

Arntez

Passionate
Cutting!

Edition 2019

FactBook

BAND SAW
BLADES

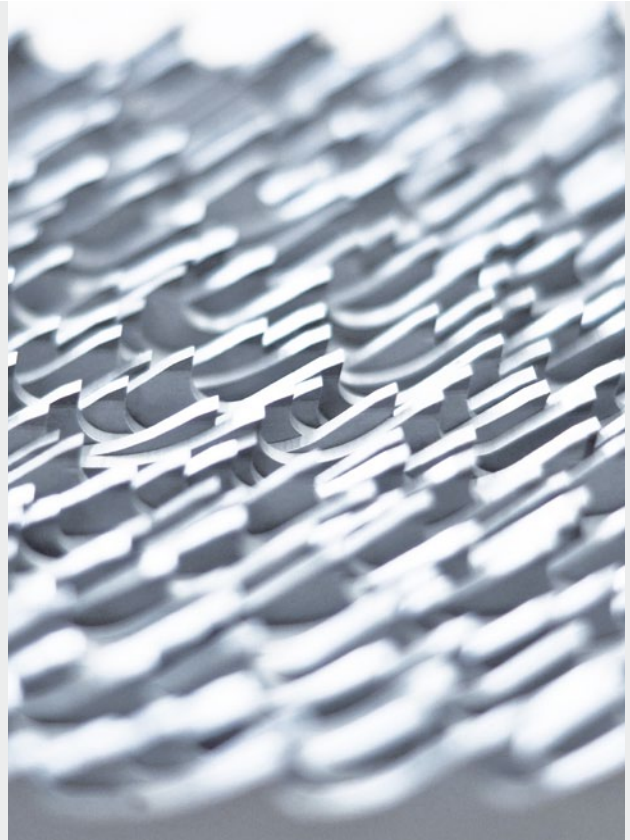
Welcome to ARNTZ

Your cutting expert for the entire world of metals.

225 years of manufacturing, 225 years of tools, 225 years of passion: We are proudly looking back on a long tradition while facing the future with excitement. Complex materials are opening up new markets and alloys are developing along with higher requirements of their products behind. This requires new and innovative cutting solutions. Our specialists are being challenged with the demands of many different markets – daily. We are familiar with the materials and their cross sections – over all industries and down to the detail.

Our operational structures allow us to quickly and individually address the individual need of our customers and develop optimal solutions close to you. We will assist you from the first question up to fine-tuning. Even at your site if required.

Saw blades from ARNTZ are high-performance tools – economical, precise and perfectly matched to the relevant application. Our actions are guided by our high quality standards and our passion for what we do. We deliver sawing technology „Made in Germany“ that you can depend on worldwide – promised!



Innovative cutting technology...

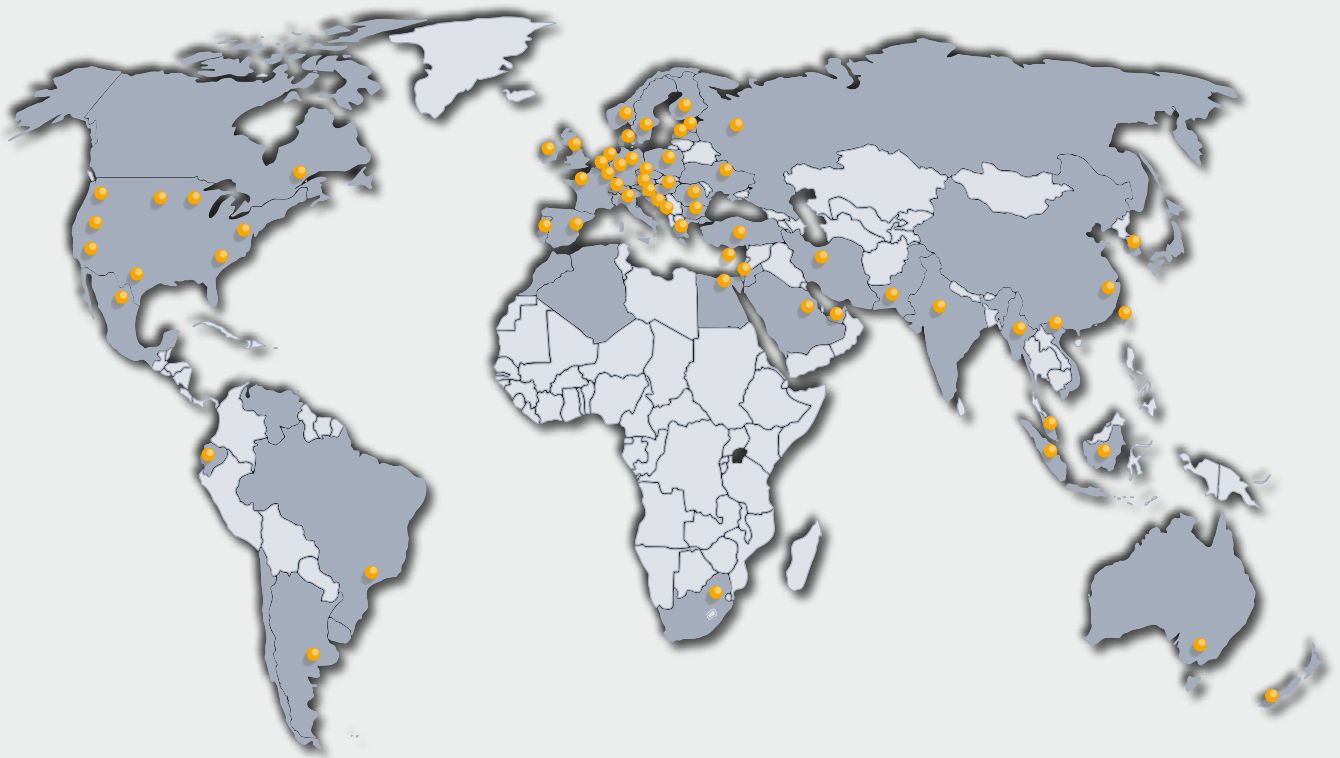


Optimized operating processes and continuous quality controls are the foundation of ARNTZ's high-end saw blades. Every single step in the production process goes through our multilayered control system to guarantee our quality standards.



Our experienced service technicians provide in-depth expert knowledge that has been adapted to fit your exact requirements. Alongside telephone assistance and on-site support, we also offer training modules targeted to your requirements.

...and competent advice.

























We are on your side – worldwide.






Jan Wilhelm Arntz · CEO

Explanation of symbols

Material	Article group
	solid material round small 420 430
	solid material round medium 421 426 434 436 457 620 622 643 650
	solid material round large 431 434 437 438 457 531 537 544 620 622 643 650
	solid material square large 431 434 437 438 531 537 544 620 622 643 650
	solid material special alloy 434 438 531 537 544 622 650
	solid material rectangular large 431 434 437 438 537 544 620 622 643 650
	solid material very large 431 437 537 544 620 622 643 650
	sheet panel 430
	small round tube standard wall thickness 430
	small round tube thin wall thickness 430
	round tube standard wall thickness 426 430 457

Material	Article group
	round tube heavy walled 431 437 531 537
	bundle of tubes 430 457
	square tube small 420
	square tube large 457
	aluminium profile 436
	standard steel beam 457
	wide flange steel beam 445
	heavy walled steel beam 445
	U channel steel 457
	L angle steel 457
	surface hardened material 651

