



CIRCULAR SAW BLADES

HIGH PERFORMANCE FOR CUTTING STEEL AND PIPES

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ABOUT US



SOLUÇÕES EM FERRAMENTAS DE CORTE COM ALTA TECNOLOGIA, QUALIDADE E PRECISÃO.

For over 30 years, the Hagane Group has excelled in the manufacture of tools such as knives, rollers, and saws for cutting and shaping metals.

We operate with innovation and customized technologies to serve different segments, encompassing companies throughout Brazil and countries in Latin America.

We invest in the continuous training of our team to guarantee excellence and superior results.





HSS

HIGH PERFORMANCE AND
PRECISION FOR DEMANDING CUTS



QUALITY OF STEELS

The robustness and precision that elevate the performance of Hagane circular saws.

> HSS

Hagane circular saws are manufactured from high-performance high-speed steel, offering strength, durability, and precision cutting. Their special elements provide high toughness, excellent thermal stability, and high wear resistance.

> HAGMAX

High-speed steel developed for maximum hardness and wear resistance. Maintains superior performance when cutting high-strength materials, such as stainless steel, even under high operating temperatures.

COATINGS

Hagane offers 3 types of coatings for the HSS saw, guaranteeing precision, durability and high performance in every cut.

> VAPORIZED OV

Controlled oxidation treatment for circular saws increases surface hardness and self-lubrication. Not compatible with aluminum, copper, and brass.

Technical characteristic:

Dureza superficial: 900 HV
Coeficiente de atrito: 0,65

> TiAlN

It is suitable for cutting high-strength materials and stainless steels, as well as abrasive materials such as pig iron, silicon alloys, aluminum, brass, and copper. Ideal for dry cutting at high speeds.

Technical characteristic:

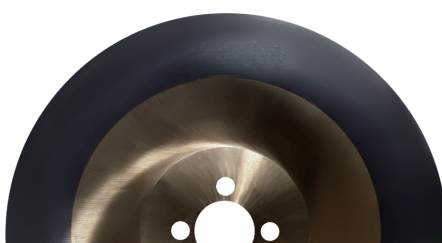
TiAlN Coating
Surface Hardness: 3,300-3,500 HV
Oxidation Temperature: 875°C
Coefficient of Friction: 0.45
Applications: Hard steel, stainless steel and pig iron.

> WHITE

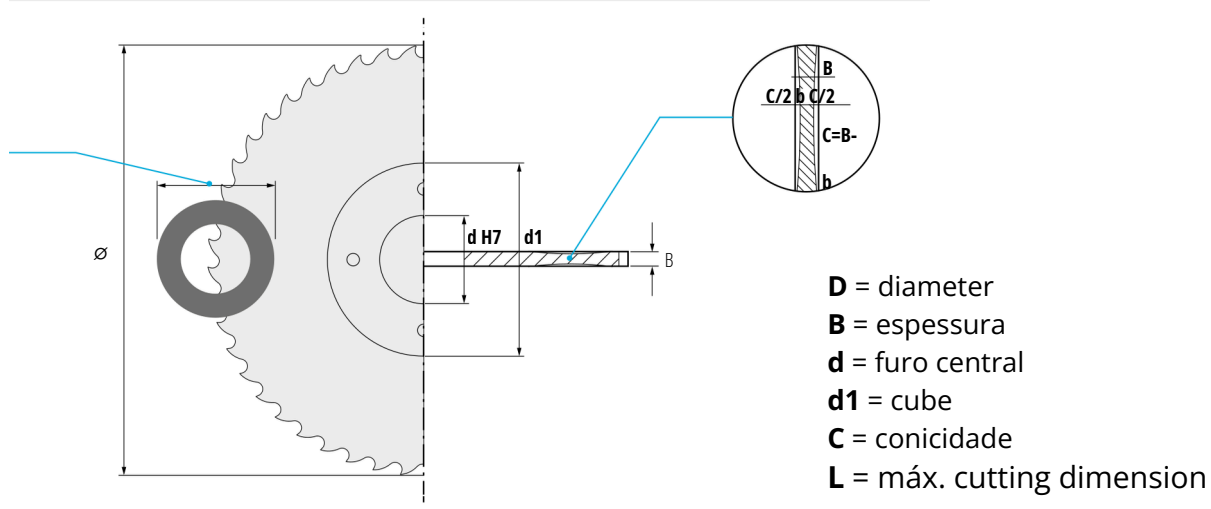
The polished finish offers high hardness and low friction, making it ideal for cutting sticky materials such as brass, copper, bronze, and aluminum.

Technical characteristic:

Coefficient of friction: 0.30
Applications: Brass, copper, bronze, aluminum and their alloys.

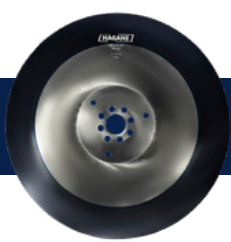


The following diagram illustrates the main dimensions of the circular saw:



