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**Tooth types**



**M**

To obtain optimum cutting rates, tooth pitch and tooth design are of great importance.

We offer various tooth pitches to solve your cutting problems.

This tooth type has ground tooth tips with a chamfered, non-set precutter and two set finishing cutters and is generally manufactured with a positive rake angle. Its particular tooth geometry allows economic cutting of high and highest alloyed steels with bimetal bandsaw blades.



**N**

With a rake angle of 0°, this tooth type is particularly suited for cutting short chipping, low alloyed materials, solids in small and medium cross sections as well as tubes and profiles.



**K / K+**

With a positive rake angle of 10° or 16° (K+), the hook tooth has a large, long-drawn-out chip space. Therefore, it is mostly used for cutting non-ferrous metals, steels with a low content of carbon, Cr-Ni alloys, and primarily bigger cross sections.



**Key**

*Solid*

*Tubes*

*Bundles*

*Inductive hardened*

*Beams*



**Others**



*Junior – where quality becomes passion*



Research & Development



Production



Training



Just in time

**Our History**

is starting more than 100 years ago – In 1908 the Mesenhöller family started with the production of classical power and hand hacksaw blades in Remscheid, the traditional German toolmaker capital. Over the course of years we acquired an excellent reputation in the metal working industries thanks to the known outstanding quality provided to customers all over Europe.

**Our highest quality**

standards possible are still the hallmark for our precision bandsaw blades produced for our worldwide partners. Today the quality control system certified to DIN EN ISO 9001:2000 standards.

**Our products**

are exclusively produced with our qualified staff in state-of-art production facilities in Remscheid, Germany.

**Our research and development center**

has a great emphasis to look ahead into the cutting tasks of tomorrow and merge this into new innovative products for our valued customers. We believe that only today's effort can guarantee tomorrow's success in quality and performance.

**Our technical service staff**

provides 1st class cutting solutions with their extensive knowledge on machinery and materials.

**Our Full Range**

of solution providing carbon, bimetal and tungsten carbide products made us not only supplier but also technology partner for professional endusers who believe in our philosophy to make all efforts for the highest product quality possible.



Since 1995

*C. Mesenhöller  
Made in Germany since 1908*

# Multicut Bimetal Sawblade M42



**Description**

This band saw blade consists of two materials: the tooth tips are made of alloyed HSS (high speed steel) with 8% cobalt while the support band is made of high-alloyed spring band steel. After heat treatment, the wear-resisting tooth tips have a hardness of approx. 67 - 68 HRc. The high speed steel is connected to the support band through state-of-the-art technology.

**Recommended use**

For cutting all usual types of steel up to a hardness of 45 HRc.

**Sales units**

- Coils of 30 m up to approx. 100 m depending on band width
- welded loops



mm	Inches	3	4	6	8	10	14	18
06 x 0,65	1/4 x .025			K		N		
06 x 0,90	1/4 x .035			K		N	N	
10 x 0,65	3/8 x .025			K	N			
10 x 0,90	3/8 x .035		K	K	N	N	N	
13 x 0,65	1/2 x .025			K		N	N	N
13 x 0,90	1/2 x .035	K	K	K	N	N	N	
20 x 0,90	3/4 x .035	K	K	K			N	N

mm	Inches	4/6	5/8	6/10	8/12	10/14
06 x 0,65	1/4 x .025					N
06 x 0,90	1/4 x .035					N
10 x 0,65	3/8 x .025					N
10 x 0,90	3/8 x .035					N
13 x 0,65	1/2 x .025				N	N
13 x 0,90	1/2 x .035					N
20 x 0,90	3/4 x .035	K	N	N	N	N

# Multicut

## Bimetal Sawblade M42



### Description

This band saw blade consists of two materials: the tooth tips are made of alloyed HSS (high speed steel) with 8% cobalt while the support band is made of high-alloyed spring steel. After heat treatment, the wear-resisting tooth tips have a hardness of approx. 67 - 68 HRc. The high speed steel is connected to the support band through state-of-the-art technology.

### Recommended use

For cutting all usual types of steel up to a hardness of 45 HRc.

