

SWEDEX

SAW BLADES

See new price list

CATALOGUE
2021/22

Made in Sweden



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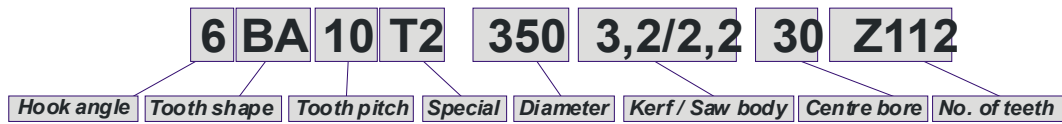
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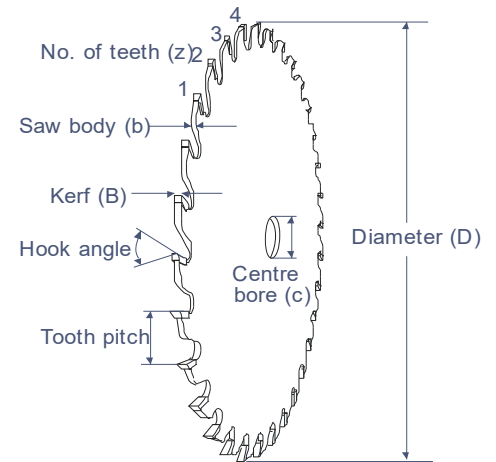
Code system



Swedex code system specifies the composition of the saw blade

- First the hook angle is specified, in this example 6 degrees.
- Negative hook angle is indicated by N, e.g. N2.
- Tooth shape is specified by two or three letters.
- Tooth pitch is the distance between two adjacent teeth.
- Special indicates different features of the saw blade, e.g. T2 states that the saw blade has smaller kerf and SP states that it is a special saw blade.
- Thereafter the diameter is specified (in mm like the other measures).
- Kerf is the width of the TCT tooth.
- Saw body is the thickness of the steel body.
- The centre bore is specified with the general tolerance H7
- No. of teeth is always written after the letter z.

In this catalogue we use the following abbreviations: diameter (D), kerf (B), saw body (b), centre bore (c), no. of teeth (z), wiper slots (RS)



HOOK ANGLE

The hook angle depends on the material, type of cutting and machine type. Some general hook angles for a range of materials are shown below.

Negative 5-10° - crosscutting of wood in pendulum and parallel saws, edge band cutting and trimmer machines using with feed.

Negative 2-5° - cutting of metals with manual feed, plastics and laminates.

6-10° - crosscutting of wood, hard plastics and veneered and laminated boards. Metal sawing with automatic feed.

5-15° - crosscutting of wood. Panel sizing of chipboards, plastics, plywood and veneered boards.

22° - ripping of dry or green wood.

25-30° - ripping and edging of green wood.



TOOTH SHAPE

Tooth shape indicates what kind of top grinding the saw blade has. Here the most common types are shown. Although there are several other types and combinations than the ones listed below.

AA. Straight teeth

For ripping wood, including multirip sawing. Can be used with high feed speeds where an average surface finish is required.



BA. Alternately beveled teeth

For ripping and crosscutting wood. Panel size sawing, e.g. of plywood. Gives good finish.



BAE. Alternately beveled teeth with chamfer

For sawing of thin and hard plastics.



CA. Right hand beveled teeth

DA. Left hand beveled teeth

All teeth are beveled in the same direction. Gives good finish. Used for pre-sawing, scribing, tenoning, and panel sizing.



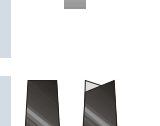
EA. Trapezoidal teeth

Roughing and finishing teeth. For sawing of coated and non-coated woodblocks e.g. chip-, fibre-, MDF- and HDF-boards. Also suitable for plastic and laminated boards.



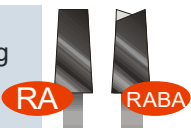
EAM. Trapezoidal teeth

EAM for sawing of metal.



RA. Straight teeth with conical sides

Used as a scribing saw blade when fractioning boards, prior to panel sizing.

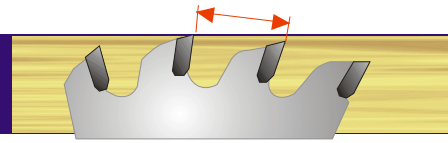


RABA. Alternately beveled teeth with conical sides

EAXH. Alternately straight and inverted V tooth, with hollow ground front
For sawing of varnished and coated boards.



TOOTH PITCH

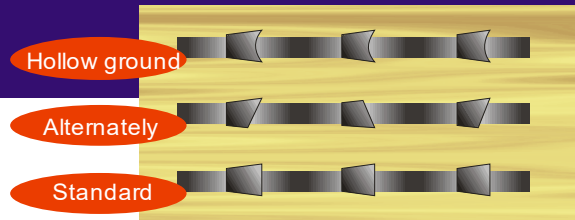


Tooth pitch is an important factor when choosing blades for different types of work. The pitch is the distance between the front faces of adjacent teeth and is given in mm. The formula to the right can be used for calculating the tooth pitch.

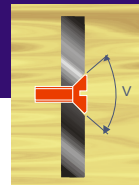
$$\text{Tooth pitch} = \frac{\text{Diameter} * \pi}{\text{No. of teeth}}$$

FRONT GRIND

The front of the tooth is straight as standard. To get maximum sharpness and the best cutting performance the teeth can also be alternately beveled or hollow ground.



KEYWAYS & SCREW/PIN HOLES



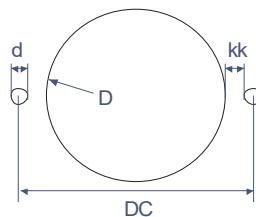
Screw- and pin holes

Screw holes (FH) and pin holes (PH) are specified by the pitch circle (DC) or "edge to edge" (kk), as shown in the picture to the right.

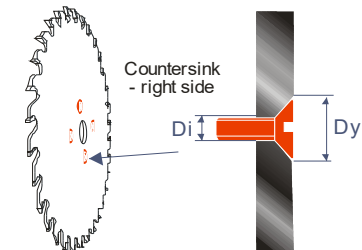
NOTE: If the sawblade only has one pin hole specify "centre / centre" distance between D and d.

For screw holes state Di and the countersunk angle or Dy or screw type (ex. M5). Furthermore, DC should always be stated.

Example:
2PH6DC80
2PH6kk7
(D=60mm, d=6mm,
DC=80mm)



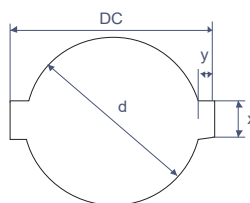
When ordering screw holes always state the side of the countersink. Hold the saw blade with the teeth on the top faced towards you as shown in the picture below. The picture shows a right countersink.



Keyways

When ordering keyways state information about width (x), depth (y) and number of keyways.

Example:
A blade has 2 keyways with width 11mm and depth 6mm.
2ks11x6



Example:

A blade has 4 screw holes, with inner diameter Di=6,0mm, outer diameter Dy=10,0mm and DC=80mm. The countersink is on the right side.
4FH 6,0 Dy=10,0 DC=80 countersink right

$$y = \frac{DC - d}{2}$$

SPECIAL

After tooth pitch "special" is stated. In the table below some common special saw blades are listed. If the saw blade is totally customised the note "sp" is stated.

B2 = Large kerf
T2 = Small kerf
T3 = Extra small kerf
T4 = Extra small kerf
(with limited cutting depth)
S = Blade with guard teeth
R = Wiper slot blade
SR = Wiper slot blade with guard teeth
E = Reduced gullet for noise reduction
L = Laser dampened saw body
BO = Bombastic side grinding

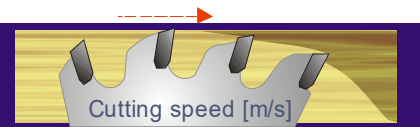
When ordering special saw blades a drawing should if possible be enclosed. If not, please provide the following information:

1. Type of machine
2. Speed (rpm)
3. Feed speed (m/min)
4. Diameter
5. Centre bore
6. Flange diameter
7. Keyways, pin holes, screw holes
8. Wiper slots, open or closed
9. Chip limiter
10. Material to be cut (green or dry)
11. Saw height (mm/blade)
12. Type of cutting edge

INQUIRY SPECIAL SAW BLADE		SWEDEX	
This form helps us to optimise the correct saw blade for your saw application. You do not need to fill in all lines, but the more information we receive, the better possibility we have to make a good solution for you.			
BASIC PAGE Saw the article no. of the previously saw blade known: Dia. 200/175 200/175 200/175 200/175 Diameter: mm (tolerance:) Kerf: mm (tolerance:) Bore: mm (tolerance:)		Customer: Address: Contact person: Phone:	
Keyways: no. pcs Width(x) Depth(y) : Pin holes, no. pcs Diameter (d) : DC: mm or Edge to Edge (kk) : When countersink also state side: Countersink diameter: mm or Type of screw: (i.e. M5) Countersink side: Left Right		When screw holes are required, the side to be countersunk (left or right side) is identified with the letter 'L' or 'R' in the top right corner of the page. The picture shows the right side of the saw blade.	
IF MORE SAW BLADE INFORMATION IS KNOWN Teeth shape: ☐ Standard ☐ Alternate ☐ Hollow No. of teeth: pcs HT size: mm HV: mm Flare: Straight Alternate Hollow Wiper slots: Outside no. pcs Length: mm Inner no. pcs Length: mm PC: mm		Other information: FACE: ☐ Left ☐ Right Saw blade with hole: ☐ Yes ☐ No	
Saw body thickness: mm Ground reduction (base-cut): ☐ Yes ☐ No Type of slot: ☐ Standard ☐ Limb Hub thickness: mm Hub diameter: mm Right Left Centre		MACHINE DATA Machine manufacturer: Machine type: Machine model: Flange diam: mm Revolution: rpm Feed rate: m/min Manual Feed Automatic feed Motorpower: kW (or HP)	
WORKPIECE MATERIAL Material: quality: Cutting direction: with feed Against feed Saw one piece at time Continuous sawing Saw height: mm Dry wood Green wood Saw quality: Rough Medium Fine Ultra fine For solid wood, screws grain Along grain			

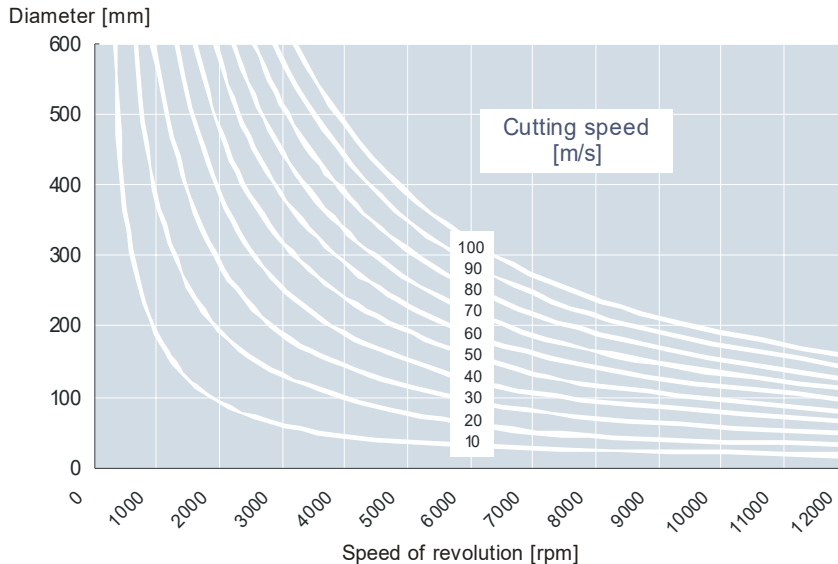
Download "Inquiry special saw blade" at:
www.swedex.com

CUTTING SPEED



Generally you should choose a blade with the smallest diameter possible (to maximize the stability) and the smallest kerf possible. At the same time the diameter must be adapted to the machine's speed of revolution to receive the most suitable cutting speed (if the speed of the machine is non-adjustable).

Carbide tipped saw blades require relatively high cutting speeds. The recommended speed for working in wood-based materials is about 70 m/sec.

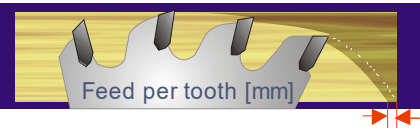


$$\text{Cutting speed} = \frac{\text{Diameter} * \text{RPM} * \pi}{60 * 1000}$$

$$[\text{M/sec}] = \frac{[\text{mm}] * [\text{rpm}] * \pi}{60 * 1000}$$

Material	Cutting speed [m/sec]
Wood: cross-cutting	50-80
ripping dry	60-100
ripping green	60-100
saw mill	60-100
Veneered and laminated board	60-80
Fibre board	70-80
Plaster- and chipboard, plywood	50-80
Veneers, cardboard rolls (tubes)	50-80
Hard plastic	50-75
Plexiglas, PVC, bakelite	50-85
Plastic laminates	50-75
Soft plastics	15-50
Aluminium	60-80
Copper	50-70
Brass	50-70
Light concrete	40-60
Steel (not hardened - mild)	5-30

FEED PER TOOTH



To optimize the saw blade's service life and cutting performance the usage of a correct feed per tooth is required. Too low feed speed cause rapid wear of the cutting edge. Too fast feed speed on the other hand could cause teeth to break (as a result of lacking chip pocket volume).