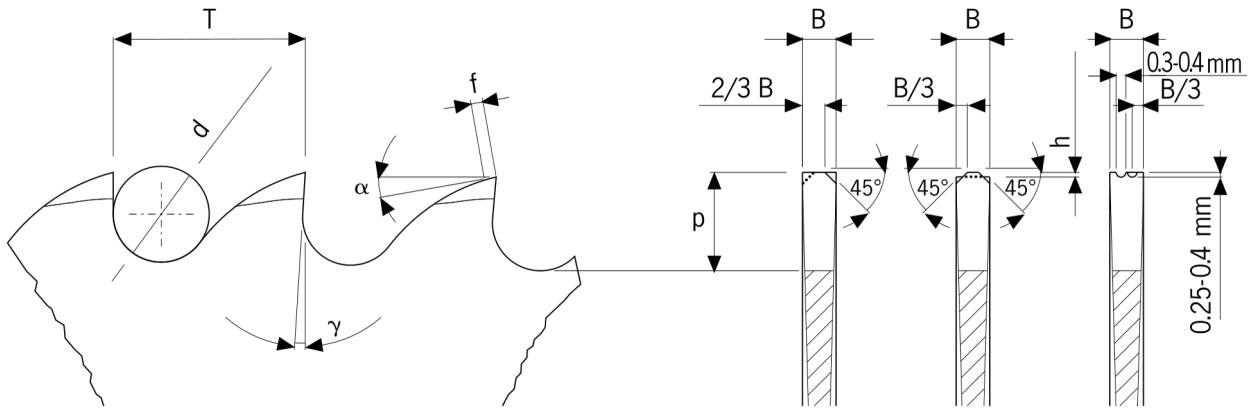
Ø	BATIMENTO LATERAL	MAXIMUM CUTTING CAPACITY Ø mm
[mm]	[mm]	
200	0,08 - 0,12	45
225	0,08 - 0,12	55
250	0,08 - 0,12	60
275	0,10 - 0,15	65
300	0,10 - 0,15	70
315	0,12 - 0,18	75
325	0,12 - 0,18	78
350	0,12 - 0,18	80
370	0,15 - 0,20	86
400	0,15 - 0,20	96
425	0,15 - 0,20	106
450	0,15 - 0,20	112
500	0,20 - 0,22	128
525	0,20 - 0,25	135
550	0,20 - 0,25	140
560	0,20 - 0,25	145
600	0,20 - 0,25	145
630	0,20 - 0,25	150

FURO CENTRAL	CODE	FURO DE ARRASTE
Ø 25,4	AE	-
Ø 32	BN	2/ 8 /45+2/ 9/ 50+2/ 11 /63
Ø 38	AK	2/ 9/ 55
Ø 40	AC	2/ 8 /55+4/ 12/ 64
Ø 40	BK	4/ 12/ 64+2/ 15/ 80+2/ 15/ 100
Ø 50	BF	4/ 15/ 80+4/ 14/ 85
Ø 80	MM	4/ 23/ 120
Ø 90	IR	3/ 12,5/ 160
Ø 140	PN	4/ 17,5/ 170



HSS SAW BLADE

> GEOMETRIA DO DENTE



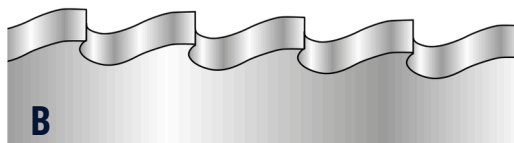
T - Tooth step
P - Tooth height
h - Difference HZ
γ - Cutting angle

α - Ângulo de saída
f - Angle length
B - Blade thickness
d - Throat diameter

α°/γ° CUTTING ANGLE					
MATERIAL		DMo5		Co5	
		γ	α	γ	α
Steel	< 500 [N/mm ²]	18°	12°	—	—
	< 800 [N/mm ²]	15°	8°	15°	8°
	< 1200 [N/mm ²]	12°	6°	12°	6°
Stainless steel		12°	6°	12°	6°
Cast Iron		12°	8°	—	—
Aluminum		15°	15°	—	—
Bronze		12°	8°	—	—
Copper		16°	18°	—	—
Brass		15°	15°	—	—
Zinc alloys		12°	8°	—	—
Inconel		—	—	12°	8°
Titanium		—	—	12°	6°

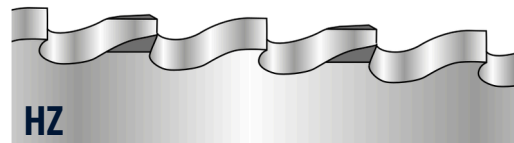


➤ TYPE OF TEETH



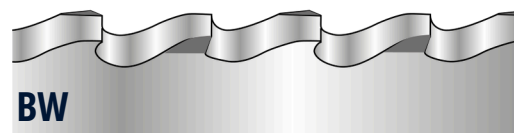
B

Common in machines for ferrous materials, with a wide discharge opening for thicker materials.



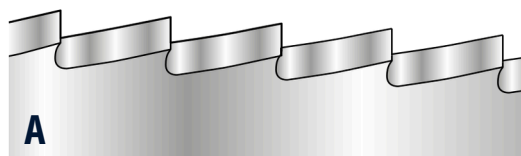
HZ

Alternating taller roughing teeth and shorter finishing teeth. Ideal for cutting thicker materials.



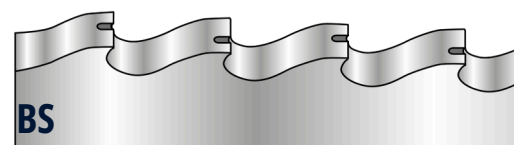
BW

Alternating teeth for efficient cutting of ferrous materials, ideal for pipes and profiles up to 3–4 mm.



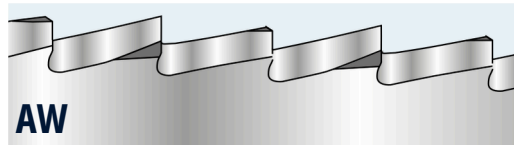
A

Suitable for precision mechanics and goldsmithing. Thin blades with a pitch of 0.8 to 3 mm and a sharp cutting edge.



BS

The chip breaker is ideal for cutting pipes on automatic machines. It ensures fragmented chips, an excellent finish, and increased blade durability.

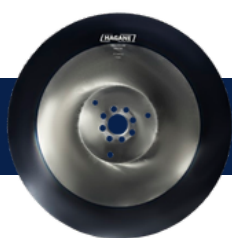


AW

Thin blades, 0.8–3 mm pitch, chamfered tooth for efficient chip fragmentation.

