Håkansson Sågblad AB

TECHNICAL DATA SHEET

BI-METAL BLADES FOR METAL

M42 BI-METAL

● Standard products
○ Special - MOQ may be required

Our M42 Bi-metal blades are made of the highest quality European Cobalt M42 steel. Extra Heavy Set (EHS) available upon request.

ALLPOWER™

Teeth/inch

sizes (mm)	3	4	6	2/3	3/4	4/6	5/8	6/10	8/12	10/14	14/18	sizes (inches)
6 x 0.6			○							○		1/4 x .025
6 x 0.9										○		1/4 x .035
10 x 0.6			○							●		3/8 x .025
10 x 0.9		●	○							●		3/8 x .035
12 x 0.6	○	○	●					●	●	●	○	1/2 x .025
12 x 0.9	○	●	●							●	○	1/2 x .035
19 x 0.9	●	○				●	●	●	●	●		3/4 x .035
27 x 0.9				●	●	●	●	●	●	●		1 x .035
34 x 1.1				●	●	●	●	●	●			1 1/4 x .042
41 x 1.3				●	●	●	●	●				1 1/2 x .050
54 x 1.3				○	○							2 x .050
54 x 1.6				●	●	●	●					2 x .063
67 x 1.6				●	●	●						2 5/8 x .063

ALLPOWER SE NEW

Teeth/inch

sizes (mm)	3	4	2/3	3/4	4/6	5/8	6/10	8/12	10/14	sizes (inches)
19 x 0.9	○	○			○	○	○	○	○	3/4 x .035
27 x 0.9				○	○	○	○	○	○	1 x .035
34 x 1.1			○	○	○	○	○	○		1 1/4 x .042

POWERMAX VS™ NEW

Teeth/inch

sizes (mm)	3/4	4/6	5/7	8/11	sizes
27 x 0.9	●	●	●	●	1 x .035
34 x 1.1	●	●	●	○	1 1/4 x .042
41 x 1.3	●	●	○		1 1/2 x .050

COMMANDER™

Teeth/inch

sizes (mm)	2/3	3/4	4/6	sizes (inches)
27 x 0.9	●	●	●	1 x .035
34 x 1.1	●	●	●	1 1/4 x .042
41 x 1.3	●	●	○	1 1/2 x .050
54 x 1.6	●	●	○	2 x .063

OPTIMIZER™

Teeth/inch

sizes (mm)	1.25	0.8/1.3	1.3/2	sizes (inches)
34 x 1.1	●			1 1/4 x .042
41 x 1.3	○		●	1 1/2 x .050
54 x 1.6	○	○	●	2 x .063
67 x 1.6		○	○	2 5/8 x .063

POWERMAX PRO™ NEW

Teeth/inch

sizes (mm)	2/3	3/4	4/6	sizes (inches)
34 x 1.1	○	○	○	1 1/4 x .042
41 x 1.3	○	○	○	1 1/2 x .050
54 x 1.6	○	○	○	2 x .063
67 x 1.6	○	○	○	2 5/8 x .063

PM51 BI-METAL

Our PM51 bi-metal blades are made using a high-alloy backing material and an HSS PM51 tooth tip. Extra Heavy Set (EHS) available upon request.

PERFORMER™

Teeth/inch

sizes (mm)	0.8/1.3	1.3/2	2/3	3/4	4/6	sizes (inches)
27 x 0.9			○	●	●	1 x .035
34 x 1.1			●	●	●	1 1/4 x .042
41 x 1.3		●	●	●	○	1 1/2 x .050
54 x 1.6	○	●	●			2 x .063
67 x 1.6	○	●	○			2 5/8 x .063
80 x 1.6	●	○	○			3 1/8 x .063

ALLPERFORMER™ NEW

Teeth/inch

sizes (mm)	2/3	3/4	4/6	5/8	6/10	8/12	10/14	sizes (inches)
27 x 0.9	○	○	○	○	○	○	○	1 x .035
34 x 1.1	○	○	○	○	○	○		1 1/4 x .042
41 x 1.3	○	○	○	○	○			1 1/2 x .050
54 x 1.6	○	○	○	○				2 x .063
67 x 1.6	○	○	○					2 5/8 x .063

PERFORMER X™

Teeth/inch

sizes (mm)	0.8/1.3	1.1/1.6	1.3/2	sizes (inches)
41 x 1.3		○	○	1 1/2 x .050
54 x 1.6	○	○	○	2 x .063
67 x 1.6	○	○	○	2 5/8 x .063
80 x 1.6	○	○	○	3 1/8 x .063

CARBIDE BLADES FOR METAL

CT CARBIDE

● Standard products
○ Special - MOQ may be required

Blades tipped with Tungsten Carbide offer many advantages when cutting high hardness materials. They are more durable than conventional blades resulting in longer life and less time spent changing blades. In addition, they retain their sharpness better to give high performance for longer.