The table shows the recommended feed per tooth for different materials.

You can calculate the feed per tooth using the formula below.

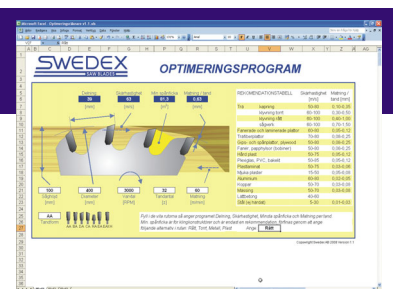
$$\text{Feed per tooth} = \frac{\text{Feed speed} * 1000}{\text{Speed of revolution} * \text{no. of teeth}}$$

$$[\text{mm}] = \frac{[\text{m/min}] * 1000}{[\text{rpm}] * z}$$

Material	Feed per tooth [mm]
Wood: cross-cutting	0,10-0,35
ripping dry	0,10-0,20
ripping green	0,20-0,80
saw mill	0,70-1,50
saw mill*	0,80-2,50
Veneered and laminated board	0,05-0,12
Fibre board	0,08-0,25
Plaster- and chipboard, plywood	0,08-0,25
Veneers, cardboard rolls (tubes)	0,08-0,25
Hard plastic	0,05-0,12
Plexiglas, PVC, bakelite	0,05-0,12
Plastic laminates	0,03-0,06
Soft plastics	0,05-0,08
Aluminium	0,02-0,05
Copper	0,03-0,08
Brass	0,03-0,08
Steel (not hardened - mild)	0,01-0,03

GULLET FEED INDEX

If the feed per tooth is very high the gullet volume needs to be calculated. A small gullet volume leads to an increased risk of cracks. We have developed a Microsoft Excel program for calculating the gullet volume along with other saw data. Contact Swedex technical sales people or one of Swedex resellers for assistance.



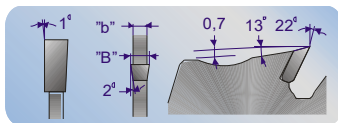


Rip Saw Blades with Wiper Slots

See new price list

22AA46SR

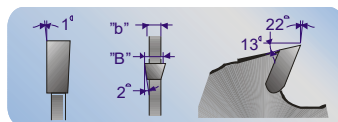
With guard teeth and wiper slots. Diameter 180 to 200mm



D	B	b	z	£
180	2.8	1.9	12+2	128.67
200	2.8	1.9	14+2	128.67
225	3.2	2.2	16+2	128.67
250	3.2	2.2	16+2	129.62
280	3.2	2.2	18+2	136.39
300	3.2	2.2	20+2	144.46
315	3.2	2.2	20+2	147.90
350	3.5	2.5	24+2	161.20
400	3.5	2.5	28+2	181.61

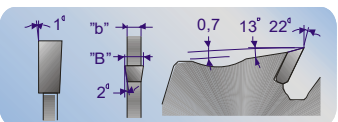
22AA46R

With large gullets and wiper slots. Diameter 225 to 400mm



22AA39SR

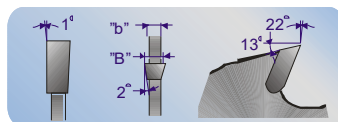
With guard teeth and wiper slots.



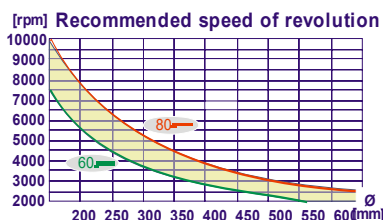
D	B	b	z	£
200	2.0	1.4	16+2	128.67
200	2.5	1.8	16+2	128.67
225	2.0	1.4	18+2	128.67
225	2.5	1.8	18+2	128.67
250	2.5	1.8	20+2	129.62
250	2.8	2.0	20+2	129.62
280	2.8	2.0	22+2	136.39
300	2.8	2.0	24+2	144.46

22AA39R

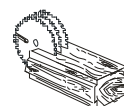
With large gullets and wiper slots. Pin holes for the Raimann machine



D	B	b	z	£
300	3.2	2.2	24+2	159.19
350	3.5	2.5	24+4	215.69
360	3.5	2.5	24+4	215.69



Wiper slot blades are Multi-rip blades. The wiper slots reduce the risk of getting stuck and also of the saw body becoming burnt. The guard tooth throws out the cuttings and keeps the cutting groove clean. The blades can be used for sawing both green and dry wood



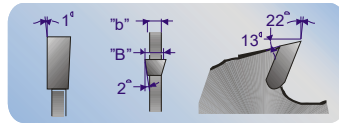


Rip Saw Blades with Wiper Slots-Thin Kerf

See new price list

22AA46RT2

With large gullets and wiper slots. Diameter 180 to 400mm



D	B	b	z	£
180	2.4	1.6	12+2	128.67
200	2.4	1.6	14+2	128.67
225	2.8	1.9	16+2	128.67
250	2.8	1.9	16+2	128.67
280	2.8	1.9	18+2	136.39
300	2.8	1.9	20+2	144.46
315	2.8	1.9	20+2	147.90
350	3.2	2.2	24+2	161.20
400	3.2	2.2	28+2	181.61

Wiper Slots

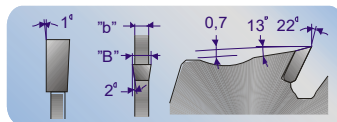
The Wiper slot length depends on the centre bore size and flange diameter

D	c-bore	WS Length
160		25
180		25
200		25
225	≤ 70	35
225	> 70	25
250	≤ 70	50
250	> 70	35
280		50
300	≤ 70	60
300	> 70	50
315	≤ 80	70
315	> 80	60
350	≤ 100	70
350	> 100	60
400		70

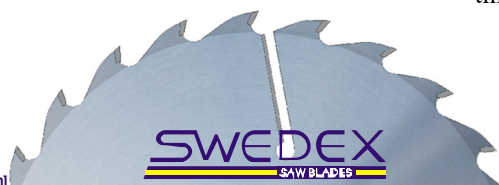
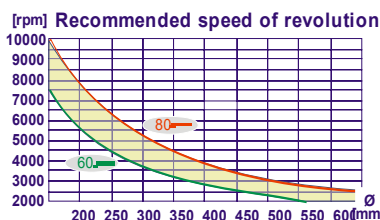
Always state saw height, feed speed, revolution and size of the flanges when ordering a saw blade

22AA46SRT3

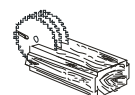
With guard teeth and wiper slots.



D	B	b	z	£
180	2.0	1.3	12+2	128.67
200	2.0	1.3	14+2	128.67
225	2.4	1.6	16+2	128.67
250	2.4	1.6	16+2	128.67
280	2.4	1.6	18+2	136.39
300	2.4	1.6	20+2	144.46
315	2.4	1.6	20+2	147.90
350	2.8	1.9	24+2	161.20
400	2.8	1.9	28+2	181.61



Wiper slot blades are Multi-rip blades. The wiper slots reduce the risk of getting stuck and also of the saw body coming burnt. The guard tooth rows out loose cuttings and keeps the cutting groove clean. The blades can be used for sawing both green and dry wood



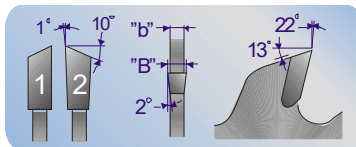


Ripping Blades

See new price list

22BA39

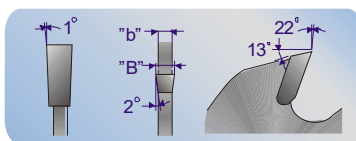
Ripping saw blade for solid wood



D	B	b	z	£
150/1				
60	2.8	1.9	12	59.94
180	2.8	1.9	14	60.67
200	2.8	1.9	16	63.13
225	3.2	2.2	18	70.74
250	3.2	2.2	20	73.11
260/2				
80	3.2	2.2	22	83.68
300	3.2	2.2	24	87.28
315	3.2	2.2	24	92.36
350	3.5	2.5	28	108.49
400	3.5	2.5	32	120.83
430	4.0	3.0	34	176.78
450	4.0	2.8	36	164.51
500	4.0	2.8	40	195.27
560	4.4	3.0	44	252.33
610	4.4	3.0	48	273.85
650	4.4	3.0	52	413.76
700	4.4	3.0	56	423.03
760	4.4	3.0	60	730.61

22AA39B2

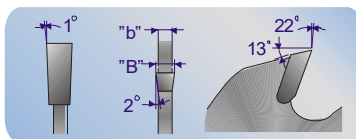
A more stable blade than the 22BA39. Can also be used as an outer blade.



D	B	b	z	£
180	3.2	2.2	14	84.35
200	3.2	2.2	16	93.52
225	3.5	2.5	18	106.63
250	3.5	2.5	20	116.98
280	3.5	2.5	22	125.05
300	3.5	2.5	24	125.05
350	4.0	2.8	28	144.81
400	4.0	2.8	32	163.54

22AA39T2

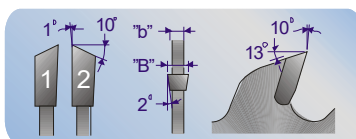
Similar design to 22AA39B2, but with a much thinner kerf.



D	B	b	z	£
160	2.4	1.6	12	62.59
180	2.4	1.6	14	64.36
200	2.4	1.6	16	66.57
225	2.8	1.9	18	77.27
250	2.8	1.9	20	78.51
280	2.8	1.9	22	88.40
300	2.8	1.9	24	91.69
350	3.2	2.2	28	114.34
400	3.2	2.2	32	127.87
450	3.5	2.5	36	179.36

10BA30

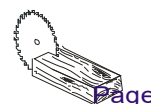
A ripping blade suitable for cross-cutting



D	B	b	z	£
400	3.5	2.5	40	139.10
450	4.0	2.8	44	177.08
500	4.0	2.8	50	218.40
550	4.4	3.0	56	277.64
610	4.4	3.0	60	292.22



wedex offer a wide range of saw-blades for ripping both hard & soft wood. Alternate bevelled tooth design is recommended when ripping hard wood.



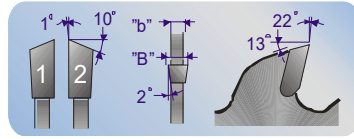


Ripping Blades

See new price list

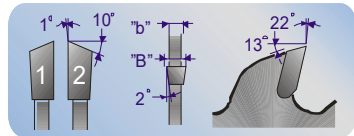
22BA30

For ripping of hard & soft wood. Tooth shape BA is recommended for hard wood. Can also be used for multi-rip sawing of dry, planed wood.



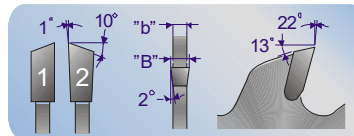
22BA30T3

Rip-saw blade with extra small cutting width



22BA26

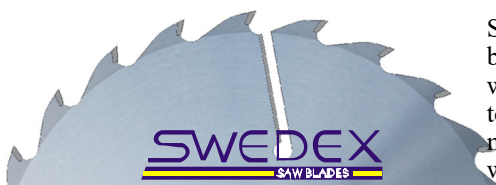
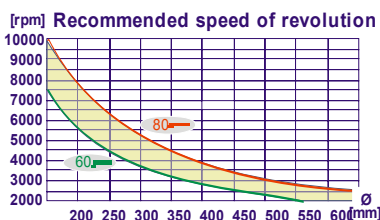
Rip-saw blade with a closer tooth pitch. Suitable for both hard and soft wood.



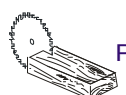
D	B	b	z	£
180	2.8	1.9	18	63.84
200	2.8	1.9	20	65.89
225	3.2	2.2	22	79.17
240	3.2	2.2 24(AA)		79.17
250	3.2	2.2	24	79.17
280	3.2	2.2	28	86.91
300	3.2	2.2	30	90.79
315	3.2	2.2	30	95.61
330	3.5	2.5	32	115.71
350	3.5	2.5	36	115.71
400	3.5	2.5	40	139.10
450	4.0	2.8	44	177.08
500	4.0	2.8	50	218.40
560	4.4	3.0	56	277.64
610	4.4	3.0	60	292.22
650	4.4	3.0	64	509.90
700	4.4	3.0	72	524.62

D	B	b	Z	£
160	2.0	1.3	16	69.58
180	2.0	1.3	18	71.18
200	2.0	1.3	20	72.84
225	2.4	1.6	22	86.16
250	2.4	1.6	24	89.29
280	2.4	1.6	28	105.28
300	2.4	1.6	30	105.28
350	2.8	1.9	36	126.69
400	2.8	1.9	40	152.82

D	B	b	z	£
160	2.8	1.9	18	69.11
180	2.8	1.9	20	69.11
190/200	2.8	1.9	24	70.49
225	3.2	2.2	28	82.35
250	3.2	2.2	30	82.35
270	3.2	2.2	30	88.15
300	3.2	2.2	36	94.72
350	3.5	2.5	42	120.24
400	3.5	2.5	48	144.46
450	4.0	2.8	56	177.80
500	4.0	2.8	60	228.36
560	4.4	3.0	64	288.41
610	4.4	3.0	72	335.32
650	4.4	3.0	78	535.31
700	4.4	3.0	84	545.89



Swedex offer a wide range of saw-blades for ripping both hard & soft wood. Alternate bevelled tooth design is recommended when ripping hard wood.