Now is the time to make the **right cut!**

	Article group		Description	Page
	uncoated	coated		
Bi-Metal Band Saw Blades	420		M42-STAR	10
	421		M42-STAR-PLUS	10
	426		M42-ALUCUT-PLUS	11
	436		M42-ALUCUT-SPRINT	11
	430		M42-SPRINT	12
	457	857 C-TEC	M42-X-FIT	13
	431	831 C-TEC	M42-SPRINT-PLUS	14
	434		M42-MAXIMA-SPRINT	15
	445	845 C-TEC	M42-PROFILER-SPRINT-VS	16
	437	837 C-TEC	M42-TAIFUN-SPRINT 	17
	438	838 C-TEC	M42-TAIFUN-MAXIMA 	18
	531		M51-SPRINT-PLUS	19
	544	844 C-TEC	M51-BLIZZARD-SPRINT	19
	537	867 C-TEC	M51-TAIFUN-MAXIMA 	20
Carbide Tipped Band Saw Blades	620		BLACK-LINE triple chip geometry	22
	622	822 C-TEC	BLACK-LINE-S band saw blade with set teeth	23
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	651		SILVER-LINE-N multi chip geometry	26
Special Applications	621		STONE-LINE carbide tipped for light-weight construction materials	27
	623		STONE-LINE-S carbide tipped for abrasive construction materials	27
Carbon Steel Band Saw Blades	100		CS-1 flexible band back	28
	110		CS-2-PLUS spring hardened band back	28
Professional Accessories			Tension measuring device, Refractometer, Application toolkit	29

Bi-Metal

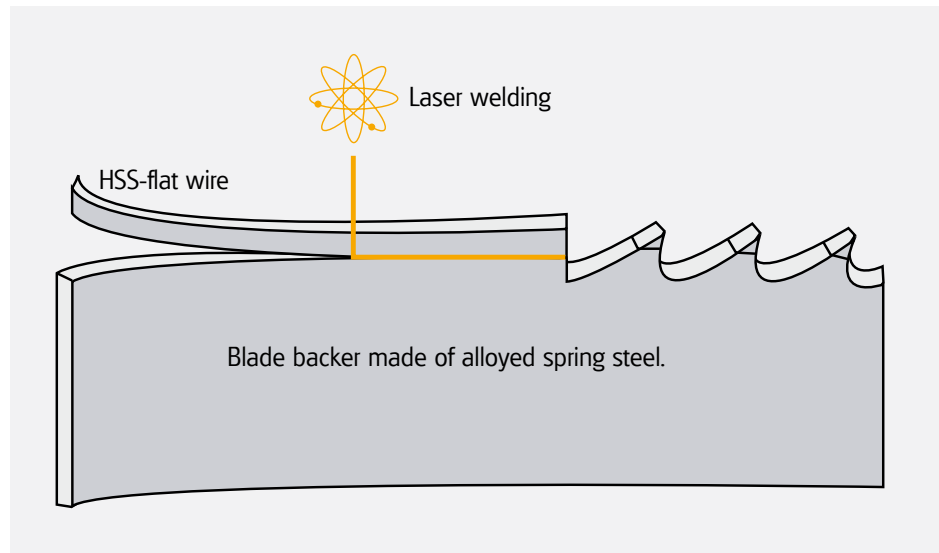
Why so successful?

M42

Material no. 1.3247
hardness approx.
68-69 HRC

M51

Material no. 1.3207
hardness approx. 69 HRC,
with high tungsten-
and cobalt content.



Flexible:

The blade backer of our Bi-Metal Band Saw Blade consists of a special alloyed spring steel. Highly flexible at a hardness of about 50 HRC. The ideal basis for long fatigue life and excellent cutting performance.

Perfectly joint:

Both materials are undetachably welded together by special electron or laser beam.

Hard and wear resistant:

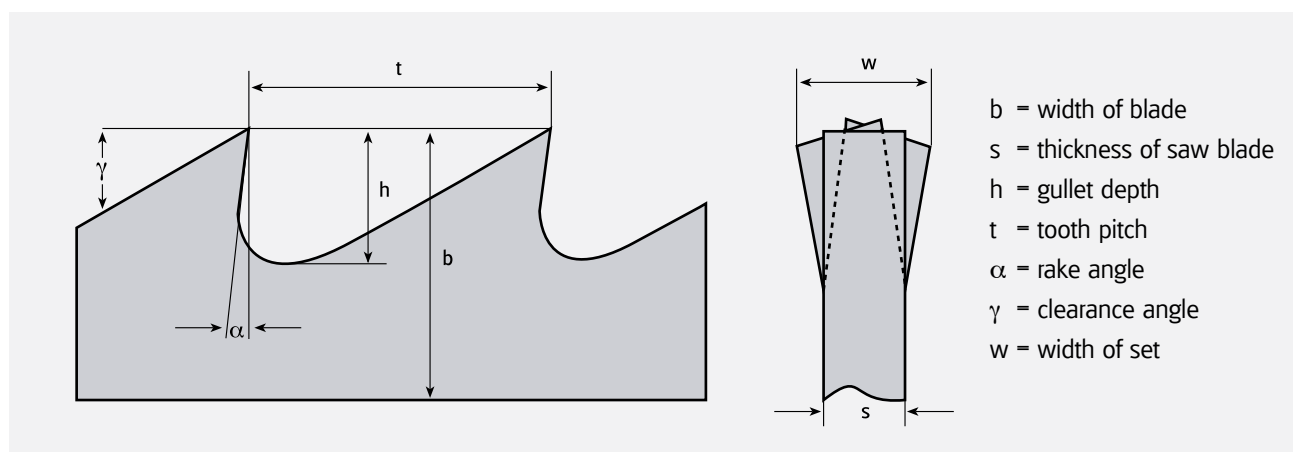
Tooth tips made of hardened HSS-Steel in M42 or M51 quality obtained due to well-balanced hardening and fixed structure resulting in high wear resistance.

All advantages:

The high quality Bi-Metal band combines the flexibility of the spring steel backing with the enormous wear resistance of high speed steel. Each tooth tip of the finished band is of hardened HSS-steel, extremely durable for best performance.

Band Saw geometry

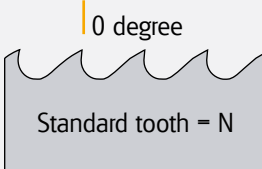
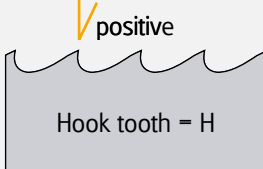
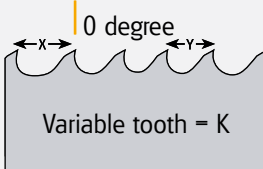
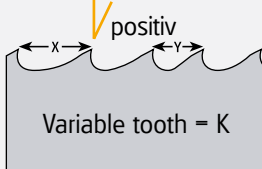
Terminology?



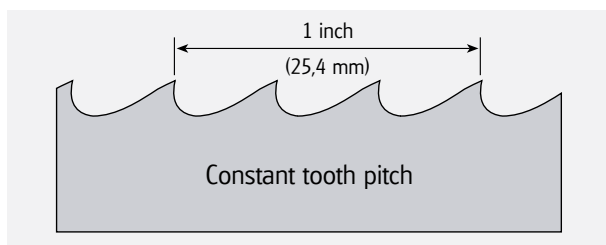
Tooth forms

Where performs the right tooth?

Only correct choice of tooth forms allows efficient cutting with low vibration. Four basic types are available:

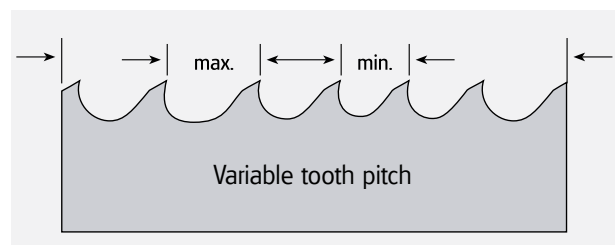
 <p>Standard tooth = N</p> <p>Designed for:</p> <ul style="list-style-type: none"> • short chipping materials • light wall thickness <p>Data:</p> <ul style="list-style-type: none"> • rake angle 0° • constant tooth pitch of 4 to 18 tpi <p>Article groups: 100, 110, 420</p>	 <p>Hook tooth = H</p> <p>Designed for:</p> <ul style="list-style-type: none"> • long chipping materials • large cross sections <p>Data:</p> <ul style="list-style-type: none"> • positive rake angle • constant tooth pitch of 2 to 6 tpi <p>Article groups: 100, 110, 421, 426</p>	 <p>Variable tooth = K</p> <p>Designed for:</p> <ul style="list-style-type: none"> • low vibration cutting • structurals <p>Data:</p> <ul style="list-style-type: none"> • rake angle 0° • variable tooth pitch of 3/4 to 10/14 tpi <p>Article group: 430 (K-0)</p>	 <p>Variable tooth = K</p> <p>Designed for:</p> <ul style="list-style-type: none"> • low vibration cutting • solid materials <p>Data:</p> <ul style="list-style-type: none"> • positive rake angle • variable tooth pitch of 0,75/1,25 to 8/11 ZpZ <p>Article groups: 445, 457 (K-VS, K-X) 431, 436, 437 (K-POS) 434, 438, 531, 537, 544 (K-PLUS)</p>
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Tooth pitch



The tooth distance is equally spaced. The number of teeth per inch (25,4 mm) denotes the tooth of the saw blade.

