WIKUS®

Precision at the cutting point

PRECISION

BAND SAW BLADES

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DIAMOND COATED BAND SAW BLADES

CBN-COATED BAND SAW BLADES

CARBIDE COATED BAND SAW BLADES

CARBON STEEL BAND SAW BLADES

CHANGES IN THE PRODUCT PORTFOLIO

New and further developments

WIKUS expands its portfolio of coated band saw blades by introducing the new product CUBOGRIT®. CUBOGRIT® uses cubic boron nitride (CBN) as its cutting material. The new PRIMAR® M42 has an expanded range of TPI. In addition, the product portfolio has been updated with the advanced bimetal band saw blades BIFLEX® M42, VARIO® M42, PROFLEX® M42 and ECOFLEX® M42.

Returning products

TCTYRE® and TCGRIT® K/U are included in the product catalog again.

“Coated band saw blade” categories

The diamond coated band saw blades DIAGRIT® K/S/U, the new CBN-coated band saw blades CUBOGRIT® K/S/U, and the carbide coated band saw blades TCGRIT®K/U, have been placed in new coated band saw blade sections.

WI.com

“Transparency in the workplace and in the mind” - This is the mission statement for the new company headquarters in Spangenberg. The building reflects the technical precision and the innovative spirit of WIKUS.

WIKUS – TOP QUALITY “MADE IN GERMANY”

Family-run, reliable, innovative

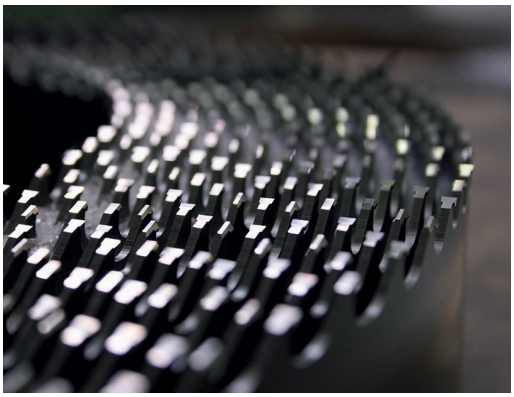
WIKUS is known for precision, quality and maximum performance. Since 1958 we use the highest quality raw materials, leading-edge manufacturing methods and continuous quality assurance to guarantee the highest standards when producing our high-tech band saw blades. At the same time we set product and technology trends through our innovative research and development.

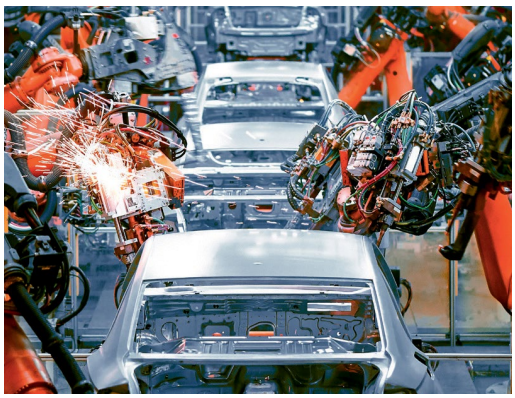
Globally represented, locally acting, technically experienced & interconnected

Our worldwide network of subsidiaries, agents and distributors provide you with professional and personal local support.
Global presence and local ties are important for us.
WIKUS and its employees support many cultural, social and environmental projects.

WIKUS stands for:

- consistent high quality
- 100 % manufacturing in Germany
- focus on high customer satisfaction
- demand-oriented development through our own in-house research and development
- partnership and expertise
- process stability according to DIN EN ISO 9001
- 60 years of experience, Europe’s largest band saw blade manufacturer
- sustainability, protection of resources and environment





THE PERFECT SAW BLADE MEETING YOUR REQUIREMENTS

From multinational corporations to local SMEs and distributors – customers, in the following market segments, trust in the highly effective solutions offered by WIKUS:

- Steel production / machining including steel trade, forge and steel / metal industry
- Aerospace, automotive, shipping industry
- Plant, mold, machine and tool construction including aluminum plate machining
- Foundries of non-ferrous and steel products
- Energy, such as offshore / petrochemical industry, renewable energy (solar, wind)
- Construction, chemicals, others such as semiconductor, carbon, glass, brick, virgin stone and plastics industry

Solutions for a wide application range

Our wide product range covers all performance and material classes. We support you in selecting the perfect high performance tooling to meet your cutting requirements for:

- Solid materials including stone
- Tubes, profiles, girders
- Cylinder heads, engine blocks and chassis components
- Aluminum precision plates
- Non-ferrous mold parts
- Silicon cutting

ECONOMICAL CUTTING FOR YOUR SUCCESS!

Value from our solutions multiply – depending on your specific needs.
The benefits:

Reduced costs

No matter if you want to reduce the costs per cut, find an all-purpose band saw blade to reduce change overs or need an economical band saw blade for basic applications, we offer the perfect solution for each situation.

Increased productivity

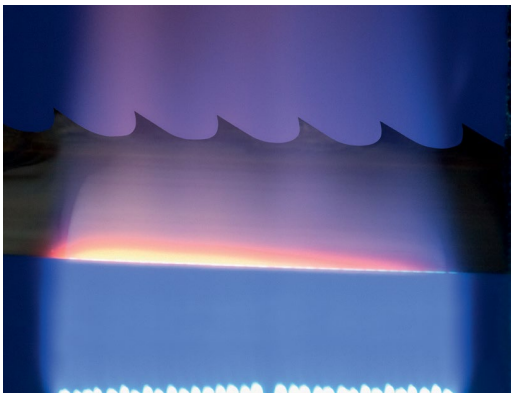
Using our band saw blades enables large output and high performance even in challenging conditions. High blade life, universal application in mixed operations, minimizes setup and downtime.

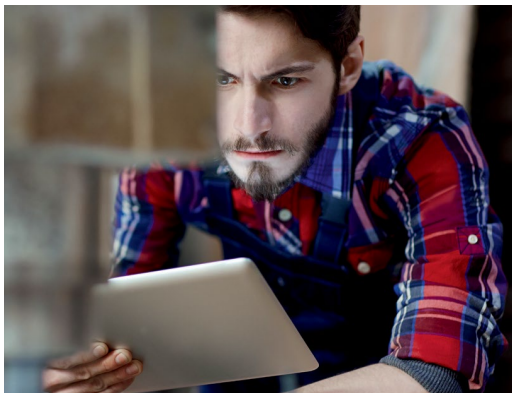
Innovative solutions

We are continuously optimizing our product range to offer you more efficient saw blades for each cutting task – even for materials which are difficult to cut – and to meet changing market needs. We work with you to solve the most demanding cutting challenges.

Consistent high quality

Our “Made in Germany” band saw blades are known for outstanding product quality. Latest manufacturing technologies, best raw materials and high process stability ensure consistency. We strive to optimize and continuously improve our quality, manufacturing processes and delivery performance.





WIKUS GLOBAL SERVICES – LET'S WIN TOGETHER!

Customer satisfaction is our priority. In addition to our wide product portfolio, we offer extensive technical consulting services.

Our consulting services:

- Support when selecting the optimal band saw blade
- Optimization of cutting parameter to increase productivity
- Fast, reliable support in case of technical challenges
- Sampling and performing cutting tests
- Process optimization regarding the use of band saw blades and machines
- Technical training

OUR ONLINE SERVICES:

ParaMaster® 4.0

Our innovative cutting data program, ParaMaster®, 4.0 supports you effectively in optimizing your cutting processes.

Your benefit:

- Recommendation of suitable cutting parameters
- Broad data base with more than 150,000 materials, more than 4,000 band sawing machines, extensive applications and much more.
- User-friendly: all information at a glance, intuitive user interface
- Cutting cost analysis shows potential savings

Access is free for WIKUS customers. Please register at **www.paramaster.de**

ParaMaster® App

Use the ParaMaster® App to scan the blade QR code for quick access to detailed blade data.

Download on the App Store GET IT ON Google Play

Blade selector

The online blade selector provides guidance when selecting the appropriate band saw blade for you cutting requirements.
www.wikus.com/bladeselector

PRODUCT CLASSIFICATION

Sawing is a science - a variety of factors determine what results you will achieve with sawing.

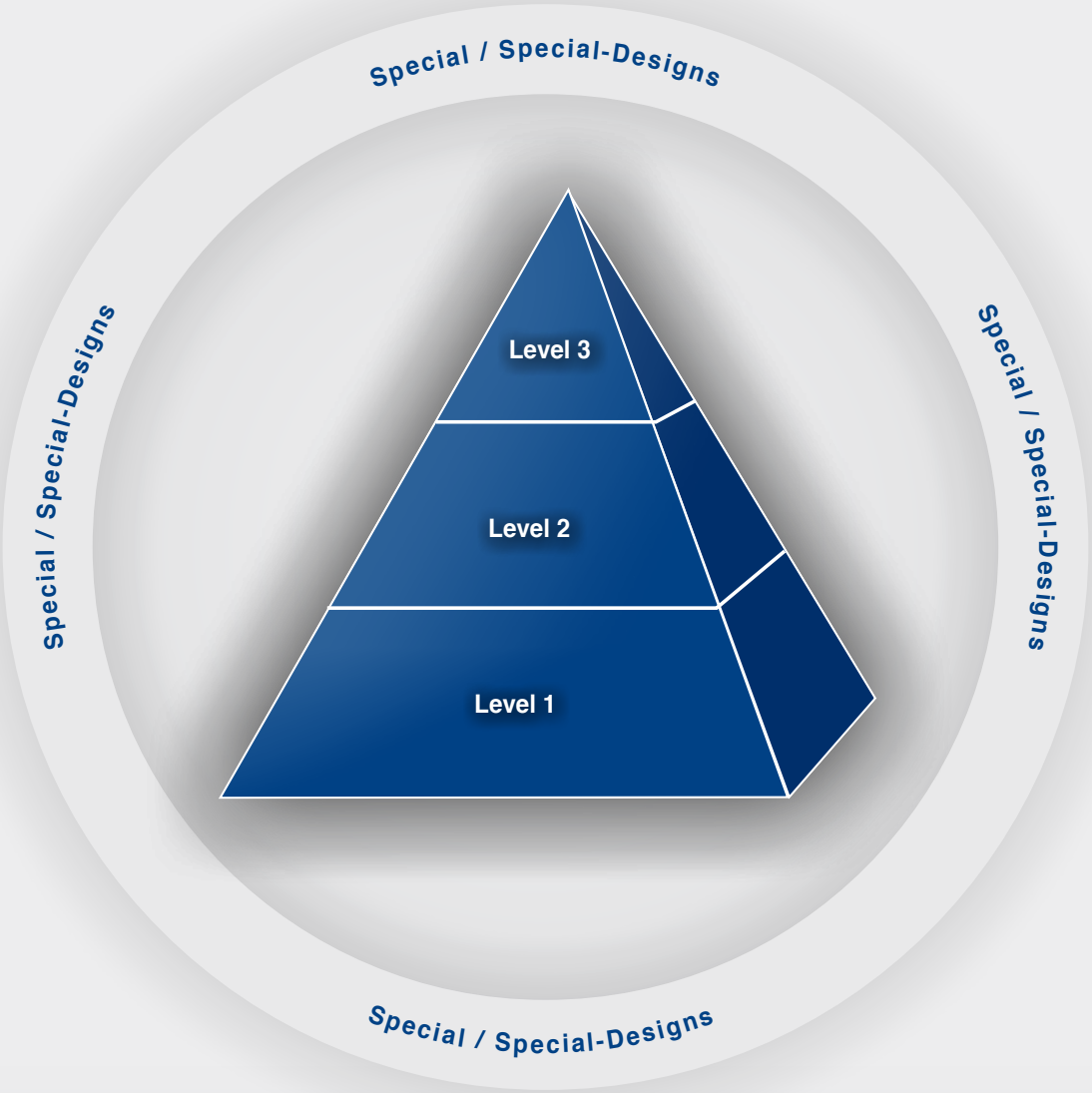
To make it easier for you to select the right products, WIKUS groups its band saw blades into three performance classes:

- **Level 1**
  General purpose band saw blades that can be used universally
- **Level 2**
  Band saw blades that offer higher performance
- **Level 3**
  High-tech band saw blades that meet the highest standards

The WIKUS product line also includes **special designs** for use in individual applications. Please note that not all special designs are available for every band saw.

Furthermore, WIKUS also offers **special blades**:

- **Special**
  Special products for use in high-performance sawing technology and very uniique applications



BLADE SELECTOR

PRODUCT FAMILY	BIMETAL					
APPLICATION						
Nickel-based alloys						
Duplex and heat-resistant steels						
Titanium, titanium alloys	MARATHON® X3000® 23		SKALAR® X3000® 24			
Aluminum bronze			SELEKTA® GS X3000® 25			
Hardened and tempered steels (over 1000 N/mm²)						
Stainless and acid-resistant steels (austenitic)						
Stainless and acid-resistant steels (ferritic)						
Nitriding and high-speed steels						
Cast iron						
Tool steels	BIFLEX® M42 13		SKALAR® M42 18		PRIMAR® M42 20	
Hardening steels Spring and ball bearing steels	VARIO® M42 14	PROFLEX® M42 16	SELEKTA® GS M42 19		ECOFLEX® M42 21	
Carbon and heat-treated steels	MARATHON® M42 15					
Construction, deep-drawing and cutting steels						
Non-ferrous metals						
Aluminum / aluminum alloys						
Surface hardened components						
CLASSIFICATION	2 Level 2		3 Level 3		1 Level 1	

CARBIDE							
●■	□○H∧	●■	□○H∧	●■	□○H∧	●■	□○H∧
		FUTURA® 718 33					
		FUTURA® VA 32					
DUROSET® 28				TAURUS® 31			
		FUTURA® 29	PROFIDUR® 30			ARION® FG 36 ARION® EG 37	ARION® PG 36
ECODUR® 34		FUTURA® NE 35					
						FUTURA® SN 38	
2 Level 2		3 Level 3		1 Level 1		S Special	

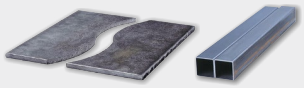
BIMETAL BAND SAW BLADES
CUTTING MATERIAL M42

- The perfect product portfolio for standard and special applications
- The back of the blade is made of alloyed steel that offers excellent continuous operation properties
- Proven cutting material M42 with superior wear resistance in conventional applications
- Coated versions for maximum cutting performance and longer tool life

Sales units:	• Coils in fixed lengths and manufacturing coils of up to 400 feet, depending on the width • Welded-to-length band saw blades
Band widths:	1/4 to 3-1/8 inches
Tooth shapes:	S, P, K See page 56 for explanations
Tooth pitches:	**Variable:** 12-16 to 0.7-1.0 teeth per inch (tpi) **Constant:** 18 to 1.25 teeth per inch (tpi) See page 57 for explanations
Types of tooth set:	SD See page 57 for explanations
Qualities:	**M42:** 68-69 HRC, approx. 980 HV
Special designs:	• **PW** available for product families: SKALAR® M42, SKALAR® PREMIUM M42, SELEKTA® GS M42, SELEKTA® GS PREMIUM M42 • **PE** available for product families: BIFLEX® M42, VARIO® M42, MARATHON® M42

BIFLEX® M42 (2)

The universal band saw blade for vertical sawing with manual feed



Application:
- Contour cuts
- Vertical sawing with manual feed

Advantages:
- Long life due to high wear resistance
- Improvement of the cut face quality due to superfinishing

Features:
- Constant tooth pitch
- M42 tooth cutting edge
- Uniform cutting force

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 18	14	6	4	3	1.25
4 x 0.90	5/32 x 0.035		S				
6 x 0.90	1/4 x 0.035			K			
10 x 0.90	3/8 x 0.035			K	K		
13 x 0.50	1/2 x 0.020		S				
13 x 0.65	1/2 x 0.025	S	S	K	K		
13 x 0.90	1/2 x 0.035			K	K	K	
20 x 0.90	3/4 x 0.035	S		K	K	K	
20 x 1.10	3/4 x 0.042					K	
27 x 0.90	1-1/16 x 0.035	S	S				
34 x 1.10	1-3/8 x 0.042						K
Contact length (inch)		< 0.4	< 0.6	2-3.1	3.1-4.7	4.7-7.9	11.8-31.5

S = Standard tooth, K = Hook tooth

VARIO® M42

The all-purpose band saw blade for small cross-sections and profiles

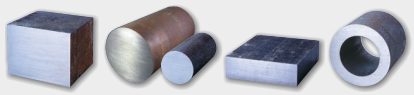
Application:	• Thin-walled profiles and small solid materials • Single, layer and bundle cutting
Advantages:	• Consistent high blade life • High running smoothness in spite of vibrations
Features:	• M42 tooth edge with 0° rake angle • Variable tooth pitch and standard set

Dimensions Width x Thickness		Tooth pitch in tpi					
mm	Inch	10-14	8-12	6-10	5-8	4-6	3-4
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
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			
Contact length (inch)		< 0.8	0.4-1.2	0.8-2	1.2-2.4	2-3.5	3.1-5.9

S = Standard tooth

MARATHON® M42

The all-purpose band saw blade for medium and large cross-sections



Application:
- Single, layer and bundle cutting

Advantages:
- Fewer blade changes due to wide application range
- Consistent high blade life
- Tighter tolerances through straighter cuts

Features:
- M42 tooth edge with positive rake angle
- Variable tooth pitch and standard set

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 5-8	4-6	3-4	2-3	1.4-2	1.0-1.4	0.75-1.25
27 x 0.90	1-1/16 x 0.035	K	K	K	K			
34 x 1.10	1-3/8 x 0.042	K	K	K	K	K		
38 x 1.30	1-1/2 x 0.050		K	K	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	
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
Contact length (inch)		1.2-2.4	2-3.5	3.1-5.9	4.7-9.8	9.8-19.7	19.7-31.5	21.7-47.2