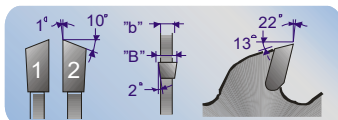




Universal Blades

22BA19

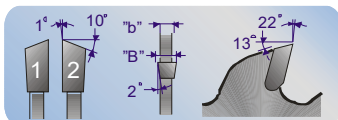
Universal saw blade for most common saw operations but primarily suitable for ripping wood in thinner sections, Suitable for both hard and soft wood.



See new price list

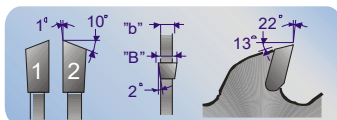
22BA19T2

Universal saw blade with narrow cutting width. Suitable for both hard and soft wood.



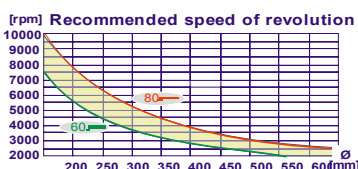
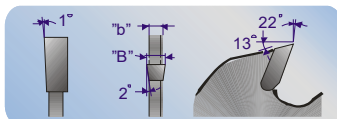
22BA19T3

Extra narrow cutting width with low cutting resistance. Suitable for frame ripping in thin sections. Is also used for edge trimming.



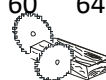
22AA19T4

Extremely small kerf. Double sided hub. NOTE: Limited cutting depth.



D	B	b	z	£	
150/160	2.8	1.9	24	71.99	
180	2.8	1.9	28	80.12	
200	2.8	1.9	32	83.10	
225	3.2	2.2	36	92.36	
250	3.2	2.2	40	92.36	
280	3.2	2.2	44	110.99	
300	3.2	2.2	48	113.80	
315	3.2	2.2	48	118.82	
335	3.5	2.5	48	133.62	
350	3.5	2.5	56	136.04	
400	3.5	2.5	64	161.53	
450	4.0	2.8	72	210.19	
500	4.0	2.8	80	245.76	
550	4.4	3.0	90	353.95	
600	4.4	3.0	96	381.25	
D	B	b	z	£	
150/160	2.4	1.6	24	73.38	
180	2.4	1.6	28	81.67	
200	2.4	1.6	32	83.88	
225	2.8	1.9	36	93.24	
250	2.8	1.9	40	93.24	
300	2.8	1.9	48	116.02	
315	2.8	1.9	48	121.13	
350	3.2	2.2	56	137.34	
400	3.2	2.2	64	163.11	
450	3.5	2.5	72	211.41	
500	3.5	2.5	80	248.13	
550	3.5	2.5	90	357.40	
600	3.5	2.5	96	384.97	
D	B	b	z	£	
125	2.0	1.3	20	74.43	
150/160	2.0	1.3	24	74.43	
180	2.0	1.3	28	78.97	
200	2.0	1.3	32	89.29	
225	2.4	1.6	36	105.28	
250	2.4	1.6	40	105.28	
300	2.4	1.6	48	118.82	
315	2.4	1.6	48	123.42	
350	2.8	1.9	56	151.25	
400	2.8	1.9	64	182.71	
D	B	b	Max Cut.depth	z	£
160	1.5	0.9/1.9	22	24	118.82
180	1.5	0.9/1.9	26	28	132.14
200	1.5	0.9/1.9	30	32	144.96
250	1.5	0.9/1.9	37	40	180.54
300	1.5	0.9/1.9	44	48	207.40
350	1.8	1.2/2.5	52	56	258.83
400	1.8	1.2/2.5	60	64	286.54

For ripping of hard & soft wood. Can also be used for cross-cutting

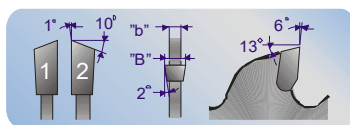




Cross-cut, Trim & Panel sizing

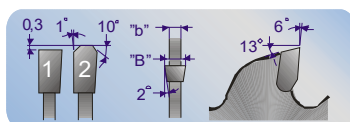
6BA10

Close tooth trimming saw blade for laminated materials and plastics. For use when a good surface finish is required. Equipped with Swedex Long-life teeth for maximum wear resistance and long life. Alternate



6EA10

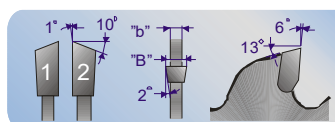
Close tooth trimming saw blade for laminated materials and plastics. For use when a good surface finish is required. Equipped with Swedex Long-life teeth for maximum wear resistance and long life. EA tooth style.



Creative Joinery

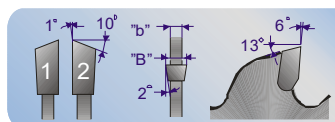
6BA10T2

As 6BA10 but with narrow cutting width.



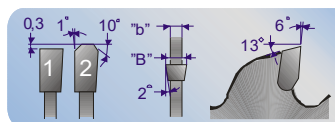
6BA10T3

Extra narrow cutting width. Cross cut blade for thin plastic profiles, printed circuits, plexiglass etc.



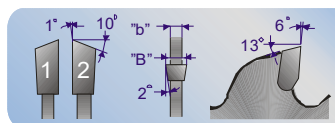
6EA10T3

Extra narrow cutting width. Cross cut blade for thin plastic profiles, printed circuits, plexiglass etc. EA tooth style.



6BA10B2

Scoring Blade for tenoners. Made with long life carbide

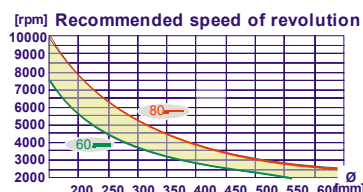


D	B	b	z	£
150/160	2.8	1.9	48	86.27
180	2.8	1.9	56	96.37
190/200	2.8	1.9	64	104.92
210	2.8	1.9	64	114.02
220	3.2	2.2	72	119.88
225	3.2	2.2	72	119.88
250	3.2	2.2	80	120.85
255	3.2	2.2	80	124.30
270	3.2	2.2	84	136.78
300	3.2	2.2	96	138.31
330	3.5	2.5	104	164.08
350	3.5	2.5	112	164.08
400	3.5	2.5	120	210.20
450	4.0	2.8	144	267.71
500	4.0	2.8	160	319.06
550	4.4	3.0	168	401.30
600	4.4	3.0	176	465.05

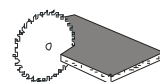
D	B	b	z	£
150/160	2.4	1.6	48	89.29
180	2.4	1.6	56	98.05
200	2.4	1.6	64	111.71
250	2.8	1.9	80	127.40
300	2.8	1.9	96	153.07
350	3.2	2.2	112	187.90
400	3.2	2.2	120	223.99

D	B	b	z	£
125	2.0	1.3	40	98.97
150/160	2.0	1.3	48	98.97
180	2.0	1.3	56	108.78
200	2.0	1.3	64	122.07
225/250	2.4	1.6	80	139.13
300	2.4	1.6	96	161.28
350	2.8	1.9	112	202.19
400	2.8	1.9	120	230.99

D	B	b	z	£
125	3.2	2.2	40	103.38
150-160	3.2	2.2	48	103.38
180	3.2	2.2	56	115.25
200	3.2	2.2	64	126.16
300	3.5	2.5	96	159.03



blades for cross-cutting of wood and for trimming and panel sizing of chipboards, laminated or non-laminated boards.

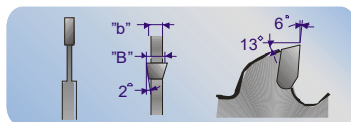




Cross-cut, Trim & Panel sizing

6AA10T4

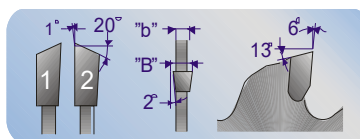
Extremely narrow cutting width. Trimming saw blade for thin plastics and printed circuits.
NOTE: Limited cutting depth.



D	B	b	Max.Cut.Depth	z	£
150	1.5	0.9/1.9	20	48	136.72
160	1.5	0.9/1.9	22	48	136.72
180	1.5	0.9/1.9	26	56	151.86
200	1.5	0.9/1.9	30	64	165.29
250	1.5	0.9/1.9	37	80	207.03
300	1.5	0.9/2.2	44	96	237.29
350	1.8	1.2/2.5	52	112	297.18
400	1.8	1.2/2.5	60	120	328.52

Fast cut 6BA11

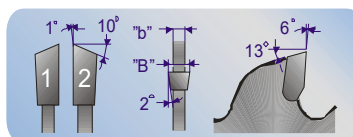
Close toothed saw blade for “Opti-cut” saws. Extra stable body. Differentiated tooth pitch together with copper rivets.



D	B	b	z	£
400	4.8	3.5	96	320.94
450	4.8	3.5	128	348.22
500	4.8	3.5	96	356.38
500	4.8	3.5	144	366.53
550	4.8	3.5	96	454.73
550	4.8	3.5	144	586.32
600	5.4	4.0	96	549.80
600	5.4	4.0	144	597.90
600	5.4	4.0	172	624.30
650	5.4	4.0	96	733.73

6BA8T3

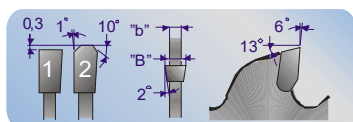
Narrow cutting width and extremely close-toothed. Intended for cutting very thin materials. BA toothstyle



D	B	b	z	£
150/160	2.0	1.3	60	120.28
180	2.0	1.3	70	151.25
200	2.0	1.3	80	163.71
225	2.4	1.6	90	193.95
250	2.4	1.6	100	193.96
300	2.4	1.6	116	218.52
350	2.8	1.9	144	281.08
400	2.8	1.9	160	311.07

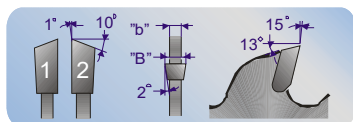
6EA8T3

Narrow cutting width and extremely close-toothed. Intended for cutting very thin materials. EA toothstyle

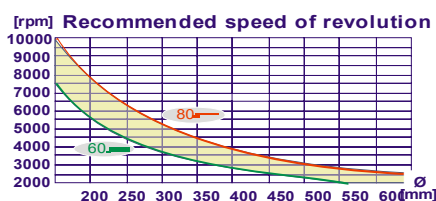


15BA16T2

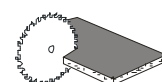
Universal saw blade, fine toothed with narrow cutting width. Suitable for ripping and cross-cutting of both hard and soft wood or thin board.



D	B	b	z	£
150/160	2.4	1.6	30	75.77
180	2.4	1.6	36	78.27
200	2.4	1.6	40	88.43
250	2.8	1.9	50	101.98
300	2.8	1.9	60	121.41
350	3.2	2.2	70	147.54
400	3.2	2.2	80	175.82



Blades for cross-cutting of wood and for trimming and panel sizing of chipboards, laminated or non-laminated boards.

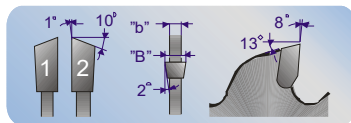




Cross-cut, Trim & Panel sizing

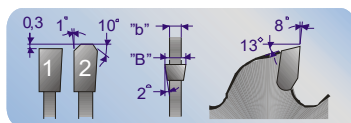
8BA13

Close toothed trimming blade for veneered and laminated material. For use when a good surface finish is required.



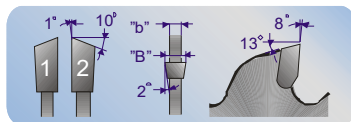
8EA13

Close toothed trimming blade for veneered and laminated material. For use when a good surface finish is required.