Constant or variable?



The tooth distances vary within a group of teeth. The smallest and the largest tooth pitch denotes the variable tooth of saw blade.

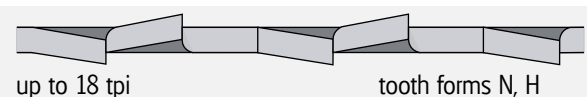
Tooth set

What groups and waves can cause.

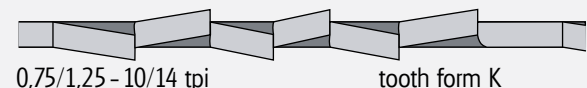
Apart from tooth pitch and tooth form the exact set is essential for the performance of the sawblade. The correct clearance of back is achieved by the specific set for the cutting application.

This is to avoid blade pinching, very important in problematic cutting jobs. Width and type of set are tuned to the cutting application.

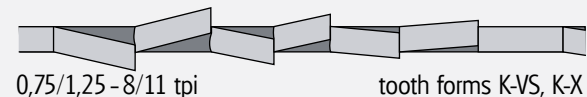
Standard raker set



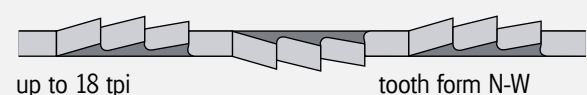
Standard group set



Variable group set



Wavy set



Correct tooth pitch – optimum performance.

The choice of the right tooth pitch can be decisive to achieve the optimum performance. Choose either standard tooth with constant tooth pitch or variable tooth with unevenly spaced teeth. It is advisable to use variable tooth to reduce vibrations.

Recommendation to cut solid material

Constant tooth pitch		
Cross section mm	Teeth per inch	
	tpi	Tooth shape
200 - 400	2	H
120 - 200	3	H
80 - 120	4	H/N
40 - 80	6	H/N
20 - 40	10	N
10 - 20	14	N
to 10	18	N

N = Standard tooth H = Hook tooth

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

K = Variable tooth

Recommendation to cut tubes and structurals

Thin wall structurals (0° - 7° rake angle)							
Wall thickness (S) in mm	Diam. of structural (D) 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	-

The choice of the right tooth has special influence on the cutting result on tubes and structurals. Variable tooth has proven to be the most favourable tooth form. Tooth pitches selected are depending on wall thickness and outer dimensions of tubes or structurals. The recommendations shown here refer to single cuts. If two or more tubes or square pipes are cut at a time, double wall thickness to select tooth pitch.

Heavy wall structurals (positive rake angle)								
Wall thickness (S) in mm	Diam. of structural (D) 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:

6-13 mm in length of approx 30,5 + 76 m | 20-34 mm in length of approx 100 m | 41 mm in length of approx 80 m
 54-67 mm in length of approx 90 m | 80 mm in length of approx 50 m

Bi-Metal and Carbide Tipped Band Saw Blades

For each cutting operation the right choice.

		Art. gr.	420	421	426	436	430	457	431	434	445	437	438	531	544	537	620	622	643	650	651
Product name			M42-STAR	M42-STAR-PLUS	M42-ALUCUT-PLUS	M42-ALUCUT-SPRINT	M42-SPRINT	M42-X-FIT	M42-SPRINT-PLUS	M42-MAXIMA-SPRINT	M42-PROFILER-SPRINT-VS	M42-TAIFUN-SPRINT	M42-TAIFUN-MAXIMA	M51-SPRINT-PLUS	M51-BLIZZARD-SPRINT	M51-TAIFUN-MAXIMA	BLACK-LINE	BLACK-LINE-S	BLUE-LINE	SILVER-LINE	SILVER-LINE-N
Page of catalogue			10	10	11	11	12	13	14	15	16	17	18	19	19	20	22	23	24	25	26
Materialabmessung (mm)																					
- Structural steels	< 70																				
- Case-hardening steels	80 - 350																				
- Free machining steels	> 350																				
- Unalloyed tool steels	< 70																				
- Spring steels	80 - 350																				
- Ball bearing steel	> 350																				
- High speed steels	< 70																				
- Cold-work steels	80 - 350																				
	> 350																				
- Nitride steels	< 70																				
- Heat treatable steels	80 - 350																				
- Hot working steels	> 350																				
- Stainless steels	< 70																				
	80 - 350																				
	> 350																				
- High temperature steels	< 70																				
- Heat resistant steels	80 - 350																				
	> 350																				
- High tensile steels	< 70																				
- Titanium + titanium alloys	80 - 350																				
- Nickel alloys	> 350																				
- Surface hardened steel shafts	< 70																				
- Hardened steels up to HRC62	80 - 350																				
- Hardchromed materials	> 350																				
- Steel castings	< 70																				
- Cast irons	80 - 350																				
	> 350																				
- Aluminium	< 70																				
- Copper	80 - 350																				
	> 350																				
- Brass	< 70																				
- Bronze	80 - 350																				
- Red brass	> 350																				
- Aluminium + alloys	< 70																				
- Aluminium alloys with silicon	80 - 350																				
	> 350																				

Qualification:  = very good  = good

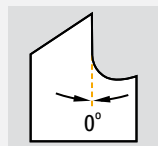
Article group 420

M42-STAR

Allrounder for solid, small-dimensioned materials.

Engineered for:

- Common steel qualities and non ferrous metals
- Short-chipping materials
- Small structurals with thin walls
- Narrow cross sections up to approx. 100 mm (4")
- Contour cutting operations



Dimensions		Tooth				
mm	inch	4	6	10	14	18
6 x 0,90	1/4 x 0,035			N	N	
10 x 0,90	3/8 x 0,035			N	N	
13 x 0,65	1/2 x 0,025			N	N	N
13 x 0,90	1/2 x 0,035				N	
20 x 0,90	3/4 x 0,035				N-W	N-W
27 x 0,90	1 x 0,035	N	N		N-W	

N = Standard tooth W = Wavy set

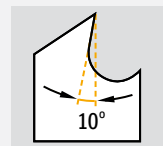
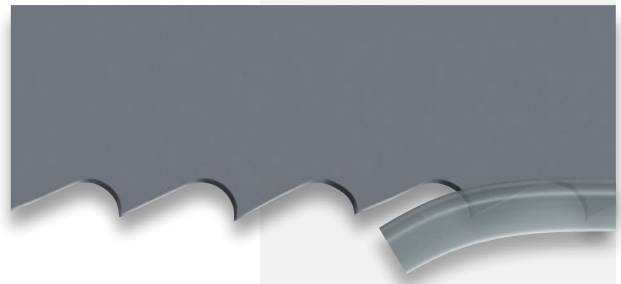
Article group 421

M42-STAR-PLUS

The saw blade for medium sized solid materials.

