



**TCT Circular Saw Blades
PCD Circular Saw Blades
Band Saw Blades**



— 2021



The production of wood cutting tools began in Hulín, Czechoslovakia as far back as in the year **1934** when „*The First Moravian Factory for Production of Saws and Tools*“ started its operations. Initially, hand held saws were the main product, gradually circular saw blades were added to the production program along with other cutting tools for wood. In the **1960s**, the product range expanded as TCT tipped circular saw blades were added.

During the **1990s**, privatization of the state owned manufacturing facilities into private hands occurred and as a result of this process company PILANA Wood was formed. Enormous efforts were brought into upgrading the machinery park, improvement of the production technologies and general shifting to western standards so that the company could become competitive in the newly opened world markets after the fall of the Eastern Block.

These new production technologies include cutting of steel bodies by laser and their machine straightening or brazing and sharpening of TCT tips. Machinery park has been constantly renewed to presently contain robotic brazing machines made by Kirschner, DE or sharpening centers made by Vollmer, DE. Strict quality control has also become one of the crucial pillars on which the whole production stands and is now an inseparable part of the overall modern approach to managing our business.

At present, we are happy to serve our customers in **more than 90 countries** of the world where they can choose from a variety of standard products available from stock as well as tools made on request. That all for applications in cutting of wood, chipboard, plastics, non-ferrous metals, steels and many other contemporary materials.

You are cordially invited to come and try the quality of our products and services for yourselves.

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General Information



Tungsten carbide tipped (TCT) circular saw blades from PILANA Wood are manufactured from high quality German steels with the use of TCT tips made for specific application based on their hardness/tenacity grade. Bodies have typically the hardness of 45-48 HRC and the complete saw bodies are laser-cut.

Expansion slots located around the saw body are specially shaped for each cutting application. As a result, they prevent blade deformation and improve cutting quality in difficult working conditions. Low-noise slots in the steel saw body reduce noise generated by the saw in the movement and allow for pleasant working conditions.

High attention is also paid to the saw blade stability, tolerances of the outer and side run and tensioning of the body thus reaching the best cutting results possible. The last but not least important parameter is the sharpening of the TCT carbide tips - ideal cutting edge/tooth shape guarantees optimal quality cutting.

Constantly renewed machine park (Vollmer sharpening machines, Kirschner and Gerling brazing machines, Trumpf lasering machines etc.) together with the best quality grinding discs/soldering material enable us to sustain high top quality of our saw blades for our customers of more than 90 countries in the world.

Tooth Geometry of TCT Circular Saw Blades

| | | | | | | | | |
|--|--------|--|--|---------|--|---------|--|--|
| | FZ | flat tooth | | TFZ | triple chip tooth alternating with flat tooth | | WZ/SSW | |
| | FZ N | flat tooth with negative hook angle | | TFZ N | triple chip tooth alternating with flat tooth with negative hook angle | | | |
| | LFZ | flat tooth with chip limiter | | | | | | |
| | WZ | alternate top bevel | | DHZ | hollow face tooth (flat tooth alternates with inverted "V" tooth) | WZ/FA | flat tooth with bevel | |
| | WZ N | alternate top bevel with negative hook angle | | DHZ N | hollow face tooth (flat tooth alternates with inverted "V" tooth), negative hook angle | | | |
| | LWZ | alternate top bevel with chip limiter | | | | | | |
| | TZ | triple chip tooth | | KON FZ | conical tooth | WZ/W | alternate tooth with double bevel | |
| | TZ/TZ | | | KON WZ | | | | |
| | KXZ FZ | barrel tooth | | WZ/FA/K | plexi | WZ/FA/N | flat tooth with bevel with negative hook angle | |

List of Carbide Tip Grades:

| Grades of tips | | | |
|---|---|---|--|
| K 01 | K 10 | K 20 | K 30 |
| Hardness [HV 30] | Hardness [HV 30] | Hardness [HV 30] | Hardness [HV 30] |
| 1900 – 2250 | 1740 – 1800 | 1520 – 1600 | 1140 – 1510 |
| Tips of K01 grade are very resistible against abrasion. Powdered grain (ultra fine grain) is very fine. Its grade is applicable for cutting hard materials. For example MDF, chipboard, HDF, double side laminated chipboard etc. | Tips with optimal combination of fine-grained structure and material hardness applicable for universal usage. Best for cutting wood, plastics, non – ferrous metals, plywood, plaster boards etc. | Tips containing higher percentage of cobalt binding material enable better tooth tenacity and therefore higher resistance while encountering other material types (branch knots, dirt, steel chips etc.). Tips are applicable for cutting along the grain of natural woods. | High percentage of cobalt binding material with lower hardness enables K30 tips high tenacity and resistance against breaking. This grade is best applicable for cutting in extreme conditions (i.e. cutting frozen wood). |

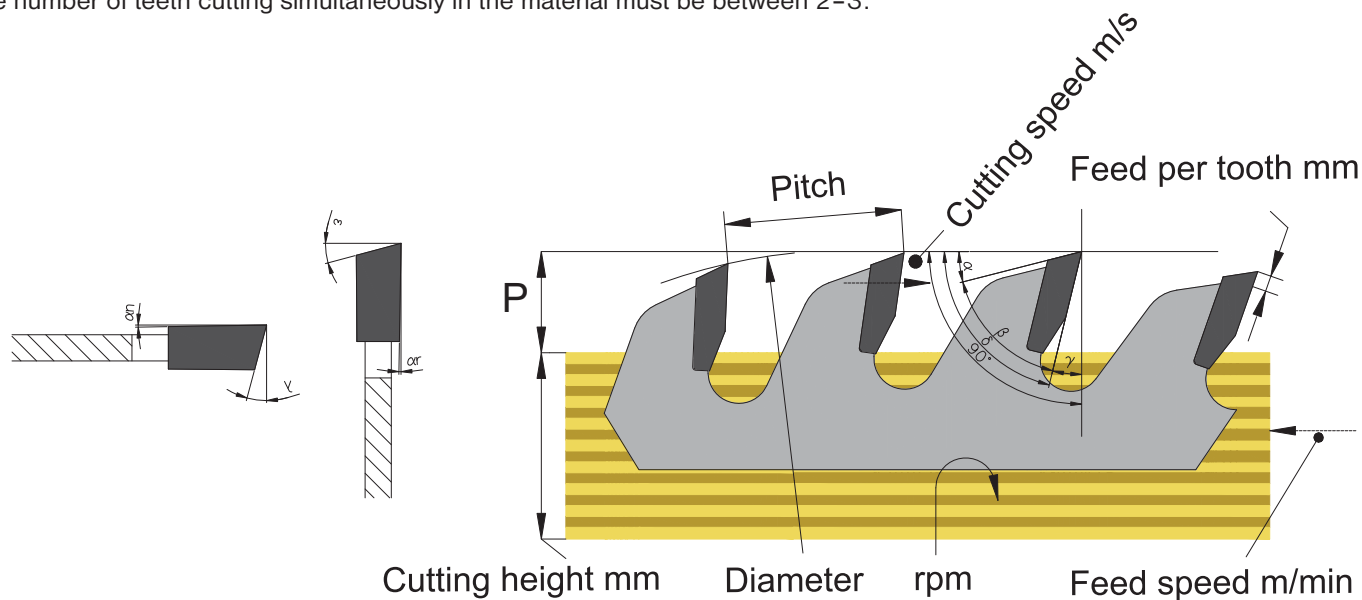
Hardness

Tenacity

Saw Blade Alignment on a Table Saw

In order to reach the best performance of a saw blade, the overhang of the saw blade teeth over the cutting material must be equal to the height of the tungsten tip (see P in picture no. 1).

The number of teeth cutting simultaneously in the material must be between 2-3.



Pict. no. 1

Tab. no. 1

| Recommended values of feed/tooth | | |
|----------------------------------|-----------------------|------------------|
| Cutting speed | Feed speed (mm/tooth) | Material |
| 60-100 | 0,1-0,35 | dry transverse |
| 60-100 | 0,15-0,5 | dry longitudinal |
| 50-90 | 0,06-0,15 | hard wood |
| 60-100 | 0,6-1,5 | pre-saw |
| 60-80 | 0,05-0,12 | laminated |
| 60-90 | 0,05-0,15 | veneer |
| 50-80 | 0,1-0,3 | chipboard |
| 50-70 | 0,05-0,12 | plastic |
| 50-80 | 0,03-0,1 | plexi, bakelite |
| 30-70 | 0,03-0,15 | plastic profile |
| 30-70 | 0,01-0,08 | aluminium |
| 7-20 | 0,02-0,05 | copper |
| 40-60 | 0,1-0,3 | heraclitus |
| 50-70 | 0,1-0,25 | plasterboard |
| 50-80 | 0,05-0,25 | plywood |
| 50-70 | 0,05-0,12 | corian |
| 60-90 | 0,05-0,25 | MDF,HDF |
| 15-60 | 0,02-0,1 | aluminium alloys |
| 50-70 | 0,02-0,1 | HPL |
| 20-45 | 0,07-0,15 | mineral woold |
| 3-10 | 0,02-0,08 | bronze |
| 50-70 | 0,1-0,3 | paper |
| 40-60 | 0,03-0,1 | cement board |
| 25-35 | 0,01-0,02 | dry cut |

| Index of angles in a saw blade | |
|--------------------------------|------------------------------|
| α | clearance angle |
| αn | tangential clearance angle |
| αr | radial clearance angle |
| β | wedge angle |
| γ | hook angle |
| δ | cut angle = $\alpha + \beta$ |
| λ | shear angle |
| ϵ | bevel angle |

Tab. no. 2 Cutting speed m/s

| D [mm] | RPM | | | | | | | | | | | | | | |
|-----------|------|------|------|------|------|------|------|------|-------|-------|------|------|-------|-------|-------|
| | 1500 | 2000 | 2500 | 2850 | 3000 | 4000 | 4500 | 5000 | 5600 | 6000 | 8000 | 9000 | 10000 | 12000 | 18000 |
| ø 80 | 6,5 | 8,5 | 10,5 | 12 | 13 | 17 | 19 | 21 | 23,5 | 26 | 34 | 38 | 42 | 52 | 76 |
| ø 90 | 7 | 9,5 | 12 | 13,5 | 14 | 19 | 21 | 24 | 26,5 | 28 | 38 | 42 | 48 | 56 | 84 |
| ø 100 | 8 | 10,5 | 13 | 15 | 16 | 21 | 24 | 26 | 29 | 32 | 42 | 48 | 52 | 54 | 96 |
| ø 120 | 9,5 | 13 | 16 | 18 | 19 | 26 | 28 | 32 | 35 | 38 | 52 | 56 | 64 | 76 | 112 |
| ø 125 | 10 | 13,5 | 16,5 | 18,5 | 19,5 | 27 | 29 | 33 | 36,5 | 39 | 54 | 59 | 66 | 78 | 118 |
| ø 140 | 11 | 15 | 18 | 21 | 22 | 30 | 33 | 36 | 41 | 44 | 60 | 66 | 72 | 88 | 132 |
| ø 150 | 12 | 15,5 | 19,5 | 22,5 | 23,5 | 31,5 | 33,5 | 39 | 44 | 47 | 63 | 70,5 | 78,5 | 94,5 | 141,5 |
| ø 160 | 13 | 17 | 21 | 24 | 26 | 34 | 38 | 42 | 48 | 52 | 68 | 76 | 84 | 104 | 152 |
| ø 180 | 14 | 19 | 24 | 27 | 28 | 38 | 42,5 | 48 | 53 | 56 | 76 | 85 | 96 | 118 | 170 |
| ø 200 | 16 | 21 | 26 | 30 | 32 | 42 | 47 | 52 | 58,5 | 64 | 84 | 94 | 104 | 128 | 188 |
| ø 225 | 18 | 24 | 30 | 33,5 | 36 | 48 | 58 | 60 | 66 | 72 | 96 | 106 | 120 | 144 | 212 |
| ø 250 | 20 | 26 | 33 | 37 | 40 | 52 | 59 | 66 | 73,5 | 80 | 104 | 118 | 132 | 160 | 236 |
| ø 300 | 24 | 31,5 | 40 | 45 | 48 | 63 | 71 | 80 | 88 | 96 | 126 | 142 | 160 | 192 | 284 |
| ø 350 | 28 | 36,5 | 47 | 52 | 56 | 73 | 88 | 94 | 105 | 112 | 146 | 166 | 188 | 224 | 332 |
| ø 400 | 32 | 42 | 54 | 60 | 64 | 84 | 94 | 108 | 117 | 128 | 168 | 188 | 216 | 256 | 376 |
| ø 450 | 35,5 | 47 | 59 | 67,5 | 70,5 | 94,5 | 106 | 118 | 132 | 141,6 | 188 | 211 | 236 | 283 | 424 |
| ø 500 | 40 | 53 | 67 | 74,5 | 80 | 106 | 118 | 134 | 146,5 | 160 | 212 | 236 | 268 | 320 | 472 |

Tab. no. 2 shows the maximum RPM of circular saw blade based on the diameter of the blade. RPM referring to cutting speed 100 m/sec. These are the maximum recommended RPM by the machine producer. When exceeding this limit, the blade may lose its characteristics and danger to user may occur.

Tab. no. 3

| D [mm] | Recommended RPM [1/min] | | | | | | | | | |
|-----------|-----------------------------|------|------|------|------|-------|-------|-------|-------|-------|
| | Cutting speed v_c [m/sec] | | | | | | | | | |
| | 10 | 20 | 30 | 40 | 50 | 60 | 70 | 80 | 90 | 100 |
| 100 | 1910 | 3820 | 5730 | 7640 | 9550 | 11460 | 13370 | 15280 | 17190 | 19100 |
| 150 | 1270 | 2550 | 3820 | 5100 | 6370 | 7640 | 8920 | 10190 | 11500 | 12730 |
| 200 | 960 | 1910 | 2870 | 3820 | 4780 | 5730 | 6690 | 7640 | 8600 | 9550 |
| 250 | 760 | 1530 | 2290 | 3060 | 3820 | 4590 | 5350 | 6110 | 6880 | 7640 |
| 300 | 640 | 1270 | 1910 | 2550 | 3180 | 3820 | 4460 | 5100 | 5740 | 6370 |
| 350 | 550 | 1090 | 1640 | 2180 | 2730 | 3280 | 3820 | 4370 | 4900 | 5460 |
| 400 | 480 | 960 | 1430 | 1910 | 2390 | 2870 | 3340 | 3820 | 4300 | 4780 |
| 450 | 430 | 850 | 1270 | 1700 | 2120 | 2550 | 2970 | 3400 | 3820 | 4250 |
| 500 | 380 | 760 | 1150 | 1530 | 1910 | 2290 | 2680 | 3060 | 3440 | 3820 |
| 550 | 350 | 690 | 1040 | 1390 | 1740 | 2080 | 2430 | 2780 | 3120 | 3470 |
| 600 | 320 | 640 | 960 | 1270 | 1590 | 1910 | 2230 | 2550 | 2880 | 3180 |
| 650 | 290 | 590 | 880 | 1180 | 1470 | 1760 | 2060 | 2350 | 2640 | 2940 |
| 700 | 270 | 550 | 820 | 1090 | 1360 | 1640 | 1910 | 2180 | 2450 | 2730 |
| 750 | 250 | 510 | 760 | 1020 | 1270 | 1530 | 1780 | 2040 | 2290 | 2550 |
| 800 | 240 | 480 | 720 | 950 | 1190 | 1430 | 1670 | 1910 | 2150 | 2390 |

$$v_c = \frac{D \times \pi \times n}{1000 \times 60}$$

$$n = \frac{1000 \times 60 \times v_c}{D \times \pi}$$

$$s = \frac{s_z \times n \times z}{1000}$$

Here are some useful formulas to help you calculate the correct number of teeth on saw blades:

$$t = \frac{h \times 1,45}{k}$$

$$z = \frac{D \times \pi}{t}$$

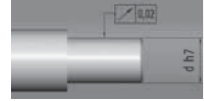
Key:

- t [mm] – tooth pitch
- h [mm] – thickness of the work piece
- k [-] – number of teeth in cutting place (2÷3)
- z [-] – number of teeth of the saw blade
- D [mm] – sawblade diameter

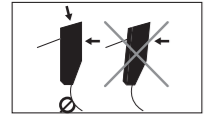


INSTRUCTIONS HOW TO USE SAW BLADES CORRECTLY

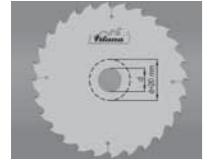
We recommend to follow the below rules in order to reach the best cutting results:



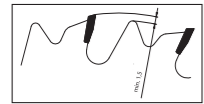
Pict. no. 2



Pict. no. 3



Pict. no. 4

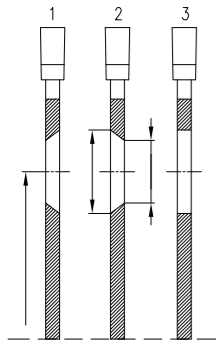


Pict. no. 5

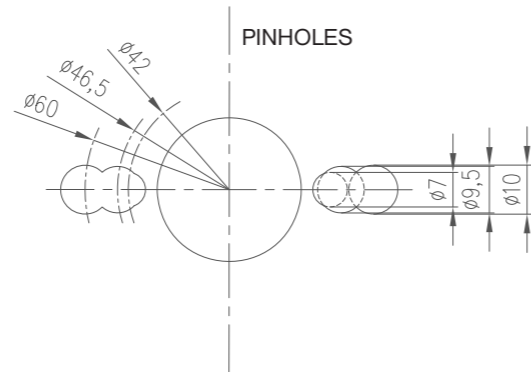
- Machine must be in good condition without vibrations

| Recommended Diameters for Flange | | | | |
|----------------------------------|-----|-----------|-----------|-----------|
| Diameter of Saw Blade (mm) | 200 | 250 - 300 | 350 - 450 | 500 - 700 |
| Flange Diameter (mm) | 70 | 80 - 100 | 100 - 140 | 140 - 160 |

- Flanges must be clean and it is important to check their side run - out
- Check the spindle of the machine. It must be absolutely straight (picture 2)
- Tips must always be sharpened with the original angles
- See the most appropriate way of sharpening (picture 3)
- If rebored by over 20mm, the blade loses its original features and its stability (picture 4)
- In saw blades with chip limiter, it is necessary to grind the TCT and the chip limiter to keep the oversize of the TCT (picture 5)



- TYPE 1
Countersink right
- TYPE 2
Countersink left
- TYPE 3
Pinhole without countersink



FREQUENTLY ASKED QUESTIONS

| | |
|---|---|
| WHAT CAN I DO TO OBTAIN BETTER CUTTING SURFACE FINISH? | Choose saw blade with more teeth |
| | Use higher peripheral speed |
| | Select saw blade with different tooth shape |
| | Check flanges and distances |
| | Check condition of spindle bearing |
| BLADE IS VERY NOISY, ESPECIALLY WHEN IDLING, WHY? | Blade goes into oscillation (self-vibration) |
| | Change number of teeth and diameter |
| | Adjust speed of revolutions if possible |
| | Choose sound absorbing saw blade |
| | A coating of sound absorbing material on the inside of the safety cover. |
| HOW TO AVOID CHIPPING OUT ON THE BOTTOM SIDE OF THE MATERIAL? | Use saw blade with more teeth |
| | Saw blade is positioned too high above cutting material |
| | Choose different tooth shape and angles |
| WHY DOES SAW BLADE WOBBLE WHEN WARM? | During cutting saw blade becomes warm, especially on the periphery, which causes its expansion and stretching. Adding expansion slots improves blade's properties |
| HOW TO AVOID BLADE CHOPPING WHEN CUTTING ALUMINIUM? | When using manual feed, negative hook angle results in softer cut, saw blade with more teeth also results in softer cutting edge |
| | Positive hook angle is used in automatic feed, saw blade with more teeth results in softer cutting edge |