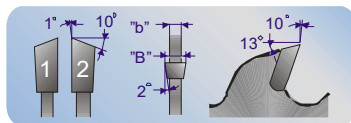
8BA13B2

Scoring blade for tenoners. Made with long life carbide



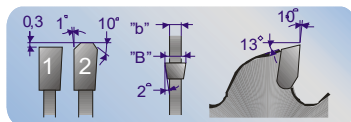
10BA16

Trimming and sizing saw blade. Standard blade for the carpentry and furniture industry. Used for non-laminated and single-side laminated board. BA style



10EA16

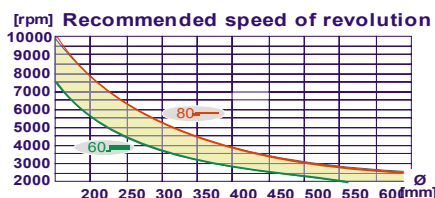
Trimming and sizing saw blade. Standard blade for the carpentry and furniture industry. Used for non-laminated and single-side laminated board. EA style



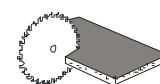
D	B	b	z	£
125	2.8	1.9	30	78.33
150/160	2.8	1.9	36	78.33
180	2.8	1.9	42	86.05
200	2.8	1.9	48	92.59
210	2.8	1.9	48	97.78
220	3.2	2.2	56	105.87
225	3.2	2.2	56	105.87
240	3.2	2.2	60	106.82
250	3.2	2.2	60	106.82
280	3.2	2.2	72	123.89
300	3.2	2.2	72	123.89
315	3.2	2.2	80	151.13
330	3.5	2.5	80	151.13
350	3.5	2.5	84	151.13
370	3.5	2.5	90	183.26
400	3.5	2.5	96	183.26
450	4.0	2.8	108	249.95
500	4.0	2.8	120	276.13
550	4.4	3.0	132	368.90
600	4.4	3.0	144	407.74

D	B	b	z	£
125	3.2	2.2	30	92.46
150	3.2	2.2	36	92.46
180	3.2	2.2	42	102.67
200	3.2	2.2	48	110.61

D	B	b	z	£
150/160	2.8	1.9	30	75.11
180	2.8	1.9	36	79.88
200	2.8	1.9	40	91.18
250	3.2	2.2	50	102.43
300*	3.2	2.2	60	122.30
315	3.2	2.2	60	145.65
350*	3.5	2.5	70	148.46
400	3.5	2.5	80	171.52
450	4.0	2.8	90	215.45
500	4.0	2.8	100	255.55
550	4.4	3.0	108	352.49
600*	4.4	3.0	120	385.99



Blades for cross-cutting of wood and for trimming and panel sizing of chipboards, laminated or non-laminated boards.

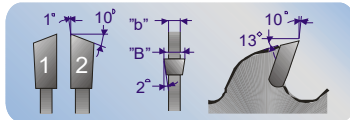




Cross-cut, Trim & Panel sizing

10BA19

Cross-cut, trimming and panel saw blade for hard-board, plasterboard and chipboard etc.
Also manufactured with a 5 degree negative hook angle.



D	B	b	z	£
180	2.8	1.9	28	74.47
200	2.8	1.9	32	79.88
225	3.2	2.2	36	83.20
250	3.2	2.2	40	87.85
255	3.2	2.2	40	92.92
270	3.2	2.2	42	104.92
300	3.2	2.2	48	108.58
315	3.2	2.2	48	118.58
330	3.5	2.5	52	131.41
350	3.5	2.5	56	131.41
380	3.5	2.5	60	157.66
400	3.5	2.5	64	157.66
450	4.0	2.8	72	197.71
500	4.0	2.8	80	229.65
560	4.4	3.0	90	295.88
610	4.4	3.0	96	350.26
650	4.4	3.0	108	563.10
700	4.4	3.0	116	568.14

BLADE FACT

Frequently asked questions

What can I do to obtain a better cutting surface finish?

- Choose a saw blade with more teeth.
- Use a higher peripheral speed.
- Select a saw blade with different tooth shape.
- Check flanges and distances.
- Condition of the spindle bearings.

The blade is very noisy, especially when idling, why?

- The blade goes into oscillation (self-vibration).
- Change number of teeth and diameter.
- Adjust the speed of revolution if possible.
- You can also choose a sound absorbing saw blade.
- A coating of sound absorbing material on the inside of the safety cover.

How to avoid chip outs on the bottom side of the material?

- Use a saw blade with more teeth.
- The saw blade is positioned too high above the material.
- Some special grindings and angles may help.

Why does the saw blade wobble when warm?

- During cutting the saw blade becomes warm, especially in the periphery, which causes the blade to expand and stretch. We can add slots for improved blade properties to meet a specific customer's needs.

How to avoid the blade chopping when cutting aluminium?

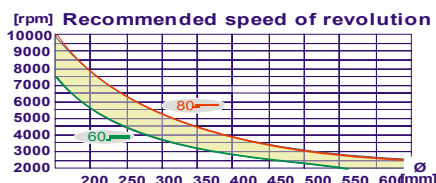
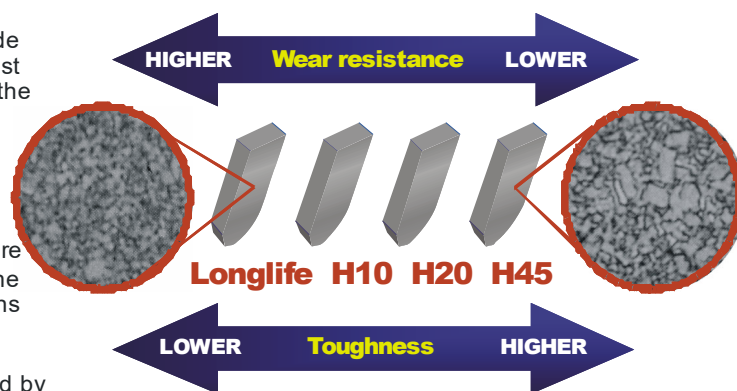
- When using manual feed, a negative hook angle results

BLADE FACT

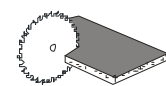
Carbide tips are made out of a metallic material consisting of hard grains of carbide held together by a binding agent. The most common carbide is tungsten carbide and the most common binding agent is cobalt. To improve toughness, the binding agent is sometimes alloyed with other metallic elements.

Carbides are chemical alloys of one or more metals and consist of very small grains. The grain size varies from 1 to around 7 microns (1 micron = 0.001 mm).

The hardness of the carbide tip is adjusted by the size of grain. Harder carbide gives a longer wear resistance but will be more brittle. Larger



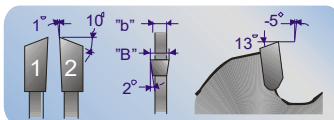
Blades for cross-cutting of wood and for trimming and panel sizing of chipboards, minated or non-aminated boards.





Negative blades for wood & plastic

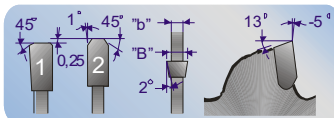
N5BA8/N5BA10



D	B	b	z	£
216	2.8	1.9	80	155.60

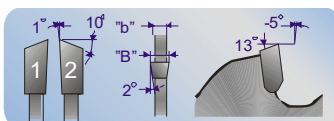
N2EA8/N5EA10

Close toothed blade for laminated material and plastics. For use when a good surface finish is required.



D	B	b	z	£
216	2.8	1.9	64	108.39
250	3.2	2.2	80	120.85
260	3.2	2.2	80	125.79
300	3.2	2.2	96	144.93
305(T2)	2.8	1.9	96	151.95
305	3.2	2.2	96	151.95
350	3.5	2.5	112	178.05

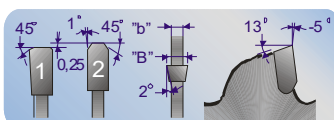
N5BA13



D	B	b	z	£
216	2.8	1.9	48	95.80
250	3.2	2.2	60	106.31

N5EA13

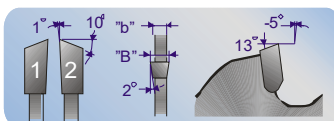
Close toothed blade for veneered & laminated material. For use when a good



D	B	b	z	£
260	2.8	1.8	60	119.53
260	3.2	2.2	60	119.53
260	3.2	2.2	80	125.79
300	3.2	2.2	72	129.02
350	3.5	2.5	84	159.76

N5BA16/(EA*)

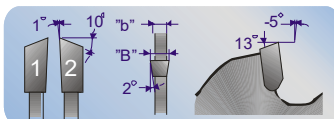
Trimming and sizing blade for the carpentry and furniture industry. Used for non-laminated and single sided board.



D	B	b	z	£
305*	3.2	2.2	60	120.05
400	3.5	2.5	80	171.93
420	3.5	2.5	84	218.28
450	4.0	2.8	90	224.68

N5BA19

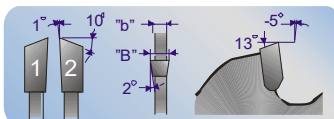
Cross cut blade for hardboard and chipboard etc.



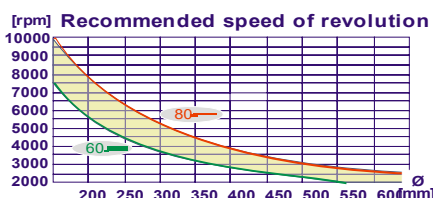
D	B	b	z	£
250	3.2	2.2	40	91.18
300	3.2	2.2	48	116.32
350	3.5	2.5	56	140.77
400	3.5	2.5	64	165.47
450	4.0	2.8	72	212.24
500	4.0	2.8	80	252.32

N5BA26/N5BA39

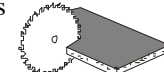
Rip-saw blades. Suitable for both hard and soft wood.



D	B	b	z	£
216*	2.8	1.9	24	72.91
250	2.8	1.8	30	82.37
260	2.8	1.9	30	86.95
305	3.2	2.2	24	99.07
520	4.4	3.0	60	284.19
550	4.4	3.0	56	277.75
565	4.4	3.0	56	297.78

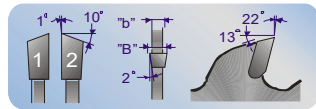


Blades with a negative hook angle for chop saws, overhead crosscut and radial arm saws. Used where the blade is above the work piece.



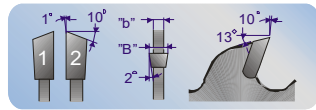
Edge banding , Nail resistant & Splitter/planers

22BA17

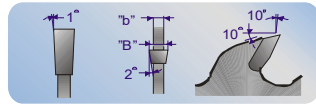


Blades for edge-banding. Non-handed

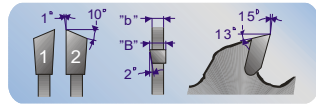
10BA15



10AA19



15BA12

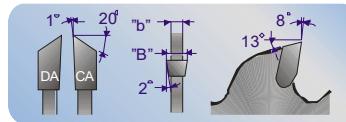


15BA19

D	B	b	z	£
100	3.2	2.2	20	104.83
110	3.6	2.5	20	102.81
115	2.6	1.6	24	84.51
120	3.2	2.5	24	101.78
140	3.2	2.2	36	129.28
160	3.2	2.2	24	105.58

8CA/DA14

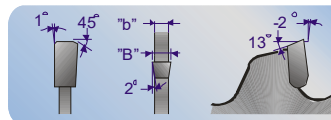
8CA/DA16



Blades for edge-banding. Handed. CA=right, DA=left

D	B	b	z	£
92	3.2	2.2	20	99.69
100	3.2	2.2	20	104.83

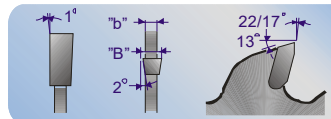
N2EE46



Special saw blades for use with low quality timber with metal inclusions etc.
Suitable for wooden pallets.

D	B	b	z	£
300	3.4	2.2	20	88.20
350	3.8	2.5	24	111.24
400	3.8	2.5	28	124.13
450	4.2	2.8	32	171.46
500	4.2	2.8	36	198.39

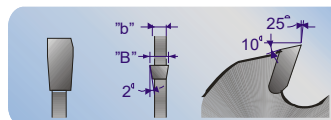
22/17AA15sp



A saw blade developed to split the material and leave a planed finish. For best results use with a hydrosleeve.
Max. cutting speed 100 m/min

D	B	b	z	£
180	3.5	2.5	38	166.92
200	3.5	2.5	42	186.53
225	3.5	2.5	48	204.54
250	3.5	2.5	54	262.98

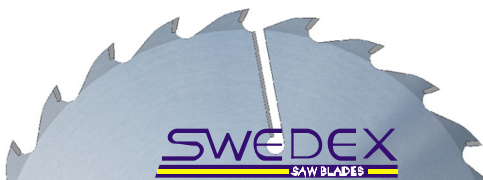
25AA25BO



The teeth have facet ground sides which result in a very smooth cutting surface. Oxide coated with a

D	B	b	z	c	£
225	3.4	2.4	28	60	205.69
250	3.4	2.4	36	60	216.00

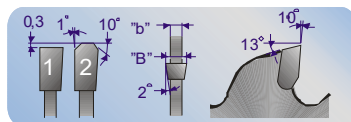
Feed Speed up to 150 m/min.