Engineered for:

- Small workshop bandsaws
- Common steel qualities and non ferrous metals
- Cross sections over approx. 100 mm (4")



Dimensions		Tooth			
mm	inch	2	3	4	6
6 x 0,90	1/4 x 0,035				H
10 x 0,90	3/8 x 0,035			H	H
13 x 0,65	1/2 x 0,025			H	H
13 x 0,90	1/2 x 0,035		H	H	H
20 x 0,90	3/4 x 0,035		H		
27 x 0,90	1 x 0,035	H	H		

H = Hook tooth

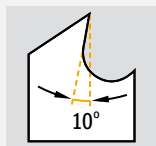
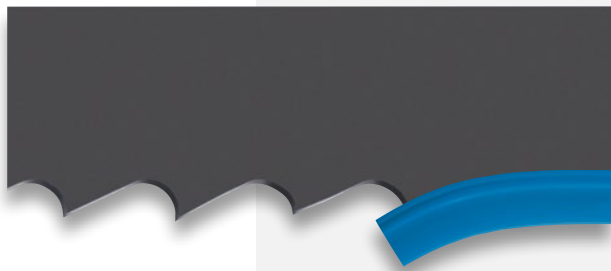
Article group 426

M42-ALUCUT-PLUS

For cutting aluminium without pinching.

Engineered for:

- Pure aluminium and aluminium alloys
- Solid material and structurals
- Materials with residual stress and a tendency to become pinched



Dimensions		Tooth		
mm	inch	3	4	6
10 x 0,90	3/8 x 0,035		H	H
13 x 0,65	1/2 x 0,025		H	H
13 x 0,90	1/2 x 0,035	H	H	H
20 x 0,90	3/4 x 0,035	H		
27 x 0,90	1 x 0,035	H		

H = Hook tooth

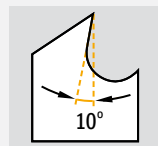
Article group 436

M42-ALUCUT-SPRINT

Easy cutting of light-weight metals.

Engineered for:

- Pure aluminium and aluminium alloys
- Solid material and structurals



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

K = Variable tooth

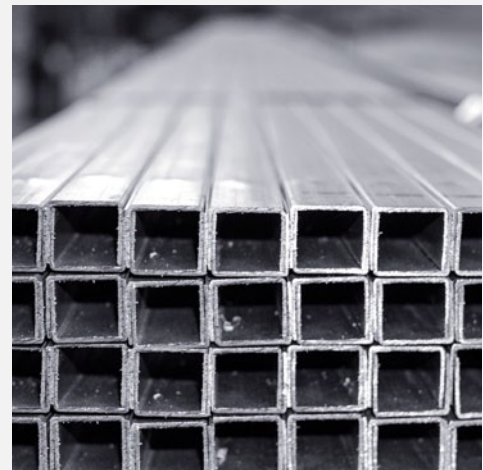
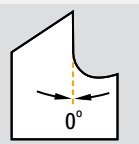
Article group 430

M42-SPRINT

The fabrication professional for light and medium wall thicknesses.

Engineered for:

- Structurals with light or medium walls
- Short chipping materials
- Sheet metal on vertical band saw machines



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

K = Variable tooth

* = Special item

Article group 457 857 C-TEC

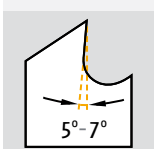
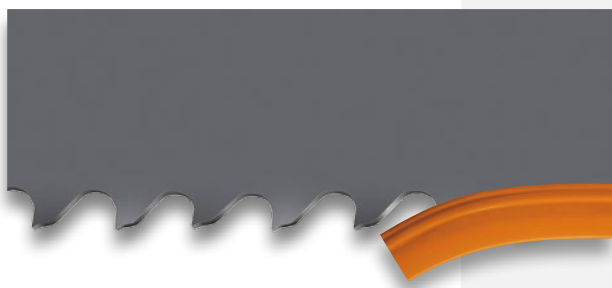
M42-X-FIT

The multi-purpose blade for small and medium cross-sections.

Also coated available **C-TEC** for extremely increased feed rates, significantly reduced cutting times and maximized blade life.

Engineered for:

- Profiles and beams
- Mixed cross-sections including solids



Dimensions		Tooth				
mm	inch	2/3	3/4	4/6	5/7	8/11
20 x 0,90	3/4 x 0,035					K
27 x 0,90	1 x 0,035		K	K	K	K
34 x 1,10	1 1/4 x 0,042	K	K	K	K	
41 x 1,30	1 1/2 x 0,050	K	K	K		
54 x 1,30	2 x 0,050		K	K		
54 x 1,60	2 x 0,063	K	K	K	K	
67 x 1,60	2 5/8 x 0,063	K	K			

K = Variable tooth

Article group 431 831 C-TEC

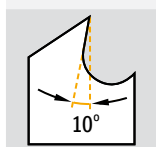
M42-SPRINT-PLUS

Perfect for materials of medium to large dimensions.

Also coated available **C-TEC** for extremely increased feed rates, significantly reduced cutting times and maximized blade life.

Engineered for:

- Production band saw machines
- All-purpose use for steels and non-ferrous metals
- Tensile strengths of up to 1400 N/mm²
- Thick walled structurals



Dimensions		Tooth					
mm	inch	0,75/1,25	1,4/2	2/3	3/4	4/6	
20 x 0,90	3/4 x 0,035					K	
27 x 0,90	1 x 0,035			K	K	K	
34 x 1,10	1 1/4 x 0,042		K	K	K	K	
41 x 1,30	1 1/2 x 0,050		K	C-TEC	K	C-TEC	K
54 x 1,30	2 x 0,050		K	C-TEC	K	C-TEC	K*
54 x 1,60	2 x 0,063	K	K	C-TEC	K	C-TEC	K
67 x 1,60	2 5/8 x 0,063	K	K	C-TEC	K	C-TEC	
80 x 1,60	3 x 0,063	K	C-TEC	K	C-TEC		

K = Variable tooth

* = Special item

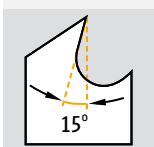
Article group 434

M42-MAXIMA-SPRINT

Excellent for tough materials and alloys.

Engineered for:

- Long chipping steels
- Stainless steel
- Titanium based alloys
- Special bronzes
- Copper based alloys
- Nickel based alloys
- Exotic alloys, difficult to cut
- Solid material of medium dimensions



Dimensions		Tooth		
mm	inch	1/1,3	2/3	3/4
27 x 0,90	1 x 0,035			K
34 x 1,10	1 1/4 x 0,042		K*	K
41 x 1,30	1 1/2 x 0,050		K	K*
54 x 1,30	2 x 0,050		K*	
54 x 1,60	2 x 0,063	K	K*	
67 x 1,60	2 5/8 x 0,063	K		

K = Variable tooth

* = Special item

Article group 445 845 C-TEC

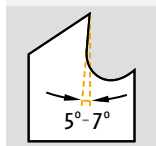
M42-PROFILER-SPRINT-VS

Robust performance for steel construction.

Also coated available **C-TEC** for extremely increased feed rates, significantly reduced cutting times and maximized blade life.

Engineered for:

- Large cross-section steel beams
- Structurals with residual stress



Dimensions		Tooth			
mm	inch	2/3		3/4	
34 x 1,10	1 1/4 x 0,042			K	
41 x 1,30	1 1/2 x 0,050	K	G-TEC	K	G-TEC
54 x 1,60	2 x 0,063	K	G-TEC	K	G-TEC
67 x 1,60	2 5/8 x 0,063	K	G-TEC	K	G-TEC

K = Variable tooth

Article group 437 837 C-TEC

M42-TAIFUN-SPRINT

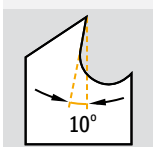
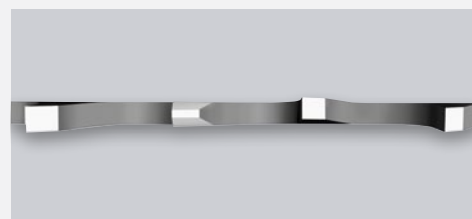
Excellent for use on high-performance band saw machines.

Also coated available **C-TEC** for extremely increased feed rates, significantly reduced cutting times and maximized blade life.

Engineered for:

- Stainless steel
- All-purpose use for steels and non-ferrous metals
- Tensile strengths of up to 1400 N/mm²
- Thick walled structurals

The borazon-ground tooth tips produce an excellent cutting surface, perfect angular cutting and long tool life.



