled profiles

Profile tooth (P)

Rake angle: positive, for:
- hollow and angle profiles
- beams
- bundle and layer cuts
- applications that are susceptible to vibrations

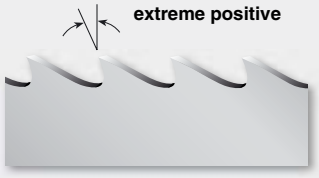


Hook tooth (K)

Rake angle: positive, for:
- universal usage
- non-ferrous metals and steels with a carbon content of < 0,8%
- structural steels, steels for cold extrusion, tempered steels

Tooth shape (HV)

Hook tooth (as above), Rake angle: positive, for:
- brittle and annealed materials
- solid material
- high cutting rates



Tooth shape (VA)

Hook tooth (as above), Rake angle: extreme positive, for:
- tough and long-chipping materials
- solid material
- high cutting rates

Trapezoid tooth (T)

Rake angle: positive, for:
- high cutting rates and best surface finish

Tooth shape (TSN)

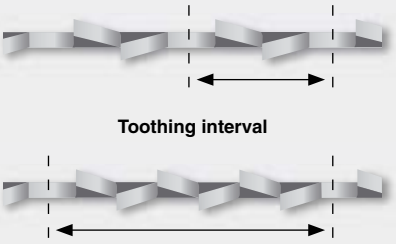
Trapezoid tooth (as above), rake angle: negative, for:
- induction hardened and chrome coated shafts
- hardened steels up to 62 HRC, hard manganese steels, hard-chrome plated work pieces
- diameters up to 200 mm

TYPES OF TOOTH SET

By means of the tooth set, where the teeth protrude alternately left and right beyond the blade body, free-cutting action of the band saw blade is achieved.

Standard set (SD)

The standard set is an all-purpose set for cutting thicknesses of more than 5 mm of steels, castings and hard non-ferrous metals.
With constant tooth pitch the set sequence is left/right/straight.
With variable tooth pitch one tooth in each toothing interval is unset. The remaining teeth in the interval are recurrently set left/right.



Group set (GS)

For band saw blades in the tooth pitch range of 4-18 tpi improved surface quality is obtained with group set.

Wavy set (WS)

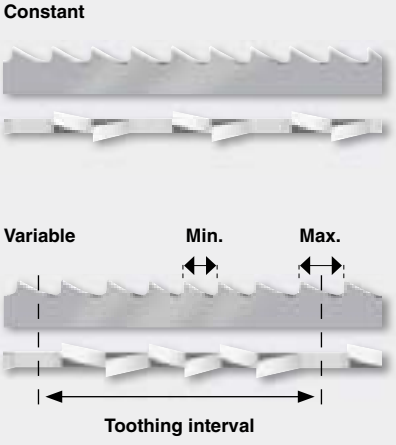
With material dimensions up to 5 mm such as sheets, thin-walled tubes and profiles, we recommend wavy set.

TOOTH PITCH (TZ)

Tooth pitch is defined as the number of teeth per inch (tpi). 1 inch corresponds to 25,4 mm.

A difference is made between constant tooth pitches with regular tooth distance and variable tooth pitches with differing tooth distance within one toothing interval.

Variable tooth pitches are marked by two measures, e.g. 2-3 tpi.
With this, 2 tpi signifies the maximum tooth distance and 3 tpi signifies the minimum tooth distance in the toothing interval.



PRODUCT RANGE

CARBON STEEL BAND SAW BLADES

Sales units:	- coils in fixed lengths and manufacturing coils up to 400 feet, depending on the band width - welded-to-length band saw blades
Band widths:	3 to 38 mm
Constant tooth pitches:	2 to 18 teeth per inch (tpi)
Tooth shapes:	L, S, K
Types of tooth set:	SD, WS, GS

BIMETAL BAND SAW BLADES

Sales units:	- coils in fixed lengths and manufacturing coils up to 400 feet, depending on the band width - welded-to-length band saw blades
Band widths:	4 to 100 mm
Constant tooth pitches:	1,25 to 18 teeth per inch (tpi)
Variable tooth pitches:	0,7 - 1,0 to 12 - 16 tpi
Tooth shapes:	S, P, K, HV, VA
Types of tooth set:	SD, GS
Qualities:	**HSS-M42:** 68 - 69 HRC, approx. 940 - 1000 HV **HSS-M51:** approx. 69 HRC, approx. 1000 HV **X3000:** approx. 69 HRC, approx. 1000 HV

CARBIDE BAND SAW BLADES

CARBIDE TIPPED

Sales units:	- coils at max. 164 feet - welded-to-length band saw blades
Band widths:	13 to 80 mm
Constant tooth pitches:	1,25 to 4 teeth per inch (tpi)
Variable tooth pitches:	0,85 - 1,15 to 3 - 4 tpi
Tooth shapes:	S, K, T, TSN

CARBIDE COATED

Sales units:	- welded-to-length band saw blades
Band widths:	10 to 41 mm
Carbide coating:	constant (K), intermittent (U), with 8 to 14 mm pitch
Grit sizes:	TC181, TC301, TC356, TC525

DIAMOND GRIT BAND SAW BLADES

Sales units:	- welded-to-length band saw blades
Band widths:	10 to 100 mm
Diamond coating:	constant (K), segmented (S), intermittent (U), with 6 to 30 mm pitch
Grit sizes:	D91, D126, D181, D252, D356, D427, D601

N	B	S	T
NORMAL	BASIC	SPECIAL	TOP LINE
500 EXTRA			
510 DIAMANT			
515 JET			
		531 MARATHON M51	633 GIGANT X3000
	524 PROFLEX M42	532 GIGANT M42	639 VECTOR X3000
	526 BIFLEX M42	534 VECTOR M42	
	528 VARIO M42		
523 ECOFLEX M42	529 MARATHON M42		
		545 FUTURA	548 FUTURA PREMIUM
	540 TCT	546 FUTURA PLUS	
	541 DUROSET	547 FUTURA SN	
	542 ECODUR	549 TCTYRE	
	550 TCGRIT K		
	554 TCGRIT U		
			570 DIAGRIT K
			572 DIAGRIT S
			574 DIAGRIT U

RECOMMENDATION FOR USE

	PRODUCT GROUP		Carbon steel		Bimetal					
	ITEM GROUP		DIAMANT 510	JET 515	ECOFLEX 523	PROFLEX 524	VARIO 528	MARATHON 529	MARATHON 531	GIGANT 532
	MATERIAL GROUPS		Carbon	Carbon	M42	M42	M42	M42	M51	M42
1	Structural steels, deep drawing steels, machining steels	○	■	■	■	■	■	■		
		●	■		■			■	■	HV
2	Structural steels, quenched and tempered steels	○	■	■	■	■	■	■		
		●	■		■			■	■	HV
3	Case hardened steels, spring steels, quenched and tempered steels	○	■	■	■	■	■	■		
		●	■		■			■	■	HV
4	Low alloyed hot-work steels	○	■	■	■	■	■	■		
		●	■		■			■	■	HV
5	Nitriding steels, high alloyed hot-working steels	○	■	■	■	■	■	■		
		●	■		■			■	■	HV
6	Unalloyed tool steels	○	■	■	■	■	■	■		
		●	■		■			■	■	HV
7	Cold work steels	○					■	■		
		●						■	■	HV
8	High-speed steels	○					■	■		
		●						■	■	HV
9	Cast iron	○					■	■		
		●						■	■	HV
10	Rust- and acid-resistant steels (light)	○		■			■	■		
		●						■	■	VA
11	Rust- and acid-resistant steels (heavy)	○		■			■	■		
		●						■	■	VA
12	Duplex and heat-resistant steels	○					■	■		
		●						■	■	VA
13	Nickel-base alloys	○								
		●								
14	Induction hardened and chrome coated shafts	○								
		●								
15	Aluminium	○	■		NE		■	■		
		●	■		NE			■		
16	Copper	○	■		■		■	■		
		●	■		■			■		■
17	Brass	○	■		■		■	■		
		●	■		■			■		
18	Aluminium bronze	○								
		●								
19	Titanium alloys	○								
		●								
20	Abrasive building materials	○								
		●								
21	Carbon	soft	■		■		■	■		
		hard								
22	Plastics	○	■		■		■	■		
		●	■		■			■		
23	Glass, fiberglass, marble, silicon	○								
		●								
24	Tires	○		■						
		●								