### Sales units

- Coils of 50 m up to approx. 100 m depending on band width
- welded loops



mm	Inches	0,75	1,25	2	3	4	6	8	10	14
27 x 0,90	1 1/16 x .035			K	K/N <sup>1)</sup>	K/N <sup>1)</sup>	K/N <sup>1)</sup>	N	N	N
34 x 1,10	1 3/8 x .042		K	K	K/N <sup>1)</sup>	K/N <sup>1)</sup>	N	N	N	
41 x 1,30	1 5/8 x .050		K	K	K	K				
54 x 1,30	2 1/8 x .050		K							
54 x 1,60	2 1/8 x .063		K	K						
67 x 1,60	2 5/6 x .063		K	K						
80 x 1,60	3 1/8 x .063	K	K							

mm	Inches	0,75/ 1,25	1,1/ 1,6	1,5/2	2/3	3/4	4/5	4/6	5/6	5/8	6/10	8/12	10/14
27 x 0,90	1 1/16 x .035				K	K/N <sup>1)</sup>	K	K/N <sup>1)</sup>	K	N	N	N	N
34 x 1,10	1 3/8 x .042				K	K/N <sup>1)</sup>	K	K/N <sup>1)</sup>	K	N	N	N	
41 x 1,30	1 5/8 x .050			K	K	K/N <sup>1)</sup>	K	K/N <sup>1)</sup>		N	N		
54 x 1,30	2 1/8 x .050		K	K	K	K	K	K					
54 x 1,60	2 1/8 x .063	K	K	K	K	K	K	K	K				
67 x 1,60	2 5/6 x .063	K	K	K	K	K	K						
80 x 1,60	3 1/8 x .063	K	K	K	K								

1) Tooth profile K or N available

# Probeam

## Bimetal Sawblade M42



### Description

This band saw blade consists of two materials: the tooth tips are made of alloyed HSS (high speed steel) with 8% cobalt while the support band is made of high-alloyed spring band steel. After heat treatment, the wear-resisting tooth tips have a hardness of approx. 67 - 68 HRC. The high speed steel is connected to the support band through state-of-the-art technology.

### Hallmark

Special tooth geometry for cutting of heavy beams and structurals under low vibration

### Recommended use

Beams and structurals

### Sales units

- Coils of 50 m up to approx. 100 m depending on band width
- welded loops



mm	Inches	2/3	3/4	4/6	5/7	8/11	12/16
20 x 0,90	3/4 x .035						P
27 x 0,90	1/16 x .035		P <sup>1)</sup>	P	P	P	
34 x 1,10	1 3/8 x .042	P	P <sup>1)</sup>	P	P		
41 x 1,30	1 5/8 x .050	P	P <sup>1)</sup>	P	P		
54 x 1,30	2 1/8 x .050	P	P				
54 x 1,60	2 1/8 x .063	P	P <sup>1)</sup>	P			
67 x 1,60	2 5/8 x .063	P	P	P			

<sup>1)</sup> also available in extra heavy set (EHS) for beam cutting

# Alucut

## Bimetal Sawblade M42



### Description

This band saw blade consists of two materials: the tooth tips are made of alloyed HSS (high speed steel) with 8% cobalt while the support band is made of high-alloyed spring band steel. After heat treatment, the wear-resisting tooth tips have a hardness of approx. 67 - 68 HRc. The high speed steel is connected to the support band through state-of-the-art technology.

### Hallmark

Special tooth geometry for cutting of non-ferrous materials.

### Recommended use

- NE Metalle
- Non-ferrous metals
  - Foundry application

### Sales units

- Coils of 75 m up to approx. 100 m depending on band width
- welded loops



mm	Inches	1,25	2	3	4
13 x 0,90	1/2 x .035			K <sup>1)</sup>	K <sup>1)</sup>
20 x 0,90	3/4 x .035			K <sup>1)</sup>	
27 x 0,90	1 1/16 x .035		K <sup>1)</sup>	K <sup>1)</sup>	K <sup>1)</sup>
27 x 1,10	1 1/16 x .042		K <sup>1)</sup>		
34 x 1,10	1 3/8 x .042	K <sup>1)</sup>	K <sup>1)</sup>	K <sup>1)</sup>	

# Procut

## Bimetal Sawblade M42



### Description

This band saw blade consists of two materials: the tooth tips are made of alloyed HSS (high speed steel) with 8% cobalt while the support band is made of high-alloyed spring band steel. After heat treatment, the wear-resisting tooth tips have a hardness of approx. 67 - 68 HRc. The high speed steel is connected to the support band through state-of-the-art technology.

