

Industrial
bandsaw
blades

Fabrosor

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Geometry K

M42 POSITIVE

Affordable bandsaw blade for solid materials



Application

- Universal application in every workshop
- Effective reduction of cutting costs
- Solid and thick-walled materials
- Mitre band saws with swivel head
- All metals up to a tensile strength of 1000 N/mm²

Features

- M42 cutting edge
- Positive tooth rake angle „K“
- Variable tooth pitch
- Cutting lengths 40–1000 mm

WIDTH × THICKNESS	NUMBER OF TEETH PER INCH (TPI)						
	0,75–1,25	1,0–1,5	1,4–2	2–3	3–4	4–6	5–8
20 × 0,90 mm					K-10	K-7	K-3
27 × 0,90 mm				K-10	K-10	K-7	K-3
34 × 1,10 mm				K-10	K-10	K-7	K-3
41 × 1,30 mm			K-10	K-10	K-10	K-7	K-3
54 × 1,60 mm	K-10	K-10	K-10	K-10	K-10	K-7	
67 × 1,60 mm	K-10	K-10	K-10	K-10	K-10		
80 × 1,60 mm	K-10	K-10					

Geometry K

M42P POSITIVE

Universal tool for small and large cross-sections

Application

Industrial use

Solid and thick-walled materials

Stainless and tool steels

Single, layered and bundle cutting

All metals up to a tensile strength of 1000 N/mm²

Features

Powder metallurgy M42P

Positive tooth rake angle „K“

Variable tooth pitch

Cutting lengths 40–1000 mm

WIDTH × THICKNESS	NUMBER OF TEETH PER INCH (TPI)						
	0,75–1,25	1,0–1,5	1,4–2	2–3	3–4	4–6	5–8
20 × 0,90 mm						K-7	K-3
27 × 0,90 mm				K-10	K-10	K-7	K-3
34 × 1,10 mm				K-10	K-10	K-7	K-3
41 × 1,30 mm			K-10	K-10	K-10	K-7	
54 × 1,60 mm	K-10	K-10	K-10	K-10	K-10	K-7	
67 × 1,60 mm	K-10	K-10	K-10	K-10	K-10		
80 × 1,60 mm	K-10	K-10					

Geometry P

M42 PROFILE

Cost-effective bandsaw blade for cutting profiles

Application

Effective reduction of cutting costs

Where operating conditions are difficult

Thin-walled stainless steel

Structural steel profiles and beams

All metals up to a tensile strength of 1000 N/mm²

Features

M42 cutting edge

Positive tooth rake angle „P“

Variable tooth pitch

Cutting lengths up to 350 mm

Profile dimensions 30x3–350x80 mm

WIDTH × THICKNESS	NUMBER OF TEETH PER INCH (TPI)						
	2-3	3-4	4-6	5-7	7-9	8-11	12-16
13 × 0,65 mm						P-7*	
20 × 0,90 mm			P-7*	P-7*	P-7*	P-7*	P-7*
27 × 0,90 mm		P-7	P-7	P-7	P-7*	P-7	P-7*
34 × 1,10 mm	P-7	P-7	P-7	P-7			
41 × 1,30 mm	P-7	P-7	P-7				
54 × 1,60 mm	P-7*	P-7	P-7				
67 × 1,60 mm	P-7*	P-7					

* Available only welded to specific length



Geometry P

M42P PROFILE

The perfect saw blade for profiles and tubes



Application

Single, layered and bundle cutting

Metal and steel profiles and beams

Workshop and industrial use

The ideal solution for all vibrating cuts

All metals up to a tensile strength of 1000 N/mm²

Features

Powder metallurgy M42P

Positive tooth rake angle „P“

Variable tooth pitch

Cutting lengths 40–350 mm

Profile dimensions 80x8–350x80 mm

WIDTH × THICKNESS	NUMBER OF TEETH PER INCH (TPI)			
	2-3	3-4	4-6	5-7
27 × 0,90 mm		P-7	P-7	P-7
34 × 1,10 mm	P-7	P-7	P-7	
41 × 1,30 mm	P-7	P-7	P-7	
54 × 1,60 mm		P-7	P-7	
67 × 1,60 mm		P-7		

Geometry S

M42 STANDARD

Versatile bandsaw blade
for every workshop

Application

- Perfect for manual band saws
- Piece cutting of smaller workpieces
- Thin-walled profiles and tubes
- Effective reduction of cutting costs
- All metals up to a tensile strength of 1000 N/mm²