MARATHON® SW M42

Special design for cutting applications with residual stress materials

Application:
- Workpieces with residual stress

Advantages:
- No jamming in the cutting channel

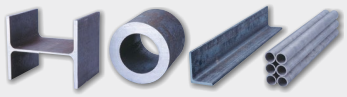
Features:
- Extra wide set and variable tooth pitch
- M42 tooth edge with positive rake angle

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 5-8	4-6	3-4	2-3	1.4-2	1.0-1.4	0.75-1.25
41 x 1.30	1-5/8 x 0.050			K	K			
54 x 1.60	2-1/8 x 0.063			K	K			
67 x 1.60	2-5/8 x 0.063			K	K			
Contact length (inch)		1.2-2.4	2-3.5	3.1-5.9	4.7-9.8	9.8-19.7	19.7-31.5	21.7-47.2

K = Hook tooth, Photo below: MARATHON® M42

PROFLEX® M42

The perfect band saw blade for profiles



Application:	• Profiles and girders, for metal and steel construction • Optimal for cutting with interrupted cutting channel
Advantages:	• Durable and resistant despite high abrasion and strong vibrations • Flatter surface finish and less burring
Features:	• Extremely sturdy tooth contour and variable tooth pitch with specific step set • M42 tooth edge with positive rake angle

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 12-16	8-11	5-7	4-6	3-4	2-3
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	P	
34 x 1.10	1-3/8 x 0.042		P	P	P	P	P
41 x 1.30	1-5/8 x 0.050		P	P	P	P	P
54 x 1.30	2-1/8 x 0.050				P	P	P
54 x 1.60	2-1/8 x 0.063				P	P	P
67 x 1.60	2-5/8 x 0.063					P	P
Contact length (inch)		< 0.8	0.4-2	1.6-2.8	2-3.5	3.1-6.3	5.9-12.2

PROFLEX® PREMIUM M42

The hard material coated band saw blade for profiles

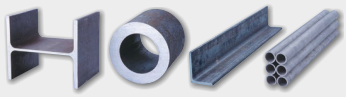
Application:	• Profiles and girders, for steel construction and industrial profile cuts • Optimal for cutting with interrupted cutting channel
Advantages:	• Productivity increase through high cutting rate • Fewer blade changes due to increased blade life • Flatter surface finish and less burring
Features:	• Tooth edge and back edge coated with wear protection • Variable tooth pitch with specific step set

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 12-16	8-11	5-7	4-6	3-4	2-3
34 x 1.10	1-3/8 x 0.042			P	P	P	
41 x 1.30	1-5/8 x 0.050					P	
54 x 1.30	2-1/8 x 0.050					P	
54 x 1.60	2-1/8 x 0.063					P	P
67 x 1.60	2-5/8 x 0.063					P	P
Contact length (inch)		< 0.8	0.4-2	1.6-2.8	2-3.5	3.1-6.3	5.9-12.2

P = Profile tooth, Photo below: PROFLEX® M42

PROFLEX® SW M42 ②

Special design for profiles made of residual stress material



Application:
- Profiles and girders with residual stress
- For steel construction and industrial profile cuts

Advantages:
- No jamming in the cutting channel

Features:
- Extra wide step set and variable tooth pitch
- Extremely sturdy tooth contour
- M42 tooth edge with positive rake angle

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 12-16	8-11	5-7	4-6	3-4	2-3
34 x 1.10	1-3/8 x 0.042					P	
41 x 1.30	1-5/8 x 0.050					P	
54 x 1.30	2-1/8 x 0.050					P	P
54 x 1.60	2-1/8 x 0.063					P	P
67 x 1.60	2-5/8 x 0.063					P	P
Contact length (inch)		< 0.8	0.4-2	1.6-2.8	2-3.5	3.1-6.3	5.9-12.2

PROFLEX® PREMIUM SW M42 ②

The coated special design for residual stress materials

Application:
- Profiles and girders with residual stress
- For steel construction and industrial profile cuts

Advantages:
- Productivity increase through high cutting rate
- No jamming in the cutting channel
- Fewer blade changes due to increased blade life

Features:
- Tooth edge and back edge covered with wear protection
- Extra wide step set and variable tooth pitch

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 12-16	8-11	5-7	4-6	3-4	2-3
41 x 1.30	1-5/8 x 0.050					P	P
54 x 1.60	2-1/8 x 0.063					P	P
67 x 1.60	2-5/8 x 0.063					P	P
Contact length (inch)		< 0.8	0.4-2	1.6-2.8	2-3.5	3.1-6.3	5.9-12.2

P = Profile tooth, Photo below: PROFLEX® PREMIUM SW M42

SKALAR® M42

The high performing band saw blade

Application:	• High cutting rate, also continuous operation in industrial production
Advantages:	• Short cutting time, lower cutting forces and smoother running • Fewer blade changes due to increased blade life
Features:	• Ground contour with specially matched tooth pitch • M42 cutting edge with extra positive rake angle • Special set for optimal chip division

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 2.5-3.4	1.8-2.5	1.4-1.8	1.2-1.6	1.0-1.4	0.7-1.0
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	K	K			
54 x 1.30	2-1/8 x 0.050	K	K	K			
54 x 1.60	2-1/8 x 0.063	K	K	K	K	K	
67 x 1.60	2-5/8 x 0.063			K	K	K	K
80 x 1.60	3-1/8 x 0.063				K	K	K
Contact length (inch)		3.5-7.9	7.9-13.4	13.4-20.9	13.8-23.6	19.7-31.5	31.5-78.7

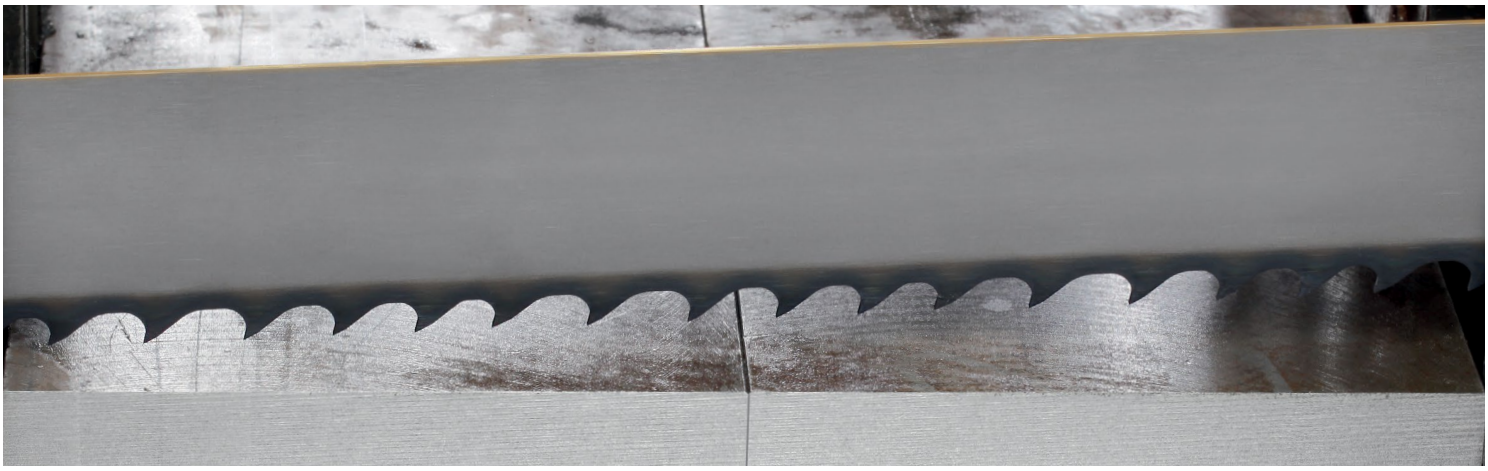
SKALAR® PREMIUM M42

High performance and extra blade-life

Application:	• High cutting rate, also continuous operation in large steel mills
Advantages:	• Long lifetime, smooth running with low vibration • Reliable and efficient multiple machine operation
Features:	• Tooth edge with special coating, back edge coating for less friction

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 2.5-3.4	1.8-2.5	1.4-1.8	1.2-1.6	1.0-1.4	0.7-1.0
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	K				
54 x 1.30	2-1/8 x 0.050	K					
54 x 1.60	2-1/8 x 0.063	K	K	K	K		
67 x 1.60	2-5/8 x 0.063			K	K	K	
80 x 1.60	3-1/8 x 0.063				K	K	K
Contact length (inch)		3.5-7.9	7.9-13.4	13.4-20.9	13.8-23.6	19.7-31.5	31.5-78.7

K = Hook tooth, Photo below: SKALAR® PREMIUM M42



SELEKTA® GS M42

High performance with Superfinishing

Application:
- High cutting rate with small and large solid material

Advantages:
- Low finishing due to perfect surface quality
- Low material waste through more precise run in
- Short cutting time through high performance

Features:
- Patented performance and surface teeth
- M42 cutting edge with extra positive rake angle

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 4-6	3-4	2-3	1.4-2	1.0-1.4
27 x 0.90	1-1/16 x 0.035	K	K	K		
34 x 1.10	1-3/8 x 0.042	K	K	K		
41 x 0.90	1-5/8 x 0.035			K		
41 x 1.30	1-5/8 x 0.050	K	K	K	K	
54 x 1.30	2-1/8 x 0.050		K	K	K	
54 x 1.60	2-1/8 x 0.063		K	K	K	K
67 x 1.60	2-5/8 x 0.063				K	K
80 x 1.60	3-1/8 x 0.063				K	K
Contact length (inch)		2-3.5	3.5-5.9	5.9-9.8	9.8-19.7	19.7-31.5

SELEKTA® GS PREMIUM M42

High performance, Superfinishing and extra blade-life

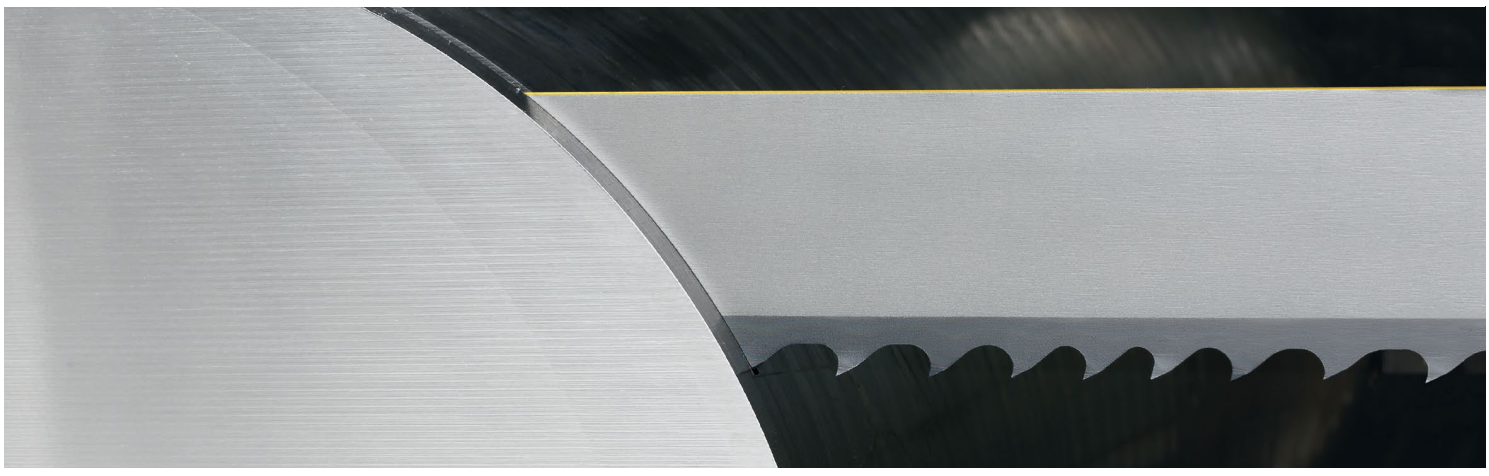
Application:
- For increased cutting rate and blade life in solid material

Advantages:
- Low finishing due to perfect surface quality
- Low material allowance through more precise run in
- Smooth, low vibration and very long running

Features:
- Patented performance and surface teeth
- Tooth edge with special coating, back edge coating for less friction

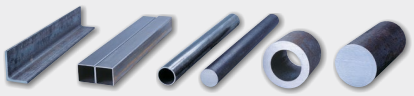
Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 4-6	3-4	2-3	1.4-2	1.0-1.4
34 x 1.10	1-3/8 x 0.042		K			
41 x 1.30	1-5/8 x 0.050		K	K		
54 x 1.60	2-1/8 x 0.063			K	K	
67 x 1.60	2-5/8 x 0.063				K	
Contact length (inch)		2-3.5	3.5-5.9	5.9-9.8	9.8-19.7	19.7-31.5

K = Hook tooth, Photo below: SELEKTA® GS PREMIUM M42



NEW: PRIMAR® M42

The versatile option in Level-1 for small and medium-sized workpieces



Application:
- Small to medium-sized workpieces
- Solids and profiles
- Industrial applications and workshops

Advantages:
- Less frequent blade changes due to universal range of application
- Good cutting surface due to precise tooth setting
- Very good price performance ratio in the Level-1 segment

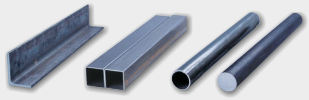
Features:
- M42 tooth edge with customized rake angle
- Optimized variable tooth pitch and standard tooth setting

Dimensions Width x Thickness		Tooth pitch in tpi							
mm	Inch	8-12	6-10	5-8	4-6	3-4	2-3	1.4-2	1.0-1.4
27 x 0.90	1-1/16 x 0.035	S	S	S	K	K	K		
34 x 1.10	1-3/8 x 0.042			S	K	K	K		
41 x 1.30	1-5/8 x 0.050				K	K	K	K	
54 x 1.30	2-1/8 x 0.050					K	K		
54 x 1.60	2-1/8 x 0.063					K	K	K	
67 x 1.60	2-5/8 x 0.063							K	K
Contact length (inch)		0.4-1.2	0.8-2	1.2-2.4	2-3.5	3.1-5.9	5.9-9.8	9.8-19.7	19.7-31.5

S = Standard tooth, K = Hook tooth

ECOFLEX® M42

The economical band saw blade for numerous cutting tasks



Application:
- Profiles and solid material made of low alloy steel
- Basic workshop operations
- Easy to cut materials

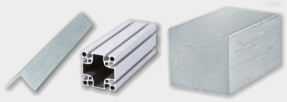
Advantages:
- Low cost with 100 % WIKUS quality

Features:
- M42 tooth edge with adapted rake angle
- Variable tooth pitch and standard set

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 10-14	8-12	6-10	5-8	4-6	3-4	2-3	1.4-2	1.0-1.4
13 x 0.65	1/2 x 0.025	S	S	S						
20 x 0.90	3/4 x 0.035	S	S	S	S	K				
27 x 0.90	1-1/16 x 0.035	S	S	S	S	K	K			
34 x 1.10	1-3/8 x 0.042		S	S	S	K	K	K		
41 x 1.30	1-5/8 x 0.050					K	K	K		
54 x 1.60	2-1/8 x 0.063						K	K	K	
67 x 1.60	2-5/8 x 0.063							K	K	K
Contact length (inch)		< 0.8	0.4-1.2	0.8-2	1.2-2.4	2-3.5	3.5-5.9	5.9-9.8	9.8-19.7	19.7-31.5

ECOFLEX® NE M42

The economical band saw blade for non-ferrous metals



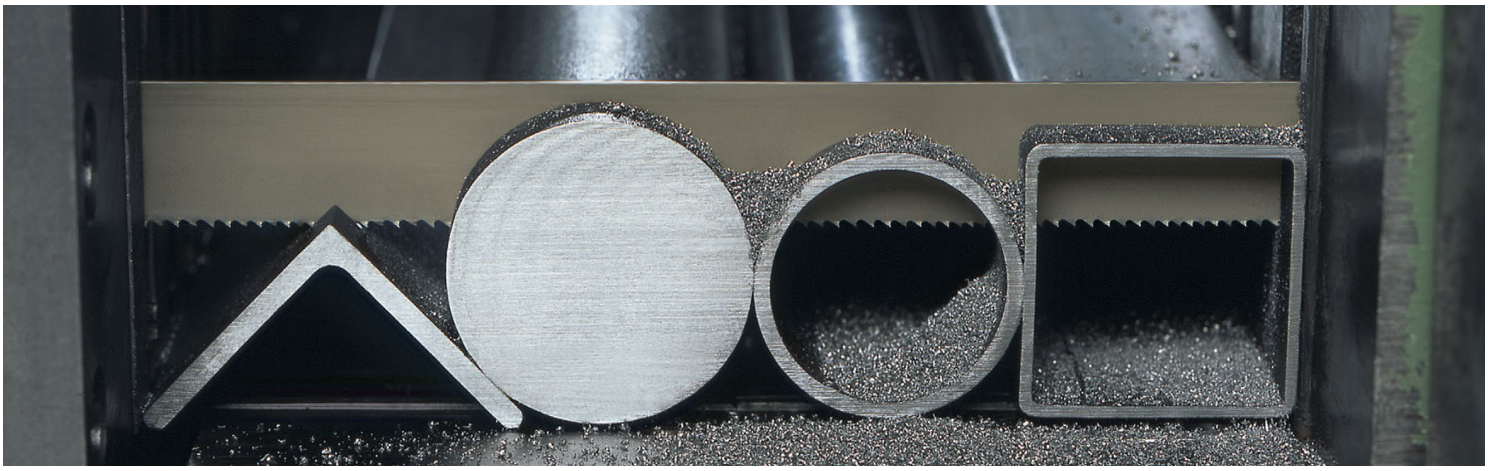
Application:
- Non-ferrous metals
- Cutting applications with manual feed
- Contour and radius cuts