### Hallmark

A style like Multicut M 42 but with a positive rake angle of the tooth tips. This rake angle leads to an aggressive cut of the bandsaw blade resulting in easier cutting.

### Recommended use

For cutting alloyed steel up to a hardness of 45 HRc.

### Sales units

- Coils of 50 m up to approx. 100 m depending on band width
- welded loops



mm	Inches	0,75/1,25	1,1/1,6	1,5/2	2/3	3/4
27 x 0,90	1 1/16 x .035					K+
34 x 1,10	1 3/8 x .042				K+	K+
41 x 1,30	1 5/8 x .050			K+	K+	K+
54 x 1,60	2 1/8 x .063		K+	K+	K+	K+
67 x 1,60	2 5/8 x .063	K+	K+	K+	K+	
80 x 1,60	3 1/8 x .063	K+	K+			



# Nirocut

## Bimetal Sawblade M42



### Description

This band saw blade is a further development of the JUNIOR bimetal bandsaw blade M 42. Thanks to a downstream grinding process, the band has teeth with very exacting height tolerances. The pre- and finishing cutter geometry results in a better chip division and more reliable free cutting of the blade.

### Recommended use

This bandsaw blade is particularly suited for cutting high and highest alloyed steels, such as austenitic steels (for example stainless steels), heat resistant alloys, titanium, nimonic alloy, Hastelloy, and Inconel.

### Sales units

- Coils of approx. 50-100 m depending on band width
- welded loops



<i>mm</i>	<i>Inches</i>	<i>0,75/1,25</i>	<i>1,1/1,6</i>	<i>1,5/2</i>	<i>2/3</i>	<i>3/4</i>
34 x 1,10	1 3/8 x .042				M	M
41 x 1,30	1 5/8 x .050			M	M	M
54 x 1,60	2 1/8 x .063	M	M	M	M	M
67 x 1,60	2 5/8 x .063	M	M	M		
80 x 1,60	3 1/8 x .063	M				

# Durocut Bimetal Sawblade M51



**Description**

This band saw blade consists of two materials: the tooth tips are made of alloyed HSS (high speed steel) with 10% cobalt and tungsten while the support band is made of high-alloyed spring band steel. After heat treatment, the wear-resisting tooth tips have a hardness of approx. 67 - 68 HRc. The high speed steel is connected to the support band through state-of-the-art technology.

**Hallmark**

The higher alloyed HSS cutting edge is most wear resistant and allows longest service life.

**Recommended use**

Universal heavy duty blade designed for large cross sections also on lower alloyed steel grades.

**Sales units**

- Coils of 50 m up to approx. 100 m depending on band width
- welded loops



mm	Inches	0,6/0,7	0,75/1,25	1,1/1,6	1,5/2	2/3	3/4	4/5	4/6
27 x 0,90	1 1/16 x .035					K	K	K	K
34 x 1,10	1 3/8 x .050					K	K		K
41 x 1,30	1 5/8 x .050				K	K	K		K
54 x 1,60	2 1/8 x .063				K	K	K		
67 x 1,60	2 5/8 x .063		K	K	K	K			
80 x 1,60	3 1/8 x .063		K	K					
100 x 1,60	4 x 0.630	K		K					

# CrNiCut

## Bimetal Sawblade M51



### Description

This band saw blade consists of two materials: the tooth tips are made of alloyed HSS (high speed steel) with 10% cobalt and tungsten while the support band is made of high-alloyed spring band steel. After heat treatment, the wear-resisting tooth tips have a hardness of approx. 67 - 68 HRc. The high speed steel is connected to the support band through state-of-the-art technology.

### Hallmark

The higher alloyed HSS cutting edge is most wear resistant and allows longest service life. A special tooth geometry is specially designed for low vibration cutting of Cr-Ni-Ti-Mo steels grades.

