

# Arntz

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Cutting!

# FactBook

CIRCULAR  
SAW BLADES



# CIRCULAR SAW BLADES

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## Carbide-tipped Circular Saw Blades

### Thin kerf

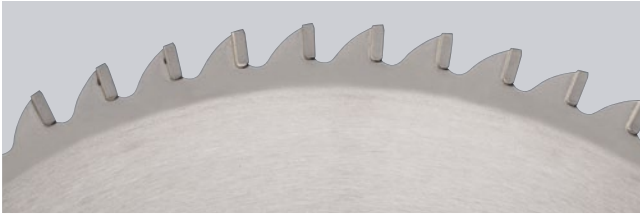


- available in cermet and carbide, uncoated and PVD-coated
- for cutting solid material or especially for thin-walled pipes

Diameter mm	Kerf mm	Number of teeth					
		40	54	60	72	80	100
250	2,0		X	X	X		
285	2,0			X	X	X	
315	2,5			X	X	X	X
360	2,6			X		X	X
420	2,7			X		X	X
425	2,7			X		X	X
460	2,7	X		X	X	X	

Further diameters, cutting widths and numbers of teeth are available upon request.

## Carbide-tipped Circular Saw Blades Standard kerf



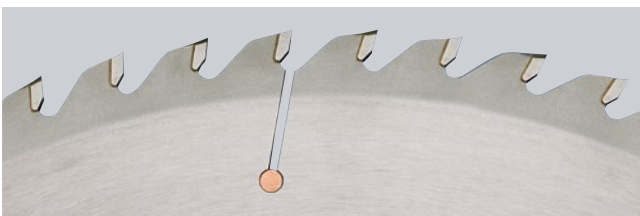
### For cutting steel

- available tooth shapes: triple chip, chip breaker or chip deflector
- for a low vibration and low noise cutting process we recommend TECHNO-laserslots

Durchmesser mm	Schnittbreite mm	Stammbblattstärke mm	Zähnezahl
500- 600	5,0- 6,5	4,0- 5,0	40   50   54   60   70   80   90   100   120
700- 860	6,0- 8,2	5,0- 6,0	48   50   60   70   80   90   100   120
900- 960	7,0- 8,0	5,5- 6,0	50   54   60   72   80   90   120   140   180
1000-1060	6,0- 8,5	5,0- 6,5	40   50   60   70   80   90   100   120   144   160   200
1120-1160	6,5- 8,5	5,0- 6,0	54   60   70   80   90   100   120   130   140   154   180
1250-1270	8,0-11,0	6,0- 8,0	50   54   56   60   72
1300-1370	8,2- 9,0	6,8- 7,5	54   60   68   100   120   140   160   180
1400-1470	9,0-11,0	7,0- 9,0	50   54   60
1500-1650	8,8-11,0	7,5- 9,0	50   54   60   66
1700-2200	10,5-12,5	9,0-10,5	50   54   60

Abweichende Durchmesser, Schnittbreiten und Zähnezahlen auf Anfrage lieferbar.

## Carbide-tipped Circular Saw Blades Standard kerf

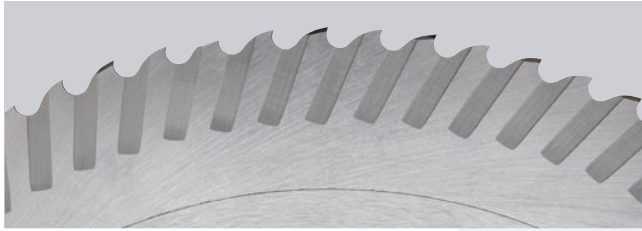


### For cutting non-ferrous metals

- available tooth shapes: triple chip or chip deflector
- POSITIVE type for cutting solid material and profiles on stationary machines
- NEGATIVE type especially for cutting thin-walled profiles on chop saws
- for a low vibration and low noise cutting process we recommend TECHNO-laserslots

