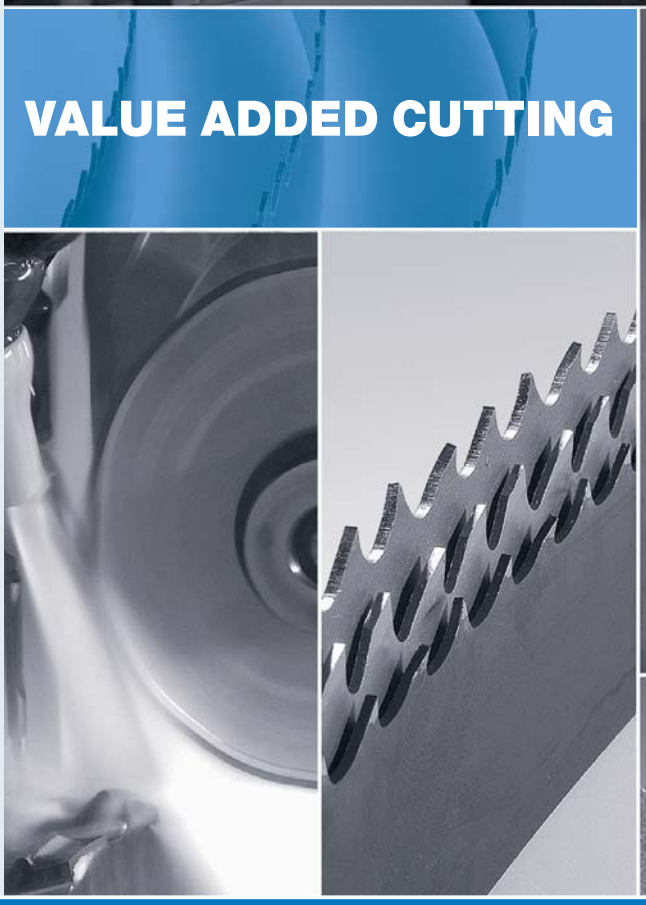
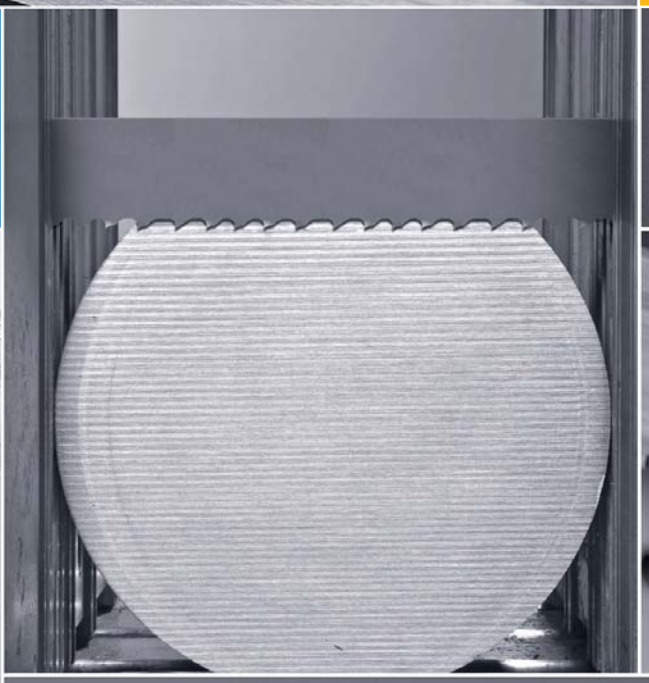
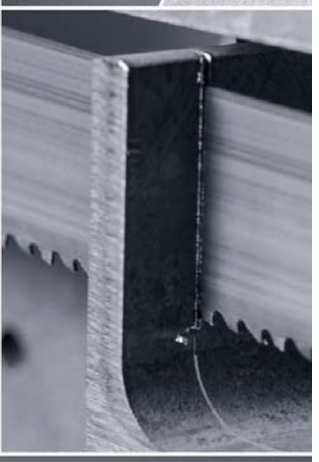
IPC Individual Performance Cutting.

VALUE ADDED CUTTING







WESPA BANDSAW BLADES

WESPA®

VALUE ADDED CUTTING

IPC | INDIVIDUAL PERFORMANCE CUTTING® band saw blade program

Material-group	Material	DIN (Example)	473-IPC Galaxy HMD -IPC	471-IPC Galaxy HMS -IPC	460-IPC DUROTEC-IPC	456-IPC XTREMA-IPC	454-IPC XENOTEC-IPC	453-IPC SUPER SCL IPC	452-IPC BITEC Plus IPC	451-IPC BITEC -IPC
IPC-Option			H X S G C	H X S G C	H X S G C	H X S G C	H X S G C	H X S G C	H X S G C	H X S G C
1	Structural steel Free Machining steel	1.0037 ST37 S235JR 1.0040 ST44 S275J2G3 1.0301 C10 1.0721 10S20				H U L	⁂ ⁂ ⇑		■ ● ⁂ ◉	□ ○ ▬ •
2	Structural steel Tempered steels	1.0050 ST50 E295 1.0060 ST60 E335 1.0501 C35 1.0503 C45				H U L	⁂ ⁂ ⇑		■ ● ⁂ ◉	□ ○ ▬ •
3	Hardened steel Tempered steel	1.7131 16MnCr5 1.7225 42CrMo4 1.8159 51CrV4 1.6582 34CrNiMo6							■ ● ⁂ ◉	□ ○ ▬ •
4	Carbon steel	1.3505 100Cr6 1.1663 C125W			■ ● ▬				■ ● ⁂ ◉	□ ○ ▬ •
5	High-speed steel	1.3343 S6-5-2 1.3247 S2-10-1-8			■ ● ▬			■ ●	■ ● ⁂ ◉	□ ○ ▬ •
6	Work tool steel	1.2436 X210CrW12 1.2379 X153CrVMoV12	■ ● ▬		■ ● ▬			■ ●	■ ● ⁂ ◉	□ ○ ▬ •
7	Alloy steel Nitride steel	1.2311 40CrMnMo7 1.2714 56NiCrMoV7 1.2344 X40CrMoV51 1.8504 34CrAl6	■ ● ▬		■ ● ▬			■ ●	■ ● ⁂ ◉	□ ○ ▬ •
8	Stainless steel	1.4301 X10CrNi1810 1.4462 X2CrNiMoN22 1.4571 X6CrNiMoTi17	■ ● ▬		■ ● ▬			■ ●	■ ● ⁂ ◉	□ ○ ▬ •
9	Heat resistant steel	1.4841 X15CrNiSi25 2.4816 NiCr15Fe	■ ● ▬		■ ● ▬			■ ●		
10	Nickel base alloy	2.4668 NiCr19NbMo 2.4610 NiMo16Cr16Ti 2.4632 NiCr20Co18Ti	■ ● ▬		■ ● ▬			■ ●		
11	Cast iron	0.6020 GG-20 0.6030 GG-30 0.7070 GGG-70		■ ● ▬ ⌶					■ ● ⁂ ◉ ⌶	□ ○ ▬ • ⌶
12	Titanium Titanium alloys	3.7065 TI 3.7115 TiAl5Sn2F79	■ ● ▬		■ ● ▬			■ ●		
13	Aluminnium	EN AW-1200 AL 99 EN AW-6082 Al Si1MgMn EN AC-AlMg5Si	■ ● ▬	■ ● ▬					■ ● ⁂ ◉	□ ○ ▬ •
14	Brass	2.0321 CuZn37 2.0402 CuZn40Pb2 2.0550 Cu Zn 40 Al 2		■ ● ▬					■ ● ⁂ ◉	□ ○ ▬ •
S	Special materials		◉	⌂						
Fe	No ferrous metals			■ ● ▬ ⌂					■ ● ⁂ ◉	□ ○ ▬ •

Note the saw blades with IPC | Individual Performance Cutting Option are matched to your application used with increased performance parameters, depending on the material for higher cutting performance and blade life in the industrial sector. Which option you need, we like to recommend. The options are available depending on dimensions and TPI.

STANDARD band saw blade program

480 SAPHIR U/D	473 GALAXY HMD	471 GALAXY HMS	460 DUROTEC	456 XTREMA	454 XENOTEC	453 SUPER SCL	452 BITEC Plus	450 BITEC	420 LG-Super	410 SPEZIAL
				HUL						
				HUL						
Page 20	Page 20	Page 21	Page 19	Page 18	Page 17	Page 16	Page 15	Page 14	Page 13	Page12

Top-quality tools made in Germany: manufacturing location in Melsungen.

From a small local manufacturer to a worldwide technology partner.

60 years ago WESPA started in Hessen's Spangenberg with the production of hand hacksaws; today we are a reliable technology partner in worldwide demand.

WESPA is one of the leading global manufacturers of bandsaw blades. More than 100 employees are producing an unmatched range of products in the headquarters in Melsungen, Germany. Which meet the requirements of numerous different sectors.

Famous global players rely on the bandsaw blades manufactured by WESPA, from automotive and aviation to the mechanical engineering industry, to name but a few. As a full-range provider, we are offering customized solutions to improve our customers' competitiveness. Our comprehensive sales network in over 60 countries guarantees fast availability, short delivery times and extensive service.

Success based on trust.

WESPA's customers can rely unconditionally on our products. Already the quality and performance of our standard products is excellent. Moreover, customers are able to further enhance the features of the bandsaw blade by specific product modifications depending on their requests. These modifications can minimize tool costs, increase the maximum throughput, decrease the running machine cost or improve the quality of the surface.

WESPA offers customized solutions for all possible sawing applications, which increase the production processes efficiency. The customers express their trust in us by choosing our products worldwide.

WESPA

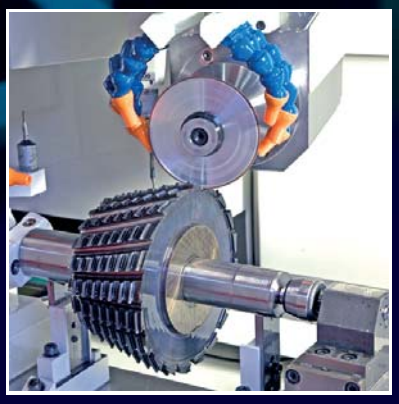
For long-term success.

At WESPA we are interested in a long-term success of our customers. Competent and individual costumer service means for us that we can match client-specific applications and requirements and suggest appropriate bandsaw blades. Accurately fitting system solutions with additional benefit and longtime partnerships are the results of our efforts.

A comprehensive service package completes WESPA's business activities. From performance checks, specialized delivery and maintenance services to training: WESPA is there to help their customers in words and deed throughout of the products economic life-time.

Wespa reacts flexible on changes
of customer's requirements
in the worldwide market.

The quality management has a particular importance to Wespa.



Continuous investments and innovations in production process guarantees first-class quality by Wespa | Made in Germany.

WESPA – a strong partner.

Individual highly efficient solutions, innovation, customer proximity, comprehensive service package, continuous investments in our production location in Germany, dedicated employees and the exact knowledge of worldwide market requirements makes WESPA to a strong partner.

This is our benefit from over 60 years of experience in the production of bandsaw blades.

CONTACT

WESPA Metallsägenfabrik
Simonds Industries GmbH

Spangenberger Straße 61
D – 34212 Melsungen, Deutschland

Tel: +(49) 5661 – 9263 0
Fax: +(49) 5661 – 9263 120

Internet: www.professional-cutting.de
E-mail: info@wespa-simonds.de

Individual Performance Cutting®

IPC

Individual®
Performance
Cutting.

IPC saw blades are used at higher cutting requirements, or when the desire to optimize the current bandsaw blade performance.

THE BENEFITS

- Higher feed rates and shorter cutting times
- Longer blade life
- Increased productivity and reduced manufacturing costs
- Profitable alternative to HM saw blades
- Shorter delivery periods by reduction of cutting times
- Higher quality of manufacture and product
- Increased manufacturing accuracy
- More flexible Work scheduling
- Protection of environment and resources

IPC options depending on material and application.

H	For longer blade life, no break in time
X	Protect tooth and pinching
S	Higher feed rates, minimized noise
G	Better surface, longer blade life
C	Reduces cutting time, longer blade life, low noise

Due to a better performance of our tools, the performance requirements are quickly adjust depending on the assignment or shift work can be organized more efficiently.

The new generation of band saw blades achieves significantly higher cutting values. This results in most improvements being with regard to sawing times and service lifetimes, tool changing and finally also eco friendliness, energy and resource management. The recommended option can be chosen jointly with WESPA: „using configuration software, we will evaluate the performance, query the desired targets and then fulfil them based on the product options." Depending on the configuration, this can result in other benefits, such as better surfaces or less operation noise.

Sawing with IPC | Individual Performance Cutting Option

Customer application example 1: C

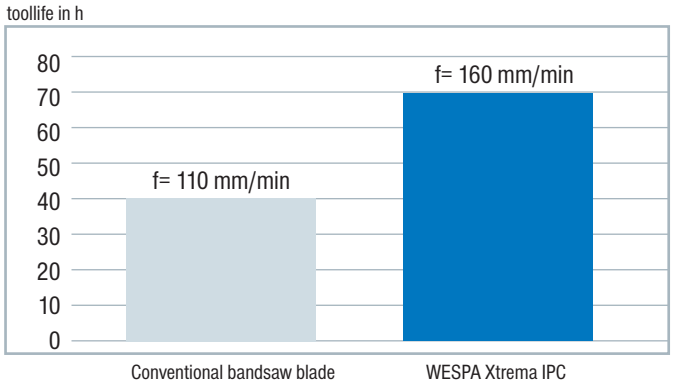
WESPA increases tool life by 75% when sawing EURO NORM steel beams with a 30% higher feed rate

(Case study: performance is different, according to the operating conditions)

Tool:
- 9550x54x1,6 3/4 XTREMA IPC

Material:
- Euronorm steel beams (Mix)
- ST37/S235JR

Cutting Parameter:
- Feedrate: 160 mm/min



Source: WESPA customer data

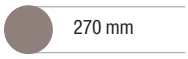
Sawing with IPC | Individual Performance Cutting Option

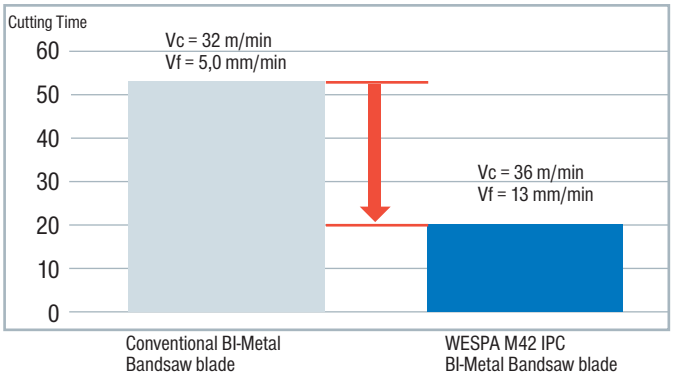
Customer application example 2: S

WESPA increases productivity 63% when cutting solid material.
(Material DIN1.4301/ASI304)
(Case study: performance is different, according to the operating conditions)

Tool:
- Bi-Metall Bandsaw blade WESPA SUPER SCLIPC S 5800 x 41 x 1,3, 1,4/2

Material:
- 1.4301 (X5CrNi 18-10) AISI 304 (V2A)





Source: WESPA customer data

IPC band saw blade is customized and manufactured individually depends on material and customer needs.

Advice and recommendation through WESPA Service or certified value added reseller.

Sawing with IPC | Individual Performance Cutting Option

Customer application example 3: C

WESPA increases tool life by 200% when sawing EURO NORM steel beams in compare conventional M42 Bi-Metal bandsaw blades.

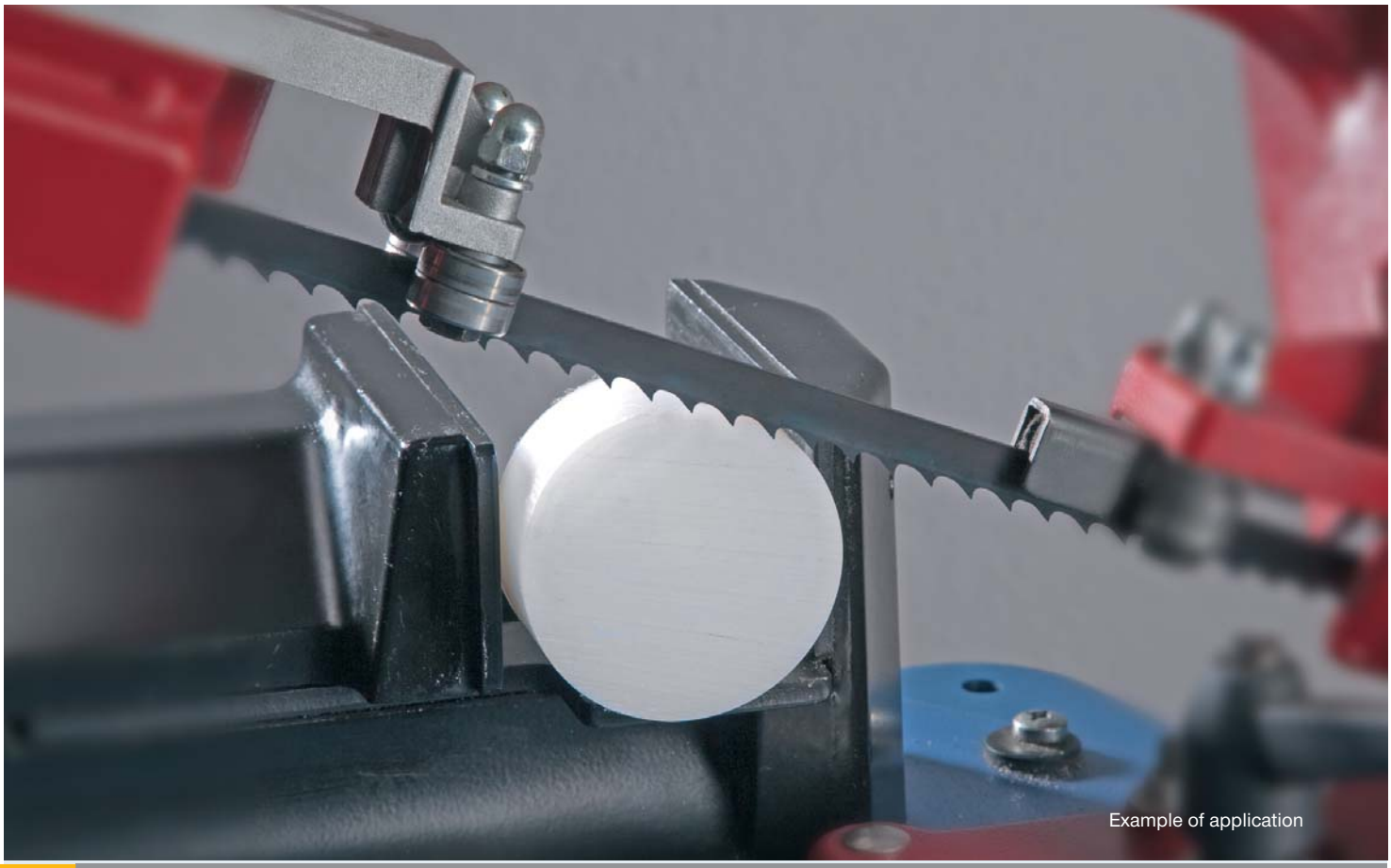
(Case study: performance is different, according to the operating conditions)