■ Suitable

○ Tubes, profiles, solid material (< 50 mm)

● Solid material (> 50 mm)

			Carbide								Diamond	
VECTOR 534	GIGANT 633	VECTOR 639	TCT 540	DUROSET 541	ECODUR 542	FUTURA 545	FUTURA PLUS 546	FUTURA SN 547	FUTURA PREM. 548	TCTYRE 549	DIAGRIT K 570	DIAGRIT S/U 572/574
M42	X3000	X3000	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Carbide	Diamond	Diamond
HV	HV	HV		■	■	■			■			
HV	HV	HV		■	■	■			■			
HV	HV	HV		■	■	■			■			
HV	HV	HV		■	■	■			■			
HV	HV	HV		■	■	■			■			
HV	HV	HV		■	■	■			■			
HV	HV	HV		■		■			■			
HV	HV	HV		■		■			■			
HV	HV	HV			■		■		■			
VA	VA	VA		■		■						
VA	VA	VA		■		■						
VA	VA	VA		■		■						
		VA										
	VA	VA		■		■						
								■				
								■				
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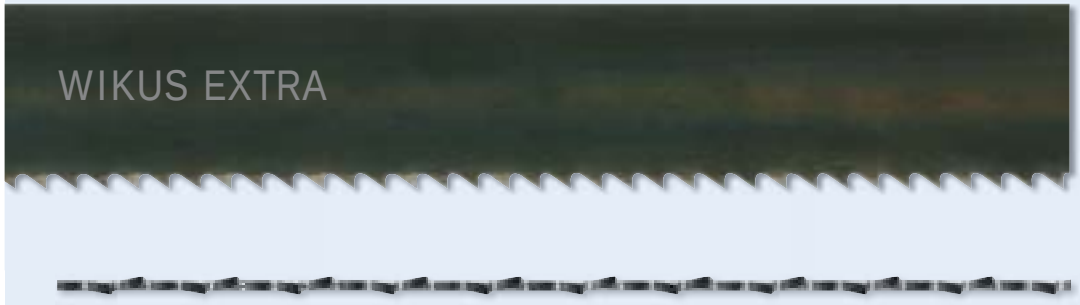
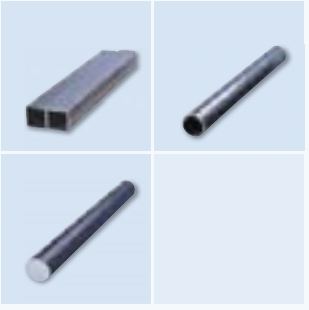
WIKUS

CARBON STEEL PROGRAM

EXTRA





*Item group **500 EXTRA** (approx. 65-66 HRC)*

Dimensions Width x thickness		Tooth pitch in tpi SD							
mm	Inches	2	3	4	6	8	10	14	18
8 x 0,65	5/16 x 0,025			L	S	S	S	S	
10 x 0,65	3/8 x 0,025		L	S-L	S	S	S	S	S
13 x 0,65	1/2 x 0,025		L	S-L	S	S	S	S	S
16 x 0,80	5/8 x 0,032		L	S	S	S	S		
20 x 0,80	3/4 x 0,032		L	S-L	S	S	S		
25 x 0,90	1 x 0,035	L	L	S-L	S	S	S		
32 x 1,10	1-1/4 x 0,042	L		S	S				
38 x 1,30	1-1/2 x 0,050					S			

Material groups

1	**2**	**3**	4	5	6	7	8
9	10	11	12	13	14	**15**	16
17	18	19	20	21	**22**	23	24

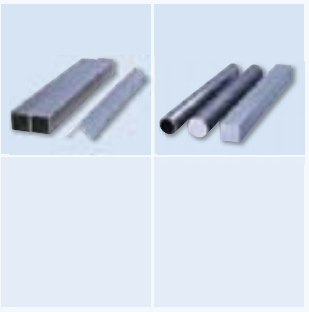
Classification

N	B	S	T

For details see legend on page 2

DIAMANT

WIKUS DIAMANT



*Item group **510 DIAMANT** (approx. 66-67 HRC)*

Dimensions Width x thickness		Tooth pitch in tpi														
		SD								WS			GS			
mm	Inches	2	3	4	6	8	10	14	18	14	18	24	4	6	8	10
3 x 0,65	1/8 x 0,025						S	S	S			S				
4 x 0,65	5/32 x 0,025						S	S	S			S				
5 x 0,40	3/16 x 0,016							S				S				
5 x 0,65	3/16 x 0,025						S	S	S			S				
6 x 0,40	1/4 x 0,016				K		S	S								
6 x 0,65	1/4 x 0,025			L	S-K	S	S	S	S			S	K			
8 x 0,65	5/16 x 0,025			K-L	S-K	S	S	S	S			S	K			
10 x 0,65	3/8 x 0,025		K	K-L	S-K	S	S	S	S			S				
13 x 0,65	1/2 x 0,025		K	S-K	S-K	S	S	S	S			S				
16 x 0,50	5/8 x 0,020					S		S								
16 x 0,65	5/8 x 0,025		K	S-K-L	S-K	S	S			S		S				
16 x 0,80	5/8 x 0,032		K	S-K	S-K	S	S			S	S	S				
20 x 0,80	3/4 x 0,032		S-K	S-K	S-K	S	S			S	S			S	S	S
25 x 0,90	1 x 0,035	K	S-K	S-K	S-K	S	S			S					S	
32 x 1,10	1-1/4 x 0,042	K	K	S	S	S	S									
38 x 1,30	1-1/2 x 0,050	K				S										

Material groups

1	**2**	**3**	**4**	**5**	**6**	7	8
9	10	11	12	13	14	**15**	**16**
17	18	19	20	**21**	**22**	23	24

Classification

N	B	S	T

For details see legend on page 2

JET

WIKUS JET

*Item group **515 JET** (approx. 63-65 HRC)*
Friction band saw blade

Dimensions Width x thickness		Tooth pitch in tpi					
		SD		RL			GS
mm	Inches	10	14	6	8	10	4
10 x 0,65	3/8 x 0,025		S				
13 x 0,65	1/2 x 0,025	S	S				
16 x 0,80	5/8 x 0,032		S		S	S	
20 x 0,80	3/4 x 0,032		S			S	
25 x 0,90	1 x 0,035		S	S	S	S	S
32 x 1,10	1-1/4 x 0,042						S

Material groups

1	**2**	**3**	**4**	**5**	**6**	7	8
9	**10**	**11**	12	13	14	15	16
17	18	19	20	21	22	23	**24**