Advantages:
- Low effort
- No jamming in the cutting channel
- Low cost, easy to resharpen

Features:
- M42 tooth edge with positive rake angle
- Constant tooth pitch and wide set

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 4	3	2
20 x 0.90	3/4 x 0.035		K	
27 x 0.90	1-1/16 x 0.035	K	K	K
34 x 1.10	1-3/8 x 0.042		K	
Contact length (inch)		3.1-4.7	4.7-7.9	7.9-15.7

S = Standard tooth, K = Hook tooth, Photo below: ECOFLEX® M42



BIMETAL BAND SAW BLADES
CUTTING MATERIAL X3000®

- The perfect product portfolio for standard and special applications
- The back of the blade is made of alloyed steel that offers excellent results in continuous operations
- Modified cutting material X3000® (exclusive to WIKUS) with high hardness and excellent toughness
- High cutting edge stability
- For materials that are difficult to machine and special alloys

Sales units:	• Coils in fixed lengths and manufacturing coils of up to 400 feet, depending on the width • Welded-to-length band saw blades
Band widths:	1-1/16 to 4 inches
Tooth shapes:	K See page 56 for explanations
Tooth pitches:	**Variable:** 5-8 to 0.7-1.0 teeth per inch (tpi) See page 57 for explanations
Types of tooth set:	SD See page 57 for explanations
Qualities:	**X3000®:** approx. 70 HRC, approx. 1000 HV
Special designs:	**PW** available for product families: SKALAR® X3000®, SELEKTA® GS X3000®

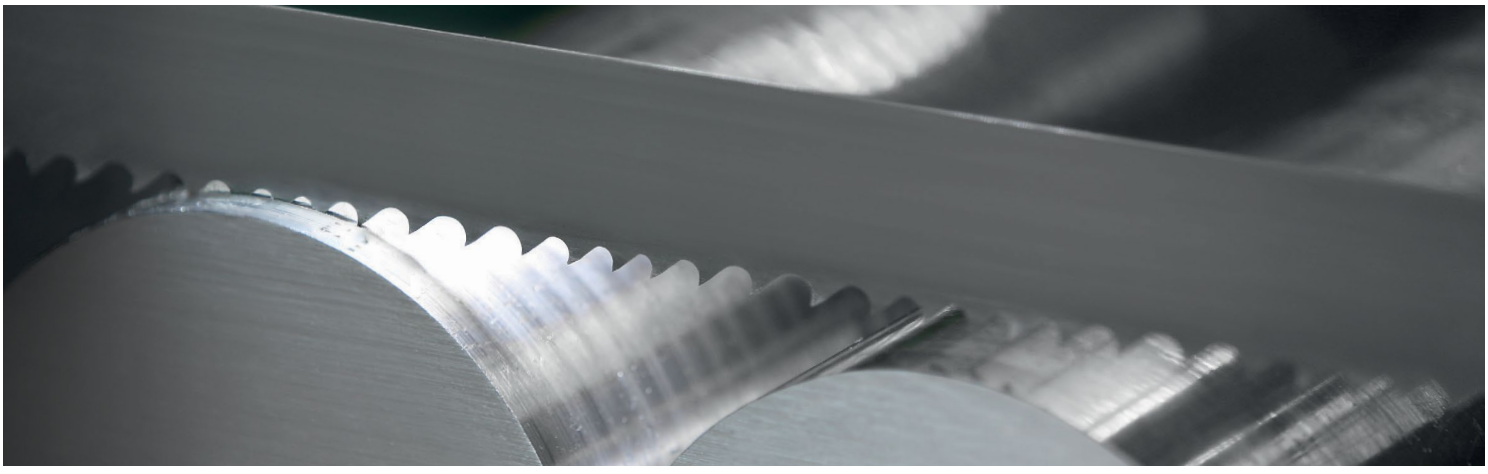
MARATHON® X3000®

The special band saw blade for high-tensile materials

Application:	• High-alloy austenitic materials • Scaled forging ingots
Advantages:	• Longer blade life and less wear • Low material loss due to improved flatness
Features:	• Tooth edge made of the cutting material X3000® with positive rake angle • High cutting edge stability and high wear resistance • Variable tooth pitch and standard set

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 5-8	4-6	3-4	2-3	1.4-2
27 x 0.90	1-1/16 x 0.035	K	K	K		
34 x 1.10	1-3/8 x 0.042		K	K	K	
41 x 1.30	1-5/8 x 0.050		K	K	K	
54 x 1.60	2-1/8 x 0.063		K	K	K	K
67 x 1.60	2-5/8 x 0.063			K	K	K
Contact length (inch)		1.2-2.4	2-3.5	3.5-5.9	5.9-9.8	9.8-19.7

K = Hook tooth



SKALAR® X3000®

The powerful band saw blade for high-tensile materials

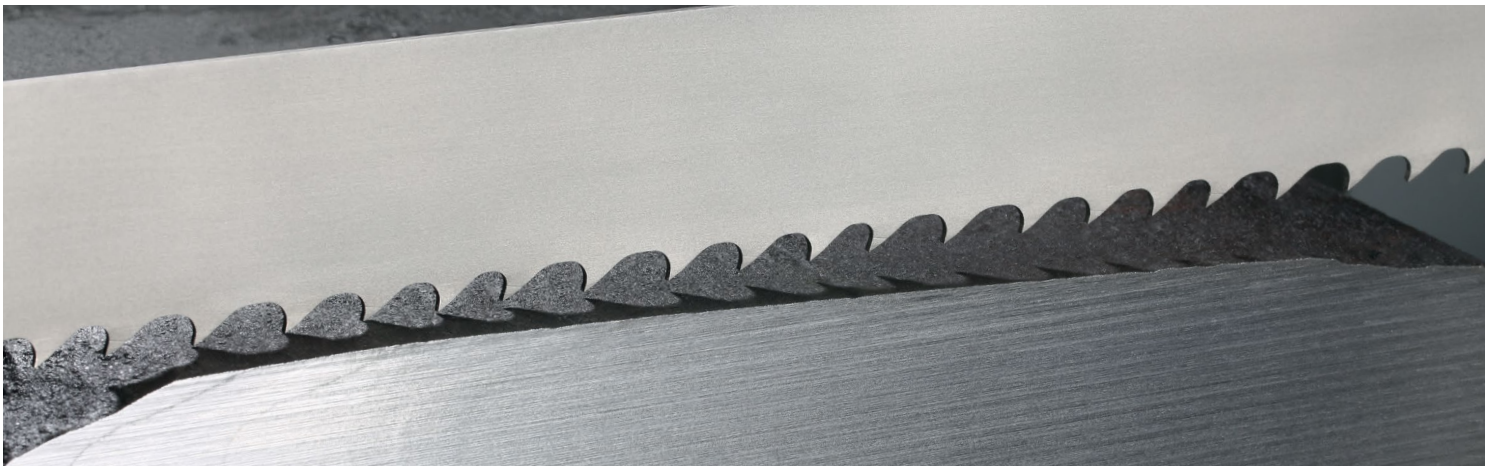
Application:
- Outstanding cutting rate with high-alloy austenitic materials
- Electroslag remelted material
- Continuous operation in large steel mills

Advantages:
- High efficiency due to excellent cutting performance
- Fewer blade changes due to increased blade life
- Lower cutting forces and smoother running

Features:
- Ground contour with specially matched tooth pitch
- Tooth edge made of the cutting material X3000® with positive rake angle
- Special set for optimal chip division

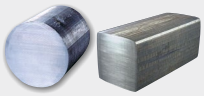
Dimensions Width x Thickness		Tooth pitch in tpi					
mm	Inch	2.5-3.4	1.8-2.5	1.4-1.8	1.2-1.6	1.0-1.4	0.7-1.0
27 x 0.90	1-1/16 x 0.035	K					
34 x 1.10	1-3/8 x 0.042	K	K				
41 x 1.30	1-5/8 x 0.050	K	K	K			
54 x 1.30	2-1/8 x 0.050		K				
54 x 1.60	2-1/8 x 0.063	K	K	K	K	K	
67 x 1.60	2-5/8 x 0.063		K	K	K	K	K
80 x 1.60	3-1/8 x 0.063			K	K	K	K
100 x 1.60	4 x 0.063						K
Contact length (inch)		3.5-7.9	7.9-13.4	13.4-20.9	13.8-23.6	19.7-31.5	31.5-78.7

K = Hook tooth



SELEKTA® GS X3000®

High performance with Superfinishing for difficult to cut materials



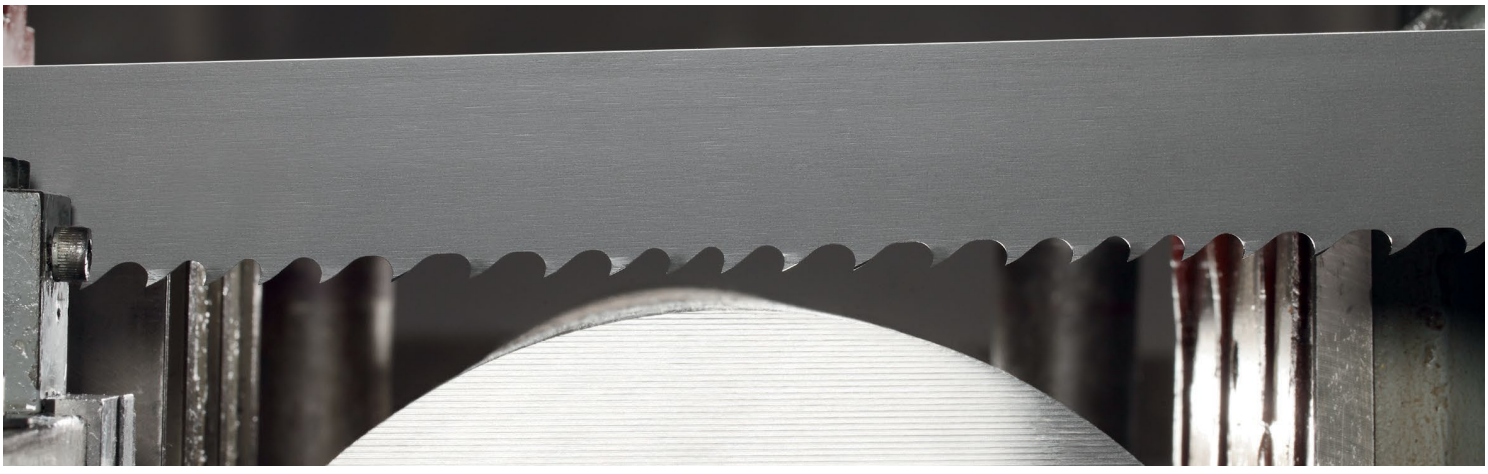
Application:
- Rust and acid-resistant steels and alloys (austenitic)
- Duplex and heat resistant steels
- For outstanding demands in surface quality and precise run-in

Advantages:
- Excellent productivity due to short cutting times
- Fewer blade changes due to increased blade life
- Perfect surfaces for low finishing

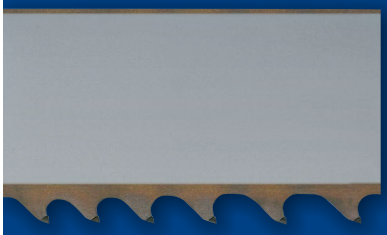
Features:
- Tooth edge made of the cutting material X3000® with positive rake angle
- High cutting edge stability and high wear resistance
- Patented performance and surface teeth

Dimensions Width x Thickness		Tooth pitch in tpi					
mm	Inch	4-6	3-4	2-3	1.4-2	1.0-1.4	0.7-1.0
27 x 0.90	1-1/16 x 0.035	K	K	K			
34 x 1.10	1-3/8 x 0.042	K	K	K			
41 x 1.30	1-5/8 x 0.050	K	K	K	K		
54 x 1.30	2-1/8 x 0.050			K	K		
54 x 1.60	2-1/8 x 0.063		K	K	K		
67 x 1.60	2-5/8 x 0.063			K	K	K	
80 x 1.60	3-1/8 x 0.063					K	K
Contact length (inch)		2-3.5	3.5-5.9	5.9-9.8	9.8-19.7	19.7-31.5	31.5-78.7

K = Hook tooth



CARBIDE TIPPED BAND SAW BLADES



- Available in specially ground and / or set tooth geometries
- Excellent results in every application through use of carbides with different degrees of hardness and compositions
- Very high cutting performance for increased machine productivity
- Coated premium blades for maximum cutting performance
- Long running times and extremely high performance from our high-tech products due to optimized backing material

Sales units:	• Coils of up to a max. of 164 feet • Welded-to-length band saw blades
Band widths:	1/2 to 4 inches
Tooth shapes:	S, K, T, TSN See page 56 for explanations
Tooth pitches:	**Variable:** 3-4 to 0.7-1.0 teeth per inch (tpi) **Constant:** 4 to 1.25 teeth per inch (tpi) See page 57 for explanations
Types of tooth set:	SD See page 57 for explanations
Special designs:	**PW** available for product families: DUROSET®, DUROSET® PREMIUM, FUTURA®, FUTURA® PREMIUM, FUTURA® VA, FUTURA® PREMIUM VA

APPLICATION RANGE FOR CARBIDE TIPPED BAND SAW BLADES

We classify our product range of carbide-tipped band saw blades into four groups to facilitate selection of the right band saw blade:

1. Structural, case-hardened, tempering and tool steels, also in mixed operation

All purpose band saw blades with the flexibility to be used for a wide application range.

2. Rust and acid resistant steels as well as special alloys

Special band saw blades for materials, which are difficult to cut, tough and tending to strain harden such as nickel-base and titanium alloys.

3. Non-ferrous metals

Band saw blades for a multitude of foundry applications including cutting of aluminum cast parts, aluminum ingots, plate cutting and all other non-ferrous metals.

4. Special applications

In addition to the above mentioned potential solutions we offer the optimal band saw blade for special applications, such as:

- **high performance cutting**
- **induction hardened steels**
- **mineral building materials**

With regard to further special requirements we invite you to get in touch with our Technical Support specialists for recommending the optimal band saw blade and suitable cutting parameter.

DUROSET®

The sturdy all-round band saw blade

Application:
- All steels, suitable for forged and scaled surfaces
- Solid material and thick-walled tubes

Advantages:
- Increased productivity of the machinery
- Sturdy design for increased wear resistance

Features:
- Set tooth geometry with positive rake angle, variable tooth pitch
- Optimized chip division

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 2.5-3.4	1.8-2.5	1.4-1.8	1.0-1.4	0.7-1.0
27 x 0.90	1-1/16 x 0.035	K	K			
34 x 1.10	1-3/8 x 0.042	K	K			
41 x 1.30	1-5/8 x 0.050	K	K	K		
54 x 1.30	2-1/8 x 0.050	K	K			
54 x 1.60	2-1/8 x 0.063		K	K		
67 x 1.60	2-5/8 x 0.063			K	K	
80 x 1.60	3-1/8 x 0.063				K	K
100 x 1.60	4 x 0.063					K
Contact length (inch)		3.5-7.9	7.9-13.4	13.4-20.9	19.7-31.5	31.5-78.7

DUROSET® PREMIUM

The sturdy all-round band saw blade coated with hard material

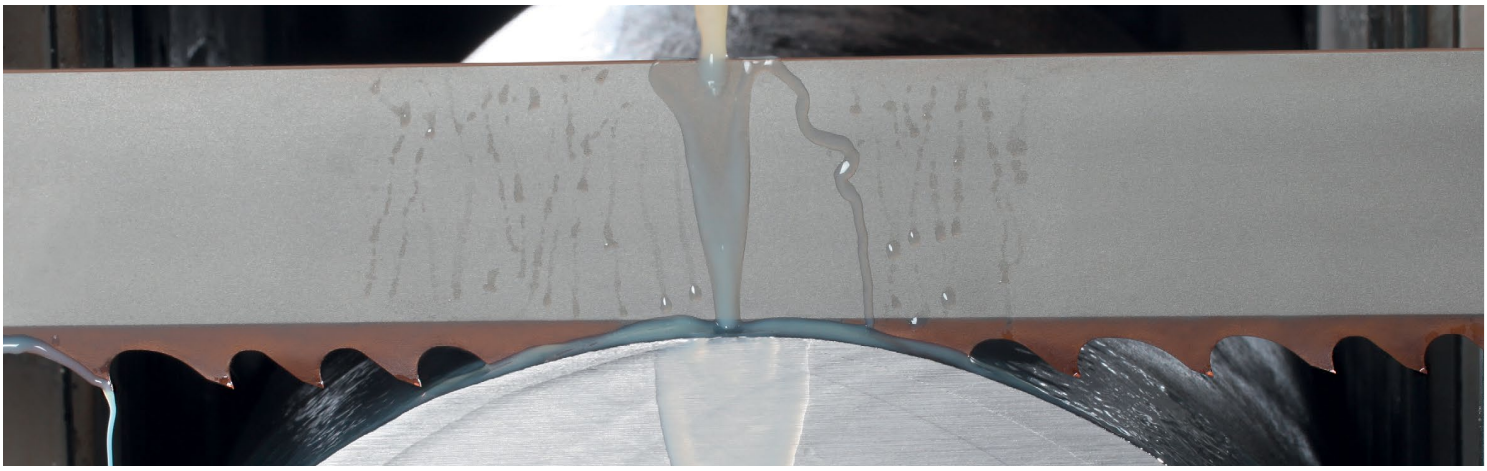
Application:
- All steels, suitable for forged and scaled surfaces
- Solid material and thick-walled tubes

Advantages:
- Higher blade life with even shorter cutting time
- Reduced cutting time expands available capacity

Features:
- Special hard material coating for steel cutting
- Extra back edge coating for lower friction