### Recommended use

Premium product designed for low vibration cutting of Cr-Ni-Ti-Mo steels grades.

### Sales units

- Coils of 50 m up to approx. 100 m depending on band width
- welded loops



mm	Inches	0,6/0,7	0,75/1,25	1,1/1,6	1,5/2	2/3	3/4
34 x 1,10	1 3/8 x .042					M	M
41 x 1,30	1 5/8 x .050				M	M	
54 x 1,60	2 1/8 x .063			M	M	M	
67 x 1,60	2 5/8 x .063		M	M	M		
80 x 1,60	3 1/8 x .063		M	M	M		
100 x 1,60	4 x 0.630	M		M			

# Powercut I

## Powercut I Black

### TCT Bandsaw Blade

Powercut I



Powercut I Black



#### Description

TCT band saw blade with the proven high chrome alloyed tenacious backing material and a carbide tipped, diamond ground tooth edge.

The special Powercut grind creates a tooth design with multi chipping sections for production cutting with lowest vibrations.

Powercut I Black is additionally uniquely coated to generate higher cutting rates and longer service life.

#### Hallmark

Hallmarks of this high tech blade are best finish, highest cutting rates, heat resistance and long service life.

#### Recommended use

Designed for universal High Performance Cutting specially for tool, stainless and high speed steels

#### Sales units

- Coils of 50 m and 75 m
- welded loops



#### Powercut I

mm	Inches	0,85/1,15	1,1/1,6	1,5/2	2/3	3/4
27 x 0,90	1 1/16 x .035					x
34 x 1,10	1 1/3 x .042				x	x
41 x 1,30	1 5/8 x .050			x	x	x
54 x 1,30	2 1/8 x .050	x		x	x	
54 x 1,60	2 1/8 x .063	x	x	x	x	
67 x 1,60	2 5/8 x .063	x	x	x		
80 x 1,60	3 1/8 x .063	x	x			

#### Powercut I — Black

41 x 1,30	1 5/8 x .050			x	x	x
54 x 1,60	2 1/8 x .063		x	x	x	
67 x 1,60	2 5/8 x .063		x			

# Powercut Pro

## TCT Bandsaw Blade

### Description

TCT band saw blade with the proven high chrome alloyed tenacious backing material and a carbide tipped, diamond ground tooth edge.

The special Powercut grind creates a tooth design with multi chipping sections for production cutting with lowest vibrations.

Powercut I Black is additionally uniquely coated to generate higher cutting rates and longer service life.

### Hallmark

Hallmarks of this high tech blade are best finish, highest cutting rates, heat resistance and long service life.

### Recommended use

Designed for universal High Performance Cutting specially for tool, stainless and high speed steels

### Sales units

- Coils of 50 m and 75 m
- welded loops



34 x 1,10	1 1/3 x .042			X
41 x 1,30	1 5/8 x .050		X	X
54 x 1,60	2 1/8 x .063		X	X
67 x 1,60	2 5/8 x .063		X	
80 x 1,60	3 1/8 x .063	X		

# Powercut II A

# Powercut II B

## TCT Bandsaw Blade



### Description

TCT band saw blade with the proven high chrome alloyed tenacious backing material and a carbide tipped, diamond ground tooth edge.

The special Powercut grind creates a tooth design with triple chip sections for production cutting with lowest vibrations.

### Hallmark

Hallmarks of this high tech blade are best finish, highest cutting rates, heat resistance and long service life.

### Recommended use

Designed for non ferrous castings and foundry applications on vertical machinery and all kind of aluminium cutting.

### Sales units

- Coils of 50 m and 75 m
- welded loops



### Powercut II A

mm	Inches	2	3	0,85/1,15	1,1/1,6	1,5/2	2/3
20 x 0,90	3/4 x .035		x				
27 x 0,90	1 1/16 x.035		x				x
34 x 1,10	1 3/8 x.042	x	x			x	x
41 x 1,30	1 5/8 x.050					x	x
54 x 1,30	2 1/8 x.050			x		x	
54 x 1,60	2 1/8 x.063			x	x	x	

### Powercut II B

mm	Inches	0,85/1,15	1,1/1,6	1,5/2	2/3
27 x 0,90	1 1/16 x.035				x
34 x 1,10	1 3/8 x.042			x	x
41 x 1,30	1 5/8 x.050			x	x
54 x 1,30	2 1/8 x.050	x		x	
54 x 1,60	2 1/8 x.063	x	x	x	

# Powercut III Powercut III Black TCT Bandsaw Blade

Powercut III



Powercut III Black



**Description**

TCT band saw blade with the proven high chrome alloyed tenacious backing material and a carbide tipped, diamond ground tooth edge.