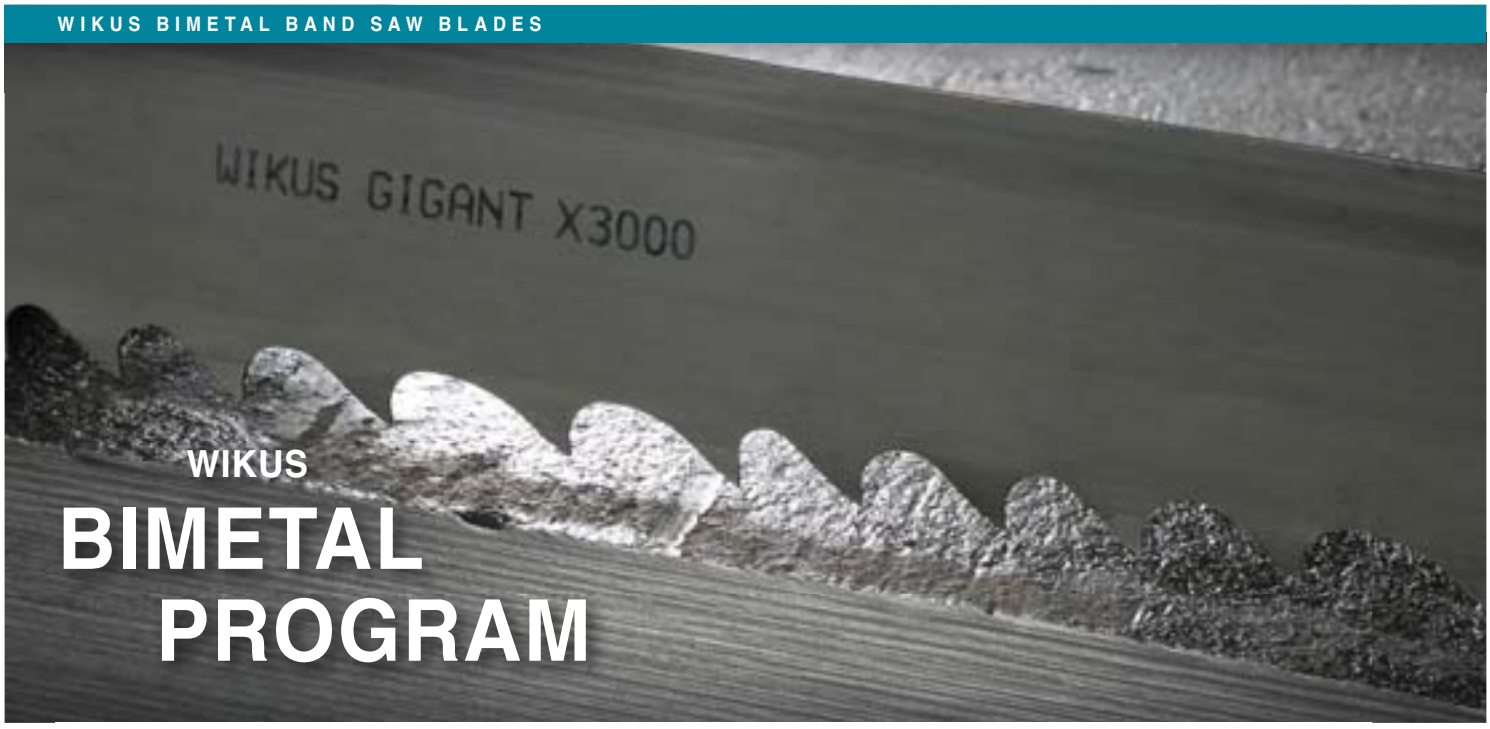
Classification

N	B	S	T

For details see legend on page 2

Tooth pitch and cutting speed

Material groups	Tooth pitch in tpi Material thickness (mm) / **Cutting speed (m/min)**				
	< 2	2 - 6	6 - 10	10 - 15	15 - 30
1/2	18 / **1800**	14 / **1800**	10 / **2500**	8 / **3000**	8 / **4000**
3-6	18 / **1800**	14 / **2500**	10 / **3000**	10 / **3500**	8 / **4000**
10/11	18 / **1800**	14 / **2500**	10 / **3000**	10 / **4000**	8 / **4500**



WIKUS BIMETAL PROGRAM

Bimetal qualities

M42

Wear resistance is the outstanding feature of the cutting edge material M42. Their decisive factors are the carbide sizes and their composition. The extremely hard special carbides are embedded in a temperature-resistant martensitic matrix. Due to our technically fully developed heat treatment process the optimal microstructure for your purposes can be achieved.

M51

Sharp cutting edges and highest wear resistance, that's what high strength austenitic steels and exotic alloys demand from band saw blades. WIKUS is able to meet this task with its HSS-M51. The high tungsten and carbon content increases the number of carbides and also the resistance against abrasive wear. Additionally, due to the high cobalt content the resistance of the microstructure against thermal wear is improved.

X3000

The new generation of WIKUS' cutting edge materials even increases the blade life of our bimetal band saw blades GIGANT and VECTOR considerably. Practice tests demonstrated huge advantages when cutting materials that are difficult to cut, rust- and acid-resistant materials as well as nickel-base alloys.

Special designs

Design PW

- Excellent cutting rate and tool life
- For rust- and acid-resistant steels as well as exotic alloys
- Shorter cutting times and longer life-time with large material cross-sections

Item groups:	526, 529, 531
Constant tooth pitches:	1,25 to 3 tpi
Variable tooth pitches:	0,7-1,0 to 3-4 tpi
Tooth shapes:	K, VA
Types of tooth set:	SD

Design PE

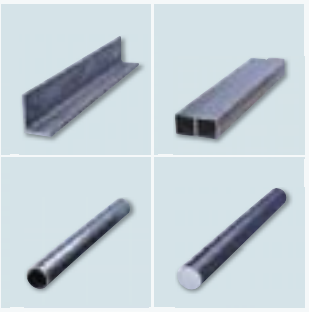
- Highest possible surface finish by double-sided ground tooth faces

Only with welded-to-length band saw blades.

Item groups:	523 to 531
Constant tooth pitches:	3 to 18 tpi
Variable tooth pitches:	3-4 to 10-14 tpi
Tooth shapes:	S, K
Types of tooth set:	SD, GS

ECOFLEX® M42

WIKUS ECOFLEX M42



Material groups

1	**2**	**3**	**4**	**5**	**6**	7	8
9	10	11	12	13	14	**15**	**16**
17	18	19	20	**21**	**22**	23	24

Classification

N B S T

*Item group **523 ECOFLEX M42** (approx. 68-69 HRC)*

Dimensions Width x thickness		Tooth pitch in tpi SD						
mm	Inches	2 - 3	3 - 4	4 - 6	5 - 8	6 - 10	8 - 12	10 - 14
20 x 0,90	3/4 x 0,035			K	S	S	S	S
27 x 0,90	1-1/16 x 0,035		K	K	S	S	S	S
34 x 1,10	1-3/8 x 0,042	K	K	K	S	S	S	
41 x 1,30	1-5/8 x 0,050	K	K	K				

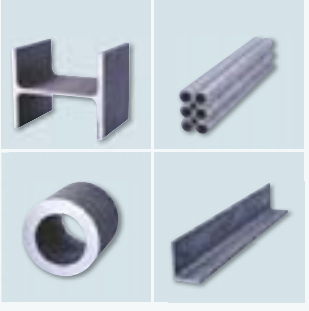
*Item group **523 ECOFLEX M42 NE** (approx. 68-69 HRC)*
with extra wide set for treating non-ferrous metals

Dimensions Width x thickness		Tooth pitch in tpi Extra wide set	
mm	Inches	3	4
20 x 0,90	3/4 x 0,035	K	K
27 x 0,90	1-1/16 x 0,035	K	K
34 x 1,10	1-3/8 x 0,042	K	

For details see legend on page 2

PROFLEX® M42

WIKUS PROFLEX M42



Material groups

1	**2**	**3**	**4**	**5**	**6**	7	8
9	10	11	12	13	14	15	16
17	18	19	20	21	22	23	24

Classification

N **B** S T

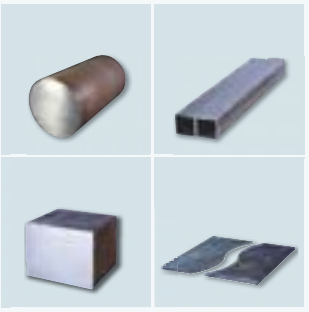
*Item group **524 PROFLEX M42** (approx. 68-69 HRC)*

