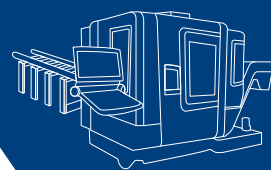


**CUTTING**  
non-ferrous  
metals

Special HM saw blades intended for cutting of profiles and solid materials made of steel and non-ferrous metals. PVD coating ensures a longer lifetime of the tool and significantly decreases cutting resistance.

## HM saw blades COOL CUT

for steel and non-ferrous metals cutting



**TOOTH GEOMETRY** - Special tooth geometry optimal for high-efficient cutting of low-alloyed and high-alloyed steels, cast-iron and hard non-ferrous metal alloys.



**SINTERED CARBIDE** - Type of sintered carbide with proper hardness, chemical composition and structure optimally selected for the type of the material cut.



**REFINING COATING** - Refining coating (PVD) ensuring longer tool lifetime and possibility of high-efficient cutting of hard-machinable steel grades.



**FEATURES / BENEFITS:**

- ▶ HM tooth made of special type of sintered carbide, dedicated for processing of hard-machinable steel grades and metals, including non-ferrous metals
- ▶ special shape of tip and teeth geometry allows to achieve highly efficient cutting
- ▶ precise disc grinding technology and process of dynamic balancing ensures stable operation of saw blades and eliminates vibrations during cutting process
- ▶ additional PVD coating (TiAlN) covering surface of teeth improves lifetime and decreases cutting resistance

**APPLICATION:**

- ▶ cutting of profiles and solid materials made of steel and non-ferrous metals
- ▶ use on highly-efficient, slow-speed, professional cutting-off machines equipped with automatic feed
- ▶ alternative solution for HSS circular saw blades
- ▶ characterized by a several times longer lifetime and the ability to use more processing parameters than in case of working with HSS circular saw blades

INDEX	INFO	MU	PRICE LIST
			euro/pc
○ PS830-	250x...*x2,1/1,8 / 80 GBH0	pcs	
○ PS830-	280x...*x2,1/1,8 / 80 GBH0	pcs	
○ PS830-	280x...*x2,1/1,8 / 100 GBH0	pcs	
○ PS830-	315x...*x2,1/1,8 / 80 GBH0	pcs	
○ PS830-	315x...*x2,1/1,8 / 100 GBH0	pcs	
○ PS830-	350x...*x2,8/2,5 / 80 GBH0	pcs	
○ PS830-	350x...*x2,8/2,5 / 100GBH0	pcs	
○ PS830-	350x...*x2,8/2,5 / 120 GBH0	pcs	
○ PS830-	400x...*x2,8/2,5 / 80GBH0	pcs	

INDEX	INFO	MU	PRICE LIST
			euro/pc
○ PS830-	400x...*x2,8/2,5 / 100 GBH0	pcs	
○ PS830-	400x...*x2,8/2,5 / 120 GBH0	pcs	
○ PS830-	450x...*x3,1/2,8 / 100 GBH0	pcs	
○ PS830-	450x...*x3,1/2,8 / 120 GBH0	pcs	
○ PS830-	450x...*x3,1/2,8 / 140 GBH0	pcs	
○ PS830-	450x...*x3,1/2,8 / 160 GBH0	pcs	
○ PS830-	560x...*x3,8/3,4 / 120 GBH0	pcs	
○ PS830-	560x...*x3,8/3,4 / 140 GBH0	pcs	

\* DIMENSIONS OF FIXING AND DRIVING HOLES:

mm	it x d <sub>1</sub> /d <sub>2</sub>
32	2x8,5/45 + 4x9/50 + 4x11/63
40	2x8,5/55 + 4x12/64 + 4x11/80
50	4x15/80 + 4x14/85
80	4x23,5/120

Key: d<sub>1</sub> – driving holes diameter d<sub>2</sub> – pitch diameter of holes ○ – per order

**MACHINING PARAMETERS:**

Material group	Exemplary grades (acc. to PN, DIN)	Speed of machining (m/min)	Feed per tooth (mm/tooth)
Structural steels	St3, St4, 10, 15, St37, St42	130-150	0,06-0,07
	St5, St6, 25, 40, 45G, St52, St60	100-120	0,06-0,07
Carburizing steels	20H, 20HG, C10, C15	130-150	0,06-0,07
	17HNM, 16 MnCr 5, 20 CrMo 5, 21 NiCrMo 2	100-120	0,06-0,07
Nitriding steels	25H3M, 38HMJ, 34 CrAlNi 7, 34 CrAlMo 5	90-100	0,06-0,07
Free-cutting steels	A10X, 9 S 20, 9 SMn 28	130-150	0,06-0,07
Toughening steels	30H, 40H, C35, C45	100-120	0,06-0,07
	30HGS, 40 HM, 35HGS, 65G, 42 CrMo 4, 34 CrNiMo 6	90-100	0,05-0,06
Bearing steels	115 CrV3, 100 Cr6	70-90	0,05-0,06
Spring steels	65 Si 7, 50 CrV 4	80-90	0,05-0,06
Tool steels	NV, NMV, NC4, WCL, WNL, C 125 W, 40 CrMnMo 7	70-90	0,05-0,06
	NC10, NM, NZ3, NPW, WWN2, X 40CrMoV 51, X 155 CrVMo 12 1	60-80	0,04-0,05
High-speed steels	SW7M, SK5M, SK8M	60-80	0,04-0,05
Stainless steels	OH13, 3H13, 4H13, OH17T, H17, H17N2, X 5 CrNi 18 10, X 6 CrNiMoTi 17 12 2, X 20 Cr 13	50-70	0,04-0,05
Cold-work steels	38Cr2, 37Cr4	80-100	0,04-0,05
Toughened steels		60-80	0,04-0,05
Carbon steels, alloy steels tensile strength to 800 N/mm2	Cutting of sections	200-300	0,03-0,05
Carbon steels, alloy steels tensile strength 800-1400 N/mm2		100-200	0,03-0,05

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