Durchmesser mm	Schnittbreite mm	Stammbblattstärke mm	Zähnezahl
150- 190	2,8- 3,0	2,0	36   42   48   54
200- 275	2,8- 3,2	2,0- 2,5	54   60   72   80   88   96
300- 350	3,2- 3,4	2,5- 2,8	72   84   96   108
400- 450	3,8- 4,0	3,2	72   96   100   108   110   120   128
500- 550	4,0- 5,0	3,4- 4,0	72   96   100   110   120   126   128   132
600- 750	4,5- 6,5	4,0- 5,0	48   50   56   60   72   80   90   100   120   140   150
770- 870	6,0- 8,2	5,0- 6,0	48   50   60   72   80   90   100   120   144   154
900- 960	7,0- 8,0	5,5- 6,0	50   54   60   72   80   90   120   140   180
1000-1060	6,0- 8,5	5,0- 6,5	40   50   60   70   80   90   100   120   144   160   200
1120-1160	6,5- 8,5	5,0- 6,0	54   60   70   80   90   100   120   130   140   154   180
1250-1270	8,0-11,0	6,0- 8,0	50   54   56   60   72
1300-1370	8,2- 9,0	6,8- 7,5	54   60   68   100   120   140   160   180
1400-1470	9,0-11,0	7,0- 9,0	50   54   60
1500-1650	8,8-11,0	7,5- 9,0	50   54   60   66
1700-2200	10,5-12,5	9,0-10,5	50   54   60

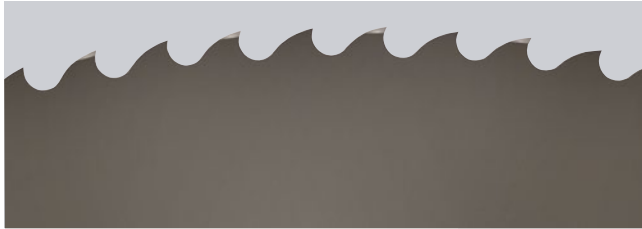
Abweichende Durchmesser, Schnittbreiten und Zähnezahlen auf Anfrage lieferbar.



## HSS-Segmental Circular Saw Blades

- available in HSS - DMo5 or HSS - E-Mo5Co5, with and without cooling slots

Diameter mm	Kerf mm	Body thickness mm	Number of teeth Z Tooth pitch T mm	Number of teeth per segment							
				2	3	4	5	6	8	10	12
275	3,0	2,2	Z T				60 14,4	72 12,0	96 9,0	120 7,2	144 6,0
315	3,6	3,0	Z T			56 17,7	70 14,1	84 11,8	112 8,8	140 7,1	168 5,9
360	3,6	2,8	Z T			64 17,7	80 14,1	96 11,8	128 8,8	160 7,1	192 5,9
370	3,6	2,8	Z T			64 18,2	80 14,5	96 12,1	128 9,1	160 7,3	192 6,1
400	4,0	3,2	Z T			64 19,6	80 15,7	96 13,1	128 9,8	160 7,9	192 6,5
425	4,0	3,2	Z T			72 18,5	90 14,8	108 12,4	144 9,3	180 7,4	216 6,2
450	4,0	3,3	Z T			72 19,6	90 15,7	108 13,1	144 9,8	180 7,9	
460	4,7	3,3	Z T			72 20,1	90 16,1	108 13,4	144 10,0	180 8,0	216 6,7
500	5,0	3,8	Z T		54 29,1	72 21,8	90 17,5	108 14,5	144 10,9	180 8,7	216 7,3
520	5,7	4,0	Z T			72 22,7	90 18,2	108 15,1	144 11,3	180 9,1	216 7,6
560	5,0	3,7	Z T			72 24,4	90 19,5	108 16,3	144 12,2	180 9,8	216 8,1
570	5,7	4,0	Z T			72 24,9	90 19,9	108 16,6	144 12,4	180 9,9	216 8,3
630	6,0	4,0	Z T		60 33,0	80 24,7	100 19,8	120 16,5	160 12,4	200 9,9	
660	6,0	4,0	Z T		60 34,6	80 25,9	100 20,7	120 17,3	180 13,0	200 10,4	240 8,6
710	6,0	4,5	Z T		72 31,0	96 23,2	120 18,6	144 15,5	192 11,6		
760	6,0	4,5	Z T		72 33,2	96 24,9	120 19,9	144 16,6	192 12,4	240 9,9	
800	7,0	5,0	Z T		72 34,9	96 26,2	120 20,9	144 17,5	192 13,1	240 10,5	
910	7,0	5,0	Z T	60 47,6	90 31,8	120 23,8	150 19,1	180 15,9	240 11,9		
1020	8,3	6,2	Z T	60 53,4	90 35,6	120 26,7	150 21,4	180 17,8	240 13,4		
1120	8,5	6,5	Z T	72 48,9	108 32,6	144 24,4	180 19,5	216 16,3			
1250	9,0	7,0	Z T	72 54,5	108 36,4	144 27,3	180 21,8	216 18,2	288 13,6		
1320	9,0	7,0	Z T	72 57,6	108 38,4	144 28,8	180 23,0	216 19,2	288 14,4		
1430	9,5	7,0	Z T	72 62,4	108 41,6	144 31,2	180 25,0	216 20,8	288 15,6		
1510	10,5	8,5	Z T	72 65,9	108 43,9	144 32,9	180 26,4	216 22,0			
1610	10,5	8,5	Z T	80 63,2	120 42,1	160 31,6	200 25,3	240 21,1			
1870	15,0	11,0	Z T	84 69,9	126 46,6	168 35,0					