Features

- M42 cutting edge
- Zero tooth rake angle „S“
- Variable or constant tooth pitch
- Cutting lengths up to 120 mm
- Profile dimensions 20x2–120x6 mm

WIDTH × THICKNESS	NUMBER OF TEETH PER INCH (TPI)						
	6–10	8–12	10–14	14–18	4	6	14
13 × 0,65 mm	S-0	S-0	S-0	S-0	S-0	S-0	S-0
20 × 0,90 mm	S-0	S-0	S-0				
27 × 0,90 mm	S-0	S-0	S-0				
34 × 1,10 mm	S-0	S-0					
41 × 1,30 mm	S-0						



Geometry K

M51P POSITIVE

The ideal bandsaw blade for tough materials



Application

Solid materials

Forged ingots with scales

High-alloy austenitic materials

To achieve a long service life

All metals up to a tensile strength of 1400 N/mm²

Features

Powder metallurgy M51P

Positive tooth rake angle „K“

Variable tooth pitch

Cutting lengths 40–1000 mm

WIDTH × THICKNESS	NUMBER OF TEETH PER INCH (TPI)						
	0,85–1,30	1,0–1,5	1,4–2	2–3	3–4	4–6	5–8
27 × 0,90 mm				K-7	K-10	K-7	K-3
34 × 1,10 mm			K-10	K-10	K-10	K-7	K-3
41 × 1,30 mm			K-10	K-10	K-10	K-7	K-3
54 × 1,60 mm		K-12	K-10	K-10	K-10	K-7	
67 × 1,60 mm	K-10	K-12	K-10				
80 × 1,60 mm	K-10	K-12					



Geometry K+

M42P PLUS

Powerful bandsaw blade
for all common steels

Application

- Large steel block manufacturers
- Steel distributors and large cutting plants
- Special and tough non-ferrous alloys
- For long cuts and increased productivity
- All metals up to a tensile strength of 1000 N/mm²

Features

- Powder metallurgy M42P
- Positive tooth rake angle „K+“
- Variable tooth pitch
- Cutting lengths 80–1400 mm

WIDTH × THICKNESS	NUMBER OF TEETH PER INCH (TPI)				
	0,75-1,25	1,0-1,5	1,4-2	2-3	3-4
27 × 0,90 mm				K-13	K-13
34 × 1,10 mm				K-13	K-13
41 × 1,30 mm			K-13	K-13	K-13
54 × 1,60 mm		K-13	K-13	K-13	
67 × 1,60 mm		K-13	K-13		
80 × 1,60 mm	K-13	K-13			



Geometry K+

M51P PLUS

Powerful bandsaw blade
for tough materials

Application

Industrial companies and large cutting plants

Distributors of various types of steel

High-alloy austenitic materials

For long cuts and increased productivity

All metals up to a tensile strength of 1500 N/mm²

Features

Powder metallurgy M51P

Positive tooth rake angle „K+“

Variable tooth pitch

Cutting lengths 80–1400 mm

WIDTH × THICKNESS	NUMBER OF TEETH PER INCH (TPI)				
	0,75–1,25	1,0–1,5	1,4–2	2–3	3–4
27 × 0,90 mm				K-13	K-13
34 × 1,10 mm				K-13	K-13
41 × 1,30 mm			K-13	K-13	K-13
54 × 1,60 mm		K-13	K-13	K-13	
67 × 1,60 mm		K-13	K-13		
80 × 1,60 mm	K-13	K-13			

