

Bandsaw Blades

2013 Edition

From Australasia's

Favourite

Bandsaw Blade Manufacturer

MADE IN
GERMANY

CELEBRATING
20 yrs

OPERATING
IN AUSTRALASIA
1993 - 2013

Dependable
Precision
GUARANTEED

Why Rontgen blades:

- *Made in Germany since 1899*
- *Ground teeth for consistent sharpness & accuracy*
- *Chromium backing for optimum blade life*
- *Every weld 100% guaranteed*

Contact Us Now...

WTS

WHITELAW
TOOLING SUPPLIES

Brisbane: Phone: (07) 3323 6311

Mackay: Phone: (07) 4952 5988

Selecting the correct Bandsaw Blade...

Selecting the correct teeth...



Tubes & Other Sections



Material Diameter (D) mm	Teeth Per Inch	Tube Width (W)	Wall Thickness (T)																
			0.6	1	1.6	2	2.5	3	4	5	6	7	8	9	10	12	15	20	50
Up to 20	10/14	10	14	14	10/14	10/14	10/14	10/14	10/14	10/14									
20 - 30	8/12	20	14	14	10/14	10/14	10/14	10/14	10/14	10/14	8/12	6/10							
25 - 35	6/10	25	14	14	10/14	10/14	10/14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	5/8			
30 - 45	5/8	30	14	14	10/14	10/14	10/14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	5/8	4/6		
45 - 60	4/6	40	14	14	10/14	10/14	10/14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	5/8	5/8	4/6	4/6	
60 - 80	3/4	50	14	14	10/14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	
80+	2/3	60-120	14	14	10/14	10/14	10/14	8/12	8/12	6/10	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	
		130-150	14	14	10/14	8/12	8/12	8/12	6/10	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	4/6	
		150-180	10/14	10/14	10/14	8/12	8/12	6/10	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	3/4	3/4	
		190-300	10/14	10/14	10/14	8/12	8/12	6/10	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	3/4	3/4	
		350-400	10/14	10/14	8/12	8/12	6/10	6/10	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	3/4	3/4	
		450-500	10/14	8/12	8/12	6/10	6/10	6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	3/4	3/4	2/3	

Band Speed

Material	in m/min.
Construction Steel/ Machining Steel	80-90
Case Hardened Steels/ Steels for hardening & tempering	45-75
Non-Alloy. Tool Steels/ Roller Bearing Steels	40-60
Alloyed Tool Steels/ High Speed Steels	30-40
Rust Resistant Steels*	20-35
Heat Resistant Steels*/ High Temp. Alloy Steels*	15-25

Break In Procedure

The life of a bandsaw blade can be increased significantly by following the recommended running-in procedure. A new saw blade benefits from a short period of cutting at reduced cutting feed rate. Use normal recommended band speed and reduce feed pressure by 50%. After approximately 500cm² of cross sectional area or 15 minutes has been sawn, the band speed should be gradually increased to maximum, followed by the feed rate. Further detailed technical advice is available by calling (07) 3323 6311 or (07) 4952 5988.

Trouble Shooting

Stripping Teeth

- ✗ Wrong tooth selection
- ✗ Parts not held securely
- ✗ Feed rate too high or speed too slow
- ✗ Chip brush not working, causing chips to overload gullets
- ✗ Check coolant concentration

Band Breakage

- ✗ Worn Guides
- ✗ Guide arms set too far apart
- ✗ Wrong band tension
- ✗ Feed rate too high
- ✗ Poor butt weld

Rough Cut

- ✗ Band speed too slow and feed rate too high
- ✗ Improper break-in
- ✗ Dull or damaged teeth
- ✗ Check chip brush

Crooked cut

- ✗ Dull blade
- ✗ Improper break-in
- ✗ Guide arms too far apart or out of alignment
- ✗ Damaged roller or carbide guides
- ✗ Feed rate too heavy or blade speed too slow
- ✗ Tooth pitch too fine
- ✗ Band tension too low
- ✗ Vice clamp out of square

Premature dulling of teeth

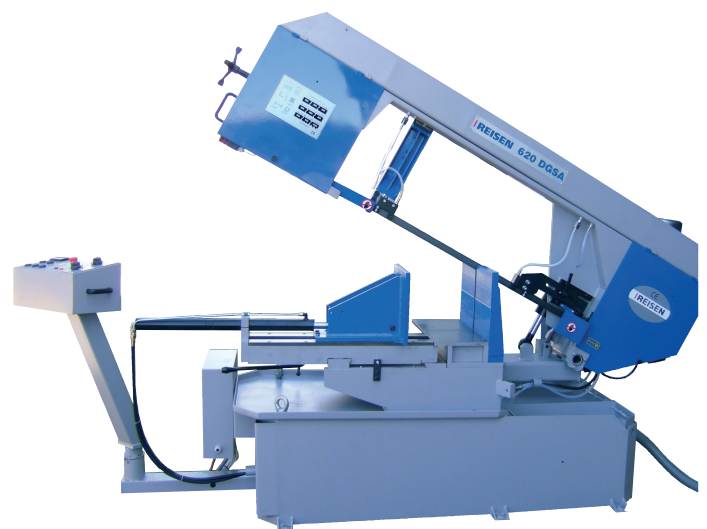
- ✗ Improper break-in
- ✗ Check coolant concentration and flow
- ✗ Check chip brush
- ✗ Check feed rates and blade speed
- ✗ Select proper tooth pitch



Supplied with safety strip which can be left on while fitting to machine.

Dependable Quality...

The RÖNTGEN bi-alfa cobalt bandsaw blade has HSS M42 cutting tips. The high wear resistance of the saw blade results from the very hard and evenly distributed carbides in the tooth tips, formed during the hardening and tempering process. With a steel backing strip containing around 4% chromium, the saw blade can withstand the considerable flexing stresses, tension and blade guide pressure present in modern sawing machines.



WTS

**WHITELAW
TOOLING SUPPLIES**

Brisbane:

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