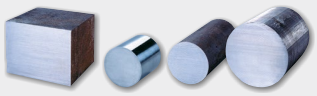
Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 2.5-3.4	1.8-2.5	1.4-1.8	1.0-1.4	0.7-1.0
34 x 1.10	1-3/8 x 0.042		K			
41 x 1.30	1-5/8 x 0.050		K			
54 x 1.60	2-1/8 x 0.063		K			
67 x 1.60	2-5/8 x 0.063			K	K	
80 x 1.60	3-1/8 x 0.063				K	K
Contact length (inch)		3.5-7.9	7.9-13.4	13.4-20.9	19.7-31.5	31.5-78.7

K = Hook tooth, Photo below: DUROSET® PREMIUM



FUTURA®

The high-performance bestseller band saw blade



Application:	• Structural, case-hardened, tempered and tool steels • Serial sections
Advantages:	• Outstanding cutting performance for increased productivity • High blade life due to optimal chip division
Features:	• Ground trapezoid tooth with positive rake angle • Patented chip division

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 3-4	2-3	1.7-2	1.4-2	1.2-1.6	1.0-1.4	0.85-1.15
27 x 0.90	1-1/16 x 0.035	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	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	T	
67 x 1.60	2-5/8 x 0.063		T	T	T	T	T	T
80 x 1.60	3-1/8 x 0.063				T		T	T
Contact length (inch)		3.5-5.9	5.1-9.8	7.9-11.8	9.8-15.7	13.8-23.6	19.7-31.5	27.6-47.2

FUTURA® PREMIUM

The high-performance bestseller band saw blade coated with hard material

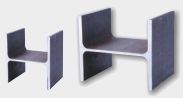
Application:	• Structural, case-hardened, tempered and tool steels • Serial sections
Advantages:	• Reduced cutting time expands available capacity • Enhanced reliability allows lights out operation • Reduction of noise emission
Features:	• Special hard material coating for steel cutting • Extra back edge coating for lower friction

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 3-4	2-3	1.7-2	1.4-2	1.2-1.6	1.0-1.4	0.85-1.15
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	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	T	
67 x 1.60	2-5/8 x 0.063		T	T	T	T	T	T
80 x 1.60	3-1/8 x 0.063				T		T	T
Contact length (inch)		3.5-5.9	5.1-9.8	7.9-11.8	9.8-15.7	13.8-23.6	19.7-31.5	27.6-47.2

T = Trapezoid tooth, Photo below: FUTURA® PREMIUM

PROFIDUR® 3

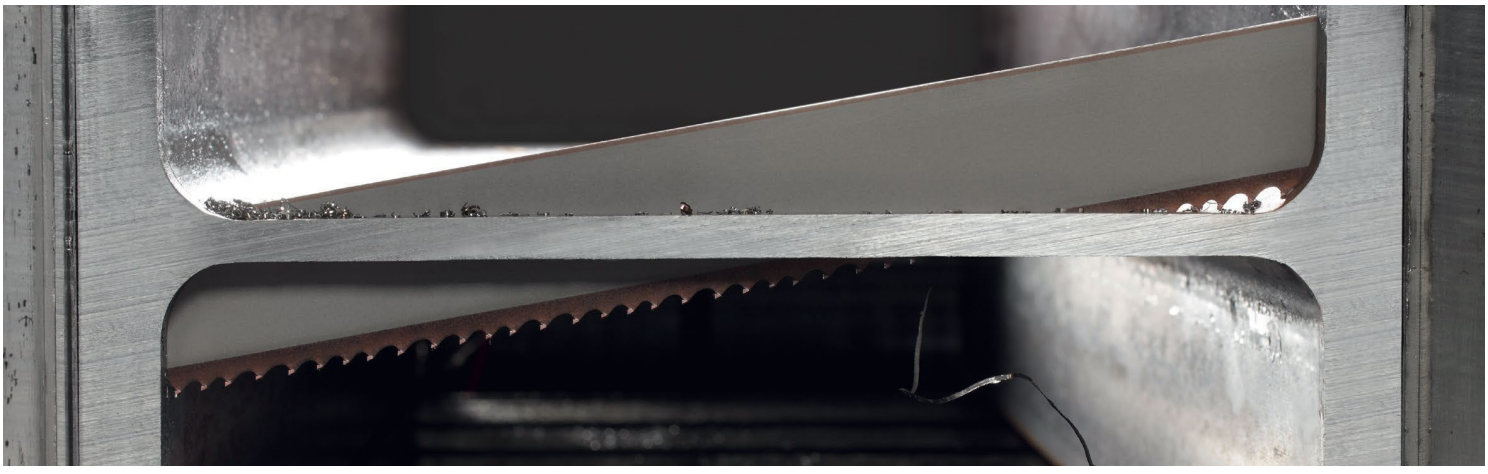
The coated professional for profiles



Application:	• Girders, beams and profiles • Perfect for industrial steel construction
Advantages:	• Capacity increase due to maximum cutting performance and blade life • Low burr and precise cuts • Considerable reduction of noise emission
Features:	• Patented tooth geometry for interrupted cutting channel • Sturdy carbide-tipped tooth edges coated with hard material

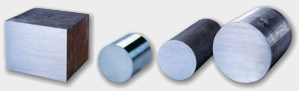
Dimensions Width x Thickness		Tooth pitch in tpi	
mm	Inch	3-4	2-3
54 x 1.30	2-1/8 x 0.050		T
54 x 1.60	2-1/8 x 0.063	T	T
67 x 1.60	2-5/8 x 0.063		T
Contact length (inch)		3.5-5.9	5.9-10.6

T = Trapezoid tooth



TAURUS®

The entry level, low-cost band saw blade with great features



Application:	• All steels and non-ferrous metals, solid material
Advantages:	• Low cost carbide-tipped band saw blade for universal use • Low finishing due to good surface quality • Suitable for machines without carbide package
Features:	• Innovative tooth geometry • Proven carbide cutting material

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 3-4	2-3	1.7-2	1.4-2	1.0-1.4	0.7-1.0
27 x 0.90	1-1/16 x 0.035	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	T		
54 x 1.30	2-1/8 x 0.050	T	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	T
Contact length (inch)		3.4-5.9	5.1-9.8	7.9-11.8	9.8-19.7	19.7-31.5	31.5-78.7

TAURUS® PREMIUM

The entry level coated carbide band saw blade

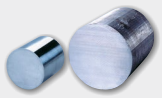
Application:	• All steels, solid material
Advantages:	• Perfect cutting performance and outstanding surface • Long lifetime reduces downtime • Low vibration and smooth running
Features:	• Carbide-tipped tooth edges coated with hard material • Extra back edge coating for lower friction

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 3-4	2-3	1.7-2	1.4-2	1.0-1.4	0.7-1.0
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	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		
67 x 1.60	2-5/8 x 0.063			T	T	T	
Contact length (inch)		3.4-5.9	5.1-9.8	7.9-11.8	9.8-19.7	19.7-31.5	31.5-78.7

T = Trapezoid tooth, Photo below: TAURUS®

FUTURA® VA

The high-performance bestseller for stainless steels



Application:	• All rust- and acid-resistant steels, titanium and titanium alloys • Serial sections
Advantages:	• Optimal chip formation and perfect surface quality • Good cutting performance for reduced cutting time • Good blade life reduces setup and downtime
Features:	• Tooth edges made of specific carbide • Ground trapezoid tooth with extra positive rake angle • Optimal chip division for tough and high-strength materials

Dimensions Width x Thickness		Tooth pitch in tpi				
mm	Inch	3-4	2-3	1.4-2	1.0-1.4	0.85-1.15
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	T		
54 x 1.60	2-1/8 x 0.063		T	T		
67 x 1.60	2-5/8 x 0.063			T		
Contact length (inch)		3.4-5.9	5.1-9.8	9.8-19.7	19.7-31.5	27.6-47.2

FUTURA® PREMIUM VA

The high-performance bestseller with hard material coating for stainless steels

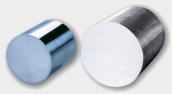
Application:	• All rust- and acid-resistant steels, titanium and titanium alloys • Serial sections
Advantages:	• Outstanding cutting performance to reduce bottlenecks • Reliable cutting of large stainless steel cross sections • Smooth and low vibration
Features:	• Special hard material coating for cutting stainless steels • Extra back edge coating for lower friction

Dimensions Width x Thickness		Tooth pitch in tpi				
mm	Inch	3-4	2-3	1.4-2	1.0-1.4	0.85-1.15
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		
67 x 1.60	2-5/8 x 0.063			T	T	
80 x 1.60	3-1/8 x 0.063				T	T
Contact length (inch)		3.4-5.9	5.1-9.8	9.8-19.7	19.7-31.5	27.6-47.2

T = Trapezoid tooth, Photo below: FUTURA® PREMIUM VA

FUTURA® 718 ③

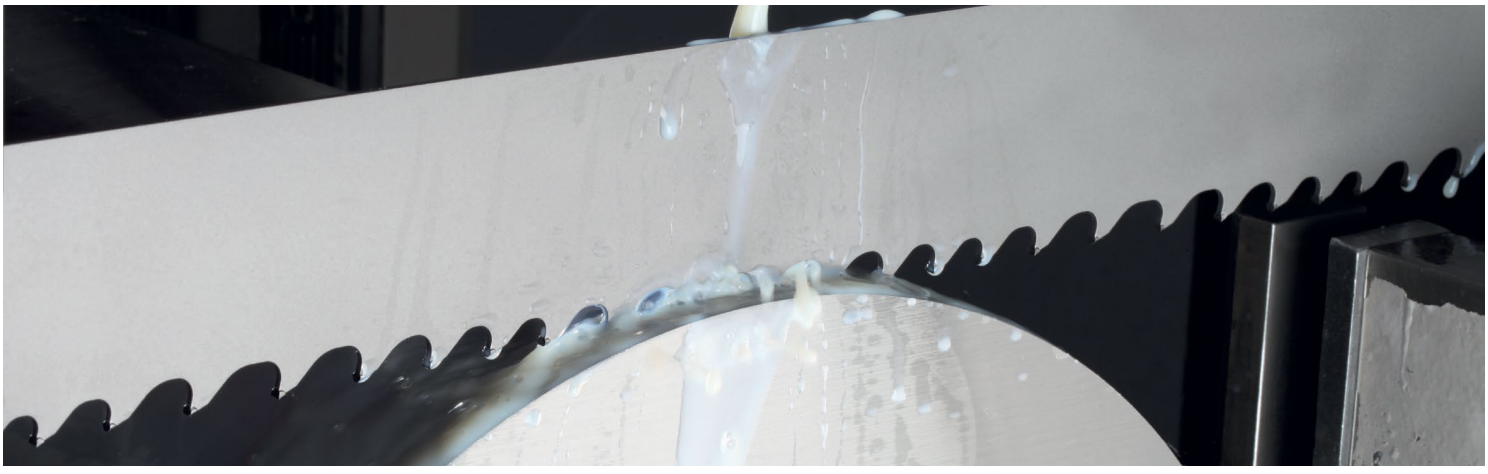
The best band saw blade for nickel-base alloys



Application:	• Solid difficult to cut steels • Nickel-base alloys • Heat-resistant, highly heat resisting and Duplex steels
Advantages:	• Outstanding cutting performance for extremely difficult to cut materials • Longe blade life when cutting high abrasive materials • Low material loss due to excellent run-in • Excellent cutting surface quality reduces finishing
Features:	• Tooth edges made of optimal carbide for high-strength tough materials • Perfectly ground trapezoid teeth with optimal geometry • Backing material with special shape forming

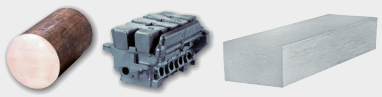
Dimensions Width x Thickness		Tooth pitch in tpi		
mm	Inch	2-3	1.4-2	1.0-1.4
41 x 1.30	1-5/8 x 0.050	T		
54 x 1.30	2-1/8 x 0.050	T	T	
54 x 1.60	2-1/8 x 0.063	T	T	
67 x 1.60	2-5/8 x 0.063		T	T
80 x 1.60	3-1/8 x 0.063			T
Contact length (inch)		5.1-9.8	9.8-19.7	19.7-31.5

T = Trapezoid tooth



ECODUR®

The low-cost band saw blade for non-ferrous foundries

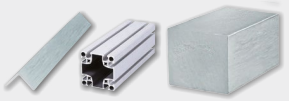


Application:	• For cutting gates and risers on non-ferrous castings • Aluminum and aluminum alloys in solid material or profiles • Copper and copper alloys in solid material or profiles
Advantages:	• Productivity increase due to short cutting times • Low finishing due to perfect surface quality
Features:	• Tooth edges made of specific carbide to prevent abrasive wear • Ground trapezoid tooth with positive rake angle • Patented chip division for performance and cutting surface quality

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 3-4	2-3	1.4-2	0.85-1.15
13 x 0.80	1/2 x 0.032	T			
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
Contact length (inch)		3.4-5.9	5.1-9.8	9.8-19.7	27.6-47.2

DUROSET® NE

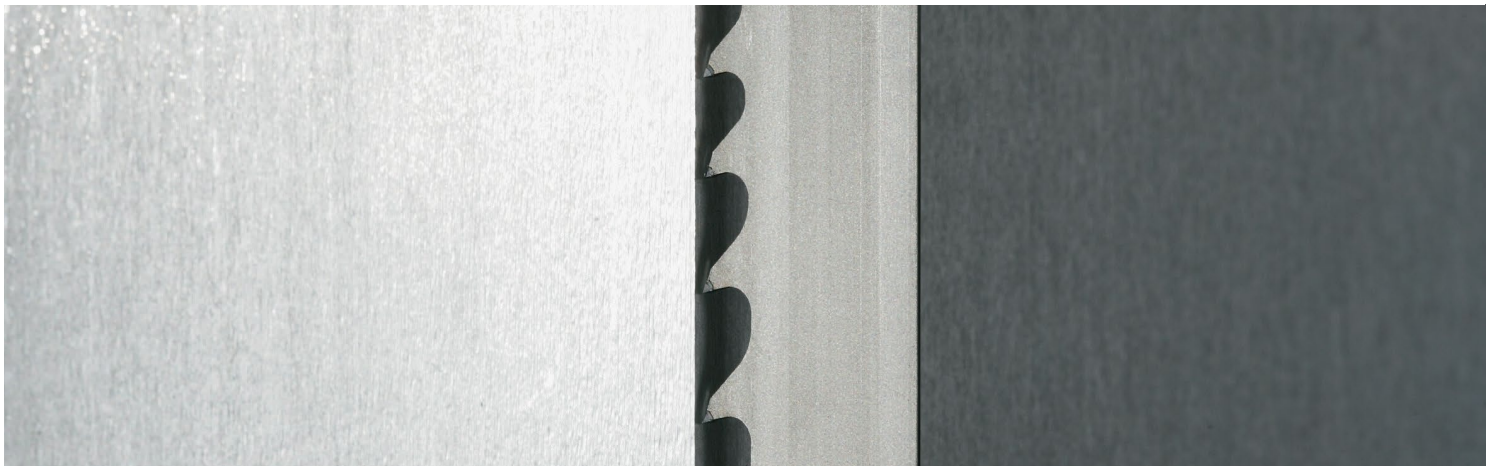
The set special design for non-ferrous metals



Application:	• Contour and radius cuts on non-ferrous metals • Automatic and manual feed
Advantages:	• High cutting performance increases productivity • High blade-life even in varying conditions
Features:	• Extra wide set • Ground trapezoid tooth with positive rake angle • Tooth edges made of specific carbide to prevent abrasion

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 3	2
20 x 0.90	3/4 x 0.035	K	
27 x 0.90	1-1/16 x 0.035	K	
34 x 1.10	1-3/8 x 0.042	K	K
Contact length (inch)		4.7-7.9	7.9-15.7

T = Trapezoid tooth, K = Hook tooth, Photo below: ECODUR®



FUTURA® NE

The high-performance bestseller for non-ferrous metals

Application:	• Aluminum mold and die castings, aluminum ingots and aluminum milling products • Copper and copper alloys
Advantages:	• Short cycle time and outstanding productivity due to high cutting performance • Low material waste due to optimal surface quality • Process reliability by high resistance against abrasion
Features:	• Tooth edges made of specific carbide to prevent abrasion • Ground trapezoid tooth with positive rake angle • Optimal chip division for performance and surface quality

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 3-4	2-3	1.4-2	0.85-1.15	0.7-1.0
27 x 0.90	1-1/16 x 0.035	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		
54 X 1.30	2-1/8 x 0.050			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		
80 x 1.60	3-1/8 x 0.063				T	T
Contact length (inch)		3.4-5.9	5.1-9.8	9.8-19.7	27.6-47.2	31.5-78.7

FUTURA® NE RS

The high-performance bestseller with reduced kerf loss for non-ferrous metals

Application:	• Cutting of aluminum ingots, aluminum plate production
Advantages:	• Extreme cutting performance due to reduced cutting volume • Optimized ingot output due to reduced offcut • Perfect cutting surface for lower finishing
Features:	• Special grinding for reduced kerf width • Ground trapezoid tooth with positive rake angle • Optimal chip division for performance and surface quality

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 3-4	2-3	1.4-2	0.85-1.15	0.7-1.0
41 x 1.30	1-5/8 x 0.050			T		
54 x 1.30	2-1/8 x 0.050			T		
54 x 1.60	2-1/8 x 0.063				T	T
80 x 1.10	3-1/8 x 0.042			T		T
Contact length (inch)		3.4-5.9	5.1-9.8	9.8-19.7	27.6-47.2	31.5-78.7

T = Trapezoid tooth, Photo below: FUTURA® NE

ARION® FG

The premium class of band sawing

Application:
- Solid materials, structural, case-hardened and tempered steels
- Large-scale production and mass cuts on heavy duty sawing machines