T		ESCOLHA DO PASSO DOS DENTES												
		THICKNESS (TUBE)						CUTTING SECTION (SOLID)						
		<1 [mm]	1,1/1,5 [mm]	1,6/2 [mm]	2,1/3 [mm]	3,1/4 [mm]	<4 [mm]	10/20 [mm]	21/40 [mm]	41/60 [mm]	61/80 [mm]	81/110 [mm]	111/130 [mm]	131/150 [mm]
MATERIALS	<500 [N/mm ²]	3	4	5	5	6	7	6	8	10	12	14	16	18
	<800 [N/mm ²]	3	4	4	5	6	7	6	8	10	12	14	16	18
	<1200 [N/mm ²]	3	3	4	5	5	6	5	7	9	11	13	15	17
Stainless steel		3	4	5	5	6	6	5	7	9	11	13	15	17
Cast Iron								6	8	10	13	15	17	19
Aluminum		4	5	6	7	8	8	8	9	12	16	18	20	20
Bronze		4	5	6	7	8	9	7	10	10	13	16	15	19
Copper		4	5	6	7	8	8	8	10	10	14	17	19	20
Brass		4	5	6	7	8	8	8	10	12	14	17	19	20
Zinc alloys		3	4	5	5	6	7	5	6	10	12	14	16	16
Inconel		3	3	4	5	5	6	5	6	8	10	12	14	14
Titanium		3	3	4	5	5	6	5	6	8	10	12	14	14

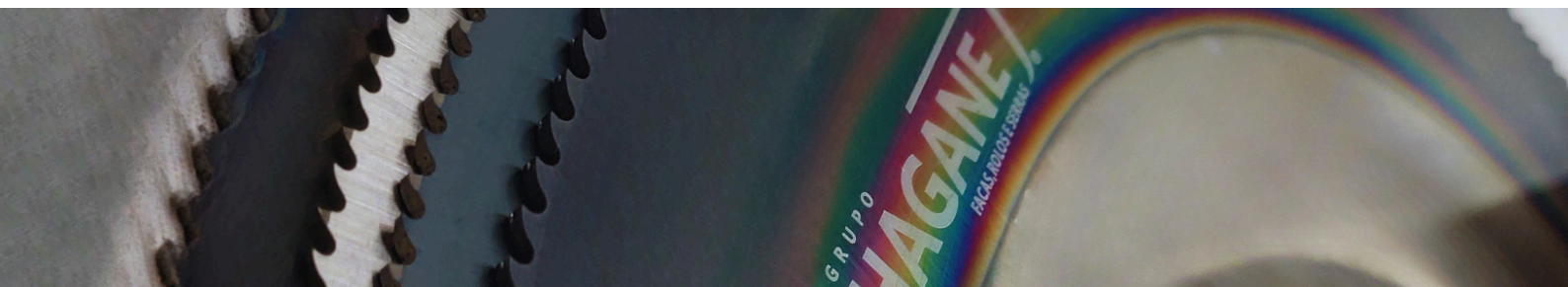
*This table is for reference only.

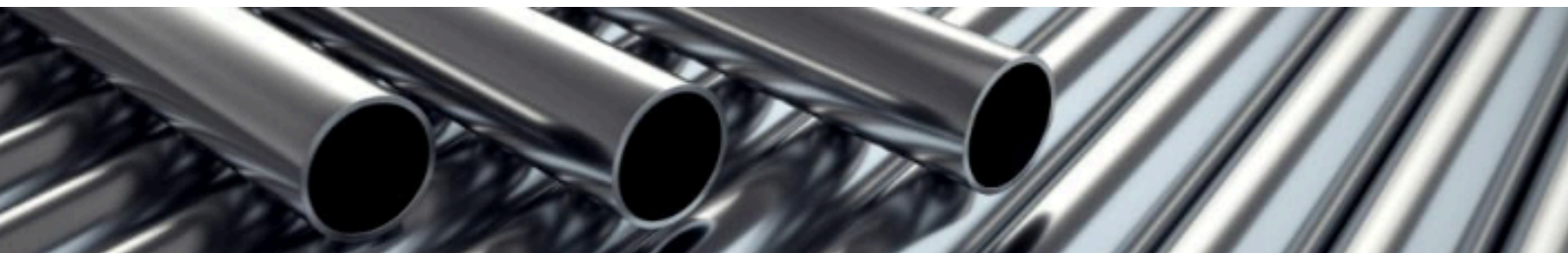


HSS SAW BLADE

STANDARD EXECUTION

Ø	Espessura	Furo Central	Flange	Number of teeth (pitch) and their shape.														
[mm]	[mm]	[mm]	[mm]	T2,5	T3	T4	T4,5	T5	T5,5	T6	T7	T8	T9	T10	T12	T14	T16	T18
200	1,2	32	100															
200	1,6	32	100	250	200	160	140	130	120	100	90	80	70	60				
200	2,0	25,4/32	100															
200	2,5	32	100	250	200	160	140	130	120	100	90	80	70	60				
250	1,6	32																
250	2,0	32/40	100	320	240	200	180	160	140	128	110	100	90	80	66			
250	2,5	32/40	100															
275	1,6	32/40	100	340	280	220	200	180	160	140	120	110	96	90	70			
275	2,0	32/40	100															
275	2,5	32/40	100	340		220	200	180	160	140	120	110	96	90	70			
300	1,6	32/40	120															
300	2,0	32/40	100	380	300	220	210	180	170	160	140	120	104	94	80			
300	2,5	32/40	100															
300	3,0	32/40	100	380	300	220	210	180	170	160	140	120	110	94	80			
315	2,0	32/40	100															
315	2,5	32/40	100	400	300	240	220	200	180	160	140	120	120	100	80			
315	3,0	32/40	100															
350	2,0	32/40	120	440	350	280	240	220	200	180	160	140	120	110	90	80	70	60
350	2,5	32/40/50	120															
350	3,0	32/40/50	120	440	350	280	240	220	200	180	160	140	120	110	90	80	70	60
370	2,0	32/40	130															
370	2,5	32/40/50	120		380	280	260	220	210	190	160	140	120	110	100	80	70	60
400	2,5	32/40/50	130															
400	3,0	32/40/50	120			310	280	250	230	200	180	160	140	120	110	96	80	70
425	2,5	32/40/50	130															
425	3,0	32/40/50	130			320	300	260	240	220	190	160	150	130	110	96	84	70
450	2,5	40/50	140															
450	3,0	40/50	130			350	320	280	260	230	200	180	160	140	120	100	90	80
500	2,5/3,0	40/50	140															
500	3,0	40/50	140			390	350	310	280	260	230	200	170	160	130	110	100	90
525	3,5	50	140															
550	3,0	50/90/140	225			440	380	340	310	280	250	220	190	170	140	120	110	90
550	3,5	50/90/140	225															
600	3,5	50/80/90/140	225			460	420	380	340	320	270	240	210	190	160	130	120	100
630	4,0	80/90/140	225															