Dimensions		Tooth					
mm	inch	0,75/1,25	1,4/2	2/3	3/4		
27 x 0,90	1 x 0,035			K	K		
34 x 1,10	1 1/4 x 0,042		K	K	K		
41 x 1,30	1 1/2 x 0,050		K	C-TEC	K	C-TEC	K C-TEC
54 x 1,30	2 x 0,050		K	C-TEC	K	C-TEC	K
54 x 1,60	2 x 0,063	K	K	C-TEC	K	C-TEC	K C-TEC
67 x 1,60	2 5/8 x 0,063	K	K	C-TEC	K	C-TEC	
80 x 1,60	3 x 0,063	K	K	C-TEC			

K = Variable tooth

Article group 438 838 C-TEC

M42-TAIFUN-MAXIMA

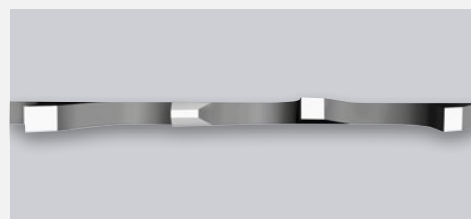
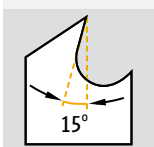
Perfect for cutting tough materials and alloys.

Also coated available **C-TEC** for extremely increased feed rates, significantly reduced cutting times and maximized blade life.

Engineered for:

- Long chipping materials
- Stainless steel
- Titanium alloys
- Special bronzes
- Copper alloys
- Nickel based alloys
- Exotic alloys, difficult to cut

The borazon-ground tooth tips produce an excellent cutting surface, perfect angular cutting and long tool life.



Dimensions		Tooth				
mm	inch	1/1,3		2/3		3/4
27 x 0,90	1 x 0,035					K
34 x 1,10	1 1/4 x 0,042			K*		K
41 x 1,30	1 1/2 x 0,050			K	G-TEC	K*
54 x 1,30	2 x 0,050			K*	G-TEC	
54 x 1,60	2 x 0,063	K	G-TEC	K*	G-TEC	
67 x 1,60	2 5/8 x 0,063	K	G-TEC			

K = Variable tooth

* = Special item

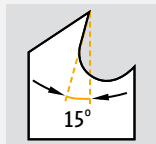
Article group 531

M51-SPRINT-PLUS

Wear resistant teeth for difficult to cut materials of medium dimensions.

Engineered for:

- Hard and tough materials up to 1700 N/mm² tensile strength
- Stainless steel
- Nickel based alloys
- Titanium and special bronzes
- Thick walled structurals



Dimensions		Tooth		
mm	inch	2/3	3/4	4/6
27 x 0,90	1 x 0,035	K	K	K
34 x 1,10	1 1/4 x 0,042	K	K	K
41 x 1,30	1 1/2 x 0,050	K	K	
54 x 1,60	2 x 0,063	K		
67 x 1,60	2 5/8 x 0,063	K		

K = Variable tooth

Article group 544 844 C-TEC

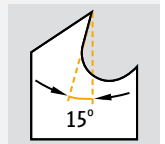
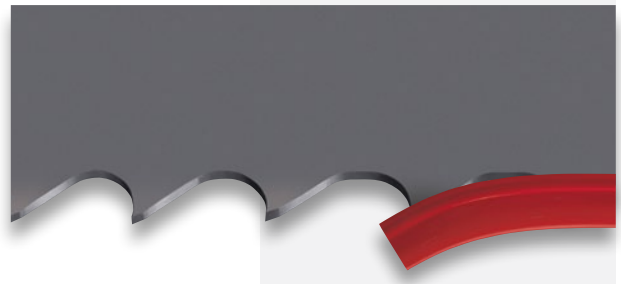
M51-BLIZZARD-SPRINT

For extra wear resistant cutting, made of powder metallurgical hardened steel for large cross-sections and demanding alloys.

Engineered for:

- Steels of the highest tensile strength
- Long chipping materials
- Stainless steel
- Titanium based alloys
- Nickel based alloys
- Special bronzes

Also coated available **C-TEC** for extremely increased feed rates, significantly reduced cutting times and maximized blade life.



Dimensions		Tooth		
mm	inch	0,75/1,25	1/1,3	1.4/2
41 x 1,30	1 1/2 x 0,050			K C-TEC
54 x 1,60	2 x 0,063		K	K
67 x 1,60	2 5/8 x 0,063	K C-TEC	K	K C-TEC
80 x 1,60	3 x 0,063	K C-TEC	K	K*

K = Variable tooth with special geometry * = Special item

Article group 537 867 C-TEC

M51-TAIFUN-MAXIMA

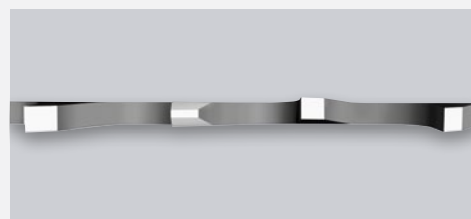
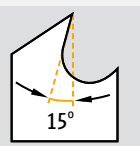
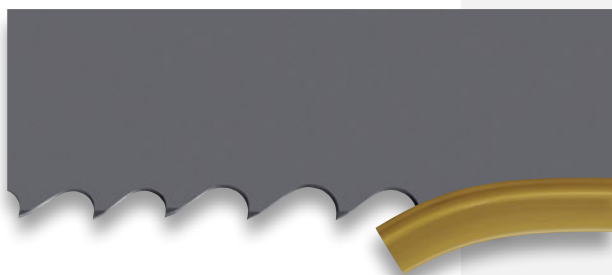
Extremely wear-resistant, ground teeth for the most difficult cutting conditions.

Also coated available **C-TEC** for extremely increased feed rates, significantly reduced cutting times and maximized blade life.

Engineered for:

- Hard and tough materials up to 1700 N/mm² tensile strength
- Stainless steel
- Nickel based alloys
- Titanium and special bronzes
- Thick walled structurals

The borazon-ground tooth tips produce an excellent cutting surface, perfect angular cutting and long tool life.

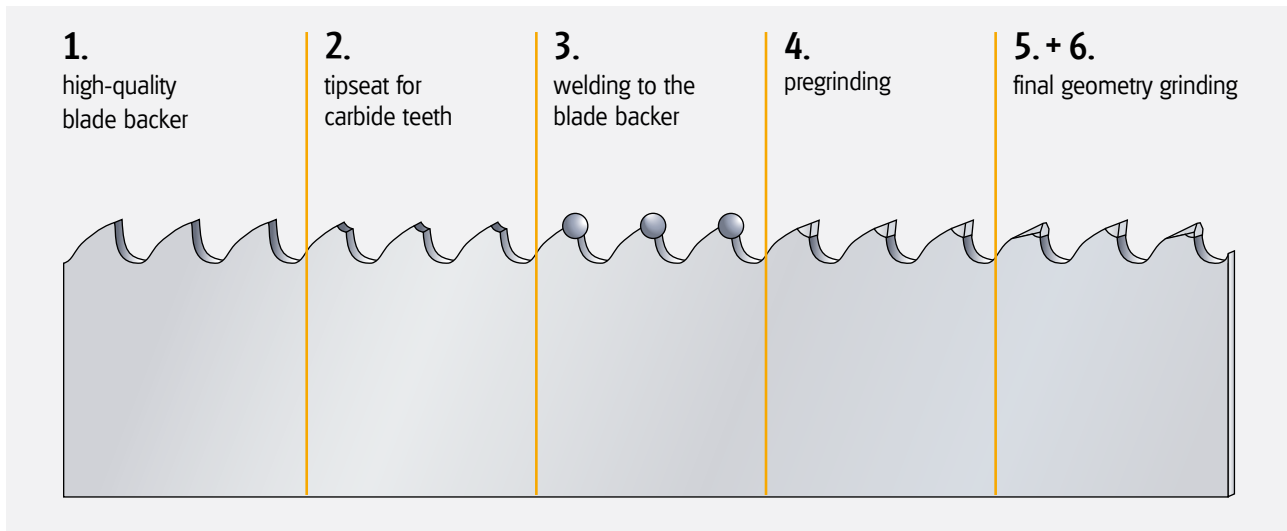


Dimensions		Tooth						
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3	3/4		
27 x 0,90	1 x 0,035				K	K		
34 x 1,10	1 1/4 x 0,042				K	K		
41 x 1,30	1 1/2 x 0,050			K	C-TEC	K	C-TEC	K
54 x 1,60	2 x 0,063		K	C-TEC	K	C-TEC	K	C-TEC
67 x 1,60	2 5/8 x 0,063	K	C-TEC	K	C-TEC	K	C-TEC	
80 x 1,60	3 x 0,063	K	C-TEC	K	C-TEC	K*		

K = Variable tooth

* = Special item

Why so successful?