Advantages:
- Highest productivity due to maximum cutting performance
- Low material loss due to thin-cutting technology
- Excellent efficiency due to high blade life
- Precise flatness of the cutting surface

Features:
- Carbide-tipped tooth edge with extreme wear-resistant hard material coating
- Ground trapezoid tooth (FUTURA® geometry)
- Thin-cutting technology with extraordinary blade stability

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 3-4	2-3	1.7-2	1.4-2	1.0-1.4	0.7-1.0
54 x 1.10	2-1/8 x 0.042	T	T	T	T		
67 x 1.10	2-5/8 x 0.042	T	T	T	T	T	
80 x 1.10	3-1/8 x 0.042		T		T	T	
100 x 1.10	4 x 0.042		T		T	T	T
Contact length (inch)		3.4-5.9	5.1-9.8	7.9-11.8	9.8-19.7	19.7-31.5	31.5-78.7

ARION® PG

High-performance for tubes and profiles

Application:
- Thick-walled tubes and profiles, structural, case-hardened and tempered steels
- Large-scale and mass production on heavy-duty sawing machines

Advantages:
- Extremely straight and low-burr cutting surfaces
- Maximum productivity with interrupted cutting channel
- Low material loss due to thin-cutting technology
- Outstanding efficiency due to high blade life

Features:
- Newly developed coated cutting material
- Extremely sturdy, ground trapezoid tooth (PROFIDUR® geometry)
- Thin-cutting technology with extremely high blade stability

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 3-4	2-3	1.7-2	1.4-2	1.0-1.4	0.7-1.0
54 x 1.10	2-1/8 x 0.042	T	T				
67 x 1.10	2-5/8 x 0.042	T	T				
Contact length (inch)		3.4-5.9	5.1-9.8	7.9-11.8	9.8-19.7	19.7-31.5	31.5-78.7

T = Trapezoid tooth, Photo below: ARION® FG

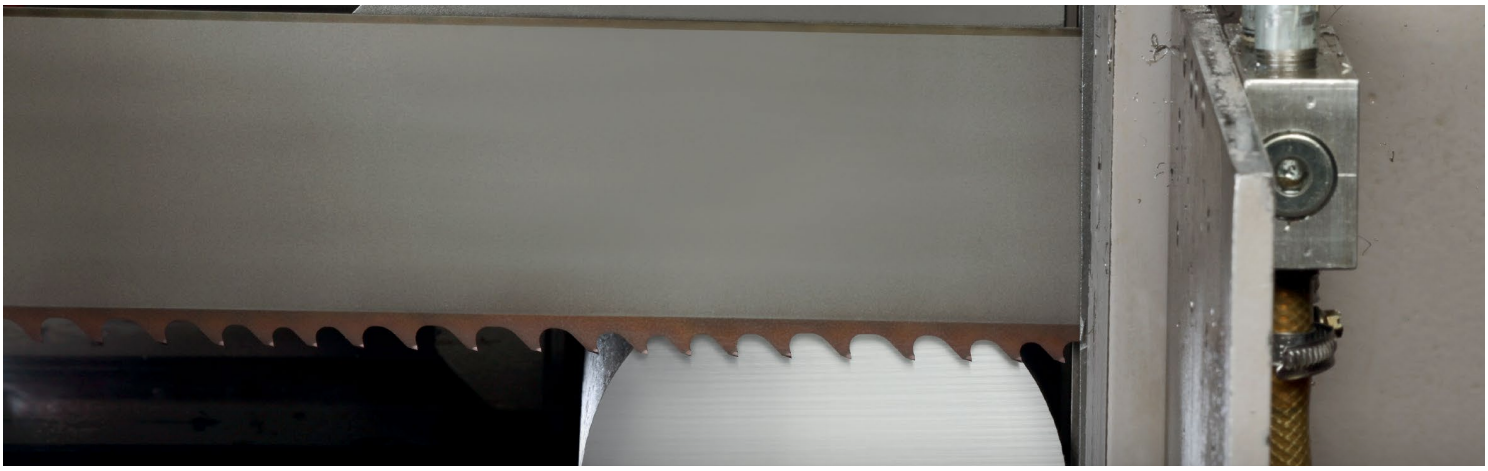
ARION® EG

High performance and excellent surface quality

Application:	• Solid materials on heavy-duty sawing machines • Large-scale and mass production for steel trade • Structural, case-hardened and tempered steels
Advantages:	• Excellent surface quality • Highest productivity due to maximum cutting performance • Lower material loss due to thin-cutting technology • Outstanding efficiency due to high blade life
Features:	• Carbide-tipped tooth edge with extreme wear-resistant hard material coating • Ground trapezoid tooth (ECODUR® geometry) • Thin-cutting technology with extremely high blade stability

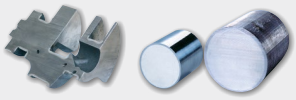
Dimensions Width x Thickness		Tooth pitch in tpi					
mm	Inch	3-4	2-3	1.7-2	1.4-2	1.0-1.4	0.7-1.0
54 x 1.10	2-1/8 x 0.042	T	T				
67 x 1.10	2-5/8 x 0.042	T	T		T		
80 x 1.10	3-1/8 x 0.042		T		T	T	
100 x 1.10	4 x 0.042		T		T	T	T
Contact length (inch)		3.4-5.9	5.1-9.8	7.9-11.8	9.8-19.7	19.7-31.5	31.5-78.7

T = Trapezoid tooth



FUTURA® SN

The specialist for "hard shell and soft core"



Application:
- Case-hardened components and hard chrome plated workpieces
- Hardened steels up to 65 HRC, Manganese high carbon steel

Advantages:
- Hardened materials machined by cutting
- Good cutting rates and good surface quality
- Increased efficiency due to high blade life

Features:
- Optimized special geometry with negative rake angle
- Ground trapezoid tooth without set

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 3-4	2-3
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
67 x 1.60	2-5/8 x 0.063		TSN
Contact length (inch)		0.8-5.9	5.1-7.9

FUTURA® PREMIUM SN

The specialist with hard material coating for hardest cases

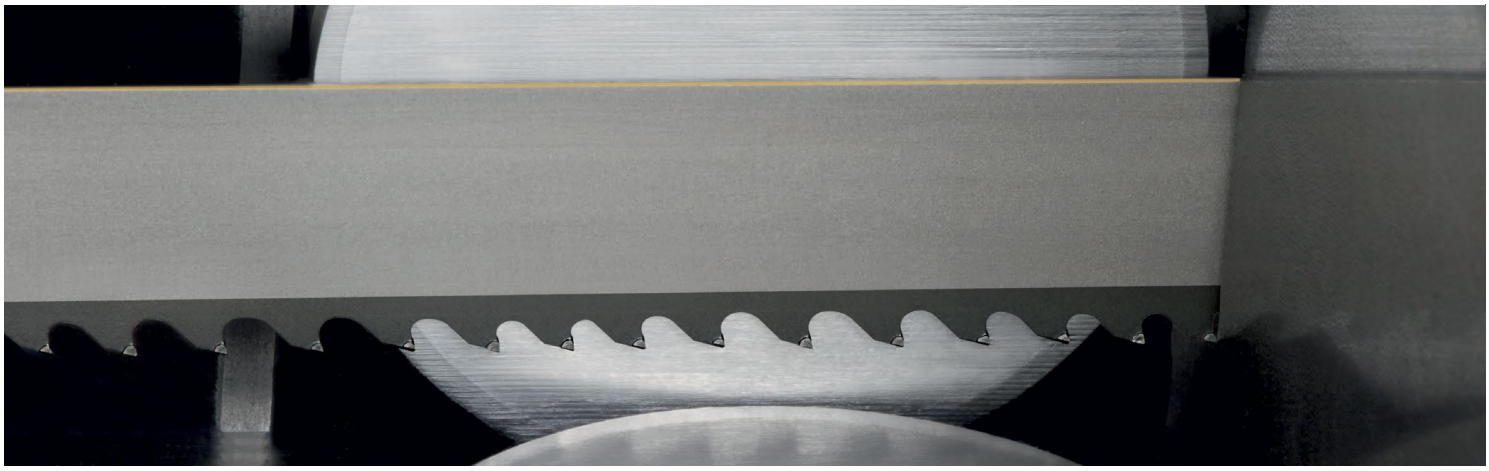
Application:
- Induction hardened and hard chrome plated workpieces
- Hardened steels up to 65 HRC, Manganese steel

Advantages:
- Considerable increase of blade life
- High cutting performance for efficiency increase
- Excellent surface quality

Features:
- Carbide-tipped tooth edges coated with high-strength hard material
- Optimized special geometry with negative rake angle
- Extra back edge coating for lower friction

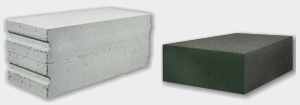
Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 3-4	2-3
27 x 0.90	1-1/16 x 0.035	TSN	
34 x 1.10	1-3/8 x 0.042	TSN	
41 x 1.30	1-5/8 x 0.050	TSN	TSN
Contact length (inch)		0.8-5.9	5.1-7.9

TSN = Tooth shape TSN, Photo below: FUTURA® PREMIUM SN



TCT®

The band saw blade for mineral materials



Application:
- Aerated concrete, graphite
- Insulation materials such as glass and rock wool
- Glass and carbon fibre reinforced plastic

Advantages:
- Excellent stability against abrasive wear
- Usable without cooling lubricant

Features:
- Carbide-tipped tooth edges with excellent wear resistance
- Precisely set tooth geometry
- Constant tooth pitch

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 4	3	2	1.25
13 x 0.80	1/2 x 0.032	S			
20 x 0.80	3/4 x 0.032	S	K		
27 x 0.90	1-1/16 x 0.035	S	S, K	S, K	
34 x 1.10	1-3/8 x 0.042		S, K	K	
41 x 1.30	1-5/8 x 0.050		K	K	K
Contact length (inch)		3.1-4.7	4.7-7.9	7.9-15.7	11.8-31.5

TCTYRE®

The special band saw blade for tires and rubber / metal composites

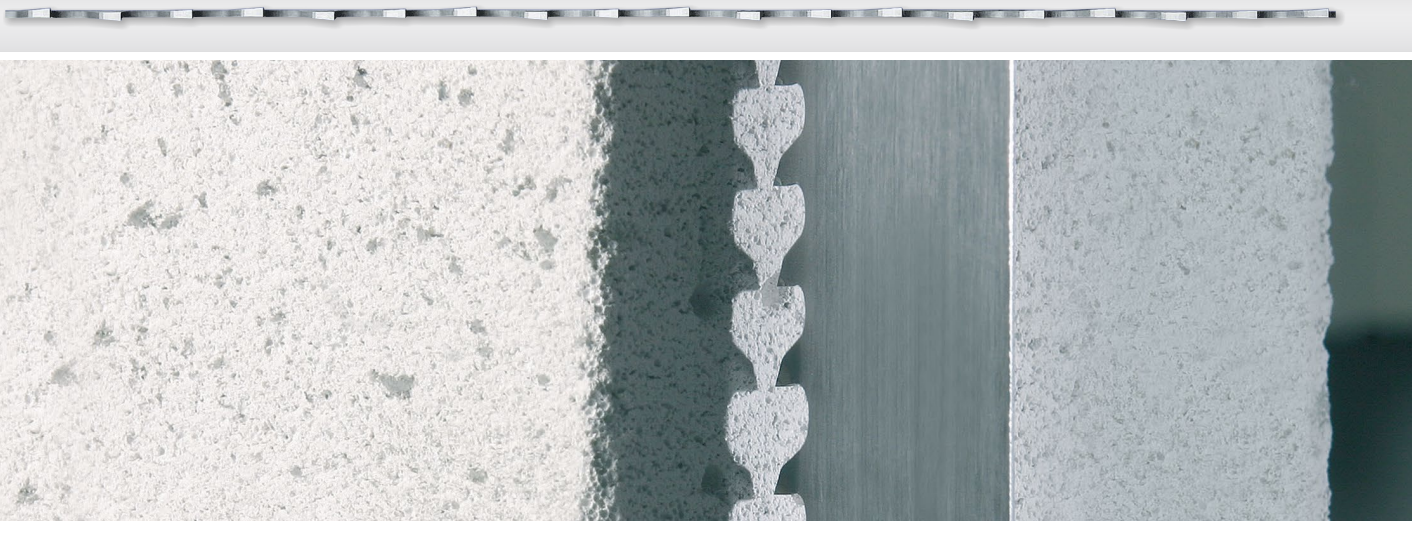
Application:
- For quality analysis of tires of all kinds
- Economic cutting of rubber composite materials

Advantages:
- Significantly reduced cutting force due to specific cutting edge
- Good cutting surface for immediate analysis
- Long blade life even with very large tires

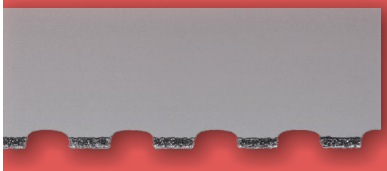
Features:
- Carbide cutting edge with high wear resistance
- Custom cutting geometry for rubber composite material

Dimensions Width x Thickness mm	Inch	Tooth pitch in tpi 3-4	2-3
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 1.30	2-1/8 x 0.050		T
54 x 1.60	2-1/8 x 0.063		T
Contact length (inch)		3.5-5.9	5.9-10.6

S = Standard tooth, K = Hook tooth, T = Trapezoid tooth, Photo below: TCT®



DIAMOND COATED BAND SAW BLADES



- As the hardest material known to man, diamonds are capable of cutting any material, including alloys.
- The unique properties of the backing materials developed for WIKUS are perfectly suited to withstand the stresses caused by these extremely high cutting speeds.
- Due to the rather unique applications of DIAGRIT®, we recommend that you contact us for advice on grain sizes to coordinate combinations of grain size and diameter of the blade to suit your application.
- The backing material of our complete DIAGRIT® program will be converted to specialized stainless steel.

Sales units:	Welded-to-length band saw blades
Band widths:	3/8 to 4 inches
Diamond coating:	Continuous (K), segmented (S), intermittent (U), with 1/4 to 1-1/8 inch pitch
Grain sizes:	D64, D91, D126, D151, D181, D252, D301, D356, D426, D501, D601, D711
Areas of application:	Glass, graphite, high-fired graphite, ceramic, silicon, concrete materials, carbon fibre reinforced plastic, sintered materials, virgin stone
Option:	Alternative band dimensions upon request

DIAGRIT® K

The continuously diamond coated band saw blade

Application:	• Glass, graphite, high-fired graphite, ceramic, silicon • Concrete materials, carbon fibre reinforced plastic, sintered materials, virgin stone • Small workpiece dimensions
Advantages:	• No chipping on the contour edges • Low finishing due to very good cutting surfaces
Features:	• Continuous diamond coating on the band edge • Backing material made of alloyed tempered steel

Dimensions Width x Thickness		Dimensions Width x Thickness		Dimensions Width x Thickness	
mm	Inch	mm	Inch	mm	Inch
10 x 0.50	3/8 x 0.020	27 x 0.70	1-1/16 x 0.028	54 x 1.10	2-1/8 x 0.042
13 x 0.50	1/2 x 0.020	27 x 0.90	1-1/16 x 0.035	67 x 0.70	2-5/8 x 0.028
13 x 0.65	1/2 x 0.025	34 x 1.10	1-3/8 x 0.042	80 x 0.90	3-1/8 x 0.035
16 x 0.50	5/8 x 0.020	41 x 0.50	1-5/8 x 0.020	80 x 1.10	3-1/8 x 0.042
20 x 0.50	3/4 x 0.020	41 x 0.80	1-5/8 x 0.032	100 x 0.90	4 x 0.035
20 x 0.80	3/4 x 0.032	41 x 1.30	1-5/8 x 0.050	100 x 1.10	4 x 0.042
27 x 0.50	1-1/16 x 0.020	50 x 0.90	2 x 0.035		

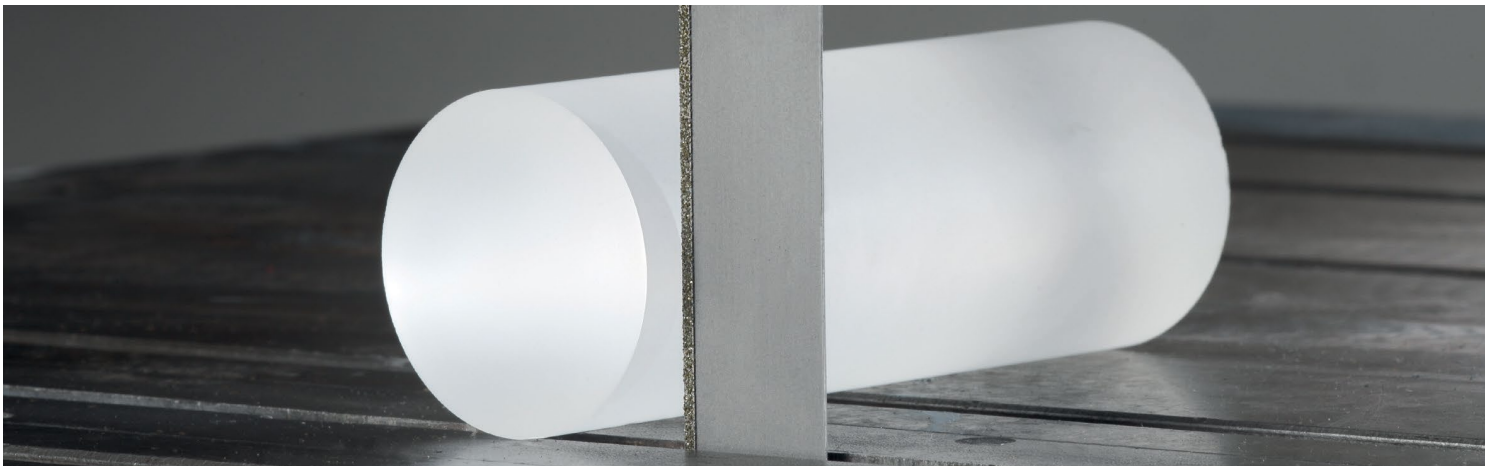
DIAGRIT® K VA

The continuously diamond coated band saw blade with stainless backing material

Application:	• Glass, graphite, high-fired graphite, ceramic, silicon • Concrete materials, carbon fibre reinforced plastic, sintered materials, virgin stone • Small workpiece dimensions
Advantages:	• Oil-free cooling lubricant usable • No corrosion of backing material during longer downtime • No chipping on the contour edges • Low finishing due to very good cutting surfaces
Features:	• Continuous diamond coating on the band edge • Backing material made of stainless special steel