➤ CUTTING SPEED AND FEED

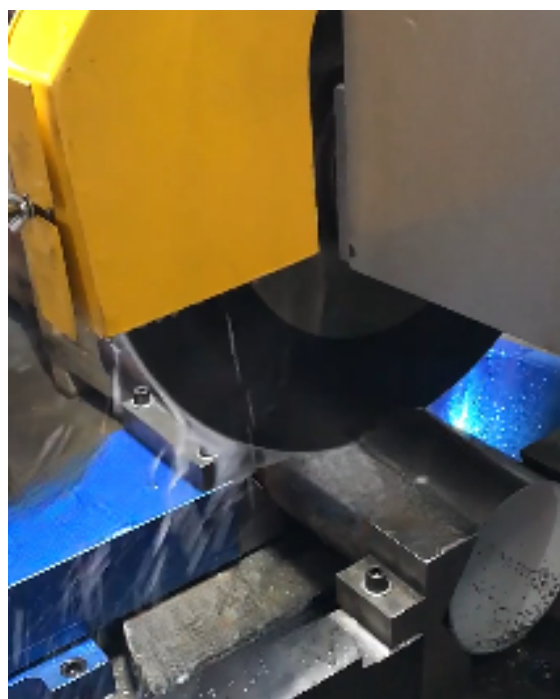
The cutting speed (V), in meters per minute, is not the same as RPM. To calculate the correct machine rotation speed:

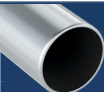
$$\text{RPM} = \frac{V \times 1000}{D \times 3.14}$$

V = cutting speed (m/min)
D = saw blade diameter (mm)

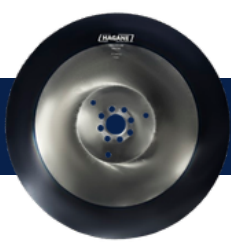
To optimize cutting, it is essential to simultaneously adjust the rotation speed and feed rate, especially in automatic machines.

The following table, based on experimental data, presents the recommended values for Cutting Speed (V) and Feed per Tooth (Az) according to the material being cut.

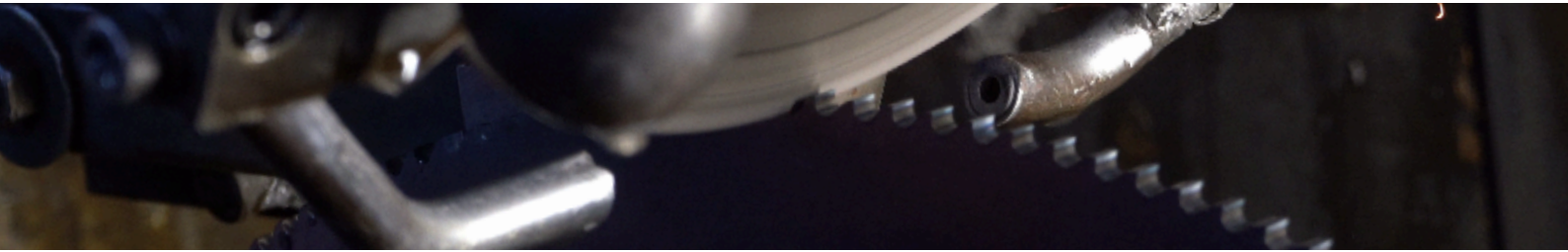


 MATERIALS		PIPE CUTTING PARAMETERS				
		ADVANCEMENT BY TOOTH (MM DENTE)			CUTTING PARAMETERS (RPM)	
		MINIMUM	SUGGESTED	MAXIMUM	WHITE/STEAMED	REVEST. TIALN
STEEL	<500 [N/mm ²]	0,025	0,03/0,10	0,24	45 - 130	70 - 230
	<800 [N/mm ²]	0,025	0,03/0,09	0,18	30 - 100	45 - 140
	<1200 [N/mm ²]	0,020	0,25/0,07	0,12	15 - 50	25 - 100
Stainless steel		0,020	0,25/0,06	0,015-0,06	15 - 45	15 - 80
Cast Iron		0,025	0,04/0,05	0,05	15 - 45	30 - 65
Aluminum		0,025	0,03/0,07	0,12	90 - 1200	1000 - 1600
Bronze		0,040	0,04/0,06	0,07	90 - 350	200 - 400
Copper		0,040	0,04/0,06	0,06	90 - 250	200 - 300
Brass		0,040	0,04/0,08	0,08	90 - 550	400 - 600
Zinc alloys		0,025	0,25/0,06	0,08		30 - 100
Inconel		0,025	0,25/0,06	0,08		15 - 45
Titanium		0,025	0,20/0,06	0,08		15 - 30

*This table is for reference only.