Special blades for wood & paper

See new price list

5EA10T2 10EA19T2

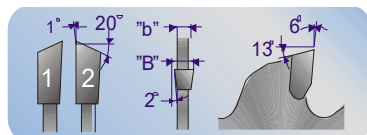


D	B	b	z	£
120	1.8	1.2	24	95.21
120	1.8	1.2	36	99.76

For the Varga engraving machine

6BA11

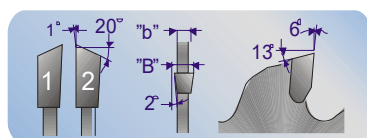
For optimiser machines



D	B	b	z	£
400	4.8	3.5	96	320.94
450	4.8	3.5	128	348.21
500	4.8	3.5	96	356.38
500	4.8	3.5	144	366.53
550	4.8	3.5	96	454.73
550	4.8	3.5	144	586.32
600	5.4	4.0	96	549.80
600	5.4	4.0	144	597.90
600	5.4	4.0	172	624.30
650	5.4	4.0	96	733.73

6BA11

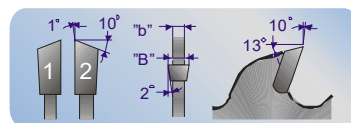
For optimiser machines



D	B	b	z	£
120	2.6	2.0	48	106.17

10BA10

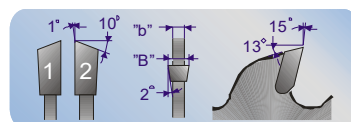
Janser m/c-c/sunk bore



D	B	b	z	£
120	2.6	2.0	48	106.17

15BA18

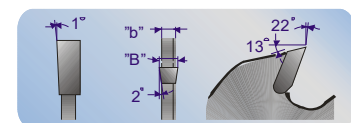
Truss saw blade for the Randek truss machine



D	B	b	z	£
700	4.5	3.5	120	661.90

22AA39R

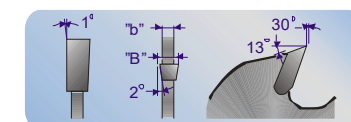
For the Raimann machine



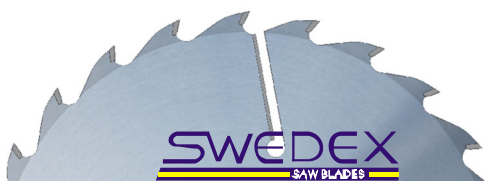
D	B	b	z	£
300	3.2	2.2 24+2		159.19
350	3.5	2.5 24+4		215.69
360	3.5	2.5 24+4		215.69

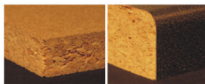
30AA34

For the Lucas portable saw



D	B	b	z	£
424	5.0	2.85	5	225.56
546	5.7	3.2	5	305.08
585	6.1	3.55	5	371.36

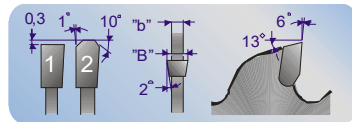




Panel sizing blades for vertical saws

6EA10

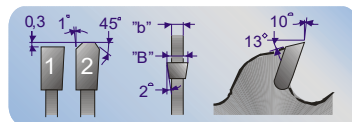
Panel sizing saw blade for vertical saws. Long life teeth and small tooth pitch.
For panel sizing of laminated or non-laminated boards.



D	B	b	z	£
220	3.2	2.2	72	119.88
250	3.2	2.2	80	120.85
300	3.2	2.2	96	138.31
350	3.5	2.5	112	164.08

10EAXH16

Panel sizing saw blade for vertical saws. For panel sizing of laminated or varnished boards when a good finish is required. Hollow ground front



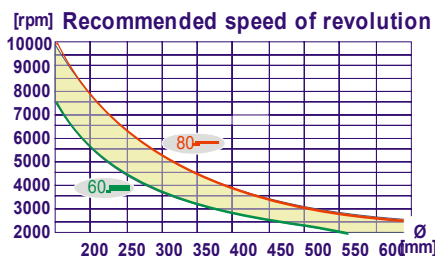
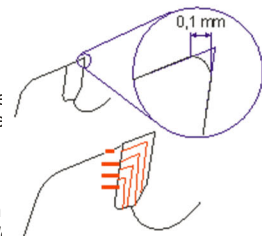
D	B	b	z	£
220	3.2	2.2	42	108.67
250	3.2	2.2	48	121.39
303	3.2	2.2	60	145.50
350	3.2	2.2	70	188.78
400	3.5	2.5	80	238.52
450	3.9	2.8	90	291.36
500	3.9	2.8	100	306.62

BLADE FACT

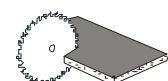
A carbide tipped blade is a precision tool that requires careful maintenance to ensure a long service life and good performance throughout its life.

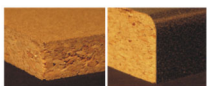
The blade must be re-sharpened at the right time, i.e. when the cut surface becomes unacceptable. This usually happens when the tip edge radius exceeds 0.1 mm or when the cutting edge becomes chipped. Normally a carbide tipped blade can be re-sharpened 20-25 times depending on the size of the carbide tips.

Clean the blade regularly to remove the coating of chips and resin that sticks to cutting edges, gullets and saw body. The coating increases the friction as well as the temperature and causes the blade to run hot and twist. The increased wear may in the worst case cause the blade to crack. We recommend the use of a good cleaning agent.



Blades for vertical panel sizing,
g. Holz-Her, Striebig
etc.
For laminated or
varnished boards.



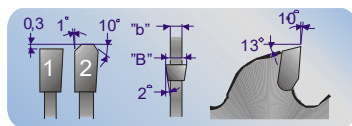


See new price list

Panel sizing saw blades(Wide kerf)

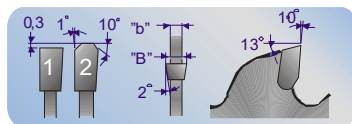
Panel sizing saw blades for use with a scribing unit. The blades have a laser dampened saw body and are equipped with long life carbide teeth, which results in a longer time between sharpening.

10EA13UB2



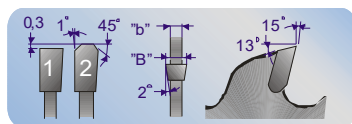
D	B	b	z	£
300	4.4	3.2	72	173.50
350	4.4	3.2	84	199.68

10EA16UB2



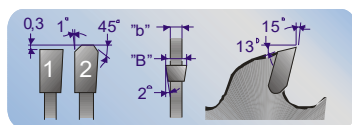
D	B	b	z	£
300	4.4	3.2	60	147.30
320/330	4.4	3.2	72	173.50
350	4.4	3.2	72	179.77
355	4.4	3.2	70	179.77
370	4.4	3.2	72	203.10
380	4.4	3.2	72	203.10
380	4.8	3.5	72	228.94
400	4.4	3.2	72	216.08
470	4.4	3.2	96	308.23

15EA19UB2



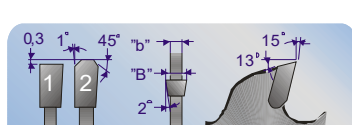
D	B	b	z	£
350	4.4	3.2	56	169.90
400	4.4	3.2	64	197.33
420	4.8	3.5	72	275.71
430	4.4	3.2	72	243.63
430	4.8	3.5	72	275.92
450	4.4	3.2	72	243.63
450	4.8	3.5	72	295.06
500	4.8	3.5	72	321.05

15EA21UB2



D	B	b	z	£
480	4.4	3.2	72	283.81
480	4.8	3.5	72	296.03

15EA25UB2

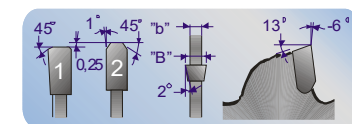


D	B	b	z	£
480	4.8	3.5	60	276.46

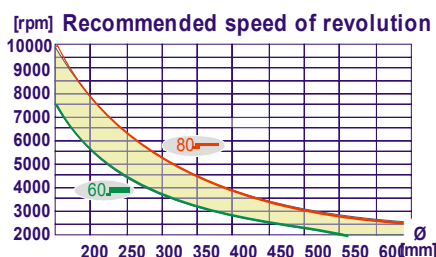
15EA26UB2

400	4.4	3.2	48	174.25
450	4.4	3.2	56	210.08

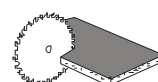
N6EA13sp

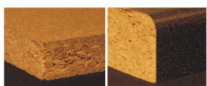


350	3.2	2.5	84	203.22
400	3.2	2.5	96	248.56
450	4.0	3.2	108	301.80
500	4	3.2	120	377.01



Blades for vertical panel sizing,
g. Holz-Her, Striebig etc.
or laminated or varnished
boards.

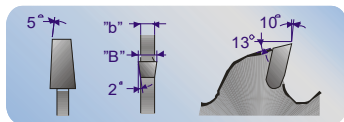




Scoring blades

10RA19

Scoring saw blades with straight teeth and conical sides (RA). Manufactured with Long-life carbide tips



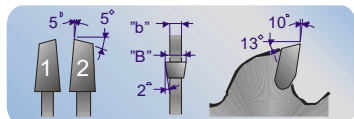
See new price list

Creative Joinery

D	B	b	z	£
80	3.0-4.0	2.2	10	60.40
90	3.2-4.4	2.2	20	65.63
100	3.2-4.4	2.2	20	73.84
105	3.2-4.4	2.2	20	73.84
120	3.2-4.4	2.2	20	76.41
120	3.5-4.5	3.2	20	94.34
120	4.4-5.4	3.2	20	95.94
125	3.2-4.4	2.2	20	78.64
125	3.5-4.5	2.5	20	94.34
125	4.4-5.4	3.2	20	95.94
140	3.1-4.2	2.2	32	102.61
150	3.2-4.2	2.2	24	106.51
150	4.4-5.4	3.2	24	106.82
160	3.5-4.5	3.5	24	106.82
160	4.4-5.4	3.2	24	108.29
160	4.8-5.8	3.5	24	117.38
175	4.4-5.4	3.2	28	115.17
175	4.8-5.8	3.5	28	117.56
180	3.5-4.5	2.5	28	120.67
180	4.4-5.4	3.2	28	121.90
180	4.8-5.8	3.5	28	125.12
200	3.2-4.4	2.2	32	134.11
200	4.4-5.4	3.2	32	136.34
200	4.8-5.8	3.5	32	141.08
215	4.4-5.4	3.2	42	139.48
280	4.8-5.8	3.5	72	245.96
300	4.4-5.4	3.2	48	185.52
300	4.8-5.8	3.5	48	208.01

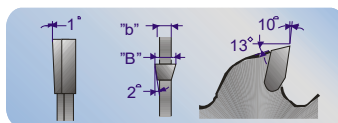
10RA/BA

Scoring saw blade with alternately bevelled teeth with conical sides (RABA) Manufactured with Long-life carbide tips.



SPLIT SCORERS

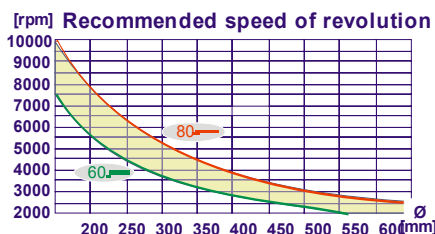
Adjustable to suit the kerf of the main saw blade. Straight teeth (AA). Shims are included.



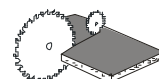
D	B	b	z	£
280	4.8-5.8	3.5	72	245.96
300	4.4-5.4	3.2	48	185.52
300	4.8-5.8	3.5	48	208.01
80	2.8-3.6	2x10		103.91
100	2.8-3.6	2x12		103.91
105	2.8-3.6	2x12		114.29
120	2.8-3.6	2x12		114.29
125	2.8-3.6	2x12		114.29
140	2.8-3.6	2x14		120.43

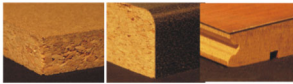
SPLIT SCORER for the Altendorf Rapido machine. Blade has 50mm bore and 4 Counter-sunk pin holes

D	B	z	£
120	2.8-3.6	2x12	128.31



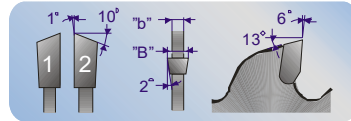
ring saw blades equipped with long-life carbide tips. Used for coring of laminated and non-coated boards.





Tenoner, Scoring blades and Hoggers

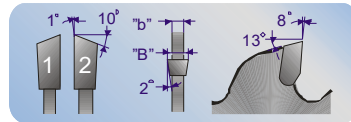
6BA10B2



Scoring blade for tenoners. BA toothform with long-life carbide tips

D	B	b	z	£
125	3.2	2.2	40	103.38
150	3.2	2.2	48	103.38
160	3.2	2.2	48	103.38
180	3.2	2.2	56	115.25
200	3.2	2.2	64	126.16
300	3.5	2.5	96	159.03

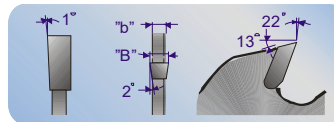
8BA13B2



Scoring saw blade for tenoners. BA toothstyle with Long-life carbide

D	B	b	z	£
125	3.2	2.2	30	92.46
150	3.2	2.2	36	92.46
180	3.2	2.2	42	102.67
200	3.2	2.2	48	110.61

22AA39B2

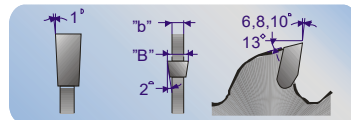


Scoring blade for tenoners. BA toothform

D	B	b	z	£
180	3.2	2.2	14	84.35
200	3.2	2.2	16	93.52
225	3.5	2.5	18	106.63

LEUCO

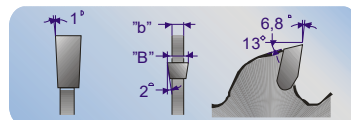
Scoring blade for the Leuco system. Manufactured with long-life carbide. With BA toothstyle but can also be produced left or right handed



	D	B	b	C	Z	PH	£
6AA10	180	3.2	2.2	50	56	3/22/80	127.27
8AA13	180	3.2	2.2	50	42	3/22/80	113.82
10AA16	180	3.2	2.2	50	36	3/22/80	101.29

HOMAG

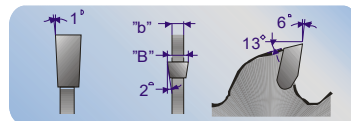
Scoring blade for Homag, Brandt, IMA. Manufactured with long-life carbide. Right (CA) or left (DA). Can also be produced BA toothstyle.