## HSS-Metal Circular Saw Blades

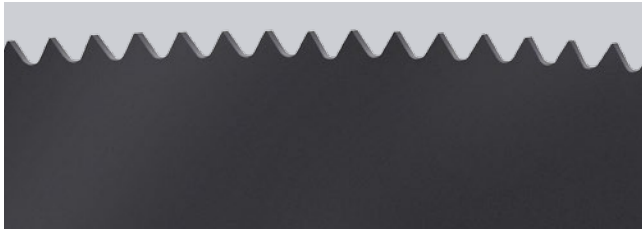
- steam-treated, PVD-coated or polished
- made of HSS - DMo5 or HSS - E-Mo5Co5
- available in tooth forms C (triple chip), BW (beveled arc tooth) and BR (chip breaker)

Dimensions mm	Pinholes mm	Tooth pitch / Number of teeth										
		3 mm	4 mm	5 mm	6 mm	7 mm	8 mm	9 mm	10 mm	12 mm	14 mm	16 mm
200 x 1,8 x 32	2/8/45+2/11/63+4/9/50	200	160	130	100		80					
210 x 2,0 x 32	2/8/45+2/11/63	210	160	140	110		80					
225 x 2,0 x 32	2/8/45+2/11/63+4/9/50	220	180	140	120		90					
225 x 2,0 x 40	2/8/55+4/12/64	220	180	150	120		90					
250 x 2,0 x 32	2/8/45+2/12/64+4/9/50	240	200	160	128	110	100		80			
250 x 2,0 x 40	2/8/55+4/12/64	240	200	160	128	110	100		80			
250 x 2,5 x 32	2/8/45+4/9/50+2/12/64	240	200	160	128	110	100		80			
250 x 2,5 x 40	2/8/55+4/12/64	240	200	160	128	110	100		80			
275 x 2,0 x 32	2/8/45+4/9/50+2/12/64	280	220	180	140	120	110	96	90	72		
275 x 2,0 x 40	2/8/55+4/12/64	280	220	180	140	120	110	96	90	72		
275 x 2,5 x 32	2/8/45+4/9/50+2/12/64	280	220	180	140	120	110	96	90	72		
275 x 2,5 x 40	2/8/55+4/12/64	280	220	180	140	120	110	96	90	72		
275 x 3,0 x 40	2/8/55+4/12/64	280	220	180	140	120	110	96	90	72		
300 x 2,5 x 32	2/8/45+4/9/50+2/12/64		220	180	160	140	120	100	94			
300 x 2,5 x 40	2/8/55+4/12/64		220	180	160	140	120	100	94			
300 x 3,0 x 40	2/8/55+4/12/64		220	180	160	140	120	100	94			
315 x 2,5 x 32	2/8/45+4/9/50+2/12/64		240	200	160	140	120		100	80		
315 x 2,5 x 40	2/8/55+4/12/64		240	200	160	140	120		100	80		
315 x 3,0 x 32	2/8/45+4/9/50+2/12/64		240	200	160	140	120		100	80		
315 x 3,0 x 40	2/8/55+4/12/64		240	200	160	140	120		100	80		
315 x 3,0 x 50	4/15/80+4/14/85		240	200	160	140	120		100	80		
325 x 3,0 x 40	2/8/55+4/12/64		250	200	170	146	128					
