

# FACT BOOK BAND SAW BLADES

Edition 2024

Made in Germany

# **HIGH PERFORMANCE BAND SAW BLADES**

Made in Germany



## SAWING TECHNOLOGY IS OUR PASSION

We are an internationally positioned manufacturer and trend-setting technologist of high-end Band Saw Blades. We specialise in customised solutions for cutting metals and all common construction and insulating materials.

For 230 years, ARNTZ has been a plannable partner for a wide range of industries – from steel construction and light metal casting to aerospace. Being a 7th generation family-owned company, we speak from experience and use our technical know-how for cutting-edge product developments, always standing by our customers' side.

Our sales engineers know the special features and requirements of the most diverse band saw machines and solve your sawing tasks with passion. Three modern production sites and an international sales network guarantee our comprehensive service, even in your vicinity.

The ARNTZ expert team provides you with close support at all levels of the purchasing process and beyond. We regularly provide training on basic questions all the way to fine-tuning your cutting process.

Your goal is our motivation!





## Facts and figures

- > Owner-managed in 7th generation
- > 180 employees
- > 230 years of metal processing
- > Manufacturer of high-performance Band Saw Blades with three production sites
- International distribution network
- > Export ratio over 70%
- > Concept solutions for the specialised trade
- > Supplier of Power Tool Accessories





Johann Wilhelm Arntz

\*1736 † 1834



Johann Ferdinand Arntz

\*1806 + 1867



Johann Wilhelm Arntz

\*1846 + 1908

Johann Wilhelm Arntz

\*1873 + 1932





Johann Wilhelm Arntz \*1908 + 1957

Johann Wilhelm Arntz \*1939 + 2021



## At your side worldwide







one of the largest welding centres in Europe

# **PRODUCTION** Bi-Metal and Carbide Tipped Band Saw Blades

ARNTZ Band Saw Blades undergo a consistent quality control throughout each stage of the production process. The right choice of materials, precise tooth manufacturing, and the utilization of dependable welding procedures are critical factors in the production of Band Saw Blades with high performance and long blade life.







## WELDING CENTRE Schmölln

With the move into our new facility, one of the largest welding centres in Europe has been established. Expert knowledge and state-of-the-art IDEAL welding machines create an inseparable connection while adhering to the highest quality standards. ARNTZ endless welded Band Saw Blades are characterised by consistency and linearity at the welding point, providing process reliability.















# THE RIGHT BREAK-IN Guarantee for extended blade life

ARNTZ Band Saw Blades should be adhered to a special break-in procedure for extended blade life, less blade changes and best payback of your tool cost. Overload of the razor-sharp tooth tips should be avoided at the start of the cutting operation. Aggressive cutting with a new blade will lead to premature tooth breakages. Correct break-in will control the gentle rounding of the cutting edges.

## **Bi-Metal Band Saw Blades**

Starting feed should be half of final feed rate at the recommended cutting speed for the first 300 – 500 cm<sup>2</sup> cutting surface. After that, feed rate should be gradually increased to the maximum cutting rate. In case vibrations or noises should occur at the beginning of the cutting operation, the cutting speed should be slightly adjusted.

## Carbide Tipped Band Saw Blades

Depending on the material, we recommend the following parameters for break-in during the first at least 30 minutes:

Material cross-section up to 600 mm	Cutting speed = Feed =	30 m/min 5 mm/min
Material cross-section over 600 mm	Cutting speed = Feed =	25 m/min 3 mm/min

Only when the Band Saw Blades are cutting without any vibrations, cutting speed and feed can be increased step by step to the maximum. The blades are working perfectly when no audible vibration appears.







## SYMBOL EXPLANATION

## ARTICLE GROUPS AT A CLANCE

## C-TEC: The optional coating – highest performance for your Band Saw Blade



from 41 mm blade width

High cutting speeds and feeds can lead to premature wear of the tooth cutting edges during sawing. Applying a hard coating protects the saw blade from wear, heat and friction and supports performance. ARNTZ C-TEC is an aluminium titanium nitride (AITiN) coating specially developed for high performance sawing and helps to make your sawing process significantly more efficient.