Dimensions Width x thickness		Tooth pitch in tpi				
mm	Inches	2 - 3	3 - 4	5 - 7	8 - 11	12 - 16
20 x 0,90	3/4 x 0,035			P	P	P
27 x 0,90	1-1/16 x 0,035		P	P	P	P
34 x 1,10	1-3/8 x 0,042	P	P*	P	P	
41 x 1,30	1-5/8 x 0,050	P*	P*	P	P	
54 x 1,30	2-1/8 x0,050	P	P	P		
54 x 1,60	2-1/8 x0,063	P*	P*	P		

* also available in wider set for profiles with extreme residual stress

BIFLEX® M42

WIKUS BIFLEX M42



Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	21	22	23	24

Classification

N **B** S T

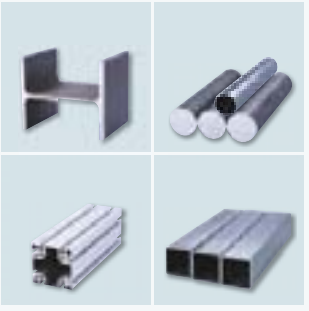
For details see legend on page 2

*Item group **526 BIFLEX M42** (approx. 68-69 HRC)*

Dimensions Width x thickness		Tooth pitch in tpi SD						GS	
mm	Inches	1,25	2	3	4	6	14	14	18
4 x 0,90	5/32 x 0,035						S		
6 x 0,65	1/4 x 0,025					K			
6 x 0,90	1/4 x 0,035					K			
10 x 0,90	3/8 x 0,035				K	K			
13 x 0,65	1/2 x 0,025				K	K	S		S
13 x 0,90	1/2 x 0,035			K	K	K			
20 x 0,90	3/4 x 0,035			K	K	K			S
27 x 0,90	1-1/16 x 0,035			K	K	K		S	S
27 x 1,10	1-1/16 x 0,042			K					
34 x 1,10	1-3/8 x 0,042	K	K	K				S	
41 x 1,30	1-5/8 x 0,050	K	K	K					

VARIO® M42

WIKUS VARIO M42



Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	21	22	23	24

Classification

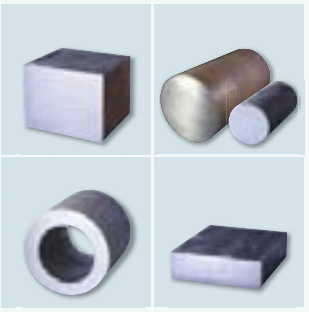
N **B** S T

For details see legend on page 2

*Item group **528 VARIO M42** (approx. 68-69 HRC)*

Dimensions Width x thickness		Tooth pitch in tpi SD					
mm	Inches	3 - 4	4 - 6	5 - 8	6 - 10	8 - 12	10 - 14
6 x 0,65	1/4 x 0,025						S
6 x 0,90	1/4 x 0,035						S
10 x 0,90	3/8 x 0,035						S
13 x 0,65	1/2 x 0,025				S	S	S
13 x 0,90	1/2 x 0,035				S	S	S
20 x 0,90	3/4 x 0,035		S	S	S	S	S
27 x 0,90	1-1/16 x 0,035	S	S	S	S	S	S
27 x 1,10	1-1/16 x 0,042		S				
34 x 1,10	1-3/8 x 0,042	S	S	S	S	S	
41 x 1,30	1-5/8 x 0,050	S	S	S	S		
54 x 1,30	2-1/8 x 0,050				S		

MARATHON® M42



Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	21	22	23	24

Classification

N	**B**	S	T

*Item group **529 MARATHON M42** (approx. 68-69 HRC)*

Dimensions Width x thickness		Tooth pitch in tpi SD							
mm	Inches	0,75 - 1,25	1,0 - 1,4	1,4 - 2	2 - 3	3 - 4	4 - 5	4 - 6	5 - 8
27 x 0,90	1-1/16 x 0,035				K	K	K	K	K
27 x 1,10	1-1/16 x 0,042				K	K			
34 x 1,10	1-3/8 x 0,042			K	K	K	K	K	K
38 x 1,30	1-1/2 x 0,050				K*	K*			
41 x 1,30	1-5/8 x 0,050			K	K	K		K	K
54 x 1,30	2-1/8 x 0,050			K	K	K		K	
54 x 1,60	2-1/8 x 0,063	K	K	K	K	K		K	
67 x 1,60	2-5/8 x 0,063	K	K	K	K	K		K	
80 x 1,60	3-1/8 x 0,063	K	K	K	K	K			
100 x 1,60	4 x 0,063	K							

* will be discontinued

MARATHON® M51

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	21	22	23	24

Classification

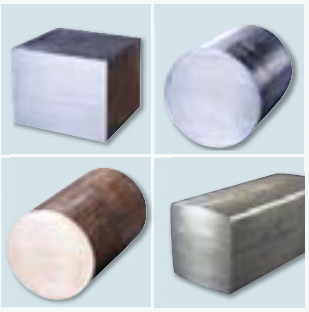
N	B	**S**	T

*Item group **531 MARATHON M51** (approx. 69 HRC)*

Dimensions Width x thickness		Tooth pitch in tpi SD			
mm	Inches	1,4 - 2	2 - 3	3 - 4	4 - 6
27 x 0,90	1-1/16 x 0,035			K	K
34 x 1,10	1-1/16 x 0,042		K	K	K
41 x 1,30	1-5/8 x 0,050		K	K	
54 x 1,60	2-1/8 x 0,063	K	K		

For details see legend on page 2

GIGANT® M42



Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	21	22	23	24

Classification

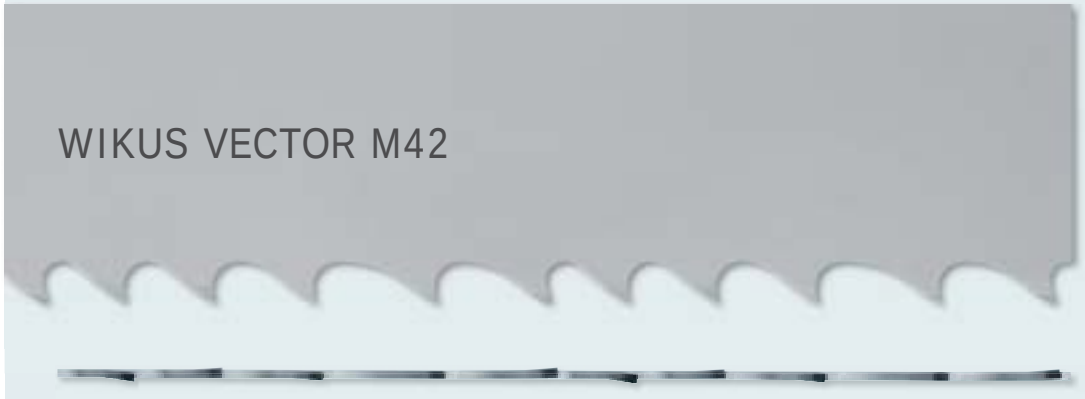
N	B	**S**	T

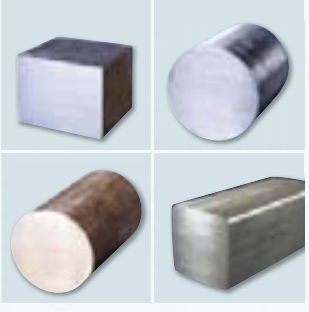
For details see legend on page 2

*Item group **532 GIGANT M42** (approx. 68-69 HRC)*

Dimensions Width x thickness		Tooth pitch in tpi Variable tooth pitch		
mm	Inches	0,75 - 1,25	1,0 - 1,4	1,4 - 2
41 x 1,30	1-5/8 x 0,050			HV, VA
54 x 1,30	2-1/8 x 0,050			HV, VA
54 x 1,60	2-1/8 x 0,063	HV, VA	HV, VA	HV, VA
67 x 1,60	2-5/8 x 0,063	HV, VA	HV, VA	HV, VA
80 x 1,60	3-1/8 x 0,063	HV, VA	HV, VA	HV, VA