The special Powercut grind creates a tooth design with multi chipping sections for production cutting with lowest vibrations.

Powercut III Black is additionally uniquely coated to generate higher cutting rates and longer service life.

**Hallmark**

Hallmarks of this high tech blade are best finish, highest cutting rates, heat resistancy and long service life.

**Recommended use**

Designed for hardened and tempered materials with hardness between 50-65 HRc for example Induction hardened piston rods etc.

**Sales units**

- Coils of 50 m and 75 m
- welded loops



Powercut III

<i>mm</i>	<i>Inches</i>	<i>2/3</i>	<i>3/4</i>
27 x 0,90	1 1/16 x .035		x
34 x 1,10	1 3/8 x .042	x	x
41 x 1,30	1 5/8 x .050	x	x

Powercut III — Black

<i>mm</i>	<i>Inches</i>	<i>3/4</i>
34 x 1,10	1 3/8 x .042	x
41 x 1,30	1 5/8 x .050	x

# Original Swedish Carbon steel Flexback



## Description

Carbon band saw blades Original Swedish steel (flexback) with hardened tooth tips (approx. 64-65 HRc) and flexible backing material. The pin-point structure ensures evenly distributed carbides and thus high resistance to wear.

## Recommended use

Non-ferrous materials, non-alloyed and low alloyed steels as well as plastics and wood.

## Sales units

- Coils of 30 m up to approx. 100 m depending on band width
- welded loops

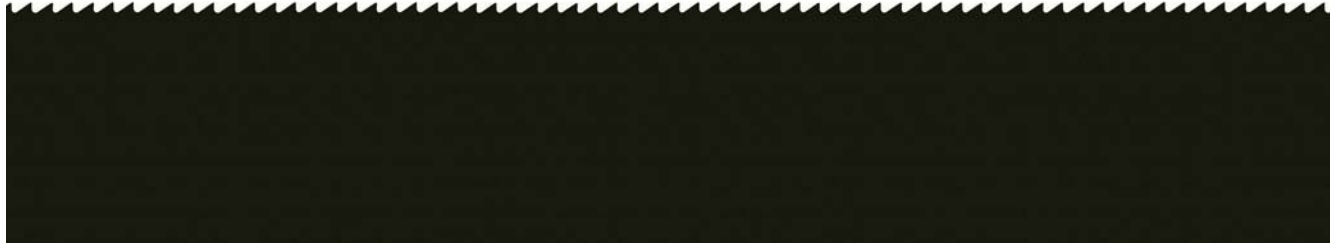


<i>mm</i>	<i>Inches</i>	2	3	4	6	8	10	14	18	24
06 x 0,65	1/4 x .025			K	N/K <sup>1)</sup>	N	N	N	N	N
08 x 0,65	5/16 x .025				N/K <sup>1)</sup>	N	N	N	N	N
10 x 0,65	3/8 x .025		K	K	N/K <sup>1)</sup>	N	N	N	N	N
13 x 0,65	1/2 x .025		K	K	N/K <sup>1)</sup>	N	N	N	N	N
16 x 0,80	5/8 x .032		K	N/K <sup>1)</sup>	N	N	N	N	N	N
20 x 0,80	3/4 x .032		K	K	N	N	N	N	N	N
25 x 0,90	1 x .035	K	K	N/K <sup>1)</sup>	N	N	N	N		N

1) Tooth profile K or N available



# Swedish Special Steel Hardback



## Description

Specially developed steel (higher alloyed tool steel) with a tooth tip hardness of approx. 64-65 HRC and hardened and tempered backing material. Therefore increased cutting rates and better edge retention.

## Recommended use

Better quality compared with the original Swedish steel quality, therefore suited for universal workshop use.

