

BANDSAW BLADES



Order a trial performance blade NOW to experience the difference.*

** Satisfaction Guaranteed or Full Purchase Price refunded*

Bi-Alfa Cobalt M42

RÖNTGEN is the world leader in manufacturing bandsaw blades and has a very strong reputation for outstanding performance, quality and consistency.

OUTSTANDING PERFORMANCE, QUALITY & CONSISTENCY

GENERAL INFORMATION: To Assist in the Selection of the Correct Bandsaw Blade

The RÖNTGEN bi-alfa cobalt bandsaw blade has HSS M42 cutting tips. The high wear resistance of the saw blade results from the very hard & evenly distributed carbides in the tooth tips, formed during the hardening and tempering process. With a steel backing strip containing around 4% chromium, the saw blade can withstand the considerable flexing stresses, tension & blade guide pressure present in modern sawing machines.



SOLIDS



TUBES & OTHER SECTIONS



Materials Cross Section mm	Pitch
up to 25	10/14
15-40	8/12
25-50	6/10
35-70	5/8
50-120	4/6
80-180	3/4
80-180	3/4
130-350	2/3
150-450	1.5/2
200-600	1.1/1.6

Wall thickness in mm	Tubes - Outside diameter in mm (D)/ Tooth selection (tpi)										
	20	40	60	80	100	120	150	200	300	500	
2	14	10/14	10/14	10/14	10/14	8/12	8/12	8/12	8/12	5/8	
3	14	10/14	10/14	8/12	8/12	8/12	8/12	6/10	6/10	5/8	
4	10/14	10/14	8/12	8/12	8/12	6/10	6/10	5/8	5/8	4/6	
5	10/14	10/14	8/12	8/12	6/10	6/10	5/8	4/6	4/6	4/6	
6	10/14	8/12	8/12	6/10	6/10	5/8	5/8	4/6	4/6	4/6	
8	10/14	8/12	8/12	6/10	5/8	5/8	4/6	4/6	4/6	4/6	
10		8/12	6/10	5/8	4/6	4/6	4/6	4/6	4/6	4/6	
12		8/12	6/10	4/6	4/6	4/6	4/6	4/6	4/6	4/6	
15		8/12	6/10	4/6	4/6	4/6	4/6	4/6	4/6	4/6	
20		4/6	4/6	4/6	4/6	4/6	4/6	4/6	4/6	3/4	
30				4/6	4/6	4/5	4/5	4/5	4/6	2/3	
50							4/5	3/4	2/3	2/3	
80								3/4	2/3	2/3	
> 100									2/3	1.5/2	

TROUBLE SHOOTING

Stripping Teeth

- ✗ Wrong tooth selection
- ✗ Parts not held securely
- ✗ Feed rate too high or speed too slow
- ✗ Chip brush not working, causing chips to overload gullets
- ✗ Check coolant concentration

Band Breakage

- ✗ Worn Guides
- ✗ Guide arms set too far apart
- ✗ Wrong band tension
- ✗ Feed rate too high
- ✗ Poor butt weld

Rough Cut

- ✗ Band speed too slow & feed rate too high
- ✗ Improper break-in
- ✗ Dull or damaged teeth
- ✗ Check chip brush

Crooked cut

- ✗ Dull blade
- ✗ Improper break-in
- ✗ Guide arms too far apart or out of alignment
- ✗ Damaged roller or carbide guides
- ✗ Feed rate too heavy or blade speed too slow
- ✗ Tooth pitch too fine
- ✗ Band tension too low
- ✗ Vice clamp out of square

Premature dulling of teeth

- ✗ Improper break-in
- ✗ Check coolant concentration & flow
- ✗ Check chip brush
- ✗ Check feed rates & blade speed
- ✗ Select proper tooth pitch

BAND SPEED

Material

Material	in m/min.
Construction Steel/ Machining Steel	80-90
Case Hardened Steels/ Steels for hardening & tempering	45-75
Non-Alloy. Tool Steels/ Roller Bearing Steels	40-60
Alloyed Tool Steels/ High Speed Steels	30-40
Rust Resistant Steels*	20-35
Heat Resistant Steels*/ High Temp. Alloy Steels*	15-25

BREAK IN PROCEDURE

The life of a bandsaw blade can be increased significantly by following the recommended running-in procedure. A new saw blade benefits from a short period of cutting at reduced cutting feed rate. Use normal recommended band speed & reduce feed pressure by 50%. After approximately 500cm² of cross sectional area or 15 minutes has been sawn, the band speed should be gradually increased to maximum, followed by the feed rate.

Further detailed technical advice is available by calling 02 4628 2800.

BEST BLADE FOR YOUR APPLICATION

_____ mm x _____ mm x _____ TPI			
Length	Width	Width	Toothpitch
_____ mm x _____ mm x _____ TPI			
Length	Width	Width	Toothpitch