VECTOR® M42





Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	21	22	23	24

Classification

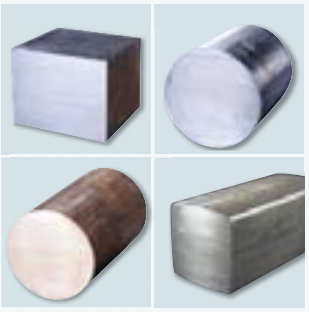
N	B	**S**	T

For details see legend on page 2

*Item group **534 VECTOR M42** (approx. 68-69 HRC)*

Dimensions Width x thickness		Tooth pitch in tpi Variable tooth pitch		
mm	Inches	2 - 3	3 - 4	4 - 6
27 x 0,90	1-1/16 x 0,035		HV, VA	HV
34 x 1,10	1-3/8 x 0,042	HV, VA	HV, VA	HV
41 x 1,30	1-5/8 x 0,050	HV, VA	HV, VA	HV
54 x 1,30	2-1/8 x 0,050	HV, VA	HV, VA	
54 x 1,60	2-1/8 x 0,063	HV, VA		

GIGANT® X3000



Material groups

1	**2**	**3**	**4**	**5**	6	7	8
9	**10**	**11**	**12**	**13**	14	15	16
17	**18**	**19**	20	21	22	23	24

Classification

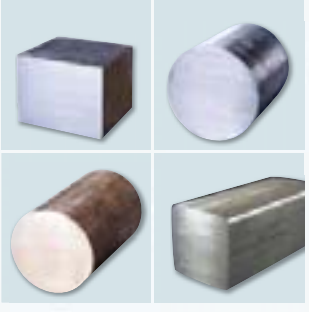
N	B	S	**T**

*Item group **633 GIGANT X3000** (approx. 69 HRC)*

Dimensions Width x thickness		Tooth pitch in tpi Variable tooth pitch		
mm	Inches	0,7 - 1,0	1,0 - 1,4	1,4 - 2
41 x 1,30	1-5/8 x 0,050			HV, VA
54 x 1,60	2-1/8 x 0,063		HV, VA	HV, VA
67 x 1,60	2-5/8 x 0,063	HV, VA	HV, VA	HV, VA
80 x 1,60	3-1/8 x 0,063	HV, VA	HV, VA	HV, VA

For details see legend on page 2

VECTOR® X3000



Material groups

1	**2**	**3**	**4**	**5**	6	7	8
9	**10**	**11**	**12**	**13**	14	15	16
17	**18**	**19**	20	21	22	23	24

Classification

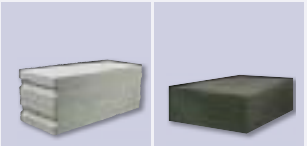
N	B	S	**T**

*Item group **639 VECTOR X3000** (approx. 69 HRC)*

Dimensions Width x thickness		Tooth pitch in tpi Variable tooth pitch		
mm	Inches	2 - 3	3 - 4	4 - 6
27 x 0,90	1-1/16 x 0,035		HV, VA	HV
34 x 1,10	1-3/8 x 0,042	HV, VA	HV, VA	HV
41 x 1,30	1-5/8 x 0,050	HV, VA	HV, VA	HV
54 x 1,60	2-1/8 x 0,063	HV, VA	HV, VA	

For details see legend on page 2

TCT



*Item group **540 TCT** (approx. 1600 HV)*

Dimensions Width x thickness		Tooth pitch in tpi SD			
mm	Inches	1,25	2	3	4
13 x 0,80	1/2 x 0,032				S-K
20 x 0,80	3/4 x 0,032			S-K	S
27 x 0,90	1-1/16 x 0,035		S-K	S-K	S-K
34 x 1,10	1-3/8 x 0,042	K	K	S-K	
41 x 1,30	1-5/8 x 0,050	K	K	K	

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	**20**	**21**	22	23	24

Classification

N	**B**	S	T

For details see legend on page 2

DUROSET®

Material groups

1	**2**	**3**	**4**	**5**	6	**7**	**8**
9	**10**	**11**	**12**	**13**	14	**15**	16
17	18	19	20	21	22	23	24

Classification

N	**B**	S	T

*Item group **541 DUROSET** (approx. 1600 HV)*

Dimensions Width x thickness		Tooth pitch in tpi SD		
mm	Inches	1,4 - 2	2 - 3	3 - 4
27 x 0,90	1-1/16 x 0,035			K
34 x 1,10	1-3/8 x 0,042		K	K
41 x 1,30	1-5/8 x 0,050		K	
54 x 1,60	2-1/8 x 0,063	K	K	
67 x 1,60	2-5/8 x 0,063	K		

*Item group **541 DUROSET NE** (approx. 1600 HV)*
with extra wide set for treating non-ferrous metals

Dimensions Width x thickness		Tooth pitch in tpi Extra wide set	
mm	Inches	2	3
20 x 0,80	3/4 x 0,032		K
27 x 0,90	1-1/16 x 0,035		K
34 x 1,10	1-3/8 x 0,042	K	K

ECODUR®

Material groups

1	**2**	**3**	**4**	**5**	**6**	7	8
9	10	11	12	13	14	**15**	**16**
17	18	19	20	21	22	23	24

Classification

N	**B**	S	T

*Item group **542 ECODUR** (approx. 1600 HV)*

Dimensions Width x thickness		Tooth pitch in tpi SD			
mm	Inches	0,85 - 1,15	1,4 - 2,0	2 - 3	3 - 4
20 x 0,80	3/4 x 0,032				T
27 x 0,90	1-1/16 x 0,035			T	T
34 x 1,10	1-3/8 x 0,042		T	T	T
41 x 1,30	1-5/8 x 0,050		T	T	T
54 x 1,30	2-1/8 x 0,050		T	T	
54 x 1,60	2-1/8 x 0,063	T	T	T	
67 x 1,60	2-5/8 x 0,063		T		

For details see legend on page 2

FUTURA®

Material groups

1	**2**	**3**	**4**	**5**	6	7	8
9	**10**	**11**	**12**	**13**	14	15	**16**
17	**18**	**19**	20	21	22	23	24

Classification

N	B	**S**	T

For details see legend on page 2

*Item group **545 FUTURA** (approx. 1600 HV)*

Dimensions Width x thickness		Tooth pitch in tpi					
mm	Inches	0,85 - 1,15	1,0-1,4	1,4 - 2	2 - 3	3	3 - 4
27 x 0,90	1-1/16 x 0,035					T	T
34 x 1,10	1-3/8 x 0,042				T		T
41 x 1,30	1-5/8 x 0,050			T	T		T
54 x 1,30	2-1/8 x 0,050			T	T		
54 x 1,60	2-1/8 x 0,063	T	T	T	T		
67 x 1,60	2-5/8 x 0,063	T	T	T	T		
80 x 1,60	3-1/8 x 0,063	T	T				

FUTURA® PLUS

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	**15**	16
17	18	19	20	**21**	22	23	24