Tool:
- 8900 x 54 x 1,6 3/4 XTREMA IPC

Material:
- Euronorm steel beams (Mix)
- ST 37/S235JR

Cutting Parameter:
- Feedrate:150 mm/min

Source: WESPA customer data



Example of application

Carbon Steel Bandsaw Blades

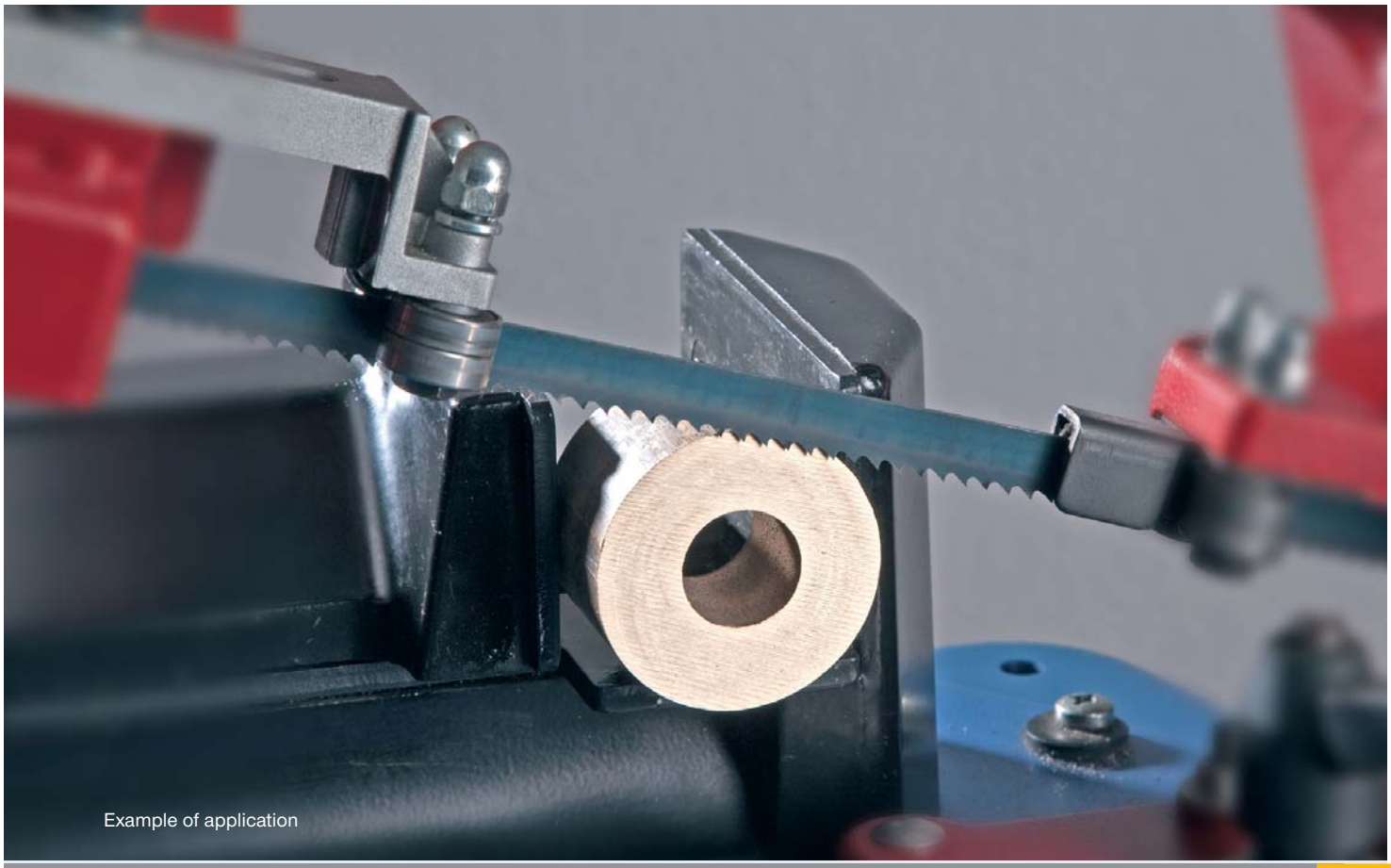
WESPA SPEZIAL

Product Group 410

Wespa Spezial (Flexback)
Standard grade carbon steel with an addition of chromium, tooth-hardened with a flexible blade body. A particular type of steel, known as “pin point”, yields hardened tooth tips with extremely high wear resistance. Easily welded!
Wespa Spezial bandsaw blades are used for materials that are easy to cut.

width x thickness		Standard Tooth (N)				teeth per inch			Hook Tooth (KL)		
mm	inch	4	6	8	10	14	18	22	3	4	6
5 x 0,65	3/16" x 0,025					■	■	■			
6 x 0,65	1/4" x 0,025			■	■	■	■	■		■	■
8 x 0,65	5/16" x 0,025			■	■	■	■	■		■	■
10 x 0,65	3/8" x 0,025	■	■	■	■	■	■	■		■	■
13 x 0,65	1/2" x 0,025	■	■	■	■	■	■			■	■
16 x 0,65	5/8" x 0,025	■	■	■	■	■					■
16 x 0,80	5/8" x 0,032	■	■	■	■	■				■	
20 x 0,80	3/4" x 0,032	■	■	■	■	■			■	■	
25 x 0,90	1" x 0,035	■	■	■	■	■			■	■	

1 2 Fe



Example of application

Carbon Steel Bandsaw Blades

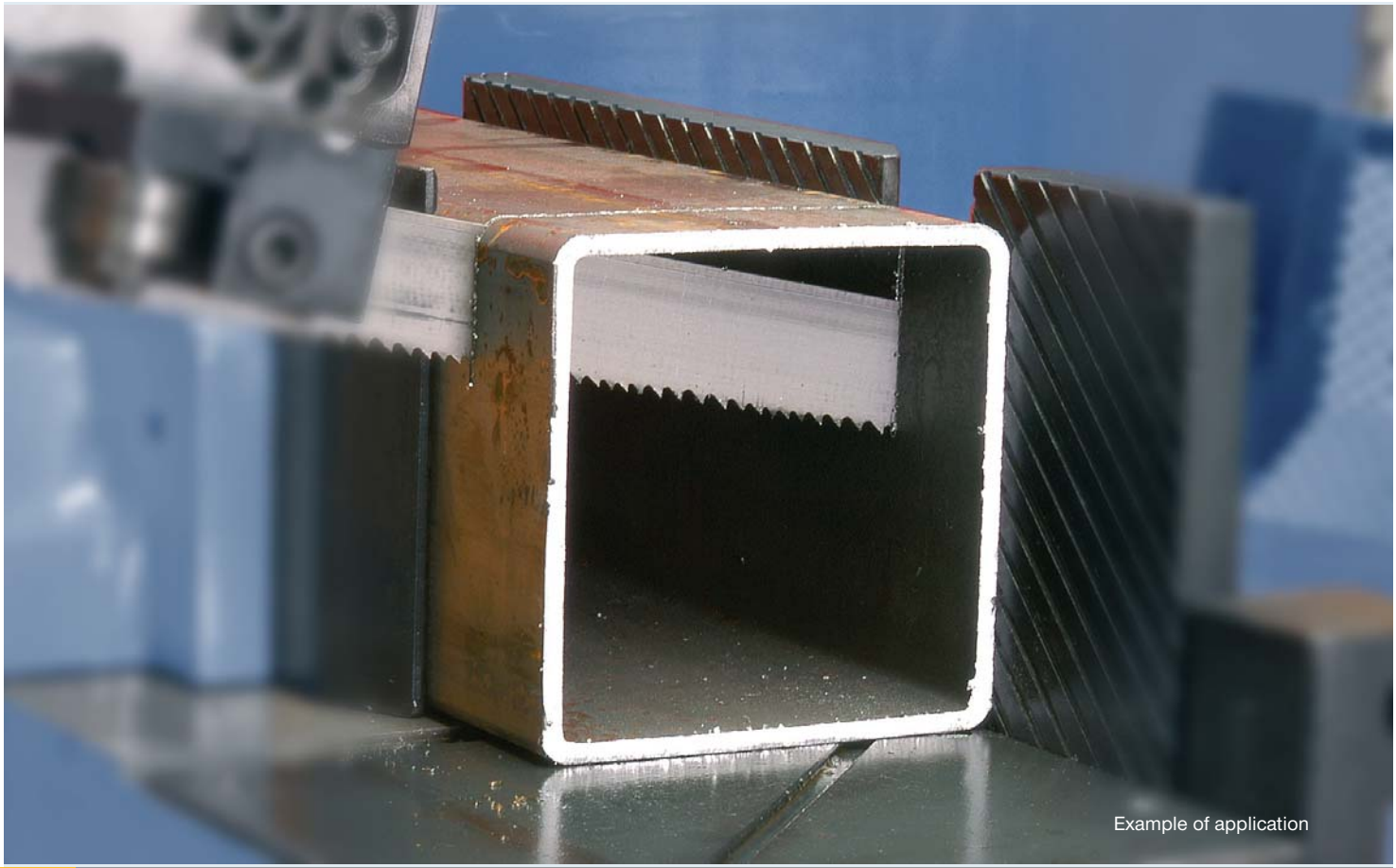
WESPA LG-SUPER

Product Group 420

Wespa LG Super (Hardback)
High-grade (carbon steel) bandsaw blades, optimized for increased cutting performance by tempering and alloying. A blade body tempered to spring hardness will ensure good cutting accuracy and increased blade life particularly in nibbling saw operations.

width x thickness		Standard Tooth (N)				teeth per inch			Hook Tooth (KL)		
mm	inch	4	6	8	10	14	18	22	3	4	6
6 x 0,65	1/4" x 0,025			■	■	■	■	■		■	■
8 x 0,65	5/16" x 0,025			■	■	■	■	■		■	■
10 x 0,65	3/8" x 0,025	■	■	■	■	■	■	■		■	■
13 x 0,65	1/2" x 0,025	■	■	■	■	■	■			■	■
16 x 0,80	5/8" x 0,032	■	■	■	■	■				■	
20 x 0,80	3/4" x 0,032	■	■	■	■	■			■	■	
25 x 0,90	1" x 0,035	■	■	■	■	■			■	■	

1 2 Fe



Example of application

Bi-Metal Bandsaw Blades

WESPA BITEC M 42

Product Group 450

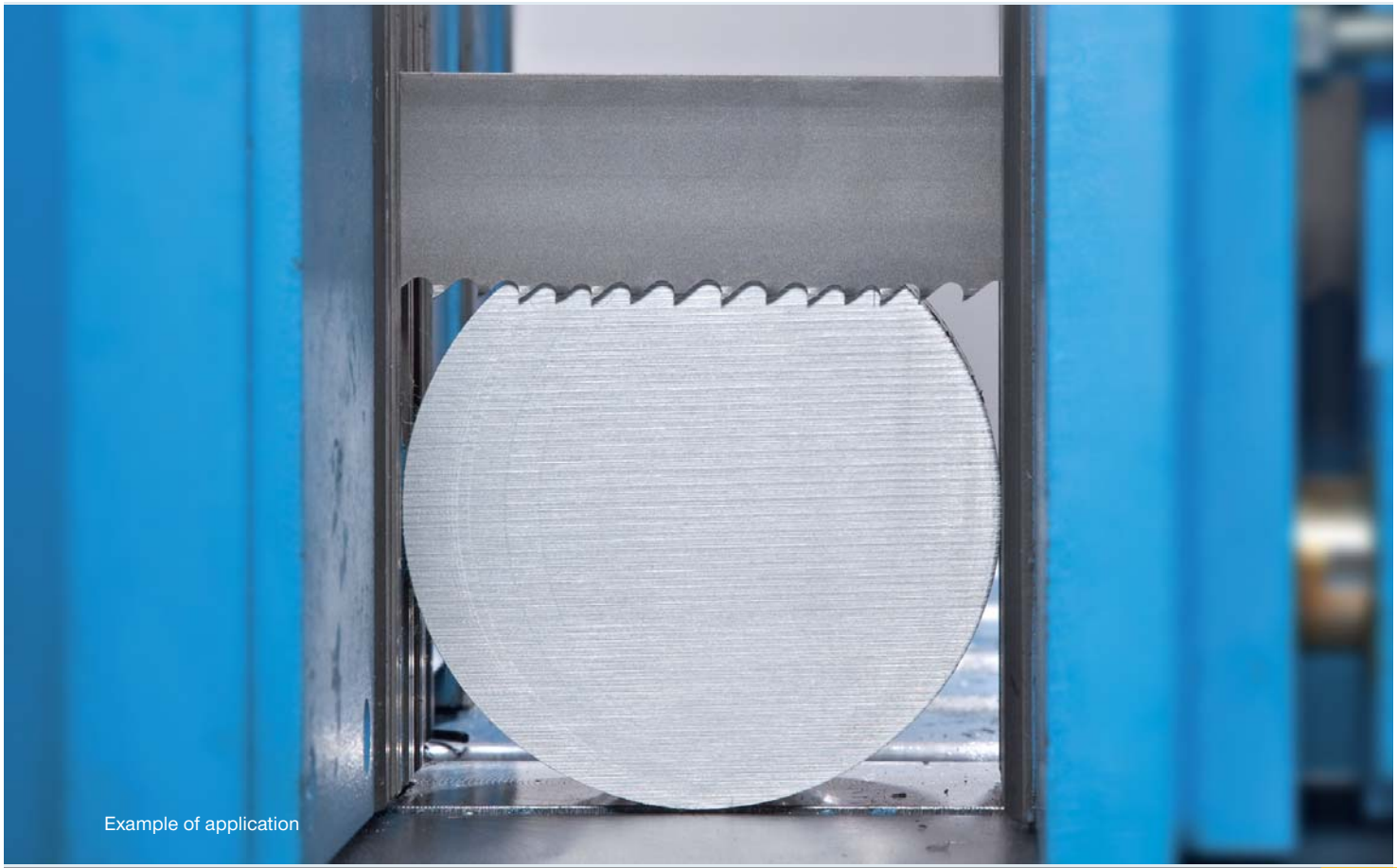
Top performance bandsaw blade, particularly wear-resistant, high cutting accuracy, in a great variety of dimensions and tooth numbers.
Particularly suitable for vibration-reduced cutting of thin or medium materials.

width x thickness

mm	inch	3/4	4	4/6	5/8	6/10	6	8/12	8	10/14	10	14	18
6 x 0,90	1/4" x 0,035									■	■	■	
10 x 0,90	3/8" x 0,035										■	■	
13 x 0,65	1/2" x 0,025					■		■		■	■	■	■
13 x 0,90	1/2" x 0,035					■		■		■		■	
20 x 0,90	3/4" x 0,035			■	■	■	■	■	■	■	■	■	
27 x 0,90	1" x 0,035	■	■	■	■	■	■	■	■	■	■	■	
34 x 1,10	1 1/4" x 0,042	■	■	■	■	■		■					
41 x 1,30	1 1/2" x 0,050	■		■	■								

1 2 3 4 5 6 7 8 11 13 14 Fe

IPC: H X S G C



Example of application

Bi-Metal Bandsaw Blades

WESPA BITEC M 42 plus

Product Group 452

Top performance bandsaw blade with positive rake angle, ensuring a high cutting performance and long service life. It is particularly wear-resistant and provides for high cutting accuracy. Available in a great variety of dimensions and tooth numbers.

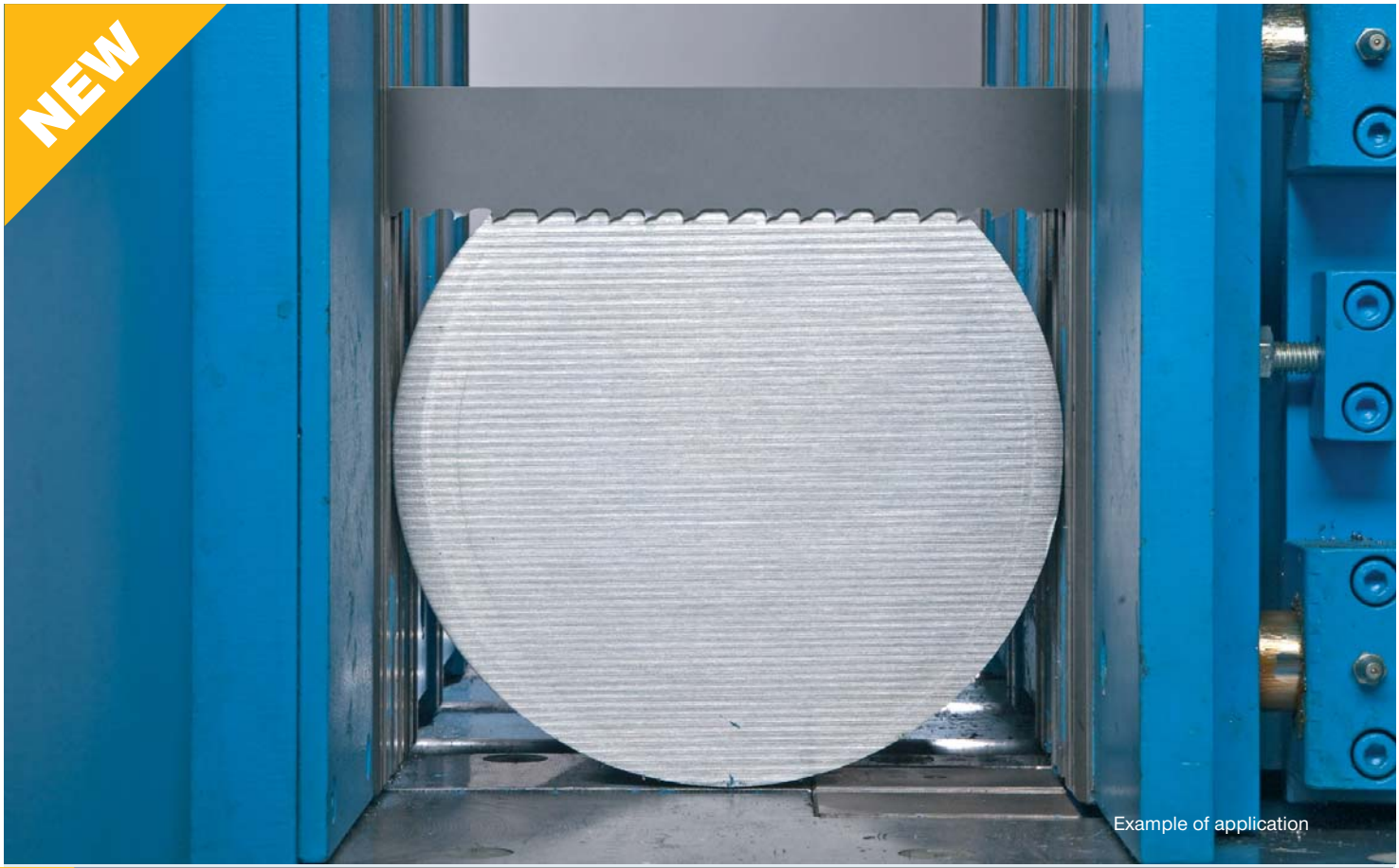
width x thickness

mm	inch	0,75/1,25	1,1/1,4	1,25	1,4/2	2/3	2	3/4	3	4/6	4	5/8	6
6 x 0,90	1/4" x 0,035												■
10 x 0,90	3/8" x 0,035												■
13 x 0,65	1/2" x 0,025										■		■
13 x 0,90	1/2" x 0,035								■		■		■
20 x 0,90	3/4" x 0,035								■	■	■	■	
27 x 0,90	1" x 0,035					■		■*	■	■*	■	■	■
34 x 1,10	1 1/4" x 0,042			■		■	■	■*	■	■*		■	
41 x 1,30	1 1/2" x 0,050			■	■	■	■	■*		■*		■	
54 x 1,30	2" x 0,050			■	■	■		■		■			
54 x 1,60	2" x 0,062	■	■	■	■	■		■		■			
67 x 1,60	2 5/8" x 0,062	■	■	■	■	■		■		■			
80 x 1,60	3 1/8" x 0,062	■	■		■	■		■					