Flexible:

The blade backer for Carbide Band Saw Blades is made of special alloyed spring steel.

Extremely durable:

The tooth tips consist of wear resistant high-grade carbide.

Perfectly joint:

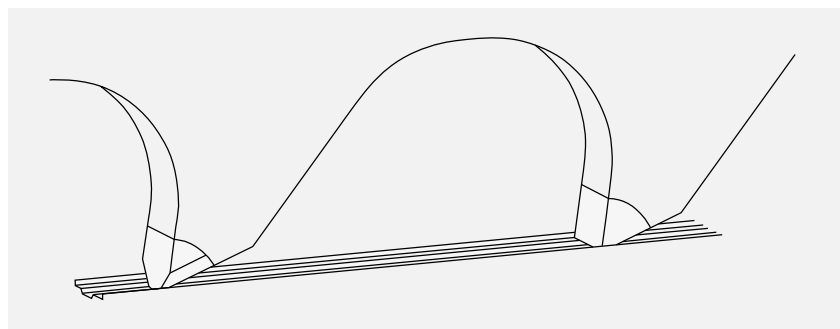
Carbide tooth tips are welded to the backer in a special procedure.

Band Saw geometry:

Also in the ARNTZ production program: High performance Carbide Band Saw Blades.

The welded carbide tips are available in different tooth geometries. These geometries grant optimal formation of chips and best cutting results.

The different tooth geometries provide clean and smooth cuts at minimum vibration.



Correct operation:

To achieve optimum performance with Carbide Band Saw Blades, suitable band saw machines for Carbide Band Saw Blades are required.

Carbide Tipped Band Saw Blades are supplied as endless welded loops or in coils:

27–80 mm in length of approx. 50 m

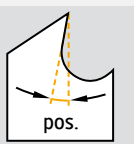
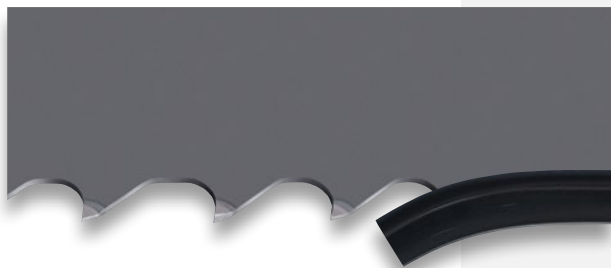
Article group 620

BLACK-LINE

Carbide tipped band saw blades with triple chip geometry for cutting steels and non-ferrous metals.

Engineered for:

- All-purpose use for construction steel, low-alloy steel, cast iron, aluminium, copper and bronze
- Solid material in medium and large dimensions



Dimensions		Tooth					
mm	inch	0,75/1,25	1/1,5	1,4/2	2/3	3	3/4
27 x 0,90	1 x 0,035				K	H	K
34 x 1,10	1 1/4 x 0,042				K		K
41 x 1,30	1 1/2 x 0,050			K	K		K
54 x 1,30	2 x 0,050			K	K		
54 x 1,60	2 x 0,063	K	K	K	K		K
67 x 1,60	2 5/8 x 0,063	K	K	K	K		

K = Variable tooth H = Hook tooth

Article group 622 822 C-TEC

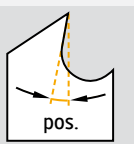
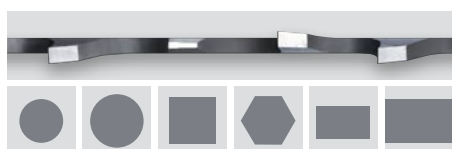
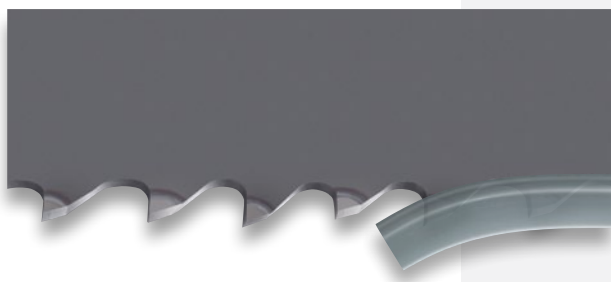
BLACK-LINE-S

Carbide tipped band saw blade with set tooth for abrasive materials, difficult to cut.

Also coated available **C-TEC** for extremely increased feed rates, significantly reduced cutting times and maximized blade life.

Engineered for:

- Titanium alloys
- Metals with high residual stress
- Stainless steels
- Special alloys
- Abrasive non-ferrous metals and graphite



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				H	
27 x 0,90	1 x 0,035			K	H	K
34 x 1,10	1 1/4 x 0,042		K	K		K
41 x 1,30	1 1/2 x 0,050		K	C-TEC	K	C-TEC
54 x 1,30	2 x 0,050		K	C-TEC	K	C-TEC
54 x 1,60	2 x 0,063	K	K	C-TEC	K	C-TEC
67 x 1,60	2 5/8 x 0,063	K	K	C-TEC		
80 x 1,60	3 x 0,063	K	K	C-TEC		

K = Variable tooth H = Hook tooth

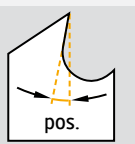
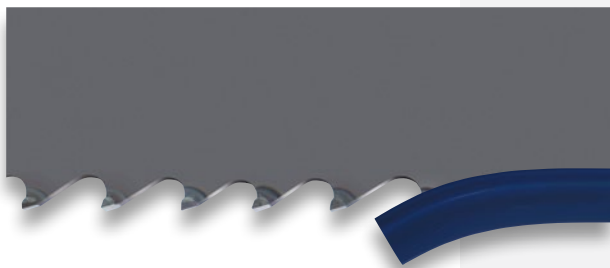
Article group 643

BLUE-LINE

Carbide tipped band saw blades with triple chip geometry for cutting non-ferrous metals and graphite.

Engineered for:

- Aluminium alloys
- Aluminium bronzes
- Copper alloys
- Sand cast aluminium and cast magnesium
- Graphite



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				H	
27 x 0,90	1 x 0,035			K	H	K
34 x 1,10	1 1/4 x 0,042		K	K	H	K
41 x 1,30	1 1/2 x 0,050		K	K		K
54 x 1,30	2 x 0,050		K	K		
54 x 1,60	2 x 0,063	K	K	K		
67 x 1,60	2 5/8 x 0,063		K			
80 x 1,60	3 x 0,063	K				

K = Variable tooth H = Hook tooth

Reengineered geometry

Article group 650 850 C-TEC

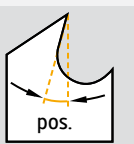
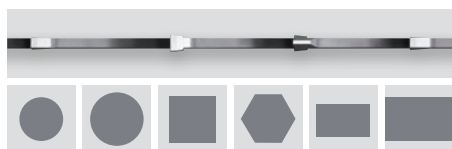
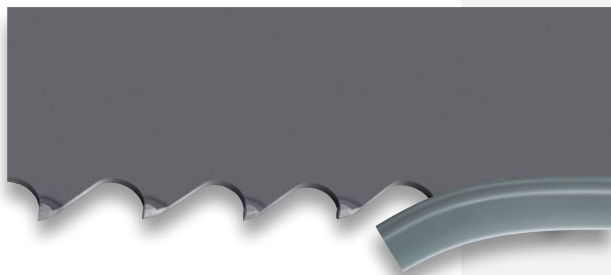
SILVER-LINE

Carbide tipped band saw blades with patented multi chip tooth geometry for cutting high-alloy steels and non-ferrous metals.