TROUBLESHOOTING CHART

| Problem | Possible cause | Action |
|---|--|--|
| Saw blade wobbles | Thickness of the tool body is too small | Select saw blade with large kerf or smaller diameter or increase flange diameter |
| | Insufficient tooth projection over tool body (saw blade jams in the cut, runs hot, tension lost) | Select saw blade with higher lateral tooth projection |
| | Resin/chips on the flanges | Clean flanges |
| | Flange run out tolerance too high | Check and correct flange |
| | Defective motor spindle bearing | Replace motor spindle bearing |
| | Tooth pitch and gullet too small | Select saw blade with higher tooth pitch |
| | Unbalanced saw blade | Balance saw blade |
| | Blunt cutting edges | Resharpen saw blade |
| | Wrong saw blade tensioning | Correct saw blade tensioning |
| Wavy cut | Irregular tooth pitch or one sided cut | Correct sharpening machine adjustment, resharpen saw blade |
| | Irregular tooth thickness | Check and correct saw blade kerf |
| | Saw blade is blunt, resin build up | Clean and resharpen saw blade |
| | Position of fence not parallel to feed direction | Check and adjust position |
| | One sided load from edge cutting | Use edging saw blade (hogger) |
| | Cutting speed too low | Select larger saw blade diameter or increase RPM |
| | Wrong saw blade tensioning | Correct saw blade with larger gullet |
| Jamming of saw blade when cutting | Slot in saw bed is too thin, insufficient chip outflow | Replace/widen saw bed |
| | Riving knife width is too thin | Replace riving knife |
| | Gullet too small | Choose saw blade with larger gullet |
| Curved cut when double edging | Saw blade's sharpening is one sided | Resharpen kerf of saw blade |
| | Resin and glue on rollers | Clean and resharpen rollers |
| | Differences in wood thickness | Improvements necessary at customer |
| | Too high cutting forces on one side | Optimize cutting force division |
| | Worn conveyor belt guide | Check and adjust chain guide |
| | Short and uneven workpieces | Comply with minimum workpiece length required by the machine manufacturer's instructions |
| | When machining piece by piece | Pay attention to angular cut off work pieces |
| Exceeded tolerances of horizontally cut lamellas | Sawblade tensioning not suitable for horizontal application | Check saw blade tensioning |
| | High resin build up on saw blade body, it runs very hot from friction in cut | Clean saw blade and check if blunt |
| | Thickness and position of riving knife not adjusted to dimensions of strips and saw blade kerf | Use riving knife dimension matching saw blade kerf. Adjust riving knife spacing to correspond to thickness of strips |
| Tear outs in workpieces coated on both sides when machining without scoring saw | Saw blade projection over workpiece too small or too big | Check and adjust saw blade protection |
| | Tooth shape or number of teeth not suitable for the application | Select saw blade suitable for the application |
| | Concentric running tolerances of saw blade too high | Have saw blade checked by PILANA service |
| | Flange used on machine does not correspond to guidelines for flange diameter and concentric running tolerances | Check flanges and clean them. If there is wrong ratio of saw blade diameter to flange diameter, adjust accordingly |
| Tear outs on panel coating when cutting in stacks | Tool is blunt | Resharpen main saw blade |
| | Pressure beam cannot press evenly on uneven workpieces | Check pressing forces of pressure beam |
| Tear outs where tool leaves workpiece when cutting in stacks | Kerf of scoring saw blade is too small for main saw blade in use | Adjust kerf of scoring saw blade to main saw blade accordingly |

Symbol Index



tooth pitch



euro pinholes



low noise slots



low noise slots



type of grade



type of grade



type of grade



side balance



side balance

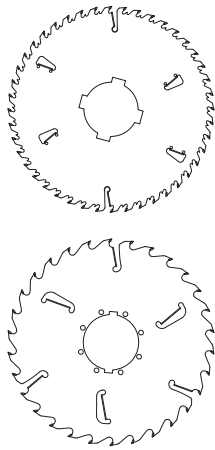
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Primary Wood Processing

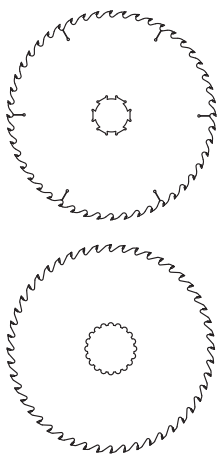




LINCK Machines

- » designed for Linck machines in automated lines for primary wood processing
- » made to fit customer's requirements
- » table below contains only examples of saw blades we produce

| D | S | s | d | z | teeth | ●/○ |
|-----|-----|-----------|-----|--------|--------|-----|
| 390 | 3,8 | 2,4 | 140 | 24 + 4 | FZ | ○ |
| 440 | 4,6 | 3,2 | 150 | 28 + 4 | FZ | ○ |
| 460 | 4,4 | 2,8 | 150 | 24 + 4 | FZ | ○ |
| 460 | 4,0 | 2,6 | 150 | 28 + 4 | FZ | ○ |
| 490 | 5,6 | 4,0 | 150 | 36 + 6 | FZ | ○ |
| 505 | 5,2 | 3,8 - 6,8 | 120 | 28 + 4 | FZ L+P | ○ |
| 535 | 4,2 | 2,8 | 120 | 40 + 4 | FZ | ○ |
| 540 | 3,6 | 2,7 - 5,7 | 150 | 30 + 6 | FZ L+P | ○ |
| 540 | 3,8 | 2,6 | 150 | 36 + 6 | FZ | ○ |
| 630 | 5,2 | 3,8 - 4,5 | 150 | 24 + 6 | FZ L+P | ○ |
| 630 | 5,2 | 3,8 - 7,0 | 150 | 24 + 6 | FZ L+P | ○ |



ARI VISLANDA, USNR/SCHURMAN, SÖDERHAMN ERIKSSON

- » designed for automated lines for primary wood processing
- » made to fit customer's requirements
- » table below contains only examples of saw blades we produce

| D | S | s | d | z | teeth | ●/○ |
|------|-----|-----|------|----|-------|-----|
| 500 | 5,0 | 3,5 | spl* | 60 | WZ | ○ |
| 600 | 4,4 | 3,2 | spl* | 48 | FZ | ○ |
| 610 | 4,2 | 2,8 | spl* | 40 | FZ | ○ |
| 640 | 3,4 | 2,6 | spl* | 20 | FZ | ○ |
| 700 | 4,2 | 2,8 | spl* | 42 | FZ | ○ |
| 710 | 4,2 | 2,8 | spl* | 56 | FZ | ○ |
| 1000 | 4,8 | 3,6 | spl* | 60 | FZ | ○ |

* spline bore

HEINOLA Machines

- » designed for Heinola machines in automated lines for primary wood processing
- » made to fit customer's requirements
- » table below contains only examples of saw blades we produce

| D | S | s | d | z | teeth | ●/○ |
|-----|-----|-----|-----|--------|-------|-----|
| 556 | 4,2 | 2,8 | 160 | 32 + 4 | FZ | ○ |
| 556 | 4,6 | 3,2 | 160 | 32 + 4 | FZ | ○ |
| 556 | 4,6 | 3,2 | 160 | 33 + 6 | FZ | ○ |
| 600 | 4,6 | 3,2 | 200 | 42 + 6 | FZ | ○ |

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

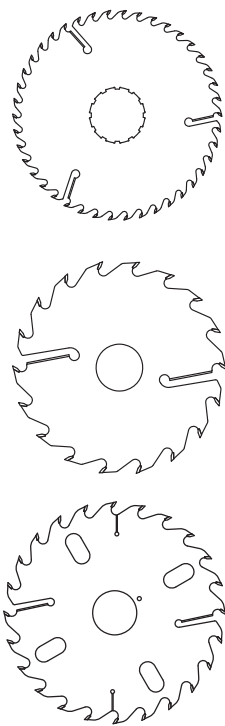


HEW SAW Machines

- » designed for Hew Saw machines in automated lines for primary wood processing
- » made to fit customer's requirements
- » table below contains only examples of saw blades we produce

Pre-saw Blades

| D | S | s | d | z | teeth | ●/○ |
|-----|-----|------------|-----|----|--------|-----|
| 345 | 4,1 | 3,1 - 10,7 | 144 | 36 | FZ L+P | ○ |
| 345 | 6,4 | 5,0 - 10,7 | 144 | 36 | FZ L+P | ○ |
| 390 | 4,5 | 3,7 - 8,7 | 190 | 39 | FZ L+P | ○ |
| 460 | 4,5 | 3,3 - 8,7 | 240 | 42 | FZ L+P | ○ |



Rip Saw Blades

| D | S | s | d | z | teeth | ●/○ |
|-----|-----|-----|-----|--------|-------|-----|
| 251 | 4,0 | 2,8 | 55 | 18 + 2 | FZ | ○ |
| 351 | 3,4 | 2,2 | 70 | 24 + 2 | FZ | ○ |
| 351 | 3,2 | 2,0 | 70 | 30 + 3 | FZ | ○ |
| 401 | 4,0 | 2,8 | 100 | 42 + 3 | TFZ | ○ |
| 450 | 4,2 | 3,0 | 99 | 24 + 4 | FZ | ○ |
| 500 | 4,5 | 3,2 | 99 | 32 + 6 | FZ | ○ |

Edging Saw Blades

| Norm | D | S | s | d | z | teeth |
|------|-----|-----|-----|-----|------|---------|
| 81 | 350 | 5 | 3,6 | 150 | 36 | FZ (WZ) |
| 81 | 350 | 5 | 3,6 | 150 | 56 | FZ (WZ) |
| 94.1 | 400 | 5,2 | 3,8 | 146 | 40+4 | FZ (WZ) |
| 94.1 | 400 | 5 | 3,6 | 146 | 46+4 | FZ (WZ) |
| 94.2 | 400 | 5,5 | 4 | 146 | 50+4 | FZ (WZ) |

We produce circular saw blades for machines of all established wood-processing machine manufacturers.

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

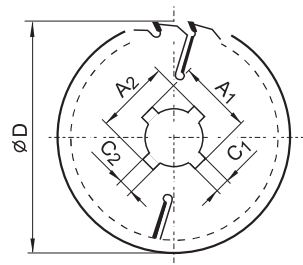
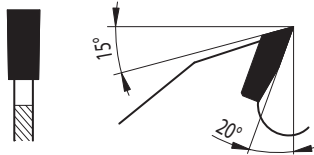
Material: Natural solid – soft and hard wood
Application: Multirip sawing of massive natural woods
Machine: Multirip saw, for single shaft, double shaft and splitting machine

94 FZ +2



- » universal rip saw blades for longitudinal cutting of all types of wood, dry and wet, with standard quality cutting edge and lower height of the cut
- » application: for multirip machines for primary processing of wood and pallet production

| D | S | s | d | z | h _{max} | d _{p max} | ●/○ | Bore | C1xA1 | C2xA2 |
|-----|-----|-----|----------|------|------------------|--------------------|-----|------|-------|-------|
| 180 | 2,6 | 1,6 | 30 | 16+2 | 40 | 60 | ○ | 70 | 13x80 | 20x83 |
| 200 | 2,8 | 1,8 | 30 | 16+2 | 40 | 100 | ○ | 75 | 14x85 | 22x90 |
| 250 | 3,6 | 2,5 | 70,80 | 16+2 | 50 | 130 | ● | 80 | 14x90 | 22x93 |
| 300 | 4,0 | 2,8 | 70,80 | 18+2 | 70 | 130 | ● | | | |
| 315 | 4,0 | 2,8 | 80 | 18+2 | 70 | 150 | ● | | | |
| 350 | 4,0 | 2,8 | 70,75,80 | 20+2 | 75 | 180 | ● | | | |
| 400 | 4,0 | 2,8 | 80 | 24+2 | 80 | 210 | ● | | | |

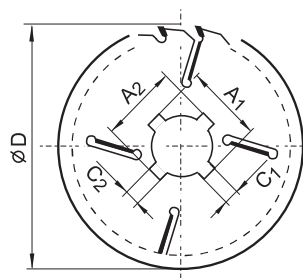
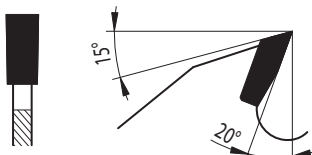


94.1 FZ +2+2



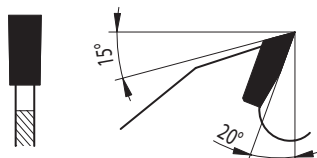
- » universal rip saw blades for longitudinal cutting of all types of wood, dry and wet, with standard quality cutting edge and lower height of the cut
- » application: for multirip machines for primary processing of wood and pallet production

| D | S | s | d | z | h _{max} | d _{p max} | ●/○ | Bore | C1xA1 | C2xA2 |
|-----|-----|-----|----------|--------|------------------|--------------------|-----|------|-------|-------|
| 250 | 3,2 | 2,2 | 70,80 | 16+2+2 | 60 | 105 | ● | 70 | 13x80 | 20x83 |
| 300 | 3,2 | 2,2 | 70,80 | 18+2+2 | 80 | 120 | ● | 75 | 14x85 | 22x90 |
| 300 | 3,2 | 2,2 | 30 | 24+2+2 | 80 | 120 | ● | 80 | 14x90 | 22x93 |
| 315 | 3,2 | 2,2 | 70,80 | 18+2+2 | 85 | 120 | ● | | | |
| 350 | 3,6 | 2,5 | 70,75,80 | 20+2+2 | 105 | 120 | ● | | | |
| 350 | 3,6 | 2,5 | 30 | 24+2+2 | 105 | 120 | ● | | | |
| 400 | 4,0 | 2,8 | 30 | 18+2+2 | 120 | 145 | ● | | | |
| 400 | 4,0 | 2,8 | 70,80 | 24+2+2 | 120 | 145 | ● | | | |
| 450 | 4,4 | 3,2 | 30 | 20+2+2 | 135 | 160 | ● | | | |
| 450 | 4,4 | 3,2 | 70,80 | 28+2+2 | 135 | 160 | ● | | | |
| 500 | 4,4 | 3,2 | 30 | 22+2+2 | 150 | 180 | ● | | | |
| 500 | 4,4 | 3,2 | 70 | 28+2+2 | 150 | 180 | ● | | | |



In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

The central bore of all saw blades can be enlarged up to: $d_{max} = d_{p max} - 30 \text{ mm}$

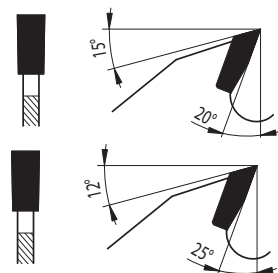
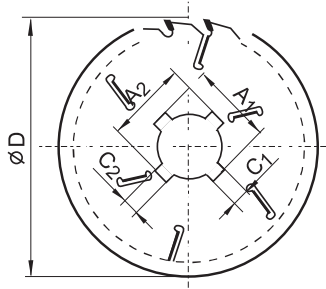


94.1 FZ +2+2+2



- » universal rip saw blades for longitudinal cutting of all types of wood, dry and wet, with a standard quality of the cutting edge
- » 6 wiper slots enable excellent saw stability even when cutting very long round pieces of wood or prisms
- » application: for multirip machines for primary processing of wood and pallet production

| D | S | s | d | z | h _{max} | d _{p max} | ●/○ |
|-----|-----|-----|----|----------|------------------|--------------------|-----|
| 400 | 4,0 | 2,8 | 30 | 24+2+2+2 | 130 | 125 | ● |
| 400 | 4,0 | 2,8 | 30 | 28+2+2+2 | 130 | 125 | ○ |
| 450 | 4,4 | 3,2 | 30 | 20+2+2+2 | 150 | 130 | ● |
| 500 | 4,4 | 3,2 | 30 | 22+2+2+2 | 175 | 130 | ● |
| 550 | 5,0 | 3,5 | 30 | 24+2+2+2 | 195 | 150 | ● |
| 550 | 5,0 | 3,5 | 30 | 32+2+2+2 | 195 | 150 | ● |
| 600 | 5,0 | 3,5 | 30 | 26+2+2+2 | 205 | 170 | ● |



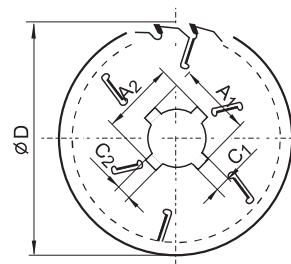
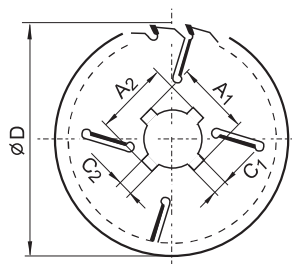
94.1 FZ – MASSIVE



- » extra strong multirip saw blades for longitudinal cutting of all types of wood, dry and wet, with a standard quality of the cutting edge. Designed for extreme cutting conditions thanks to the very stable and massive saw body which eliminates side strain and ensures stability of the saw blade

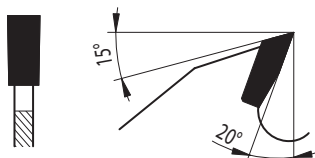
| D | S | s | d | z | h _{max} | d _{p max} | ●/○ | Bore | C1xA1 | C2xA2 |
|-----|-----|-----|----------|----------|------------------|--------------------|-----|------|-------|-------|
| 315 | 4,0 | 2,8 | 70,80 | 18+2+2 | 90 | 120 | ● | 70 | 13x80 | 20x83 |
| 350 | 4,0 | 2,8 | 70,75,80 | 20+2+2 | 105 | 120 | ● | 75 | 14x85 | 22x90 |
| 400 | 4,2 | 3,0 | 30 | 20+2+2 | 120 | 145 | ● | 80 | 14x90 | 22x93 |
| 450 | 5,0 | 3,5 | 30 | 20+2+2 | 135 | 160 | ● | | | |
| 500 | 5,0 | 3,5 | 30 | 22+2+2+2 | 175 | 130 | ● | | | |
| 550 | 5,5 | 3,5 | 30 | 24+2+2+2 | 190 | 150 | ● | | | |

| D | S | s | d | z | h _{max} | d _{p max} | ●/○ |
|-----|-----|-----|----|------------|------------------|--------------------|-----|
| 600 | 6,2 | 4,0 | 30 | 26+2+2+2 | 205 | 170 | ● |
| 700 | 6,5 | 4,5 | 30 | 28+2+2+2 | 235 | 210 | ● |
| 800 | 7,5 | 5,0 | 30 | 24+2+2+2+2 | 300 | 170 | ● |



In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

The central bore of all saw blades can be enlarged up to: $d_{max} = d_{p max} - 30 \text{ mm}$

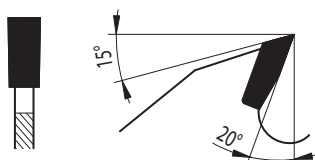


94.1 FZ – MASSIVE plus



» extra strong multirip saw blades for longitudinal cutting of all types of wood, dry and wet, with a standard quality of the cutting edge. Designed for extreme cutting conditions thanks to a very stable and massive saw body which eliminates side strain and ensures stability of the saw blade

| D | S | s | d | z | h _{max} | d _{p max} | ●/○ |
|-----|-----|-----|----|--------|------------------|--------------------|-----|
| 300 | 5,0 | 3,5 | 30 | 18+2+2 | 90 | 105 | ● |
| 320 | 5,0 | 3,5 | 30 | 18+2+2 | 100 | 105 | ● |
| 350 | 5,0 | 3,5 | 30 | 18+2+2 | 110 | 105 | ○ |
| 400 | 5,0 | 3,5 | 30 | 20+2+2 | 120 | 145 | ○ |
| 450 | 5,5 | 3,5 | 30 | 20+2+2 | 145 | 140 | ○ |



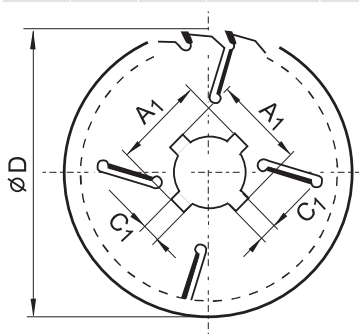
94.1 FZ – TOS, RAIMANN, COSTA



» specially constructed multirip saw blades for longitudinal cutting of all types of wood, dry and wet, with a standard quality of the cutting edge for multirip machines by TOS SVITAVY

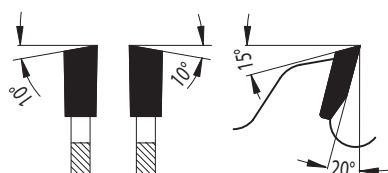
» possibility to rip wood up to the clamping flange of the saw blade without losing body stability of the saw blade with a large side strain and thus ensuring maximum utilisation of the machine. With spiral design of the keyways, it also offers the possibility of a smoother entering into the cut

| D | S | s | d | z | h _{max} | d _{p max} | ●/○ | Bore | 4x C1x A1 |
|-----|-----|-----|----|--------|------------------|--------------------|-----|------|-----------|
| 300 | 3,2 | 2,2 | 80 | 18+2+2 | 90 | 105 | ● | 80 | 13x90 |
| 320 | 3,2 | 2,2 | 80 | 18+2+2 | 100 | 105 | ● | | |
| 350 | 4,0 | 2,8 | 80 | 18+2+2 | 115 | 105 | ● | | |
| 400 | 4,0 | 2,8 | 80 | 20+2+2 | 140 | 105 | ● | | |
| 450 | 4,4 | 3,2 | 80 | 24+2+2 | 165 | 105 | ● | | |