	D	B	b	C	Z	Csk PH L/ R	£
6AA10	180	3.2	2.2	65	56	6/7/60/10.5	127.27
8AA13	180	3.2	2.2	65	42	6/7/60/10.5	113.82

LEUCO HOGGER

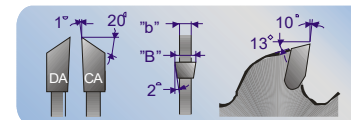
For panel sizing of laminated or non-laminated boards. Produced with long-life carbide tips. Left or right handed. Can also be manufactured with BA



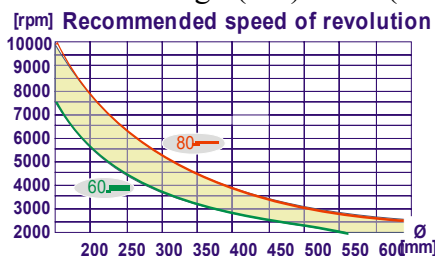
	D	B	b	C	Z	Csk PH L/ R	£
6AA10	200	4.0	2.8	80	64	4/6.5/140	145.75
6AA11	220	4.0	2.8	80	64	6/6/154	151.28
6AA10	250	4.0	2.8	80	78	6/6.5/200	160.08
6AA10	250	4.0	2.8	100	78	6/6.5/200	160.08

10CA/DA16

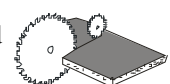
Trim saw blade for edge trimming. Long life carbide. Right (CA) or left (DA)

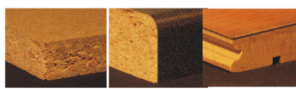


	D	B	b	C	Z	Csk PH L/ R	£
CA/DA	100	3.2	2.2	32	20	2/4/52	104.83



ring saw blades equipped with long-life carbide tips. Used for coring of laminated and non-coated boards.

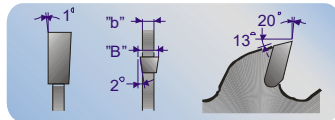




See new price list Groove cutting saw blades

20AA26

Groove cutting
saw blades for wood, chipboards and
non-ferrous metals with moderate feed speeds.



D	B	b	z	f
100	1.5	1.0	12	107.30
100	2.0	1.3	12	98.17
100	2.5	1.5	12	95.80
100	3.0	2.0	12	95.80
100	3.5	2.5	12	101.36
100	4.0	3.0	12	103.64
100	4.5	3.5	12	107.30
100	5.0	4.0	12	110.39
100	6.0	4.0	12	129.37
100	10.0	7.0	12	251.47

125	1.5	1.0	16	107.30
125	2.0	1.3	16	98.17
125	2.5	1.5	16	95.80
125	3.0	2.0	16	95.80
125	3.5	2.5	16	101.36
125	4.0	3.0	16	103.64
125	4.5	3.5	16	107.30
125	5.0	4.0	16	110.39
125	6.0	4.0	16	129.37
125	6.5	4.0	16	140.74
125	12.0	8.0	16	338.45

140	3.0	2.0	18	100.46
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150	1.5	1.0	18	112.75
150	2.0	1.3	18	102.67
150	2.5	1.5	18	100.52
150	3.0	2.0	18	100.52
150	3.5	2.5	18	106.71
150	4.0	3.0	18	109.10
150	4.5	3.5	18	112.75
150	5.0	4.0	18	117.77
150	6.0	4.0	18	136.02
150	8.0	6.0	18	192.00
150	10.0	7.0	18	262.69
150	12.0	8.0	18	411.81

D	B	b	z	
180	1.5	1.0	18	115.71
180	2.0	1.3	18	106.71
180	2.5	1.5	18	103.64
180	3.0	2.0	18	103.64
180	3.5	2.5	18	109.66
180	4.0	3.0	18	112.75
180	4.5	3.5	18	115.71
180	5.0	4.0	18	119.66
180	6.0	4.0	18	140.18
180	6.5	4.0	18	152.29
180	8.0	6.0	18	223.86
180	10.0	8.0	18	294.03

200	1.5	1.0	18	119.66
200	2.0	1.3	18	109.66
200	2.5	1.5	18	106.71
200	3.0	2.0	18	106.71
200	3.5	2.5	18	113.48
200	4.0	3.0	18	115.71
200	4.5	3.5	18	119.66
200	5.0	4.0	18	123.55
200	6.0	4.0	18	144.68
200	10.0	8.0	18	394.31
200	12.0	8.0	18	596.11
				0.00

225	4.0	3.0	18	127.25
225	4.5	3.5	18	131.87
225	5.0	4.0	18	137.69
225	6.0	4.0	18	159.88
225	7.0	4.0	18	194.20

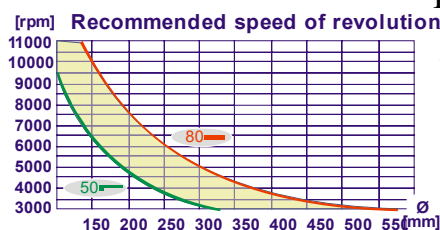
250	4.5	3.5	20	188.85
250	5.0	4.0	20	191.96
250	6.0	4.0	20	191.96
250	8.0	6.0	20	234.57

280	4.0	3.0	22	194.66
280	6.0	4.0	22	209.50

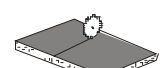
300	6.0	4.0	24	240.95
300	8.0	6.0	24	435.01
300	10.0	8.0	24	497.44

Biscuit Jointers

15AA52



Groove cutting saw blade for wood and
boards. When grooving
cross the grain, use half
the speed compared to
along the grain.



Page

21

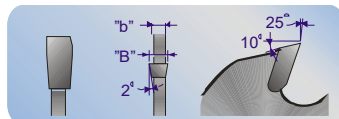


See new price list

Saw blades for moulders

25AA25BO

The teeth have facet ground sides which result in a very smooth cutting surface. Oxide coated with a maximum cutting depth of 50mm.

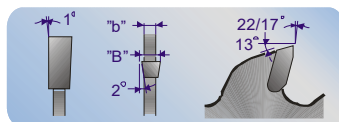


D	B	b	z	c	£
225	3.4	2.4	28	60	205.69
250	3.4	2.4	36	60	216.00

Feed Speed up to 150 m/min.

22/17AA15

The teeth have a special front grind (bevelled) for a better cutting results. Oxide coated with a maximum cutting depth of 30mm.

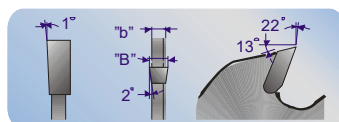


D	B	b	z	c	£
180	3.5	2.4	38	40/60	166.92
200	3.5	2.4	42	40/60	186.53
225	3.5	2.4	48	40/60	204.54
250	3.5	2.4	54	40/60	262.98

Feed Speed up to 150 m/min.

22AA19

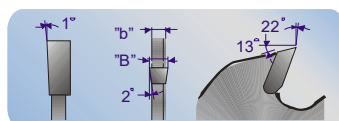
Ripping in moulders with normal surface requirements. Maximum cutting depth 30mm.



D	B	b	z	c	£
225	3.2	2.2	36	60	92.36
250	3.2	2.2	40	60	92.36

22AA26

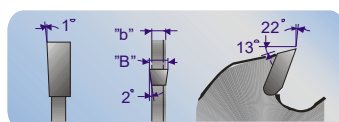
Ripping in moulders with normal surface requirements. Maximum cutting depth 50mm



D	B	b	z	c	£
225	3.2	2.2	28	60	82.35
250	3.2	2.2	30	60	82.35

22AA39

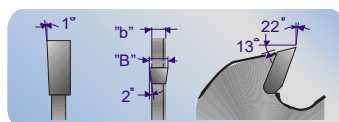
Ripping in moulders with lower feed speed



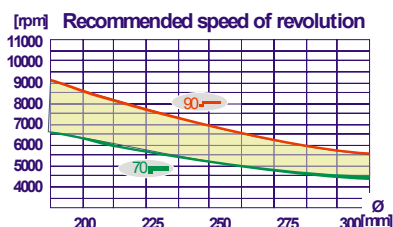
D	B	b	z	c	£
225	3.2	2.2	18	60	70.74
250	3.2	2.2	20	60	73.11

22AA39B2

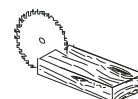
Ripping in moulders with lower feed speed

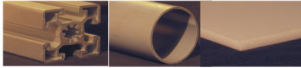


D	B	b	z	c	£
225	3.5	2.5	18	60	106.63
250	3.5	2.5	20	60	106.63



Blades for moulders. Some of these blades are "oxide coated"

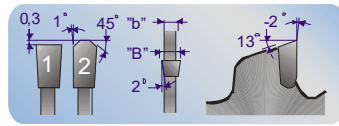




For Non-ferrous metals & Plastics

N2EAM6T3

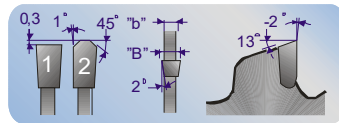
Extra narrow cutting width and extremely close toothed. Intended for cutting very thin material.



D	B	b	z	£
200	2.2	1.4	100	192.30
225	2.8	1.8	114	196.40
250	2.8	1.8	126	222.82
250	2.2	1.5	126	244.19
300	2.8	2.0	156	288.63
305	2.8	2.0	156	288.63

N2EAM8T3

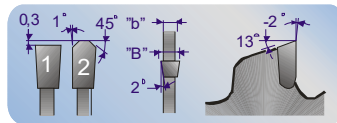
Extra narrow cutting width and extremely close toothed. Intended for cutting very thin material.



D	B	b	z	£
175	2.1	1.4	68	144.82
180	2.1	1.4	70	144.82
200	2.1	1.4	80	156.89
225	2.1	1.4	80	169.71
250	2.2	1.5	80	172.43
250	2.8	2.0	100	177.92
300	2.8	2.0	120	232.51

N2EAM10T3

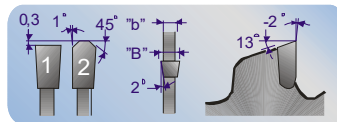
Extra narrow cutting width and extremely close toothed. Intended for cutting very thin material.



D	B	b	z	£
250	2.0	1.3	80	172.43

N2EAM08

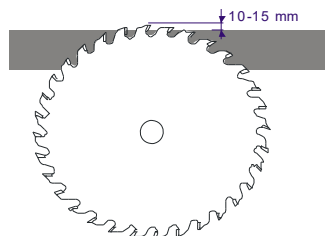
Close toothed. Intended for cutting thin material.



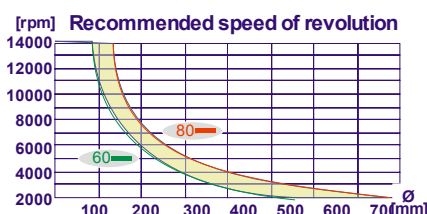
D	B	b	z	£
200	2.8	2.0	80	155.25
216	2.8	2.0	80	164.04
225	3.2	2.4	90	176.28
250	2.8	2.0	100	177.92
350	3.6	2.8	144	258.23
400	4.0	3.2	146	292.65

BLADE FACT

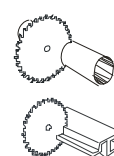
When cutting plastics the saw blade should be placed about 10-15 mm above the material.



For thin, hard plastics we recommend alternately beveled teeth with chamfer (BAE).



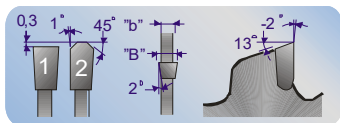
For Non-ferrous metals such as aluminium, copper and brass and also for plastics etc. Positive hook angle is used for automatic feed, the material is impeded and negative used for manual feed.