## **R-TEC**:

The optional blade back - ramp-shaped ground for more power

R-TEC optional from 41 mm saw band width 

The second generation with improved ramp design for individual solutions in demanding sawing applications.

- > Increases the cutting performance without additional feed pressure of the sawing machine
- > Individual ramp definition
- > Improved ramp design for faster and straighter cutting
- > Precise machining of the saw band back reduces the load on the carrier band and increases the blade life
- > Enables sawing of a wider range of workpiece dimensions

## WS:

## Wide set for larger cutting width



- > Band Saw Blades in this special design have a particularly wide tooth restriction and thus a larger cutting width
- > Prevents jamming of the saw blade in the cutting channel for wide and thick-walled steel profiles, bundle cuts, and materials with residual stress.

	Workpiece
٠	Solid material round small
	Solid material round medium
	Solid material round large
S	Solid material special alloy
	Solid material rectangular large
	Metal sheet
0	Round tube thick-walled
0	Small round tube thin-walled
	Tube bundle
0	Round tube normal wall
	Square tube
Н	Normal steel beam
Н	Wide steel beam
Н	Thick-walled steel beam
	U-steel
	Larger bundle packages
$\wedge$	L-steel
0	Surface-hardened material
Ĩ	Block, perforated and plane bricks
ſ	Aerated concrete, gas concrete, insulating material, insulation boards
	Wooden pallet

Performance level	Article G	iroup C-TEC	Designation		The specialist for Material cross-section		Page
	couled	courcu	<b>BI-METAL BAND S</b>	AW BLADES			
Standard	431		SPRINT-PLUS		Solid material, profile		17
Universal use at a good price-performance ratio	457		X-FIT		Mix	Η • (	18
Professional Professional sawing of	445	845	PROFILER		Profile		19
large steel construction profiles and hard materials	544		BLIZZARD		Solid material	5 0 (	20
	440	840	X-CELL		Solid material		21
Protessional Plus High-performance sawing	437	837	TYPHOON	ground ✓	Solid material		22
-	537	<mark>867</mark>	TYPHOON-MAXIMA	ground V	Solid material	<b>S</b>	23
Basic The less expensive	401		BASIC-PLUS		Solid material, profile		24
alternative to our Made in Germany products	402		BASIC-GP		Mix	Η • (	25
			CARBIDE TPPED B	and saw blade	S		
Standard	626	826	BLACK-LINE-GP	Triple chip geometry	Universal use		28
universal application	627	827	Q-LINE	Multi chip geometry	Universal use		29
Professional Professional sawing	622	822	BLACK-LINE-S	Triple chip set	Difficult to cut and abrasive materials		30
of difficult to cut materials and non-ferrous metals	643		BLUE-LINE	Triple chip geometry	Non-ferrous metals and graphite		31
Professional Plus	650	850	SILVER-LINE	Multi chip geometry	High-alloy steels and non- ferrous metals		32
High-performance sawing	651		SILVER-LINE-N	Multi chip geometry negative	Extremely hard or surface hardened materials		33
			OTHER APPLICATIO	ONS			
	623		STONE-LINE-S	Set	Building and insulating materials		34
	621		STONE-LINE-RT	Multi chip geometry	Building and insulating materials		35
	490		PAL-CUT		Wooden pallets		36
			CARBON BAND SA	W BLADES			
	100		CS-1	Flexible back			37
	110		CS-2-PLUS	Spring hardened and tempered back			37
			PROFESSIONAL AC	CESSORIES			
			Blade Tension Mete	er, Refractometer,	Application Toolkit		38
			POWER TOOL ACCE	SSORIES			
			Hole saws, hole saw circular saw blades, p	set, annular cutter, a ower hacksaw blad	annular cutter set, recipro es, hand hacksaw blades	cating saw blade , cooling lubrica	es, 39 Its

### Arntz. 14

## **BI-METAL – WHY SO SUCCESSFUL?**

Material1.3247 Hardness approx. 68 - 69 HRC

## M51

Material 1.3207 Hardness approx. 69 HRC, with high tungsten and cobalt content.