350 x 2,5 x 32	2/8/45+4/12/64+2/12/75		280	220	190	160	140	120	110	90	80	70
350 x 2,5 x 40	2/8/55+4/12/64		280	220	190	160	140	120	110	90	80	70
350 x 2,5 x 50	4/15/80+4/14/85		280	220	190	160	140	120	110	90	80	70
350 x 3,0 x 32	2/8/45+4/12/64+2/12/75		280	220	190	160	140	120	110	90	80	70
350 x 3,0 x 40	2/8/55+4/12/64		280	220	190	160	140	120	110	90	80	70
350 x 3,0 x 50	4/15/80+4/14/85		280	220	190	160	140	120	110	90	80	70
370 x 3,0 x 32	2/8/45+4/12/64+2/12/75		280	220	190	160	140	120	110	100	80	
370 x 3,0 x 40	2/15/80+4/12/64+2/9/55		280	220	190	160	140	120	110	100	80	
370 x 3,0 x 50	4/15/80+4/14/85		280	220	190	160	140	120	110	100	80	
400 x 3,0 x 40	2/15/80+4/12/64+2/15/100			250	200	180	160	140	120	100	96	80
400 x 3,0 x 50	4/15/80+4/14/85			250	200	180	160	140	120	100	96	80
400 x 3,5 x 40	2/15/80+4/12/64+2/15/100			250	200	180	160	140	120	100	96	80
400 x 3,5 x 50	4/15/80+4/14/85			250	200	180	160	140	120	100	96	80
400 x 4,0 x 40	2/15/80+4/12/64+2/15/100			250	200	180	160	140	120	100	96	80
400 x 4,0 x 50	4/15/80+4/14/85			250	200	180	160	140	120	100	96	80
425 x 3,5 x 40	2/15/80+4/12/64+2/15/100			260	220	190	160		130		96	
425 x 3,5 x 50	4/15/80+4/14/85			260	220	190	160		130		96	
425 x 4,0 x 40	2/15/80+4/12/64+2/15/100			260	220	190	160		130		96	
425 x 4,0 x 50	4/15/80+4/14/85			260	220	190	160		130		96	
450 x 3,5 x 40	2/15/80+4/12/64+2/15/100				230	200	180		140	120	100	90
450 x 3,5 x 50	4/15/80+4/18/100				230	200	180		140	120	100	90
450 x 4,0 x 40	2/15/80+4/12/64+2/15/100				230	200	180		140	120	100	90
450 x 4,0 x 50	4/15/80+4/18/100				230	200	180		140	120	100	90
470 x 4,0 x 40	2/15/80+4/12/64+2/15/100					200	180	170	150	120	100	90
500 x 4,0 x 40	2/15/80+4/12/64+2/15/100		390	310	260	230	200		160			

Further diameters, cutting widths and numbers of teeth are available upon request.