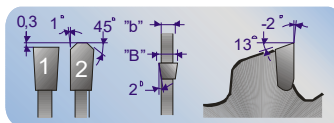


For Non-ferrous metals & Plastics

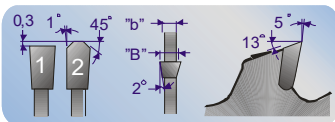
N2EAM10



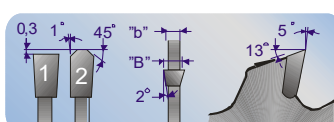
N2EAM13



5EAM10



5EAM13



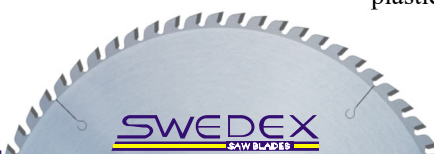
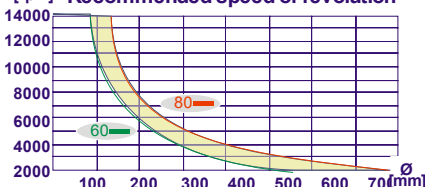
Close toothed for thin-walled metals & hard plastics

For cutting thin walled material with thickness up to approx.10mm

D	B	b	z	f
102	2.8	2.0	32	106.73
125	2.8	2.0	40	106.73
160	2.8	2.0	48	106.73
180	2.8	2.0	56	118.04
190	2.8	2.0	60	125.78
200	2.8	2.0	64	125.78
210	2.8	2.0	64	137.21
216	2.8	2.0	64	137.21
220	3.2	2.4	64	148.63
225	3.2	2.4	72	148.63
230	3.2	2.4	72	148.63
250	3.2	2.4	80	148.63
260	3.2	2.4	80	161.91
275	3.2	2.4	84	165.36
280	3.2	2.4	88	188.31
300	3.2	2.4	96	188.31
305	3.2	2.4	96	188.31
330	3.6	2.8	104	204.36
350	3.6	2.8	108	204.36
370	4.0	3.2	116	234.59
380	4.0	3.2	116	234.59
400	4.0	3.2	120	234.59
420	4.0	3.2	132	299.58
450	4.0	3.2	144	299.58
500	4.0	3.2	160	308.80
550	4.4	3.4	172	604.82

D	B	b	z	f
102	2.8	2.0	24	102.67
125	2.8	2.0	32	102.67
150	2.8	2.0	36	102.67
160	2.8	2.0	36	102.67
180	2.8	2.0	42	108.82
200	2.8	2.0	48	116.55
210	2.8	2.0	48	118.04
216	2.8	2.0	48	118.04
225	3.2	2.4	56	132.71
230	3.2	2.4	56	132.71
250	3.2	2.4	60	132.71
260	3.2	2.4	60	144.83
275	3.2	2.4	64	144.83
300	3.2	2.4	72	158.56
330	3.6	2.8	80	181.38
350	3.6	2.8	84	181.38
370	4.0	3.2	90	214.29
380	4.0	3.2	90	214.29
400	4.0	3.2	96	214.29
420	4.0	3.2	100	261.36
450	4.0	3.2	108	261.36
500	4.0	3.2	120	291.94
520	4.4	3.4	120	474.73
530	4.4	3.4	128	474.73
550	4.4	3.4	132	474.73
600	4.4	3.4	144	486.96
650	4.4	3.4	160	709.78

[rpm] Recommended speed of revolution



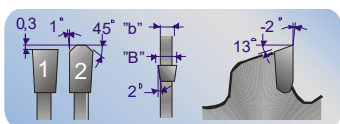
For Non-ferrous metals such as aluminium, copper and brass and also for plastics etc. Positive hook angle is for automatic feed where the material is clamped and negative used for manual feed.



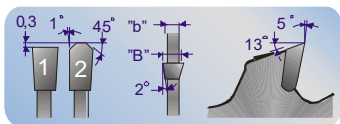


For Non-ferrous metals & Plastics

N2EAM16



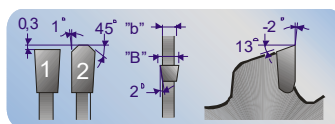
5EAM16



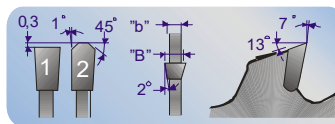
For solid metal and profiles with
Material thickness up to approx.
15mm

D	B	b	z	£
102	2.8	2.0	20	102.67
160	2.8	2.0	30	102.67
180	2.8	2.0	36	108.82
200	2.8	2.0	40	116.55
250	3.2	2.4	50	132.71
275	3.2	2.4	54	144.83
300	3.2	2.4	60	158.56
330	3.6	2.8	64	181.38
350	3.6	2.8	70	181.38
370	4.0	3.2	76	214.29
400	4.0	3.2	80	214.29
420	4.0	3.2	84	261.36
450	4.0	3.2	90	261.36
500	4.0	3.2	100	291.94
550	4.4	3.4	108	474.73
600	4.4	3.4	120	486.96

N2EAM19



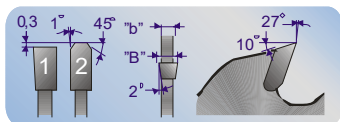
7EAM19



For solid metal and profiles with
material thickness above approx.
10mm.

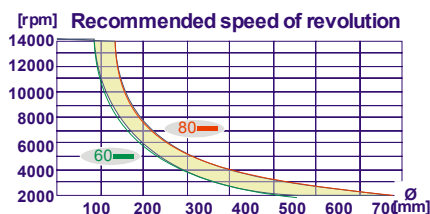
D	B	b	z	£
200	2.8	2.0	32	96.93
216	2.8	2.0	32	108.13
225	3.2	2.4	36	124.98
250	3.2	2.4	40	124.98
275	3.2	2.4	44	140.90
300	3.2	2.4	48	147.13
330	3.6	2.8	54	172.17
350	3.6	2.8	56	172.17
370	4.0	3.2	60	191.32
400	4.0	3.2	64	191.32
420	4.0	3.2	68	244.65
450	4.0	3.2	72	244.65
500	4.0	3.2	80	263.10
550	4.4	3.4	90	432.51
600	4.4	3.4	96	444.73
650	4.4	3.4	108	676.57
700	4.4	3.4	116	734.34

27EAM30B2



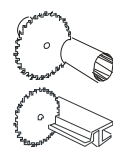
For solid aluminium ingots.
Minimum material thickness 25mm.

D	B	b	z	£
300	4.0	2.6	30	180.00
400	4.4	3.0	40	221.38
450	5.0	3.6	44	272.35
500	5.0	3.6	50	291.83
550	5.0	3.6	56	409.65
600	5.0	3.6	60	416.05
650	5.5	4.0	68	539.90
700	5.5	4.0	72	624.33



For Non-ferrous metals such as aluminium, copper and brass and also for plastics etc. Positive hook angle is used for automatic feed where the material is clamped and negative is

for manual feed.





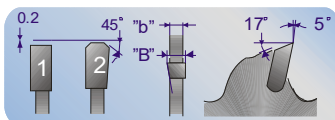
blades for Non-ferrous metals

See new price list

The 'Highline' blades for non-ferrous metals are used when the demand for quality, function and performance is paramount. The 'Highline' blade with its optimised variable pitch geometry and reduced noise levels through its dampened slits and finish allows the blade to operate at a higher rpm and to accept larger lateral loads. It is suitable for non-ferrous metals, plastic, aluminium, copper, brass etc.

H5EAM10

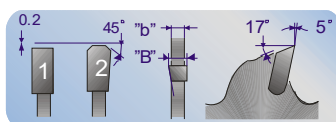
Close-toothed saw blade for Thin walled metals and hard plastics. Maximum material



D	B	b	z	£
370	4.0	3.2	114	351.81
400	4.0	3.2	120	351.81
420	4.0	3.2	132	449.20
450	4.0	3.2	144	449.20
500	4.0	3.2	160	458.26

H5EAM13

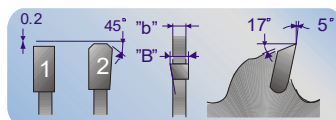
Saw blade for cutting profiles and solid aluminium. Material thickness up to 13mm.



D	B	b	z	£
370	4.0	3.2	90	321.39
400	4.0	3.2	96	321.39
420	4.0	3.2	100	391.99
450	4.0	3.2	108	391.99
500	4.0	3.2	120	437.84
550	4.4	3.4	132	712.04
600	4.4	3.4	144	712.04

H5EAM16

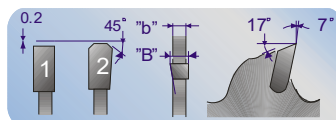
Saw blade for cutting profiles and solid aluminium. Material thickness up to 20mm. Positive rake angle.



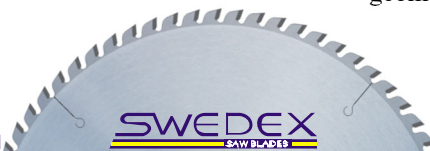
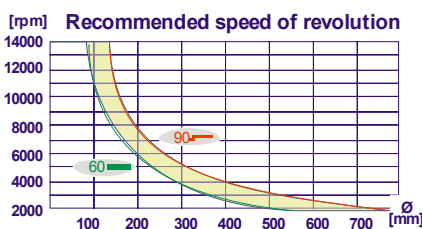
D	B	b	z	£
370	4.0	3.2	76	321.39
400	4.0	3.2	80	321.39
420	4.0	3.2	84	391.99
450	4.0	3.2	90	391.99
500	4.0	3.2	100	437.84
550	4.4	3.4	108	712.04
600	4.4	3.4	120	712.04

H7EAM19

Saw blade for cutting solid aluminium. Maximum material thickness up to 30mm.



D	B	b	z	£
370	4.0	3.2	60	297.93
400	4.0	3.2	64	297.93
420	4.0	3.2	68	366.90
450	4.0	3.2	72	366.90
500	4.0	3.2	80	394.59
550	4.4	3.4	90	648.61
600	4.4	3.4	96	648.61

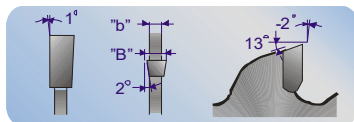


Blade for non-ferrous metals. The blade has an optimised variable pitch geometry and reduced noise levels through its dampened slits and finish. The blade can operate at a higher rpm and can accept larger lateral loads. For Non-ferrous and plastics



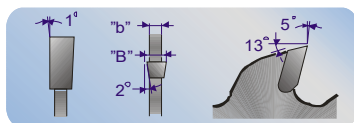
Special blades for window/UPVC industry

N2AAM6 Elumatec
N2AAM9 V-notch



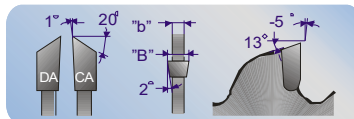
D	B	b	z	£
200	2.2	1.4	100	192.30
250	2.2	1.5	126	244.19
400	4.0	3.2	146	292.65

5AAM8 V-notch
as above



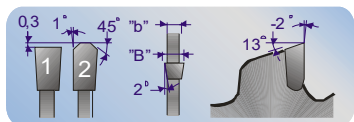
D	B	b	z	£
254	3.4	2.6	100	239.52

N5CA/DA10 AND N5CA/DA15 Trim saw
blades



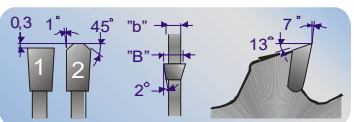
D	B	b	z	£
95	2.0	1.4	20	97.86
98	2.0	1.4	30	113.02
103	2.0	1.4	24	113.02
103	2.0	1.4	42	118.02
113.4	2.25	1.4	30	123.66

N2EAM8 Haffner
machines



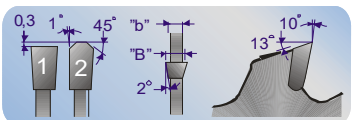
D	B	b	z	£
175	2.1	1.3	68	144.82
180	2.1	1.3	70	144.82

7EAM19sp Emmegi
machines



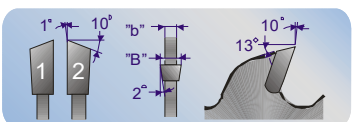
D	B	b	z	£
650 (40mm Bore)	5.0	4.4	108	872.93

10EAM24 Bombastic
machines



D	B	b	z	£
500	4.4	3.9	66	328.96

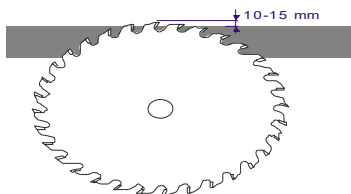
10BA10 Janser m/c
c/sunk bore



D	B	b	z	£
160	1.6	2.0	48	106.17

BLADE FACT

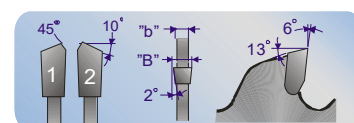
When cutting plastics the saw blade should be placed about 10-15 mm above the material.



For thin, hard plastics we recommend alternately beveled teeth with chamfer (BAE).



6BAE10 For Corian &
N5BAE10 Hard plastics



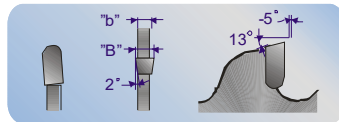
For N5BAE10 hook angle should be -5°

D	B	b	z	£
250	3.2	2.2	80	126.27
300	3.2	2.2	96	145.78
350	3.5	2.5	112	179.08



Radius tip blades for the window industry

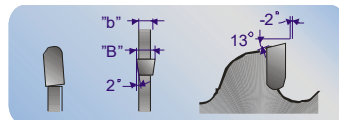
N5AAR25



Full radius tips for Urban and Haffner corner cleaners

D	B	b	z	£
180	5.0	4.0	24	263.44
200	5.0	4.0	24	275.56
250	5.0	4.0	32	314.78
250	5.0	4.0	64	613.54

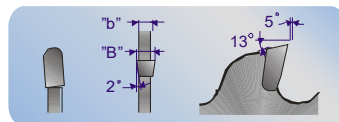
N2AAMR10



Full radius tips for Elumatic corner cleaners etc.