RAPID CT10

Teeth/inch

sizes (mm)	0.8/1.2	1.1/1.6	1.5/2	2/3	3/4	sizes (inches)
27 x 0.9					○	1 x .035
34 x 1.1				○	○	1 1/4 x .042
41 x 1.3			○	○	○	1 1/2 x .050
54 x 1.6			○	○		2 x .063
67 x 1.6		○	○			2 5/8 x .063
80 x 1.6	○	○				3 1/8 x .063

RAPID CT20

Teeth/inch

sizes (mm)	0.8/1.2	1.1/1.6	1.5/2	2/3	sizes (inches)
34 x 1.1				○	1 1/4 x .042
41 x 1.3			○	○	1 1/2 x .050
54 x 1.6			○	○	2 x .063
67 x 1.6	○	○	○		2 5/8 x .063
80 x 1.6	○	○			3 1/8 x .063

RAPID CT30

Teeth/inch

sizes (mm)	2	3	1.5/2	2/3	sizes (inches)
19 x 0.9		○			3/4 x .035
27 x 0.9		○		○	1 x .035
34 x 1.1	○	○	○		1 1/4 x .042

RAPID CT40

Teeth/inch

sizes (mm)	2/3	3/4	sizes (inches)
27 x 0.9		○	1 x .035
34 x 1.1		○	1 1/4 x .042
41 x 1.3	○	○	1 1/2 x .050

CARBIDE GRIT

Used for extremely hard material that cannot be cut using normal saw blades.

CARBIDE GRIT - STRAIGHT EDGE

sizes (mm)		sizes (inches)
12 x 0.60	○	1/2 x .025
19 x 0.80	○	3/4 x .032

CARBIDE GRIT - GULLETED EDGE

sizes (mm)		sizes (inches)
12 x 0.60	○	1/2 x .025
19 x 0.80	○	3/4 x .035
25 x 0.90	○	1 x .035
32 x 1.10	○	1 1/4 x .042

BLADES BASED ON MATERIAL

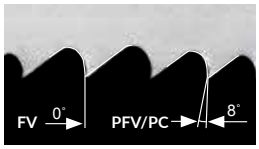
Non Ferrous, Aluminum	Carbon steels	Thin to Medium profiles	Thick profiles and H-beams	Alloy steels	Mold Steels	Stainless Steels	Duplex	Tool Steels	Titanium alloys	Incone 625	High temp steels, Inconel	Surface hardened	Application symbols
Easy to cut												Difficult to cut	
ALLPOWER				ALLPOWER		ALLPOWER							
ALLPOWER SE				ALLPOWER SE		ALLPOWER SE							
	COMMANDER			COMMANDER				COMMANDER					
	OPTIMIZER			OPTIMIZER				OPTIMIZER					
		POWERMAX VS											
			POWERMAX PRO										
ALLPERFORMER				ALLPERFORMER				ALLPERFORMER					
	PERFORMER			PERFORMER							PERFORMER		
	PERFORMER X			PERFORMER X							PERFORMER X		
			POWERMAX PRO										
				CT-10									
				CT-20									
CT-30													
									CT-40				

RECOMMENDED - VERY GOOD	CUTTING POSSIBLE

M42 BI-METAL

ALLPOWER™

- Our most popular allround blade from workshops to heavy industrial cutting
- Suitable for production as well as non-production cutting
- Produced from HSS M42 edge and known for its consistency
- Tooth set: AR
- Positive cutting angle (8°) in pitches: Tooth profile: PC (Hook) 3, 4, 6, Tooth profile: PFV 2/3, 3/4, 4/6 and 5/8
- Zero degree cutting angle (0°) in variable tooth pitches 6/10, 8/12, 10/14 and 14/18. Tooth profile: FV



ALLPOWER SE

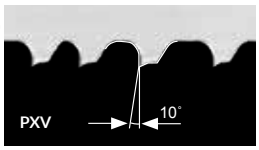
NEW

- Made from Western European raw materials and manufactured in our factory in Åmål, Sweden
- Ideal blade for general cutting applications
- Tooth set: AR
- Positive cutting angle (8°) in pitches: Tooth profile: PC (Hook) 3, 4, Tooth profile: PFV 2/3, 3/4, 4/6 and 5/8
- Zero degree cutting angle (0°) in variable tooth pitches 6/10, 8/12, and 10/14. Tooth profile: FV

POWERMAX VS™

NEW

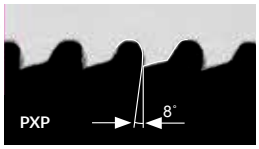
- **Now with variable setting height!**
- A completely different type of blade with a unique design and setting pattern.
- Results in high performance for interrupted cuts in structural steels like tubes, profiles and beams.
- Shock-resistant, reduces vibrations, noise level, and tooth breakage.
- Especially suitable for bundle cutting in one or multiple layers.
- Tooth set: AR.