In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

The central bore of all saw blades can be enlarged up to: $d_{max} = d_{p max} - 30 \text{ mm}$

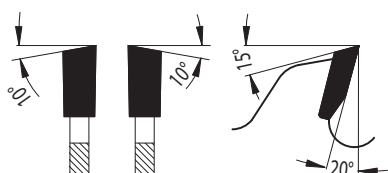


94.1 WZ – TOS, RAIMANN, COSTA



- » specially designed multirip saw blades for longitudinal cutting of all types of wood, dry and wet
- » possibility to rip wood up to the maximum bore of the saw blade without losing body stability of the saw blade with a large side strain. Thereby the maximum utilisation of the machine is ensured
- » with its design of the wiper slots, it also offers the possibility of a smoother entering into the cut
- » WZ geometry ensures a smooth, stable cut with a superior quality of the cutting edge and electric energy savings
- » It is suitable to use in higher quality type of wood

| D | S | s | d | z | h _{max} | d _{p max} | ●/○ | Bore | 4x C1xA1 |
|-----|-----|-----|--------|--------|------------------|--------------------|-----|------|----------|
| 300 | 3,2 | 2,2 | 30 | 18+2+2 | 90 | 105 | ● | 80 | 13x90 |
| 320 | 3,2 | 2,2 | 30 | 18+2+2 | 100 | 105 | ● | | |
| 350 | 3,6 | 2,5 | 30, 80 | 18+2+2 | 115 | 105 | ● | | |
| 400 | 3,6 | 2,5 | 30 | 20+2+2 | 140 | 105 | ● | | |
| 450 | 4,0 | 2,8 | 30 | 24+2+2 | 165 | 105 | ● | | |



94.1 WZ

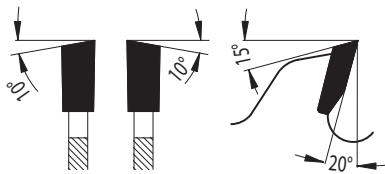


- » universal rip saw blades for longitudinal cutting of all types of wood, dry and wet, with a standard quality of the cutting edge
- » WZ geometry ensures fluent and stable cut with high quality cutting edge and energy savings
- » used in multirip saw machines for primary wood processing and production of palets
- » suitable for mounting on bottom shaft of multirip saw machine

| D | S | s | d | z | h _{max} | d _{p max} | ●/○ |
|-----|-----|-----|----|----------|------------------|--------------------|-----|
| 300 | 3,2 | 2,2 | 30 | 24+2+2 | 80 | 120 | ○ |
| 350 | 4,0 | 2,8 | 30 | 24+2+2 | 105 | 120 | ○ |
| 400 | 4,0 | 2,8 | 30 | 28+2+2+2 | 130 | 125 | ○ |

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

The central bore of all saw blades can be enlarged up to: $d_{max} = d_{p max} - 30 \text{ mm}$

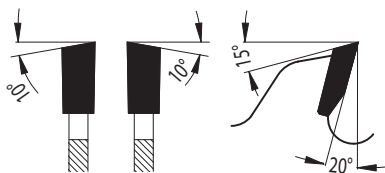


94.1 WZ – EFFECTIVE



- » thin multirip saw blades for longitudinal cutting of all types of wood, especially planks and stronger boards. Decrease in weight will positively show in energy savings and increased yield
- » WZ tooth geometry ensures a smooth, stable cut with a superior quality of the cutting edge, it is suitable for use in higher quality type of wood
- » application: for multirip machines

| D | S | s | d | z | h _{max} | d _{p max} | ●/○ |
|-----|-----|-----|----|----------|------------------|--------------------|-----|
| 250 | 2,7 | 1,8 | 30 | 20+2+2 | 65 | 110 | ● |
| 300 | 2,7 | 1,8 | 30 | 24+2+2 | 80 | 120 | ● |
| 350 | 3,5 | 2,5 | 30 | 24+2+2+2 | 105 | 120 | ● |



94.1 Angle Tilting Saws



- » specially designed rip saw blades for angle tilting saws
- » the number of teeth is calculated for the maximum cutting height
- » clearance teeth exactly match the flange of individual machine types which eliminates cracking of saw blades while ensuring maximum amount of chip removal from the cut
- » the reinforcement and thermal treatment of the saw blades ensures their perfect action in the horizontal cut conditions
- » the tooth geometry is optimised for maximum cutting speed of the saw blades

STROJCAD - WZ

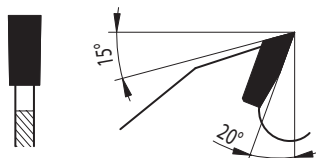
| D | S | s | d | z | h _{max} | ●/○ |
|-----|-----|-----|---------------|----------|------------------|-----|
| 400 | 4,2 | 3,0 | 30 + 6/17/96 | 20+2+2 | 120 | ● |
| 400 | 4,2 | 3,0 | 55 + 6/17/112 | 20+2+2 | 120 | ● |
| 450 | 5,0 | 3,5 | 55 + 6/17/112 | 20+2+2 | 145 | ● |
| 500 | 5,2 | 3,5 | 30 + 6/17/96 | 22+2+2+2 | 170 | ● |
| 500 | 5,2 | 3,5 | 55 + 6/17/112 | 22+2+2+2 | 170 | ● |
| 550 | 5,5 | 3,5 | 30 + 6/17/96 | 24+2+2+2 | 205 | ● |
| 550 | 5,5 | 3,5 | 55 + 6/17/112 | 24+2+2+2 | 195 | ● |

WEP - FZ

| D | S | s | d | z | h _{max} | ●/○ |
|-----|-----|-----|---------------------|----------|------------------|-----|
| 500 | 5,0 | 3,5 | 30+8/11/100+2/10/60 | 22+2+2+2 | 155 | ● |
| 500 | 5,0 | 3,5 | 30+8/11/150+2/10/60 | 22+2+2+2 | 155 | ● |
| 550 | 5,5 | 3,5 | 30+8/11/100+2/10/60 | 24+2+2+2 | 180 | ● |
| 550 | 5,5 | 3,5 | 30+8/11/150+2/10/60 | 24+2+2+2 | 180 | ● |

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

We can produce in dimensions from $\varnothing 150$ to $\varnothing 1000$.



94.2 LFZ



- » longitudinal cutting of soft and hard woods
- » trimming saw, multirip saw, joining saw
- » saw blade geometry includes a chip thickness limiter

| D | B | b | d | z | h _{max} | d _{p max} | ●/○ |
|-----|-----|-----|----|--------|------------------|--------------------|-----|
| 250 | 3,2 | 2,2 | 30 | 18+3 | 55 | 115 | ● |
| 300 | 3,2 | 2,2 | 30 | 18+3 | 75 | 130 | ● |
| 350 | 3,6 | 2,5 | 30 | 20+2+2 | 110 | 110 | ● |
| 400 | 4,0 | 2,8 | 30 | 24+2+2 | 125 | 120 | ● |

94.3 Saw Blade with Reinforced Centre



94.4 Tempered Unpolished Body with Intermediate Tooth



Heat and Surface Treatment of Saw Blades

Special tempering:

- » thermal treatment of saw blades made on customer's request
- » prevents the occurrence of cracks and tears in the body of the saw blade especially in hard cutting conditions
- » increases the lifespan of the saw blade

Black coating:

- » increases the saw blade lifespan by up to 20% compared to untreated TCT saw blade
- » treatment of saw blades is made on customer's request
- » thin chemical layer of black colour on the saw blade surface made by oxidizing

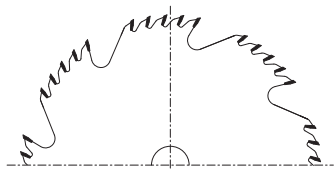
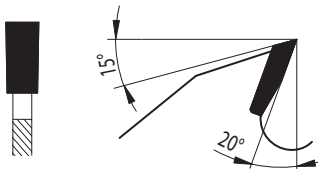
Material: Solid natural wood
Application: Cutting of woods of massive dimensions
Machine: Machine feed

33.1 FZ



- » along the grain cutting of massive wood dimensions
- » machine feed

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----|-----|
| 600 | 5,5 | 3,5 | 30 | 40 | ● |
| 700 | 5,5 | 3,5 | 35 | 40 | ● |
| 800 | 6,5 | 4,5 | 35 | 40 | ● |

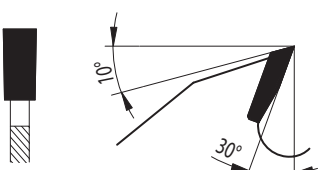


LUCAS or ECOPRO



- » along the grain cutting of massive wood dimensions
- » suitable for manual and automatic feed

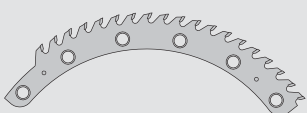
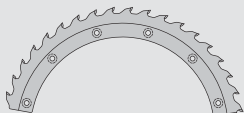
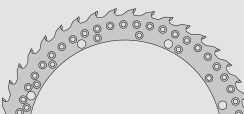
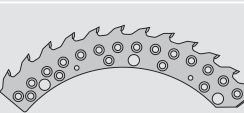
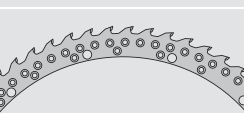
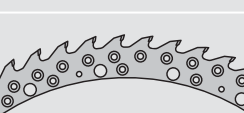
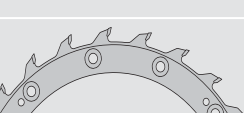
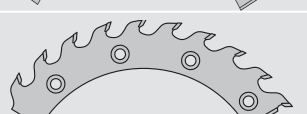
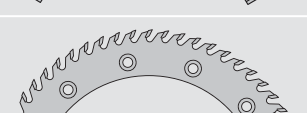
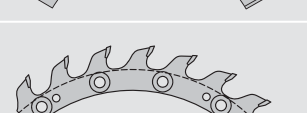
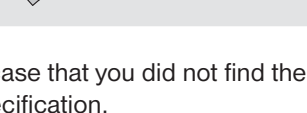
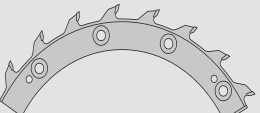
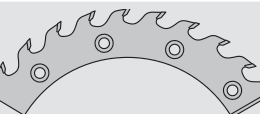


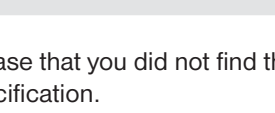
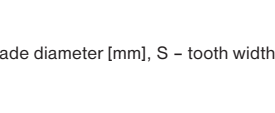

| D | S | s | d | z | teeth | ●/○ |
|-----|-----|------------|----|----------|-------|-----|
| 542 | 6,0 | 3,5 | 30 | 5, 8, 10 | LFZ | ○ |
| 634 | 6,0 | 3,6 or 4,0 | 30 | 5, 8, 10 | LFZ | ○ |



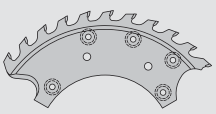
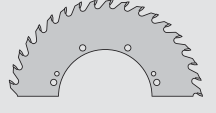

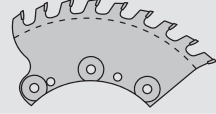


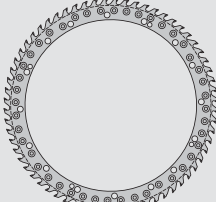
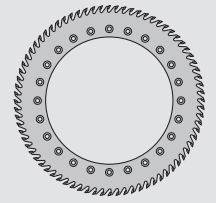
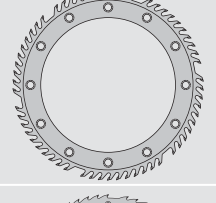
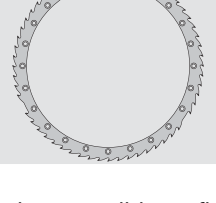
In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.



» designed for Linck, EWD and other machines in automated lines for primary wood processing

| | Machine type | D | S | s | z | ●/○ |
|---|--------------|-----|-----|---------|----|-----|
|  | EWD-FZ 3 | 555 | 6,2 | 5 | 19 | ○ |
|  | V25 | 570 | 4,5 | 3,5-5,0 | 19 | ○ |
|  | | 570 | 4,5 | 3,5-5,0 | 19 | ○ |
|  | | 570 | 4,5 | 3,5 | 19 | ○ |
|  | | 570 | 4,5 | 3,5 | 19 | ○ |
|  | | 570 | 4,5 | 3,5 | 12 | ○ |
|  | | 570 | 4,5 | 3,5 | 12 | ○ |
|  | V40 | 830 | 4,5 | 3,5 | 17 | ○ |
|  | | 830 | 4,5 | 3,5 | 17 | ○ |
|  | | 830 | 5 | 4 | 12 | ○ |
|  | | 830 | 5 | 4 | 12 | ○ |
|  | VP34 | 403 | 3,5 | 2,5-5,0 | 8 | ○ |
|  | | 403 | 3,5 | 2,5-5,0 | 8 | ○ |
|  | VP48 | 411 | 6,4 | 4,9 | 10 | ○ |
|  | | 411 | 6,4 | 4,9 | 10 | ○ |
|  | | 411 | 6,4 | 4,9 | 20 | ○ |
|  | | 411 | 6,4 | 4,9 | 20 | ○ |
|  | | 411 | 4 | 3,0-5,0 | 7 | ○ |
| | | 411 | 4 | 3,0-5,0 | 7 | ○ |

In case that you did not find the type of segments you require in our catalogue, please contact us. We will make them upon your specification.

| | machine type | D | S | s | z | ●/○ |
|--|--------------|-----|-----|---------|----|-----|
|  | VP48 | 415 | 3,5 | 2,5-8,0 | 11 | ○ |
| | | 415 | 3,5 | 2,5-8,0 | 11 | ○ |
|  | | 415 | 6 | 5 | 19 | ○ |
|  | | 415 | 8 | 7 | 15 | ○ |
|    | VPS | 400 | 3,5 | 2,5-8,0 | 9 | ○ |
| | | 400 | 3,5 | 2,5-8,0 | 9 | ○ |
| | | 401 | 3,5 | 2,5-8,0 | 10 | ○ |
| | | 401 | 3,5 | 2,5-8,0 | 10 | ○ |
| | | 401 | 4,5 | 3,5-8,0 | 10 | ○ |
| | | 401 | 4,5 | 3,5-8,0 | 10 | ○ |
| | | 497 | 3,5 | 2,5-8,0 | 8 | ○ |
| | | 497 | 3,5 | 2,5-8,0 | 8 | ○ |
| | | 497 | 3,5 | 2,5-8,0 | 8 | ○ |
|  | VM30 | 730 | 4,5 | 3,5-6,0 | 64 | ○ |
| | | 730 | 4,5 | 3,5-6,0 | 64 | ○ |
|  | | 530 | 6,4 | 5 | 76 | ○ |
|  | | 650 | 6,5 | 4,5-7,0 | 60 | ○ |
| | | 650 | 6,5 | 4,5-7,0 | 60 | ○ |
|  | | | 830 | 6,5 | 5 | 57 |

In case that you did not find the type of segments you require in our catalogue, please contact us. We will make them upon your specification.

We produce circular saw blades for machines of all established wood - processing machine manufacturers.

pilana.com

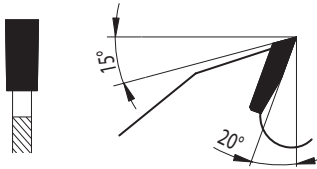


pilana.wood.com

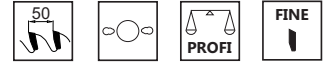
Secondary Wood Processing



Material: Natural wood – soft, hard, wet or dry
Application: Cutting and ripping along and across the grain of natural solid wood

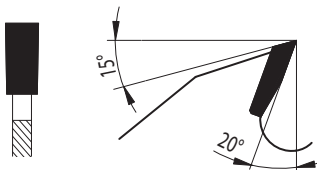


80-50 FZ



- » cutting along the grain of natural solid wood
- » suitable for prismatic beam saws

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----|-----|
| 300 | 4,0 | 2,8 | 30 | 18 | ● |
| 350 | 4,0 | 2,8 | 30 | 20 | ● |
| 400 | 4,4 | 3,2 | 30 | 24 | ● |
| 450 | 4,4 | 3,2 | 30 | 28 | ● |
| 500 | 5,2 | 3,5 | 30 | 30 | ● |
| 550 | 5,5 | 3,5 | 30 | 32 | ● |
| 600 | 5,5 | 3,5 | 30 | 36 | ● |



80-40 FZ

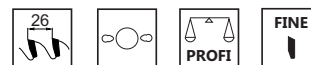


- » cutting along the grain of natural solid wood

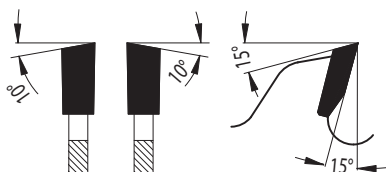
| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----|-----|
| 200 | 2,5 | 1,6 | 20 | 16 | ● |
| 250 | 3,2 | 2,2 | 30 | 20 | ● |
| 300 | 3,2 | 2,2 | 30 | 24 | ● |
| 350 | 3,6 | 2,5 | 30 | 28 | ● |
| 400 | 3,6 | 2,5 | 30 | 32 | ● |
| 450 | 4,0 | 2,8 | 30 | 36 | ● |
| 500 | 4,0 | 2,8 | 30 | 40 | ● |
| 600 | 5,5 | 3,5 | 30 | 48 | ● |
| 700 | 5,5 | 3,5 | 35 | 56 | ● |

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

81-26 WZ

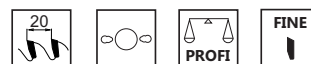


- » universal cutting along and across the grain of natural solid wood
- » cutting of plywood, unprocessed chipboard and wood based panels

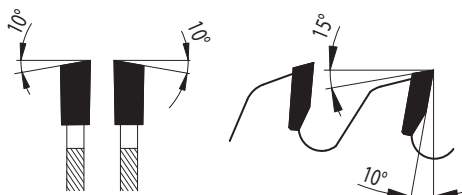


| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----|-----|
| 160 | 2,5 | 1,6 | 20 | 16 | ● |
| 180 | 2,5 | 1,6 | 20 | 20 | ● |
| 200 | 2,5 | 1,6 | 20 | 24 | ● |
| 250 | 3,2 | 2,2 | 30 | 32 | ● |
| 300 | 3,2 | 2,2 | 30 | 36 | ● |
| 350 | 3,6 | 2,5 | 30 | 40 | ● |
| 400 | 3,6 | 2,5 | 30 | 48 | ● |
| 450 | 4,0 | 2,8 | 30 | 56 | ● |
| 500 | 4,0 | 2,8 | 30 | 64 | ● |
| 550 | 5,2 | 3,5 | 30 | 64 | ● |
| 600 | 6,0 | 4,0 | 30 | 64 | ● |

81-20 WZ



- » cutting across the grain of natural wood
- » cutting of plywood, unprocessed chipboard and wood based panels



| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|-----|-----|
| 160 | 2,5 | 1,6 | 20 | 24 | ● |
| 180 | 2,5 | 1,6 | 20 | 28 | ● |
| 200 | 2,5 | 1,6 | 20 | 32 | ● |
| 250 | 3,2 | 2,2 | 30 | 40 | ● |
| 300 | 3,2 | 2,2 | 30 | 48 | ● |
| 315 | 3,2 | 2,2 | 30 | 48 | ● |
| 350 | 3,6 | 2,5 | 30 | 54 | ● |
| 400 | 3,6 | 2,5 | 30 | 64 | ● |
| 450 | 4,0 | 2,8 | 30 | 72 | ● |
| 500 | 4,0 | 2,8 | 30 | 84 | ● |
| 500 | 4,2 | 3,0 | 30 | 84 | ● |
| 550 | 5,2 | 3,8 | 30 | 84 | ● |
| 600 | 5,2 | 3,5 | 30 | 90 | ● |
| 650 | 5,9 | 4,2 | 30 | 100 | ● |

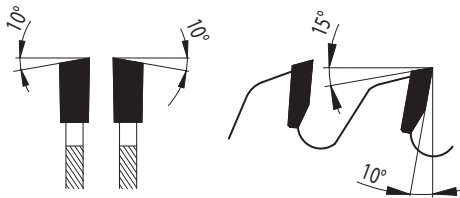
In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

81-16 WZ



- » cutting across the grain of natural wood
- » cutting of plywood, unprocessed chipboard, wood based panels and exotic solid woods

