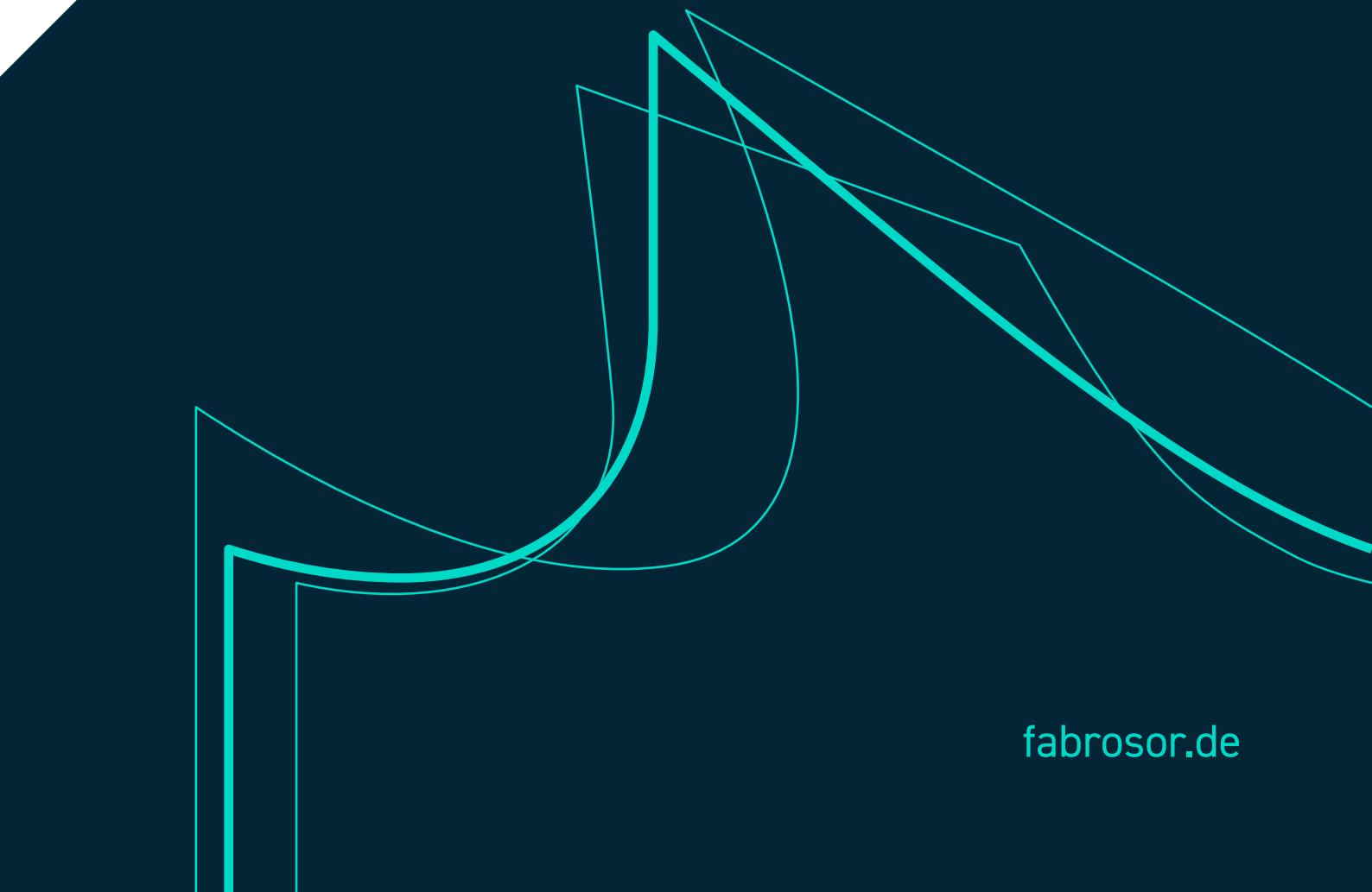
Industrial
bandsaw
blades

Fabrosor



fabrosor.de

Geometry S

STANDARD

Versatile tool for small and medium workpieces

Aplication

- Piece cutting
- Tubes and profiles
- Workshop and lighter industrial applications
- Diameters up to 500 mm or walls up to 20 mm
- All metals up to a tensile strength of 1000 N/mm²