Dimensions Width x Thickness		Dimensions Width x Thickness		Dimensions Width x Thickness	
mm	Inch	mm	Inch	mm	Inch
13 x 0.50	1/2 x 0.020	41 x 0.50	1-5/8 x 0.020	80 x 1.10	3-1/8 x 0.042
20 x 0.50	3/4 x 0.020	41 x 0.80	1-5/8 x 0.032	100 x 1.10	4 x 0.042
20 x 0.80	3/4 x 0.032	54 x 0.50	2-1/8 x 0.020		
27 x 0.50	1-1/16 x 0.020	60 x 0.50	2-1/3 x 0.020		

Alternative band dimensions upon request



DIAGRIT® S

The segmented diamond coated band saw blade

Application:
- Glass, graphite, high-fired graphite, ceramic, silicon
- Concrete materials, carbon fibre reinforced plastic, sintered materials, virgin stone
- Medium workpiece dimensions

Advantages:
- Higher cutting rate
- Individual coating geometry
- Low finishing due to good cutting surfaces

Features:
- Segmented diamond coating on the band edge
- Backing material made of alloyed tempered steel

Dimensions Width x Thickness		Dimensions Width x Thickness		Dimensions Width x Thickness	
mm	Inch	mm	Inch	mm	Inch
10 x 0.50	3/8 x 0.020	27 x 0.70	1-1/16 x 0.028	50 x 0.90	2 x 0.035
13 x 0.65	1/2 x 0.025	27 x 0.90	1-1/16 x 0.035	67 x 0.70	2-5/8 x 0.028
16 x 0.50	5/8 x 0.020	34 x 1.10	1-3/8 x 0.042	80 x 0.90	3-1/8 x 0.035
20 x 0.50	3/4 x 0.020	41 x 0.50	1-5/8 x 0.020	80 x 1.10	3-1/8 x 0.042
20 x 0.80	3/4 x 0.032	41 x 0.80	1-5/8 x 0.032	100 x 0.90	4 x 0.035
27 x 0.50	1-1/16 x 0.020	41 x 1.30	1-5/8 x 0.050	100 x 1.10	4 x 0.042

DIAGRIT® S VA

The segmented diamond coated band saw blade with stainless backing material

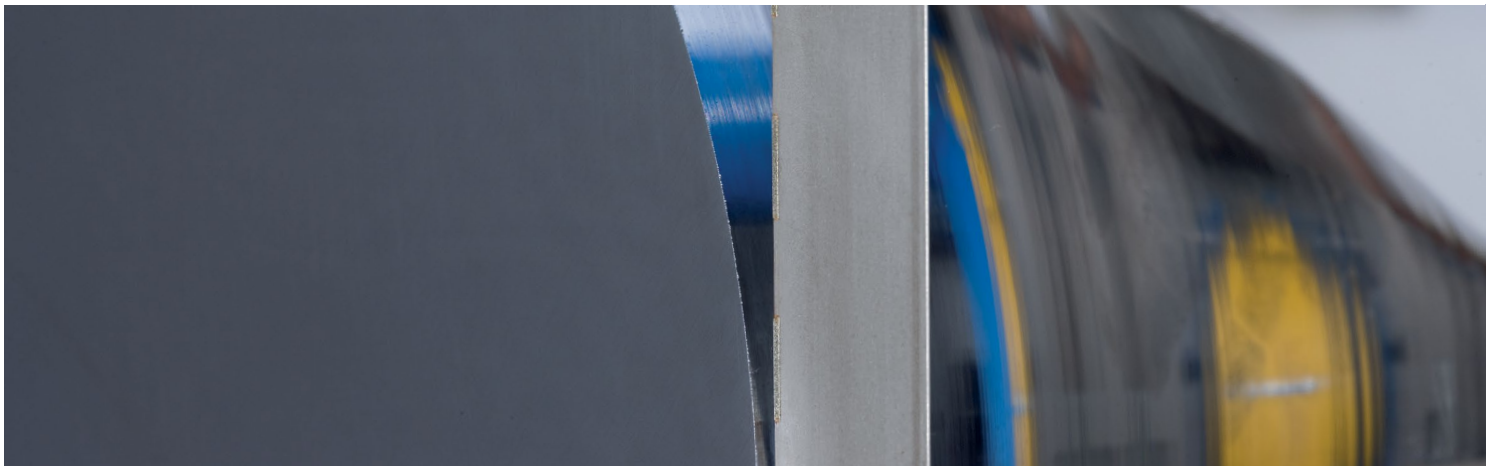
Application:
- Glass, graphite, high-fired graphite, ceramic, silicon
- Concrete materials, carbon fibre reinforced plastic, sintered materials, virgin stone
- Medium workpiece dimensions

Advantages:
- Oil-free cooling lubricant usable
- No corrosion of backing material during longer downtime
- Higher cutting rate
- Individual coating geometry

Features:
- Segmented diamond coating on the band edge
- Backing material made of stainless special steel

Dimensions Width x Thickness		Dimensions Width x Thickness		Dimensions Width x Thickness	
mm	Inch	mm	Inch	mm	Inch
13 x 0.50	1/2 x 0.020	41 x 0.50	1-5/8 x 0.020	80 x 1.10	3-1/8 x 0.042
20 x 0.50	3/4 x 0.020	41 x 0.80	1-5/8 x 0.032	100 x 1.10	4 x 0.042
27 x 0.50	1-1/16 x 0.020	60 x 0.50	2-1/3 x 0.020		

Alternative band dimensions upon request



DIAGRIT® U

The toothed diamond coated band saw blade

Application:
- Glass, graphite, high-fired graphite, ceramic, silicon
- Concrete materials, carbon fibre reinforced plastic, sintered materials, virgin stone
- Large workpiece dimensions

Advantages:
- Large gullet for material chipping
- Individual segment geometry (special tooth)
- Short cutting time due to excellent cutting rate

Features:
- Protruding segments with diamond coating in different distances
- Backing material made of alloyed tempered steel

Dimensions Width x Thickness		Pitch T	Dimensions Width x Thickness		Pitch T	Dimensions Width x Thickness		Pitch T
mm	Inch	mm	mm	Inch	mm	mm	Inch	mm
10 x 0.50	3/8 x 0.020	6	27 x 0.70	1-1/16 x 0.028	30	54 x 1.10	2-1/8 x 0.042	20
13 x 0.50	1/2 x 0.020	8	27 x 0.90	1-1/16 x 0.035	12	67 x 1.60	2-5/8 x 0.063	30
13 x 0.65	1/2 x 0.025	8	34 x 1.10	1-3/8 x 0.042	20	80 x 1.10	3-1/8 x 0.042	12
16 x 0.50	5/8 x 0.020	8	41 x 0.50	1-5/8 x 0.020	20	100 x 0.90	4 x 0.035	12
20 x 0.80	3/4 x 0.032	8	41 x 0.80	1-5/8 x 0.032	20	100 x 1.10	4 x 0.042	12
27 x 0.50	1-1/16 x 0.020	12	41 x 1.30	1-5/8 x 0.050	20	100 x 1.10	4 x 0.042	30
27 x 0.70	1-1/16 x 0.028	12	50 x 0.90	2 x 0.035	20			

DIAGRIT® U VA

The toothed diamond coated band saw blade with stainless backing material

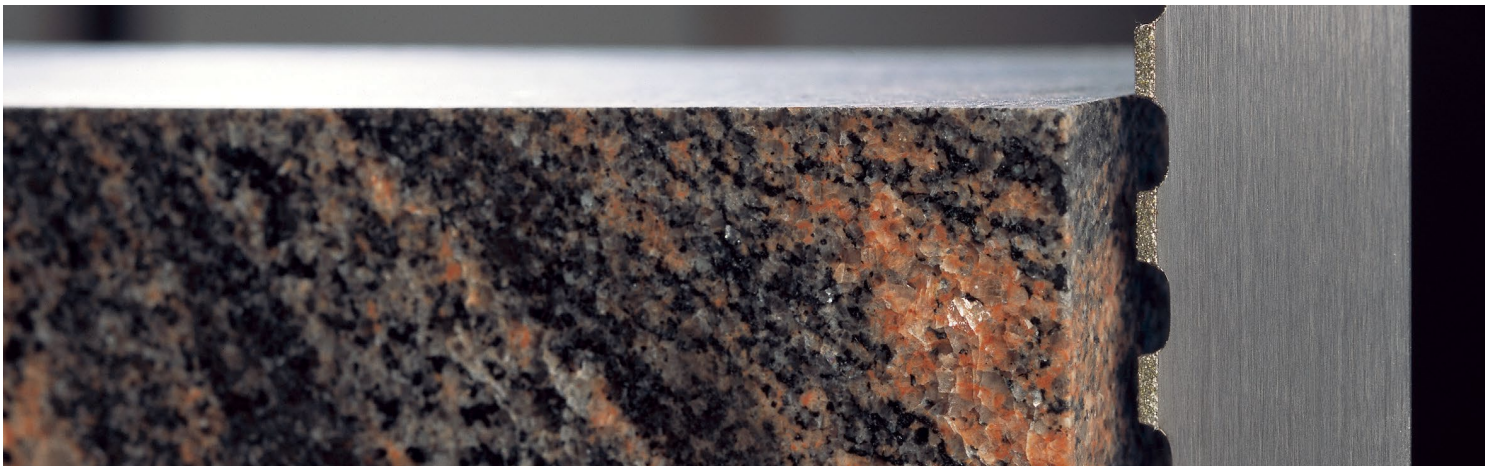
Application:
- Large workpiece dimensions
- Concrete materials, carbon fibre reinforced plastic, sintered materials, virgin stone
- Glass, graphite, high-fired graphite, ceramic, silicon

Advantages:
- Suitable for oil-free cooling lubricant
- No corrosion of backing material during longer downtime
- Large gullet for material chipping
- Short cutting time due to excellent cutting rate

Features:
- Protruding segments with diamond coating in different distances
- Backing material made of stainless special steel

Dimensions Width x Thickness		Pitch T	Dimensions Width x Thickness		Pitch T	Dimensions Width x Thickness		Pitch T
mm	Inch	mm	mm	Inch	mm	mm	Inch	mm
20 x 0.50	3/4 x 0.020	8	80 x 1.10	3-1/8 x 0.042	12	100 x 1.10	4 x 0.042	30
41 x 0.50	1-5/8 x 0.020	20	80 x 1.10	3-1/8 x 0.042	30			
41 x 0.80	1-5/8 x 0.032	20	100 x 1.10	4 x 0.042	12			

Alternative band dimensions upon request



CBN-COATED BAND SAW BLADES

- WIKUS expands its portfolio of the coated band saw blades by introducing a new product CUBOGRIT®. CUBOGRIT® uses cubic boron nitride (CBN) as its cutting material. Cubic boron nitride is the second hardest material known. In addition to a high hardness and strength, CBN has excellent thermal and chemical resistance properties.
- The unique properties of the backing materials developed for WIKUS are perfectly suited to stand up to the stress these extremely high cutting speeds cause.
- We are available to advise you on the possible combinations of grain sizes, band saw blade dimensions and operating conditions for optimal and efficient use of CUBOGRIT®. Our technical experts will gladly get in contact with you.

Sales units:	Welded-to-length band saw blades
Band widths:	3/8 to 4 inches
CBN-coating:	Continuous (K), segmented (S), intermittent (U), with 1/4 to 1-1/8 inch pitch
Grain sizes:	B91, B126, B252, B602, Alternative grain sizes upon request
Areas of application:	Hardened high speed steel (HSS), high-alloy tool steels > 55 HRC, case-hardened steels, iron-based powder coatings, chilled casting, stellite, nickel-based superalloys
Option:	Alternative band dimensions upon request

NEW: CUBOGRIT® K

The continuously CBN-coated band saw blade

Application:	• Hardened high speed steel (HSS), case-hardened steels • High-alloy tool steels > 55 HRC • Iron-based powder coatings, chilled casting, stellite • Small workpiece dimensions
Advantages:	• No chipping at the edge of the contours • Low reworking due to very good cutting surfaces
Features:	• Complete CBN-coating at the band edge • Backing material made of tempered alloy steel

Dimensions Width x Thickness		Dimensions Width x Thickness		Dimensions Width x Thickness	
mm	Inch	mm	Inch	mm	Inch
10 x 0.50	3/8 x 0.020	27 x 0.70	1-1/16 x 0.028	54 x 1.10	2-1/8 x 0.042
13 x 0.50	1/2 x 0.020	27 x 0.90	1-1/16 x 0.035	67 x 0.70	2-5/8 x 0.028
13 x 0.65	1/2 x 0.025	34 x 1.10	1-3/8 x 0.042	80 x 0.90	3-1/8 x 0.035
16 x 0.50	5/8 x 0.020	41 x 0.50	1-5/8 x 0.020	80 x 1.10	3-1/8 x 0.042
20 x 0.50	3/4 x 0.020	41 x 0.80	1-5/8 x 0.032	100 x 0.90	4 x 0.035
20 x 0.80	3/4 x 0.032	41 x 1.30	1-5/8 x 0.050	100 x 1.10	4 x 0.042
27 x 0.50	1-1/16 x 0.020	50 x 0.90	2 x 0.035		

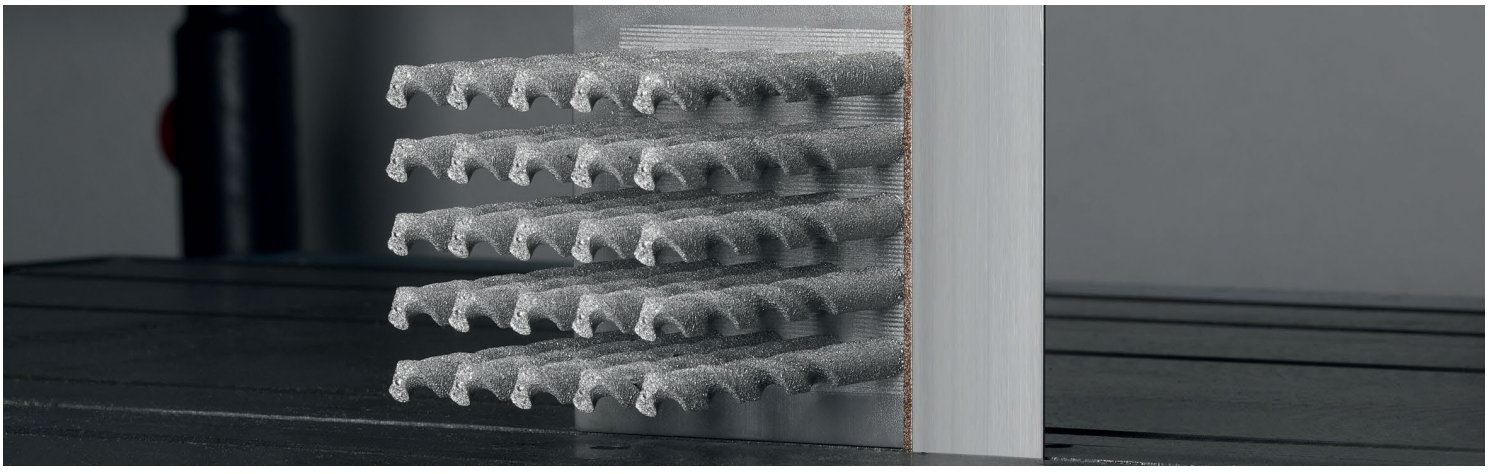
CUBOGRIT® K variant **CUBOGRIT® K VA** is available with a special corrosion-resistant steel backing material. This version offers the following advantages:

- Cooling with pure water
- No corrosion of backing material during longer downtime

We are available to advise you on the possible combinations of grain sizes, band saw blade dimensions and operating conditions in order to achieve optimal and efficient results in you sawing application using CUBOGRIT®. Our technical experts will gladly get in contact with you.

Machine requirements:

- Cutting speed higher than 3937 ft/min
- High machine stability
- High torque drive engine



NEW: CUBOGRIT® S ②

The segmented CBN-coated band saw blade

Application:	• Hardened high speed steel (HSS), case-hardened steels • High-alloy tool steels > 55 HRC • Iron-based powder coatings, chilled casting, stellite • Medium workpiece dimensions
Advantages:	• High cutting performance • Individual design of the coating geometry • Low reworking due to very good cutting surfaces
Features:	• Segmented CBN-coating at the band edge • Backing material made of tempered alloy steel

Dimensions Width x Thickness		Dimensions Width x Thickness		Dimensions Width x Thickness	
mm	Inch	mm	Inch	mm	Inch
10 x 0.50	3/8 x 0.020	27 x 0.70	1-1/16 x 0.028	50 x 0.90	2 x 0.035
13 x 0.65	1/2 x 0.025	27 x 0.90	1-1/16 x 0.035	67 x 0.70	2-5/8 x 0.028
16 x 0.50	5/8 x 0.020	34 x 1.10	1-3/8 x 0.042	80 x 0.90	3-1/8 x 0.035
20 x 0.50	3/4 x 0.020	41 x 0.50	1-5/8 x 0.020	80 x 1.10	3-1/8 x 0.042
20 x 0.80	3/4 x 0.032	41 x 0.80	1-5/8 x 0.032	100 x 0.90	4 x 0.035
27 x 0.50	1-1/16 x 0.020	41 x 1.30	1-5/8 x 0.050	100 x 1.10	4 x 0.042

CUBOGRIT® S variant **CUBOGRIT® S VA** is available with a special corrosion-resistant steel backing material. This version offers the following advantages:

- Cooling with pure water
- No corrosion of backing material during longer downtime

We are available to advise you on the possible combinations of grain sizes, band saw blade dimensions and operating conditions in order to achieve optimal and efficient results in you sawing application using CUBOGRIT®. Our technical experts will gladly get in contact with you.