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|-----|-----|
| 180 | 2,5 | 1,6 | 20 | 36 | ● |
| 200 | 2,5 | 1,6 | 20 | 40 | ● |
| 250 | 3,2 | 2,2 | 30 | 48 | ● |
| 300 | 3,2 | 2,2 | 30 | 60 | ● |
| 300 | 3,2 | 2,2 | 30 | 64 | ● |
| 350 | 3,6 | 2,5 | 30 | 72 | ● |
| 400 | 3,6 | 2,5 | 30 | 84 | ● |
| 450 | 4,2 | 3,0 | 30 | 84 | ● |
| 500 | 4,0 | 2,8 | 30 | 100 | ● |
| 550 | 5,0 | 3,8 | 30 | 96 | ● |
| 600 | 5,7 | 4,0 | 30 | 110 | ● |

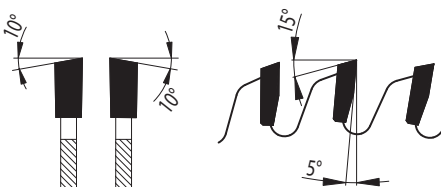


81-13 WZ

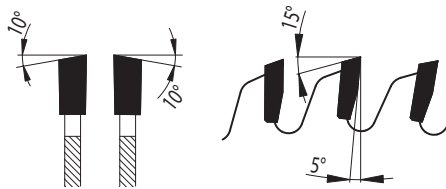


- » cutting across the grain of natural wood
- » cutting of plywood, veneer, unprocessed chipboard, wood based panels and exotic solid woods

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|-----|-----|
| 160 | 2,5 | 1,6 | 20 | 36 | ● |
| 200 | 2,5 | 1,6 | 20 | 48 | ● |
| 250 | 3,2 | 2,2 | 30 | 60 | ● |
| 250 | 3,2 | 2,2 | 30 | 64 | ● |
| 300 | 3,2 | 2,2 | 30 | 72 | ● |
| 350 | 3,6 | 2,5 | 30 | 84 | ● |
| 400 | 3,6 | 2,5 | 30 | 96 | ● |
| 400 | 3,8 | 2,8 | 30 | 96 | ● |
| 450 | 5,0 | 3,2 | 30 | 108 | ● |
| 500 | 5,0 | 3,2 | 30 | 120 | ● |



In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

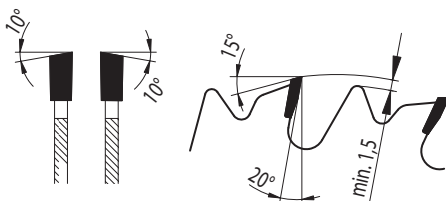


81-11 WZ



- » high quality smooth cutting across the grain of natural wood
- » cutting of plywood, veneer, unprocessed chipboard, wood based panels and exotic solid woods

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|-----|-----|
| 160 | 2,5 | 1,6 | 20 | 48 | ● |
| 180 | 2,5 | 1,6 | 20 | 56 | ● |
| 200 | 2,5 | 1,6 | 20 | 64 | ● |
| 250 | 3,2 | 2,2 | 30 | 72 | ● |
| 250 | 3,2 | 2,2 | 30 | 80 | ● |
| 300 | 3,2 | 2,2 | 30 | 96 | ● |
| 350 | 3,6 | 2,5 | 30 | 108 | ● |
| 400 | 3,6 | 2,5 | 30 | 120 | ● |
| 400 | 3,8 | 2,8 | 30 | 108 | ● |
| 450 | 4,2 | 3,0 | 30 | 120 | ● |
| 500 | 4,0 | 2,8 | 30 | 144 | ● |



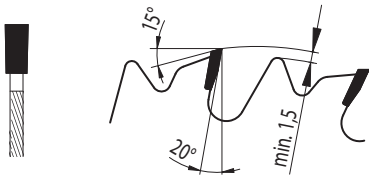
83-35 LWZ



- » cutting along and across the grain of natural solid wood
- » saw blade geometry includes a chip thickness limiter
- » anti-kick back design

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----|-----|
| 250 | 3,2 | 2,2 | 30 | 24 | ● |
| 300 | 3,2 | 2,2 | 30 | 28 | ● |
| 315 | 3,2 | 2,2 | 30 | 28 | ● |
| 350 | 3,6 | 2,5 | 30 | 32 | ● |
| 400 | 3,6 | 2,5 | 30 | 36 | ● |
| 450 | 4,0 | 2,8 | 30 | 40 | ● |
| 500 | 4,0 | 2,8 | 30 | 44 | ● |
| 600 | 5,2 | 3,5 | 30 | 54 | ● |

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.



83-55 LFZ



- » cutting along the grain of natural solid wood
- » suitable for single blade machines with manual feed
- » saw blade geometry includes a chip thickness limiter
- » anti-kick back design

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----|-----|
| 300 | 3,6 | 2,5 | 30 | 18 | ● |
| 350 | 4,0 | 2,8 | 30 | 20 | ● |
| 400 | 4,0 | 2,8 | 30 | 24 | ● |
| 500 | 4,0 | 2,8 | 30 | 36 | ● |
| 600 | 4,2 | 2,8 | 30 | 36 | ● |
| 700 | 4,4 | 3,2 | 30 | 44 | ● |



81 WZ Saw Blades for Fire Wood

- » cross cutting of natural solid wood
- » suitable for cutting of fire wood

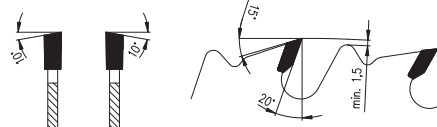


| D | S | s | d | z | teeth | ●/○ |
|-----|-----|-----|----|----|-------|-----|
| 600 | 4,0 | 2,8 | 30 | 40 | LWZ | ● |
| 700 | 4,2 | 3,2 | 30 | 42 | LFZ | ● |
| 700 | 4,2 | 3,2 | 30 | 84 | WZ | ● |
| 700 | 5,0 | 3,8 | 30 | 60 | WZ | ○ |

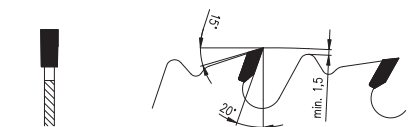
WZ



LWZ



LFZ

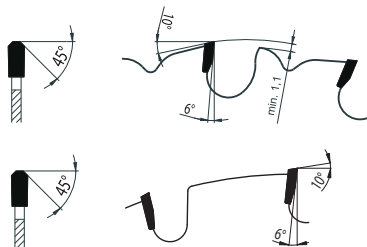


In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

88 TZ GLADIUS



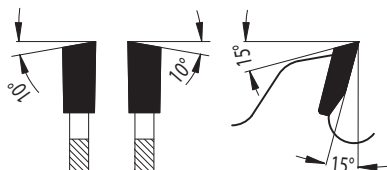
- » cutting of construction wood containing metal parts, chipboard, Heraklit boards, porous concrete
- » tooth geometry improves resistance against abrasive and mechanical damage



| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----|-----|
| 300 | 3,2 | 2,2 | 30 | 20 | ● |
| 350 | 3,6 | 2,5 | 30 | 24 | ● |
| 400 | 3,6 | 2,5 | 30 | 28 | ● |
| 450 | 4,0 | 2,8 | 30 | 32 | ● |
| 500 | 4,0 | 2,8 | 30 | 36 | ● |
| 600 | 3,8 | 2,8 | 30 | 42 | ● |
| 700 | 4,2 | 3,2 | 30 | 48 | ● |

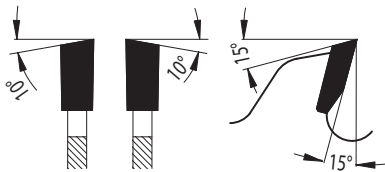
TCT Circular Saw Blades for Pruning

- » suitable for use in hard shoulder rotary trimmers
- » for clearing of vegetation from road shoulders on Mulag® and similar machines



| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----|-----|
| 390 | 3,5 | 2,5 | 25 | 60 | ○ |
| 390 | 3,5 | 2,5 | 61 | 60 | ○ |
| 500 | 4,0 | 3,0 | 30 | 60 | ○ |
| 500 | 4,0 | 3,0 | 30 | 72 | ○ |
| 590 | 4,5 | 3,6 | 30 | 78 | ○ |
| 590 | 4,5 | 3,6 | 85 | 78 | ○ |
| 600 | 4,0 | 3,0 | 45 | 60 | ○ |

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

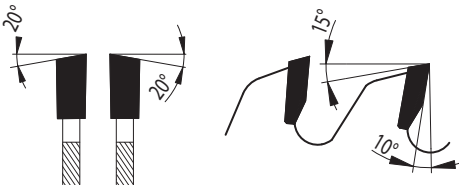


81 WZ – “Hundegger” Type



- » for use in joinery machines (e.g. fully automatic Hundegger or Paul machines) to cut or trim timber, roofing materials, construction panels & boards, logs or beams, wood for lining, planking and other types of wood used in construction
- » cutting across & along the grain, cutting to size or angle cutting of frames in soft and hard wood
- » circular saw blades with positive hook angle, WZ tooth shape and robust body to cope with high mechanical load
- » pinholes are added to a particular saw blade on request based on the type of machine used

| D | S | s | d | z | Pin holes | ●/○ |
|-----|-----|-----|----|----|---|-----|
| 720 | 6,0 | 4,5 | 30 | 72 | 4-8.5-90+2-15-415 8-8.5-120 sunken 4-8,1-90 2-14-400 | ● |
| 760 | 6,0 | 4,5 | 30 | 72 | 4-8.5-90+2-15-415 | ● |
| 800 | 6,0 | 4,5 | 30 | 72 | "8-8.5-160 sunken 4-8.1-90 2-14-400" | ● |
| 800 | 6,0 | 4,5 | 30 | 80 | 4-8.5-90+2-15-415 | ● |



81 WZ OPTI Cross Cut & Cut Off Saw



- » saw blades with suitable tooth geometry for cross cutting and cut off optimising applications
- » for optimising saws made by STÖRI MANTEL, WEINIG, DIMTER, HOLZ-HER, PANHANS and other manufacturers
- » standard bevel angle 20 degrees, possibility to sharpen up to 40 degrees or WZ/SSW on request and under special production

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|-----|-----|
| 400 | 3,8 | 2,8 | 30 | 60 | ● |
| 400 | 4,5 | 3,2 | 30 | 120 | ● |
| 450 | 4,8 | 3,5 | 30 | 138 | ● |
| 500 | 5 | 3,2 | 30 | 96 | ● |
| 500 | 5,2 | 3,2 | 30 | 120 | ● |
| 500 | 4,8 | 3,5 | 30 | 144 | ● |
| 550 | 4,8 | 3,5 | 30 | 144 | ● |
| 600 | 5,8 | 4 | 30 | 120 | ● |
| 600 | 5,4 | 4 | 30 | 172 | ● |

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

Application: Cutting of wood and wood based materials
Machine: Miter saws and optimising saws

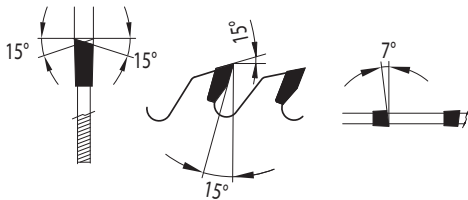


81 WZ SSW



- » saw blades designed for all regular types of miter saws
- » featuring alternate face bevel intended for high quality of cutting surface

| D | S | s | d | z | ●/○ |
|-----|-----|-----|------|----|-----|
| 254 | 2,6 | 1,6 | 30 | 60 | ○ |
| 260 | 2,6 | 1,8 | 30 | 60 | ● |
| 305 | 2,8 | 1,8 | 25,4 | 80 | ○ |

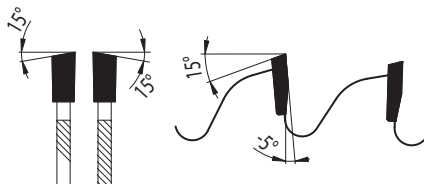


81 WZ N



- » suitable for trimming applications
- » used in pendulum cross cut saws, radial saws with manual feed
- » negative hook angle enables fluent cutting start

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----|-----|
| 210 | 2,6 | 1,8 | 30 | 24 | ● |
| 210 | 2,8 | 1,8 | 30 | 48 | ● |
| 210 | 2,8 | 1,8 | 30 | 60 | ● |
| 216 | 2,8 | 1,8 | 30 | 24 | ● |
| 216 | 2,8 | 1,8 | 30 | 48 | ● |
| 216 | 2,8 | 1,8 | 30 | 60 | ● |
| 216 | 2,8 | 1,8 | 30 | 80 | ● |
| 250 | 2,8 | 1,8 | 30 | 48 | ● |
| 250 | 2,8 | 1,8 | 30 | 60 | ● |
| 250 | 2,8 | 1,8 | 30 | 80 | ● |
| 260 | 2,8 | 1,8 | 30 | 60 | |
| 260 | 2,8 | 1,8 | 30 | 80 | |
| 305 | 2,6 | 1,8 | 30 | 60 | |



In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

Material: Natural wood
Application: Cutting of wood and wood based materials, grooving
Machine: CNC machines, grooving machines

81 CNC

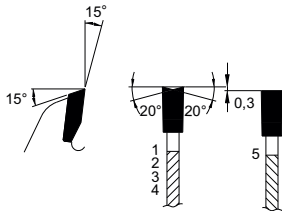


- » designed for CNC machining centers with circular saw blade attachments
- » suitable for cutting, grooving and formatting
- » precise geometry ensures excellent quality of the edge

WZ/FZ H



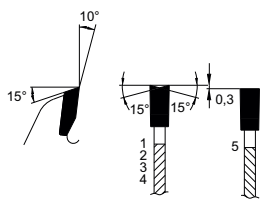
WZ/FZ H



| D | S | s | d | z | Pinholes | Machine | ●/○ |
|-----|-----|-----|----|----|-------------|-----------------|-----|
| 100 | 3,5 | 2,5 | 30 | 35 | | Weeke | ● |
| 100 | 4,0 | 2,8 | 30 | 35 | | Weeke | ● |
| 120 | 3,5 | 2,5 | 20 | 35 | 2x3/4,5 /35 | SCM, Morbidelli | ● |
| 120 | 3,5 | 2,5 | 35 | 35 | 2x4/6,3/50 | Biesse | ● |
| 120 | 4,0 | 2,8 | 20 | 35 | 2x3/4,5/35 | SCM, Morbidelli | ● |
| 120 | 4,0 | 2,8 | 35 | 35 | 2x4/6,3/50 | Biesse | ● |
| 125 | 3,5 | 2,5 | 30 | 35 | 2x4/5,5/48 | Homag, Weeke | ● |
| 125 | 4,0 | 2,8 | 30 | 35 | 2x4/5,5/48 | Homag, Weeke | ● |

WZF/SSW

WZF/SSW

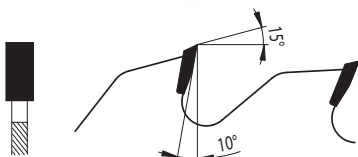


| D | S | s | d | z | Pinholes | Machine | ●/○ |
|-----|-----|-----|----|-----|----------|-----------|-----|
| 300 | 3,2 | 2,4 | 30 | 100 | 8/6/90 | Homag | ● |
| 300 | 3,2 | 2,4 | 30 | 100 | 6/6,8/90 | universal | ● |
| 300 | 3,2 | 2,4 | 50 | 100 | 6/5/80 | Biesse | ● |
| 350 | 3,5 | 2,6 | 30 | 110 | 8/6/90 | Homag | ● |
| 350 | 3,5 | 2,6 | 30 | 110 | 6/6,8/90 | universal | ○ |

92 FZ



- » grooving of all types of natural wood and furniture materials



| D | S | s | d | z | ●/○ |
|-----|------------|-----|----|----|-----|
| 125 | 4,0 - 10,0 | | 30 | 10 | ○ |
| 150 | 3,0 | 2,2 | 30 | 12 | ● |
| 150 | 3,5 | 2,5 | 30 | 12 | ● |
| 150 | 4,0 | 2,5 | 30 | 12 | ● |
| 150 | 5,0 | 3,5 | 30 | 12 | ● |
| 150 | 6,0 | 3,5 | 30 | 12 | ● |
| 150 | 8,0 - 12,0 | | 30 | 12 | ○ |
| 180 | 4,0 | 2,5 | 30 | 16 | ● |
| 180 | 5,0 | 3,5 | 30 | 16 | ● |
| 180 | 6,0 | 3,5 | 30 | 16 | ● |
| 180 | 8,0 - 12,0 | | 30 | 16 | ○ |
| 200 | 4,0 | 2,5 | 30 | 32 | ● |
| 200 | 5,0 | 3,5 | 30 | 32 | ● |

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

TCT Saw Blades for Grooving / TCT Saw Blades for Grooving in Biscuit Joining



Material: Natural wood, chipboard
Application: Grooving

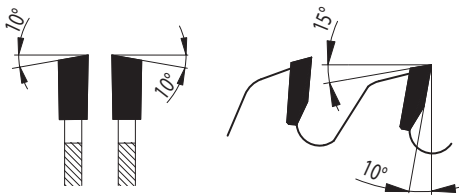


96 WZ



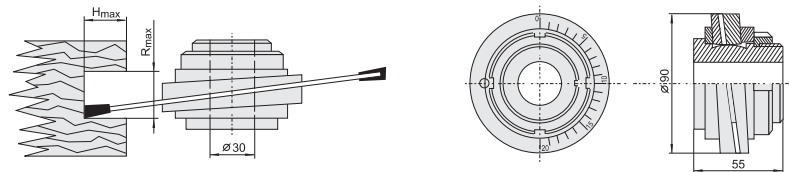
- » size adjustable grooving in combination with a clamping bush
- » saw blades suitable for wobble saws

| D | S | s | R _{max} | H _{max} | d | z | ●/○ |
|-----|-----|-----|------------------|------------------|----|----|-----|
| 200 | 3,2 | 2,2 | 15 | 50 | 50 | 32 | ● |
| 250 | 3,6 | 2,5 | 20 | 70 | 50 | 40 | ● |
| 300 | 3,6 | 2,5 | 22 | 100 | 50 | 48 | ● |



5748 Clamping bushes

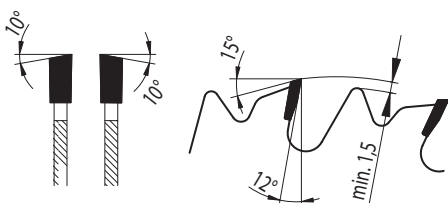
- » clamping bush is made of steel, size of required grooves is adjustable by using skew symmetric plates and matrix



83 LWZ



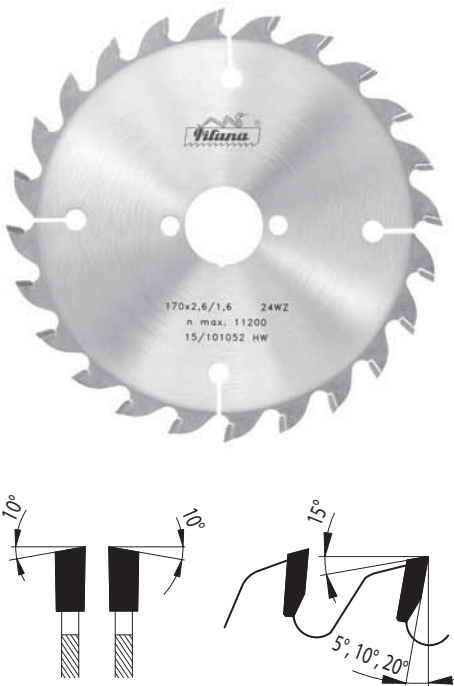
- » grooving saw blades used in hand machines for making of biscuit joining



In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

D - blade diameter [mm], S - tooth width [mm], s - body thickness [mm], d - bore [mm], z - number of teeth, R_{max} - maximum groove width [mm], H_{max} - maximum groove depth [mm], ● - in stock, ○ - made to customer's request

Material: Wood and plastics, laminated materials
Application: Sawing with electrical hand-held machines



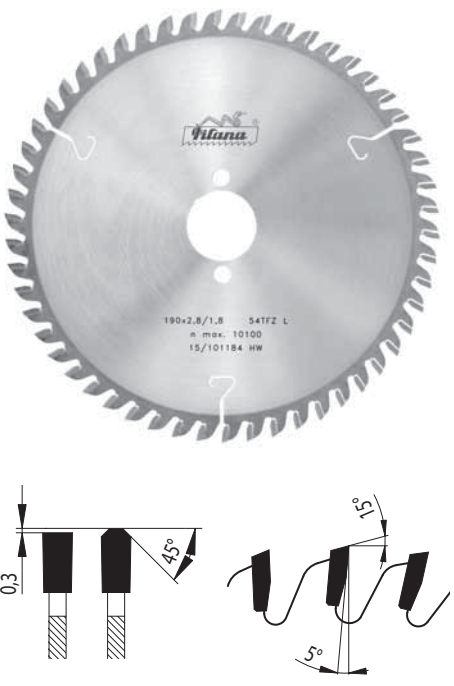
91 WZ



Characteristics:

