

## HSS - circular saw blades for metal CSN 222916 - rough teeth, tooth form B



**Materials:** steel, cast, non-ferrous metals

**Application:** recommended for deep slotting and cutting materials which make longer chips, suitable for cutting thick-walled profiles (wall over 2,5 mm)

**Machine:** metal processing machines

**Characteristic:**

- » HSS circular saw blades with rough teeth
- » hollow ground with flange, standardly produced without driving pin holes and without groove
- » tooth form B (by request BW)
- » the chip clearance isn't so much reduced as in the case of fine teeth A and it allows to put the chips away more efficiently
- » the tolerances and hollow ground according CSN 222916

The saw blades CSN 222916 with rough teeth and teeth form B are very efficient for cutting steel materials. In comparison with teeth form A there is much larger area for removing the chips and that's why they enable bigger cut. They can be ordered with teeth form BW (the teeth form B with alternate chamfering).

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D (mm)	20	25	32	40	50	63	80	100	125	160	200	225	250	275	315
dH7 (mm)	5	8	8	10	13	16	22	22	22/27	32	32	32	32	32	32/40
B (mm)	number of teeth														
1,00 mm						40	40	52	64	80					
1,20 mm						32	40	50	64	64	80				
1,60 mm						32	40	50	50	64	80	80	80		
2,00 mm						32	32	40	50	64	64	80	80	100	
2,50 mm						32	32	40	50	50	64	64	80	80	80
3,00 mm						24	32	40	40	50	64	64	64	80	80
3,50 mm						24	32	40	40	50	64	64	64	80	80
4,00 mm						24	26	32	40	50	50	50	64	80	80
4,50 mm						24	26	32	40	50	50	50	64	84	80
5,00 mm						24	26	32	40	40	50	50	64	64	64
5,50 mm						24	26	32	40	40	50	50	64	64	64
6,00 mm						20	26	32	32	40	50	50	50	50	64

**HSS slitting saws ? coarse with Coarse Pitch as to DIN 1838 Toothform B. Used for medium deep cutting and cut-off operations. Hollow ground on both sides to prevent binding.**

D (mm)	2 1/2	3"	3 1/2	4"	4"	4 1/2"	5"	5"	6"	6"	7"	7"	8"	8"	10"	10"	12"	12"
dH7 (mm)	1"	1"	1"	1"	1 1/4"	1"	1"	1"	1 1/4"	1 1/4"	1"	1 1/4"	1"	1 1/4"	1"	1 1/4"	1"	1 1/4"
B (mm)	number of teeth																	
1/6 4	26	30																
1/3 2	26	30	32	36		38	40		44	44								
3/6 4	26	30	32	36		38	40		44									
1/1 6	26	30	32	36	36	38	40	40	44	44	48		52	52	62	62		
5/6 4	26	30	32	36	36		40		44		48	48	52	52	62			
3/3 2	26	30	32	36		38	40	40	44	44	48	48	52	52	62	62		
7/6 4	26	30	32	36					44									
1/8	26	30	32	36	36		40	40	44	44	48	48	52	52	62	62	70	70
5/3 2		30	32	36			40		44	44	48		52		62			
3/1 6	26	30	32	36			40		44	44	48		52	52	62		70	
7/3 2		30	32	36	36		40		44		48		52		62			
1/4	26	30	32	36			40		44	44		48	52	52	62			

Slitting saws range is  $\varnothing$  20 mm -  $\varnothing$  315 mm with thicknesses ranging 0,2 mm - 6 mm in variable increments with tooth forms: A - B - BW. All standard saws are available in HP-GRIND execution but are readily available in VAPO or P.V.D. (Physical Vapour Deposition) coated execution. The above-mentioned examples of slitting saws are only a small overview of our production possibilities. We are ready to produce also different tools according to your documentation like prismatic cutters, gear milling cutters, profile cutters, shell end mills cutters, side and face milling cutters, halfcircle milling cutters convex, half circle milling cutters concave, corner rounding milling cutters, single angle milling cutters, double angle milling cutters , HSS Side Chip Clearance Saws straight teeth, M2 Side Chip Clearance Saws staggered tooth, HSS Side and Face Cutters straight teeth, HSS Side and Face Cutters staggered teeth.