## Sales units

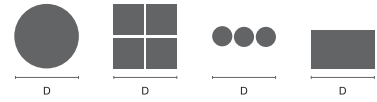
- Coils of 30 m up to approx. 100 m depending on band width
- welded loops



mm	Inches	3	4	6	8	10	14	18	24
06 x 0,65	1/4 x .025		K	N/K <sup>1)</sup>	N	N	N	N	N
08 x 0,65	5/16 x .025			N/K <sup>1)</sup>	N	N	N	N	N
10 x 0,65	3/8 x .025		K	N/K <sup>1)</sup>	N	N	N	N	N
13 x 0,65	1/2 x .025	K	K	N/K <sup>1)</sup>	N	N	N	N	N
16 x 0,80	5/8 x .032	K	N/K <sup>1)</sup>	N	N	N	N	N	N
20 x 0,80	3/4 x .032	K	K	K	N	N	N		N
25 x 0,90	1 x .035	K	N/K <sup>1)</sup>	N/K <sup>1)</sup>	N	N	N	N	

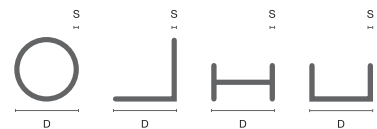
1) Tooth profile K or N available

# Tooth pitch recommendation Solid Material



D	tpi	D	tpi	D	tpi
< 10 mm	14	< 25 mm	10/14	50 – 120 mm	3/4
10 – 30 mm	10	15 – 40 mm	8/12	100 – 250 mm	2/3
30 – 50 mm	8	25 – 50 mm	6/10	150 – 400 mm	1,5/2
50 – 80 mm	6	35 – 70 mm	5/8	350 – 600 mm	1,1/1,6
80 – 120 mm	4	40 – 90 mm	5/6	> 500 mm	0,85/1,15
120 – 200 mm	3	50 – 120 mm	4/6		
200 – 300 mm	2	80 – 150 mm	3/4		
300 – 700 mm	1,25	130 – 350 mm	2/3		
> 600 mm	0,75	150 – 450 mm	1,5/2		
		200 – 600 mm	1,1/1,6		
		> 500 mm	0,75/1,25		

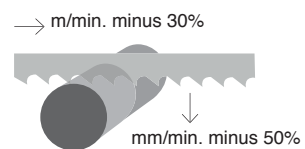
# Tooth pitch recommendation Tubes and Profiles



Wall thickness

S (mm)	20	40	60	80	100	120	150	200	300	500
2	14	10/14	10/14	10/14	10/14	8/11P	8/11P	8/11P	8/11P	5/7P
3	14	10/14	10/14	8/11P	8/11P	8/11P	8/11P	5/7P	5/7P	5/7P
4	10/14	10/14	8/11P	8/11P	8/11P	5/7P	5/7P	5/7P	5/7P	4/6P
5	10/14	10/14	8/11P	8/11P	5/7P	5/7P	5/7P	4/6P	4/6P	4/6P
6	10/14	8/11P	8/11P	5/7P	5/7P	5/7P	5/7P	4/6P	4/6P	4/6P
8	10/14	8/11P	8/11P	5/7P	5/7P	5/7P	4/6P	4/6P	4/6P	4/6P
10		8/11P	5/7P	5/7P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P
12		8/11P	5/7P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P
15		8/11P	5/7P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P
20			4/6P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P	3/4P
30				4/6P	4/6P	4/5P	4/6P	4/6P	4/6P	2/3P
50							4/6P	3/4P	2/3P	2/3P
80								3/4P	2/3P	2/3P
>100									2/3P	1,5/2

# Break-in Procedures



Life-time of band saw blades mainly depends on a controlled break-in.

We recommend the following break-in procedure:

- 1st step  
Select the correct speed  $V_c$  (m/min) and cutting rate  $V_z$  (cm /min) based on cutting conditions chart
- 2nd step  
You start with 70% of the regular cutting speed and 50% of the regular cutting rate.

