

TECHNICAL INFORMATION
CIRCULAR SAW BLADES WITH HM TIPS



SHAPE AND GEOMETRY OF THE TYPES OF TEETH USED:

NAME	DRAWING	MARKING	NAME	DRAWING	MARKING
Flat top teeth (for ripping)		GM	All left top bevel teeth (for cutterheads)		GW
Alternate top bevel teeth (for cross cutting)		GS	Triple chip – flat top teeth (for PVC profiles, Al, wood-based materials)		GA
Alternate top bevel teeth (for ripping)		2GS	Top bevel teeth (for steel profiles)		GC
Tapered teeth (for scoring wood-based materials)		GR	Top bevel teeth (for steel profiles)		2GC
Tapered teeth (for scoring wood-based materials)		1GR	Triple chip teeth (general use in construction)		GB
All right top bevel teeth (for cutterheads)		GT	Top bevel teeth (v-shaped – specialist)		W3S
Triple top bevel teeth (specialist)		GF	Round top teeth (specialist)		WR
			Biradial top teeth (specialist)		W2R

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MINIMUM CLAMPING DISC DIAMETER AND MAXIMUM SPEED FOR SAWS WITH HM TIPS (DNPDE):

		diameter of clamping discs min. according to DIN 8083	saw speed n max
100	20	60	19.000
125			15.000
130/140			13.500
160	20/30	80	12.000
180	30/60		10.500
200			9.500
225		8.500	
250	85	120	7.500
280	30/60	160	7.000
	85	160	
300/315	30/60	120	6.000 / 6.500
	85	160	
350/355	30/60	120	5.000
	85	160	
400	30/60	120	4.500
	85	160	
425/450	30/60	140	4.200
	85	180	
500	30/60	140	3.600
	85	180	
560	30/60	140	3.400
	85	200	
600/630	40/60	160	2.800 / 3.000
	85	200	
700	2.600		
800	2.100		

The table shows the permitted speed (maximum) for saws for cutting speed $V_s = 100$ m/s

The optimum cutting speed ensuring the high performance and long life of the saw is within the limits of 50-100 m/s, depending on the material being cut.

RECOMMENDED CUTTING SPEEDS DEPENDING ON THE TYPE OF MATERIAL CUT:

material	cutting speed [m/s]
softwood	60-100
wet softwood	70-100
hardwood	59-90
soft fibreboard	60-100
hardboard	50-80
chipboard	60-80
MDF board	60-80
plywood	50-80
duroplast panel	15-50
thermoplastic board	40-80
thermoplastic sections	40-80
Al. alloys	20-40
Al. alloy sections	40-60
steel sections	20-25
drywall	50-70
mineral board, cellular concrete	2-10

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CUTTING SPEED AND PERFORMANCE CHART:

