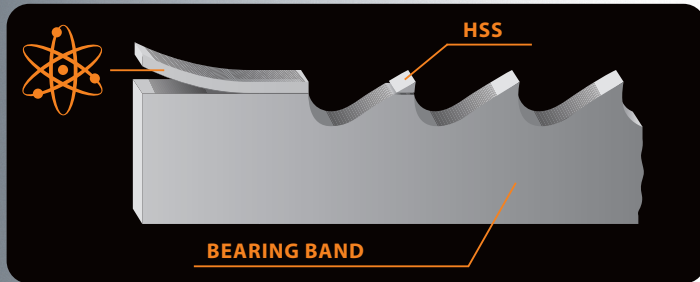


Sawblades *Pilous MaxTech*

- Original bandsaw blades produced using the latest technology with top-quality German materials, while strictly complying with all stated production and control procedures.
- High productivity and precision of cut with the maximum service life of the blade is ensured.
- Wide range of produced types of sawblades and tothing enables the professional cutting of almost all available materials.



Bi-metal blade – consists of bearing band from special steel on which a layer of HSS material is welded into where the teeth are milled.

M42 – universal blade recommended for a wide palette of material, including tool steels and stainless steel up to hardness 45 HRC. Teeth are made from steel HSS-M42 containing cobalt.

M51 – blade for tool and stainless steel with hardness up to 50 HRC. Tooth tips are made from steel HSS-M42 containing cobalt and wolfram.

Carbide – consists of bearing band from special steel into which the teeth are milled on which especially grinded carbide plates are welded. The carbide mounted blade is recommended for cutting surface hardened materials, chrome parts, forged pieces and materials with external tenacity and hardness up to 62 HRC.

Constant tothing – the distance of the teeth are always the same.

Variable tothing – the distance of teeth vary and is periodically repeated. This results in a greater cutting range, ability to further eliminate vibrations caused by the impact of the tooth blade on material, longer service life of the blade.

Cutting range – for optimal output of the blade, the correct selection of the size of the blade tooth is important depending on the size of the divided material.

SOLID MATERIALS



PROFILED MATERIALS



Variable tothing		Constant tothing	
a(D) [mm]		a(D) [mm]	
0-10	14 / 18	0-10	18
0-25	10 / 14	5-20	14
20-40	8 / 12 (8/11)	20-40	10
30-60	6 / 10	40-80	6
40-70	5 / 8 (5/7)	80-120	4
60-110	4 / 6	120-200	3
80-140	3 / 4	200-400	2
120-350	2 / 3	300-800	1,25
250-550	1,4 / 2		
380-750	1 / 1,5		
550-3000	0,75 / 1,25		

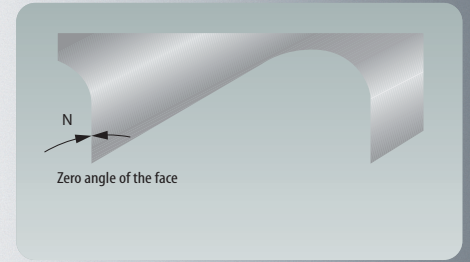
Variable tothing		Constant tothing	
t [mm]		t [mm]	
0-2	14 / 18	0-1	18
0-4	10 / 14	0-3	14
3-6	8 / 12 (8/11)	4-7	10
6-9	6 / 10	8-11	6
9-13	5 / 8 (5/7)	12-15	4
12-16	4 / 6	16-20	3
16-22	3 / 4	21-30	2
20-35	2 / 3	31-90	1,25
30-85	1,4 / 2		
40-85	1 / 1,5		
80-200	0,75 / 1,25		

When selecting the number of teeth for the blade, the general principle applies of a minimum of 4 teeth, but no more than 30 teeth are in contact with the work piece.

Bi-Metal M42

art. 420 / M42 / constant toothing

[mm]	Number of teeth per inch				
	4	6	10	14	18
13 × 0,65			N	N	N
13 × 0,9			N	N	
20 × 0,9	N	N		N	
27 × 0,9	N	N		N	
34 × 1,1	N				
41 × 1,3	N				

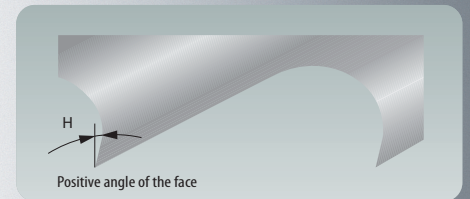


N = standard form of the tooth

Description: tooth points are from material HSS M42 1.3247 ● standard tooth with zero or slightly positive angle of the face and the standard or waved spring set ● excellent when cutting materials with shorter chip and thin-wall materials ● clean and smooth cut. **Use:** standard types of steel up to tensile strength of 1400 N/mm² ● non-ferrous metals ● cross-section up to 100 mm ● form cutting on vertical machine tools.

