

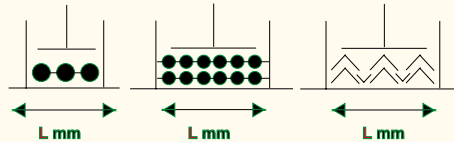
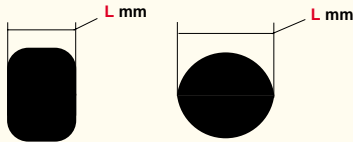
LAMES DE SCIES À RUBAN : CONSEILS D'UTILISATION POUR SCIES POUR MÉTAUX

ADVICE FOR USE OF METAL CUTTING BAND SAW
RATSCHLÄGE FÜR DEN GEBRAUCH VON METALLSÄGEN
CONSEJOS DE USO PARA SIERRA DE METAL

D/P -

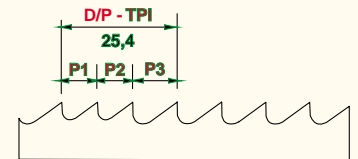
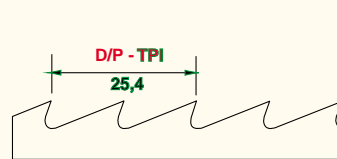
CHOIX DU PAS

Pitch choice - Wahl der Zahnteilung - Elección del paso



SECTIONS PLEINES

Full section - Alle Sektionen - Sección llena

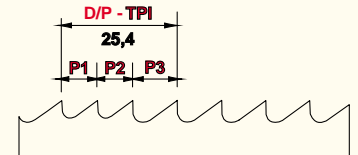
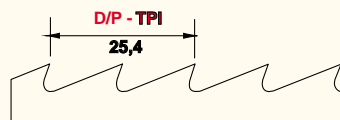
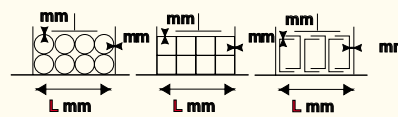
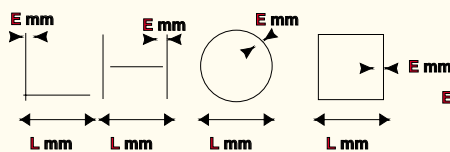


L mm	D/P - TPI
< 10 mm	14
10 - 30 mm	10
30 - 50 mm	8
50 - 80 mm	6
80 - 120 mm	4
120 - 200 mm	3
200 - 400 mm	2
300 - 700 mm	1.25
> 600 mm	0.75

L mm	D/P - TPI
< 25 mm	10/14
15 - 40 mm	8/12
25 - 50 mm	6/10
35 - 70 mm	5/8
40 - 90 mm	5/6
50 - 120 mm	4/6
80 - 180 mm	3/4
130 - 350 mm	2/3
150 - 450 mm	1,5/2
220 - 600 mm	1/2
200 - 600 mm	1,1/1,6
> 500 mm	0,75/1,25

TUBES ET PROFILÉS

Pipes and profiles - Tuben und Profile - Tubos y perfiles



	L 20	40	60	80	100	120	150	200	300	500
E 2	14	14	14	14	14	14	10/14	10/1	8/12	6/10
E 3	14	14	14	10/14	10/1	10/1	8/12	8/12	6/10	5/8
E 4	10/14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	5/8	4/6
E 5	10/14	8/12	8/12	8/12	6/10	6/10	5/8	5/8	4/6	4/6
E 6	8/12	8/12	6/10	6/10	5/8	5/8	5/6	5/6	4/6	3/4
E 8	8/12	6/10	6/10	6/10	5/8	5/8	5/6	5/6	4/6	3/4

	L 40	60	80	100	120	150	200	300	500
E 10	6/10	5/8	5/8	5/8	5/6	5/6	4/6	3/4	3/4
E 12	5/8	5/8	5/6	5/6	5/6	4/6	3/4	3/4	3/4
E 15	5/8	5/8	5/6	4/6	4/6	4/6	3/4	2/3	2/3
E 20	-	4/6	4/6	4/6	3/4	3/4	2/3	2/3	2/3
E 30	-	-	3/4	3/4	3/4	3/4	2/3	2/3	2/3
E 50	-	-	-	-	-	2/3	2/3	2/3	2/3
E >50	-	-	-	-	-	-	1,5/2	1,5/2	1,5/2