Machine requirements:

- Cutting speed higher than 3937 ft/min
- High machine stability
- High torque drive engine

NEW: CUBOGRIT® U

The CBN-coated band saw blade with toothing

Application:	• Hardened high speed steel (HSS), case-hardened steels • High-alloy tool steels > 55 HRC • Iron-based powder coatings, chilled casting, stellite • Large workpiece dimensions
Advantages:	• Large chip space for material abrasion • Individual design of the segment geometry (special tooth) • Short cutting time due to high cutting performance
Features:	• Raised segments with CBN-coating with variable pitch • Backing material made of tempered alloy steel

Dimensions Width x Thickness		Pitch T	Dimensions Width x Thickness		Pitch T	Dimensions Width x Thickness		Pitch T
mm	Inch	mm	mm	Inch	mm	mm	Inch	mm
10 x 0.50	3/8 x 0.020	6	27 x 0.70	1-1/16 x 0.028	30	54 x 1.10	2-1/8 x 0.042	20
13 x 0.50	1/2 x 0.020	8	27 x 0.90	1-1/16 x 0.035	12	67 x 1.60	2-5/8 x 0.063	30
13 x 0.65	1/2 x 0.025	8	34 x 1.10	1-3/8 x 0.042	20	80 x 1.10	3-1/8 x 0.042	12
16 x 0.50	5/8 x 0.020	8	41 x 0.50	1-5/8 x 0.020	20	100 x 0.90	4 x 0.035	12
20 x 0.80	3/4 x 0.032	8	41 x 0.80	1-5/8 x 0.032	20	100 x 1.10	4 x 0.042	12
27 x 0.50	1-1/16 x 0.020	12	41 x 1.30	1-5/8 x 0.050	20	100 x 1.10	4 x 0.042	30
27 x 0.70	1-1/16 x 0.028	12	50 x 0.90	2 x 0.035	20			

CUBOGRIT® U variant **CUBOGRIT® U VA** is available with a special corrosion-resistant steel backing material. This version offers the following advantages:

- Cooling with pure water
- No corrosion of backing material during longer downtime

We are available to advise you on the possible combinations of grain sizes, band saw blade dimensions and operating conditions in order to achieve optimal and efficient results in you sawing application using CUBOGRIT®. Our technical experts will gladly get in contact with you.

Machine requirements:

- Cutting speed higher than 3937 ft/min
- High machine stability
- High torque drive engine

CARBIDE COATED BAND SAW BLADES

- Carbide coated band saw blades for cutting wire-reinforced tires, composite materials, case-hardened steels, glass fibre and graphite.
- The extremely durable band edge is suitable for wet and dry cutting.

Sales units:	Welded-to-length band saw blades
Band widths:	1/4 to 1-1/2 inch
Carbide coating:	Continuous (K), intermittent (U) with 1/2 to 9/16 inch pitch
Grain sizes:	TC181, TC301, TC356, TC525
Option:	Alternative band dimensions upon request

TCGRIT® K

The carbide coated saw band with continuous coating

Application:
- Cables and wires, composite materials, metal flex hoses
- Glass fibre and carbon fibre reinforced plastics (GRP / CRP)
- Small workpiece dimensions

Advantages:
- Long life due to high wear resistance
- Low rework due to high surface quality

Features:
- Continuously carbide coated
- Extremely durable band edge, suitable for wet and dry cutting

Dimensions Width x Thickness		Grain sizes		
mm	Inch	181	301	525
6 x 0.50	1/4 x 0.020		K	
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	
25 x 0.90	1-1/16 x 0.035			K
32 x 1.10	1-1/4 x 0.042			K

TCGRIT® U

The carbide coated saw band with discontinuous coating

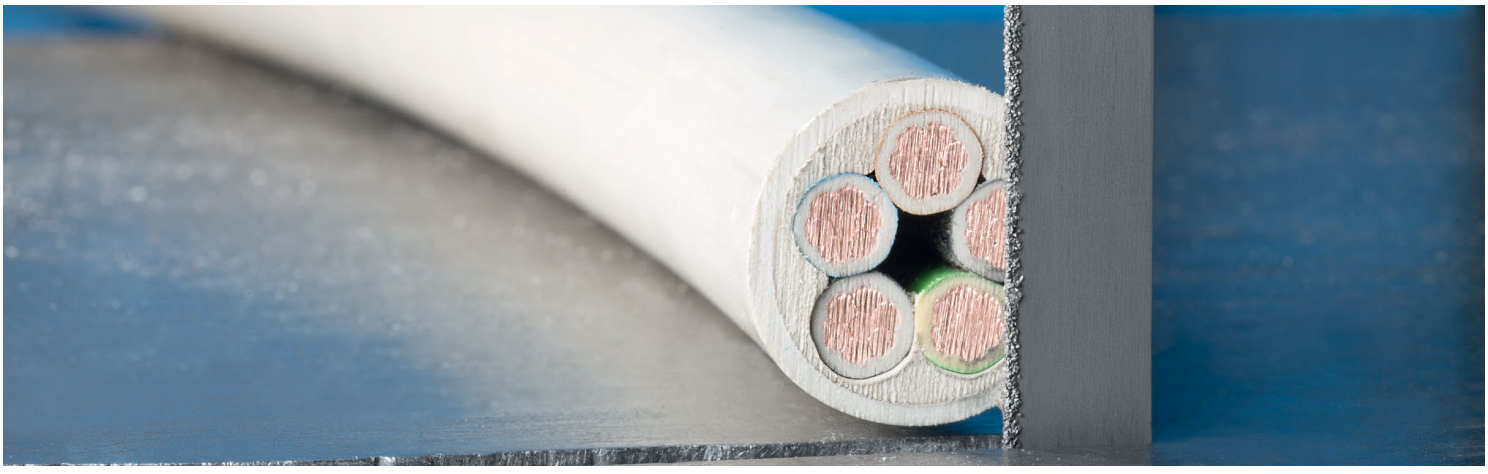
Application:
- Glass fibre and carbon fibre reinforced plastics (GRP / CRP)
- Abrasive construction materials, case-hardened steel, two-wheeler and car tires
- Larger workpiece dimensions

Advantages:
- Long life due to high wear resistance
- Low rework due to high surface quality

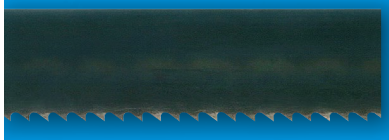
Features:
- Discontinuous carbide coated
- Extremely durable band edge, suitable for wet and dry cutting

Dimensions Width x Thickness		Grain sizes		
mm	Inch	301	356	525
10 x 0.65	3/8 x 0.025	U		
13 x 0.65	1/2 x 0.025	U		
20 x 0.80	3/4 x 0.032	U		
25 x 0.90	1 x 0.035		U	U
32 x 1.10	1-1/4 x 0.042			U
38 x 1.10	1-1/2 x 0.042			U

Photo below: TCGRIT® K



CARBON STEEL BAND SAW BLADES

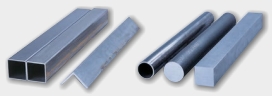


- Well suited for tasks that include everything from basic workshop operations to machining of composite materials
- Hardened tooth tips and an extremely flexible blade body ensure high reliability

Sales units:	• Coils in fixed lengths and manufacturing coils of up to 400 feet, depending on the width • Welded-to-length band saw blades
Band widths:	3/16 to 1 inch
Tooth shapes:	L, S, K See page 56 for explanations
Tooth pitches:	**Constant:** 24 to 3 teeth per inch (tpi) See page 57 for explanations
Types of tooth set:	SD, WS, GS See page 57 for explanations

DIAMANT 2

The band saw blade with increased blade stability



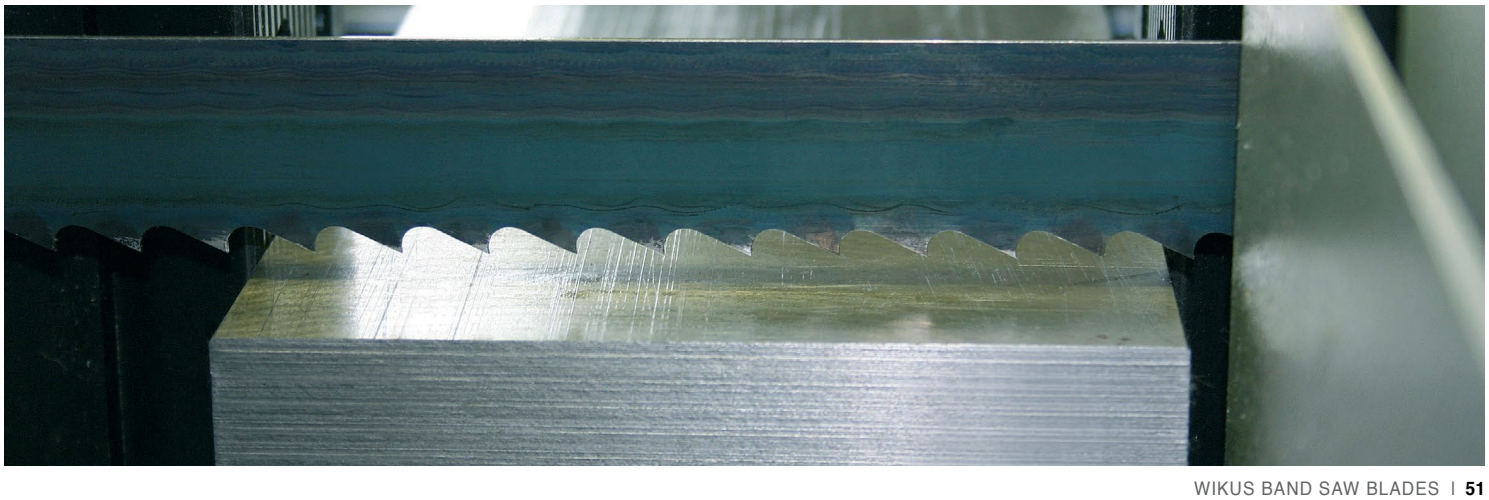
Application:
- Solid material, tubes and profiles up to medium cross-section
- Unalloyed steels with low strength, wood, non-ferrous metals
- Suitable for workshop use

Advantages:
- Superior straightness and surface quality
- Economic band saw blade
- Easy to weld

Features:
- Hardened tooth tips
- Quenched and tempered backing material made of flexible carbon steel
- Tooth shape: standard tooth (0°) and hook tooth (positive rake angle)

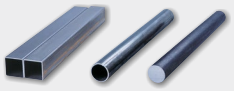
Dimensions Width x Thickness		Tooth pitch in tpi SD							
mm	Inch	24	18	14	10	8	6	4	3
5 x 0.40	3/16 x 0.016	S		S					
5 x 0.65	3/16 x 0.025	S		S	S				
6 x 0.40	1/4 x 0.016						K		
6 x 0.65	1/4 x 0.025	S	S	S	S	S	S,K	K	
8 x 0.65	5/16 x 0.025		S	S	S	S	S,K	K	
10 x 0.65	3/8 x 0.025	S		S	S	S	S,K	K	K
13 x 0.65	1/2 x 0.025	S		S	S	S	S,K	S,K	K
16 x 0.50	5/8 x 0.020			S					
16 x 0.65	5/8 x 0.025			S		S	K	K	K
16 x 0.80	5/8 x 0.032			S			K	K	K
20 x 0.80	3/4 x 0.032			S	S	S	K	K	K
25 x 0.90	1 x 0.035				S		S	S,K	K

S = Standard tooth, K = Hook tooth
Please use the table on page 54 to determine the contact length.



EXTRA 1

The domestic use band saw blade



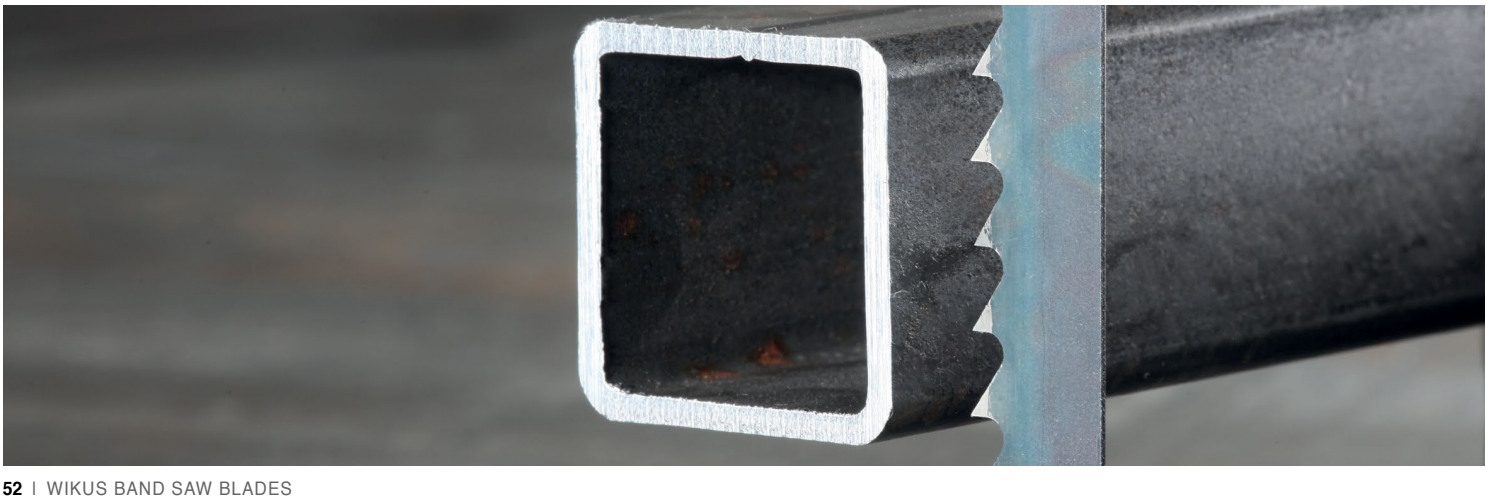
Application:
- Solid material, tubes and profiles with small cross-section
- Unalloyed steels with lower strength, wood, non-ferrous metals
- Suitable for home handyman and small workshops

Advantages:
- Economic band saw blade
- Easy to weld

Features:
- Hardened tooth tips
- Backing material made of flexible carbon steel
- Tooth shape: standard and skip tooth with rake angle 0°

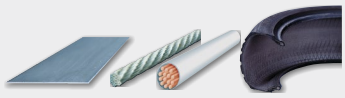
Dimensions Width x Thickness		Tooth pitch in tpi		
mm	Inch	6	4	3
8 x 0.65	5/16 x 0.025		L	
10 x 0.65	3/8 x 0.025	S	S, L	L
13 x 0.65	1/2 x 0.025	S	S, L	L
16 x 0.80	5/8 x 0.032		S	L
20 x 0.80	3/4 x 0.032	S	S	L

L = Skip tooth, S = Standard tooth
Please use the table on page 54 to determine the contact length.



JET

The special band saw blade for friction cutting



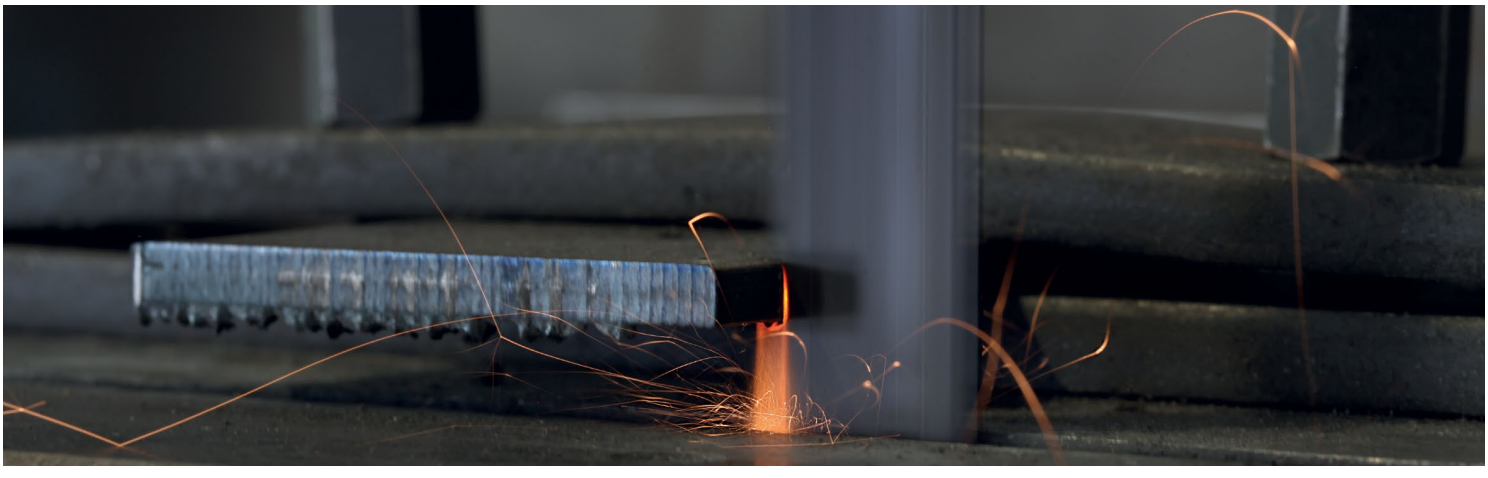
Application:
- Steels up to 1-3/16 inch thickness
- Composite materials
- Tires

Advantages:
- Sturdy band saw blade for very high cutting speed
- High thermal wear resistance

Features:
- Hardened tooth tips with high silicon content
- Backing material made of flexible carbon steel
- Tooth shape: standard tooth with 0° rake angle

Dimensions Width x Thickness		Tooth pitch in tpi				
		SD	RL			GS
mm	Inch	14	10	8	6	4
10 x 0.65	3/8 x 0.025		S			
20 x 0.80	3/4 x 0.032	S				
25 x 0.90	1 x 0.035			S	S	S

S = Standard tooth
Please use the table on page 54 to determine the contact length.