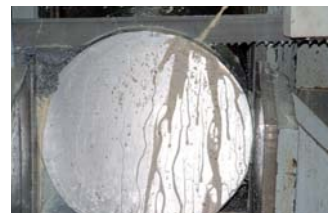
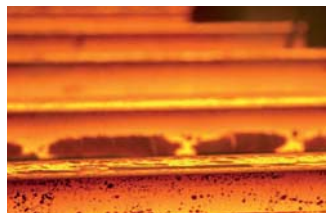
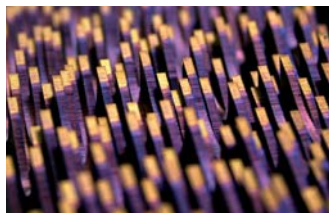
3rd step  
If vibrations still occur, change the speed carefully until the vibrations stop. A permanent chip formation is important during the whole cutting process.

4th step  
After cutting approx. 400-600 cm<sup>2</sup> or at least 15 minutes real cutting time for tubes and profiles you can first slowly turn up to the final speed and then up to the normal cutting rate.

# Cutting rates

Material	DIN	USA	JIS	Size mm		Size mm		Size mm	
				27 x 0,9 – 34 x 1,1 ø 50 – 350 cm		41 x 1,3 – 54 x 1,6 ø 100 – 500 cm		67 x 1,6 – 80 x 1,6 ø 400 – 2000 cm	
				Vc (m/cm)	Vz (cm <sup>2</sup> )	Vc (m/cm)	Vz (cm <sup>2</sup> )	Vc (m/cm)	Vz (cm <sup>2</sup> )
1.0060	St 60-2	A 572 Gr.65	SM 58	65 – 70	35 – 40	60 – 65	40 – 45	40 – 50	20 – 30
1.0401	C15	1016	S 15C	65 – 70	35 – 40	60 – 65	40 – 45	40 – 50	20 – 30
1.0503	C45	1045	S 45C	68 – 74	40 – 45	65 – 70	45 – 50	40 – 55	20 – 35
1.0570	St52–3	A572 Gr.50	SM 490	68 – 74	40 – 45	65 – 70	45 – 50	40 – 55	20 – 35
1.1158	Ck25	1025	S25C	68 – 74	40 – 45	60 – 70	45 – 50	40 – 55	20 – 30
1.1221	Ck60	1060	S58C	68 – 74	40 – 45	60 – 70	40 – 45	35 – 45	15 – 25
1.2080	X210 Cr 12	D3	SKD 1	33 – 37	10 – 18	25 – 35	15 – 20	15 – 20	05 – 10
1.2312	40CrMnMoS 8–6			49 – 53	22 – 30	45 – 50	28 – 32	25 – 30	10 – 15
1.2343	X38 CrMoV 5–1	H11	SKD 6	41 – 45	18 – 24	36 – 40	22 – 26	22 – 30	10 – 20
1.2363	X100 CrMoV 5–1	A2	SKD 12	38 – 42	15 – 20	30 – 36	18 – 22	20 – 26	08 – 14
1.2379	X155 CrVMo 12–1	D2	SKD 11	33 – 37	10 – 18	25 – 35	15 – 20	15 – 20	05 – 10
1.2510	100 MnCrW 4	O1	SKS 3	42 – 46	18 – 24	36 – 42	22 – 26	26 – 30	12 – 18
1.2606	X37 CrMoW 5–1	H12	SKD 62	42 – 46	18 – 24	36 – 42	22 – 26	20 – 28	08 – 16
1.2714	56 NiCrMoV 7	L6	SKT 4	42 – 46	20 – 26	40 – 45	25 – 30	26 – 34	12 – 18
1.2842	90 MnCrV 8	O2		42 – 45	18 – 24	36 – 42	24 – 28	24 – 32	12 – 18
1.3343	S6–5–2	M2	SKH 51	36 – 40	16 – 20	30 – 35	16 – 20	26 – 30	12 – 18
1.3247	S20–20–1–8	M42	SKH 59	36 – 40	16 – 20	30 – 35	16 – 20	26 – 30	12 – 18
1.3965	X8 CrMnNi 18–8	Nitronic 50		30 – 32	8 – 12	26 – 28	12 – 18	12 – 18	04 – 08
1.4006	X10Cr 13	SUS410	410	32 – 34	12 – 16	30 – 34	16 – 22	20 – 26	08 – 14
1.4028	X20 Cr 13	420	SUS 420J1	36 – 38	15 – 20	32 – 36	18 – 22	26 – 30	06 – 10
1.4125	X105 CrMo 17	440 C	SUS 440 C	34 – 37	12 – 18	28 – 32	16 – 18	16 – 22	06 – 10