D/P -

CONDITIONS DE COUPE À OBSERVER

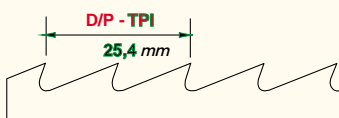
Cutting conditions to be followed - Schneid-Bedingungen, die zu beachten sind - Condiciones de corte a respetar

Matières Materials Material Materias	Vitesse en m/min. Speed in m/min Geschwindigkeit in m/min Velocidad en m/min.	Vitesse de rendement en cm ² /min. (sur la base du diamètre) Full output speed in cm ² /min Geschwindigkeits-Leistung in cm ² /min. (auf den Durchmesser basiert) Redimiento de velocidad en cm ² /min. (sobre la base del diametro)					
		25	50	75	100	150	200
Acier de construction Building steels Stahlkonstruktion Acero de construcción	80 - 90	25 - 35	40 - 50	50 - 60	55 - 70	70 - 90	75 - 85
Acier à revenu Annealed steels Gehärteter Stahl Acero a revenido	45 - 75	20 - 25	25 - 35	30 - 40	35 - 50	40 - 60	40 - 60
Acier à outil non allié Non allied steel for tools Stahl für nicht-legiertes Werkzeug Acero a herramienta no aleado	40 - 60	20 - 25	25 - 35	30 - 35	30 - 40	40 - 50	40 - 50
Acier à outil allié, Acier rapide Allied steels and speed steel Stahl für legiertes Werkzeug, Schnell-Stahl Acero a herramienta no aleado y acero rápido	30 - 40	15 - 20	20 - 25	25 - 30	30 - 35	30 - 35	30 - 35
INOX* - INOX* - INOX* - INOX*	20 - 35	10 - 15	15 - 20	15 - 20	15 - 20	15 - 20	15 - 20
Aciers réfractaires et résistants à hautes températures Refractory and high temperature strength steel Feuerfestes Stahl, widerstandfest bei hohen Temperaturen Aceros refractarios y resistentes a altas temperaturas	15 - 25	5 - 10	5 - 10	7 - 13	5 - 15	5 - 15	5 - 15

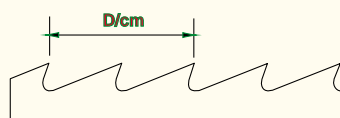
CONVERSIONS DES DENTURES

Tooth conversions - Umwandlungen der Zahnformen - Conversiones de dientes

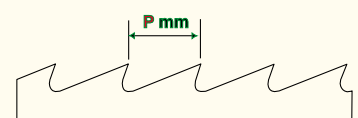
Dts/Pouce - Teeth per Inch - Zähne/Zoll - Dts/Pouce	1.25	2	3	4	6	8	10	14	18	24	32
Dts/cm - Dts/CM - Zähne/cm / - Dts/CM	0.5	0.8	1.2	1.6	2.5	3.2	4	6	8	10	12
Pas - Pitch - Teilung - Paso	20	12.5	8.5	6.3	4.2	3.1	2.5	1.8	1.4	1	0.8



- Dents / pouce
- Teeth per Inch
- Zähne/Zoll
- Dientes por pulgada



- Dents / cm
- Teeth per cm
- Zähne/cm
- Dientes por cm

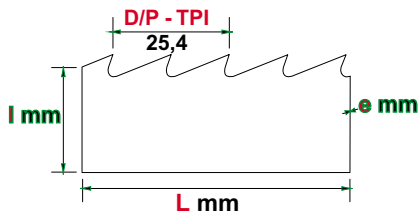


- Pas
- Pitch
- Teilung
- Paso

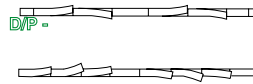
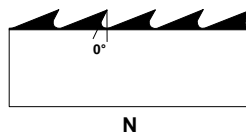
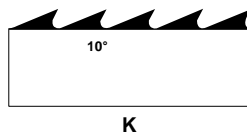
LAMES DE SCIES À RUBAN : POUR MÉTAUX BI-MÉTAL - SUPER HSS M42 (8% cobalt)