art. 421 / M42 / constant toothing

[mm]	Number of teeth per inch			
	2	3	4	6
13 × 0,65			H	H
13 × 0,9		H	H	H
20 × 0,9		H	H	
27 × 0,9	H	H		

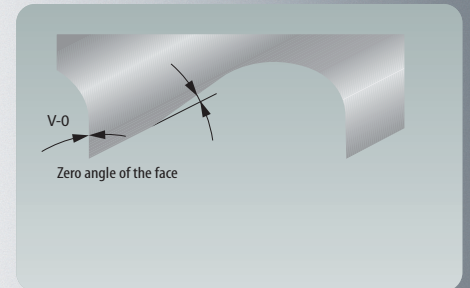


H = hook form of the tooth

Description: tooth points are from material HSS M42 1.3247 ● tooth with the positive angle of the face and the standard spring easily penetrate the material and create excellent chips for material with greater dimensions ● easily cuts materials with long chip and tough materials ● cuts smoothly and precisely. **Use:** standard types of steel up to tensile strength of 1400 N/mm² ● non-ferrous metals ● cross-sections over 100 mm.

art. 430 (410) / M42 / variable toothing

[mm]	Number of teeth per inch					
	3/4	4/6	5/8	6/10	8/12	10/14
13 × 0,65			V-0	V-0	V-0	V-0
13 × 0,9				V-0	V-0	V-0
20 × 0,9		V-0	V-0	V-0	V-0	V-0
27 × 0,9	V-0	V-0	V-0	V-0	V-0	V-0
34 × 1,1	V-0	V-0	V-0	V-0	V-0	V-0
41 × 1,3	V-0	V-0	V-0	V-0		
54 × 1,6	V-0	V-0	V-0			

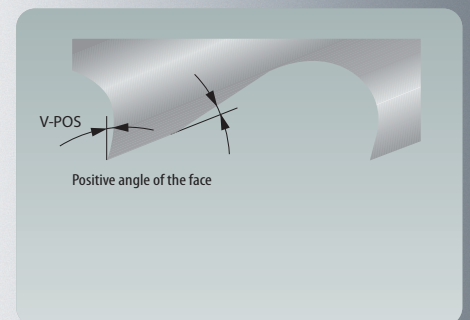


V-0 = variable tooth with 0 angle

Description: tooth points HSS M42 1.3247 ● variable tooth with the angle of the face 0° and special group spring set ● problem-free cutting of material with short chip ● long service life of bands and low cutting costs. **Use:** standard types of steel with tension strength 1,400 N/mm² ● profiles from non-ferrous metals ● cutting of individual pieces and bundles ● tubes and profiles with small or medium thickness of the wall ● metal sheet tables on vertical machines.

art. 431 (412) / M42 / variable toothing

[mm]	Number of teeth per inch				
	0,75/1,25	1,4/2	2/3	3/4	4/6
20 × 0,9					V-POS
27 × 0,9			V-POS	V-POS	V-POS
34 × 1,1		V-POS	V-POS	V-POS	V-POS
41 × 1,3		V-POS	V-POS	V-POS	V-POS
54 × 1,3		V-POS	V-POS	V-POS	V-POS
54 × 1,6		V-POS	V-POS		
67 × 1,6	V-POS	V-POS			
80 × 1,6	V-POS	V-POS			

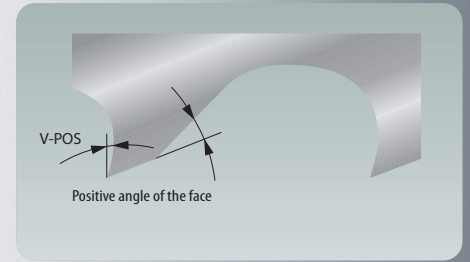


V-POS = variable tooth with positive angle

Description: tooth points from material HSS M42 1.3247 ● variable tooth with positive angle of the face and special group spring set cuts quickly and smoothly solid materials, as well as thick-wall profiles ● long service life and low cutting costs. **Use:** standard types of steel up to tension strength 1,400 N/mm² ● profiles from non-ferrous materials ● cutting of individual pieces and bundles ● solid materials with medium and large dimensions ● thick-wall tubes.

art. 433 / M42 / variable toothing

[mm]	Number of teeth per inch				
	2/3	3/4	4/6	5/7	8/11
27 × 0,9		V-POS	V-POS	V-POS	V-POS
34 × 1,1	V-POS	V-POS	V-POS	V-POS	
41 × 1,3	V-POS	V-POS	V-POS		
54 × 1,3		V-POS			
54 × 1,6	V-POS	V-POS	V-POS		
67 × 1,6	V-POS	V-POS			