BLADE SELECTION

1. Tooth pitch

The dimensions of the band will depend on what band saw machine you are using – you will find an interactive overview of the most popular band saw machines and appropriate dimensions of WIKUS band saw blades on our website: www.wikus.com

2. Band width

- The wider the band saw blade, the more stability it will have
- Horizontal machines: band width specified by the manufacturer
- Vertical band saw machines: higher variations in band width are possible, please see the manufacturer's information
- Contour cuts: the smallest radius to be cut is the limiting factor for the band width

3. Cutting edge material

WIKUS offers five main groups of cutting edge materials:

- **Bimetal (HSS)**
- **Carbide**
- **Diamond**
- **Cubic boron nitride (CBN)**
- **Carbon steel**

The machinability of the material to be cut determines what cutting material you should choose.

4. Tooth pitch

The length of engagement of the saw blade in the workpiece represents the most important parameter for choosing the tooth pitch.
The material to be sawed and the type of saw blade used also plays a role in selecting the right pitch.

You will find the different contact lenghts listed with upper and lower limits in the tables on the individual products. We specify our recommended tooth pitch here.
The table to the right is used to determine the appropriate tooth pitch for carbon steel band saw blades when cutting solid material at a constant pitch.

When cutting pipes, the outside diameter and wall thickness are the defining parameters for choosing the right tooth pitch. Please refer to our recommendations in the table shown opposite.

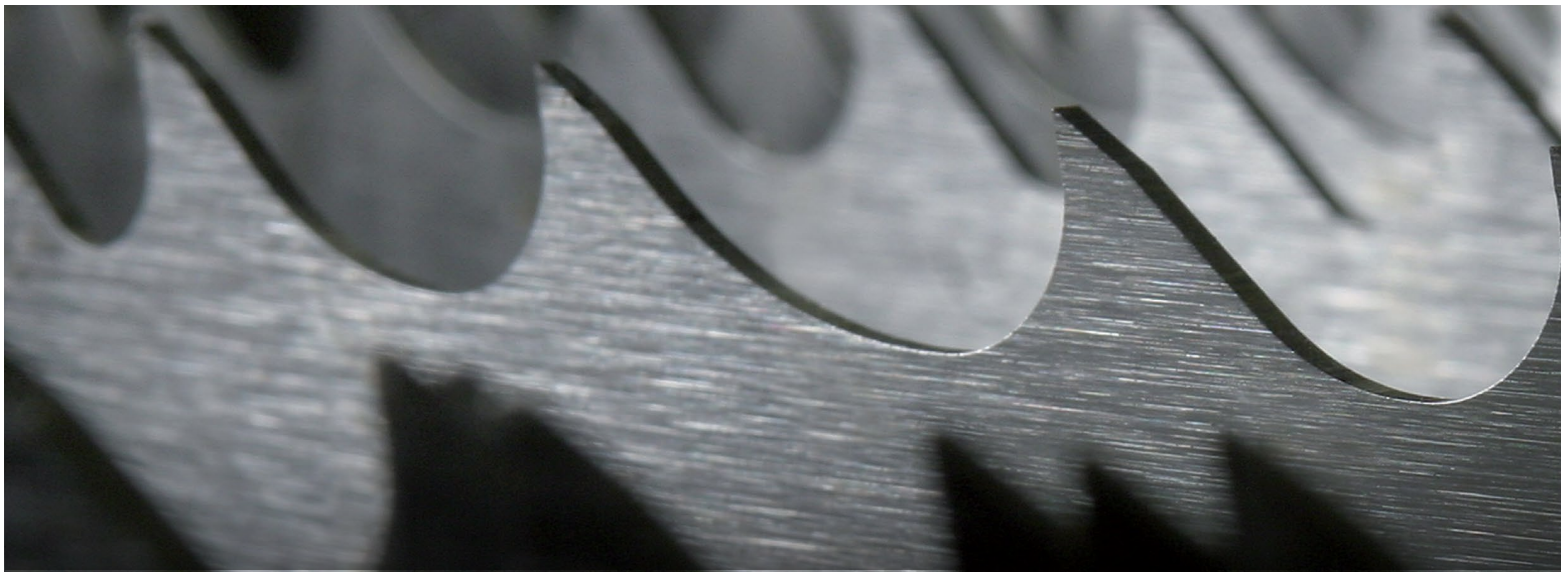
Constant tooth pitch	Contact length (inch)	
tpi	from	to
24		1/4
18		3/8
14		9/16
10	9/16	1-1/8
8	1-1/8	2
6	2	3-1/8
4	3-1/8	4-3/4
3	4-3/4	7-7/8
2	7-7/8	15-3/4

5. Tooth shape

The combination of our various tooth shapes, cutting-edge materials and band saw dimensions allows for the highest possible cutting performance.

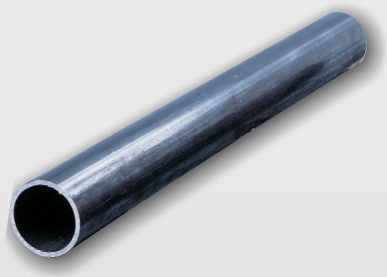
6. Types of tooth set

For a more detailed description, please refer to page 57.



s	Cutting of tubes **Outer diameter of the tube** (inch) / Tooth pitch Tz in tpi																
inch	3/4	1-5/8	2-3/8	3-1/8	4	4-3/4	5-7/8	7-7/8	11-3/4	15-3/4	19-5/8	23-5/8	27-9/16	31-1/2	35-3/8	39-3/8	59
1/16	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
1/8	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
5/32	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
3/16	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
1/4	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
5/16	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
3/8		8-12	6-10	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
1/2		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
9/16		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
3/4			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
1-1/8				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	1.4-2
2						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
3								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
4									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
5-7/8										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
7-7/8											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
9-7/8												1.4-2	1.0-1.4	1.0-1.4	1.0-1.4	0.75-1.25	0.75-1.25
11-3/4													1.0-1.4	1.0-1.4	0.75-1.25	0.75-1.25	0.75-1.25
13-3/4														1.0-1.4	0.75-1.25	0.75-1.25	0.7-1.0
15-3/4															0.75-1.25	0.75-1.25	0.7-1.0
17-3/4																0.7-1.0	0.7-1.0
19-5/8																	0.7-1.0

s = Wall thickness
If you need to cut two or more tubes that are lying side by side, please use this table that takes the double wall thickness into consideration (s).



TOOTH SHAPES

Skip tooth (L)

Rake angle: 0°, for:

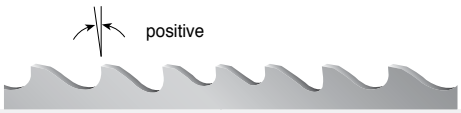
- flexible materials (aluminum and wood)
- only available in carbon steel blades

Standard tooth (S)

Rake angle: 0°, for:

- short-chipping materials
- steels with a high carbon content
- tool steel and cast iron
- materials with small cross-sections
- thin-walled profiles

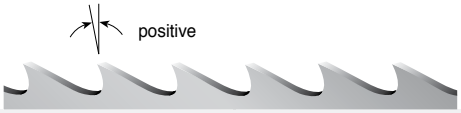
Profile tooth (P)



Rake angle: positive, for:

- hollow and angle profiles
- steel beams
- bundle and layer cuts
- applications that are susceptible to vibrations

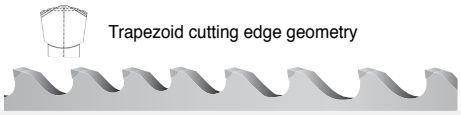
Hook tooth (K)



Rake angle: positive, for:

- universal use
- non-ferrous metals and steels
- profiles and solid materials

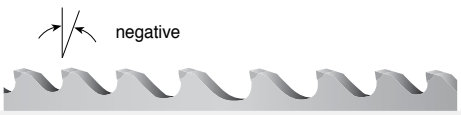
Trapezoid tooth (T)



Rake angle: positive, for:

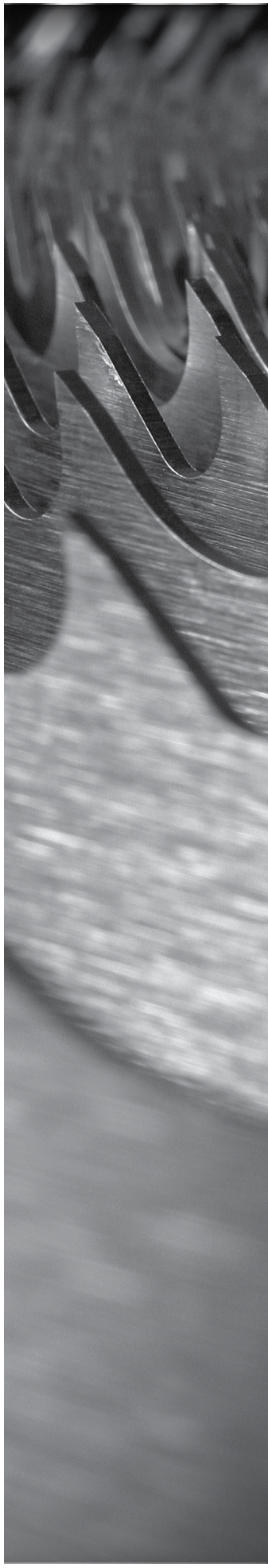
- high cutting performance
- optimal surface finishes

Tooth shape TSN (Trapezoid tooth)



Rake angle: negative, especially for:

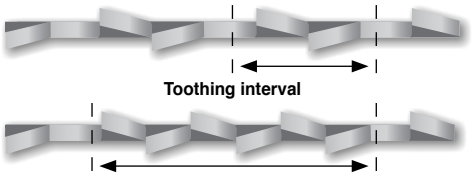
- surface-hardened shafts
- hardened steels up to 65 HRC, hard manganese steels, hard-chrome plated workpieces
- diameters of up to 7-7/8 inch



TYPES OF TOOTH SET

The number of teeth, angle of offset, and tooth pattern is referred to as “tooth set”. Tooth set affects the cutting performance and work piece finish.

Standard set (SD)



All-purpose set for cutting thicknesses of more than 0.2 inch with steels, castings and hard non-ferrous metals.
Constant tooth pitch: set sequence is left/right/straight.
Variable tooth pitch: one tooth in each toothing interval is unset, the remaining teeth in the interval are alternately set left/right or right/left.

Group set (GS)

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

Wavy set (WS)

We recommend wavy set for material dimensions of up to 0.2 inch, like sheets, thin-walled tubes and profiles.

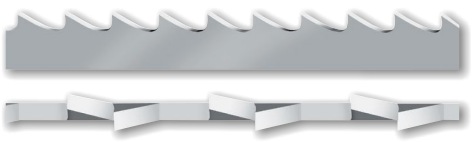
TOOTH PITCH (T_Z)

Tooth pitch refers to the number of teeth per inch (tpi).

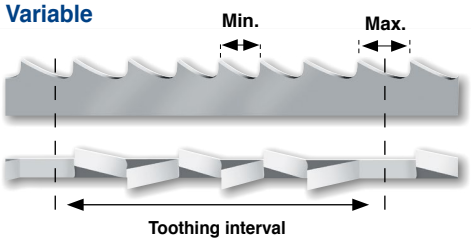
A distinction is made between constant tooth pitches with a uniform tooth distance, 2 tpi for example, and variable tooth pitches with different tooth distances within one toothing interval.

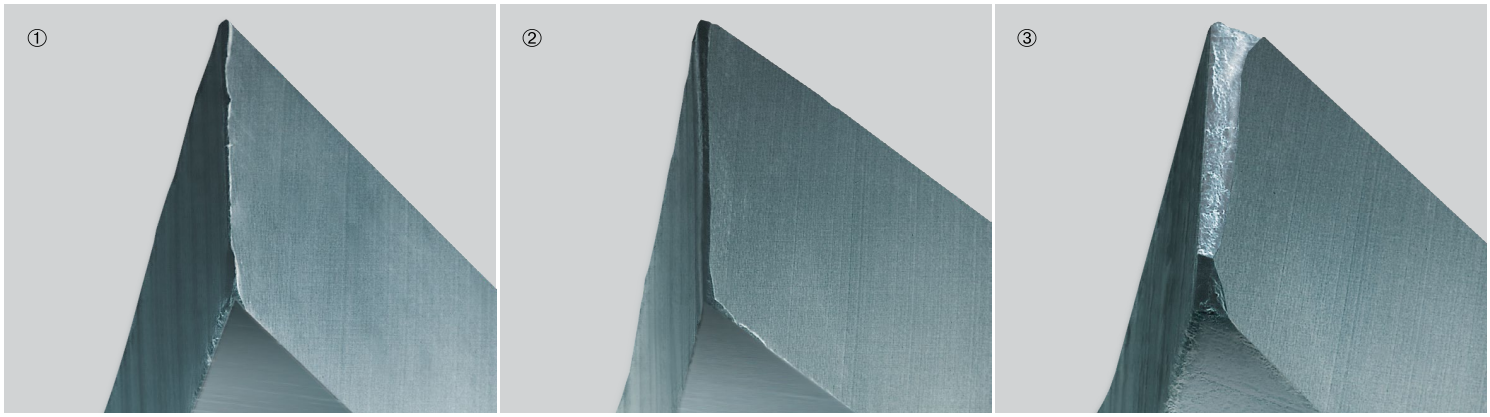
Variable tooth pitches, for instance 2-3 tpi, can be characterized by two measures: 2 tpi stands for the maximum tooth distance and 3 tpi stands for the minimum tooth distance in the toothing interval.

Constant



Variable





BREAKING IN YOUR BAND SAW BLADES

Sharp cutting edges that have extremely small edge radii are the ideal prerequisites for high cutting ability and a long service life. This is ensured by breaking in the blades properly. See pictures above:

1. New cutting edge with a very small edge radius
2. Proper breaking 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

Before you use the blade for the first time:

- Band tension should be about 43,000 psi
- Check and adjust the oil content of the cooling lubricant by using a hand refractometer
- The recommended oil content of the cooling lubricant can be found in the cutting data slide rule or in ParaMaster® 4.0

BIMETAL BAND SAW BLADES

- Determine the right cutting speed and feed rate based on the material to be cut and its dimensions using ParaMaster® 4.0 .
- Important: Use approx. 75% of the cutting speed (ft/min) and approx. 50% of the feed rate (inch/min)

CARBIDE BAND SAW BLADES

- Determine the right cutting speed and feed rate based on the material to be cut and its dimensions using ParaMaster® 4.0.
- Important: Use approx. 75% of the cutting speed (ft/min) and approx. 50% of the feed rate (inch/min)
- Very important: band saw blades can be prone to vibration and vibration noise - Help: To resolve this issue, reduce the cutting speed (ft/min) once again.

- With small workpiece dimensions, approx. 46 sq inch of the material should be cut to break in the blade.
- With large workpiece dimensions, we recommend breaking in over a period of about 15 min.
- After breaking in, slowly increase the cutting speed (ft/min) and then gradually increase the feed rate (inch/min) until you reach the recommended settings from ParaMaster® 4.0*.

***ParaMaster® 4.0, the online cutting data program from WIKUS, features a wide variety of different functions.**

More information can be found on page 8 or by visiting and registering at www.paramaster.de

CONTACT

WIKUS SAW TECHNOLOGY, CORP.

700 West Belden Avenue
Addison, IL 60101, USA
Phone: 1-844-WIKUS-4U
Fax: 1-877-766-0996
E-Mail: sales@wikussawtech.com

West Distribution Center

11823 Slauson Avenue, #44
Santa Fe Springs, CA 90670

Social Media

HEADQUARTERS GERMANY

Melsunger Str. 30
34286 Spangenberg, Germany
Phone: +49 5663 500 0
Fax: +49 5663 500 57
E-Mail: info@wikus.com

Contacts worldwide

You can find our global contact persons based on regional responsibilities on our WIKUS website under the category Contact.

www.wikus.de

WIKUS®
Precision at the cutting point

WIKUS Saw Technology, Corp.
700 West Belden Avenue
Addison, IL 60101
USA

WIKUS®
Precision at the cutting point

WIKUS Saw Technology, Corp.
WEST DISTRIBUTION CENTER
11823 Slauson Avenue, #44
Santa Fe Springs, CA 90670

Phone: 1-844-WIKUS-4U
Fax: 1-877-766-0996

www.wikussawtech.com
sales@wikussawtech.com

WIKUS-Sägenfabrik
Wilhelm H. Kullmann GmbH & Co. KG

Melsunger Str. 30
34286 Spangenberg, Germany

Phone: +49 5663 500-0
Fax: +49 5663 500-57

www.wikus.com
info@wikus.com

Innovative precision tools
designed and manufactured
in Spangenberg, Germany