

HSS circular saw blades for metal according CSN 222913 half-rough teeth



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 A (by request AW)
- » the chip clearance is not so much reduced as in the case of the fine teeth in the norm CSN 222910 and it allows to put the chips away more efficiently
- » the tolerances and hollow ground according CSN 222913

The saw blades CSN with half-rough teeth and teeth form A. The cutting edge is very sharp. The chip clearance isn't reduced as much as in the case of fine teeth. They can be ordered with teeth form AW (the teeth form A with alternate chamfering).

HSS - circular saw blades for metal CSN 222913 - half-rough teeth															
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.