

# BI-ALFA

## COBALT M42

The ROENTGEN bi-alfa cobalt band saw blade has HSS-M42 cutting tips. The high wear resistance of the band saw blade results from the very hard and evenly distributed carbides in the tooth tips, formed during the hardening and tempering process. The martensitic structure of the tooth tips and the high cobalt content create excellent heat resistance and toughness reducing wear rates at high sawing speeds. With a high chromium backing, the saw blade can withstand the considerable flexing stresses, tension and blade guide pressure.

### HOOK TOOTH

#### TOOTH FORM



The hook tooth has a positive cutting angle of 10°. This tooth form is particularly suitable for cutting solid, thick-walled tubes and all higher-grade alloy material.

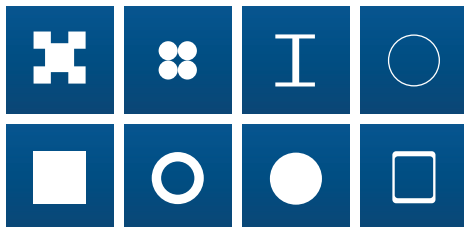
### NORMAL TOOTH

#### TOOTH FORM



The normal tooth has a cutting angle of 0°. It is suitable for cutting material with a high carbon content (such as cast iron), for material with small cross sections and for thin-walled profiles and tubes.

### APPLICATION AREAS



### Teeth per inch / Constant tooth pitch (Normal tooth)

	3	4	6	8	10	14	18
6 x 0,6							
6 x 0,9							
10 x 0,6							
10 x 0,9							
13 x 0,6							
13 x 0,9							
20 x 0,9							
27 x 0,9							
34 x 1,1							
41 x 1,3							
54 x 1,3							
54 x 1,6							
67 x 1,6							
80 x 1,6							

Band saw blade width x thickness (mm)

### Teeth per inch / Constant tooth pitch (Hook tooth)

	1,25	2	3	4	6
6 x 0,6					
6 x 0,9					
10 x 0,6					
10 x 0,9					
13 x 0,6					
13 x 0,9					
20 x 0,9					
27 x 0,9					
34 x 1,1					
41 x 1,3					
54 x 1,3					
54 x 1,6					
67 x 1,6					
80 x 1,6					

Band saw blade width x thickness (mm)

### Teeth per inch / Combi tooth pitch (Normal tooth)

	0,75/1,25	1,1/1,6	1,5/2	2/3	3/4	4/5	4/6	5/6	5/8	6/10	8/12	10/14
6 x 0,6												
6 x 0,9												
10 x 0,6												
10 x 0,9												
13 x 0,6												
13 x 0,9												
20 x 0,9												
27 x 0,9												
34 x 1,1												
41 x 1,3												

Band saw blade width x thickness (mm)

### Teeth per inch / Combi tooth pitch (Hook tooth)

	0,75/1,25	1,1/1,6	1,5/2	2/3	3/4	4/5	4/6	5/6	5/8	6/10	8/12	10/14
20 x 0,9												
27 x 0,9												
34 x 1,1												
41 x 1,3												
54 x 1,3												
54 x 1,6												
67 x 1,6												
80 x 1,6												

Band saw blade width x thickness (mm)