POWERMAX PRO™

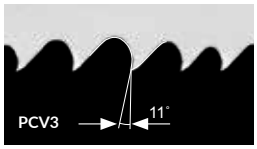
NEW

- This new blade is perfect for thick web H beams, thick web Angles, Seamless thick-walled tubes, thick flanges cutting.
- Bundle cutting depends on application and thickness.
- Extra-Heavy Set or Standard Set upon request.
- Shock-resistant, reduces vibrations, noise level, and tooth breakage.
- Especially suitable for bundle cutting in one or multiple layers.
- Tooth set: AR.
- Variable Setting height
- Also available in PM51



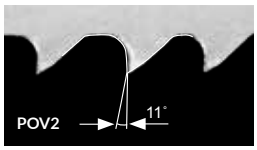
COMMANDER™

- The suitable choice where high productivity is required
- Specially designed for optimal chip flow and increased cutting rate
- High wear resistance
- Produced from HSS M42 edge suitable for solid and tough materials
- Tooth set: AR
- Tooth profile: PCV III



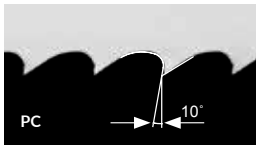
OPTIMIZER™

- Specially designed tooth for improved chip flow
- For tough and demanding production cutting
- Fast cutting of wide cross sections of ferrous and non-ferrous metals
- High heat and wear resistance
- Increased blade life when sawing in material that can work harden if not consistently penetrated
- Tooth profile: POV II



M42 LOG™

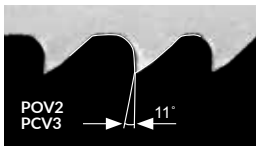
- For portable sawmills
- The suitable choice were high production is required
- Specially designed for optimal chip flow and increased cutting rate
- High wear resistance
- HSS edge for longer run time between regrinding
- Tooth set: RS



PM51 BI-METAL

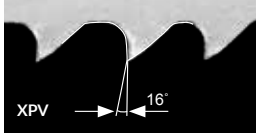
PERFORMER™

- PM51 HSS tooth
- Heavy set
- High wear and heat resistance
- Long and reliable tool life
- High shock resistance
- For difficult to cut materials
- Higher cutting rate
- Tooth set: AR
- Tooth profiles: POVII, PCVIII



PERFORMER X™

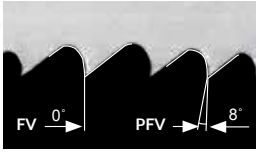
- For higher productivity on harder materials
- Special tooth profile - 16°
- PM51 HSS tooth
- Extra heavy set available
- High wear and heat resistance
- Long and reliable tool life
- High shock resistance
- Suitable for high-alloy materials
- Improved chip flow
- Higher cutting rate
- Tooth set: AR
- Tooth profile: XPV



ALLPERFORMER™

NEW

- Tooth profile: PFV 8° in variable tooth pitches 2/3, 3/4, 4/6 and 5/8
- Tooth profile: FV: 0° in variable tooth pitches 6/10, 8/12 and 10/14
- Great for all machines
- PM51 HSS tooth
- High wear and heat resistance
- Long and reliable tool life
- High shock resistance
- For difficult to cut materials
- Higher cutting rate



CT CARBIDE

RAPID CT10

- Carbide tipped band saw blade for cutting tool steels, high speed steels and stainless steels
- The unique tooth geometry results in better chip separation, low noise and high cutting rates
- For faster cutting and excellent finish

RAPID CT20

- Carbide tipped band saw blade with unique setting
- For cutting materials with residual stress
- Suitable for titanium, titanium alloys, and Ni-Cr based alloys
- Ideal for wider / thicker profiles

RAPID CT30

- Carbide tipped band saw blade developed for cutting non-ferrous materials and especially aluminum
- The fatigue resistant alloyed steel backing withstands the severe mechanical stress due to the high cutting speeds and feeds
- For high productivity and long blade life

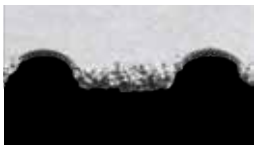
RAPID CT40

- Carbide tipped band saw blade with special design developed for cutting hardened and tempered or induction hardened materials
- For cutting materials with hardness between 50-60 HRc