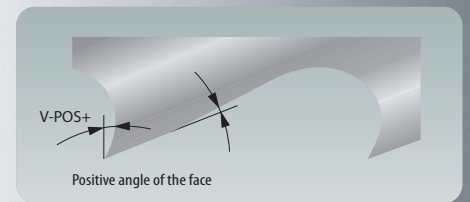


V-POS = variable tooth with positive angle

Description: tooth points HSS M42 1.3247 • variable tooth with new HL form, slightly positive angle of the face with special spring set • prevention of clamping of the band in the cut • restriction of vibrations and increase of cutting output • quality of surface and longer service life. **Use:** for optimal output of cutting on smaller and medium-sized machines • standard types of steel up to tensile strength 1,400 N/mm² • cutting of individual pieces and bundles • tubes and profiles for all wall thicknesses • solid material.

art. 434 / M42 / variable toothing

[mm]	Number of teeth per inch		
	1,4/2	2/3	3/4
34 × 1,1		V-POS	V-POS
41 × 1,3		V-POS	V-POS
54 × 1,3		V-POS	
54 × 1,6	V-POS	V-POS	V-POS



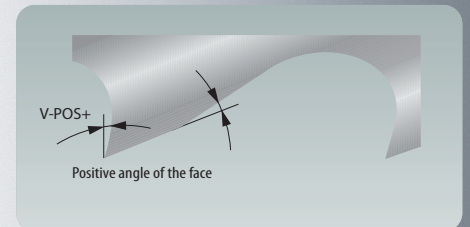
V-POS = variable tooth with positive angle

Description: tooth points from material HSS M42 1.3247 • especially designed variable tooth with positive face aggressively cuts tough materials • decreased cutting forces and easy creation of chips • exact cuts and long service life. **Use:** steel with long chip • stainless steels • titanium alloys • special bronzes • cooper alloys • alloys on the basis of nickel • exotic, hard dividing alloys • solid material with medium dimensions.

Bi-Metal M51

art. 531 / M51 / variable toothing

[mm]	Number of teeth per inch			
	1,4/2	2/3	3/4	4/6
27 × 0,9		V-POS	V-POS	V-POS
34 × 1,1		V-POS	V-POS	V-POS
41 × 1,3		V-POS	V-POS	
54 × 1,6	V-POS	V-POS		
67 × 1,6	V-POS	V-POS		

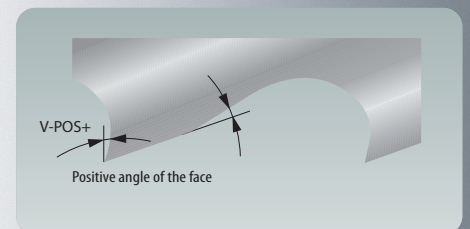


V-POS = variable tooth with positive angle

Description: tooth tips made from HSS M51 1.3207 material • especially strong tooth form with a positive face angle • high heat and wear resistance increases the service life of the band in all hard and problematic materials. **Use:** steel up to tensile strength 1700 N/mm² • austenitic stainless steel • nickel alloys • titanium and special bronze • solid material with medium dimensions • thick-wall tubes.

art. 537 / M51 / variable toothing

[mm]	Number of teeth per inch				
	0,75/1,25	1/1,5	1,4/2	2/3	3/4
34 × 1,1				V-POS	V-POS
41 × 1,3			V-POS	V-POS	V-POS
54 × 1,6	V-POS	V-POS	V-POS	V-POS	
67 × 1,6	V-POS	V-POS	V-POS		
80 × 1,6	V-POS		V-POS		

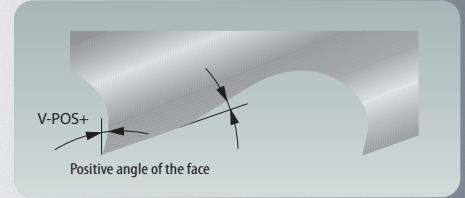


V-POS = variable tooth with positive angle

Description: Precise borazon ground tooth points from material HSS M51 1.3207 • tooth with specially positive face angle in connection with borazon ground geometry and variable group spring set takes the chips perfectly • faced teeth ensure excellent guiding of the band also in the case of higher vibrations • hardness of tooth tips of approximately 69 HRC increases the service life and cutting output. **Use:** steels with the tensile strength of 1,700 N/mm² • austenitic stainless steel • nickel alloys • solid material with medium dimensions.

art. 544 / M51 / variable toothing

[mm]	Number of teeth per inch			
	0,75/1,25	1/1,5	1,4/2	2/3
41 × 1,3			V-POS	V-POS
54 × 1,6	V-POS	V-POS	V-POS	V-POS
67 × 1,6	V-POS	V-POS	V-POS	V-POS
80 × 1,6	V-POS		V-POS	



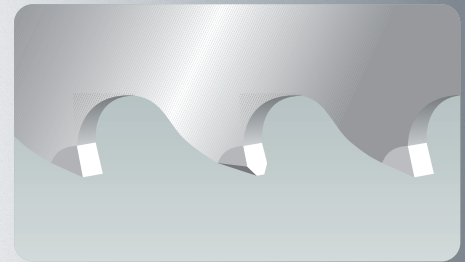
V-POS = variable tooth with positive angle

Description: tooth tips made from HSS M51 1.3207 • special tooth form with positive face angle and standard spring set • teeth are produced by pressure grinding for perfect form and surface quality. **Use:** steel up to the tensile strength 1,700 N/mm² • austenitic stainless steel • nickel alloys • titanium and special bronze • solid material with large dimensions.