Features

- M42 cutting edge
- Zero tooth rake angle
- Variable or constant tooth pitch
- Regular tooth shape „S“

WIDTH × THICKNESS	NUMBER OF TEETH PER INCH (TPI)					
	5–8	6–10	8–12	10–14	14	18
6 × 0,65 mm				S		
6 × 0,90 mm				S		
10 × 0,90 mm				S		
13 × 0,50 mm					S	
13 × 0,65 mm		S	S	S	S	S
20 × 0,90 mm	S	S	S	S		S
27 × 0,90 mm	S	S	S	S	S	S
34 × 1,10 mm	S	S	S			

Geometry K

POSITIVE

Universal tool for small and large cross-sections

Aplication

- Industrial use
- Solid and thick-walled materials
- Single, layered and bundle cutting
- Small to large diameters up to 900 mm
- All metals up to a tensile strength of 1000 N/mm²

Features

- M42 tooth edge
- Positive tooth rake angle
- Variable or constant tooth pitch
- Regular tooth shape „K“
- Regular tooth shape with extra wide setting „N“

WIDTH × THICKNESS	NUMBER OF TEETH PER INCH (TPI)								
	1–1,4	1,4–2	2–3	3–4	4–6	2	3	4	6
13 × 0,65 mm								K	K
20 × 0,90 mm					K		N	N	
27 × 0,90 mm			K	K	K	N	N	N	
34 × 1,10 mm			K	K	K		N		
41 × 1,30 mm		K	K	K	K				
54 × 1,30 mm			K	K					
54 × 1,60 mm	K	K	K	K					
67 × 1,60 mm	K	K	K						

Geometry P

PROFILE

Perfect band saw blade
for profiles and tubes

Aplication

- Single, layered and bundle cutting
- Metal and steel profiles and beams
- Workshop and industrial use
- Diameters up to 1500 mm or walls up to 100 mm
- All metals up to a tensile strength of 1000 N/mm²

Features

- M42 cutting edge
- Positive tooth rake angle
- Variable tooth pitch
- Profile tooth shape „P“
- Extremely stable geometry

WIDTH × THICKNESS	NUMBER OF TEETH PER INCH (TPI)								
	2–3	3–4	4–6	5–7	7–9	8–11	10–14	12–16	14–18
13 × 0,65 mm					P	P	P		P
20 × 0,90 mm			P	P	P	P	P	P	
27 × 0,90 mm		P	P	P	P	P	P	P	
34 × 1,10 mm	P	P	P	P	P	P			
41 × 1,30 mm	P	P	P	P	P	P			
54 × 1,30 mm	P	P	P	P					
54 × 1,60 mm	P	P	P						
67 × 1,60 mm	P								

Geometry K

M51 POSITIVE

Special for high-strength and difficult-to-cut materials

Aplication

- Solid materials
- Forged ingots with scales
- High-alloy austenitic materials
- Small to large diameters up to 900 mm
- All metals up to tensile strength 1400 N/mm²

Features

- M51 cutting edge
- Positive tooth rake angle
- Variable tooth pitch
- Regular tooth shape „K“
- Stability and wear resistance

