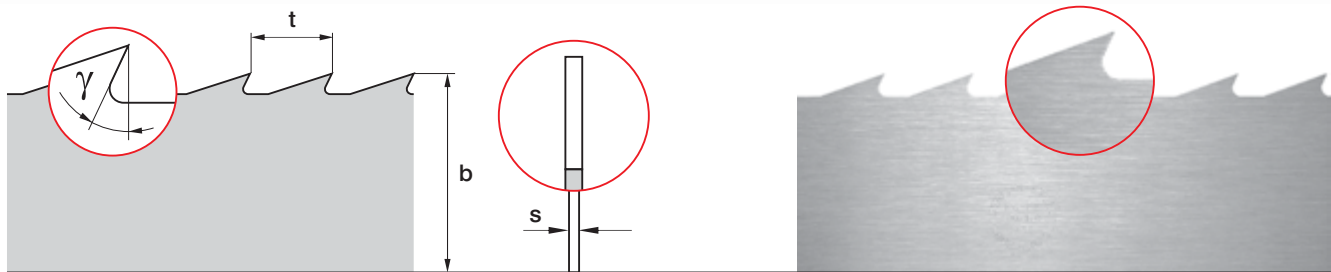


Wide band saws

Raw Swaged Stellited

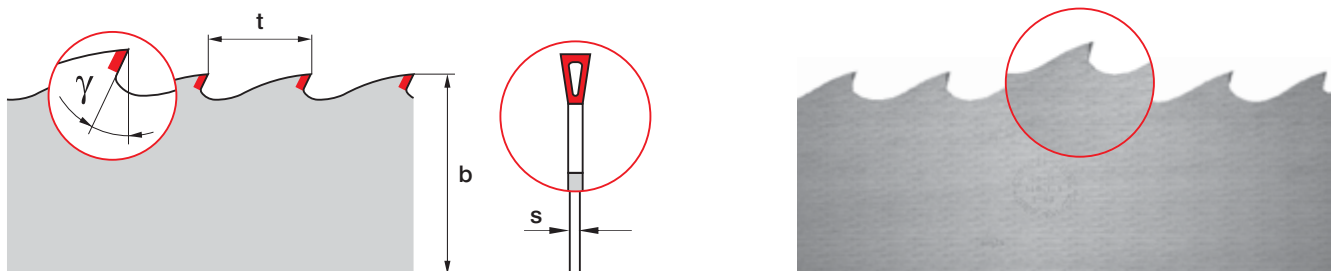
Raw

R - for setting



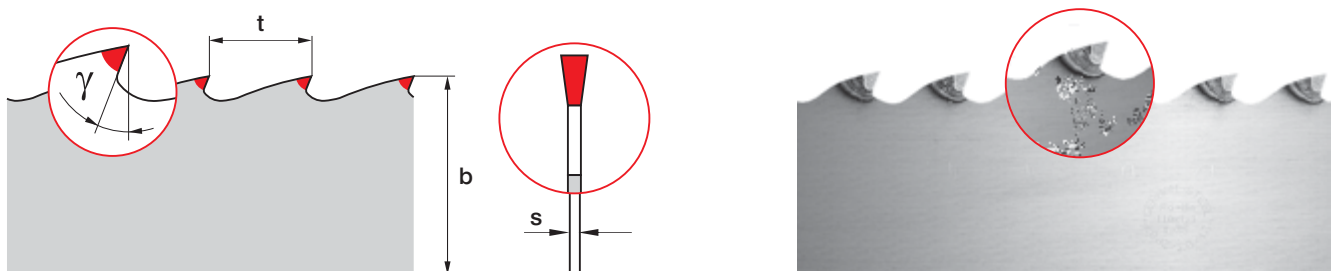
Swaged

Z - for swaging



Stellited

S - for stelliting



Parameters/ Steel

German Steel	b x s [mm]	80 x 1,0	80 x 1,1	100 x 1,0	100 x 1,1	100 x 1,2	100 x 1,6	104 x 1,25
		110 x 1,1	120 x 1,1	130 x 1,2	130 x 1,3	140 x 1,2	150 x 1,3	160 x 1,3
		180 x 1,4	200 x 1,4	206,4 x 1,47	230 x 1,4	230 x 1,5	230 x 1,6	
Uddeholm	b x s [mm]	100 x 1,0	110 x 1,1	130 x 1,2	140 x 1,1	160 x 1,3	180 x 1,47	206,4 x 1,47
		260,4 x 1,83						

# wide band saws

## Wide band saws

## General information

### → Basic information

Saws available: **raw**, **swaged**, **stellite**.

Teeth available: **R** (for setting), **Z** (for swaging), **S** (for stellite).

Pitches available: **t=25-50 mm**. For the following widths of the saws (**b**) we recommend the following pitches (**t**):

b	80 - 90	100 - 120	130 - 140	150 - 160	180 - 260
t	25	30	35	40	50

### → Hardness of saws

Saw's body **44-46 HRC** | Swaged teeth **46-48 HRC** | Stellite teeth **49-51 HRC**

### → Use

Saws for sawing round wood and for flitching. **Set wide band saws** provide highly effective performance on soft and fresh wood. **Swaged wide band saws** provide highly effective performance on hard and frozen wood. **Stellite wide band 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.

### → Rules of usage

**Cooling** - the saw requires very abundant cooling to prevent overheating.

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

Set saws **1-2 h** | Swaged saws **2-3 h** | Stellite saws **3-4 h**

### → Sharpening, setting, swaging, stellite

During sharpening you must work according to the instructions of the sharpener's manufacturer. Setting, swaging – at 1/2 or 2/3 height of the tooth measured from its tip, depending on its height. We recommend the following values per side [mm]:

thickness of saw	type of wood	setting values	swaging, stellite values
1,0 - 1,25	fresh, soft	0,60 - 0,75	0,60 - 0,65
	hard, frozen	0,50 - 0,65	0,50 - 0,55
1,3 - 1,47	fresh, soft	0,70 - 0,85	0,65 - 0,70
	hard, frozen	0,60 - 0,75	0,55 - 0,60
1,5 - 1,83	fresh, soft	0,80 - 0,95	0,65 - 0,80
	hard, frozen	0,70 - 0,85	0,55 - 0,70

- i** We adjust wide band saws. Adjustment includes: leveling, tensioning and straightening. It is necessary to inform about the amount of the crown (usually it is 1/2 or 1/3 of the saw's width).  
We recondition wide band saws. Reconditioning includes: preparation, stellite tipping and sharpening of saw.