# HSS flat wire



# HIGHLY FLEXIBLE

The backer of the Bi-Metal Band Saw Blade is made of specially alloyed spring steel. Highly flexible with a strength of approx. 50 HRC.

## HARD AND RESISTANT

Tooth tips made from hardened HSS in gualities M42 and powder metallurgical M51 ensure the highest wear resistance due to an extensive heat treatment.

## OPTIMALLY CONNECTED

The backer and the HSS flat wire are undetachably welded together by a special electron or laser beam welding process.

## ADVANTAGES

The high-quality Bi-Metal Band Saw Blade combines the flexibility of the spring steel backer with the enormous wear resistance of the high speed steel. Each tooth tip of the finished band is made of hardened HSS, extremely durable for best performance. TOOTH SET -WHAT GROUPS AND WAVES DO

Beside the tooth pitch and the tooth form, the exact setting is essential for the performance of the sawblade. The correct clearance results from the corresponding setting. It avoids blade pinching, which is especially important in problematic steels. Width and type of set are precisely tailored to the cutting application.

### Standard raker set

Standard group set

Variable group set

Wavy set





Blade backer made of alloyed spring steel





## CORRECT TOOTH PITCH – OPTIMUM PERFORMANCE

## **BI-METAL BAND SAW BLADES**

The choice of the correct toothing for the material cross section to be cut is decisive for the optimum use of a Bi-Metal Band Saw Blade.

The combi-tooth with variable tooth pitch is recommended for low-vibration sawing. Vibration resonances are reduced.

Variable tooth pitch			
Cross section	Teeth per inch		
mm	tpi		
from 550	0,75/1,25		
380 - 750	1/1,3		
250 - 550	1,4/2		
120 - 350	2/3		
80 - 140	3/4		
60 - 110	4/6		
40 - 70	5/7 5/8		
30 - 60	6/10		
20 - 40	8/11 8/12		
to 25	10/14		

Toothing recommendation for solid material

## Article group 431

## **SPRINT-PLUS**

- The classic with a wide range of applications for plannable cutting costs and reproducible results
- Extensive toothing selection with neutral and positive rake angle for all common material cross-sections

## Toothing recommendation for profiles

Thin-walled profiles									
Wall thickness	Profile outer diameter in mm								
in mm	20	40	60	80	100	120	150		
2	14	14	14	14	14	14	10/14		
3	14	14	14	14	10/14	10/14	8/11 8/12		
4	14	14	10/14	10/14	8/11 8/12	8/11 8/12	6/10		
5	14	10/14	10/14	8/11 8/12	8/11 8/12	6/10	6/10		
6	14	10/14	8/11 8/12	8/11 8/12	6/10	6/10	5/7 5/8		
8	14	8/11 8/12	6/10	6/10	5/7 5/8	5/7 5/8	5/7 5/8		
10	-	6/10	6/10	5/7 5/8	5/7 5/8	5/7 5/8	-		

Especially when cutting profiles, the choice of toothing has a decisive influence on the sawing result. The variable tooth pitch has proven to be the ideal toothing. The required tooth pitch depends on the wall thickness and diameter of the profiles to be cut. The tables apply to single cuts. If two or more profiles are cut next to each other, the tables apply taking into account two times the wall thickness with a single profile outer diameter.

Thick-walled profiles									
Wall thickness	Profile outer diameter in mm								
in mm	80	100	120	150	200	300	500	750	
10	-	-	-	4/6	4/6	4/6	3/4	2/3	
15	4/6	4/6	4/6	4/6	4/6	3/4	2/3	2/3	
20	4/6	4/6	4/6	4/6	3/4	3/4	2/3	2/3	
30	4/6	4/6	4/6	3/4	3/4	2/3	2/3	2/3	
50	-	-	3/4	3/4	2/3	2/3	2/3	1,4/2	
80	-	-	-	-	2/3	2/3	1,4/2	1,4/2	
100	-	-	-	-	-	2/3	1,4/2	1,4/2	