* items in BITEC Plus 6 available

1 2 3 4 5 11 13 14 Fe

IPC: H X S G C



Bi-Metal Bandsaw Blades

WESPA SUPER SCL

Product Group 453

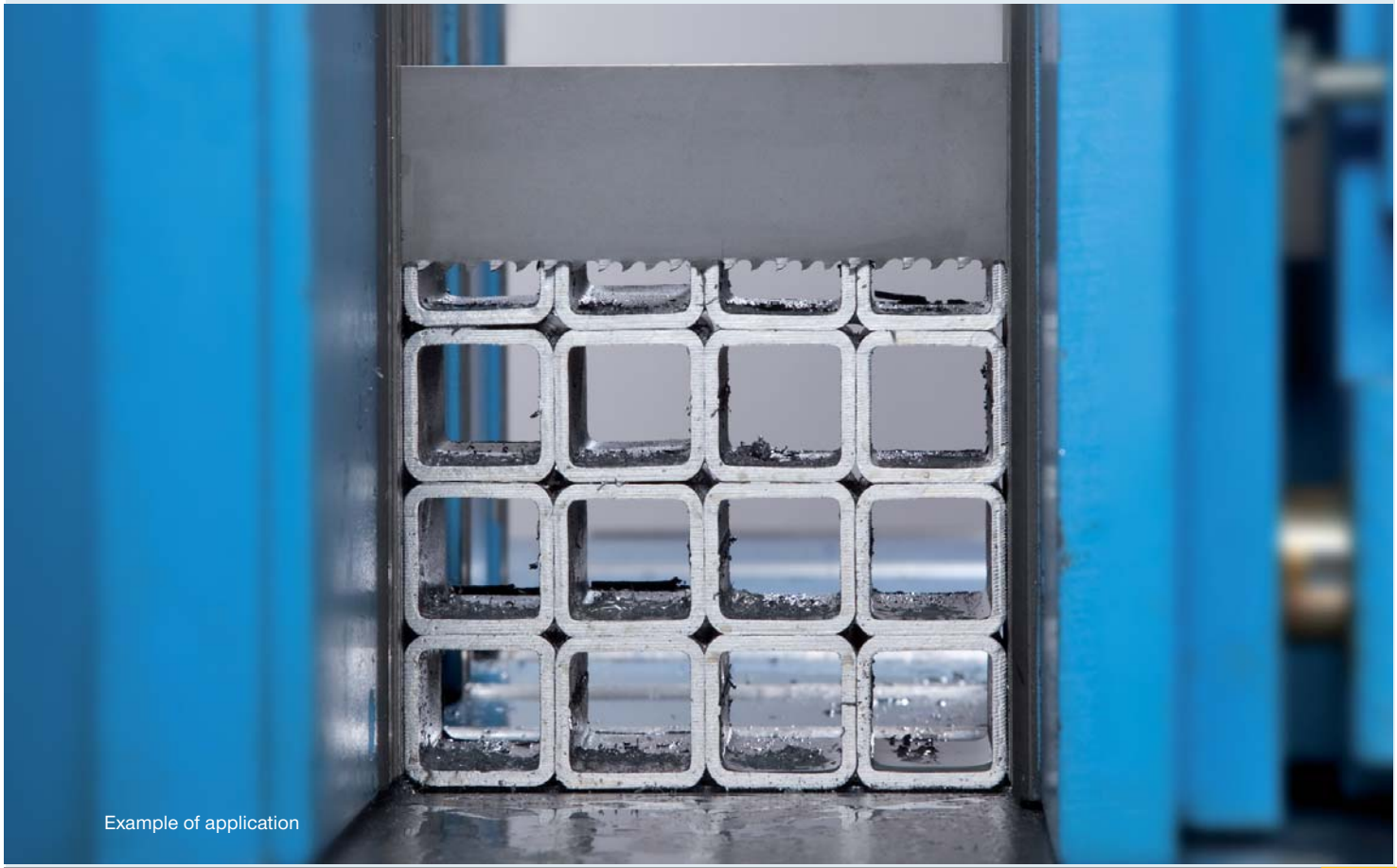
New High Performance Bi-Metal band saw blade with unique tooth geometry and extremely positive rake angle, designed to cut hard materials and stainless steels. Special features is the very smooth running. Designed for machines with constant and variable feed rate.

width x thickness		teeth per inch ▮ Combi Tooth extrem positiv			
mm	inch	0,75/1,25	1,4/2	2/3	3/4
27 x 0,90	1" x 0,035			■	■
34 x 1,10	1 1/4" x 0,042			■	■
41 x 1,30	1 1/2" x 0,050		■	■	■
54 x 1,30	2" x 0,050		■	■	
54 x 1,60	2" x 0,062		■	■	
67 x 1,60	2 5/8" x 0,062	■	■		

5 6 7 8 9 10 12

■ ●

IPC: C S G H X



Example of application

Bi-Metal Bandsaw Blades

WESPA XENOTEC

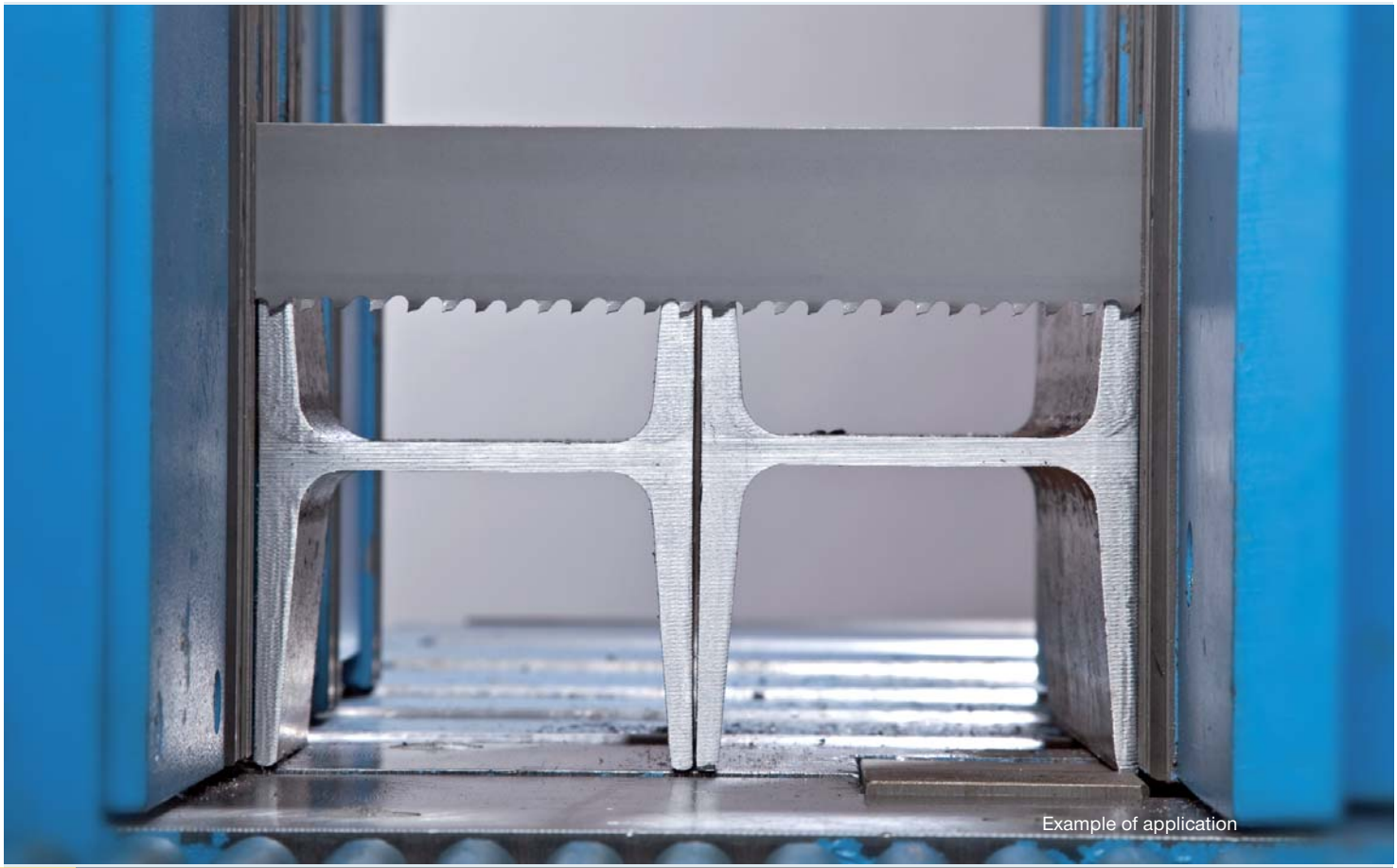
Product Group 454

An extreme innovative bandsaw blade with a complete new tooth design and rationalized tooth spacing. Special tooth geometry provides an optimum cutting performance across a wide array of applications and materials. A bandsaw blade developed particularly for cutting tubes and structural shapes in layers and bundles.

width x thickness		teeth per inch			
mm	inch	2/3	3/4	4/6	5/8
20 x 0,90	3/4" x 0,035				■
27 x 0,90	1" x 0,035		■	■	■
34 x 1,10	1 1/4" x 0,042	■	■	■	■
41 x 1,30	1 1/2" x 0,050	■	■	■	

1 2

IPC: H C


Example of application

Bi-Metal Bandsaw Blades

WESPA XTREMA

Product Group 456

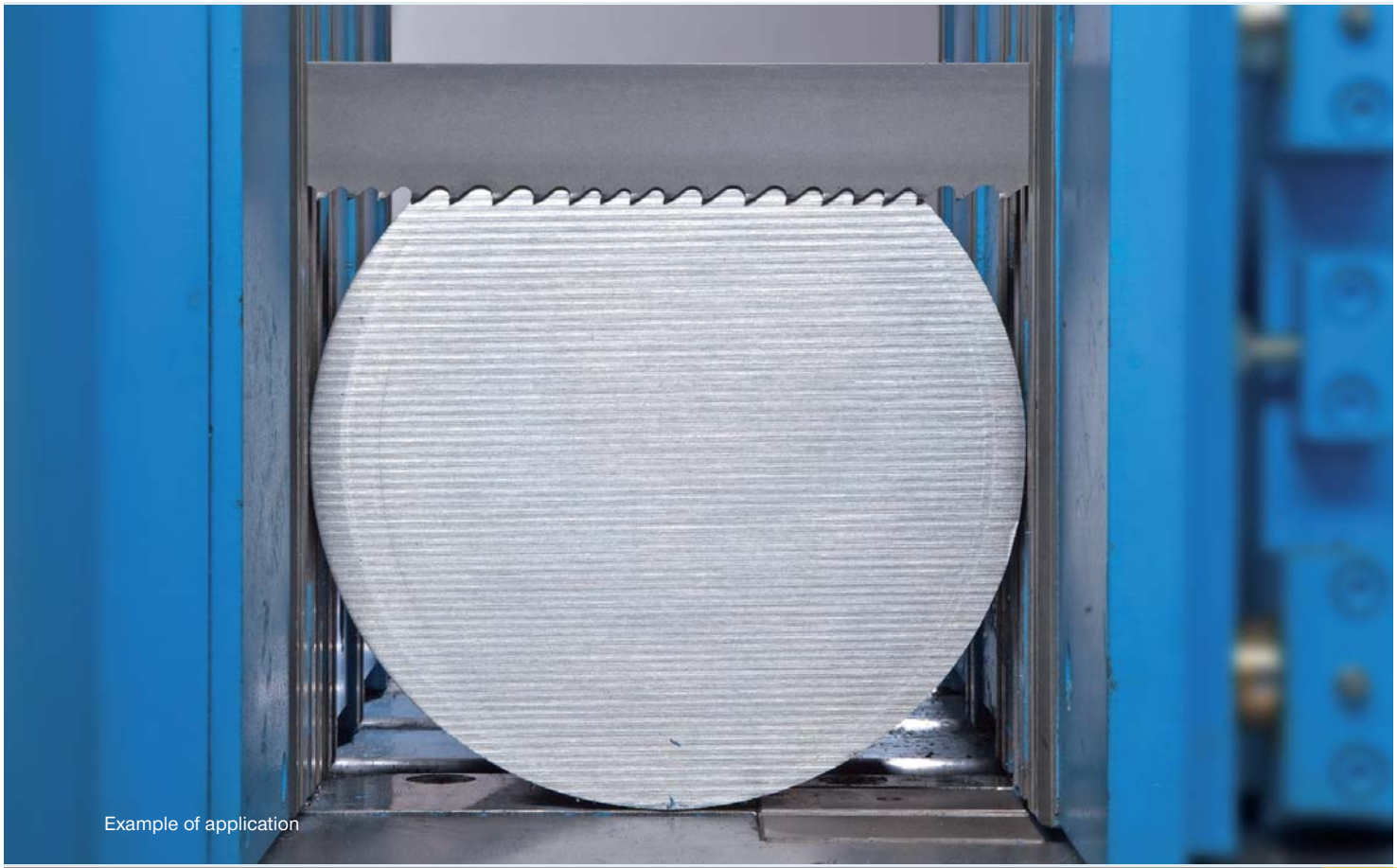
A bandsaw blade especially new designed for the cutting of profiles and beams.
Special settings avoid blade pinching during the cut.

width x thickness		teeth per inch		
mm	inch	2/3	3/4	4/6
41 x 1,30	1 1/2" x 0,050	■	■	■
54 x 1,30	2" x 0,050	■	■	■
54 x 1,60	2" x 0,062	■	■	■
67 x 1,60	2 5/8" x 0,062	■	■	

1 2

I H L

IPC: H C X



Example of application

Bi-Metal Bandsaw Blades

WESPA DUROTEC

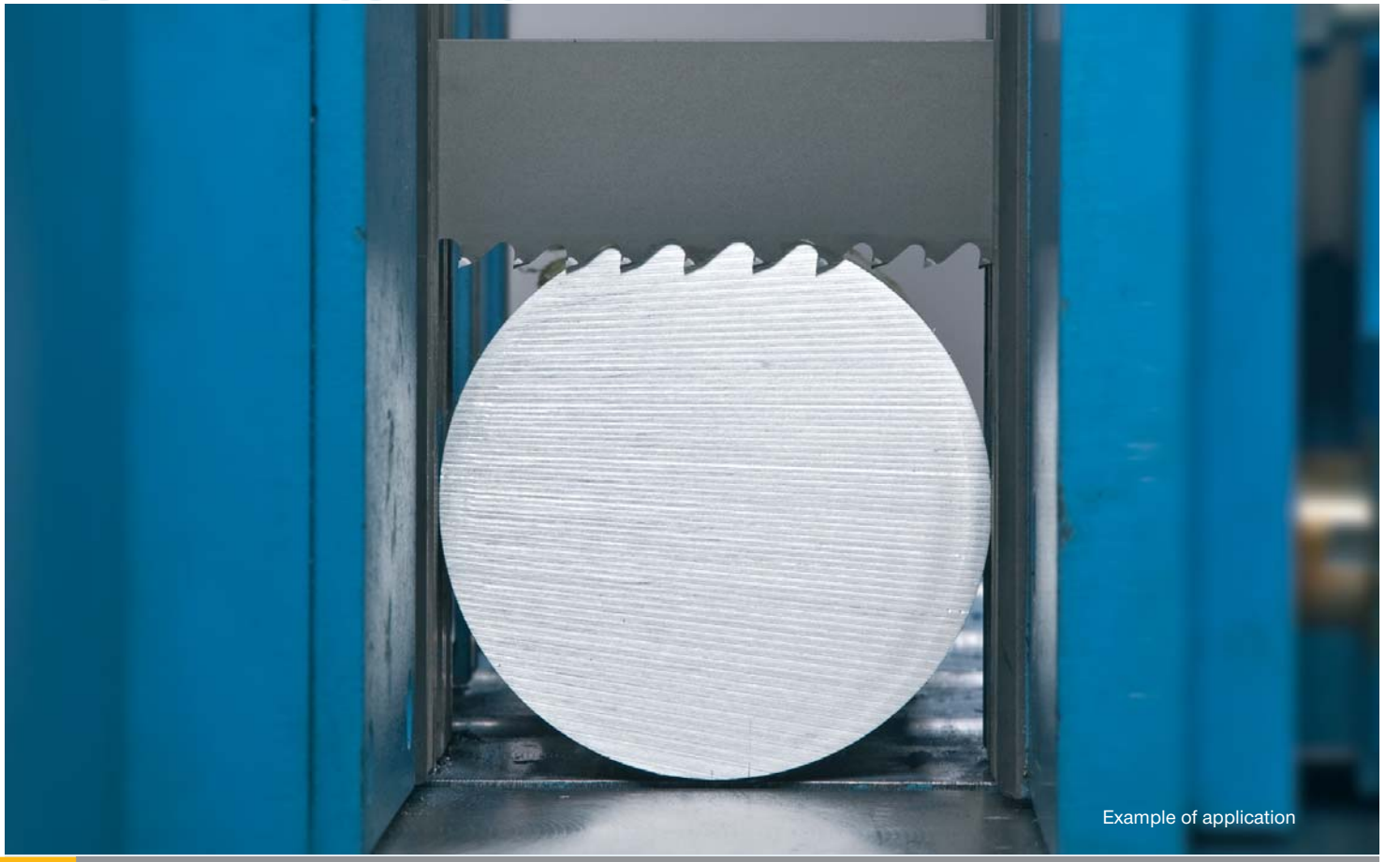
Product Group 460

Variable toothing for high performance, with tooth tips consisting of a highly wear-resistant HSS steel grade. Improving service lifetime in applications for medium and large cross sections as well as for cutting of hard metal materials that are difficult to handle.