» cutting wood and plastics with electrical hand-held machines

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|--------------------|-----|
| 127 | 2,6 | 1,6 | 20 | 10, 20, 36 | ● |
| 130 | 2,6 | 1,6 | 20 | 10, 20, 36 | ● |
| 140 | 2,6 | 1,6 | 20 | 10, 20, 42 | ● |
| 150 | 2,6 | 1,6 | 20 | 12, 24, 40, 48 | ● |
| 160 | 2,2 | 1,6 | 20 | 24, 48 | ● |
| 160 | 2,6 | 1,6 | 20 | 12, 24, 40, 48 | ● |
| 165 | 2,2 | 1,6 | 20 | 20, 24, 48, 56 | ● |
| 170 | 2,6 | 1,6 | 30 | 12, 24, 40, 54 | ● |
| 180 | 2,6 | 1,6 | 30 | 12, 24, 40, 56 | ● |
| 184 | 2,6 | 1,6 | 30 | 12, 24, 40, 56 | ● |
| 190 | 2,2 | 1,6 | 20 | 20, 24, 48, 56 | ● |
| 190 | 2,6 | 1,6 | 30 | 14, 24, 30, 40, 56 | ● |
| 200 | 2,8 | 1,8 | 30 | 16, 30, 40, 64 | ● |
| 210 | 2,8 | 1,8 | 30 | 18, 32, 40, 64 | ● |
| 216 | 2,8 | 1,8 | 30 | 24, 48, 64 | ● |
| 230 | 2,8 | 1,8 | 30 | 20, 34, 48, 64 | ● |
| 235 | 2,8 | 1,8 | 30 | 20, 24, 34, 48, 64 | ● |



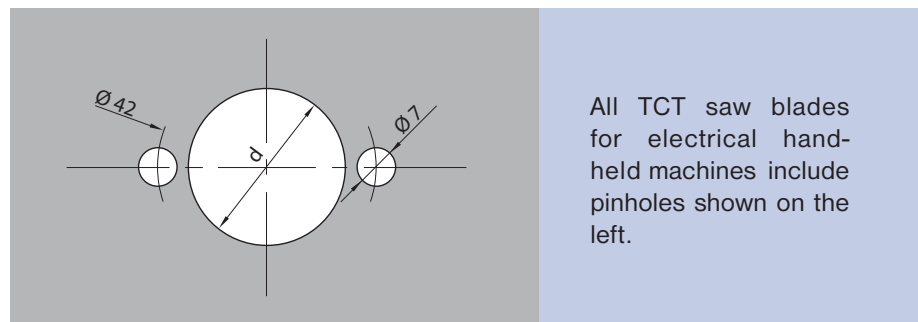
91 TFZ L



Characteristics:

» geometry suitable for cutting of laminated materials

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|--------|-----|
| 160 | 2,2 | 1,6 | 20 | 24, 48 | ● |
| 160 | 2,8 | 1,8 | 20 | 48 | ● |
| 190 | 2,8 | 1,8 | 30 | 54 | ● |



All TCT saw blades for electrical hand-held machines include pinholes shown on the left.

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

pilana.com



pilanawood.com

TCT Sizing Saw Blades



Material: Laminated chipboard, MDF and HDF

Application: Cutting of laminated boards

Machine: Panel sizing machines

HIGH PROFI+



- » Pilana's premium line of saw blades for cutting of laminated chipboards, MDF and HDF featuring larger TCT tips that allow for more resharpening
- » low noise slots for additional silencing of the saw blade
- » supplied in TFZ, TZ/TZ and WZ L geometry
- » for optimal cutting the use of a scoring blade is recommended

97 TFZ L HP+

| D | S | s | d | z | ●/○ |
|-----|-----|-----|--------|----|-----|
| 300 | 4,4 | 3,2 | 30, 60 | 72 | ● |
| 320 | 4,4 | 3,2 | 30 | 60 | ● |
| 350 | 4,4 | 3,2 | 30, 60 | 72 | ● |
| 360 | 4,4 | 3,2 | 30, 65 | 72 | ● |
| 380 | 4,4 | 3,2 | 30 | 72 | ● |
| 380 | 4,8 | 3,5 | 30 | 72 | ● |
| 400 | 4,4 | 3,2 | 30 | 72 | ● |
| 450 | 4,4 | 3,2 | 30 | 72 | ● |

97 TZ/TZ L HP+

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----|-----|
| 350 | 4,4 | 3,2 | 30 | 72 | ● |

98 WZ L HP+

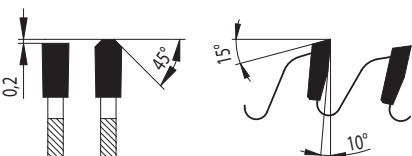
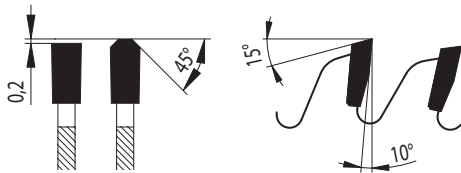
| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----|-----|
| 350 | 4,4 | 3,2 | 30 | 54 | ● |

97 TFZ L HP



- » designed for cutting of chipboard based materials, MDF and HDF
- » in combination with a conical scoring saw blade for achieving of excellent cutting performance (KON or KON/WZ based on customer's request)
- » long lifespan of carbide tips

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----|-----|
| 300 | 4,4 | 3,2 | 30 | 60 | ● |
| 350 | 4,4 | 3,2 | 30 | 72 | ● |
| 380 | 4,4 | 3,2 | 30 | 72 | ● |
| 400 | 4,4 | 3,2 | 30 | 72 | ● |
| 450 | 4,4 | 3,2 | 30 | 72 | ● |



In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

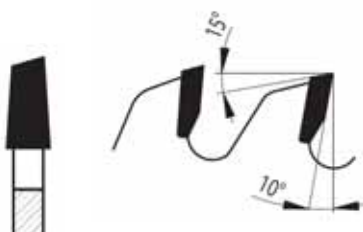


93 KON WZ HP+



» scoring saw blades for equipment with the possibility of height adjustment of the scoring saw blade accessory

| D | S | s | d | z | ●/○ |
|-----|-----------|-----|--------|----|-----|
| 125 | 4,4 - 5,2 | 3,2 | 20 | 24 | ● |
| 150 | 4,4 - 5,2 | 3,2 | 20 | 24 | ● |
| 160 | 4,4 - 5,2 | 3,2 | 55 | 36 | ● |
| 180 | 4,4 - 5,2 | 3,5 | 30, 45 | 36 | ● |
| 200 | 4,4 - 5,2 | 3,5 | 20 | 36 | ● |
| 200 | 4,8 - 5,6 | 3,5 | 45 | 36 | ● |

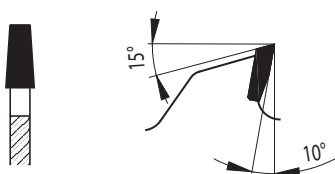


93 KON FZ



» scoring saw blades for equipment with the possibility of height adjustment of the scoring saw blade accessory

| D | S | s | d | z | ●/○ |
|-----|-----------|-----|----|----|-----|
| 125 | 4,3 - 5,4 | 3,0 | 20 | 24 | ● |
| 150 | 4,4 - 5,6 | 3,2 | 45 | 24 | ● |
| 180 | 4,8 - 5,8 | 3,5 | 45 | 36 | ● |
| 200 | 4,3 - 5,1 | 3,5 | 20 | 34 | ● |



In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

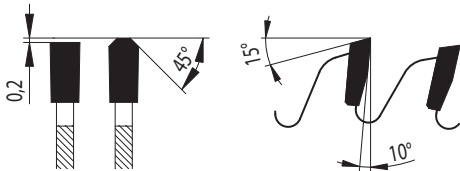
Material: Laminated chipboard, MDF and HDF
Application: Cutting of laminated boards
Machine: Sizing machines

97 TFZ L HP+



- » Pilana's premium line of saw blades for cutting of laminated chipboards, MDF and HDF featuring larger TCT tips that allow for more resharpening
- » low noise slots for additional silencing of the saw blade
- » supplied in TFZ geometry
- » for optimal cutting the use of a scoring blade is recommended

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----|-----|
| 300 | 3,2 | 2,2 | 30 | 96 | ● |

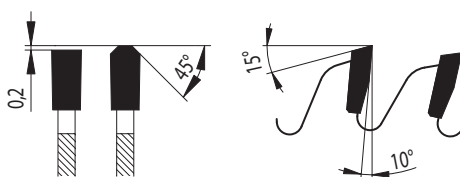


97 TFZ L HP

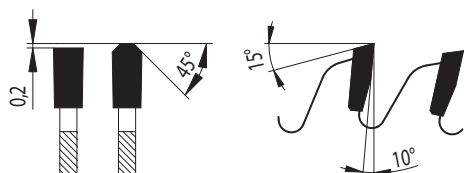


- » designed for cutting of chipboard based materials, MDF and HDF
- » for optimal cutting the use of a scoring blade is recommended
- » long lifespan of carbide tips

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|-----|-----|
| 200 | 3,2 | 2,2 | 30 | 64 | ● |
| 250 | 3,2 | 2,2 | 30 | 60 | ● |
| 250 | 3,2 | 2,2 | 30 | 80 | ● |
| 300 | 3,2 | 2,2 | 30 | 72 | ● |
| 300 | 3,2 | 2,2 | 30 | 96 | ● |
| 350 | 3,6 | 2,5 | 30 | 108 | ● |



In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.



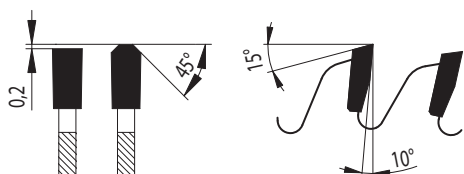
97-11 TFZ L



Characteristics:

- » suitable for cutting of laminated chipboards
- » for optimal cutting the use of a scoring blade is recommended
- » low noise slots for additional silencing of the saw blade

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|-----|-----|
| 200 | 3,2 | 2,2 | 30 | 64 | ● |
| 250 | 3,2 | 2,2 | 30 | 80 | ● |
| 300 | 3,2 | 2,2 | 30 | 96 | ● |
| 350 | 3,6 | 2,5 | 30 | 108 | ● |



97-13 TFZ L

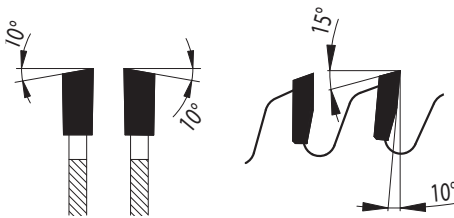


Characteristics:

- » suitable for cutting of laminated chipboards
- » for optimal cutting the use of a scoring blade is recommended
- » low noise slots for additional silencing of the saw blade

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----|-----|
| 250 | 3,2 | 2,2 | 30 | 60 | ● |
| 300 | 3,2 | 2,2 | 30 | 72 | ● |

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

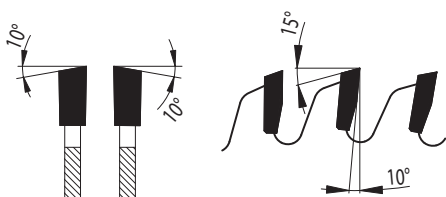


98 WZ L HP



- » designed for cutting of chipboard based materials, MDF and HDF
- » for optimal cutting the use of a scoring blade is recommended
- » long lifespan of carbide tips

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|-----|-----|
| 250 | 3,2 | 2,2 | 30 | 64 | ● |
| 250 | 3,2 | 2,2 | 30 | 72 | ● |
| 300 | 3,2 | 2,2 | 30 | 72 | ● |
| 300 | 3,2 | 2,2 | 30 | 96 | ● |
| 350 | 3,6 | 2,5 | 30 | 84 | ● |
| 350 | 3,6 | 2,5 | 30 | 108 | ● |



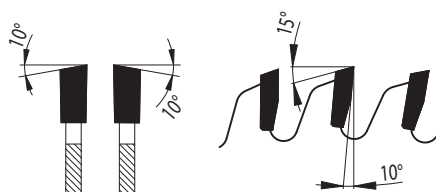
98-11 WZ L



- » suitable for cutting of laminated chipboards
- » for optimal cutting the use of a scoring blade is recommended
- » low noise slots for additional silencing of the saw blade

| D | S | s | d | z | teeth | ●/○ |
|-----|-----|-----|----|-----|-------|-----|
| 250 | 3,2 | 2,2 | 30 | 72 | WZ L | ● |
| 300 | 3,2 | 2,2 | 30 | 96 | WZ L | ● |
| 350 | 3,6 | 2,5 | 30 | 108 | WZ L | ● |

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.



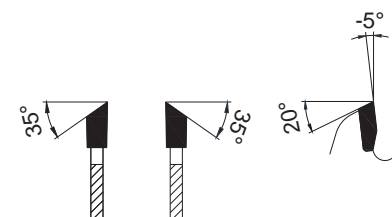
98-13 WZ L



Characteristics:

- » suitable for cutting of laminated chipboards
- » for optimal cutting the use of a scoring blade is recommended
- » low noise slots for additional silencing of the saw blade

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----|-----|
| 250 | 3,2 | 2,2 | 30 | 64 | ● |
| 300 | 3,2 | 2,2 | 30 | 72 | ● |
| 350 | 3,6 | 2,5 | 30 | 84 | ● |



98-11 WZ L N



- » suitable for cutting of laminated chipboards
- » for optimal cutting the use of a scoring blade is recommended
- » low noise slots for additional silencing of the saw blade

| D | S | s | d | z | teeth | ●/○ |
|-----|-----|-----|----|-----|--------|-----|
| 250 | 3,2 | 2,2 | 30 | 80 | WZ L N | ○ |
| 300 | 3,2 | 2,2 | 30 | 96 | WZ L N | ○ |
| 350 | 3,6 | 2,5 | 30 | 108 | WZ L N | ○ |

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.



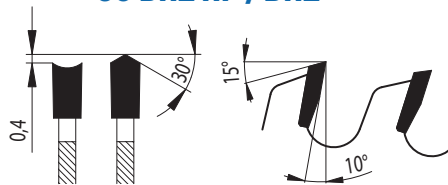
90 DHZ/N HP



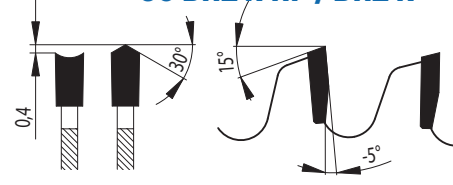
- » cutting of laminated boards with or without the use of a scoring blade
- » suitable for use in vertical panel saws
- » low noise slots for additional silencing of the saw blade
- » ground bore ensures top run-out parameters of the saw

| D | S | s | d | z | teeth | ●/○ |
|-----|-----|-----|----|----|-------------|-----|
| 220 | 3,2 | 2,2 | 30 | 42 | DHZ | ● |
| 250 | 3,2 | 2,2 | 30 | 48 | DHZ | ● |
| 303 | 3,2 | 2,2 | 30 | 60 | DHZ / DHZ N | ● |
| 350 | 3,6 | 2,5 | 30 | 72 | DHZ | ● |

90 DHZ HP / DHZ



90 DHZ N HP / DHZ N

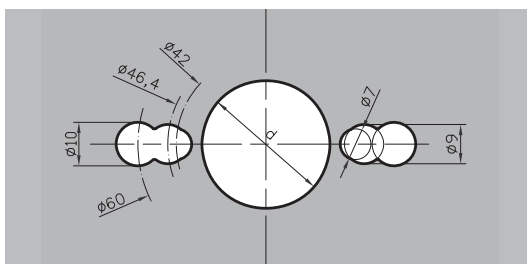


90 DHZ/N



- » cutting of laminated boards with or without the use of a scoring blade
- » suitable for use in vertical panel saws
- » low noise slots for additional silencing of the saw blade

| D | S | s | d | z | teeth | ●/○ |
|-----|-----|-----|----|----|-------------|-----|
| 220 | 3,2 | 2,2 | 30 | 42 | DHZ | ● |
| 250 | 3,2 | 2,2 | 30 | 48 | DHZ | ● |
| 303 | 3,2 | 2,2 | 30 | 60 | DHZ / DHZ N | ● |
| 350 | 3,6 | 2,5 | 30 | 72 | DHZ | ● |



All sizing saw blades include pinholes.
Parameters of pinholes are shown on the left.
Versions without pinholes can be produced on request.

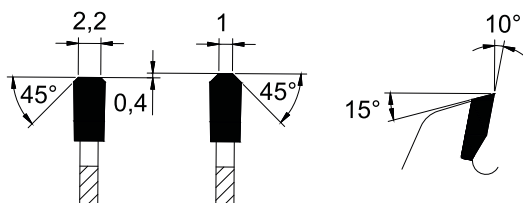
In case that you did not find the type of saw blades which you require in our catalogue, please contact us. We will make them upon your specification.

Material: Synthetic materials
Application: Cutting of boards, sizing
Machine: Sizing machines

97 CORIAN

- » designed for sizing of boards with the use of a scoring saw blade
- » suitable for cutting of synthetic materials based on natural minerals and pure acrylic polymer Corian, HI-MACS, Varicor, Staron, Marlan
- » special TCT tips with tooth geometry for a long life and an excellent cutting edge

| D | S | s | d | z | teeth | ●/○ |
|-----|-----|-----|----|----|-------|-----|
| 300 | 3,2 | 2,5 | 30 | 84 | TZ/TZ | ● |



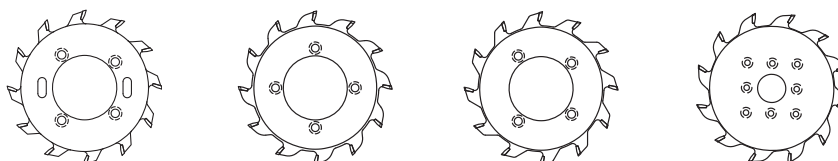
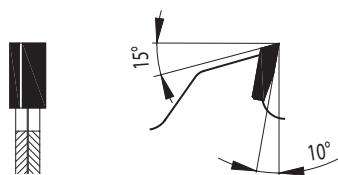
Material: Laminated boards, chipboards
Application: High quality of cut on the bottom side of laminated materials
Machine: Panel sizing saws with scoring saw blade accessory

93.1 FZ - SPLIT SCORING



- » suitable for panel sizing
- » possibility to set up kerf with shims

| D | S | d | z | teeth | ●/○ |
|-----|-----------|--------|-------|-------|-----|
| 80 | 2,8 - 3,6 | 20, 22 | 10+10 | FZ | ○ |
| 100 | 2,8 - 3,6 | 20, 22 | 12+12 | FZ | ● |
| 120 | 2,8 - 3,6 | 20, 22 | 12+12 | FZ | ● |
| 125 | 2,8 - 3,6 | 20, 22 | 12+12 | FZ | ● |
| 140 | 2,8 - 3,6 | 20, 22 | 14+14 | FZ | ● |
| 160 | 2,8 - 3,6 | 20, 22 | 16+16 | FZ | ● |



In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.