HSS SAW BLADE



In the previous table, in addition to the cutting speed, the recommended feed per tooth (A_z) values are indicated, which allow the calculation of the total feed to be programmed into the machine. The formula used is as follows:

$$\text{Avanço total } A = A_z \times Z \times \text{RPM}$$

Where:

- A_z = Advancement per tooth (mm/dente)
- A = Forward speed (mm/min)
- Z = Number of teeth

		PARÂMETROS DE CORTE MACIÇO			
		ADVANCEMENT BY TOOTH [MM/Z]		CUTTING PARAMETERS [RPM]	
MATERIALS		MINIMUM	MAXIMUM	WHITE / STEAMED	REVEST. TIALN
STEEL	<500 [N/mm ²]	0,025	0,08	30-40	30-115
	<800 [N/mm ²]	0,025	0,07	20-35	25-70
	<1200 [N/mm ²]	0,020	0,06	15-25	15-50
Stainless steel		0,020	0,06	10-25	10-40
Cast Iron		0,025	0,05	20-30	30-50
Aluminum		0,040	0,09	90-500	500-900
Bronze		0,040	0,07	90-300	200-400
Copper		0,040	0,06	90-250	200-300
Brass		0,040	0,08	90-550	400-600
Zinc alloys		0,025	0,08	90-100	30-100
Inconel		0,025	0,05		16-45
Titanium		0,020	0,05		15-30