CARBIDE GRIT

CARBIDE GRIT – STRAIGHT EDGE

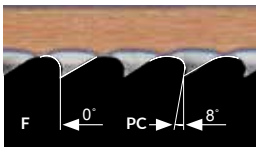
- Instead of teeth, this saw blade has carbide grains soldered in place
- Used for extremely hard material that cannot be cut using normal saw blades
- Suitable for glass, fibreglass, titanium and nickel alloys



CARBIDE GRIT – GULLETED EDGE

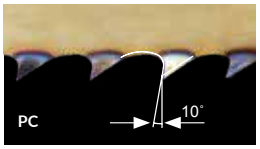
- Instead of teeth, this saw blade has carbide grains soldered in place
- Used for extremely hard material that cannot be cut using normal saw blades
- Suitable for composites, ceramics, wire, tyres and hardened steels

FLEXBACK CARBON STEEL



SILCO™

- Suitable for cutting wood, aluminum, brass, bronze, cast iron, copper, lead, zinc, graphite
- Manufactured from high silicon steel
- High quality, flexibility and performance make the blade ideal for friction cutting
- Hardened tooth tip/flexible back
- Tooth set: AR



SILCO LOG™

- Our most popular saw blade for portable sawmills
- Carbon steel with hardened teeth
- Produced from the best raw material with high silicon content
- Tooth set: RS

HOBBY

- Extra flexible blade
- Specially designed for small bandsaw machines with small diameter wheels
- Tooth set: AR

ACCESSORIES

TENSION METER

Correct band tension is essential for straight cut and prolonged blade life.

REFRACTOMETER

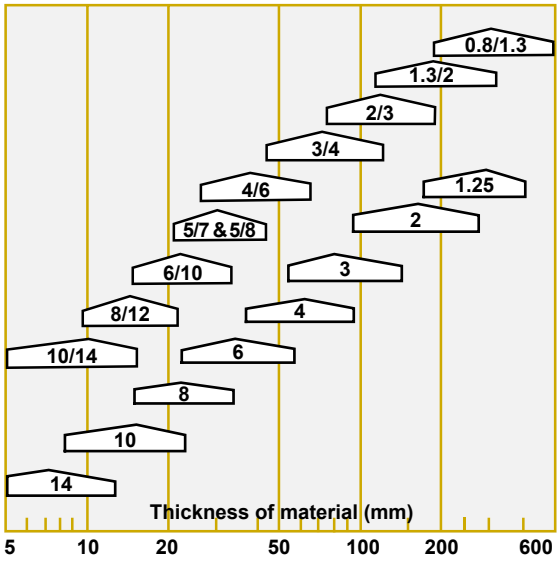
Proper concentration of the cooling lubricants is of utmost importance for the cutting result.

TACHOMETER

Digital tachometer showing the band speed in feet/min as well as m/min.

RECOMMENDED TOOTH PITCH.

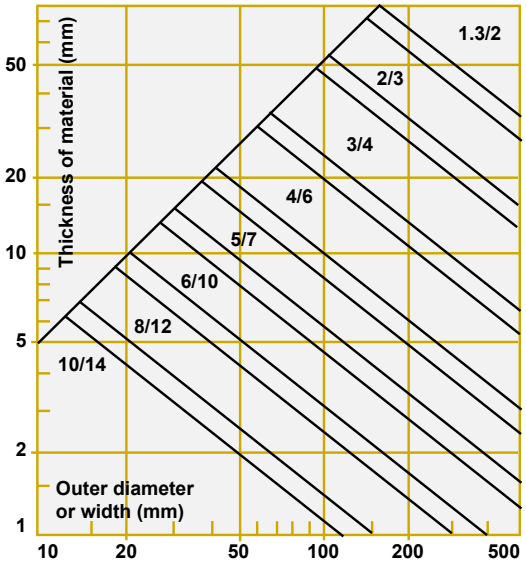
Solid work piece



This diagram is a guide to help you chose the correct tooth pitch when **cutting solid work pieces**.
The very best choice is where the tooth pitch-area is at its widest.

When cutting soft materials such as wood, plastics, aluminum etc. choose a two-step coarser tooth pitch.

Pipes and profiles



This diagram is a guide to help you chose the correct tooth pitch when **cutting pipes and profiles**. The very best choice is in the area, where a line from the outer diameter crosses a line from the thickness of the material.

When cutting profiles, choose the tooth pitch, where the line from the width of the profile crosses the line from the material thickness of the profile.

Can't see what you're looking for?
Contact us to find out about other options and customization possibilities to match your application.

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