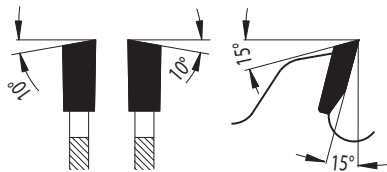
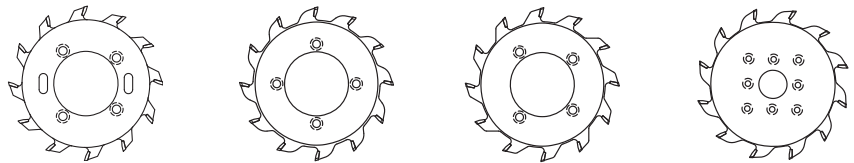
93.1WZ - SPLIT SCORING

- » suitable for panel sizing
- » possibility to set up kerf with shims



| D | S | d | z | teeth | ●/○ |
|------|-----------|----|-------|-------|-----|
| 120* | 2,8 - 3,6 | 50 | 12+12 | WZ | ● |
| 125 | 2,8 - 3,6 | 30 | 12+12 | WZ | ● |

* suitable for Altendorf - Rapido and related systems

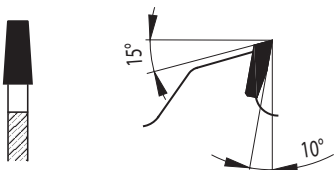


93 KON FZ



- » scoring saw blades for equipment with the possibility of height adjustment of the scoring saw blade accessory

| D | S | s | d | z | ●/○ |
|-----|-----------|-----|----|----|-----|
| 100 | 3,1 - 4,2 | 2,2 | 20 | 20 | ● |
| 100 | 3,5 - 4,5 | 2,5 | 20 | 20 | ● |
| 125 | 3,1 - 4,2 | 2,2 | 20 | 24 | ● |
| 140 | 3,1 - 4,2 | 2,2 | 20 | 32 | |
| 200 | 3,1 - 4,2 | 2,2 | 30 | 32 | |



In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

TCT Saw Blades and Segments for Hogging Machines



Material: Chipboard and MDF based materials
Application: Panel sizing saws



86 – TCT Hogging Saw Blades

- » sizing in combination with segments mounted on a hogging head
- » dimensions manufactured based on customer's request

| D | S | s | d | z | teeth | ●/○ |
|-----|-----|-----|-----|----|---------|-----|
| 360 | 4,4 | 3,0 | 135 | 48 | TFZ-L/R | ○ |
| 260 | 4,4 | 2,8 | 80 | 48 | FZ-L/R | ○ |
| 355 | 4,4 | 3,0 | 120 | 60 | ES-L/R | ○ |
| 200 | 4,0 | 2,8 | 80 | 48 | FZ-L/R | ○ |
| 305 | 4,1 | 2,8 | 155 | 72 | ES-L/R | ○ |
| 355 | 4,4 | 3,0 | 80 | 72 | WZ-L/R | ○ |
| 405 | 4,4 | 3,0 | 80 | 84 | ES-L/R | ○ |
| 395 | 4,4 | 3,5 | 80 | 84 | ES-L/R | ○ |
| 305 | 4,1 | 2,8 | 155 | 72 | ES-L/R | ○ |

| FZ | | ES | | WZ | | WZW | |
|----|---|----|---|----|---|-----|---|
| L | R | L | R | L | R | L | R |
| | | | | | | | |



Material: Chipboard and MDF based materials
Application: For complete chipping (disintegration) of waste materials
Machine: Mounted on a segmental hogging head

50 – Hogging Saw Segments

- » segments fitted with tungsten carbide tips
- » other dimensions and types of segments can be produced based on customer's request

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

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TCT Saw Blades

for Non-Ferrous
Metals, Thin Walled
Profiles, Plastics
and Dry-cutting



TCT Saw Blades for Cutting of Non-Ferrous Metals and Plastics



Material: Non-ferrous metals and plastics
Application: Profiles, mouldings, solid materials, tubes
Machine: Automatic feed machines

87-13 TFZ P



Characteristics:

- » cutting of aluminum profiles and mouldings, plastic boards, brass (Pertinax)
- » suitable for angle cutting and cross cutting
- » saw blades are equipped with Cu rivets

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|-----|-----|
| 200 | 3,2 | 2,5 | 30 | 48 | ● |
| 250 | 3,2 | 2,5 | 30 | 60 | ● |
| 300 | 3,2 | 2,5 | 30 | 72 | ● |
| 350 | 3,6 | 2,8 | 30 | 84 | ● |
| 400 | 3,6 | 2,8 | 30 | 96 | ● |
| 450 | 4,0 | 3,2 | 30 | 108 | ● |
| 500 | 4,0 | 3,2 | 30 | 120 | ● |



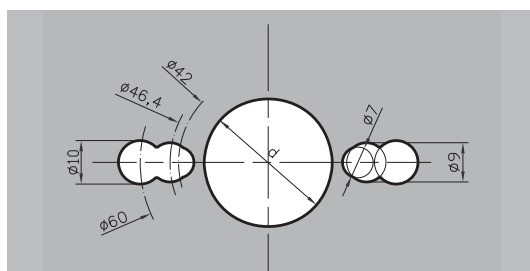
87-11 TFZ P



Characteristics:

- » cutting aluminum profiles and mouldings, plastic boards, brass (Pertinax)
- » suitable for cutting of thin-walled profiles
- » suitable for angle cutting and cross cutting
- » saw blades are equipped with Cu rivets

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|-----|-----|
| 250 | 3,2 | 2,5 | 30 | 80 | ● |
| 300 | 3,2 | 2,5 | 30 | 96 | ● |
| 350 | 3,6 | 2,8 | 30 | 108 | ● |
| 400 | 3,6 | 2,8 | 30 | 120 | ● |



All saw blades include pinholes.
 Parameters of pinholes are shown on the left.
 Versions without pinholes can be produced on request.

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

Material: Non-ferrous metals and plastics
Application: Profiles, mouldings, solid materials, tubes
Machine: Manual feed machines

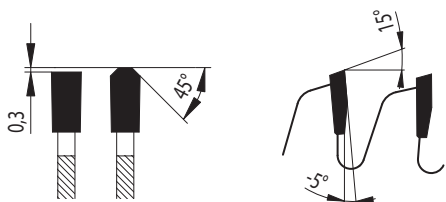
87-13 TFZ N



Characteristics:

- » cutting of non-ferrous metals, profiles and plastics
- » suitable for angle cutting and cross cutting
- » saw blades are equipped with Cu rivets

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|-----|-----|
| 250 | 3,2 | 2,5 | 30 | 60 | ● |
| 300 | 3,2 | 2,5 | 30 | 72 | ● |
| 350 | 3,6 | 2,8 | 30 | 84 | ● |
| 400 | 3,6 | 2,8 | 30 | 96 | ● |
| 420 | 4,0 | 3,2 | 30 | 96 | ● |
| 450 | 4,0 | 3,2 | 30 | 108 | ● |
| 500 | 4,0 | 3,2 | 30 | 120 | ● |



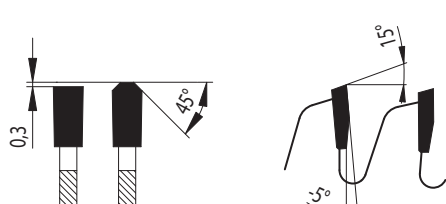
87-11 TFZ N



Characteristics:

- » cutting of non-ferrous metals, profiles and plastics
- » suitable for angle cutting and cross cutting
- » suitable for cutting of thin-walled profiles
- » saw blades are equipped with Cu rivets

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|-----|-----|
| 160 | 2,8 | 2,2 | 20 | 48 | ● |
| 190 | 2,8 | 2,2 | 30 | 56 | ● |
| 200 | 3,2 | 2,5 | 30 | 60 | ● |
| 210 | 3,2 | 2,5 | 30 | 60 | ○ |
| 216 | 2,8 | 1,8 | 30 | 80 | ● |
| 216 | 3,2 | 2,5 | 30 | 60 | ○ |
| 250 | 3,2 | 2,5 | 30 | 80 | ● |
| 260 | 3,2 | 2,5 | 30 | 80 | ○ |
| 300 | 3,2 | 2,5 | 30 | 96 | ● |
| 330 | 3,2 | 2,5 | 30 | 96 | ○ |
| 350 | 3,6 | 2,8 | 30 | 108 | ● |
| 380 | 3,6 | 2,8 | 30 | 110 | ○ |
| 400 | 3,6 | 2,8 | 30 | 120 | ● |



In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

TCT Saw Blades for Cutting of Non-Ferrous Metals and Plastics



Material: Non-ferrous metals and plastics
Application: Profiles, mouldings, solid materials, tubes
Machine: Automatic or manual feed machines

87 TFZ P



- » for cutting of plastic, aluminium and duralumin mouldings and profiles, plastic boards, synthetic resins (Pertinax)
- » saw blades are equipped with Cu rivets

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----------|-----|
| 400 | 4,2 | 3,6 | 30 | 120 | ● |
| 420 | 4,2 | 3,6 | 30 | 120 | ● |
| 450 | 4,2 | 3,6 | 30 | 120 | ● |
| 500 | 4,2 | 3,6 | 30 | 120, 144 | ● |
| 500 | 4,4 | 3,8 | 30 | 96, 120 | ● |
| 550 | 4,4 | 3,8 | 30 | 108, 144 | ● |
| 600 | 4,6 | 4,0 | 30 | 140 | ● |
| 650 | 5,2 | 4,4 | 30 | 144 | ● |

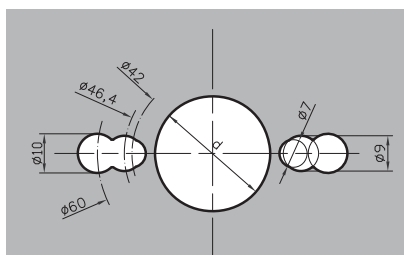


87 TFZ N



- » for cutting plastic, aluminium and duralumin mouldings and profiles, plastic boards, synthetic resins (Pertinax)
- » suitable for cross-cut or miter cutting applications
- » saw blades are equipped with Cu rivets

| D | S | s | d | z | ●/○ |
|-----|-----|-----|----|----------|-----|
| 400 | 4,2 | 3,6 | 30 | 128 | ● |
| 420 | 4,2 | 3,6 | 30 | 120 | ● |
| 450 | 4,2 | 3,6 | 30 | 128 | ● |
| 500 | 4,2 | 3,6 | 30 | 144 | ● |
| 500 | 4,4 | 3,8 | 30 | 96, 120 | ● |
| 550 | 4,4 | 3,8 | 30 | 108, 128 | ● |
| 600 | 4,6 | 4,0 | 30 | 140 | ● |
| 650 | 5,2 | 4,4 | 30 | 144 | ● |



All the "87 series" saw blades till diameter 450 are equipped with universal pin holes seen on the left. From diameter 500 there are no pinholes in the saw blades and are made upon request.

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

Material: Plastic window frames

Application: Grooving, crosscutting, angle cutting

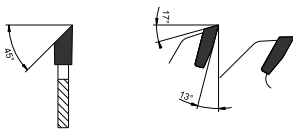
87.1



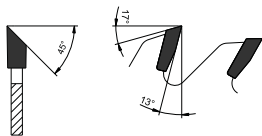
- » used to cut and clean profiles, window ledges and laths in plastic windows, doors production
- » used in sets, for single or double-sided miter or cross cutting
- » tooth geometry designed to reach high-quality and precise cut in thin-walled materials



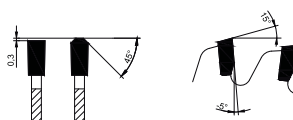
ES-L



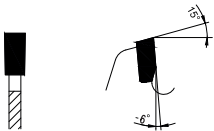
ES-R



TFZ N



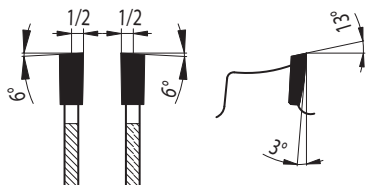
FZ N



| D | S | s | d | z | Teeth |
|-----|-----|-----|--------|----------|-----------|
| 95 | 2,1 | 1,6 | 20 | 20 | ES-L/ES-R |
| 98 | 3 | 2,5 | 32 | 36 | ES-L/ES-R |
| 103 | 2,1 | 1,6 | 32 | 24 | ES-L/ES-R |
| 103 | 2,1 | 1,6 | 32 | 40 | ES-L/ES-R |
| 175 | 2,2 | 1,8 | 20 | 68 | TFZ N |
| 200 | 2 | 1,6 | 30 | 100 | TFZ N |
| 200 | 2,2 | 1,8 | 20, 32 | 100 | TFZ N |
| 250 | 2,2 | 1,8 | 30 | 100, 120 | TFZ N |
| 250 | 2,6 | 2 | 30 | 100 | TFZ N |
| 250 | 4,5 | 3,5 | 20 | 56+8 | FZ N |
| 250 | 4,5 | 3,5 | 20 | 68+5 | FZ N |
| 250 | 5 | 4 | 32 | 32 | FZ N |
| 250 | 5 | 4 | 32 | 63+5 | FZ N |

In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

Material: Building materials, sandwich panels, thin steel profiles
Application: Universal usage in building industry
Machine: Miter saws or dry-cut machines



88 WZ/FA – DRY CUT



Characteristics:

- » for cutting without cooling of sandwich materials made of thin carbon steel or aluminium outer walls, filled with composites, mineral wool or PUR foam, thin steel or aluminium profiles with thickness up to 0,5 mm (typically dry wall profiles)
- » to be used on table saws, radial arm saws and hand-held/dry cut machines with reduced RPM (see table), i.e. Jepson, Elu, Ryobi, Makita, Milwaukee, DeWalt, Black&Decker, etc...
- » suitable for manual or automatic feed

| D | S | s | d | z | ●/○ |
|-----|-----|-----|------|--------|-----|
| 150 | 2,2 | 1,6 | 20 | 30 | ● |
| 160 | 2,2 | 1,6 | 20 | 30 | ● |
| 180 | 2,2 | 1,6 | 20 | 36 | ● |
| 190 | 2,4 | 1,8 | 20 | 38 | ● |
| 200 | 2,4 | 1,8 | 20 | 40 | ● |
| 210 | 2,4 | 1,8 | 30 | 40 | ● |
| 230 | 2,4 | 1,8 | 30 | 44 | ● |
| 235 | 2,4 | 1,8 | 30 | 44 | ● |
| 250 | 2,4 | 2,0 | 30 | 48 | ● |
| 300 | 2,4 | 2,0 | 30 | 60, 80 | ● |
| 305 | 2,4 | 2,0 | 25,4 | 60, 80 | ● |
| 350 | 2,6 | 2,2 | 30 | 80 | ● |
| 355 | 2,6 | 2,2 | 25,4 | 80, 90 | ● |

| D | 160 | 190 | 200 | 250 | 300 | 350 | 400 | 450 |
|-----------------|------|------|------|------|------|------|------|------|
| Recommended RPM | 4000 | 3500 | 3000 | 2000 | 1500 | 1500 | 1000 | 1000 |

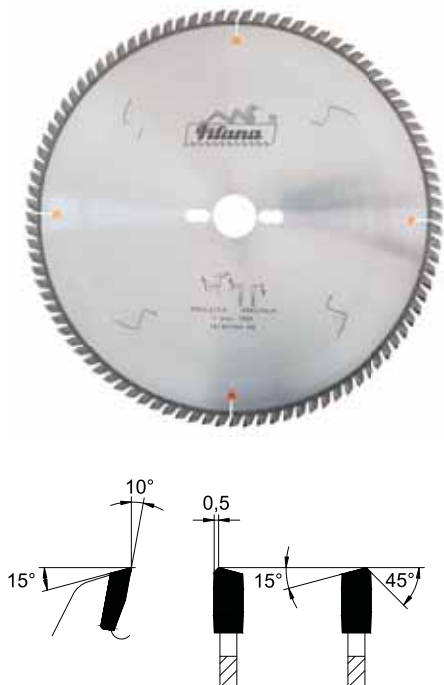
In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

Material: Non-ferrous metals and plastics
Application: Profiles, mouldings, solid materials, tubes
Machine: Automatic feed machines

87 PLEXI K/WZ/FA

- » designed for formatting of boards or cross cutting as well as for use in portable machines
- » suitable for cutting of transparent PMMA thermoplastics, plexiglass and PU boards
- » TCT tips with special geometry and convex side edges of the tooth for excellent cutting edge

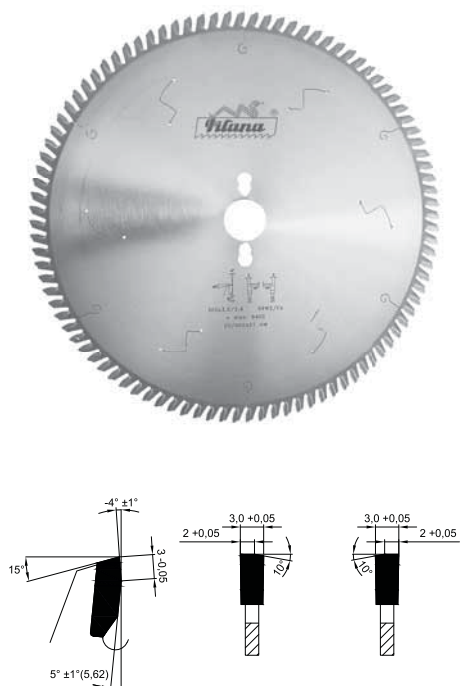
| D | S | s | d | z | Geometry | ●/○ |
|-----|-----|-----|----|-----|----------|-----|
| 300 | 3,2 | 2,5 | 30 | 60 | K/WZ/FA | ● |
| 300 | 3,2 | 2,5 | 30 | 96 | K/WZ/FA | ● |
| 350 | 3,5 | 2,8 | 30 | 108 | K/WZ/FA | ● |
| 350 | 4,4 | 3,2 | 30 | 72 | K/WZ/FA | ○ |
| 350 | 4,4 | 3,2 | 60 | 72 | K/WZ/FA | ○ |



87 PROFILE SUPERIOR CUT WZ/FA

- » for extremely smooth edges
- » suitable for cross cutting, miter cutting or optimizing of profiles in non-ferrous metals, plastics especially acrylic glass or lacquered profiles, polycarbonat (LEXAN)
- » TCT tip with double hook angle and tooth geometry WZ/FA for excellent cutting edge without additional working steps

| D | S | s | d | z | Geometry | ●/○ |
|-----|-----|-----|----|----|----------|-----|
| 300 | 3,0 | 2,4 | 30 | 96 | WZ/FA | ● |



In case that you did not find the type of saw blades which you require in our catalogue, please contact us. We will make them upon your specification.

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TCT or CERMET Saw Blades for Steel Cutting



| | |
|---------------------|--|
| Material: | Ferrous metals |
| Application: | Solid materials, tubes, pipes, profiles, tubes |
| Machine: | High performance circular saw blade machines |

METAL SPEED S/C - THROW AWAY TYPE

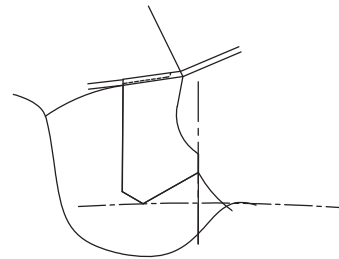
Cermet tipped (C or CH)

- » throw away circular saw blades for structural and low alloyed steels with carbon content less than 0,45% approx. (750-800 N/mm²)
- » „H“ version to be applied on non-alloy or alloyed steels with higher tensile strength (special tooth design, please refer to the sketch below)

TC tipped (S or SH)

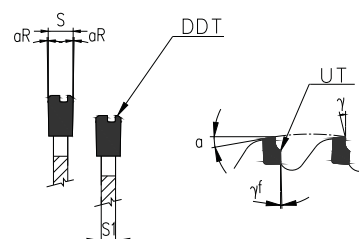
- » for alloyed steels with more than 0,45% carbon content, high strength steels (800 N/mm² +), stainless steels, bearing steels, etc.
- » „H“ version to be applied on steels with difficult cutting conditions – Ti/Ni based „superalloys“ (special tooth design, please refer to the sketch below)

„H“ version picture



IMPORTANT GENERAL INFORMATION

- » for cutting of solid and pipes on stationary cutting machines (Adige, Rattunde, ExactCut, Amada, Tsune, RSA, Nishijimax, etc.) and also in bulk cutting. For flying cut-off or orbital cutting/milling machines see next pages;
- » optional PVD coating (AlTiN, AlTiCrN, etc.) for specific applications (stainless, high Ni content, tubes, Ti based „superalloys“ etc.) is recommended;
- » for Ni/Ti based alloys dedicated special cooling fluid must be used, please talk to your supplier!
- » dimensions and teeth numbers are on request



In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

TYPICAL SIZES AND APPLICATIONS

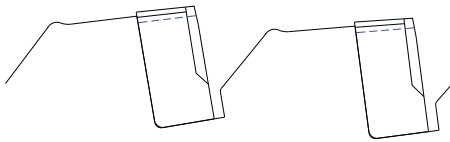
| Ø (mm) | kerf/body (mm) | main bore + pin holes (mm) | teeth count | typical application |
|--------|----------------|----------------------------|-----------------|---------------------|
| 250 | 2,0/1,75 | 32 + 4/9/50 + 4/11/63 | 60/72/80 | solid |
| | | 40 + 4/11/80 + 4/12/64 | 80/90 | tube |
| 285 | 2,0/1,75 | 32 + 4/9/50 + 4/11/63 | 60/72/80 | solid |
| | | 40 + 4/11/80 + 4/12/64 | 80/90/110 | tube |
| 315 | 2,3/2,0 | 32 + 4/11/63 + 4/9/50 | 60/72/80 | solid |
| | | 40 + 4/11/80 + 4/12/64 | 80/90/110 | tube |
| 350 | 2,7/2,4 | 50 + 4/16/80 | 80/100/120/140 | tube |
| 360 | 2,6/2,25 | 40 + 4/16/80 + 4/12/90 | 60/80/100 | solid |
| | | 50 + 4/16/80 + 4/11/90 | 80/100/120/130 | tube |
| 425 | 2,7/2,25 | 40 + 4/16/80 + 4/12/90 | 50/60/72/80/100 | solid |
| | | 50 + 4/16/80 + 4/11/90 | 100/120/130 | tube |
| 460 | 2,7/2,25 | 40 + 4/16/80 + 4/12/90 | 40/50/60/80/100 | solid |
| | | 50 + 4/16/80 + 4/11/90 | 100/120/140 | tube |
| 560 | 3,5/3,0 | 50 + 4/16/80 + 4/11/90 | 40/50/60/80 | solid |
| 580 | 3,2/2,7 | 80 + 4/22/120 | 40/50/60/80 | solid |
| 620 | 3,5/2,7 | 50 + 4/15/80 | 48/60/72 | solid |
| 750 | 3,8/3,2 | 80 + 4/21/80 | 60/80/100 | solid |

TYPICAL APPLICATION VALUES

| Material grade | Solid/tube | Blade type | Cutting speed m/min | Feed speed Fz/tooth | PVD coating |
|----------------|------------|----------------|---------------------|---------------------|-------------|
| St37 | Solid | Metal speed C | 110-140 | 0,06-0,08 | |
| 42 CrMo4 | Solid | Metal speed CH | 90-110 | 0,04-0,06 | |
| 44 MnSiV | Solid | Metal speed CH | 90-110 | 0,04-0,06 | |
| C45 | Solid | Metal speed C | 90-110 | 0,05-0,07 | |
| 20CrMo5 | Solid | Metal speed C | 100-125 | 0,06-0,07 | |
| 100 Cr6 | Solid | Metal speed S | 70-90 | 0,04-0,06 | yes |
| 50CrV4 | Solid | Metal speed S | 80-90 | 0,04-0,05 | yes |
| X20Cr13 | Solid | Metal speed SH | 50-90 | 0,04-0,05 | yes |
| St52 | Tube | Metal speed S | 230-270 | 0,04-0,08* | yes |
| E275/355+C | Tube | Metal speed CH | 220-250 | 0,04-0,15* | yes |

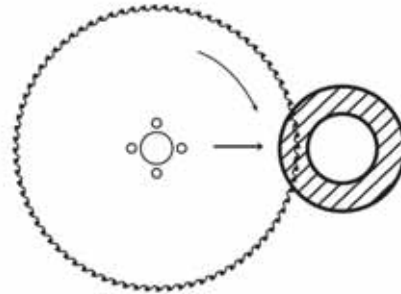
* variable feed speed in cut (entry – centre – exit)

- » cutting speed for tube cutting can be raised for thin walled tubes/profiles to eliminate vibrations
- » values are typical only, please consult with our technical department prior to ordering



Blades for single/twin flying cut-off machines (ERW/HFW steel pipes and profiles)

- » PVD coated carbide tipped saw blade for pipe/tube and construction steel profiles (HSS) cutting on fly cutting machines
- » limited regrinding possibilities
- » high cutting speed with burr-free and smooth surface
- » to be used on tube/profile forming lines of the tube mills
- » for Adige, Oto Mills, Sinico, Adda Fer, etc.