Also coated available **C-TEC** for extremely increased feed rates, significantly reduced cutting times and maximized blade life.

Engineered for:

- Stainless steel
- Heat resistant steels
- Cold and hot working steels
- Hardened steel up to 1900 N/mm²
- Nickel based alloys
- Aluminium-silicon alloys
- Copper-nickel alloys
- Titanium and titanium alloys
- Exotic, hard to cut alloys



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				K	K		
34 x 1,10	1 1/4 x 0,042			K	K	K		
41 x 1,30	1 1/2 x 0,050			K	G-TEC	K	G-TEC	K G-TEC
54 x 1,30	2 x 0,050			K	G-TEC	K	G-TEC	
54 x 1,60	2 x 0,063	K	K G-TEC	K	G-TEC	K	G-TEC	K G-TEC
67 x 1,60	2 5/8 x 0,063	K	K G-TEC	K	G-TEC	K	G-TEC	
80 x 1,60	3 x 0,063	K G-TEC		K	G-TEC			

K = Variable tooth

Patent-no. 102 53 711

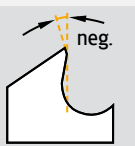
Article group 651

SILVER-LINE-N

Carbide tipped band saw blades with multi chip tooth geometry, negative rake angle for cutting extremely hard or surface hardened materials.

Engineered for:

- Induction hardened piston rods
- Steels hardened up to 62 HRC
- Hard chromium plated materials
- Manganiferrous alloyed steels



Dimensions		Tooth		
mm	inch	1,4/2	2/3	3/4
27 x 0,90	1 x 0,035		K	K
34 x 1,10	1 1/4 x 0,042		K	K
41 x 1,30	1 1/2 x 0,050	K	K	K
54 x 1,60	2 x 0,063	K	K	K

K = Variable tooth

Patent-no. 102 53 711

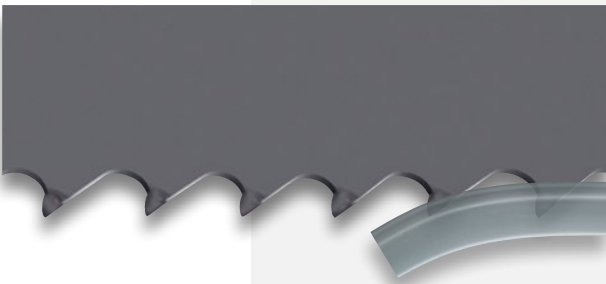
Article group 621

STONE-LINE

Carbide tipped band saw blades for cutting **soft construction materials**.

Engineered for:

- light-weight construction materials such as porous concrete / gas concrete and insulating boards



Dimensions		Tooth
mm	inch	
27 x 0,90	1 x 0,035	H

H = Hook tooth



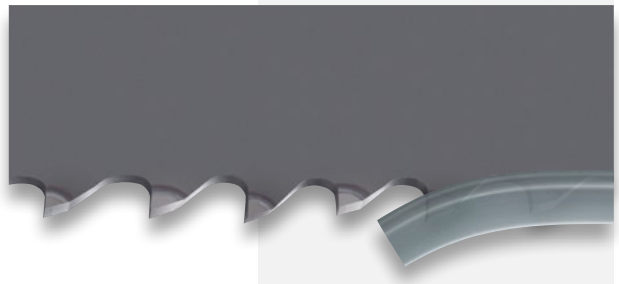
Article group 623

STONE-LINE-S

Carbide tipped band saw blades with tooth set for cutting **abrasive construction materials**.

Engineered for:

- abrasive and dense construction materials like perforated bricks



Dimensions		Tooth
mm	inch	
27 x 0,90	1 x 0,035	N-S

N-S = Standard set tooth



CARBON STEEL BAND SAW BLADES

Article group 100

CS-1

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

Dimensions		Tooth per inch									
mm	inch	3	4	4	6	6	8	10	14	18	24
6 x 0,65	1/4 x 0,025	H*		H		H	N	N	N	N	N
10 x 0,65	3/8 x 0,025	H		H	N	H	N	N	N	N	N
13 x 0,65	1/2 x 0,025	H		H	N	H	N	N	N	N	N
16 x 0,80	5/8 x 0,032	H*		H	N		N	N	N	N	N*
20 x 0,80	3/4 x 0,032	H		H	N	H	N	N	N	N	N
25 x 0,90	1 x 0,035	H	N	H*	N		N	N	N		

N = Standard tooth 0° H = Hook tooth 10°

* = Special item

Article group 110

CS-2-PLUS

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

Dimensions		Tooth per inch									
mm	inch	3	4	4	6	6	8	10	14	18	24
6 x 0,65	1/4 x 0,025			H*		H*		N*	N*	N*	N*
8 x 0,65	5/16 x 0,025		N*	H*					N*		
10 x 0,65	3/8 x 0,025	H*		H*		H*	N*	N*	N*	N*	
13 x 0,65	1/2 x 0,025	H*		H*	N*	H*	N*	N*	N*	N*	N
16 x 0,80	5/8 x 0,032	H*						N*	N*	N*	
20 x 0,80	3/4 x 0,032	H		H*	N		N*	N*	N*	N*	
25 x 0,90	1 x 0,035	H	N*		N*		N*	N*	N*		

N = Standard tooth 0° H = Hook tooth 10°

* = Special item



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 band saw tension.



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, tachometer, accessories and more.



Break-in procedures: For long blade life.

Like all HSS tools, 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 cutting operation. Aggressive cutting with a new blade will lead to premature tooth breakages. Correct break-in will control the gentle rounding of 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 cm² cut surface (see table on page 30). After that, feed rate should be gradually increased for maximum cutting rate. Should vibrations or noises occur at the beginning of the cutting operation, cutting speed should be slightly adjusted.

Carbide Tipped Band Saw Blades

For break-in procedure during the first 30 minutes we recommend following parameters:

Material diameter up to 600 mm	Cutting speed	= 30 m/min
	Feed	= 5 mm/min
Material diameter over 600 mm	Cutting speed	= 25 m/min
	Feed	= 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 Band Saw Blades are working perfectly when no vibrations will appear.