Classification

N	B	**S**	T

*Item group **546 FUTURA PLUS** (approx. 1600 HV)*

Dimensions Width x thickness		Tooth pitch in tpi						
mm	Inches	0,85 - 1,15	1,0-1,4	1,4 - 2	2	2 - 3	3	3 - 4
27 x 0,90	1-1/16 x 0,035						T	T
34 x 1,10	1-3/8 x 0,042			T	T	T		T
41 x 1,30	1-5/8 x 0,050			T	T	T		T
54 x 1,30	2-1/8 x 0,050		T	T		T		
54 x 1,60	2-1/8 x 0,063	T	T	T		T		
67 x 1,60	2-5/8 x 0,063	T	T	T				
80 x 1,60	3-1/8 x 0,063	T	T					

FUTURA® SN

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	**14**	15	16
17	18	19	20	21	22	23	24

Classification

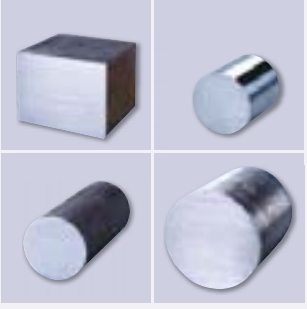
N	B	**S**	T

For details see legend on page 2

*Item group **547 FUTURA SN** (approx. 1700 HV)*

Dimensions Width x thickness		Tooth pitch in tpi	
mm	Inches	2 - 3	3 - 4
27 x 0,90	1-1/16 x 0,035		TSN
34 x 1,10	1-3/8 x 0,042	TSN	TSN
41 x 1,30	1-5/8 x 0,050	TSN	TSN
54 x 1,60	2-1/8 x 0,063	TSN	

FUTURA® PREMIUM



Material groups

1	**2**	**3**	**4**	**5**	**6**	**7**	**8**
9	10	11	12	13	14	15	16
17	18	19	20	21	22	23	24

Classification

N	B	S	**T**

For details see legend on page 2

*Item group **548 FUTURA PREMIUM** (approx. 3800 HV)*

Dimensions Width x thickness		Tooth pitch in tpi				
mm	Inches	0,85 - 1,15	1,0-1,4	1,4 - 2	2 - 3	3 - 4
34 x 1,10	1-3/8 x 0,042				T	T
41 x 1,30	1-5/8 x 0,050			T	T	T
54 x 1,60	2-1/8 x 0,063		T	T	T	
67 x 1,60	2-5/8 x 0,063	T	T	T		
80 x 1,60	3-1/8 x 0,063	T	T			

Coated tooth

TCTYRE®

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	21	22	23	**24**

Classification

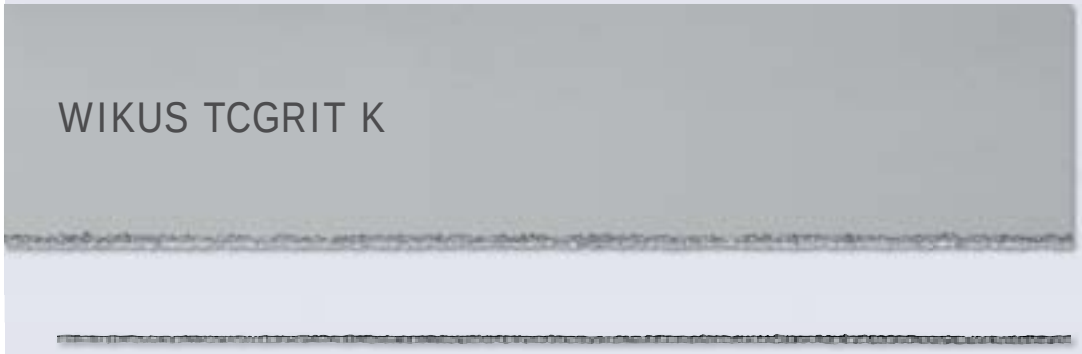
N	B	**S**	T

For details see legend on page 2

*Item group **549 TCTYRE** (approx. 1700 HV)*

Dimensions Width x thickness		Tooth pitch in tpi	
mm	Inches	2 - 3	3 - 4
27 x 0,90	1-1/16 x 0,035	T	T
34 x 1,10	1-3/8 x 0,042	T	T
41 x 1,30	1-5/8 x 0,050	T	T
54 x 1,60	2-1/8 x 0,063	T	

TCGRIT® K



Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	**20**	21	22	23	**24**

Classification

N	**B**	S	T

continuous coating K, alternative dimensions on request

*Item group **550 TCGRIT K** (approx. 1500 HV)*

Dimensions Width x thickness		Grit sizes		
mm	Inches	TC 181	TC 301	TC 525
10 x 0,65	3/8 x 0,025		K	
13 x 0,50	1/2 x 0,020		K	
13 x 0,65	1/2 x 0,025	K	K	
20 x 0,80	3/4 x 0,032		K	K
25 x 0,90	1 x 0,035			K
32 x 1,10	1-1/4 x 0,042			K

TCGRIT® U

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	**20**	21	22	23	**24**

Classification

N	**B**	S	T

intermittent coating U, alternative dimensions on request

*Item group **554 TCGRIT U** (approx. 1500 HV)*

Dimensions Width x thickness		Grit sizes			Gap pitch T
mm	Inches	TC 301	TC 356	TC 525	mm
10 x 0,65	3/8 x 0,025	U			12
13 x 0,50	1/2 x 0,020	U			12
13 x 0,65	1/2 x 0,025	U			12
20 x 0,80	3/4 x 0,032	U		U	12
25 x 0,90	1 x 0,035		U	U	12
32 x 1,10	1-1/4 x 0,042		U	U	14
38 x 1,10	1-1/2 x 0,042			U	14

WIKUS DIAMOND PROGRAM

DIAGRIT® K / DIAGRIT® S

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	**20**	**21**	22	**23**	24

Classification

N	B	S	T

For details see legend on page 2

continuous coating K,
segmented gritting S

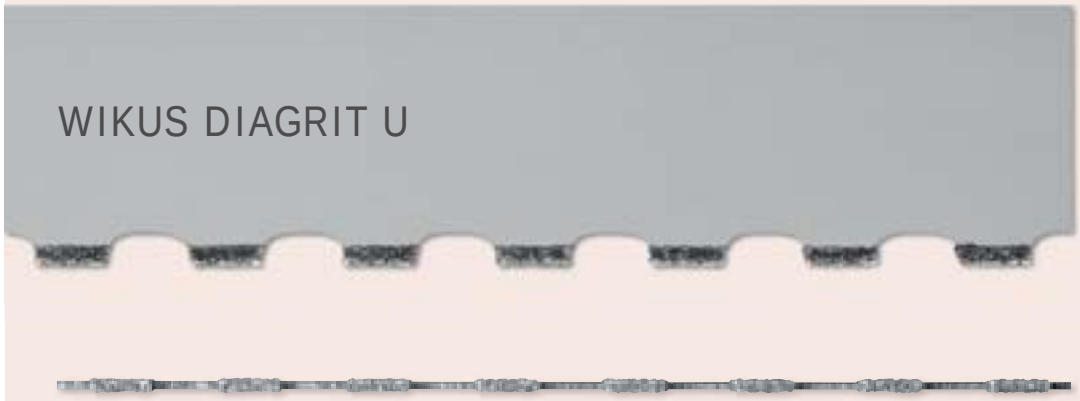
WIKUS diamond program offers seven grit sizes:
D 91, D 126, D 181, D 252, D 356, D 427, D 601

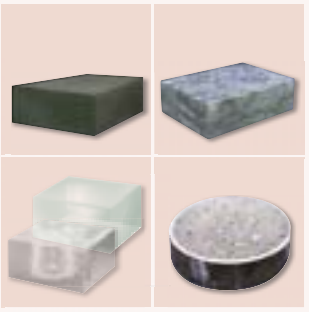
alternate band dimensions on request

*Item group **570 DIAGRIT K** (approx. 9000 HV)*
*Item group **572 DIAGRIT S** (approx. 9000 HV)*