width x thickness		teeth per inch ▮ Combi Tooth positiv				
mm	inch	0,75/1,25	1,4/2	2/3	3/4	4/6
27 x 0,90	1 " x 0,035			■	■	■
34 x 1,10	1 1/4" x 0,042			■	■	■
41 x 1,30	1 1/2" x 0,050		■	■	■	■
54 x 1,30	2 " x 0,050		■	■	■	
54 x 1,60	2 " x 0,062	■	■	■	■	
67 x 1,60	2 5/8" x 0,062	■	■	■		
80 x 1,60	3 1/8" x 0,062	■	■			

4 5 6 7 8 9 10 12

IPC: S


Example of application

Carbide-Tipped Bandsaw Blades

WESPA GALAXY HMD

Product Group 473

Carbide-tipped bandsaw blade with unset ground teeth as well as pre-cutter and after-cutter. Available variable tooth numbers for extremely clean and accurate cuts in hard materials and for cutting stock that is difficult to handle, as well as in NF foundries for large, sand casted material cross sections.

width x thickness		Combi Tooth				
mm	inch	0,9/1,1	1,4/1,8	1,9/2,1	2/3	3/4
20 x 0,90	3/4" x 0,035					■
27 x 1,10	1" x 0,035				■	■
34 x 1,10	1 1/4" x 0,042			■	■	■
41 x 1,30	1 1/2" x 0,050		■	■	■	■
54 x 1,60	2" x 0,062	■	■	■	■	■
67 x 1,60	2 5/8" x 0,062	■	■			
80 x 1,60	3 1/8" x 0,062	■				

6 7 8 9 10 12 13 S

IPC: H G C S

Example of application

Carbide-Tipped Bandsaw Blades

WESPA GALAXY HMS

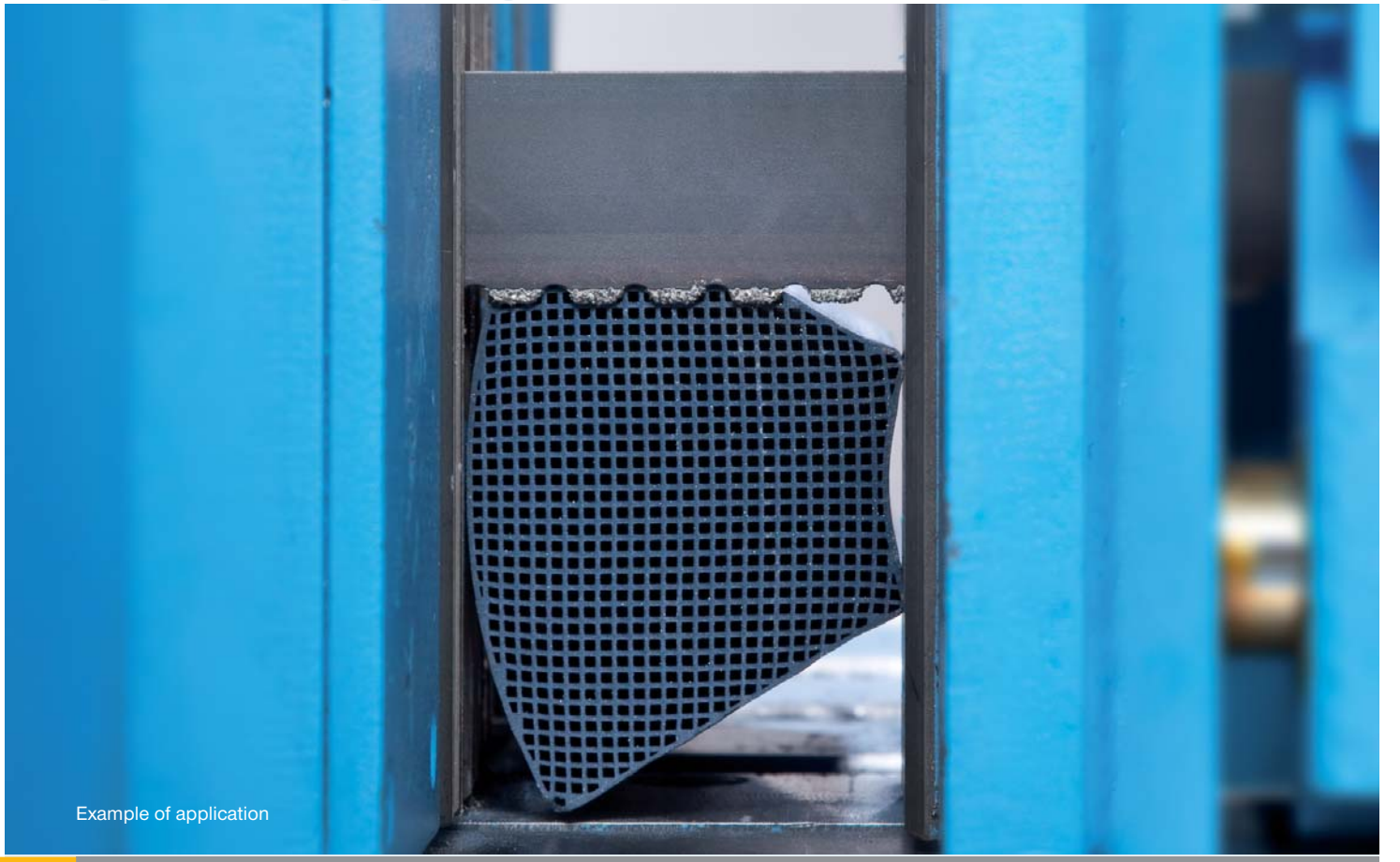
Product Group 471

Carbide-tipped bandsaw blade for sawing of hard materials and metals that are hard to handle, as well as cutting of sanded castings and abrasive material.

width x thickness		teeth per inch		
mm	inch	2	3	4
20 x 0,90	3/4" x 0,035		■	
27 x 0,90	1" x 0,035		■	■
34 x 1,10	1 1/4" x 0,042		■	
41 x 1,30	1 1/2" x 0,050	■	■	
54 x 1,60	2" x 0,062	■		
67 x 1,60	2 5/8" x 0,062	■		

11 13 14 S Fe

IPC: X



Example of application

Carbide Grit Coated Bandsaw Blades

WESPA SAPHIR

Product Group 480 U, 480 D

High-performance bandsaw blades for cutting of abrasive materials and bonded materials that cannot be cut easily by normal toothed bandsaw blades, for example: vehicle tires, graphite, brake linings, glass-fiber reinforced plastics, cables and ceramic tiles.
These blades consist of a cutting edge coated with carbide particles on a spring-hard end, fatigue-resistant blade body which is continuous or intermittent for chip removal.
Other versions of items available by request.

Wespa Saphir U: Carbide grit coated bandsaw blade with intermittent cutting edge (chipping space), for cutting stock of medium and large dimensions.

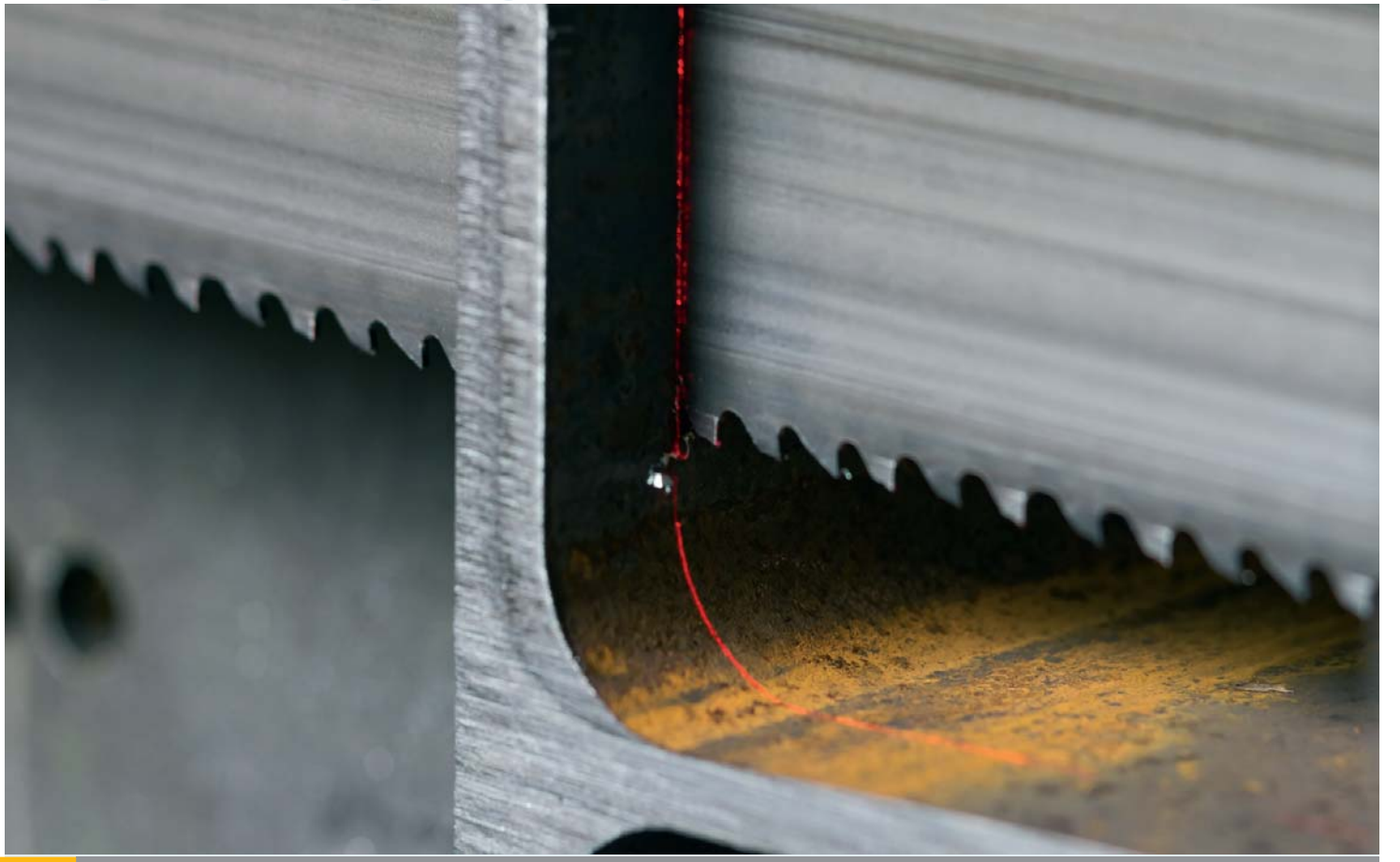
Wespa Saphir D: Carbide grit coated bandsaw blade showing a continuously coated cutting edge without chipping spaces, for cutting stock of small cross sections, thin-walled parts or fiber-reinforced materials.

width x thickness		intermittent	continuous
mm	**inch**	**medium**	**medium**
20 x 0,80	3/4" x 0,032	■	■
25 x 0,90	1" x 0,035	■	■
32 x 1,10	1 1/4" x 0,042	■	■
38 x 1,10	1 1/2" x 0,042	■	■

Example of application

Power hacksaws, hand hacksaws

Power hacksaws and hand hacksaws you can find now on our accessories catalog.



Value Added Cutting®

VALUE ADDED CUTTING®

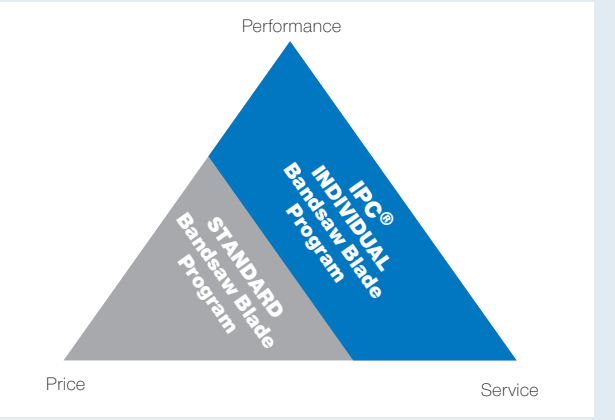
WESPA supplies custom-made solutions for all conceivable saw applications which increase the efficiency of production processes.

Demanding cutting of all materials requires innovative and flexible saw designs. The high quality of your product begins with the first cut. The trust that customers place in us when deciding upon our products pays for itself within the shortest possible time.

Added value for all industries

We consider our products and services to be a part of the added value chains of our customers, making a considerable contribution to the efficiency of the entire production process, regardless of whether it concerns saw bands, improvement of saw efficiency, supply and maintenance services, long-term partnerships or training.

An integrated approach, at the center of which is the added value of a partnership with WESPA.



This is the concept we have imparted to our claim: VALUE ADDED CUTTING®.

Those interested in learning more can do so at the WESPA website: www.individual-cutting.de

Technical Information

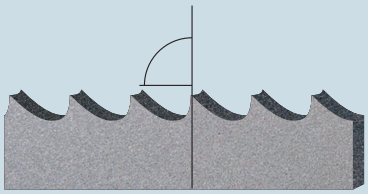
Additionally WESPA offers as follows:

- Solution of application problems
- Wide product range
- Suitable bandsaw blades
- Optimizing of sawing processes
- Advisory service by phone or suburb
- Trial cuts / samples
- Worldwide customer advisory service

Tooth Styles

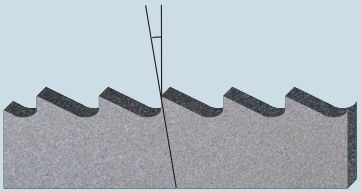
To achieve optimum cutting performance, apart from steel grade, the number of teeth as well as the shape of the cutting edge is of great importance.
The geometry of the cutting edge and of the gullet are dependent on the material to be cut and will essentially influence the cutting behavior of a saw. As a solution to your cutting requirements, we are offering you four different tooth styles:

Standard Tooth N



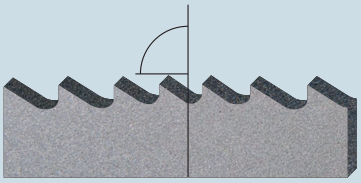
Rake angle 0°: completely rounded gullet.
For universal applications to cut small to medium solid cross sections, tubes, plates, contour sawing operations.

Hook Tooth (KL)

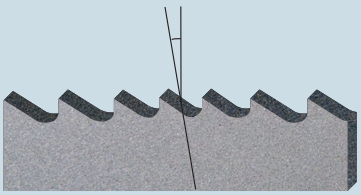


Positive rake angle: with rounded gullet.
Advantageous for cutting materials producing long chips, such as Non Ferrous metals, steel grades of low carbon content, materials of large cross sections, metallic materials with a tendency to strain harden undernormal cutting operations.

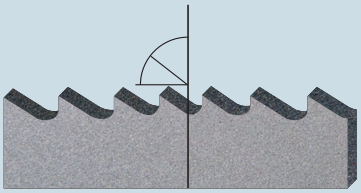
Variable Tooth Pitch



No.1



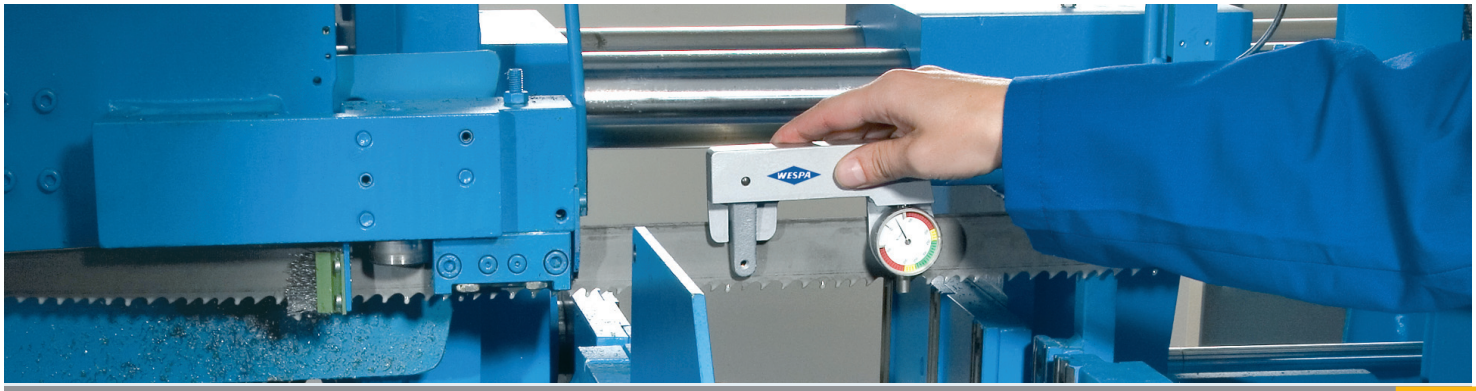
No.2



No.3

- Toothing with 0° [No.1]
- positive rake angle [No.2]
- or extreme positive rake angle [No.3]:

Regular intermittent tooth sequences where the teeth within a group show different tooth pitch, i.e. greater height. Excessive vibrations will be reduced, with apositive effect on noise level, cutting surface quality, and service life.
Applications for this toothing pattern are universal – ranging from cutting of layers and bundles up to large solid cross sections of a great variety of metallic materials.



Band Tension

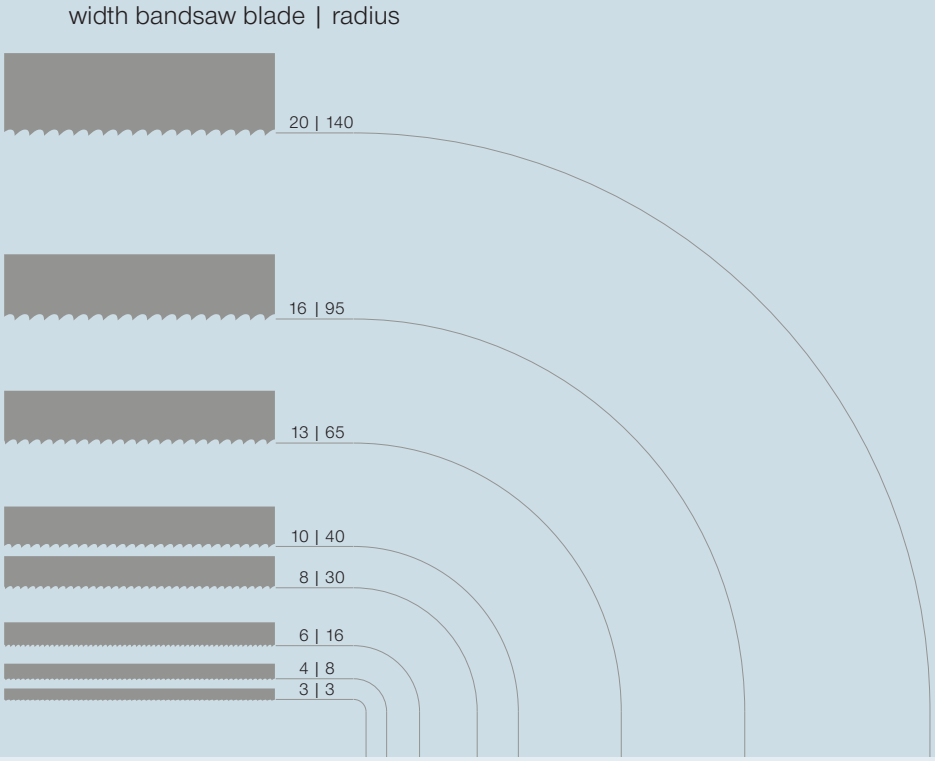
Proper blade tension is required to obtain long life and accurate cutting.