1.4301	X5 CrNi 18–10	304	SUS 304	36 – 38	15 – 20	32 – 36	18 – 22	16 – 22	06 – 10
1.4401	X5 CrNiMo 17–12–2	316	SUS 316	34 – 36	14 – 18	28 – 32	16 – 18	16 – 22	06 – 10
1.4462	X2 VnNiMoN 22–5–3	2205	SUS 329J3L	32 – 34	10 – 14	28 – 32	16 – 20	16 – 22	06 – 10
1.4571	X6 CrNiMoTi 17-12-2	316 Ti	SUS 316	32 – 34	10 – 14	28 – 32	16 – 20	16 – 22	06 – 10
1.4841	X15 CrNiSi 25–20	314	SUH 310	28 – 32	8 – 12	26 – 30	12 – 16	14 – 20	04 – 08
1.4864	X12 NiCrSi 36–16	330	SUH 330	28 – 32	8 – 12	26 – 30	12 – 16	14 – 20	04 – 08
1.4923	X22 CrMoV 12–1			28 – 32	8 – 12	26 – 30	12 – 16	14 – 20	04 – 08
1.4980	X5 NiCrTi 26–15	A286	SUH 660	28 – 32	8 – 12	26 – 30	12 – 16	14 – 20	04 – 08
1.5710	36 NiCr 6	(X)3140		48 – 52	22 – 28	44 – 48	28 – 32	26 – 34	12 – 18
1.5755	31 NiCr 14	3415	SNC 815	50 – 54	24 – 30	46 – 52	30 – 36	30 – 36	14 – 20
1.6310	20 MnMoN i-5			48 – 52	22 – 28	44 – 48	28 – 32	26 – 34	12 – 18
1.6523	20 NiCrMo 2	8620	SNCM 220	50 – 54	24 – 30	44 – 50	30 – 34	26 – 34	14 – 20
1.6546	40 NiCrMo 2–2	8640	SNCM 240	50 – 54	24 – 30	44 – 50	30 – 34	30 – 34	10 – 18
1.6562	40 NiCrMo 7	E4340	SNB24-1-5	50 – 54	24 – 30	44 – 50	30 – 34	30 – 34	10 – 18
1.6749	23 CrNiMo 7–4–7			50 – 54	24 – 28	44 – 50	28 – 32	30 – 34	10 – 16
1.6985	28 CrMoNiV 4–9			54 – 58	28 – 34	48 – 54	32 – 38	36 – 40	16 – 22
1.7147	20 MnCr 5	SMnC420H	5120	58 – 62	28 – 36	52 – 56	32 – 38	38 – 46	18 – 26
1.7225	42 CrMo 4	4140	SCM 440	54 – 58	28 – 34	48 – 54	32 – 38	36 – 40	16 – 22
1.7228	50 CrMo 4	4150	SCM 445	56 – 60	30 – 36	52 – 56	34 – 40	34 – 40	16 – 20
1.7335	13 CrMo 4–4	SFVA F 12	A387 Gr. 12	62 – 64	32 – 38	56 – 60	36 – 44	40 – 46	18 – 26
1.7707	30 CrMoV 9			54 – 58	28 – 34	44 – 50	28 – 34	28 – 34	16 – 20
1.8159	50 CrV 4	6150	SUP10	52 – 54	24 – 30	52 – 48	32 – 38	32 – 40	12 – 20
1.8509	41 CrAlMo 7	A 355 Cl. A	SACM 645	42 – 45	18 – 24	36 – 40	22 – 26	18 – 24	08 – 14

Above cutting chart refers to average settings. Figures might differ depending on blade type, band saw machine type, condition of the material to be cut (surface, heat treatment, standard, ...) and the required cutting specification (tolerances, service life, ...). Please notice that the ultimate service life can only be achieved after correct beak-in. If your material is not listed please do not hesitate to contact us for further information.



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