ARNTZ Bi-Metal Band Saw Blades are supplied as endless welded loops to fit your band saw machines, or in coils.Coils can be delivered in different coil length. Please notice that the minimum order quantities refer to the production length.6-13 mm in length of approx 30+76 m20-34 mm in length of approx 100 m54-67 mm in length of approx 90 m80 mm in length of approx 40 m



Dimensions	;	Tooth													
mm	inch	0,75/1,25	1,4/2	2/3	3	3/4	4	4/6	6	5/8	6/10	8/12	10/14	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							-		•					
54 x 1,30	2 x 0,050														
54 x 1,60	2 x 0,063		•	•		-		-							
67 x 1,60	2 5/8 x 0,063														
80 x 1,60	3 x 0,063		•												



## Standard





## **BI-METAL BAND SAW BLADES**

Standard

## **BI-METAL BAND SAW BLADES**

## Article group 457

## **X-FIT**

- > The all-rounder with particularly strong tooth back for use in mixed operation
- > Longer blade life
- Reduced blade changes
- > Lower inventory costs





Dimensions		Tooth				
mm	inch	2/3	3/4	4/6	5/7	8/11
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					

## Article group 445 845 C-TEC

## **PROFILER**

- > The powerhouse for machining large profiles and beams
- > Extended blade life due to robust tooth design even in bundle cutting with chip nests
- > Extra wide set prevents jamming in materials with high residual stress



Dimensions		Tooth	
mm	inch	2/3	3/4
54 x 1,60	2 x 0,063		• •
67 x 1,60	2 5/8 x 0,063	• •	
Coated variant C-TEC op	otional		



Professional





## **BI-METAL BAND SAW BLADES**

## Article group 544

## **BLIZZARD**

- > The high-performance Band Saw Blade for demanding materials up to 1700 N/mm<sup>2</sup> tensile strength
- > Aggressive cutting angle enhances cutting performance



S **R-TEC** optional  M51

Professional

Dimensions Tooth 0,75/1,25 1/1,3 mm inch 1,4/2 2/3 3/4 4/6 5/8 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 0,063 67 x 1,60 2 5/8 x 0,063 80 x 1,60 3 x 0,063 Ramping technology R-TEC optional

## Article group 440 840 C-TEC

## **X-CELL**

- > The new limit pusher for high-performance cutting processes where conventional M42 qualities fall short
- > Especially robust tooth design and newly developed aggressive tooth geometry
- > Extra-large chip chamber volume for higher machining rates





Dimensions	Tooth					
mm	inch	0,75/1,25				
41 x 1,30	1 1/2 x 0,050					
54 x 1,60	2 x 0,063					
67 x 1,60	2 5/8 x 0,063	■* ■				
80 x 1,60	3 x 0,063	■* ■				

ted variant C-IEC optional / Ramping technology R-IEC op



## Professional Plus



Professional Plus

## **BI-METAL BAND SAW BLADES**

## Article group 437 837 C-TEC

## **TYPHOON**

- > The powerhouse with ground tooth tips for robust performance in versatile applications on steels and non-ferrous metals up to 1400 N/mm<sup>2</sup> tensile strength
- > Excellent cutting surfaces and precise cuts



0

**R-TEC** optional

M42

C-TEC optional haaaaa

Dimensions		Tooth				
mm	inch	0,75/1,25	1/1,3	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 0,063					
67 x 1,60	2 5/8 x 0,063		• •	• •	• •	
80 x 1,60	3 x 0,063					
80 x 1,60 Coated variant C-TE	3 x 0,063 C optional / Ramping technolo	ogy R-TEC optional	•••	• •		

## Article group 537 867 C-TEC

## **TYPHOON-MAXIMA**

- > The top-tier of high-performance Band Saw Blades with ground teeth and extremely aggressive tooth geometry for materials up to 1700 N/mm<sup>2</sup> tensile strength
- > Bi-Metal Band Saw Blade delivering carbidelevel performance for heavy-duty cutting tasks on machines without carbide package
- > Straight cuts with increased throughput, impressive machining rates and faster feeds