By using the WESPA blade tension gauge you can measure the blade tension applied by your band saw machine and adjust it to the proper level.

For WESPA - band saw blades we recommend a blade tension of 250-300 N/mm².

Blade brakeage due to excessive blade tension or cut deviation due to insufficient blade tension can be avoided by using the correct blade tension.

Table of Radiuses



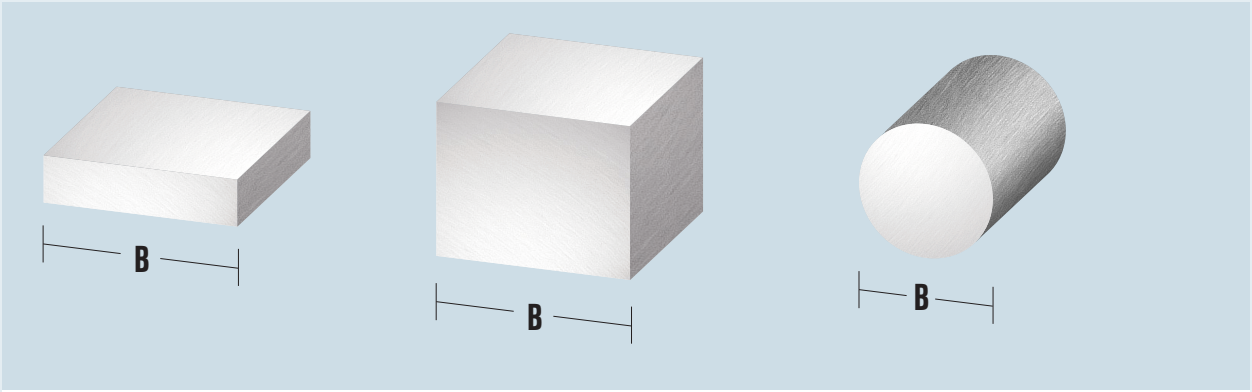
For contour sawing, the smallest radius to be sawed depends on the width of the bandsaw blade. The blade width is to be measured from the tooth tips to the back edge.

The graph indicates which maximum bandsaw blade width is to be selected for the smallest radius to be cut.

Recommendations for tooth pitch and tooth styles

Consistently Toothing Material cross section (B)	Tooth pitch with tooth style
bis 15 mm	14 ZpZ. N
15 - 30 mm	10 ZpZ. N
30 - 50 mm	8 ZpZ. N
50 - 80 mm	6 ZpZ. N | KL
80 - 120 mm	4 ZpZ. KL
120 - 200 mm	3 ZpZ. KL
200 - 400 mm	2 ZpZ. KL
400 - 800 mm	1,25 ZpZ. KL
> 800 mm	0,75 ZpZ. KL

Variable Toothing Material cross section (B)	Tooth pitch with tooth style
bis 30 mm	10/14 ZpZ.
20 - 50 mm	8/12 ZpZ.
25 - 70 mm	6/10 ZpZ.
35 - 90 mm	5/8 ZpZ.
50 - 100 mm	4/6 ZpZ. pos.
80 - 150 mm	3/4 ZpZ. pos.
120 - 350 mm	2/3 ZpZ. pos.
250 - 600 mm	1,4/2 ZpZ. pos.
> 500 mm	0,75 - 1,25 ZpZ. pos.

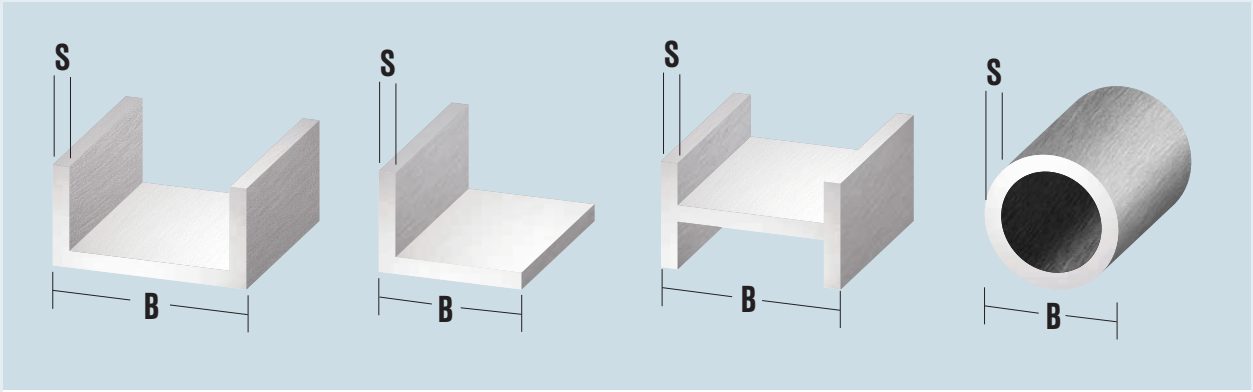


Correct tooth pitch

- Selecting the correct tooth pitch is important for optimized cutting results.
- The tooth pitch results from the engaged length of bandsaw blade in the material.
- If the tooth pitch is too small, (irregular) cutting may result. Chips may clog the cutting length, forcing the bandsaw blade from its cutting line.
- If the tooth pitch is too large, teeth may break out because the cutting pressure acting upon individual teeth becomes too high.
- At least 3 teeth are recommended to be engaged to achieve an optimum result.

Sawing of tubes and structural shapes

Wall thickness (S) in mm / Teeth per inch Diameter (B)	20	40	60	80	100	120	150	200	300	500	750	1000
2	22	22	18	18	14	14	10/14	10/14	8/12	6/10	5/8	5/8
3	22	18	14	14	10/14	10/14	8/12	8/12	6/10	5/8	4/6 0°	4/6 0°
4	18	10/14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	4/6 0°	4/6 0°	4/6 0°
5	18	10/14	10/14	8/12	6/10	6/10	6/10	5/8	4/6 0°	4/6 0°	4/6 0°	3/4 0°
6	14	8/12	8/12	8/12	6/10	6/10	5/8	5/8	4/6 0°	4/6 0°	3/4 0°	3/4 0°
8		6/10	6/10	6/10	5/8	5/8	5/8	4/6 0°	4/6 0°	3/4 0°	3/4 0°	3/4 0°
10		6/10	6/10	5/8	5/8	5/8	4/6 0°	4/6 0°	4/6 0°	3/4 0°	3/4 0°	3/4 0°
12		5/8	5/8	5/8	4/6 pos	4/6 pos	4/6 pos	4/6 pos	3/4 pos	3/4 pos	2/3 pos	2/3 pos
15			5/8	4/6 pos	4/6 pos	4/6 pos	4/6 pos	3/4 pos	3/4 pos	2/3 pos	2/3 pos	2/3 pos
20			4/6 pos	4/6 pos	4/6 pos	3/4 pos	3/4 pos	3/4 pos	2/3 pos	2/3 pos	2/3 pos	2/3 pos
30				3/4 pos	3/4 pos	3/4 pos	3/4 pos	2/3 pos	2/3 pos	2/3 pos	1,4/2 pos	1,4/2 pos
50						3/4 pos	2/3 pos	2/3 pos	2/3 pos	1,4/2 pos	1,4/2 pos	1,4/2 pos
75								2/3 pos	1,4/2 pos	1,4/2 pos	1,4/2 pos	0,75/1,25 pos
100									1,4/2 pos	0,75/1,25 pos	0,75/1,25 pos	0,75/1,25 pos
150										0,75/1,25 pos	0,75/1,25 pos	0,75/1,25 pos
200										0,75/1,25 pos	0,75/1,25 pos	0,75/1,25 pos



If you have two or more tubes side by side lying to be separated, then you consult the table under consideration of the double wall thickness.

Factors for the right choice of the tooth pitch

- Saws of tubes and profiles in bundles
- Saws of tubes and profiles in the single cut

General advice for band saws

Band saw maschines

Check regularly:

- function of the chip brush
- function + concentration of the coolant
- wear + paralleliam of band saw guide
- blade tension
- blade speed

Coolant/ cutting fluid

The coolant lubricates, cools and transports the chips out of the cut.

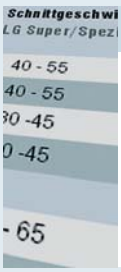
What is important:

- use a cutting fluid that is recommended for the intended operation
- use the recommended concentration of cutting fluid
- check that the coolant is applied at the correct pressure

Work piece

What is important:

- make sure the work piece is clamped securely and can not vibrate or rotate
- do not use work pieces that are damaged, twisted or severely deformed
- the closer the guide of the band saw is to the work piece, the more precise the cut will be



Observe start up programme

What is important:

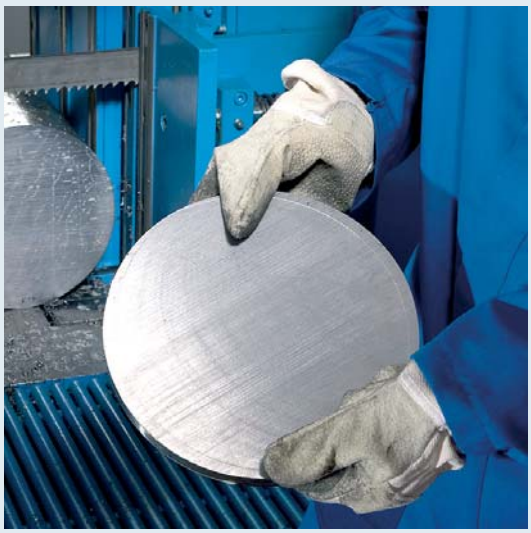
- follow our stat-up advice
- use the recommended cutting parameters to obtain the best service life

Optimal chip formation

- very fine and powdery chips indicate insufficient cutting precssure
- thick, highly compressed and blue tarnisch chips indicate overtaxing of the saw band
- loosely rolled chips are a sign of good cutting conditions

Optimal chip formation with customized bandsaw blades IPC Option C

- Optimum cutting performance with colored (gold to blue) chips
- Fine chips indicate insufficient cutting pressure.
  It comes to early worn out of the teeth and high noises.
  Increase cutting pressure and feed rates.



WESPA Standard bandsaw blades:

Break-In-Process increases the service life of conventional bandsaw blades.

- Sharp cutting edges with extremely small edge radii are required for high performance blades.
- To get the best blade life we recommend that the blade be „broken in".
- Determine the proper cutting speed (m/min) and feed (mm/min) based on the material and dimension of the work piece to be cut.
- It is important to only operate the new saw blade at about 50% of the determined feed during the break-in cuts. This is done to avoid damaging the extremely sharp blade teeth by micro-chipping due to excessive chip thickness.
- Sometimess new saw blades are prone to vibrations or oscillating noises. If this happens you may reduce the cutting speed.
- With small work piece dimensions, 300-500 cm^2 of the work piece cutting material should be cut during break in. When large work piece dimensions are being cut we recommend a break in period of 15 min. After the start-up slowly increase the feed to the previously determined value.

WESPA Individual bandsaw blades (IPC):

Without break-in-process!

- No break-in-process necessary, immediately full cutting performance.

  We recommended with new bandsaw blade and minimum lubrication 5 laps before you start the regular cutting process.

Bandsaw blade dimensions

Endless Bandsaw Blades

AMADA

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
H-250 SA, HA-250, HDA-250, HFA-250	3505 x 27 x 0,90
HA 250 W, HFA-250 W	3505 x 34 x 1,10
HA-250 II, HA-253	3505 x 34 x 1,10
CRH-300 S, CHA-300 S	3660 x 27 x 0,90
HK 400	3885 x 34 x 1,10
HFA-330	4115 x 34 x 1,10
HA-400, HFA-400	4570 x 34 x 1,10
HA-400 W	4570 x 41 x 1,30
H-450 H	4670 x 41 x 1,30
VM-1200, VM-2500	4670 x 41 x 1,30
CTB 400	4715 x 41 x 1,30
HFA-400 S, HFA-400 CNC	4995 x 41 x 1,30
HFA-400 LUL	4995 x 41 x 1,30
H-650 H, H-650 HD	5040 x 41 x 1,30
HA-500, HFA-500	5300 x 41 x 1,30
CTB-400 / 700 W	5630 x 41 x 1,30
HK-800, HKA-800	6650 x 41 x 1,30
HFA-500 S, HFA 500 CNC	5820 x 54 x 1,60
optional	5820 x 54 x 1,30
HBK 6050	5890 x 54 x 1,30
VM-3800	6430 x 54 x 1,60
HK-700 FR	6460 x 54 x 1,30
HK-800, HKA-800	6650 x 41 x 1,30
H-600, H-700	7600 x 54 x 1,60
HA-700, HFA-700	7600 x 54 x 1,60
H-900 HD	8000 x 54 x 1,60
HFA-700 II	8000 x 54 x 1,60
H-1080	8800 x 67 x 1,60
H-1080 /1100 W	9700 x 80 x 1,60
HFA 1000	9700 x 80 x 1,60
H 1300	11880 x 67 x 1,60
H 1600	14425 x 80 x 1,60
H-2000	17600 x 125 x 2,00
PCSAW 330	4115 x 41 x 0,90
PCSAW 430AX	6100 x 54 x 1,60
PCSAW 430X	6100 x 54 x 1,60
PCSAW 530AX	7000 x 67 x 1,60
PCSAW 530X	7000 x 67 x 1,60
PCSAW 700	8300 x 67 x 1,60

BAUER

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
VBS 320	3000 x 20 x 0,9
S 280 G	3000 x 27 x 0,9
S 280 DG	3000 x 27 x 0,9
HS 280 GZA	3000 x 27 x 0,9
HS 280 dGZA	3000 x 27 x 0,9
400 V / 400 VS	3000 x 6-20
VG 320	3400 x 27 x 0,9
VG 320 ST	3400 x 27 x 0,9
VG 320 ZA-2	3400 x 27 x 0,9
HBS 450-1	3430 x 6-25
HBS 450-4	3430 x 6-25
HBS 450 S-1	3430 x 6-25
HBS 450 S-4	3430 x 6-25
S 320	3660 x 27 x 0,9
HS 260 ZA	3660 x 27 x 0,9
S 320 L	3900 x 27 x 0,9
S 320 DG	3900 x 27 x 0,9
HS 320 ZA	3900 x 34 x 1,1
HS 310 A	3900 x 34 x 1,1
500 V / 500 VS	3900 x 6-25
HBS 550 S-1	3980 x 6-25
HBS 550 S-4	3980 x 6-25
SA 320	4150 x 34 x 1,1
VG 450	4150 x 34 x 1,1
SA 320 ZA	4150 x 34 x 1,1
VG 450 ST	4150 x 34 x 1,1
VG 450 ZA-2	4150 x 34 x 1,1

continuation BAUER

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
S 380	4450 x 34 x 1,1
S 380 G	4450 x 34 x 1,1
VG 450 L	4450 x 34 x 1,1
VG 450 L-ST	4450 x 34 x 1,1
VG 450 L-ST-X	4450 x 34 x 1,1
VG 450 L-ZA-2	4450 x 34 x 1,1
650 V	4800 x 27 x 0,9
1000 V	5000 x 27 x 0,9
S 500	5200 x 34 x 1,1
SA 430	5200 x 41 x 1,3
SA 430 ZA	5200 x 41 x 1,3
VG 520	5640 x 41 x 1,3
SA 550	6380 x 41 x 1,3
SA 550 ZA	6380 x 41 x 1,3

BEHRINGER

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
SLB 230 G, SLB 230 DG SLB 230 DG-Halbautomat	2700 x 27 x 0,90
SLB 240 A, SLB 240 A/G, SLB 240 G-Halbautomat	3180 x 27 x 0,90
HBP 220, HBP 220 A	3720 x 27 x 0,90
optional	3720 x 34 x 1,10
HBP 260 A	4100 x 34 x 1,10
HBE261A / HBE321A	4440 x 34 x 1,10
HBP 263 G, HBP 260/403 G, HBP 263, HBP 263 A, HBP 263 A/G	4640 x 34 x 1,10
HBP 303, HBP 303 A	4640 x 41 x 1,30
HBP 320, HBP 320 A, HBP 340 HBP 340 A, HBP 340 G	4860 x 34 x 1,10
HBP 313 G, HBP 310/523 G, HBP 310/403 GA	5000 x 34 x 1,10
BP 360, HBP 360 A, HBP 360 G	5400 x 41 x 1,30
LPS 40-2, LPS 40-3, LPS 40-4, LPS 40 T	5400 x 41 x 1,30
HBE411A / HBE511A	5730 x 41 x 1,30
HBP 340-700 G, HBP 400, HBP 400 A, HBP 413, HBP 413 A, HBP 420,HBP 420 A	5800 x 41 x 1,30
LPS 40-6	5800 x 41 x 1,30
HBP 430, HBP 430 A, HBP 430 G	5800 x 54 x 1,30
LPS 60-2, LPS 40-3, LPS 40-4	5800 x 54 x 1,30
HBBS65/40-2F3, HBBS65/40-2F4, HBBS65/40-2F6	6000 x 54 x 1,60
HBP 360/704 G	6300 x 41 x 1,30
HBP 410/723, G HBP 420/723 G	6300 x 41 x 1,30
HBM 370 A	6600 x 34 x 1,10
optional	6600 x 41 x 1,30
HBM 440 A	6600 x 34 x 1,10
optional	6700 x 54 x 1,30
HBP 410/923 G	6700 x 41 x 1,30
HBP 500, HBP 500 A	6900 x 41 x 1,30
HBBS 65/80-2F3 HBBS 65/80-2F4, HBBS 65/80-2F6	6900 x 67 x 1,60
HBM 440 ALU	7200 x 34 x 1,10
HBP 430/854 G	7200 x 54 x 1,30
HBP 530, HBP 530 A, HBP 530/700 G	7200 x 54 x 1,60
HBBS 110/60-3F3 HBBS 110/60-3F4, HBBS 110/60-3F6	7200 x 67 x 1,60
HBP 530 /4S, HBP 530 A/4S, HBP 530/704 G, HBP 530A 1000, HBP 530A /4 HM	7300 x 54 x 1,60
HBP 540A	7500 x 54 x 1,60
optional	7500 x 41 x 1,30
HBM 540 ALU	7500 x 34 x 1,10
HBBS 110/100-3F3, HBBS 110/100-3F4, HBBS 110/100-3F6	7900 x 67 x 1,60
HBP 530/1104 G	8800 x 54 x 1,60
HBP 650, HBP 650 A, HBP 650/1050, HBP 650/1050 A, HBP 800, HBP 800 A, HBP 800/1050, HBP 800/1050 A, HBP 650/850 A, HBP 800/850 A	8800 x 67 x 1,60
HBBS 160/80-3F3, HBBS 160/80-3F4 , HBBS 160/80-3F6	9400 x 67 x 1,60

continuation BEHRINGER

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
HBP 800/1204, HBP 800/1004, HBP 800/1004 G	10000 x 67 x 1,60
HBP 800/1304 G	10600 x 67 x 1,60
HBP 1080, HBP 1080 A, HBP 1080 T, HBP 1300, HBP 1300 A, HBP 1300 T	12300 x 80 x 1,60
HBP 1300	12300 x 80 x 1,60
HBP 1080/1700 A, HBP 1300/ 1700	13100 x 80 x 1,60
HBP 1080-1700 , HBP 1080-1700 A, HBP 1080-1700 T, HBP 1300-1700, HBP 1300-1700 T,	13100 x 80 x 1,60
HBP 1300 Gantry	13360 x 80 x 1,60
HBP 1080/2100, HBP 1080/2100 A, HBP 1300/2100	13900 x 80 x 1,60
HBP 1800 Gantry	14150 x 80 x 1,60
HBP 1800 T	14300 x 80 x 1,60