Carbide

art. 620 / TC Black-Line / variable and constant toothing

[mm]	Number of teeth per inch					
	0,75/1,25	1/1,5	1,4/2	2/3	3	3/4
27 × 0,9				V	H	
34 × 1,1				H	H	V
41 × 1,3			V	V		V
54 × 1,3			V	V		
54 × 1,6	V	V	V	V		
67 × 1,6	V	V	V			

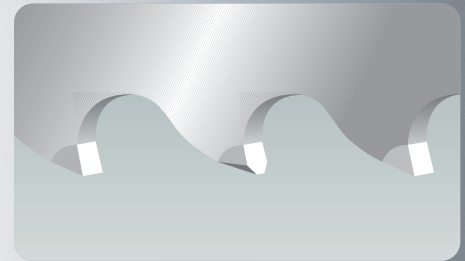


H = hook form of the tooth, V = variable tooth

Description: specially processed welded carbide, precision ground carbide tooth tips • use of special grinding of tooth geometry, pre-cut and post-cut tooth ensures the highest cutting output with minimal vibration. **Use:** titanium • stainless and acid resistant steels • nickel-alloys • exotic and hard processing alloys • solid material with medium and largest size.

art. 630 / TC Red-Line / variable and constant toothing

[mm]	Number of teeth per inch					
	0,75/1,25	1/1,5	1,4/2	2/3	3	3/4
27 × 0,9				V	H	
34 × 1,1				V	H	V
41 × 1,3			V	V		V
54 × 1,3			V	V		
54 × 1,6	V	V	V	V		
67 × 1,6	V	V	V			

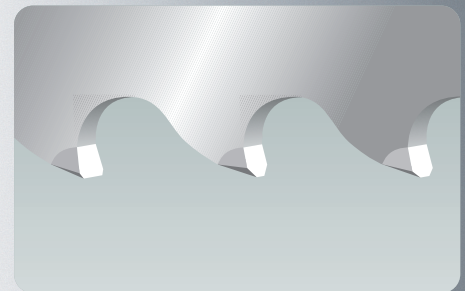


H = hook form of the tooth, V = variable tooth

Description: carbide welded by special process, precision ground tooth tips from carbide • use of special grinding of tooth geometry where the cutting channel is created by the higher number of toothed cutting sections. This achieves the maximum cutting output with almost no vibration. **Use:** solid material and the largest size • stainless and acid-proof steels • fire-resistant steels • high alloyed steels • hemmer steel • nickel-alloys • exotic and heavy tooled alloys • titanium • steels up to tensile strength of 1900 N/mm² • Ampco • zirconium.

art. 650 / TC Silver-Line / variable toothing

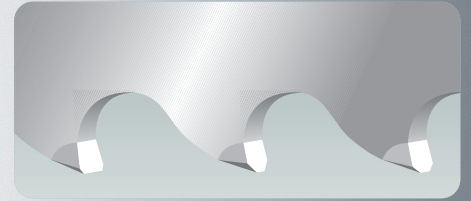
[mm]	Number of teeth per inch				
	0,75/1,25	1/1,5	1,4/2	2/3	3/4
27 × 0,9				V	
34 × 1,1				V	V
41 × 1,3			V	V	V
54 × 1,3			V	V	
54 × 1,6	V	V	V	V	
67 × 1,6	V	V	V		
80 × 1,6	V		V		



V = variable tooth

Description: carbide welded by special process, precision ground tooth tips from carbide • use of special grinding of the tooth geometry where the cutting channel is created by the higher number of toothed cutting sections. This achieves the maximum cutting output with almost no vibration. **Use:** solid material, medium and largest sizes • stainless and acid-proof steels • fireproof steels • high alloyed steels • hammer steel • nickel-alloys • exotic and hard tooled alloys • titanium • steels up to a tension strength of 1,900 N/mm² • Ampco • zirconium.

[mm]	Number of teeth per inch	
	2/3	3/4
27 × 0,9	V	
34 × 1,1	V	V
41 × 1,3	V	V
54 × 1,6	V	



V = variable tooth

Description: induction hardened piston rods ● up to 62 HRC hardened steels ● hard-chrome – coated steel ● manganese steel.