Dimensions Width x thickness		Dimensions Width x thickness		Dimensions Width x thickness	
mm	Inches	mm	Inches	mm	Inches
10 x 0,50	3/8 x 0,020	20 x 0,80	3/4 x 0,032	41 x 0,50	1-5/8 x 0,020
10 x 0,65	3/8 x 0,025	25 x 0,65	1 x 0,025	41 x 0,80	1-5/8 x 0,032
13 x 0,65	1/2 x 0,025	27 x 0,50	1-1/16 x 0,020	41 x 1,30	1-5/8 x 0,050
13 x 0,80	1/2 x 0,032	27 x 0,70	1-1/16 x 0,028	50 x 0,90	2 x 0,035
16 x 0,50	5/8 x 0,020	27 x 0,90	1-1/16 x 0,035	54 x 1,10	2-1/8 x 0,042
16 x 0,65	5/8 x 0,025	34 x 0,90	1-3/8 x 0,035		
20 x 0,50	3/4 x 0,020	34 x 1,10	1-3/8 x 0,042		

DIAGRIT® U





Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	**20**	**21**	22	**23**	24

Classification

N	B	S	**T**

intermittent gritting U

WIKUS diamond program offers seven grit sizes:
D 91, D 126, D 181, D 252, D 356, D 427, D 601

alternate band dimensions on request

*Item group **574 DIAGRIT U** (approx. 9000 HV)*

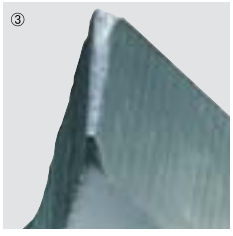
Dimensions Width x thickness		Gap pitch T	Dimensions Width x thickness		Gap pitch T
mm	Inches	mm	mm	Inches	mm
10 x 0,50	3/8 x 0,020	6	34 x 1,10	1-3/8 x 0,042	20
10 x 0,65	3/8 x 0,025	6	41 x 0,50	1-5/8 x 0,020	20
13 x 0,65	1/2 x 0,025	8	41 x 0,80	1-5/8 x 0,032	20
16 x 0,65	5/8 x 0,025	8	41 x 1,30	1-5/8 x 0,050	20
20 x 0,50	3/4 x 0,020	8	50 x 0,90	2 x 0,035	20
20 x 0,80	3/4 x 0,032	8	54 x 1,10	2-1/8 x 0,042	20
27 x 0,50	1-1/16 x 0,020	12	54 x 1,60	2-1/8 x 0,063	20
27 x 0,70	1-1/16 x 0,028	12	67 x 1,60	2-5/8 x 0,063	30
27 x 0,90	1-1/16 x 0,035	12	80 x 1,10	3-1/8 x 0,042	12
34 x 0,90	1-3/8 x 0,035	20	100 x 1,10	4 x 0,042	12/30

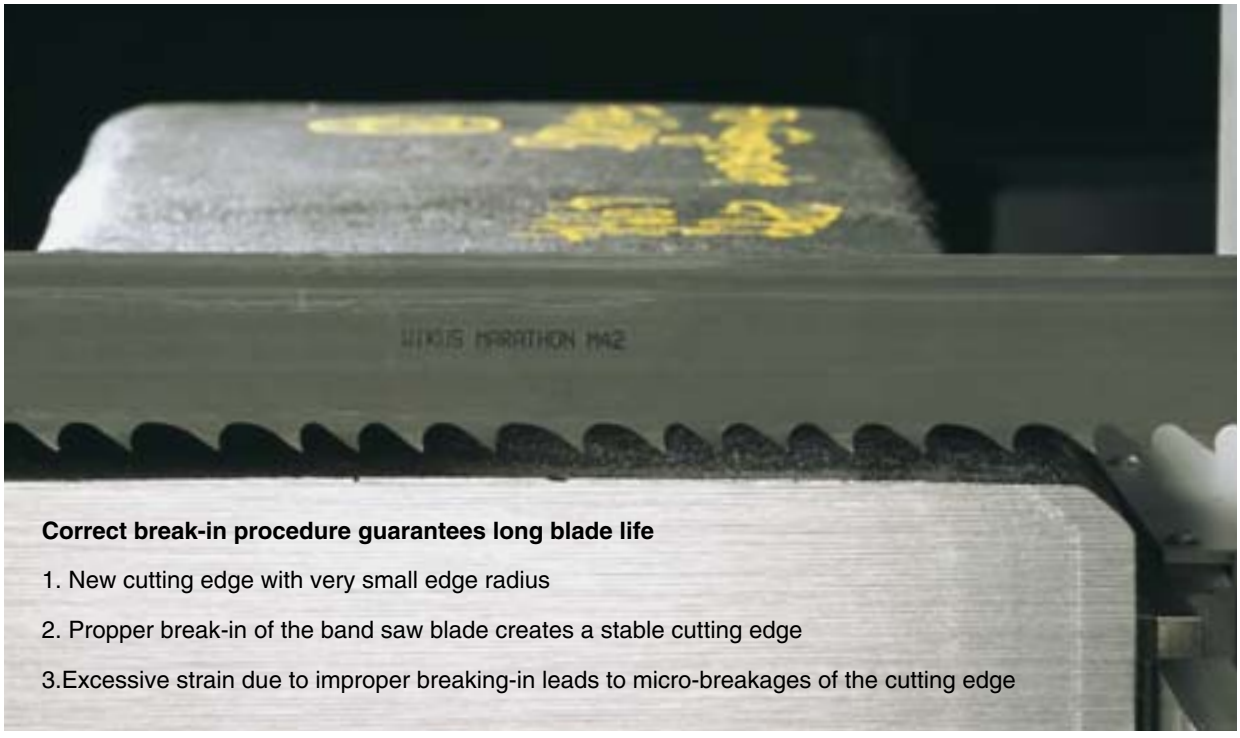
MATERIALS AND STANDARDS

	MATERIAL GROUPS	MATERIAL NUMBER	DIN
1	Structural steels, deep drawing steels, machining steels	1.0037, 1.0301, 1.0721, 1.0040,1.0401	St37, St42, C10, C15, 10 S 20
2	Structural steels, quenched and tempered steels	1.0050, 1.0060, 1.0501, 1.0503	St 50, St 60, C35, C45
3	Case hardened steels, spring steels, quenched and tempered steels	1.7131, 1.7225, 1.8159	16 Mn Cr 5, 42 CrMo 4, 50 Cr V 4
4	Low alloyed hot-work steels	1.2311, 1.2714	40 Cr Mn Mo 7, 55 Ni Cr Mo V 6
5	Nitriding steels, high alloyed hot-working steels	1.2344. 1.2738	X 40 Cr Mo V 5 1, 40 Cr Mn Ni Mo 8 6 4
6	Unalloyed tool steels	1.3505, 1.1663	100 Cr 6, C 125 W
7	Cold work steels	1.2080, 1.2379	X 210 Cr 12, X 155 Cr V Mo 12 1
8	High-speed steels	1.3343, 1.3247	S 6-5-2, S 2-10-1-8
9	Cast iron	0.6015, 0.6030, 0.7050	GG 15, GG 30, GGG 50
10	Rust- and acid-resistant steels (light)	1.4057, 1.4028, 1.2083	X 17 Cr Ni 16-2, X30Cr 13, X42 Cr 13
11	Rust- and acid-resistant steels (heavy)	1.4301, 1.4404, 1.4571	X 5 Cr Ni 18-10, X 2 Cr Ni Mo 17-12-2, X 6 Cr Ni Mo 17-12-2
12	Duplex and heat-resistant steels	1.4462, 1.4841	X2 Cr Ni Mo N 22-5-3, X 15 Cr Ni Si 25-25
13	Nickel-base alloys	2.4668, 2.4610, 2.4632	Ni Cr 19 NbMo, Ni Mo 16 Cr 16 Ti
14	Induction hardened and chrome coated shafts	3.0285, 3.3547, 3.2581	AlMg3, AlSi 12, AlMg4,5 Mn
15	Aluminium		
16	Copper	2.0050	Cu 99,9
17	Brass	2.0321, 2.0402	Cu Zn 37, Cu Zn 40 Pb 2
18	Aluminium bronze	2.0976, 2.0941, Ampco	CuAl 10 Ni, CuAl 10 Fe
19	Titanium alloys	3.7025, 3.7164	Ti 1, Ti-6Al-4V
20	Abrasive building materials		
21	Carbon		
22	Plastics		
23	Glass, fiberglass, marble, silicon		
24	Tires		