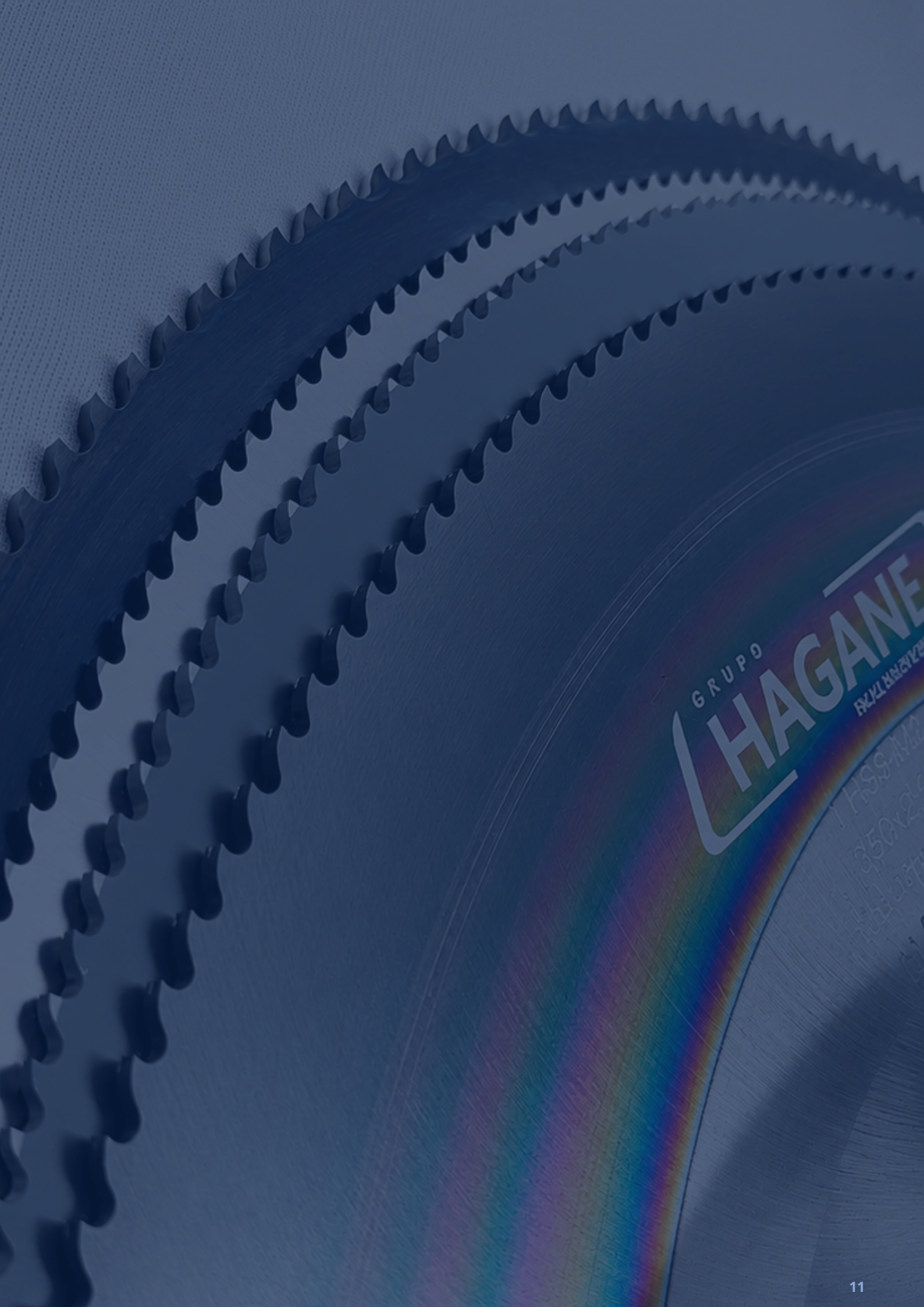


➤ FLYING CUTTING MACHINES

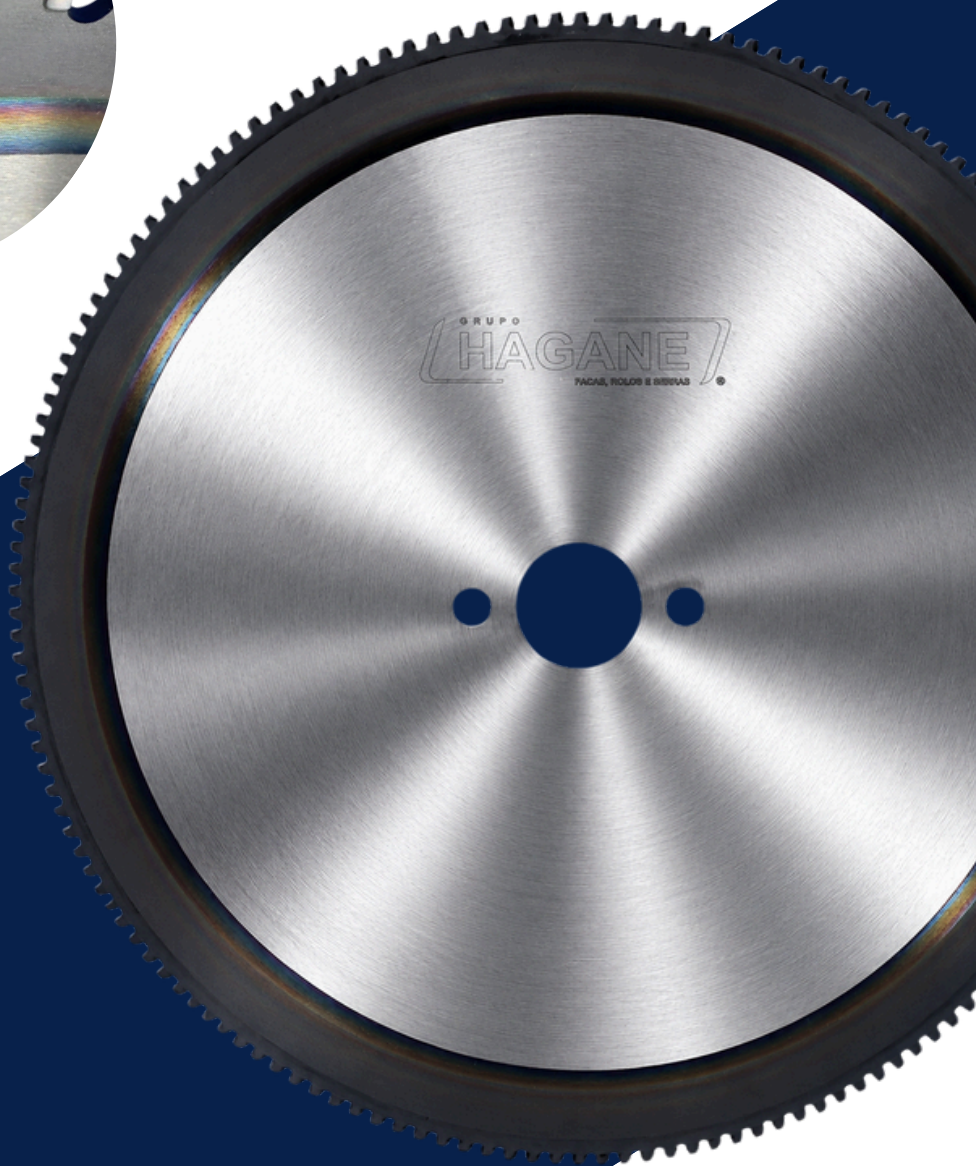
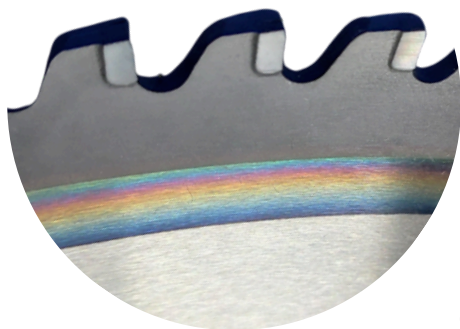
SUGGESTED PRICES FOR CUTTING PIPES AND PROFILES.



FLYING CUT		[MM/Z]			T	VC [MAX]			
Tube	Tube thickness	Advance/tooth			Passo T	Steel <500 [N/mm²]	Steel <550 -800 [N/mm²]	Steel <850 -1200 [N/mm²]	Stainless steel
[MM]	[MM]	[MM/Z]			[MM]	TIALN [M/1']	TIALN [M/1']	TIALN [M/1']	TIALN [M/1']
10	<1	0,040	0,085	0,035	3,0	240	160	110	90
	1 - 1,5	0,035	0,070	0,030	4,0	235	155	105	85
	1,5 - 2	0,035	0,050	0,030	5,0	230	150	100	80
	2 - 3	0,030	0,035	0,025	5,0	225	145	95	75
25	<1	0,040	0,120	0,035	3,0	235	155	105	85
	1 - 1,5	0,035	0,100	0,030	4,0	230	150	100	80
	1,5 - 2	0,035	0,085	0,030	5,0	225	145	95	75
	2 - 3	0,030	0,060	0,025	5,0	220	140	90	70
	3 - 4	0,030	0,050	0,025	6,0	215	135	85	65
	4 - 6	0,025	0,030	0,020	7,0	210	130	80	60
50	<1	0,030	0,120	0,025	4,0	230	150	100	80
	1 - 1,5	0,025	0,110	0,020	4,0	225	145	95	75
	1,5 - 2	0,025	0,095	0,020	5,0	220	140	90	70
	2 - 3	0,025	0,075	0,020	5,0	215	135	85	65
	3 - 4	0,025	0,065	0,020	6,0	210	130	80	60
	4 - 9	0,025	0,040	0,020	7,0	205	125	75	55
75	<1	0,035	0,120	0,030	5,0	225	145	95	75
	1 - 1,5	0,030	0,120	0,025	5,0	220	140	90	70
	1,5 - 2	0,025	0,120	0,020	5,0	215	135	85	65
	2 - 3	0,025	0,095	0,020	6,0	210	130	80	60
	3 - 4	0,025	0,080	0,020	6,0	205	125	75	55
	4 - 9	0,025	0,050	0,020	7,0	200	120	70	50
100	<1	0,040	0,120	0,035	6,0	220	140	90	70
	1 - 1,5	0,035	0,120	0,030	6,0	215	135	85	65
	1,5 - 2	0,030	0,120	0,030	6,0	210	130	80	60
	2 - 3	0,025	0,110	0,025	6,0	205	125	75	55
	3 - 4	0,025	0,095	0,020	7,0	200	120	70	50
	4 - 9	0,025	0,060	0,020	8,0	195	115	65	45
125	<1	0,035	0,120	0,030	6,0	215	135	85	65
	1 - 1,5	0,030	0,120	0,030	6,0	210	130	80	60
	1,5 - 2	0,025	0,120	0,025	6,0	205	125	75	55
	2 - 3	0,025	0,120	0,020	7,0	200	120	70	50
	3 - 4	0,025	0,110	0,020	7,0	195	115	65	45
	4 - 9	0,025	0,070	0,020	9,0	190	110	60	40
150	<1	0,035	0,120	0,030	6,0	210	130	80	60
	1 - 1,5	0,030	0,120	0,025	6,0	205	125	75	55
	1,5 - 2	0,025	0,120	0,020	6,0	200	120	70	50
	2 - 3	0,025	0,120	0,020	7,0	195	115	65	45
	3 - 4	0,025	0,120	0,020	7,0	190	110	60	40
	4 - 9	0,025	0,080	0,020	9,0	185	105	55	35
175	<1	0,040	0,120	0,035	7,0	205	125	75	55
	1 - 1,5	0,035	0,120	0,030	7,0	200	120	70	50
	1,5 - 2	0,030	0,120	0,025	7,0	195	115	65	45
	2 - 3	0,025	0,120	0,020	7,0	190	110	60	40
	3 - 4	0,025	0,120	0,020	8,0	185	105	55	35
	4 - 9	0,025	0,085	0,020	9,0	180	100	50	30