BAND SAW BLADE : BI-METAL, QUALITY SUPER HSS M42 (8% COBALT)
 BANDSÄGEBLÄTTER FÜR METALLE : BI-METALL-SUPER HSS M42 (8% KOBALT)
 HOJAS DE SIERRAS DE CINTA : PARA METALES : BI-METAL - SUPER HSS M (8% CABALTA)

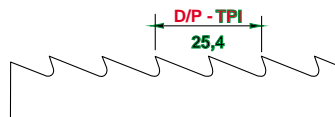


Niveaux de finition
 Finishing level
 Ausführung
 Nivel de acabado

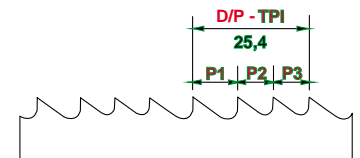


Programme de fabrication
 Production scheme
 Fabrikations-Programm
 Programa de fabricación

SUPER HSS M 42 (8% Colbat)



l	e	PAS NORMAL (Dts/Pouce)								
		0.75	1.25	2	3	4	6	8	10	14
4	0,9								N	N
6	0,6									
6	0,9						K		N	N
10	0,6						K			
10	0,9					K	K	N	N	N
13	0,6					K	N	N		
13	0,9				K	K	K	N	N	N
20	0,9				K	K	K	N		
27	0,9			K	NK	NK	N	N	N	
34	1,1		K	K	NK	NK	NK	N	N	
41	1,3		K	K	K	K	N			
54	1,3		K	N						
54	1,6		K	K	K					
67	1,6	K	K	K						
80	1,6	K	K							



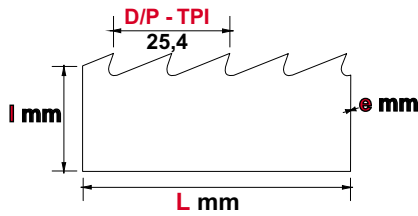
l	e	PAS VARIABLE (Dts/Pouce)											
		0,75/1,2	1,1/1,6	1,5/2	2/3	3/4	4/5	4/6	5/6	5/8	6/10	8/12	10/14
6	0,6												N
6	0,9												N
10	0,6												N
10	0,9												N
13	0,6										N	N	N
13	0,9												N
20	0,9							K		N	N	N	N
27	0,9				K	NK	K	NK	K	N	N	N	N
34	1,1				K	NK	K	NK	K	N	N	N	
41	1,3			K	K	NK	K	NK			N		
54	1,3		K	K	K	K	K	K		N			
54	1,6	K	K	K	K	K	K	K	K				
67	1,6	K	K	K	K	K							
80	1,6	K	K	K									

SPÉCIAL BI-MÉTAL : BI-MASTER

Spécial BI-MÉTAL - BI-MASTER - Speziales BI-METALL - BI-METAL Especial - BI-MATER

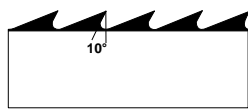
Application : Titane, Inox, Inconel

Application : Titanium, Inox, Inconel
Verwendung : Titan, Inox, Ni-Legierung
Aplicación : titanio, Inox, «Inconel»

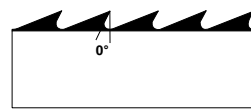


Niveaux de finition

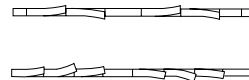
Finishing level
Ausführung
Nivel de acabado



K



N



D/P -

SPÉCIAL BI-MASTER



l	e	PAS NORMAL (Dts/Pouce)				PAS VARIABLE	
		1.25	2	3	4	2/3	3/4
27	0,9			K		K	K
34	1,1		K	K	K	K	K
41	1,3	K	K	K	K	K	
50	1,3	K		K			
50	1,6	K	K	K		K	K
67	1,6	K					

Qualité réservée aux : INOX - TITANE - INCONEL

Programme de fabrication

Production scheme
Fabrikations-Programm
Programa de fabricación

Conditionnement

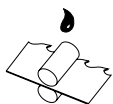
Packaging
Die Verpackung
Acondicionamiento



30 m



75 m



PROTECTION ANTI-CORROSION

RUST - PROTECTION
ROST - SCHUTZ
PROTECCION ANTI-CORROSION



PROTECTION DE LA DENT

PLASTIC TOOTH PROTECTOR
ZAHN-SCHUTZ
PROTECCION DE LAS DIENTES