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

HOW TO CHOOSE THE RIGHT BLADE

Cutting edge material makes the difference in the blade quality

Bimetal bandsaw blades with M42

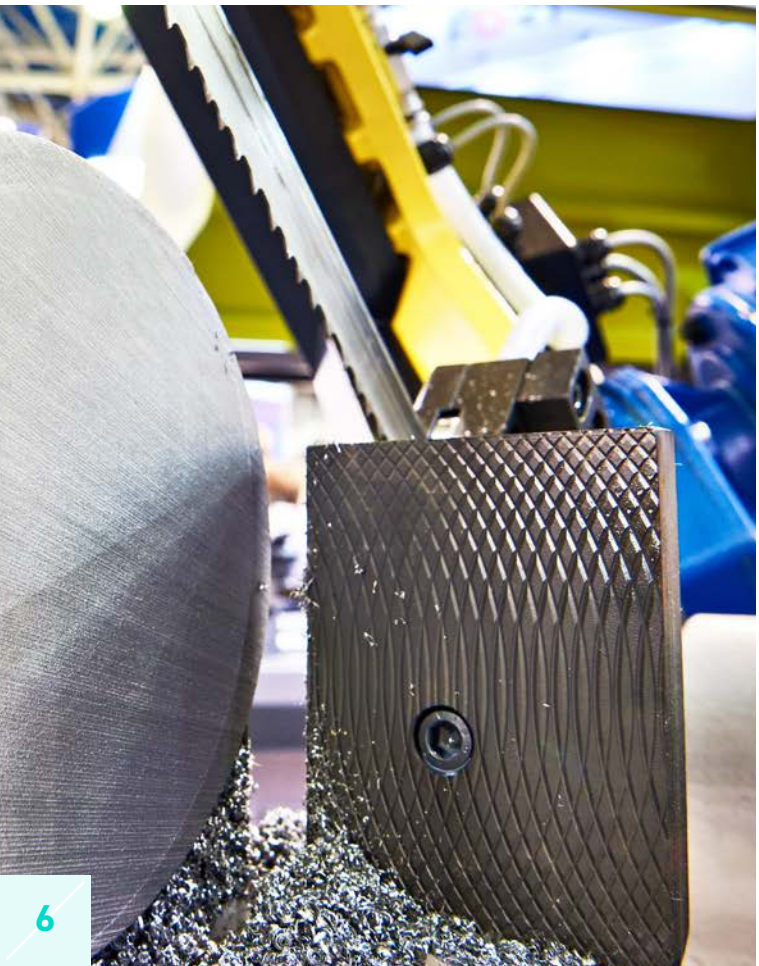
An established standard that can be offered in many designs and finishes, from conventional strips to more thermally enhanced ones

Bimetal bandsaw blades with M51

The higher quality of the cutting edges makes these blades suitable for demanding applications where the conventional M42 is losing its strength.

Carbide tipped bandsaw blades

They can be used for cutting highly durable materials, but their main advantage is significantly higher productivity.



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

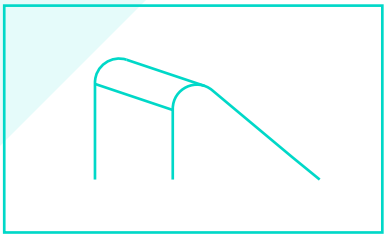
MAKING THE BLADE LAST LONGER

Run-in the blade

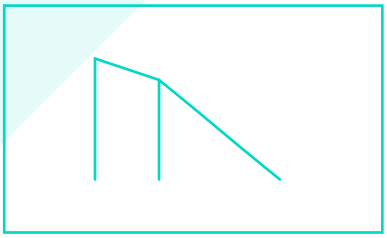
In order to achieve good cutting performance and a long service life, it is necessary to first run-in the bandsaw blade to slightly round the cutting edges. Otherwise, there is a risk of extensive breakage of the tooth tips and thus a significant reduction in tool life.

Follow these guidelines

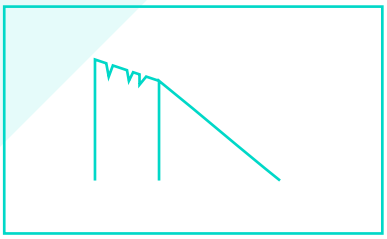
- For large materials by cutting off approximately 500 cm².
- For small materials for approximately 15 minutes.
- For bimetals, by setting 100% cutting speed and 50% feed compared to recommended values.
- For carbides by setting 75% cutting speed and 50% feed compared to the recommended values.
- When vibrating, by reducing the bandsaw blade speed again.



Proper bandsaw blade run-in creates a stable cutting edge



New tool with extremely small cutting edge roundness



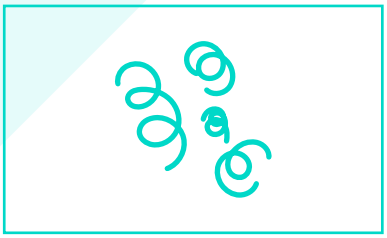
Incorrect run-in will cause micro-cracks on the cutting edge

Watch the chips

You can deduce the correctness of the cutting parameters by the chips that the blade ejects 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.

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 in Germany
with the highest precision

fabrosor.de