GRUPO
HAGANE
HSS-M2
350x25
100mm



TCT

MAXIMUM DURABILITY AND PRECISION
IN HIGH-STRENGTH MATERIALS.



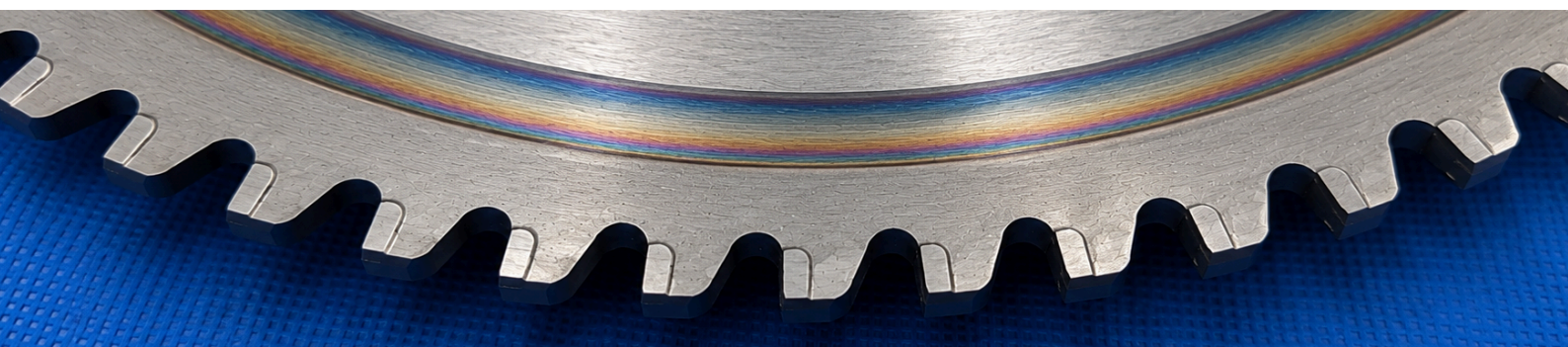


TCT SAW BLADE

Designed for cutting high-strength, abrasive, and dry materials, the TCT saw has:

- Dentes de carboneto (Tungstênio):
- Ideal for cutting carbon steel, high-strength alloy steel, stainless steel, and non-ferrous materials.
- Less cutting effort, better quality, and longer service life.

Ø [mm]	Espessura		Furo Central [mm]	Z	Pipe cutting capability	
	Tooth [mm]	Body [mm]			MAX [mm]	Espessura [mm]
315	2,20	1,90	32/40	80	90	4,0 - 7,5
	2,20	1,90	32/40	100	90	3,0 - 6,0
	2,20	1,90	32/40	120	90	2,5 - 5,0
	2,20	1,90	32/40	140	90	2,0 - 4,0
350	2,60	2,30	50	80	100	4,0 - 8,0
	2,60	2,30	50	100	100	3,0 - 6,5
	2,60	2,30	50	120	100	2,5 - 5,5
	2,60	2,30	50	140	100	2,2 - 4,5
360	2,60	2,30 [2,27]	32/40/50	80	110	4,5 - 9,0
	2,60	2,30 [2,27]	32/40/50	100	110	3,5 - 7,0
	2,60	2,30 [2,27]	32/40/50	120	110	3,0 - 6,0
	2,60	2,30 [2,27]	32/40/50	140	110	2,2 - 4,5
370	2,30	2,00	32/50	80	110	4,5 - 9,0
	2,30	2,00	32/50	100	110	3,5 - 7,0
	2,30	2,00	32/50	120	110	3,0 - 6,0
	2,30	2,00	32/50	140	110	2,2 - 4,5
400	3,00	2,50	50	100	115	3,5 - 7,0
	3,00	2,50	50	120	115	3,0 - 6,0
	3,00	2,50	50	140	115	2,5 - 5,0
450	2,90	2,50	50	90	145	5,0 - 10,5
	2,90	2,50	50	100	145	5,0 - 9,5
	2,90	2,50	50	120	145	4,0 - 8,0
	2,90	2,50	50	130	145	3,5 - 7,5
	2,90	2,50	50	140	145	3,0 - 7,0
	2,90	2,50	50	160	145	2,5 - 6,0
500	3,50	3,00	50	120	170	4,5 - 9,0
	3,50	3,00	50	140	170	4,0 - 8,0
	3,50	3,00	50	170	170	3,0 - 6,0
550	3,80	3,20	90/140	120	175	5,0 - 9,5
	3,80	3,20	90/140	140	175	4,0 - 8,0
	3,80	3,20	90/140	170	175	3,5 - 6,5
	3,80	3,20	90/140	180	175	3,0 - 6,0
560	3,80	3,20	80/90/140	120	180	5,0 - 9,5
	3,80	3,20	80/90/140	140	180	4,0 - 8,0
	3,80	3,20	80/90/140	170	180	3,5 - 6,5
600	3,80	3,20	90/140	120	200	5,0 - 11,0
	3,80	3,20	90/140	140	200	4,5 - 9,5
	3,80	3,20	90/140	170	200	4,0 - 8,0
	3,80	3,20	90/140	180	200	3,5 - 7,5