HOW TO CHOOSE THE RIGHT BLADE

Cutting edge material makes the difference in the blade quality

Bimetal bandsaw blades with M42

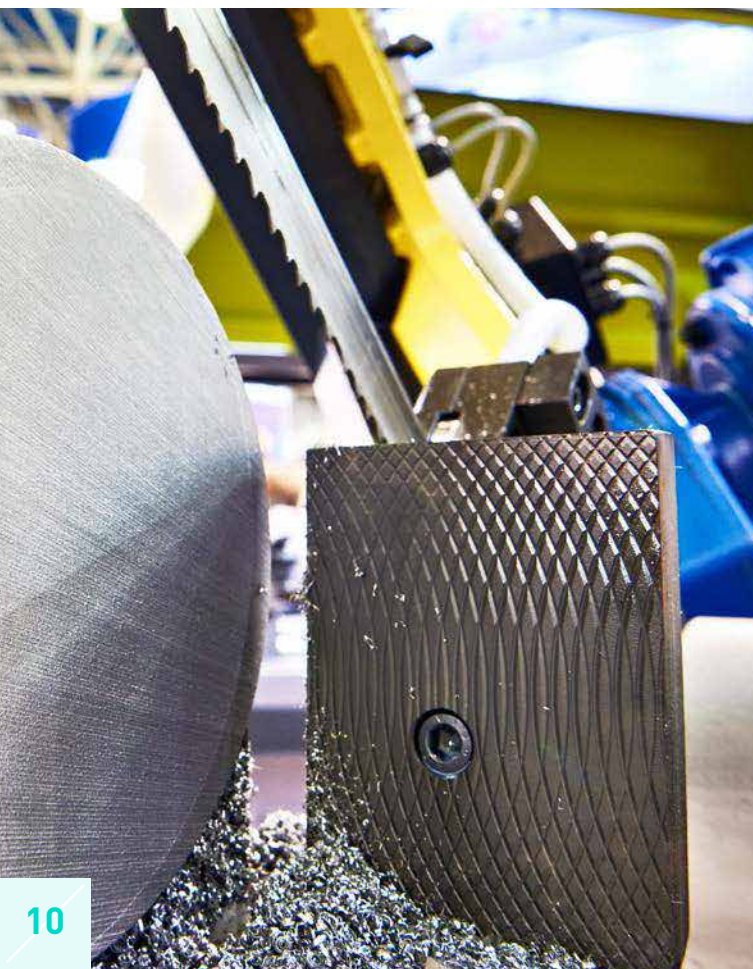
The most versatile bandsaw blades, covering up to 90% of all cutting operations. A wide selection of geometries, dimensions, and tooth pitches.

Bimetal bandsaw blades with M51

Suitable for cutting stainless, acid-resistant, heat-treated, and heat-resistant steels. High abrasion resistance.

Carbide tipped bandsaw blades

The main advantage is high productivity and performance. However, the best results can only be achieved on suitable band saws.



Select the appropriate tooth geometry for the material

Standard S

- ✦ small cross-section materials
- ✦ tool and cast steel
- ✦ materials with higher carbon content

Profile P

- ✦ profile material shapes O, L, I, T, H, U
- ✦ cutting in bundles and layers
- ✦ where vibrations occur during cutting

Positive K

- ✦ full materials of larger sizes
- ✦ thick-walled tubes, non-metallic materials
- ✦ stainless and acid-resistant steels

MAKING THE BLADE LAST LONGER

Run-in the blade

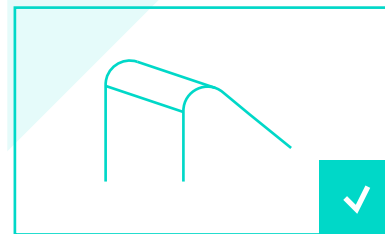
In order to achieve good cutting performance and a long service life, it is necessary to first run-in the bandsaw blade to slightly round the cutting edges. Otherwise, there is a risk of extensive breakage of the tooth tips and thus a significant reduction in tool life.

Follow these guidelines

- ✦ By setting 75% cutting speed and 50% feed rate compared to the recommended values.
- ✦ For large materials by cutting off approximately 500 cm².
- ✦ For small materials for approximately 15 minutes.
- ✦ When vibrating, by reducing the bandsaw blade speed again.

Watch the chips

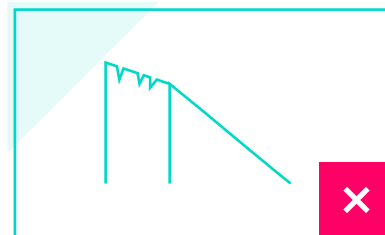
You can deduce the correctness of the cutting parameters by the chips ejected from the cut. The shape of the chip is affected by the selected tooth pitch, the speed of the bandsaw blade and also the feed. For most materials, thick and blue chips are bad, powder is unnecessary caution. Similarly, beware of heavily twisted chips, which can indicate a clogged gap and be the cause of a broken tooth.



Proper bandsaw blade run-in creates a stable cutting edge



New tool with extremely small cutting edge roundness



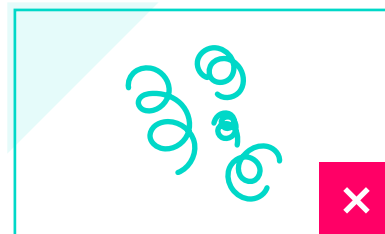
Incorrect run-in will cause micro-cracks on the cutting edge



Loose twisted chips – correct cutting values



Thin or powdery chips – speed up the feed or reduce the blade speed



Thick, heavy or blue chips – slow down the feed or increase the blade speed

Fabrosor

**Made and packed
with the highest precision**

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