Individual standards, no comparison

AISI / ASTM / SAE	JIS	BS	AFNOR
1015, 1005, A242,1212	STKM 12A, SN400 B, SUM 21	En 40 B, En 2 A	E24 E27 XC10 XC 15
1040,1060, A572	SS490, SM 570, S 45 CM	E355, E395, EN 8	XC 48
5115, 4140, 6150	SCM 420H, SNCM 22, SCM 440, SUP 10	EnN19, 735 A 51, EN 47	16MC5 42CD4 50CV4
P20, L6; 4340	SKT 4	620, 632	40CMD7 55 NCDV7
H-13, H-14, H-21, HNV 3	SKD 61, SKD 11, Sk 4	BH11, BH 13	Z40CDV5 40CMND8
52100, 50100,L3, W2	Sk2, SK5, SUJ 2	BL3, BA2	100C6
D-2,D-3, D-7, O-2,O-6	SKD 1, SKD 11	BD3, Grade 2, GHC 134	Z160CDV12 Z200C12
M-2, M-7, M42, T-5, T-15	SKH 51, SKH 59, SKH 2	BT42, BM 35, BM 2	HS6-5-2 HS2-9-1-8
Class 20, Class 40, Class 60	FC 150, FC 300, FGS 500	Grade 150, Grade 300	GJS500-7U GS60
431, 430, 403, 405,420	SUS 420 J1, SDS416, SUS 431	J91151, 416S37	Z 15 CN 16-02 Z 33 C 13 Z 40 C 14
316, 304, 440	SUS 304, SUS316, 17-7PH	EN58E, 301s22, J92590	304L 316L
309, 310, Incoloy	SUS630, SUH310	NA15, 254SMO, 347	Z 3 CND 22-05 314
Inconel, Hastelloy, Nimonic, Monel, Rene 41	NCF600	NA13,NA19, Alloy 718	INCO 718 Thermax90
2017, 1000, 7075			A5, AU 4 G, Au 2 GT
	A2017, A1050, A7075		
101, 172	C1020		Cu 99,9
	C2720P, C2720R		Cu Zn 37, Cu Zn 40 Pb 2
	CAC703, CAC701		CuAl 10 Ni, CuAl 10 Fe AMPCO
			TA 6V





Correct break-in procedure guarantees long blade life

1. New cutting edge with very small edge radius

2. Propper break-in of the band saw blade creates a stable cutting edge

3.Excessive strain due to improper breaking-in leads to micro-breakages of the cutting edge

BREAKING-IN A BAND SAW BLADE

Bimetal band saw blades

Sharp cutting edges having extremely small edge radii are required for high cutting power. WIKUS blades are predestined for that.

For keeping the optimal blade life we recommend to break-in the blade properly. Please determine the correct cutting speed (m/min) depending on the material to be cut and its dimension. Our cutting data slide rule is a helpful tool. It is important to break-in a new blade with only 50 % feed rate. Micro breakages caused by too large chip thicknesses can thus be avoided.

New band saw blades may tend to vibrations and noise. In this case, a slight reduction of cutting speed is also helpful. With small work piece dimensions approx. 300 cm² of the material should be cut to break-in the blade. In case of large work piece dimensions we recommend breaking-in over a period of about 15 min. After breaking-in, the feed rate may be slowly increased up to the full value.

Carbide band saw blades

After choosing the optimal parameters for your application by using our carbide data slide rule you should break-in a carbide-tipped band saw blade with approx. 50 % feed rate and 50 % cutting speed.

It is very important to avoid vibrations and noise. In such a case it should be helpful to reduce the cutting speed. After a breaking-in period of about 15 min or 300 cm² please slowly increase the cutting speed and then the feed rate up to the full value.

In addition to the band tension, which should be about 300 N/mm², please also check the oil content of the cooling lubricant before first use. Hand refractometer and band tension gauge are available at WIKUS..

Practical help: Cutting data slide rule and ParaMentor

Only with optimal cutting conditions and exact cutting parameters can a long blade life and high cutting rate be guaranteed.
Our extensive cutting data slide rules for bimetal and carbide-tipped blades, which are developed by WIKUS, offer you a practical help. Both show 18 different material groups with all important parameters for cutting metals.

A special service is offered to our customers on our website: ParaMentor, the online cutting data program of WIKUS.

You may reach ParaMentor through our website: www.wikus.com

CUSTOMER SERVICE

For questions about our product range or individual solutions for your application, please contact us.

Our specialists have extensive experience with most applications and are glad to help you.

If needed, our technicians will be there for you on the spot - assisting you in the best possible use of our band saw blades.

For extensive product recommendation we require the following information:

1. Exact description of the material to be cut, if possible including material number and tensile strength.

2. Cross-sections of the material (for tubes diameter and wall thickness) and shape of the material (round, square, tube, profile etc.).

3. Surface condition (forged, rolled, cast, drawn, bare etc.)

4. Type of cut (single, layer, bundle cut). When layer and bundle cutting please indicate the number of layers or bars. With flat, square or profile material, please specify whether the material is clamped flat or on edge.

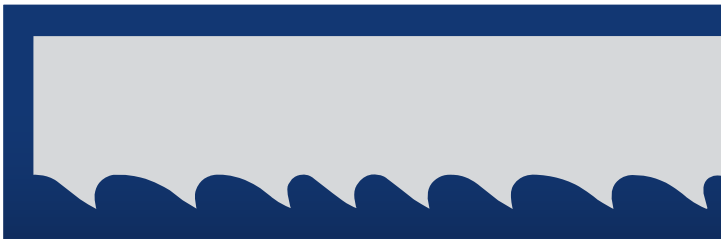
5. Band saw blade dimensions (length, width, thickness) as well as the machine type. In case of contour cuts please indicate the smallest radius to be cut.

You will find up to date and detailed information about our products as well as useful help on our website.

Please visit our website.
www.wikussawtech.com

WIKUS®

Precision at the cutting point



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LEGEND

Material groups

1	Structural steels, deep drawing steels, machining steels
2	Structural steels, quenched and tempered steels
3	Case hardened steels, spring steels, quenched and tempered steels
4	Low alloyed hot-work steels
5	Nitriding steels, high alloyed hot-working steels
6	Unalloyed tool steels
7	Cold work steels
8	High-speed steels
9	Cast iron
10	Rust- and acid-resistant steels (light)
11	Rust- and acid-resistant steels (heavy)
12	Duplex and heat-resistant steels
13	Nickel-base alloys
14	Induction hardened and chrome coated shafts
15	Aluminium
16	Copper
17	Brass
18	Aluminium bronze
19	Titanium alloys
20	Abrasive building materials
21	Carbon
22	Plastics
23	Glass, fiberglass, marble, silicon
24	Tires

Tooth shapes

L, S, P, K, HV, VA, T, TSN (see page 10)

Types of tooth set

SD, GS, WS (see page 11)

Classification

N **Normal:**
For standard applications

B **Basic:**
Capable all-round tool

S **Special:**
Special applications with high quality demand

T **Top Line:**
High-tech tool for highest demands

Klappseite
Aussen

Breite 105 mm