Dimensions		Tooth						
mm	inch	0,75/1,25						
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 0,063							
67 x 1,60	2 5/8 x 0,063	• •						
80 x 1,60	3 x 0,063	• •						
Costod variant CTEC or	Control variant (TEC antianal / Damaing technology DTEC antianal							



## Professional Plus



**R-TEC** optional

1/1,3	1,4/2	2/3
• •		
• •		
• •		



Basic

## **BI-METAL BAND SAW BLADES**

## Article group 401

## **BASIC-PLUS**

- > The budget-friendly choice with a wide range of tooth profiles
- > Versatile application for thin-walled profiles up to large solid material workpieces





Dimensions		Tooth									
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14
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 0,063										
67 x 1,60	2 5/8 x 0,063										
80 x 1,60	3 x 0,063	-	-	•							

## Article group 402

## **BASIC-GP**

- > The budget-friendly multitool with a robust tooth design for varying cutting tasks
- > Saves inventory costs with extended tool life in mixed operations
- Reduced blade changes





Dimensions		Tooth		
mm	inch	2/3	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 0,063		•	
67 x 1,60	2 5/8 x 0,063		•	



## **EXTREMELY POWERFUL**

Our Carbide Tipped Band Saw Blades are true high-performance professionals, developed for absolutely clean and smooth results under extreme cutting conditions.



### FLEXIBLE:

# PRECISELY GROUND:

The blade backer consists of a specially alloyed spring steel and forms the optimal foundation for high-performance cutting.

## PERFECTLY CONNECTED:

Each ARNTZ Band Saw Blade undergoes a specialized process in which the highly wear-resistant carbide teeth are securely bonded to the backing strip through welding techniques.

TARGETED: The carbide tipped tooth tips work highly efficiently and achieve up to 3 times higher cutting performance in low-vibration cuts.

## THE RIGHT APPLICATION:

For optimum performance, ARNTZ Carbide Tipped Band Saw Blades should be used on bandsaw machines specially designed for this purpose.

The subsequent grinding processes are crucial to ensure the correct tooth geometry and excellent performance.

ARNTZ Carbide Tipped Saw Blades are supplied as endless welded loops, customfit for your sawing machine, or in coils: 27 – 80 mm in lengths of approx. 50 meters

Arntz.



## CARBIDE TIPPED BAND SAW BLADES

Standard

## CARBIDE TIPPED BAND SAW BLADES

## Article group 626 826 C-TEC

## **BLACK-LINE-GP**

- > The Carbide Tipped all-rounder with a robust triple chip geometry
- > Consistent performance with changing materials





C-TEC optional	R-TEC optional

Dimensions		Tooth			
mm	inch	0,75/1,25	1/1,5	1,4/2	2/3
41 x 1,30	1 1/2 x 0,050				
54 x 1,60	2 x 0,063				
67 x 1,60	2 5/8 x 0,063	• •			
80 x 1,60	3 x 0,063	• •			
	ntional / Pamping tochnolog	PTEC optional			

## Article group 627 827 C-TEC

## **Q-LINE**

- > The universal talent with precision-ground multichip geometry
- Perfectly matched rake angle for exceptional tooth stability at high machining rates





-	<b>C</b>	c

Dimensions		Tooth	
mm	inch	0,75/1,25	1
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 0,063	• •	
67 x 1,60	2 5/8 x 0,063		
80 x 1,60	3 x 0,063	• •	
Coated variant C-TEC o	ptional		



Standard

# - to the planted -

1,4/2 2/3 /1.5 3/4 . . 

