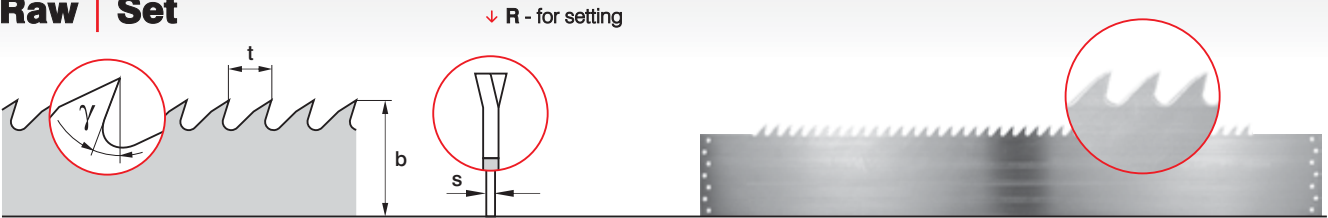


Gang saws

Raw Set Stellited Chromed

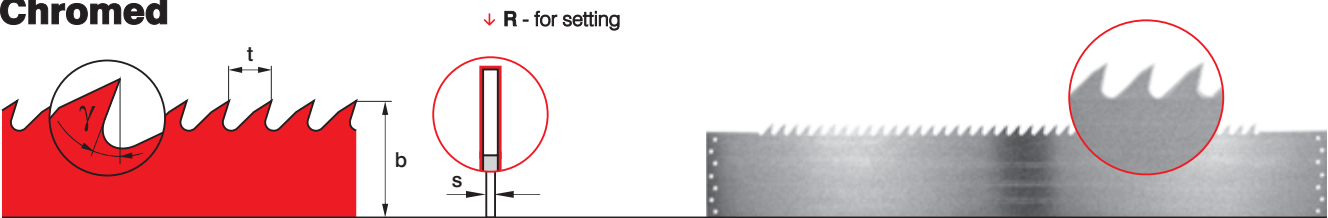
→ **Raw | Set**



→ **Stellited**



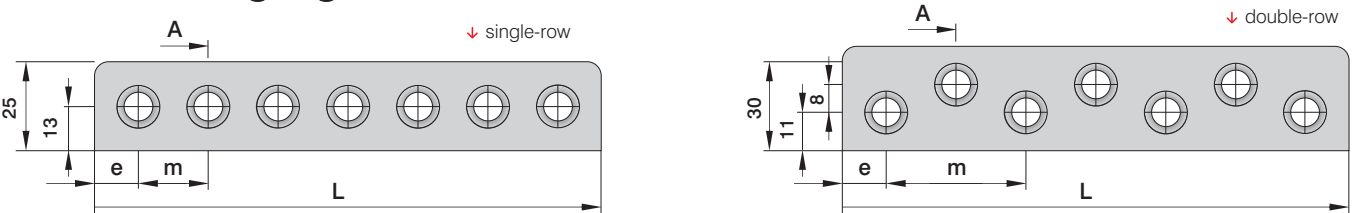
→ **Chromed**



→ **Parameters/ Steel**

German Steel	b x s [mm]	140 x 2,2	160 x 2,2	180 x 2,45
Uddeholm	b x s [mm]	140 x 2,2	160 x 2,2	

→ **Borders for gang saws**



→ **Parameters**

Width of border 25 mm	e [mm]	12,5	m [mm]	20	L [mm]	125 145 165
Width of border 30 mm	e [mm]	10,0	m [mm]	35	L [mm]	125
	e [mm]	12,5	m [mm]	40	L [mm]	145
	e [mm]	16,5	m [mm]	44	L [mm]	165

gang saws

Gang saws

General information

→ Basic information

Saws available: **raw, set, stellited, chromed.**

Teeth available: **R** (for setting), **S** (for stelliting).

Pitches available: **t=25 mm / t=26 mm / t=30 mm.**

→ Hardness of saws

Saw's body **45-47 HRC; 48-49 HRC** (Uddeholm) | Stellited teeth **49-51 HRC** | Chromium coating **15-20 mm**

→ Use

Saws for sawing every kind of wood. **Set gang saws** provide highly effective performance on soft and fresh wood. **Stellited gang saws** provide highly effective performance on some types of exotic wood, featuring mineral inclusions such as makore or azobe. Foreign objects in the form of chips up to 1 mm wide present no risk of damaging the cutting edge. **Chromed gang saws** provide highly effective performance on hard wood, frozen wood and wood rich in resin.

→ Working time (h + 12 h rest time = sharpening)

Set saws **2-3 h** | Stellited saws **5-7 h** | Chromed saws **3-5 h**

→ Sharpening, setting, stelliting

During sharpening you must work according to the instructions of the sharpener's manufacturer.
Setting gang saws at 1/2 height of the tooth measured from its tip.
We recommend the following values per side [mm]:

thickness of saw	type of wood	setting values	stelliting values
2,2	fresh, soft	0,90 - 0,95	0,85 - 0,90
	hard, frozen	0,80 - 0,85	0,75 - 0,80
2,45	fresh, soft	0,95 - 1,00	0,90 - 0,95
	hard, frozen	0,85 - 0,90	0,80 - 0,85

- ⓘ Gang saws are cut using laser.
- Gang saws are tensioned.
- We do special orders.
- We cut compensatory holes in saws.
- We recondition gang saws. Reconditioning includes: preparation, stellite tipping and sharpening of saw.