DIN metal circular saw blades Ø 20 x 0,2 to Ø 315 x 6,0 mm also available in tooth forms A (angle tooth), B (arc tooth) and C (triple chip).

## Hot and Friction Circular Saw Blades



- hot circular saw blades for cutting hot steels > 700°C
- friction circular saw blades for cutting cold steels < 250°C
- tooth shapes: parrot tooth, pendulum tooth or according to customer specifications
- available in black rolled, taper or conical ground
- normalized, hardened or tooth-hardened up to 50-55 HRC 75

Diameter mm	Kerf mm	Number of teeth
550- 680	4,0- 6,0	180   240   300
700- 900	5,0- 6,0	140   180   200   280   300   320
900-1190	5,0- 8,0	144   160   210   250   280   300   360
1200-1350	7,0- 8,5	160   218   250   260   280   312
1400-1520	8,0-10,0	180   191   214   224   240   332
1600-1780	8,0-12,0	280   295   332   400
1800-2000	8,0-14,0	288   300   393   476   450   534
2100-2500	13,0-16,0	380   420   500   580

Further diameters, cutting widths and numbers of teeth are available upon request.

## Standard Friction Circular Saw Blades



- tooth shape: parrot tooth
- made of 1.2235 (CV) or alternatively 1.2604 (WoMo)
- fully hardened to 45 +/- 2 HRC
- conical ground with flange

Diameter mm	Kerf mm	Number of teeth
300-400	2,5- 4,0	200   220   240   300
450-500	2,5- 6,0	240   300
520-560	3,0- 6,0	300
580-650	4,0- 6,0	300
700-750	4,0- 7,0	300   350   400
800-850	5,0- 8,0	300   350   380   400
900	6,0- 8,0	320   350   400
1000	7,0-10,0	320   400   450

Further diameters, cutting widths and numbers of teeth are available upon request.

Parrot tooth



Pendulum tooth



## Recording form for circular sawblades

### Customer information

Company: \_\_\_\_\_ Complete by / date: \_\_\_\_\_  
 Street: \_\_\_\_\_ Contact person: \_\_\_\_\_  
 Postcode / city: \_\_\_\_\_ Phone: \_\_\_\_\_  
 State: \_\_\_\_\_ Fax: \_\_\_\_\_  
 Email: \_\_\_\_\_

### Sawing machine

Manufacturer: \_\_\_\_\_ Year of construction: \_\_\_\_\_  
 Machine type: \_\_\_\_\_

### Sawblade

- Carbide - thin kerf blade       Segmental sawblade       Friction sawblade  
 Carbide - standard blade / for steel       HSS metal sawblade       Hot sawblade  
 Carbide - standard blade / for non-ferrous

Type (for example PVD coated, steam treated, conical ground): \_\_\_\_\_  
 Blade diameter / kerf: \_\_\_\_\_ Bore / pin holes: \_\_\_\_\_  
 Number of teeth / tooth shape: \_\_\_\_\_ Description: \_\_\_\_\_  
 Cooling lubricant:     Oil emulsion     Microspray system     Dry cutting  
 Blade life: \_\_\_\_\_ cuts      \_\_\_\_\_ m<sup>2</sup>

### Cutting data

Cutting speed rate: \_\_\_\_\_ m/min.      Number of revolutions: \_\_\_\_\_ RPM  
 Feet rate: \_\_\_\_\_ mm/min.      Feed per tooth: \_\_\_\_\_ mm

### Workpiece

Shape (for example round, square, rectangular, tube, profile, beam): \_\_\_\_\_  Single cut  
 \_\_\_\_\_  Cut in layer  
 Dimension (for example diameter, width x height, diameter x wall thickness): \_\_\_\_\_  Bundled cut  
 \_\_\_\_\_

### Material

Material grade: \_\_\_\_\_ Strength / hardness: \_\_\_\_\_  
 Material no.: \_\_\_\_\_ International standard: \_\_\_\_\_  
 Material surface:     Heat waste / casting skin     Bright     Forged

### Remarks

\_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_



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