Professional

## CARBIDE TIPPED BAND SAW BLADES

## Article group 622 822 C-TEC

## **BLACK-LINE-S**

- > The professional with precisely set teeth > Extended free cut prevents jamming in
- materials with significant residual stress
- > Applicable on machines with and without carbide software



**R-TEC** optional



-						
Dimensions		Tooth				
mm	inch	0,75/1,25	1,4/2	2/3	3	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 1,30	2 x 0,050					
54 x 1,60	2 x 0,063					
67 x 1,60	2 5/8 x 0,063					
80 x 1,60	3 x 0,063					

Coated variant C-TEC optional / Ramping technology R-TEC optional

## Article group 643

## **BLUE-LINE**

> The specialist for non-ferrous metals and graphite with triple chip geometry > Cutting edges with the special grind





Abmessung		Tooth					
mm	inch	0,65/0,95	0,75/1,25	1,4/2	2/3	3	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 1,30	2 x 0,050			•			
54 x 1,60	2 x 0,063				•		
67 x 1,60	2 5/8 x 0,063						
80 x 1,60	3 x 0,063	•					



## Professional



Professional Plus

## CARBIDE TIPPED BAND SAW BLADES

## Article group 650 850 C-TEC

## **SILVER-LINE**

- > The champion with complex multi chip geometry for highest demands
- > Best performance rates in extremely difficultto-machine materials up to 1900 N/mm<sup>2</sup> tensile strength
- > Precision-ground teeth with aggressive rake angle







Dimensions		Tooth				
mm	inch	0,75/1,25	1/1,5	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 0,063	• •	• •	• •	• •	
67 x 1,60	2 5/8 x 0,063	• •				
80 x 1,60	3 x 0,063	• •		• •		
Coated variant C-TEC o	ptional / Ramping technolog	gy R-TEC optional				

## Article group 651

## **SILVER-LINE-N**

- > The expert for surface hardened workpieces
- > Special blade with negative rake angle and multi chip geometry for highest cutting performance



Dimensions		Tooth
mm	inch	1,4/2
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 0,050	



## Professional Plus



2/3	3/4



## **OTHER APPLICATIONS**

## **OTHER APPLICATIONS**

## Article group 623

## **STONE-LINE-S**

- > The confident choice for softer construction materials like aerated concrete, insulation boards, and insulating materials
- > Set Carbide Tipped Band Saw Blade with wide clearance reduces jamming and buildup of deposits





Dimensions		Tooth				
mm	inch	3				
27 x 0,90	1 x 0,035	•				

## Article group 621

## **STONE-LINE-RT**

- > The master for hard and abrasive construction materials like solid, engineered, and perforated bricks
- > Vibration-free cutting with reduced force required due to high-performance, precisionground tooth geometry
- Perfect cutting results



Dimensions		Tooth
mm	inch	2/3
27 x 0,90	1 x 0,035	
34 x 1,10	1 1/4 x 0,042	

## Carbide Tipped



## Carbide Tipped





Bi-Metal

## CARBON STEEL BAND SAW BLADES

## Article group 490

## **PAL-CUT**

- > The rustic for repair and dismantling of wooden pallets
- > Special tooth geometry guarantees constant performance while sawing through nails and staples





Dimensions		Tooth
mm	inch	5/8
34 x 1,10	1 1/4 x 0,042	

## Article group 100 **CS-1**

Dimensions		Tooth									
mm	inch	3	4	4	6	6	8	10	14	18	24
6 x 0,65	1/4 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										
Neutral rake angle Positive rake angle *= Special item											

## Article group 110 **CS-2-PLUS**

Dimensions		Tooth									
mm	inch	3	4	4	6	6	8	10	14	18	24
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								•		
Neutral rake angle Positive rake angle *= Special item							ecial item				

Neutral rake angle
Positive rake angle

## 

Flexible band back in pin-point quality with hardened teeth. Suitable for everyday workshop purposes.

Spring hardened backer with hardened teeth. For increased wear resistance and long tool life.

## Arntz

## **PROFESSIONAL ACCESSORIES**



## Tension measuring device

Wrong tension of band can be the reason for crooked cuts or can cause blade breakage. Therefore, the band tension should be checked frequently. Detailed instructions explain how to select and control the right tension of the band saw blade.



## Refractometer

The correct concentration of cooling liquid is important for optimum life time of ARNTZ Band Saw Blades. To check the right concentration of liquid while operating it is recommended to use the ARNTZ Refractometer.



## Application toolkit

Making sure your blade runs under perfect conditions. Featuring: Tension measuring device, refractometer, tacho-meter, accessories and more.

Phone +49(0)2191.9986-01





## Head quarters









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