NEW

For loose or/and heavy inner scarf applications we offer special tooth and blade design to protect cutting tip from early damage.

TYPICAL SIZES AND APPLICATIONS

| Ø (mm) | kerf/body (mm) | main bore + pin holes (mm) | tooth count | typical application |
|---------|----------------|----------------------------|-----------------|---------------------|
| 400 | 2,8/2,5 | 50 + 4/16/80 | 100/120/130 | Fly cut-off tube |
| 450 | 2,8/2,5 | 50 + 4/16/80 | 100/120/140 | Fly cut-off tube |
| 500 | 3,5/3,0 | 50 + 4/16/80 | 120/140/160 | Fly cut-off tube |
| | | 90 + 3/12,5/160 | 120/140/160 | Fly cut-off tube |
| 550/560 | 3,7/3,2 | 80 + 4/23/120 | 120/140/160/170 | Fly cut-off tube |
| 600 | 3,6/3,0 | 90 + 3/12,5/160 | 130/140/160/180 | Fly cut-off tube |
| 650 | 3,8/3,2 | 140 + 4/18/170 | 150/160/180 | Fly cut-off tube |

TYPICAL APPLICATION VALUES

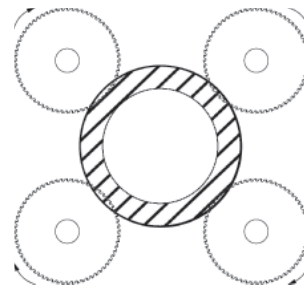
| Material grade | Solid/tube | Blade type | Cutting speed m/min | Feed speed Fz/tooth | PVD coating |
|----------------|------------|----------------|---------------------|---------------------|-------------|
| E235 | tube | Metal speed SH | 350-400 | 0,04-0,12* | yes |
| St52 | tube | Metal speed SH | 350-400 | 0,03-0,1* | yes |
| HSLA100 | tube | Metal speed SH | 350-400 | 0,03-0,08* | yes |

* variable feed speed in cut (entry - centre - exit)



BLADES FOR ORBITAL CUTTING LINES (ERW/HFW steel pipes and profiles)

- » carbide tipped saw blade for pipe and tube cutting on orbital cutting machines, construction profiles (HSS)
- » possibility of regrinding
- » PVD coating
- » for Nakata, SMS-Meer, Adda Fer, Kusakabe, etc



Dimensions and teeth numbers are on request.

TYPICAL SIZES AND APPLICATIONS

| Ø (mm) | kerf/body (mm) | main bore + pin holes (mm) | tooth count | typical application |
|---------|----------------|----------------------------|-------------|--------------------------|
| 250 | 3,2/2,5 | 45 + 4/16/80 | 52/64/72 | Orbital fly cut-off tube |
| 300 | 3,2/2,5 | 80 + 4/16/80 | 52/64/72 | Orbital fly cut-off tube |
| 350/355 | 3,2/2,5 | 80 + 4/16/80 | 52/64/72 | Orbital fly cut-off tube |
| | 3,8/3,0 | 80 + 3/12,5/160 | 52/64/72 | Orbital fly cut-off tube |
| 380 | 3,8/3,0 | 115 + 4/21/200 | 52/64/70 | Orbital fly cut-off tube |
| | 4,3/3,2 | 115 + 4/21/200 | 52/64/70 | Orbital fly cut-off tube |

TYPICAL APPLICATION VALUES

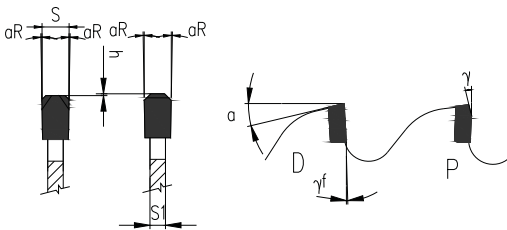
| Material grade | Solid/tube | Blade type | Cutting speed m/min | Feed speed Fz/tooth | PVD coating |
|----------------|------------|----------------|---------------------|---------------------|-------------|
| E235 | tube | Metal standard | 300-350 | 0,05-0,25* | yes |
| E355 | tube | Metal standard | 300-350 | 0,05-0,25* | yes |

* variable feed speed in cut (entry - centre - exit)



METAL STANDARD

- » cutting of solids, tubes and construction profiles (HSS), rail tracks, large billets
- » non-alloy or alloy steels, bearing steel
- » possibility of regrinding
- » number of teeth and type of blade depending on application
- » diameter of the blade: from 280 to 1300 mm



TCT Metal standard (typical sizes)

| Ø (mm) | kerf/body (mm) | main bore + pin holes (mm) | tooth count | typical application |
|--------|----------------|----------------------------|-------------|--------------------------------|
| 630 | 6,5/5,0 | 80 + 8/27/160 | 60 | rail cutting |
| 720 | 5,5/4,5 | 80 + 8/32/200 | 60/72/80 | large steel billets |
| 760 | 5,5/4,5 | 80 + 8/27/160 | 60/80/100 | steel billets/thick wall tubes |
| 860 | 7,0/5,5 | 80 + 8/32/200 | 60 | steel billets |

- many other sizes upon request for Linsinger, Wagner, Kasto machines...

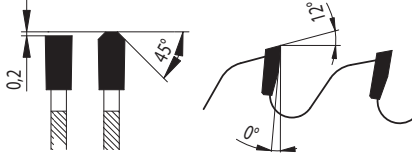
Material: Ferrous & nonferrous metals
Application: Solid materials, pipes, profiles, tubes
Machine: Automatic or manual feed machines

METAL CUT

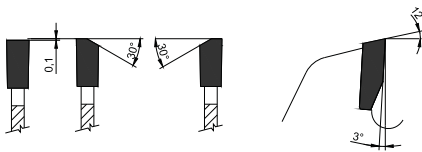
- » for quick dividing without cooling of bars, pipes, tubes and profiles made of construction steels or aluminium alloys with approximate wall thickness 0,5-6 mm
- » to be used on cut-off, table saws, radial arm saws and hand-held/dry cut machines with reduced RPM (see table), for example Jepson, Elu, Ryobi, Makita, Milwaukee, DeWalt, Black&Decker, etc...
- » special geometry and TCT grade enhances lifetime of the cutting edge, cut quality and multiple use of the saw blade
- » TCT tips are resharpenable



WZ/FA



WZ/FA/F



| D | S | s | d | z | Geometry | ●/○ |
|-----|-----|-----|------|----|----------|-----|
| 180 | 1,8 | 1,4 | 20 | 44 | WZ/FA | ● |
| 190 | 1,8 | 1,4 | 20 | 48 | WZ/FA | ● |
| 305 | 2,2 | 1,8 | 25,4 | 60 | WZ/FA/F | ● |
| 305 | 2,2 | 1,8 | 25,4 | 78 | WZ/FA/F | ● |
| 355 | 2,2 | 1,8 | 25,4 | 66 | WZ/FA/F | ● |
| 355 | 2,2 | 1,8 | 25,4 | 90 | WZ/FA/F | ● |

| D | 160 | 190 | 200 | 250 | 300 | 350 | 400 | 450 |
|-----------------|------|------|------|------|------|------|------|------|
| Recommended RPM | 4000 | 3500 | 3000 | 2000 | 1500 | 1500 | 1000 | 1000 |

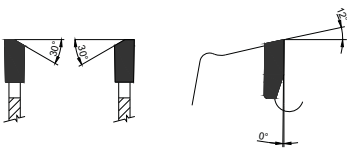
CERMET

- » cutting of steel & plastic pipes with a hand machine
- » standard steels, stainless, copper, plastics
- » cermet tipped circular saw blade for heavy duty applications, saw blade can be sharpened

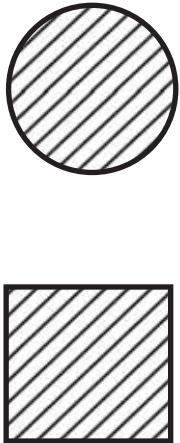


| D | S | s | d | z | Geometry |
|-----|-----|-----|----|----|----------|
| 140 | 1,8 | 1,4 | 62 | 46 | WZ/FA |
| 165 | 1,8 | 1,4 | 62 | 54 | WZ/FA |

Dimensions and teeth numbers are on request.



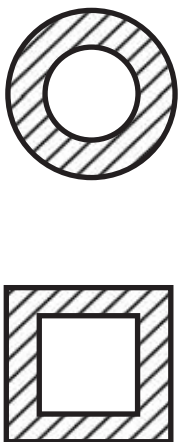
Tab. no. 3: Teeth number indication based on material size - full materials



| D - Blade diameter [mm] | Number of Teeth | Ø of cutting materials | | | | | | | | | | | |
|-------------------------|-----------------|------------------------|----|----|----|----|----|----|----|-----|-----|-----|---|
| | | 20 | 30 | 40 | 50 | 60 | 70 | 80 | 90 | 100 | 120 | 140 | |
| 250 | 60 | | ● | ● | ● | ● | | | | | | | |
| | 72 | ● | ● | | | | | | | | | | |
| | 80 | ● | | | | | | | | | | | |
| 285 | 60 | | | ● | ● | ● | ● | | | | | | |
| | 72 | | ● | ● | ● | ● | | | | | | | |
| | 80 | ● | ● | ● | ● | | | | | | | | |
| 315 | 60 | | ● | ● | ● | ● | ● | ● | | | | | |
| | 80 | ● | ● | ● | ● | ● | | | | | | | |
| 360 | 60 | | | ● | ● | ● | ● | | | | | | |
| | 80 | | ● | ● | ● | ● | | | | | | | |
| | 100 | ● | ● | ● | ● | | | | | | | | |
| 420 | 60 | | | | ● | ● | ● | ● | ● | ● | ● | ● | |
| | 80 | | | ● | ● | ● | ● | ● | | | | | |
| 460 | 60 | | | | | | | | ● | ● | ● | ● | ● |
| | 80 | | | | | ● | ● | ● | ● | ● | ● | | |
| | 100 | | | ● | ● | ● | ● | ● | ● | ● | | | |

● Recommended

Tab. no. 4: Teeth number indication based on material size - tubes, profiles



| D - Blade diameter [mm] | Wall thickness | Ø of cutting materials | | | | | | | | | |
|-------------------------|----------------|------------------------|-----|-----|-----|-----|-----|-----|-----|-----|--|
| | | 30 | 40 | 50 | 60 | 70 | 80 | 90 | 100 | 120 | |
| 315 | 3-5 | 110 | 110 | 100 | 100 | 100 | 100 | | | | |
| 360 | 3-6 | | 120 | 120 | 100 | 100 | 100 | 80 | 80 | | |
| 400 | 3-6 | | 140 | 140 | 140 | 120 | 120 | 100 | 100 | | |
| | 6-10 | | 120 | 120 | 120 | 100 | 100 | 100 | 100 | | |
| 460 | 3-6 | | | 140 | 140 | 120 | 120 | 120 | 120 | | |
| | 6-10 | | | 140 | 120 | 120 | 100 | 100 | 100 | | |
| 500 | 5-10 | | | | 160 | 140 | 140 | 120 | 120 | | |
| | > 10 | | | | 160 | 140 | 140 | 120 | 120 | | |
| 560 | 5-10 | | | | | 160 | 160 | 140 | 140 | 120 | |
| | > 10 | | | | | 160 | 160 | 140 | 140 | 120 | |

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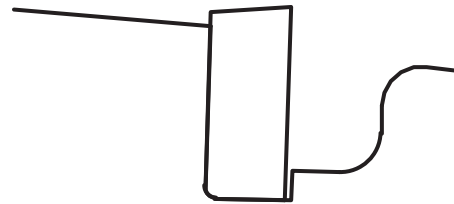
Special TCT Saw Blades, Segments Reduction and Distance Rings



| | |
|---------------------|-------------------------|
| Material: | Rock / mineral wool |
| Application: | Solid materials |
| Machine: | Automatic feed machines |

95 MINERAL/ROCK WOOL

- » cutting along and across of mineral fibres
- » specially designed saw body improves resistance against abrasive wear
- » TCT saw blades for cutting of mineral fibres are produced in all dimensions on request of our customers



Thin Kerf TCT Saw Blades

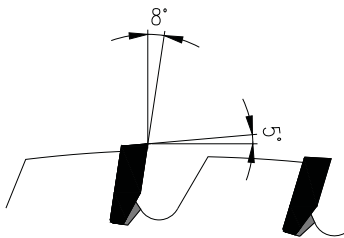
- » suitable for cutting of standard and higher quality dry woods
- » applicable in production of floors or furniture for cross cutting and cutting along the grain
- » less force during feeding, better energy effectiveness and less waste produced
- » produced with black coating for smoother surface of the body and extra tensioning in the body to prevent wobbling
- » thin kerf saw blades are produced in diameters from 100 - 250 mm, body thickness 0,9 - 1,2 mm



Material: Meat
Application: Meat processing
Machine: Manual feed machines, hand machines

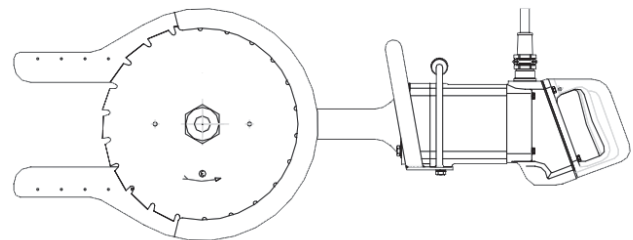
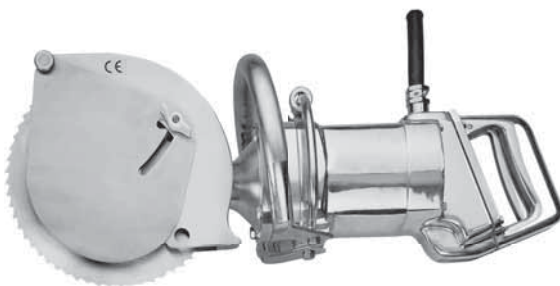
55 WZ FOOD INDUSTRY Saw Blades

- » supplied in WZ tooth shape with stainless steel body
- » used in slaughter houses for industrial breaking of meat for EFA (SCHMID & WEZEL), FREUND, JARVIS and many other brands



| D | S | s | d | z |
|-----|-----|-----|---|----|
| 180 | 1,9 | 1,5 | * | 44 |
| 210 | 1,9 | 1,5 | * | 40 |
| 230 | 1,9 | 1,5 | * | 44 |
| 270 | 1,9 | 1,5 | * | 52 |
| 270 | 2 | 1,6 | * | 48 |
| 300 | 2 | 1,6 | * | 52 |
| 330 | 1,9 | 1,5 | * | 46 |
| 360 | 2 | 1,6 | * | 64 |

* to customer request



In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.