BERG & SCHMID

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
MBS 85	1335 x 13 x 0,65
TBS 102	1440 x 13 x 0,65
MBS 130/150 / TBS 150	1735 x 13 x 0,90
MBS 160	2000 x 20 x 0,90
MBS 170	2140 x 20 x 0,90
MBS 210, manuell, AutoCut	2465 x 20 x 0,90
GBS 220 Basic, manuell, AutoCut	2530 x 20 x 0,90
GBS 230 Eco, GBS 230 Super jew. manuell, AutoCut, Halb-, Vollautomat	2765 x 27 x 0,90
GBS 280/305 AutoCut, Halbautomat, Vollautomat,	3375 x 27 x 0,90
SBS 260 VA-I	3920 x 34 x 1,10
SBS 300 VA-I	3920 x 34 x 1,10
DGS 350/450, Halbautomat	3930 x 27 x 0,90
VGS 500 Halbautomat	4140 x 34 x 1,10
SBS 320 Vollautomat	4240 x 34 x 1,10
SBS 330 VA-I	4570 x 34 x 1,10
SBS 410 Vollautomat	4770 x 41 x 1,30
SBS 420 VA-I	4880 x 41 x 1,30
DGS 500/600, Halbautomat	5320 x 34 x 1,10
SBS 460 VA-I	5450 x 41 x 1,30
SBS 520 Vollautomat	5815 x 54 x 1,30
SBS 550 VA-I	5980 x 41 x 1,30
x-tech 320 VA CNC	5095 x 34 x 1,10
X-tech 410	6175 x 41 x 1,30
x-tech 630 VA CNC	8250 x 54 x 1,60

BIANCO

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
280M	2450 x 27 x 0,90
330M	3010 x 27 x 0,90
370M	3120 x 27 x 0,90
420M	3270 x 27 x 0,90
280 M DS	2450 x 27 x 0,90
280 SA 60°	2450 x 27 x 0,90
330 SA 60°	3010 x 27 x 0,90
370 SA 60°	3120 x 27 x 0,90
420 SA 60°	3270 x 27 x 0,90
370 SA DS	3120 x 27 x 0,90
370 SA DS MS	3120 x 27 x 0,90
420 SA DS MS	3270 x 27 x 0,90
330 A 60°	3010 x 27 x 0,90
370 A 60°	3120 x 27 x 0,90
370 A 60° CNC	3120 x 27 x 0,90
420 A 60°	3270 x 27 x 0,90
370 AF	3120 x 27 x 0,90
370 AF CNC	3120 x 27 x 0,90
370 A DS CNC	3120 x 27 x 0,90

continuation BIANCO

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
370 A DS CNC 1R	3120 x 27 x 0,90
370 A DS CNC 3R	3120 x 27 x 0,90
370 A DS CNC 1R C 6000 D 120	3120 x 27 x 0,90
370 A DS CNC 3R C 6000 D 120	3120 x 27 x 0,90
370 A DS CNC 1R CL 6000 D 120	3120 x 27 x 0,90
370 A DS CNC 3R CL 6000 D 120	3120 x 27 x 0,90
370 AF CNC 1 CL 6000 D 120	3120 x 27 x 0,90
370 A 60° CNC 1C 6000 D 120	3120 x 27 x 0,90
330 A 60° CNC	3820 x 27 x 0,90

BTM

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
51.31 SA 90°	4750 x 34 x 1,10
61.41 SA 90°	5200 x 34 x 1,10
71.51 SA 90°	5800 x 41 x 1,30
51.31 AF CNC/800	4750 x 34 x 1,10
51.31 AF CNC/3000	4750 x 34 x 1,10
61.41 AF CNC/800	5200 x 34 x 1,10
61.41 AF CNC/3000	5200 x 34 x 1,10
71.51 AF CNC/800	5800 x 41 x 1,30
71.51 AF CNC/3000	5800 x 41 x 1,30
125 SA 27	5760 x 27 x 0,90
125 SA 34	6610 x 34 x 1,10
51.31 SA DAS	4750 x 34 x 1,10
61.41 SA DS	5200 x 34 x 1,10
71.51 SA DS	5800 x 41 x 1,30
51.31 A DS CNC/3000	4750 x 34 x 1,10
61.41 A DS CNC/3000	5200 x 34 x 1,10
71.51 A DS CNC/3000	5800 x 41 x 1,30
50.33 SA 60°	4750 x 34 x 1,10
50.33 SA DS	4920 x 34 x 1,10
50.33 CNC 90° CC 800	4750 x 34 x 1,10
50.33 CNC 90° CC 3000	4750 x 34 x 1,10
50.33 CNC 60° CC 800	4750 x 34 x 1,10
50.33 CNC 60° CC 3000	4750 x 34 x 1,10
320 CNC	5300 x 34 x 1,10
420 CNC	6300 x 41 x 1,30
600 SA	8020 x 54 x 1,60
600 CNC	8020 x 54 x 1,60
720 SA	9360 x 67 x 1,60
720 CNC	9360 x 67 x 1,60
860 SA	9640 x 67 x 1,60
860 CNC	9640 x 67 x 1,60
1.000 CNC	12030 x 80 x 1,60
75.75 CNC	10375 x 54 x 1,60
700.500 SA 90°	7925 x 41 x 1,30
800.600 SA 90°	8700 x 54 x 1,60
1000.800 SA 90°	9325 x 54 x 1,60
60.40 SA 60°/60°	6340 x 34 x 1,30
70.50 SA 60°/60°	7925 x 41 x 1,30
100.60 SA 60°/60°	8275 x 41 x 1,30
120.70 SA 60°/60°	8625 x 41 x 1,30
60.40 CNC 60°/60°	6340 x 41 x 1,30
70.50 CNC 60°/60°	7925 x 54 x 1,60
100.60 CNC 60°/60°	8275 x 54 x 1,60
120.70 CNC 60°/60°	8625 x 54 x 1,60
30.15 CNC 60°/60°	3820 x 27 x 0,90
350 HFA CNC	3980 x 34 x 1,10
450 HFA CNC	4880 x 41 x 1,30
520 HFA CNC	5800 x 41 x 1,30
SB 360 CNC	4625 x 34 x 1,10
SB 460 CNC	5120 x 41 x 1,30
1600	14445 x 80 x 1,60

DANOBAT

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
Horizontal	
CR-260, CR-260 I, CR-260 A, CR 260 AI	4090 x 27 x 0,90
CR-260 F, CR-260 AF	4520 x 34 x 1,10
CR-260 L, CR-260 AL	4520 x 27 x 0,90
CR-330, CR-330 I, CR-330 A, CR-330 AI	4970 x 34 x 1,10
CR-330 L, CR-330 AL	4970 x 27 x 0,90
CPS 400, CPS 400 I, CPS 400 A, CPS 440 AI	5920 x 41 x 1,30
CPS 440 L, CPS 420 AL	5920 x 34 x 1,10
CP 420 N, CP 420 AN	5920 x 41 x 1,30
CP-520 I, CP-520 AI	6585 x 41 x 1,30
CP-520 F, CP-520 AF	7690 x 54 x 1,60
CP 650, CP 650 A	8015 x 67 x 1,60
CP 100.65, CP 800 A	8700 x 67 x 1,60
CP 100.80, CP 800 T	9190 x 67 x 1,60
CP 1000 T	10415 x 80 x 1,60
CP 1100 A	11100 x 67 x 1,60
CP 12/11, CP 12/11 T	11300 x 67 x 1,60
CP 13/11, CP 13/11 T	11500 x 67 x 1,60
CP 15/12	12415 x 80 x 1,60
Gantry 12/11	12600 x 80 x 1,60
Gantry 15/15	14470 x 80 x 1,60
Gantry 20/15	15470 x 80 x 1,60
Gantry 20/20	17040 x 80 x 1,60
Mitre	
CPIs 54/40DI	5920 x 34 x 1,10
CPI 54/40DI	5920 x 41 x 1,30
CPI 70/50DI	6585 x 41 x 1,30
CPI 100/50DI	7545 x 54 x 1,30
CPI 100/70DI	8930 x 54 x 1,60
CPI 120/50DI	9330 x 54 x 1,60
CPI 120/70DI	10715 x 54 x 1,60
Vertical	
VP 50/50/120	5265 x 41 x 1,30
VP 50/50/210	5265 x 41 x 1,30
VPL 50/70	6040 x 41 x 1,30
VL 40/110	6800 x 54 x 1,30
VL 40/200	8540 x 41 x 1,30
VL 40/250	9620 x 41 x 1,30
VL 70/110	7930 x 54 x 1,60
VL 70/200	9760 x 54 x 1,60
VL 70/250	10820 x 54 x 1,60
VL 110/110	9260 x 80 x 1,60
VL 150/90	8740 x 80 x 1,60
VLR 100/100/2	9420 x 54 x 1,60
VLR 50/110/3	8840 x 41 x 1,30
VLTA 60/1502	8420 x 54 x 1,60
VLTA 60/250/8	11140 x 41 x 1,30
VLTA 30/200/6	9170 x 54 x 1,30

DOALL

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
230 SA, 230 DG SA	2710 x 27 x 0,90
CJ-260	3505 x 34 x 1,10
C-10, C-10 M, C-41, C-41 A, C-55, C-56, C-57, C-58, C-67, C-68,C-69, C-70, C-79, C-80, C-81, C-82, C-8015, C-167,C-169, C-170, c-179, C-180, C-270, C-280	3660 x 27 x 0,90
C-1213 M/A	3660 x 27 x 0,90
optional	3660 x 34 x 1,10
CJ-1213, C-305 M/A/NC	3660 x 34 x 1,10
C-912 M/A	3735 x 27 x 0,90
C-1212 M/A	4010 x 27 x 0,90
optional	4010 x 34 x 1,10

continuation DOALL

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
C-916 M/S/A, HCS 275	4010 x 27 x 0,90
C-7, C-8, C-9, C-9 A	4050 x 27 x 0,90
HC-34 HC-35 A	4064 x 27 x 0,90
C-3300 N/C	4090 x 34 x 1,10
CJ-1216	4100 x 34 x 1,10
C-916 SA/DS	4318 x 27 x 0,90
TF-14/H/HA	4370 x 27 x 0,90
C-330 M/NC	4450 x 34 x 1,10
TF-20	4572 x 34 x 1,10
C-4100 M/A/NC/CNC, CJ-410 M/A/NC, CJ-1220 A/NC	4720 x 41 x 1,30
TF-2021	4875 x 34 x 1,10
C-260 NC	4900 x 34 x 1,10
HCS-375/350 A	5000 x 34 x 1,10
TF-24	5230 x 34 x 1,10
TF-36	5230 x 41 x 1,30
TF-25	5285 x 41 x 1,30
TF-2025 M/NC	5309 x 34 x 1,10
TF-2525	5321 x 41 x 1,30
C-430 M/NC	5450 x 41 x 1,30
C-520 M/NC, C-530 M/NC	6400 x 54 x 1,30
optional	6400 x 54 x 1,60
C-650 M/NC	7620 x 54 x 1,60
C-3232	7722 x 67 x 1,60
C-1000 x 500S	8200 x 54 x 1,60
C-650 S/SNC	8300 x 54 x 1,60
C-670 M/NC	8450 x 54 x 1,60
C-820 M/NC	9150 x 67 x 1,60
C-1020 M/NC	9700 x 67 x 1,60
C-4048	9805 x 67 x 1,60
C-1350	13600 x 80 x 1,60

EISELE

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
HBT 240	2835 x 27 x 0,90
HB 280 N, HB 280 S, HB 360 S, HB 360 SE	4020 x 27 x 0,90
HBG 325	4020 x 34 x 1,10
HB 450 N, HB 450 S, HB 620 N, HB 620 S	5620 x 34 x 1,10

EVERISING

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
S-250 HA	3505 x 27 x 0,90
S-250 HB	3505 x 34 x 1,10
S-12 T, A, AA	3820 x 27 x 0,90
S-300/HA	3820 x 27 x 0,90
H-260 HA	3820 x 27 x 0,90
S-300 HB	3820 x 34 x 1,10
S-260 HB	3920 x 34 x 1,10
P-300 MNC	3920 x 34 x 1,10
S-4633 SA	4115 x 27 x 0,90
S-330 HC	4115 x 34 x 1,10
H-360 HA, H-360 SA	4420 x 34 x 1,10
S-400 HA	4570 x 34 x 1,10
S-400 HB	4570 x 41 x 1,30
S-460 HB	4670 x 41 x 1,30
VB 0405-12, (15), (25)	4670 x 41 x 1,30
H-5550	4880 x 41 x 1,30
S-6235 HA, S-623 SA	4900 x 41 x 1,30
H-460 HA	5450 x 41 x 1,30
NC-460 HA	5450 x 41 x 1,30
H-7050	5450 x 41 x 1,30

continuation EVERISING

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
S-8246 SA	5980 x 41 x 1,30
VBS-0407 30, (45), (60)	6200 x 54 x 1,60
H-560 HA	6600 x 54 x 1,60
VB-070 715, VB-070 725	6800 x 54 x 1,60
VBS-0707-60, (25)	6800 x 54 x 1,60
H-7056	6800 x 54 x 1,60
VBS-0710-45, (60)	7140 x 54 x 1,60
H-7065 HA	7600 x 54 x 1,60
H-8070	7600 x 54 x 1,60
V-0615	7890 x 41 x 1,30
H-700	8000 x 54 x 1,60
H-1060	8300 x 54 x 1,60
H-8276	8300 x 67 x 1,60
H-1010	8800 x 67 x 1,60
VBS 0425	9610 x 41 x 1,30
V 0625	9900 x 41 x 1,30
VBS 1316-45, (60)	10000 x 80 x 1,60
H-11110V	11100 x 80 x 1,60
H-1300	12300 x 80 x 1,60
H-1613	13000 x 80 x 1,60
H-1816	15900 x 80 x 1,60
H-2116	16500 x 80 x 1,60

FMB

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
200A, 250D, 250DP, 200DS, 250SA, 250SA PIPING	2450 x 27 x 0,90
Triton (280D), Antilia (280DP), Antares (280DS), Orion (310D+S), Uranus (310D+S-P), Sirus (280SA), Omega (310D, S-SA), Centauro, Cynus, Calipaso, Pulsar	2700 x 27 x 0,90
Titan (300D), Major (300SAV), Zeus (240AV), Jupiter (240AVD)	3180 x 27 x 0,90
Galactica (400SAV)	3420 x 27 x 0,90
Pluton 1 (1200SAV)	4980 x 27 x 0,90
Pluton 2	5020 x 34 x 1,10
Olimpus 1-2-3	5450 x 41 x 1,30

FORTE

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
Piccolo	1215 x 13 x 0,65
F 200/S	2740 x 20 x 0,90
F 250	3660 x 27 x 0,90
Fortemat BA 321/SIP, BA 321/SIP-CNC	3660 x 34 x 1,10
Fortemat SBA 241/S, SBA 241/S/M-CNC	4100 x 34 x 1,10
Uniforte 500	4300 x 34 x 1,10
F 320/SI-GBS	4350 x 34 x 1,10
F 360/S	4870 x 27 x 0,90
F 420/SI, Fortemat SBA 341/S	4870 x 34 x 1,10
Fortemat SBA 361/S, SBA 361/S-CNC	4870 x 41 x 1,30
Fortemat SBA 421/S, SBA 421/S-CNC	6050 x 41 x 1,30
Fortemat SBA 531/S, SBA 531/S-CNC	6270 x 54 x 1,60
Fortemat SBS 681/S, SBS 681/S-CNC	7400 x 54 x 1,60
Fortemat SBS 801/S	9000 x 67 x 1,60
Fortemat SBS 1001/S	10270 x 67 x 1,60

FRIGGI

Manufacturer/Machinery type		Band dimensions length x width x thickness mm
1 MF 320		4550 x 41 x 1,30
FP 280 ACN		4650 x 34 x 1,10
FG 600 TS		5370 x 41 x 1,30
AST 650 x 400		5500 x 34 x 1,10
1 MF 420		5550 x 41 x 1,30
VAS H 2500 x 650 x 900		5920 x 67 x 1,60
2 MF 520 N ACN		6750 x 54 x 1,30
AST 1200 x 400		6890 x 34 x 1,10
VAS H 4000 x 650 x 900		6900 x 54 x 1,60
	optional	6900 x 67 x 1,60
VAS H 3000 x 1000 x 900		7900 x 54 x 1,60
	optional	7900 x 67 x 1,60
VTS 3000, VTS 4000		8270 x 41 x 1,30
ONL 560 x 600 ACN		8470 x 54 x 1,60
AST 1500 x 600 S		8590 x 41 x 1,30
AST 1500 x 600 R		8600 x 41 x 1,30
ONL 660 x 700 ACN		8660 x 41 x 1,30
	optional	8660 x 54 x 1,60
VAS H 3000 x 1500 x 900		9080 x 54 x 1,60
	optional	9080 x 67 x 1,60
VAS OSF 6250		9360 x 41 x 1,30
ONL 800		9820 x 67 x 1,60
2 MF 1000 F ACN		11900 x 67 x 1,60
2 MF 1500		13500 x 80 x 1,60
2 MF G 1500 x 1500		14000 x 80 x 1,60
2 MF G1500 x 2000		15000 x 80 x 1,60
2 MF G 2000 x 2000		15600 x 80 x 1,60
2 MF G 2500 x 2500		17600 x 80 x 1,60

HESKA

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
HES-250 DGH	2750 x 27 x 0,90
HES-250 DGH	2800 x 27 x 0,90
HES-260	3660 x 27 x 0,90
HES-260 AL	3660 x 27 x 0,90
HES-320	3660 x 27 x 0,90
HES-300 DG	3660 x 27 x 0,90

INDOTECH MACHINES PVT. LTD.