D	B	b	z	£
230	3.2	2.4	72	303.58

5AAR27



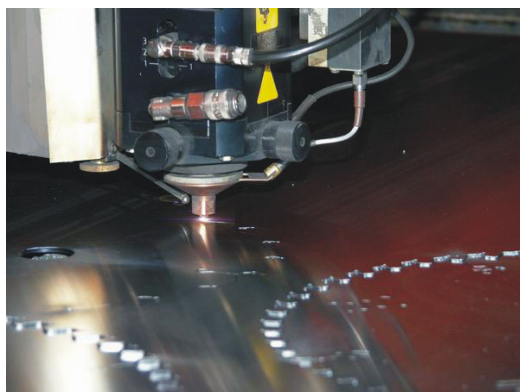
The tips have radius corners for Rotox machines

D	B	b	z	£
170	4.5	3.1	20	547.46
190	4.5	3.1	22	573.77

BLADE FACT

The steel used in our saw blades is of the highest quality. It is a spring steel hardened to give the saw body additional strength and stability.

The steel is laser cut and thereafter tempered to receive the correct hardness, depending on the application and use of the saw blade.



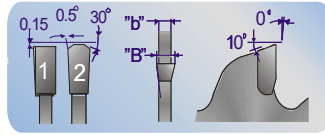


Steel cutting saw blades

Dry cut blades equipped with special carbide tips suitable for sawing steel without cooling.

S13 125-230mm

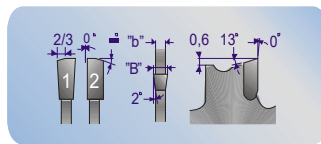
For cutting mild steel



D	B	b	z	£
136	2.2	1.6	36	96.06
150	2.0	1.6	36	103.23
160	2.0	1.6	36	103.23
160	2.2	1.6	62	149.68
165	2.2	1.6	36	105.71
180	2.0	1.6	42	110.37
200	2.0	1.6	48	118.06
210	2.0	1.6	50	126.53
216	2.0	1.6	48	119.51
230	2.0	1.6	54	134.30
230	2.0	1.6	72	157.08
250	2.2	1.8	60	134.30
250	2.2	1.8	80	167.27
305	2.2	1.8	60	137.44
305	2.2	1.8	80	169.05
355	2.6	2.2	84	183.86
400	3.5	2.8	96	222.88
450	3.8	3.1	96	272.08
500	4.2	3.5	96	303.98
550	4.4	3.6	96	518.50
600	4.4	3.6	96	558.55
700	4.4	3.6	116	888.48

S13 250-700mm

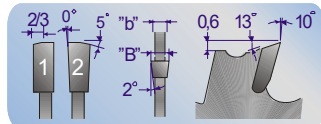
For cutting mild steel



D	B	b	z	£
160	2.2	1.6	62	149.68
200	2.2	1.6	64	154.99
230	2.0	1.6	72	157.08
250	2.2	1.8	80	167.27
305	2.2	1.8	80	169.05
355	2.6	2.2	84	183.86

S13 Stainless

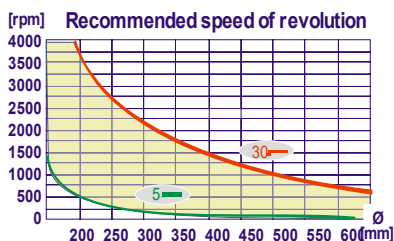
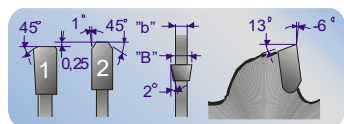
Positive hook angle designed for cutting stainless steel



D	B	b	z	£
350	3.2	2.5	84	203.22
400	3.2	2.5	96	248.57
450	4.0	3.2	108	301.80
500	4.0	3.2	120	377.01

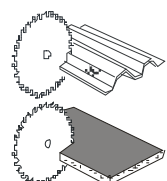
N6EA13sp

Special grind for cutting thin-walled sheets of sandwich material (steel/foam etc.)



Our S13s are Dry cut blades for cutting steel without cooling. Steel

is very abrasive and consequently resharping should be done on a regular basis. These blades are suitable for sheet-metal workers and for use in machine shops. Can also be used on a portable saw.



Page



Blades for the Sawmill industry

See new price list

----- NOTE-----

We supply and manufacture sawblades for almost any application on almost any type of machine. Among the most popular being Söderhamn, Ari/Vislanda, Ari/Heinola, Iggesund, Linck, EWD, SAB, Catech, Ahlström and Hew saw.

If you require any advise or a quote for your particular needs, them please contact a member of our technical staff.





HSS (High Speed Steel) saw blades

SHSS for mild steel

DIN 1,3343 DM05 Steam Oxide Finish For Cutting Mild Steel

D	b	c	z	£
180	2.0	32	180	66.00
200	1.8	32	200	66.00
200	1.8	32	160	66.00

225	2.0	32	220	69.32
225	2.0	32	180	69.32
250	2.0	32	250	78.61
250	2.0	32/40	200	78.61
250	2.0	32/40	180	78.61
250	2.0	32/40	160	78.61
250	2.0	32	128	78.61
250	2.0	32	BLK	72.54

275	2.0	32	220	103.36
275	2.0	32	180	103.36
275	2.0	32	160	103.36
275	2.0	32	BLK	95.52
275	2.5	32/40	220	107.53
275	2.5	32/40	180	107.53
275	2.5	32/40	160	107.53
275	2.5	32/40	BLK	99.33

SHSS for stainless steel

Extreme TI-ALN
For Cutting Mild Steel

D	b	c	z	£
275	2.0	32	220	152.33
275	2.0	32	180	152.33
300	2.5	32	220	184.27
300	2.5	32	180	184.27
315	2.5	32	220	199.70
315	2.5	32	180	199.70
350	2.5	32	280	262.90
350	2.5	32	220	262.90

D	b	c	z	£
300	2.0	32	220	127.07
300	2.0	32	180	127.07
300	2.0	32	160	127.07
300	2.0	32	BLK	117.12

300	2.5	32/40	220	129.89
300	2.5	32/40	180	129.89
300	2.5	32/40	160	129.89
300	2.5	32/40	BLK	119.83
315	2.0	32/40	220	138.56
315	2.0	32/40	180	138.56
315	2.0	32/40	160	138.56
315	2.0	32/40	BLK	127.81

315	2.5	32/40	220	139.08
315	2.5	32	200	139.08
315	2.5	32/40	180	139.08
315	2.5	32/40	160	139.08
315	2.5	32/40	BLK	128.29

350	2.5	32	280	177.77
350	2.5	32	220	177.77
350	2.5	32	180	177.77
350	2.5	32	160	177.77
350	2.5	32	BLK	164.16

SHSS Low Rockwell

Low Rockwell Blades for the
Window Industry

D	b	c	z	£
250	2.0	32	200	109.20

SHSS Trim Blades

Supplied 45 deg Left & Right Hand

D	b	c	z	£
103	2.0	32	60	77.16

Swedex are the UK agents for GLG,
Spain's premier manufacturer of SHSS
saw blades.





Hobby Blades

See new price list

Professional Hard Body Saw Blades

Wood cutting ATB

D	B	b	c	z	£
110	2.0	1.4	20	20	18.97
128	2.6	1.6	20	14	13.97
130	2.6	1.6	20	24	17.46
140	2.6	1.6	16	16	14.86
150	2.6	1.6	20	24	17.79
150	2.6	1.6	20	40	26.28
160	2.6	1.6	20	16	15.71
160	2.6	1.6	20	50	28.17
165	2.6	1.6	30	18	17.46
165	2.6	1.6	20	50	26.28
180	2.6	1.6	30	20	19.51
180	2.6	1.6	30	40	26.51
184	2.6	1.6	16/30	24	22.00
184	2.6	1.6	16/30	40	26.63
184	2.6	1.6	16/30	60	33.07
190	2.6	1.6	16/30	24	24.53
190	2.6	1.6	16/30	40	29.23
200	2.6	1.6	30	24	27.06
200	2.6	1.6	30	40	29.23
210	2.6	1.6	30	20	29.23
210	2.6	1.6	30	40	29.23
230	2.8	1.8	30	40	38.04
235	2.8	1.8	30	30	30.19
235	2.8	1.8	30	40	39.44
235	2.8	1.8	30	60	47.30
250	2.8	1.8	30	24	37.72
250	2.8	1.8	30	40	42.76
250	2.8	1.8	30	60	53.85
250	2.8	1.8	30	80	61.42
260	2.8	1.8	30	30	45.92
260	2.8	1.8	30	60	58.89
300	2.8	1.8	30	48	71.57
305	2.8	1.8	30	40	75.45

Steel cutting

D	B	b	c	z	£
180	2.2	2.0	20	36	52.17
230	2.2	1.8	30	54	93.06

Nail resistant(Flat top)

184	2.2	1.6	16	14	14.55
190	2.2	1.6	16	14	16.40

Chop Saw Blades

D	B	b	c	z	£
205	2.6	1.8	18	24	34.73
210	2.6	1.8	30	48	45.55
216	2.8	2.0	30	24	36.49
216	2.8	2.0	30	48	47.30
216	2.8	2.0	30	60	56.71
250	2.8	2.0	30	80	66.65
254	2.8	2.0	30	40	60.07
254	2.8	2.0	30	60	69.36

Aluminium & Plastic (Triple Chip)

D	B	b	c	z	£
184	2.2	1.6	16	48a	38.91
200	2.2	1.6	30	60a	51.49
210	2.2	1.6	30	48a	47.30
216	2.4	1.8	30	48a	49.03
216	2.4	1.8	30	60a	61.08
216	2.4	1.8	30	80a	63.37
250	2.8	2.2	30	80a	67.00
260	2.8	2.2	30	60a	64.12

Cordless machines

D	B	b	c	z	£
85	1.6	1.0	10	20	23.16
136	1.6	1.0	10	24	24.10
150	1.6	1.0	10	24	24.97
165	1.6	1.0	10/20	24	25.73
165	1.6	1.0	10	52	27.48
190	1.6	1.0	30	24	29.48

Cordless machines-Steel

D	B	b	c	z	£
136	1.5	1.0	10	30	66.00
165	1.5	1.0	10	40	82.82

A range of saw blades for use with portable saws.





Other Cutting Tools

See new price list

Angle grinder Super System

A range of blades for use on an angle grinder. These blades are designed to be used with a special protective guard, which is also available from stock.

	D	B	b	c	z	£
Steel	125	2.2	1.6	25.4	24	77.68
	115	2.2	1.6	25.4	24	70.38
Wood	125	2.5	1.5	25.4	12	59.16
	115	2.5	1.5	25.4	12	54.26
Carver	125	4.0	2.5	25.4	6	60.78
	115	4.0	2.5	25.4	6	55.85
Guards	115/125					76.17

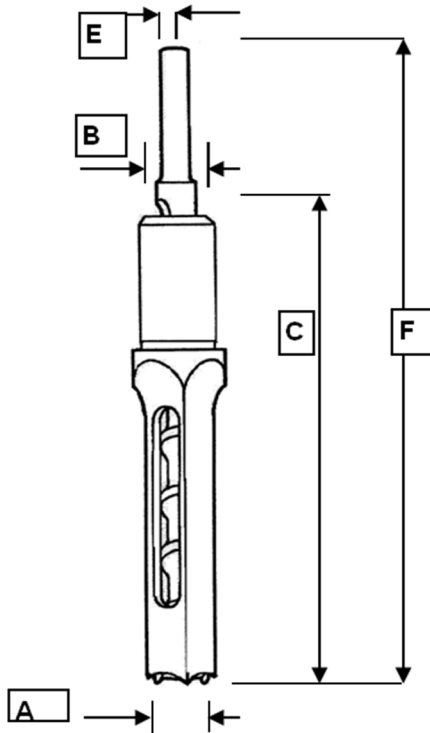
Router Cutters

2 Flute Plunge router cutters



Cutting Dia	Cutting Length	Shank Dia	Shank Length	£
A	B	C	D	
1/2"	2"	1/2"	35mm	23.25
1/2"	1.1/14"	1/2"	35mm	20.25

Mortice Chisel & bit Sets



SizeA	B	C	E	F	£
1/4"	20.6	133	4.4	210	43.63
5/16"	20.6	138	5.9	210	43.63
3/8"	20.6	138	7.0	210	43.63
7/16"	20.6	138	8.4	210	47.68
1/2"	20.6	138	9.4	210	47.68
9/16"	20.6	156	10.5	225	55.34
5/8"	20.6	156	11.9	225	55.34
3/4"	20.6	163	11.9	240	79.25
1"	30.1	190	12.5	275	146.16