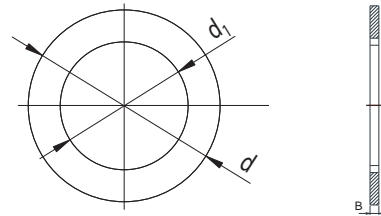
WE CARRY OUT:

- » blade modifications (bores and holes) to fit various machinery brand requirements
- » production of saw blades and segments based on customer's drawing documentation up to 1 300 mm in diameter
- » development and production based on cutting conditions and requirements of individual wood processing companies
- » development and production of saw blades in cooperation with wood-processing machinery manufacturers



Reduction Rings

Ring sizes available upon request



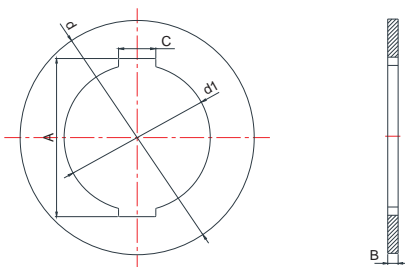
Hogging Heads

- » for longitudinal and transverse hogging with or without the use of a scoring blade
- » quality of cutting edges depends on the type of circular saw blade used
- » for gradual cutting with TCT tipped segments
- » for particulate or fibrous materials like chipboard or MDF with or without a laminated or veneered layer



TCT Segments Accessories

- » steel jigs for fastening of TCT segments or ring saws used in primary processing of goods
- » to be used in machines for primary processing of wood



Distance rings

- » to be used to distance saw blades on a shaft
- » made of steel
- » dimensions on request

How to order:

- » $d \times d1 \times B + C/A$

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pilanawood.com



PCD Saw Blades



Material: Coated and uncoated chipboards, coated and uncoated MDF, various plastic materials, non-ferrous metals, building and insulation materials

Machine: Panel sizing saws, forming saws, hand saws

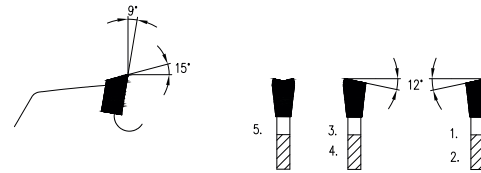
- » saw blades are tipped with tips made from polycrystalline diamonds (PCD)
- » saw blades are suitable for panel sizing applications of single boards
- » for MDF, HDF, HPL, laminated or melaminated chipboards, panels made of composite materials, panels used in flooring, aluminium and plastic profiles



77 PCD SAW BLADE

| D | S/s | d | z | Teeth | ●/○ |
|-----|-----------|----|----|-------|-----|
| 303 | 3,2 / 2,4 | 30 | 60 | KX/WZ | ● |

* other dimensions and tooth geometries on request



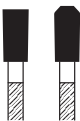
73 FZ and KON PCD Scoring Saw Blades

- » scoring saw blades suitable for cutting applications together with panel sizing saw blades

| D | S/s | d | z | Teeth | ●/○ |
|-----|-----------------|------------------|-------|-------|-----|
| 120 | 2,8 - 3,6 | 20 | 12+12 | FZ | ○ |
| 120 | 2,8 - 3,6 | 50 ¹⁾ | 12+12 | FZ | ● |
| 120 | 2,8 - 3,6 | 30 ²⁾ | 12+12 | FZ | ● |
| 125 | 2,8 - 3,6 | 20 | 12+12 | FZ | ○ |
| 180 | 4,3 - 5,1 / 3,5 | 30 | 30 | KON | ○ |
| 200 | 4,3 - 5,1 / 3,5 | 20 | 30 | KON | ○ |

1/ Rapido 2/ Dimar

TFZ



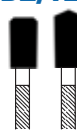
KON



WZ



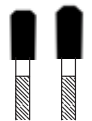
DZ/TZ



FZ



TZ/TZ



77 FZ PCD Saw Blades

- » for Cembrit, Varicor, Trespa, eternit and acrylic boards
- » available tip height sizes 3,0 and 5,6 mm

| D | S/s | d | z | Teeth |
|-----|---------|----|-----------------|------------|
| 160 | 2,2/1,6 | 20 | 4, 6, 8, 12, 20 | FZ, TZ, RZ |
| 190 | 2,2/1,6 | 20 | 4, 6, 8, 12, 20 | FZ, TZ, RZ |
| 210 | 2,2/1,6 | 20 | 4, 6, 8, 12, 20 | FZ, TZ, RZ |
| 230 | 2,2/1,6 | 20 | 4, 6, 8, 12, 20 | FZ, TZ, RZ |

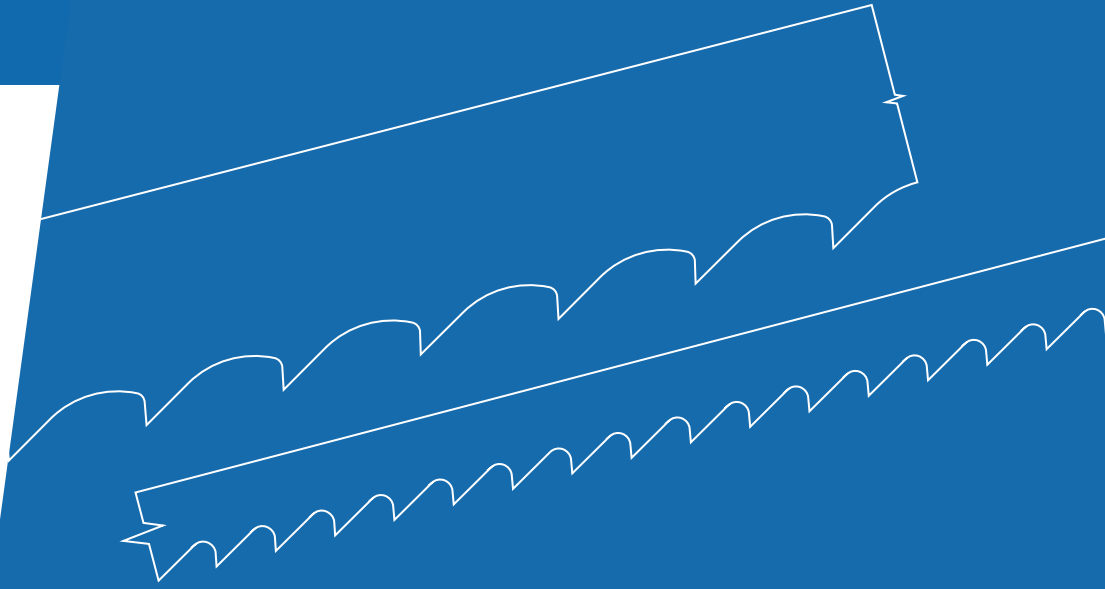
In case that you did not find the type of saw blades you require in our catalogue, please contact us. We will make them upon your specification.

We also offer complete servicing of PCD saw blades!

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pilanawood.com



Band Saw Blades for Wood



Dimensions:

Dimensions of band saw blade depend on the machine type and material type.

Width of the band saw blade type 40 – C75 is determined by the smallest radius that is cut in the material. Otherwise the width may be by max. 10 mm wider than width of the flywheel of the particular machine.

| Minimum radius (mm) | 25 | 50 | 100 | 150 | 200 | 300 | 400 | 500 | 600 | 700 |
|---------------------|----|----|-----|-----|-----|-----|-----|-----|-----|-----|
| Width of blade (mm) | 6 | 10 | 15 | 20 | 25 | 30 | 35 | 40 | 45 | 50 |

Band saw blades type 40 – WM1, 40 – WM2 the width of blade is determined by machine builder and it is calculated based on the width of the flywheel.

Thickness of band saw blade must not exceed value S1 because material of band saw blade would be too strained while bending and mechanical damage could happen.

$$S_1 = \frac{\text{diameter of welded loop [mm]}}{1000}$$

When choosing the right tooth pitch, the height of cutting material must be considered. We recommend 3 – 5 teeth to be in cut.

Working conditions:

Maximum cutting speed of band saw blade is recommended by the machine builder. Usually the speed is between 20 – 35 m/sec. General rule is that the harder cutting material, the lower cutting speed we use.

General rules for usage:

1. Before you start cutting check if the band saw blade is properly sharpened, set and whether it is not damaged or heated up. Band saw heating can be recognized if blade is purple color even after cooling.
2. Band saw blade must be properly tightened. Please be aware not to tighten the blade too much. This could cause disruption of the blade.

Maximum recommended values of straightening the band saw blade.

Type: 40 C75

| Dimensions HxSxT [mm] | Tensile stress [Mpa] | Tensioning strength [N] |
|-----------------------|----------------------|-------------------------|
| 6x0,5x4 | 25 | 105 |
| 8x0,5x5 | 25 | 142,5 |
| 10x0,6x6 | 25 | 211,5 |
| 12x0,6x7 | 30 | 320 |
| 15x0,6x7 | 30 | 428 |
| 16x0,6x7 | 30 | 464 |
| 20x0,6x8 | 30 | 585 |
| 25x0,6x8 | 30 | 893 |
| 25x0,7x8 | 30 | 1006 |
| 30x0,7x10 | 30 | 1245 |
| 35x0,8x10 | 40 | 1702 |
| 40x0,7x10 | 45 | 2190 |
| 40x0,8x10 | 45 | 2550 |
| 45x0,9x12 | 50 | 3564 |
| 50x0,9x12 | 50 | 4014 |

Type: 40 WM1, 40 WM2

| Dimensions HxSxT [mm] | Tensile stress [Mpa] | Tensioning strength [N] |
|-----------------------|----------------------|-------------------------|
| 32x0,9x22 | 40 | 1840 |
| 32x1,0x22 | 40 | 2040 |
| 32x1,1x22 | 40 | 2240 |
| 35x0,9x22 | 40 | 2050 |
| 35x1,0x22 | 40 | 2280 |
| 35x1,1x22 | 40 | 2510 |
| 40x0,9x22 | 45 | 2700 |
| 40x1,1x22 | 40 | 2930 |
| 50x1,1x22 | 50 | 4760 |

3. Guidance of blade and guiding wheels must be clean from chips and resin. Allowance between guiding and band saw blade may be maximum 0,2mm. The distance between the top guidance from the cutting material should be as little as possible so that blade rigidity is as big as possible.
4. Hold the cutting material with both hands so that your body is not in the same level as the cutting blade. Do not cut material using extra strength.
5. Start cutting after the proper cutting speed is achieved. Do not shorten or slow down the cutting period by friction of the blade against the side of material or slowing against cutting material.
6. While cutting big dimensions it is important to use fixed guidance. While finish sizing the material it is important to use holding device.
7. It is necessary to replace the band saw blade and set it away (even if not dull). Mechanical attributes of band saw blade will remain the same.
8. Do not let the band saw to heat up by any means. If this happens, set away the blade immediately and after cooling set and sharpen it again. You can also check the straightness. To prevent heating it is better to sharpen the blades in time and follow the right cutting conditions.
9. Replace the band saw blade if any break off occurs.
10. After finishing cutting process do not leave the band saw blade straightened in the machine, always loosen it

Service:

Tooth setting is done to 1/2 to 2/3 tooth height and is set by 1/2 to 1/3 over the size of band saw thickness. Tooth setting can be even bigger for soft woods but there must never happen that a piece of wood remains in between the teeth. Please keep the same distance while tooth setting the whole band saw blade. Pay special attention to regularity of setting (max. 0,1 mm). If not, run in of blade might occur on the side where the bigger tooth set is.

Tooth sharpening is done by ceramic disc with medium grain roughness. Tooth face is sharpened. If the blade is extra dull, it is possible to sharpen the tooth back as well. Prevent the tooth to become black from annealing (unwanted stage). While grinding it is needed to keep the radius on tooth bottom. Sharp edge on tooth bottom could cause blade breakage.

Recommendations How to Use Band Saw Blades

The most common causes of trouble while cutting with band saw blades is wrong choice of band saw blade type, dimensions of blade or wrong tooth pitch for particular material. Not adhering to cutting conditions is the second most common problem along with usage of insufficiently set or dull band saw blade.

In the below tab you can find most common problems and their possible solution.

| Most common problem | Probable reason | Solution |
|------------------------|---|--|
| Broken/ fissured blade | • Wrong tooth pitch | Choose a blade with tooth pitch so that 3-5 teeth are in cut |
| | • Overstressing of blade | Lower the blade straightness between circling wheels |
| | • Feed is too high | Lower down-force of material on the blade |
| | • Teeth are in contact with material before cutting | Adjust allowance between blade/material to minimum 10mm before cutting |
| | • Diameter of guiding wheels is too small | Use a thinner blade |
| | • Side press on band saw | Adjust manually |
| Undercutting | • Blade friction against carrier wheels | Adjust parallelity of wheels |
| | • High feed | Lower the feed speed |
| | • Insufficient blade straightness | Straighten the blade |
| | • Damaged top tooth line | Use a blade with harder teeth (hardened) |
| | • Big allowance between guiding wheels and blade | Lower the guiding wheels |
| Rough cut | • Big distance between guidance and material | Adjust distance from guidance |
| | • High feed | Adjust cutting conditions |
| Blunting of blade | • Wrong tooth pitch | Use correct tooth pitch |
| | • Cutting with tooth backs | Turn over the band saw blade |
| Tooth breaking off | • High cutting speed | Lower the cutting speed |
| | • High pressure on blade | Lower the feed speed |
| | • Wrong choice of tooth pitch | Use correct tooth pitch |
| | • Cutting with tooth backs | Turn over the band saw blade |
| Twisting of blade | • Dirt in cutting material | Do not cut in places where dirt occurs (stones, metals etc.) |
| | • Blade stuck in cut | Lower the feed speed |
| | • Free guiding of blade | Adjust the blade guiding |

Safety rules for band saw blade usage

Application:

Band saw blades are used for splitting, cutting off wood logs, woodbase materials and light metal alloys. Band saw blades can be used for mechanical or manual feed speed while following the recommended safety rules.

Unwrapping/packing:

When unwrapping/packing and during manipulation (i.e. when setting up into the machine) please proceed with maximum caution! Danger of getting hurt by very sharp objects.

Transport:

Move the tools in an appropriate packing!
Danger of getting hurt!

Application:

Do not exceed maximum tensioning limit. Make sure the area of tensioning wheels is kept clean.

Tool:

Check the cutting edge. Check the machine set up.

Machine:

It is necessary to stop the machine while tool replacement.

Tool set up:

Set up the tool into the machine and secure it following the manufacturer's specification. Follow the manufacturer's safety rules.

Service:

Always keep to safety instructions.

Proper functioning and safety will be met only when keeping to operating instructions of Pilana Wood s.r.o.

How to use the tool:

- Follow the valid regulations
- Unskilled usage and usage out of purpose is forbidden.
- If not required by national law, use specific objects to protect your eyes, ears and mouth.
- Never leave the machine unattended without monitoring!
- Please clean the band saw blades in time and remove resin. Clean blades have longer life-time and are therefore more economical..

Sharpening/servicing:

Well-timed sharpening and cleaning the blade are basic conditions how to keep the quality and follow the safety rules. It is important to have these activities done by an expert.

Tools are often covered by resin and dust etc. Any dirt negatively influences the cutting performance. To clean the machine use only convenient objects, which do not cause rust or chemical damage to band saw blades.

Material: Natural wood
Application: Cutting massive natural wood
Machine: Mobile band saw machines



40 - Band Saw Blades for Mobile Band Saw Machines

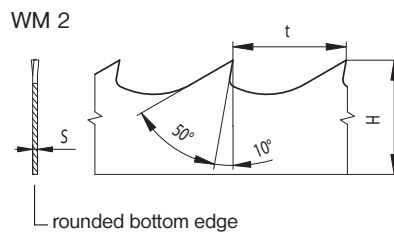
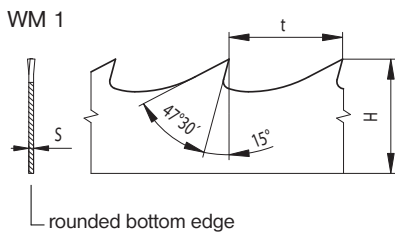
Characteristics:

- » we supply band saw blades welded to requested length or in coils of 25, 50 or 100 m
- » band saw blades type WM1 are for cutting of soft woods
- » band saw blades type WM2 are for cutting of hard woods

| Type | Geometry | Application |
|------|----------|---------------------------|
| WM 1 | 15°/28° | soft wood |
| WM 2 | 10°/30° | hard, frozen or soft wood |

Type:

- V** – toothed
- R** – toothed, set
- RO** – toothed, set, sharpened
- ROK** – toothed, set, sharpened, hardened



Tooth pitch (t):

22 mm | 22,2 mm

EXPERT

Working time: 2 hours + 12 hours on rest

Basic line of band saws for cutting of soft, hard and frozen wood. This most popular band saw ensures a high quality cut and maximum reliability under all cutting conditions.

Used material: high quality German steel with chromium and vanadium content; hardness 42 - 44 HRc; polished silver surface; rounded bottom edge to prevent cracking; hardness of hardened tips 63 - 65 HRc.

Dimensions H x S (in mm)

| | |
|----------|----------|
| 35 x 1,0 | 35 x 1,1 |
| 40 x 1,0 | 40 x 1,1 |
| | 50 x 1,1 |

SILVER MASTER

Working time: 2,5 hours + 12 hours on rest

Premium line of band saws for cutting of soft, hard, frozen and exotic wood. Due to its excellent material properties it meets the most demanding requirements for quality of the cut.

Used material: premium German steel of the highest quality with nickel and molybdenum content; hardness 44 - 46 HRc; polished silver surface; rounded bottom edge to prevent cracking; hardness of hardened tips 63 - 65 HRc.

Dimensions H x S (in mm)

| | |
|----------|----------|
| 32 x 1,0 | 32 x 1,1 |
| 35 x 1,0 | 35 x 1,1 |
| 40 x 1,0 | 40 x 1,1 |

GOLD MASTER

Working time: 3 hours + 12 hours on rest

Top line of band saws for cutting of soft, hard, frozen and exotic wood under the most challenging cutting conditions. Modification with hardened tips is most recommended.

Used material: premium German steel of highest quality with nickel and molybdenum content; hardness 44 - 46 HRc; polished golden surface; rounded bottom edge to prevent cracking; hardness of hardened tips 63 - 65 HRc.

Dimensions H x S (in mm)

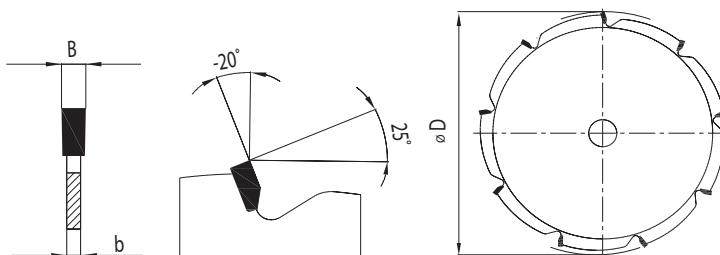
| | |
|-----------|----------|
| 32 x 1,07 | 35 x 1,0 |
| 38 x 1,14 | 40 x 1,0 |
| 50 x 1,1 | |



80 – Scoring Saw Blades for Band Saws

» for removing of bark from logs, while extending the lifespan of the band saw

| D | S | d | z | Teeth |
|-----|-----|----|---|-------|
| 180 | 5,0 | 20 | 9 | FZ N |



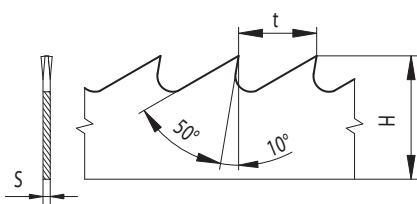
Material: Natural wood
Application: Cutting of natural wood
Machine: Band saw machines



Band Saw Blades for Carpenters

Characteristics:

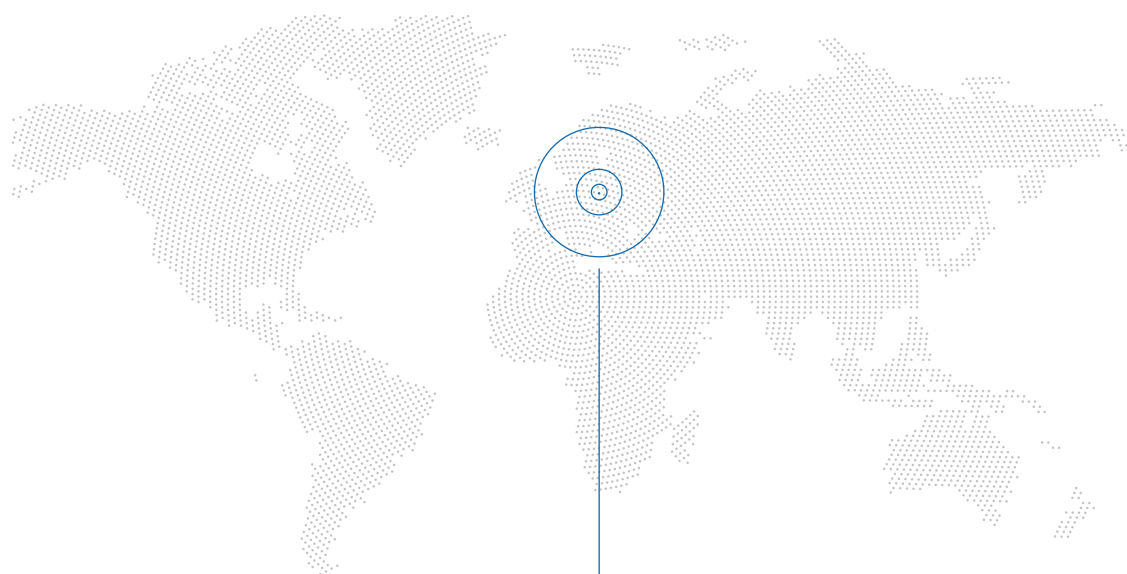
- » natural wood
- » joinery, carpentry
- » joining band saw machines
- » we produce the following modifications of band saw blades - toothed, set, sharpened, hardened
- » band saws are supplied in coils of 25, 50, 100 m or welded to a particular machine length
- » material type used - carbon steel C 75 – material hardness 42 – 44 HRC



| H | S | t | C 75 set | C 75 set and sharpened | C 75 set, sharpened and hardened 64 HRC |
|----|-----|----|----------|------------------------|---|
| 6 | 0,5 | 4 | ● | ● | ● |
| 8 | 0,5 | 5 | ● | ● | ● |
| 10 | 0,4 | 6 | ● | ● | ● |
| 10 | 0,5 | 6 | ● | ● | ● |
| 10 | 0,6 | 6 | ● | ● | ● |
| 12 | 0,6 | 7 | ● | ● | ● |
| 15 | 0,4 | 7 | ● | ● | ● |
| 15 | 0,5 | 7 | ● | ● | ● |
| 15 | 0,6 | 7 | ● | ● | ● |
| 15 | 0,7 | 7 | ● | ● | ● |
| 20 | 0,4 | 7 | ● | ● | ● |
| 20 | 0,4 | 8 | ● | ● | ● |
| 20 | 0,6 | 8 | ● | ● | ● |
| 20 | 0,7 | 8 | ● | ● | ● |
| 25 | 0,6 | 8 | ● | ● | ● |
| 25 | 0,7 | 8 | ● | ● | ● |
| 30 | 0,7 | 10 | ● | ● | ● |
| 35 | 0,7 | 10 | ● | ● | ● |
| 40 | 0,7 | 10 | ● | ● | ● |
| 45 | 0,9 | 12 | ● | ● | ● |
| 50 | 0,9 | 12 | ● | ● | ● |



A large rectangular area with horizontal lines, intended for handwritten notes.



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