TECHNICAL RECOMMENDATIONS

For Bi-Metal Band Saw Blades

Material groups	Material specification DIN	Material no.	Cutting speed V _c (m/min)	Cooling fluids	
			Bi-Metal	Cutting oil	Emulsion
Structural steels	St 37 – 2	1.0037	80-100		x
	St 50 – 2	1.0050	60-85		x
	St 60 – 2	1.0060	50-70		x
Case-hardening steels	C 10	1.0301	80-100	x	
	14 NiCr 14	1.5752	40-55	x	
	21 NiCrMo 2	1.6523	50-60	x	
	16 MnCr 5	1.7131	40-60	x	
Free machining steels	9 S 20	1.0711	80-120		x
	45 S 20	1.0727	80-120		x
Heat treatable steels	C 45	1.0503	60-70		x
	40 Mn 4	1.1157	60-70		x
	36 NiCr 6	1.5710	60-70		x
	34 CrNiMo 6	1.6582	50-65		x
	42 CrMo 4	1.7225	50-65		x
Ball bearing steels	100 Cr 6	1.3505	35-50		x
	100 CrMn 6	1.3520	35-50		x
Spring steels	65 Si 7	1.5028	45-60		x
	50 CrV 4	1.8159	45-60		x
Unalloyed tool steels	C 125 W	1.1663	40-60		x
	C 75 W	1.1750	40-60		x
Cold-work tool steels	125 Cr 1	1.2002	40-50	x	x
	X 210 Cr 12	1.2080	30-40	x	x
	X 155 CrVMo 12 1	1.2379	30-40	dry	
	X 42 Cr 13	1.2083	35-45	x	x
	X 165 CrV 12	1.2201	30-45	x	x
	100 CrMo 5	1.2303	30-50	x	x
	X 32 CrMoV 3 3	1.2365	45-60	x	x
	45 WCrV 7	1.2542	40-50	x	x
Hot-work tool steels	56 NiCrMoV 7	1.2714	40-50	x	x
High speed steels	S 6-5-2-5 (E Mo5 Co5)	1.3243	35-45		x
	S 2-10-1-8 (M 42)	1.3247	35-45		x
	S 6-5-2 (DMo5)	1.3343	35-45		x
Valve steels	X 45 CrSi 9 3	1.4718	30-45	x	x
	X 45 CrNiW 18 9	1.4873	30-40	x	x
High temperature steels	X 20 CrMoV 12 1	1.4922	10-30	x	x
	X 5 NiCrTi 26 15	1.4980	10-30	x	x
Heat resistant steels	X 10 CrSi 6	1.4712	15-25	x	x
	X 10 CrAl 18	1.4742	15-25	x	x
	X 15 CrNiSi 25 20	1.4841	15-25	x	x
Stainless steels	X 5 CrNi 18 10 (V2A)	1.4301	30-40	x	x
	X 6 CrNiMoTi 17 12 2 (V4A)	1.4571	30-40	x	x
Steel castings	GS-38	1.0420	40-60		x
	GS-60	1.0558	40-60		x
Cast irons	GG-15	0.6015	30-60	dry	
	GG-30	0.6030	30-60	dry	
	GGG-50	0.7050	30-60	dry	
	GTW-40	0.8040	30-60	dry	
	GTS-65	0.8165	30-60	dry	
Copper	KE-Cu	2.0050	100-400	x	x
	Elektrolyt-Copper		100-400	x	x
Brass (copper-zinc alloys)	CuZn 10	2.0230	100-400		x
	CuZn 31 Si 1	2.0490	100-400		x
Aluminium bronze (copper-aluminium alloys)	CuAl 8	2.0920	35-50		x
	CuAl 10 Fe 3 Mn 2	2.0936	35-50		x
Bronze (copper-TiN alloys)	CuSn 6	2.1020	80-150		x
	CuSn 6 Zn 6	2.1080	80-150		x
Red brass (copper-cast alloys)	CuSn 10 Zn	2.1086	50-100		x
	CuSn 5 ZnPb	2.1096	50-100		x
Nickel base alloys	NiCr 20 TiAl	2.4631	10-25	x	x
	NiCr 22 FeMo	2.4972	10-25	x	x
Aluminium and aluminium alloys	Al 99.5	3.0255	80-800		x
	AlMgSiPb	3.0615	80-800		x
	G-AlSi 5 Mg	3.2341	80-800		x
Titanium and titanium alloys	Ti Grade 1	3.7025	10-20	x	x
	TiAl 6 V 4	3.7164	10-20	x	x
Thermoplastic plastics	PVC		100-400	dry	
	Teflon, Hostalen		100-400	dry	
Plastics with fibre inlays	Resitex		50-300	dry	
	Novotex		50-300	dry	

For Carbide Band Saw Blades (for cutting steel)

Material group	Material specifications DIN	Material no.	Cutting speed	Recommended tooth pitch Material dimensions			
			V _c (m/min)	75 - 140 mm	100 - 350 mm	300 - 550 mm	≥540 mm
Structural steels	St 37/42	1.0037/1.0042	100-130	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	St 52/60	1.0050/1.0060	90-120	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Case-hardening steels	C10/C15	1.0301/1.0401	110-140	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	16 MnCr 5	1.7131	80-100	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	20 CrMo 5	1.7264	80-100	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	21 NiCrMo 2	1.6523	70-90	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Nitride steels	34 CrAlNi 7	1.8550	45-60	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	34 CrAlMo 5	1.8507	45-60	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Free machining steels	9 S 20	1.0711	100-160	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Heat treatable steels	C 35/45	1.0501/1.0503	90-120	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	42 CrMo 4	1.7225	70-90	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	34 CrNiMo 6	1.6582	70-90	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Ball bearing steels	100 Cr 6	1.3505	70-90	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	100 CrMo 7 3	1.3536	65-85	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Spring steels	65 Si 7	1.5028	65-85	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	50 CrV 4	1.8159	65-85	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	C 125 W	1.1663	65-80	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Unalloyed tool steels	C 80 W 1	1.1525	70-85	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	125 Cr 1	1.2002	65-80	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Cold-work tool steels	X 210 Cr 12	1.2080	40-50	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	X 155 CrVMo 12 1	1.2379	40-50	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	90 MnCrV 8	1.2842	45-55	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	40 CrMnMo 7	1.2311	70-90	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Hot-work tool steels	X 40 CrMoV 5 1	1.2344	60-80	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	56 NiCrMoV 7	1.2714	50-70	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	40 CrMnNiMo 8 6 4	1.2738	35-50	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	S 6-5-2	1.3343	50-60	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
High speed steels	S 3-3-2	1.3333	55-65	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	S 2-10-1-8	1.3247	45-60	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	S 10-4-3-10	1.3207	45-60	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	S 18-0-1	1.3355	45-60	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	X 5 CrNi 18 10	1.4301	70-80	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Stainless steels	X 6CrNiMoTi 17 12 2	1.4571	65-75	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	X 20 Cr 13	1.4021	80-100	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	X 45 CrSi 9 3	1.4718	50-60	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Valve steels	X 45 CrNiW 18 9	1.4873	40-50	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	X 12 CrCoNi 21 20	1.4971	30-40	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
High temperature steels	X 20 CrMoWV 12 1	1.4935	80-100	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	X 15 CrNiSi 25 20	1.4841	30-40	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Heat resistant steels	X 12 NiCrSi 36 16	1.4864	30-40	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	NiCr 19 NbMo	2.4668	20-30	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Special alloys	NiMo 30	2.4810	22-35	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	NiCr 13 Mo 6 Ti 3	2.4662	20-30	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	NiCo 20 Cr 20 MoTi	2.4650	22-35	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	X 8 CrNiAlTi 20 20	1.4847	22-35	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	Heat treated steels						
Heat treated steels	1000 - 1200 N/mm ²		35-50	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	1200 - 1400 N/mm ²		30-45	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	1400 - 1600 N/mm ²		25-35	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Hardened steels	50 HRC		15-20	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	55 HRC		10-15	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	60 HRC		8-12	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Steel castings	GS-38	1.0420	70-100	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	GS-60	1.0558	60-85	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Cast irons	GG-30	0.6030	60-80	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	GGG-50	0.7050	55-75	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K

For Carbide Band Saw Blades (for cutting non ferrous metals)

Material group	Material specifications DIN	Material no.	Cutting speed	Recommended tooth pitch Material dimensions			
			V _c (m/min)	75 - 140 mm	100 - 350 mm	300 - 550 mm	≥540 mm
Aluminium and aluminium alloys	Al 99,5	3.0255	up to 3000	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	AlMg 1	3.3315	up to 3000	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	AlMg 3	3.3535	up to 3000	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	AlMg 4.5Mn	3.3547	up to 3000	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	AlMgSi 1	3.2315	up to 3000	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Copper	KE-Cu	2.0050	100-200	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	E-Cu	2.0060	100-200	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Brass (copper-zinc alloys)	CuZn 39 Pb 3	2.0401	150-250	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	VuZn 31 Si	2.0230	150-250	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Bronze	CuSn 6	2.1020	90-130	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Red brass	CuSn 5 ZnPb	2.1096	90-130	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	CuSn 10 Zn	2.1086	90-130	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Aluminium-bronze	CuAl 8	2.0920	60-80	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	CuAl 8 Fe 38	2.0920.60	52-65	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	CuAl 10 Ni 5 Fe 4	2.0966	50-70	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
	Ti Grade 1	3.7025	80-100	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K
Titanium and titanium alloys	TiAl 6 V 4	3.7164	60-90	3/4 K	3 ZpZ 2/3 K	1,4/2 K	0,75/1,25 K

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