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
210 DCA/DCTV	3760 x 27 x 0,90
210 DC	3760 x 27 x 0,90
220 DCA/DCTV	3760 x 27 x 0,90
300 DCTV/DC/VDCNC	4100 x 34 x 1,10
200 VTR VERTICAL	4860 x 34 x 1,10
340 DCTV/DCA	4860 x 41 x 1,30
420 DCTV/DCA	5800 x 41 x 1,30
460 DCTV/DCA/DCNC	5800 x 41 x 1,30
300 V3 VERTICAL	6300 x 41 x 1,30
530 DCTV/DCTA	6900 x 54 x 1,60
650 DCTV/DCTA	8000 x 67 x 1,60
800 DCTV/DCTA	8800 x 67 x 1,60
6024 DCTV	9700 x 80 x 1,60
1000 DCTV	12300 x 67 x 1,60
5040 DCTV	12300 x 80 x 1,60
1250 DCTV	13900 x 80 x 1,60
1500 DCTV	16080 x 80 x 1,60
8060 DCTV	16080 x 80 x 1,60

JAESPA

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
W 150 G	2000 x 20 x 0,90
Concept 180 G	2220 x 13 x 0,65
W 160 G	2300 x 20 x 0,90
W 180 G	2450 x 20 x 0,90
Concept 220 G	2600 x 27 x 0,90
Concept 240 GA	2710 x 27 x 0,90
Concept 220 A	2710 x 27 x 0,90
Concept 240 GT/GTH/GTA	2940 x 27 x 0,90
W 220 DG/DGH/DGA	2940 x 27 x 0,90
Concept 240 GT/GTH	3340 x 27 x 0,90
Classic 300 DG	3660 x 27 x 0,90
Classic 302 DGH	3660 x 27 x 0,90
Comfort 260 A	3660 x 27 x 0,90
W 260 M, W 320	3660 x 27 x 0,90
W 260 DG/DGH	3660 x 27 x 0,90
W 270 A	3900 x 27 x 0,90
W 270 A/34er Band	3900 x 34 x 1,10
W 320 G	4120 x 27 x 0,90
W 320 G/34er Band	4120 x 34 x 1,10
W 331	4120 x 27 x 0,90
Concept 320 GH (W 320 GH)	4120 x 27 x 0,90
Concept 320 GA (W 320 GA)	4120 x 34 x 1,10
Compact 2 V 325 DG/DGHS	4240 x 34 x 1,10
V 380 DG/DGH	4250 x 34 x 1,10
Classic 380 DG (V 380 DG)	4250 x 34 x 1,10
Concept 330 GTH	4440 x 34 x 1,10
Classic 420 DGH/DGA	4490 x 34 x 1,10
W 400 A, W 400 HA	4570 x 34 x 1,10
Comfort 400 A	4570 x 34 x 1,10
Compact 3	4660 x 34 x 1,10
Classic 500 DGH/DGA	4900 x 34 x 1,10
Classic 500 H	4900 x 34 x 1,10
Concept 340/630 PG	5150 x 34 x 1,10
W 340 AZP	5100 x 34 x 1,10
Classic 650 H	5200 x 34 x 1,10
W 323 AZP	5300 x 34 x 1,10
W 300 AZP, W 302 AZP	5390 x 34 x 1,10
W 400 AZP	5500 x 34 x 1,10
Compact 4	5600 x 41 x 1,30
W 400 HAP	6100 x 34 x 1,10
W 420 AZP	6400 x 41 x 1,30
W 500 HAP	6700 x 41 x 1,30
Concept 500/800 PG	7050 x 54 x 1,60
Concept 500/800 HAP	7050 x 54 x 1,60
W 501 AZP	7250 x 54 x 1,60
W 500 HAP/G	7500 x 54 x 1,60
Concept 800 HAP/800/1000	8500 x 54 x 1,30
W 800 HAP/G	8500 x 54 x 1,60

KALTENBACH

Manufacturer/Machinery type		Band dimensions length x width x thickness mm
UMB 250		3200 x 27 x 0,90
KB 360 G, KB 360 NA G		3830 x 27 x 0,90
KBR 280 NA		3800 x 34 x 1,10
KBR 500 G		4600 x 34 x 1,10
KBC 280/350 NA		5100 x 34 x 1,10
KBR 610 DG		5620 x 34 x 1,10
KB 305 H, KB 305 NA		5620 x 34 x 1,10
	optional	5620 x 41 x 1,30
KB 380 H, KB 380 NA		5620 x 34 x 1,10
	optional	5620 x 41 x 1,30
KBS 400 DG		5730 x 34 x 1,10
KBR 370 H, KBR 370 NA		5730 x 34 x 1,10
	optional	5730 x 41 x 1,10
KBR 371 H, KBR 371 NA		5920 x 34 x 1,10
	optional	5920 x 41 x 1,10
KBC 410		5920 x 41 x 1,30
KBS 620 DG		6175 x 41 x 1,30
KB 455 H, KB 455 NA		6200 x 41 x 1,30
	optional	6200 x 54 x 1,30
KBS 750 DG, KBS 860		6990 x 41 x 1,30
KBS 920 DG		7290 x 41 x 1,30
KBS 1010		7470 x 41 x 1,30
KBR 460 H, KBR 460NA		7470 x 54 x 1,30
KB 550 H, KB 550 NA		7820 x 54 x 1,60
KBS 851 DG		7980 x 54 x 1,30
	optional	7980 x 54 x 1,60
KBS 1001		8250 x 54 x 1,30
	optional	8250 x 54 x 1,60
KBS 761		8320 x 54 x 1,60
KBS 1051		8900 x 54 x 1,60
KB 700 H, KB 700 NA		8920 x 54 x 1,60
KBS 1301		9800 x 67 x 1,60
KBS 1551 DG		10300 x 67 x 1,60
KBS 2101		11980 x 80 x 1,60

KASTO

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
KASTObsm M2/E2/U2	2825 x 27 x 0,90
KASTOpractical M2/U2/E2/A2	2825 x 27 x 0,90
KASTOfunctional M/U/A	2910 x 27 x 0,90
KASTOverto	3180 x 27 x 0,90
KASTO SBA A 2	3830 x 27 x 0,90
KASTOcut E 2	3830 x 27 x 0,90
KASTOcut GE3/GU3	4930 x 34 x 1,10
KASTOcut GE4/GU4/DU4	5090 x 34 x 1,10
KASTOprofil 3	5090 x 34 x 1,10
KASTOpos GA2	4930 x 34 x 1,10
KASTOpos GA3	4930 x 34 x 1,10
KASTOpos GA4	5090 x 34 x 1,10
KASTOvericut	5630 x 41 x 1,30
altern.	5630 x 34 x 1,10
KASTOtwin A2	4530 x 34 x 1,10
KASTOtwin AE3/L3	5090 x 34 x 1,10
KASTOtwin AE4/LE4	5090 x 34 x 1,10
KASTOevo 3x4	4930 x 34 x 1,10
KASTOtwin A4x5	5700 x 41 x 1,30
KASTOtwin A4/L4	5700 x 41 x 1,30
KASTOevo 4x5	5700 x 41 x 1,30
KASTOtwin U4	5090 x 41 x 1,30
KASTOtwin A5	7400 x 54 x 1,60
KASTOtwin A6/L6	8670 x 54 x 1,60
KASTOtwin A8	8670 x 67 x 1,60
SSB A2	4115 x 41 x 1,30
altern.	4115 x 34 x 1,10
KASTOtec A3/AC3	6830 x 41 x 1,30
altern.	6830 x 34 x 1.10
altern.	6830 x 54 x 1,30
altern.	6830 x 54 x 1,60
KASTOtec A4/AC4	6830 x 41 x 1,30
altern.	6830 x 34 x 1,10
altern.	6830 x 54 x 1,30
altern.	6830 x 54 x 1,60
KASTOtec A5	7675 x 54 x 1,30
altern.	7675 x 54 x 1,60
altern.	7675 x 67 x 1,60
KASTOtec AC5	7675 x 54 x 1,60
altern.	7675 x 34 x 1,10
altern.	7675 x 54 x 1,30
altern.	7675 x 41 x 1,30
altern.	7675 x 67 x 1,60
KASTOtec A5x10	8555 x 54 x 1,30
altern.	8555 x 54 x 1,60
altern.	8555 x 67 x 1,60
KASTOtec AC5x10	8555 x 54 x 1,60
altern.	8555 x 54 x 1,30
altern.	8555 x 67 x 1,60
KASTOtec A7/AC7/A8/AC8	9195 x 67 x 1,60
altern.	9195 x 80 x 1,60
altern.	9195 x 54 x 1,60
altern.	9195 x 54 x 1,30
KASTOtec A7x10/AC7x10	9735 x 80 x 1,60
altern.	9735 x 67 x 1,60
KASTOtec A8x10/AC8x10	9735 x 80
altern.	9735 x 67 x 1,60

continuation KASTO

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
KASTOhba A/U8x10	10260 x 67 x 1,60
altern.	10260 x 80 x 1,60
KASTOhba A/U13x13	12660 x 80 x 1,60
KASTOhba A/U10x12	11430 x 80 x 1,60
altern.	11430 x 67 x 1,60
KASTOhba A/U 13x17	13460 x 80 x 1,60
KASTOcross A4x12	7417 x 41 x 1,30
KASTOcross A3x20	11820 x 54 x 1,60
KASTOvertical	5450 x 41 x 1,30
altern.	5450 x 54 x 1,30
altern.	5450 x 34 x 1,10
altern.	5450 x 27 x 0,90
KASTOplate U3/A3	5450 x 41 x 1,30
altern.	5450 x 54 x 1,30
altern.	5450 x 34 x 1,10
altern.	5450 x 27 x 0,90
KASTObloc U5	5450 x 41 x 1,30
altern.	5450 x 54 x 1,30
altern.	5450 x 34 x 1,10
altern.	5450 x 27 x 0,90
KASTObbs U3x6	5290 x 41 x 1,30
altern.	5290 x 54 x 1,30
KASTObbs U5x10	7440 x 54 x 1,60
altern.	7440 x 67 x 1,60
KASTObbs U8x10	7440 x 54 x 1,60
altern.	7440 x 67 x 1,60
KASTObbs U10	7772 x 54 x 1,60
altern.	7772 x 67 x 1,60
KASTObbs U/A 4x16/6x16	8350 x 54 x 1,60
altern.	8350 x 67 x 1,60
KASTObbs U/A 3x20	8686 x 41 x 1,30
altern.	8686 x 54 x 1,30
KASTObbs U 13x10/15x10	8738 x 80 x 1,60
gleich mit KASTObbs 15x12 (bis 4m Tisch)	
KASTObbs U 8x16	8890 x 67 x 1,60
KASTObbs U 8x20	9754 x 67 x 1,60
KASTObbs U12x15	10260 x 67 x 1,60
altern.	10260 x 80 x 1,60
KASTObbs U18x8	10516 x 80 x 1,60
KASTObbs U 10x20	10617 x 67 x 1,60
KASTObbs U 15	10780 x 80 x 1,60
KASTObbs A 3x27	10871 x 54 x 1,60
KASTObbs U18x15	11430 x 80 x 1,60
altern.	(11430 x 100 x 1,60)
KASTObbs U 16x20	12630 x 80 x 1,60
KASTObbs U 10x25	12650 x 67 x 1,60
KASTObbs A 3x30	12751 x 54 x 1,30
KASTObbs U 20	13284 x 80 x 1,60
KASTOmax cut 20x20	17440 x 100 x 1,60
altern.	17440 x 80 x 1,60

KLAEGER

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
HBS 220, HBS 220 G, HBS 220 G, HBA 220, HBA 220 G, HBA S220	2890 x 27 x 0,90
HBS 265, HBS 265 G, HBS 265 DG, HBA 265, HBA 265 G	3280 x 27 x 0,90
HBS 325, HBS 325 G, HBA 325, HBA 325 G	3770 x 27 x 0,90
HBA S 265, HBA S 325, HBA S 325 G	4150 x 34 x 1,10
HBA S 400, HBA 500	4400 x 34 x 1,10
HBA S 500G, HBA S 500 DG	4700 x 34 x 1,10

MARVEL

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
V10, V10APC	4115 x 27 x 0,90
8 Mark II	4420 x 27 x 0,90
81, 81APC	4420 x 34 x 1,10
15, 15APC	4720 x 34 x 1,10
MV460, MV460APC	4775 x 34 x 1,10
MV525, MV525APC	5330 x 41 x 1,30
2125	5334 x 32 x 1,10
2150	5537 x 38 x 1,13
25, 25APC	5740 x 41 x 1,30

MEBA

Manufacturer/Machinery type		Band dimensions length x width x thickness mm
200		2490 x 20 x 0,90
220 G		2450 x 27 x 0,90
230 G / DG / DG-P / GA-P/ GA-H / GA-NC		2720 x 27 x 0,90
220 DG		2825 x 27 x 0,90
180		3020 x 27 x 0,90
225		3350 x 27 x 0,90
260 AP, 260 GP		3350 x 27 x 0,90
251, 251 A, 270 A / 301 G / 301 GA		3660 x 27 x 0,90
260 AP		3700 x 27 x 0,90
MEBAswing 260 GA		3700 x 27 x 0,90
305 G / DG / GA		3800 x 27 x 0,90
250 A, 250, 320		3800 x 27 x 0,90
310 G / GA		3800 x 34 x 1,10
300 A, 320, 320 A, 325		3800 x 34 x 1,10
310 DG		4200 x 27 x 0,90
ECO 320 G standard		4200 x 27 x 0,90
ECO 320 GA standard		4200 x 27 x 0,90
260 A /280 / 280 A		4200 x 34 x 1,10
320 DG		4200 x 34 x 1,10
310 G-L, 310 GA-L		4200 x 34 x 1,10
ECO 320 G stufenloser Antrieb / HSS		4200 x 34 x 1,10
ECO 320 G stufenloser Antrieb / S		4200 x 34 x 1,10
MEBAMAT 260 A		4200 x 34 x 1,10
ECO 320 DG / DGA		4400 x 34 x 1,10
ECO-S 335/ 335 A/ G/ GA / DG / DGA		4400 x 34 x 1,10
330 /330 A		4471 x 34 x 1,10
(nach Maschinenkarte)		4471 x 41 x 1,30
340 /340 A		4623 x 34 x 1,10
(nach Maschinenkarte)		4623 x 41 x 1,30
280 A	bis Bj. 94	4670 x 41 x 1,30

continuation MEBA

Manufacturer/Machinery type		Band dimensions length x width x thickness mm
407 A, 407 A CV		5120 x 41 x 1,30
MEBAMAT 407 A		5120 x 41 x 1,30
MEBAMAT 407 A OV		5120 x 41 x 1,30
420 / 420 A		5334 x 41 x 1,30
380 / 380 A	bis Bj. 94	5334 x 41 x 1,30
400		5400 x 34 x 1,10
300 G / DG/ GA / DGA-500		5400 x 34 x 1,10
440		5400 x 41 x 1,30
380 / 380 A		5800 x 41 x 1,30
410 / 410 A / 410 DG-620 410 DGA-1300 / 410 DGA-2300 410 DGA-1300 / 410 DGA-2300 410 DGA-3300		5800 x 41 x 1,30
420 G /420 GA		5800 x 41 x 1,30
430 /430 A		5800 x 41 x 1,30
ECO-Serie 410 / A /DG / DGA		5800 x 41 x 1,30
620 DGP	bis Bj. 94	5800 x 41 x 1,30
400 G -700	bis Bj. 94	6000 x 41 x 1,30
435 G / 435 GA		6080 x 41 x 1,30
510		6100 x 41 x 1,30
510 DG		6100 x 41 x 1,30
510 DGA-2300		6100 x 41 x 1,30
510 DGA-3300		6100 x 41 x 1,30
510 DGA-1300		6100 x 41 x 1,30
MEBAe-cut 400		6220 x 41 x 1,30
MEBAe-cut 400 A		6220 x 41 x 1,30
MEBAe-cut 500 A		6220 x 41 x 1,30
MEBAe-cut 500		6220 x 41 x 1,30
MEBAMAT 434		6220 x 41 x 1,30
400 G-700	ab Bj. 94	6310 x 41 x 1,30
400 GA-700	ab Bj. 97	6310 x 41 x 1,30
520		6354 x 41 x 1,30
420 G-800 / 420 GA-800		6450 x 54 x 1,30
400 GA-700	ab Bj. 97	6760 x 41 x 1,30
400 DG / DGA-700		6760 x 41 x 1,30
560 / 560 A / 660/ 660 A	bis Bj. 97	7830 x 54 x 1,60
560 / 560 A / 660 / 660 A		8500 x 54 x 1,60
560 G / DG / GA-700		8500 x 54 x 1,60
650 - 700 G / DG / GA / DGA		8500 x 54 x 1,60
850 - 510		9000 x 67 x 1,60
800-510		9000 x 67 x 1,60
800-600		9000 x 67 x 1,60
800-510 A		9000 x 67 x 1,60
800-600 A		9000 x 67 x 1,60
800-600 A-2300		9000 x 67 x 1,60
800-600 A-3300		9000 x 67 x 1,60
560 G / DG / GA / DGA - 1000		9300 x 54 x 1,60
650 - 1000 G / DG / GA / DGA		9300 x 54 x 1,60
1000 DG P/ 1140 - 510 / 1250 - 510		9800 x 67 x 1,60
1020 DGP		9800 x 67 x 1,60
1270 DGP		9800 x 67 x 1,60
1140-510		9800 x 67 x 1,60
1140-600		9800 x 67 x 1,60
1250-600		9800 x 67 x 1,60
1250 DG		10000 x 67 x 1,60
1250-800		10300 x 67 x 1,60
1250-1000		11045 x 67 x 1,60
1000-1000		11045 x 67 x 1,60

MEGA

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
H- 260 A, H-260 GA	3660 x 27 x 0,90
BS-250 HAS, BS-250 GA	3660 x 34 x 1,10
BS-300 HAS, BS-300 GA	3820 x 34 x 1,10
BS-330 A, H-330 GA, H-330	3920 x 34 x 1,10
BS-400 HAS, BS-400 GA, BS-400 HA, BS-360 GA, BS-360 HA, BS-450 M, BS-360 SA, BS-360 A	4115 x 34 x 1,10
H- 400 A, H-400 GA, H-400	4570 x 34 x 1,10
BS-450 SA	4670 x 41 x 1,30
BS-450 HAAS, BS-450 GAAS,	4880 x 41 x 1,30
H-5042 A	5100 x 41 x 1,30
H-460 A, H-460GA, H-460, BS-1830 (H-1830)	5300 x 41 x 1,30
BS-760 M	5500 x 41 x 1,30
H- 410 NC	5590 x 41 x 1,30
H- 550 A, H-550 GA, H-550	5800 x 41 x 1,30
H- 600, S-600	7600 x 54 x 1,60
H- 700 A, H-700 GA, H-700, H-800, S-800	8128 x 54 x 1,60
MH-800 S	8500 x 54 x 1,60
H-1080, S-1080	8800 x 67 x 1,60
MH-1080 S	9070 x 54 x 1,60
MH-1865 S	10600 x 67 x 1,60
MH-1190 S	10818 x 67 x 1,60
H-1100	10820 x 80 x 1,60
MH-1690 S	10980 x 67 x 1,60
MH-1385 S, H-1300	12300 x 80 x 1,60
H-1613	12900 x 80 x 1,60

MEP

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
PH 101	1138 x 13 x 0,65
PH 211	2085 x 20 x 0,90
SH 200	2375 x 20 x 0,90
PH 261	2450 x 27 x 0,90
SH 260 / 260 CCS	2750 x 27 x 0,90
SH 280 / SH 280 SX / SH 280 SXI / SH 282 / SH 282 SX / SH 282 CNC FE / SH 282 CCS	2950 x 27 x 0,90
SH 332 CCS / SH 332 SX / SH 332 SXI / SH 332 CNC FE / SH 330 AXI / SH 330 CNC S	3320 x 27 x 0,90
SH 400 CNC FES	4400 x 34 x 1,10
SC 452 CCS	4500 x 27 x 0,90
SH 420 SXI / SH 420 SXI /E	4640 x 34 x 1,10
SC 500 CNC FE	5450 x 41 x 1,30

MISSLER

Manufacturer/Machinery type		Band dimensions length x width x thickness mm
DEB 280 CE		4100 x 34 x 1,10
ACM 600		4570 x 34 x 1,10
DEB 340 CE		5000 x 34 x 1,10
DEB 410 CE		5940 x 41 x 1,30
DEB 420 CE		6200 x 54 x 1,30
	optional	6200 x 54 x 1,60
DEB 540 CE		7460 x 54 x 1,30
	optional	7460 x 54 x 1,60
DEB 650 CE		9400 x 67 x 1,60
DEB 720 CE		9520 x 67 x 1,60

MÖSSNER

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
LB 421, LBV 421, LB 421 E, LBV 421 E	3700 x 27 x 0,90
HM 280 CNC	5200 x 34 x 1,10
SM 320	2550/2630 x 3 – 13
SM/SSF 420	3160/3260 x 3 – 13
SSF 520	4100/4200 x 6 – 27
SSF 520 (erhöht)	4500/4600 x 6 – 27
SSF 630	5100/5180 x 10 – 34
SSF 630 (250 erhöht)	5600/5680 x 10 – 34
SSF 1050 (2 Räder)	3920/4050 x 6 – 27
SSF 1050 (3 Räder)	5250/5350 x 6 – 27
SSF 801	6250/6400 x 13 – 34
SSF 801 mit Zylinder	6270/6350 x 13 – 34
SSF 1600	6575/6635 x 6 – 27
SSF 1600 (270 erhöht)	6980/7040 x 6 – 27
VB 801 F	6670/6730 x 34 – 41
LB (V) 421 (E)	3700 x 27 x 0,90
HM 280 CNC	5400 x 34 x 1,10

MÜLLER

Manufacturer/Machinery type		Band dimensions length x width x thickness mm
Kamu 150 G		1470 x 13 x 0,65
Kamu 210 G, Kamu 220 G		2450 x 20 x 0,90
HBS 220 G		2450 x 27 x 0,90
HBS 230 G-M, HBS 230 G-MA, HBS 230 G-LR-M, HBS 230 G-LR-M, HBS 230 G-LR-HA		2700 x 27 x 0,90
Kamu 260 G-M, Kamu 220 G-SC, Kamu 280 DG-M, Kamu 280 DG-SC, Kamu 280 G-HHS, Kamu 280 DG-HHS, Kamu 310 G-HA, Kamu DG-HA		2700 x 27 x 0,90
HBA 240, HBA 240 G G		3180 x 27 x 0,90
Kamu 270 A, Kamu 300 G-A		3180 x 27 x 0,90
SBS 410, SBS 420, SBS 430 SBS 450, SBS 460		3400 x 13 x 0,65
	optional	3400 x 20 x 0,90
HBS 275 G		3460 x 27 x 0,90
	optional	3460 x 34 x 1,10
HBS 280, HBS 300, HBS 320 G HBS 321 G, HBS 260, HBA 260, HBA 280		3660 x 27 x 0,90
	optional	3660 x 34 x 1,10
Kamu 500 G-HA		4120 x 34 x 1,10
Kamu 450 G-A		4140 x 34 x 1,10
HBS 320, HBS 320 G-LR, HBS 322 G HBA 320, HBS 500 G, HBA 320 SG		4150 x 27 x 0,90
	optional	4150 x 34 x 1,10
HBA 320 SG		4150 x 34 x 1,10
Kamu 380 VDG-HA		4250 x 34 x 1,10
HBA 400 S,HBA 500 SG, HBS 500 SG, HBS 400 S		4400 x 34 x 1,10
Kamu 400 A		4500 x 34 x 1,10
SBS 650, SBS 660		4750 x 13 x 0,65
SBS 1150, SBS 1160		5000 x 20 x 0,90
	optional	5000 x 13 x 0,65
HBS 450, HBS 450 G,		5060 x 34 x 1,10
Kamu 700 HA, Kamu 700 DG-HA		5450 x 41 x 1,30
Kamu 1200		5600 x 34 x 1,10

PEHAKA

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
HS 300 GBS, HS 300 GBS-AU	3660 x 27 x 0,90
HS 260, HSL 260, HSL 260 Super, Pehakamat 250 SL, Pehakamat 250 Super	3700 x 27 x 0,90
Pehakamat 260 ZP	4850 x 34 x 1,10
HS 340 GBS	5000 x 34 x 1,10
HS 420 , Pehakamat 420-R	5300 x 34 x 1,10
HS 340/500, Pehakamat 360 ZP	5600 x 41 x 1,30
HS 440/560	6100 x 41 x 1,30
HS 540/710	6700 x 54 x 1,60
HS 310/600 GBS	6850 x 34 x 1,10
Pehakamat 440 ZP	7200 x 41 x 1,30
Pehakamat 540/610 ZP	7900 x 54 x 1,60
HS 650/800	8000 x 67 x 1,60
HS 400/800 GBS	8100 x 41 x 1,30
Pehakamat 650/800 ZP	8800 x 67 x 1,60
HS 540/1100 GBS	10260 x 54 x 1,60
HS 820/820, Pehakamat 820 ZP	10880 x 67 x 1,60
HS 820/1050	11350 x 67 x 1,60
HS 1700/1700	11880 x 54 x 1,60
HS 1070/1250	12700 x 67 x 1,60
HS 1500/1500	13520 x 67 x 1,60
HS 1250/1350	14000 x 67 x 1,60
optional	14000 x 80 x 1,60

RURACK

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
BS 150	1650 x 13 x 0,65
BS 200	2080 x 16 x 0,65
BS 260	2465 x 27 x 0,90
BS 300	2865 x 27 x 0,90
BS 350	2865 x 27 x 0,90
BS 350 A	2825 x 27 x 0,90
BS 400 A / H	2945 x 27 x 0,90
BS 275 A / H	2945 x 27 x 0,90
BS 380 A / H	3340 x 27 x 0,90
BS 320 A / H	2915 x 27 x 0,90

RÜSCH

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
Rüsch TopSaw 320	2825 x 27 x 0,90
Rüsch S800	9080 x 54 x 1,30
Rüsch S460	6000 x 41 x 1,30
Rüsch S420	4900 x 27 x 0,90
Rüsch S300	4150 x 27 x 0,90
Rüsch S250	3660 x 27 x 0,90
Rüsch QuickSaw 260SA	2700 x 27 x 0,90
Rüsch QuickSaw 260MF	2700 x 27 x 0,90
Rüsch QuickSaw 260M	2700 x 27 x 0,90
Rüsch HBSA250SA	3660 x 27 x 0,90
Rüsch HBS260	3660 x 27 x 0,90
Rüsch HBS250	3660 x 27 x 0,90
Rüsch G650	5400 x 34 x 1,10
Rüsch AS460	6000 x 41 x 1,30
Rüsch AS420	4900 x 27 x 0,90
Rüsch AS400	4900 x 27 x 0,90
Rüsch AS300	4150 x 27 x 0,90
Rüsch AS250	3660 x 27 x 0,90
Rüsch AR250	3660 x 27 x 0,90
Rüsch AM420	5420 x 41 x 1,30
Rüsch AM330	5230 x 41 x 1,30
Rüsch AM270	3660 x 27 x 0,90
Rüsch AS420	4900 x 27 x 0,90
Rüsch AC340	5400 x 34 x 1,10
Rüsch AC275	3660 x 27 x 0,90
Rüsch 600A	8800 x 67 x 1,60
Rüsch 555A	7860 x 54 x 1,60
Rüsch 550A	8400 x 67 x 1,60
Rüsch 520A2500	6830 x 41 x 1,30
Rüsch 520A	5890 x 41 x 1,30
Rüsch 520/700GS	6380 x 41 x 1,30
Rüsch 520/700GA2500	6830 x 41 x 1,30
Rüsch 520/700GA	6380 x 41 x 1,30
Rüsch 520/700G	6380 x 41 x 1,30
Rüsch 520/700A2500	6830 x 41 x 1,30
Rüsch 520/700	6380 x 41 x 1,30
Rüsch 450G	3660 x 27 x 0,90
Rüsch 444AS	5890 x 41 x 1,30
Rüsch 444A	5890 x 41 x 1,30
Rüsch 420A2500	5740 x 34 x 1,10
Rüsch 420A	5420 x 41 x 1,30
Rüsch 420/700GS	5740 x 34 x 1,10
Rüsch 420/700G	5740 x 34 x 1,10
Rüsch 420/700A2500	5740 x 34 x 1,10
Rüsch 420/700	5740 x 34 x 1,10
Rüsch 420/500GA2500	5890 x 41 x 1,30
Rüsch 420/500G	5890 x 41 x 1,30
Rüsch 420/500	5890 x 41 x 1,30
Rüsch 400A	5250 x 34 x 1,10
Rüsch 400/SA	5250 x 34 x 1,10
Rüsch 400/270G	3660 x 27 x 0,90
Rüsch 340A	5250 x 34 x 1,10
Rüsch 320/450G	3660 x 27 x 0,90
Rüsch 290A	4500 x 34 x 1,10
Rüsch 280A	4500 x 34 x 1,10
Rüsch 275A	3660 x 27 x 0,90
Rüsch 260/320AF	3660 x 27 x 0,90
Rüsch 1100/1260A	13650 x 67 x 1,60
Rüsch 1100/1260A	13650 x 80 x 1,60

SABI

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
BR 150/210	2400 x 20 0,90
BR 240 A NC	2910 x 27 0,90
BR 240/320	2925 x 27 0,90
PBS 250/400, PBS 250 A	3660 x 27 0,90
BR 260/410	3800 x 27 0,90
BR 230/510	4335 x 34 1,10
PSR 320/400, PSR 320 a	4570 x 27 0,90
PSR 320/450, PBS 320 a	4570 x 34 1,10
PSR 440/610	5200 x 34 1,10
PB 360/500, PB 360 a	5330 x 34 1,10
PBS 360/700, PSR 360/600	5500 x 34 1,10
PB 450 A NC	6000 x 41 1,30
PB 450/700, PSR 450/700, PB 450 A	6775 x 41 1,30
PB 550 A NC	7360 x 54 1,60
PB 550 a	7600 x 54 1,60
PBR 550/1000	8400 x 54 1,30
PB 550/1000, PB 650/850, PB 650 A	8400 x 54 1,60
PB 800/1000, PB 800 a	9500 x 67 1,60
PBR 700/1300	10500 x 54 1,60
PB 1000	11000 x 80 1,60

TRENNJÄGER

Manufacturer/Machinery type	Band dimensions length x width x thickness mm
TEBA 100	1350 x 13 x 0,65
TEBA 110	1620 x 13 x 0,65
TEBA 130	1730 x 13 x 0,65
TEBA 160, TEBA 160 L	2080 x 13 x 0,65
TEBA 200	2490 x 20 x 0,90
TEBA 200 L	2570 x 27 x 0,90
TEBA 240 bis NC	2710 x 27 x 0,90
Pegas 240 A / 240 A NC	2825 x 27 x 0,90
TEBA 250 DGHA	3110 x 27 x 0,90
TEBA 290 bis NC	3110 x 27 x 0,90
TEBA 361 -362	3660 x 27 x 0,90
TEBA 310	3990 x 27 x 0,90
TEBA 310 DGA	3990 x 27 x 0,90
Pegas 300 Serie	4000 x 27 x 0,90
TEBA 400 + SAF	4300 x 34 x 1,10
Pegas 380 Serie	5140 x 34 x 1,10
TEBA 450 DGHA	5150 x 34 x 1,10
TEBA 450 DGHA–Linear	5150 x 34 x 1,10
Pegas 440/600	5720 x 34 x 1,10
TEBA 230 G	2700 x 27 x 0,90
TEBA 230 DG	2700 x 27 x 0,90
TEBA 230 GHA	2700 x 27 x 0,90
TEBA 230 ANC	2700 x 27 x 0,90
TEBA 260 GHA	3200 x 27 x 0,90
TEBA 260 ANC 90°	3200 x 27 x 0,90
TEBA 260 ANC 90°/30°	3200 x 27 x 0,90
TEBA 330 GHA	4440 x 34 x 1,10
TEBA 330 ANC 90°	4440 x 34 x 1,10
TEBA 330 ANC 90°/30°	4440 x 34 x 1,10

UZAY MAKINA

Manufacturer/Machinery type		Band dimensions length x width x thickness mm
UMS 280 MANUEL		3660 x 27 x 0,90
UMSY 280 SEMI		3660 x 27 x 0,90
UMSO 280 FULL		3660 x 27 x 0,90
UMSY 350 SEMI		4320 x 34 x 1,10
UMSO 350 FULL		4320 x 34 x 1,10
UMSO 280 E FULL		3660 x 27 x 0,90
UMSO 350 E FULL		4320 x 34 x 1,10
UMSO 280 GE FULL		3960 x 27 x 0,90
UMSO 350 GE FULL		4320 x 34 x 1,10
UMS 150 G MANUEL		2080 x 20 x 0,90
UMSY 150 G SEMI		2080 x 20 x 0,90
UMSY 220 DG SEMI		3030 x 27 x 0,90
UMSY 350 G SEMI		4320 x 34 x 1,10
UMSY 350 DG SEMI		4320 x 34 x 1,10
UMSY 350 LG SEMI		5430 x 34 x 1,10
	optional	5430 x 41 x 1,30
UMSY 540 DG SEMI		8025 x 41 x 1,30
UMSY 360 SEMI		4570 x 34 x 1,10
UMSO 360 FULL		4570 x 34 x 1,10
UMSY 420 SEMI		5040 x 34 x 1,10
UMSO 420 FULL		5040 x 34 x 1,10
UMSY 540 SEMI		6100 x 41 x 1,30
UMSO 540 FULL		6100 x 41 x 1,30
UMSY 800 SEMI		7250 x 41 x 1,30
UMSY 1010 SEMI		9400 x 54 x 1,60
UMSY 1300 SEMI		12000 x 67 x 1,60
UMSY 1600 SEMI		13500 x 80 x 1,60
UMSO 280 H FULL		3660 x 27 x 0,90
UMSO 420 H FULL		5350 x 41 x 1,30
UMSO 540 H FULL		6250 x 41 x 1,30
UMSO 800 H FULL		8300 x 54 x 1,60
UMSO 1010 H FULL		10100 x 54 x 1,60
BLOCK 500 x 500 x 3500		5190 x 41 x 1,30
BLOCK 600 x 700 x 4500		6200 x 54 x 1,60
BLOCK 600 x 1000 x 6200		7000 x 54 x 1,60
UMSY 600 SP SEMI		7100 x 54 x 1,60
UMSY 820 SP SEMI		9000 x 54 x 1,6

WAGNER

Manufacturer/Machinery type		Band dimensions length x width x thickness mm
WPB 340 A		5270 x 34 x 1,10
	optional	5720 x 41 x 1,30
WPB 420 A		6280 x 41 x 1,30
WPB 520 A		7350 x 41 x 1,30
	optional	7350 x 54 x 1,60

TABLE OF CUTTING RESULT

Fax +49 (0) 5661 . 92 63 120 I Phone +49 (0) 5661 . 92 63 0

Company Name | Customers Number

Contact Person | P.O Box

Street | City/Town

Country | Phone/Fax

Surface of the Material

Machine Name | Type (horizontal/vertical) Machine Code

Sawing Fluid

Product Name | Size ZpZ / Tooth Pitch | Product Code

Material Group	Materials	Type of Material	Size mm	Blade Speed m/min	Cutting Rate mm/min	Cutting Result cm²/min	m² per Blade	Remarks

Date | Department | Signature

INDIVIDUAL PERFORMANCE CUTTING

Fax +49 (0) 5661 . 92 63 500 I Phone +49 (0) 5661 . 92 63 0

Company Name, Address

IPC Individual® Performance Cutting.

Piece	Band Saw Dimension	TPI	IPC	Notes:

Type of Materials:

Shape of Material:

LOH

Dimension: Dimension: Dimension:

Diameter: Wall Thickness: Wall Thickness:

Quantity of bundle:

Quantity of pieces:

Machine Manufacturer:

Machine Type:

What is your company ordepartment important when you intruduce the new bandsaw blade innovation?

mark what you expected

- ☐ more blade life
- ☐ better surface finish
- ☐ better delivery service
- ☐ better surface finish
- ☐ miscellaneous.....
- ☐ better cost performance
- ☐ lower noise
- ☐ shorter cuttime
- ☐ reduce tool costs

SYMBOLS

Tubes	▢ ○
Profiles/Beams	H ⊔ L
Thick walled tube	⊙
Solid steel plates	▬
Solid squares	■
Solid steel rounds, big/small	● •
Bundles	
Formed plates	
Castings	
Mineral building materials, e.g. sandstore	
Burnt bricks, e.g. poroton	
Foam glass, fiber glas	
Fiber reinforced stock bonded materials	
Powdered metal	
Cable, wire rope	
Case hardened material	

IPC options depending on material and application.

For longer blade life, no break in time	H
Protect tooth and climbing	X
Higher feed rates, minimized noise	S
Better surface, longer blade life	G
Reduces cutting time, longer blade life, low noise	C

IPC band saw blade is customized and manufactured individually depends on material and customer needs. Advice and recommendation through WESPA Service or certified value added reseller.

VALUE ADDED CUTTING

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WESPA Metallsägenfabrik
Simonds Industries GmbH

Spangenberger Straße 61
D – 34212 Melsungen, Germany

phone: +49 (0)5661 – 9263 0
fax: +49 (0)5661 – 9263 166 or 9263 120

www.individual-cutting.de
info@wespa-simonds.de

Technical changes reserve