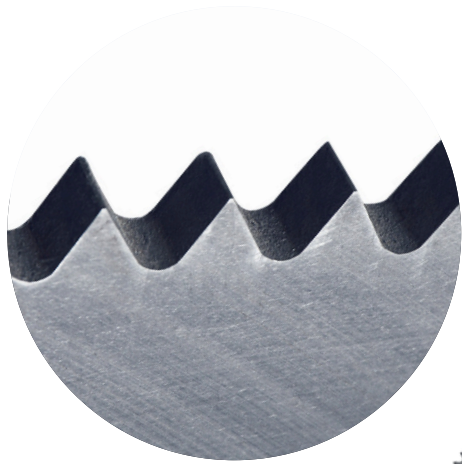
PIPE CUTTING PARAMETERS				
MATERIALS	> 2,0 mm <7m		> 7 mm	
	V [m/1]	AZ [mm/z]	V [m/1]	AZ [mm/z]
Carbon steel <500 [N/mm ²]	250 - 400	0,03 - 0,12	200 - 350	0,03 - 0,10
Carbon steel 500 – 750 [N/mm]	200 - 350	0,03 - 0,10	150 - 300	0,03 - 0,09
Alloy steel 750-950 [N/mm]	150 - 300	0,03 - 0,09	100 - 250	0,03 - 0,08
High-strength steel 950 -1200 [N/mm]	90 - 160	0,03 - 0,09	90 - 150	0,03 - 0,08
Tool steel >950 [N/mm]	70 - 110	0,03 - 0,07	70 - 105	0,03 - 0,06
Stainless steel 500 – 800 [N/mm]	50 - 130	0,03 - 0,07	50 - 110	0,03 - 0,06
Ferrous stainless steel 400 -700 [N/mm]	70 - 250	0,03 - 0,08	60 - 150	0,03 - 0,07

*This table is for reference only.





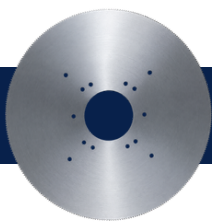
500-201-2501
500-201-2502
500-201-2503
500-201-2504
500-201-2505
500-201-2506
500-201-2507
500-201-2508
500-201-2509
500-201-2510



FRICTION

SPEED, PRECISION, AND DURABILITY IN
THE SAME CUT.





FRICTION SAW BLADE

The Hagane friction saw efficiently cuts large diameter pipes, thick walls, beams and profiles.

Applications: carbon steel, stainless steel and light alloys.



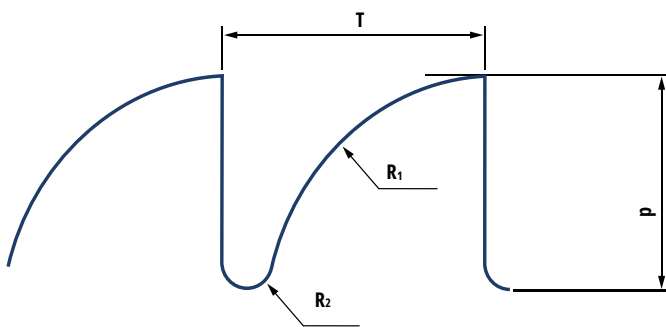
	ESPESSURA	CENTRAL HOLE	Z
[MM]	[MM]	[MM]	
300	2,5	40 [30]	200
	3,0	40 [30]	200
350	2,5	40 [30]	200/220
	3,0	40 [30]	160/200/220
400	2,5	40	240/300
	3,0	40	240/300
	4,0	40	240/300
450	2,5	40	240/300
	3,0	40	240/300
	4,0	40	240/300
500	3,0	40	300
	4,0	40	300
	5,0	40	300
	6,0	40	300
520	3,0	40	300
	4,0	40	300
	5,0	40	300
	6,0	40	300
550	3,0	40	300
	4,0	40	300
	5,0	40	300
560	3,0	40	300
	4,0	40	300
	5,0	40	300
580	4,0	40	300
	5,0	40	300
	6,0	40	300
600	4,0	40/50	300
	5,0	40/50	300
	6,0	40/50	300
650	4,0	40/50	300
	5,0	40/50	300
	6,0	40/50	300
700	4,0	40/50	300
	5,0	40/50	300
	6,0	40/50	300
	7,0	40/50	300
750	5,0	40/50	300/350/400
	6,0	40/50	300/350/400
	7,0	40/50	300/350/400
800	5,0	40/50	300/350/400
	6,0	40/50	300/350/400
	7,0	40/50	300/350/400
	8,0	40/50	300/350/400
850	6,0	40/50	320/350/380
	7,0	40/50	320/350/380
	8,0	40/50	320/350/380
900	7,0	50/80/100	320/350/380
	8,0	50/80/100	320/350/380
1000	7,0	40/50/80/100	320/400/450
	8,0	40/50/80/100	320/400/450
	9,0	40/50/80/100	320/400/450
	10,0	40/50/80/100	320/400/450

> TOOTH SHAPES

Friction saw blades have different tooth shapes, determined by the application and the temperature of the workpiece being cut. The correct choice ensures better performance, efficiency, and durability.

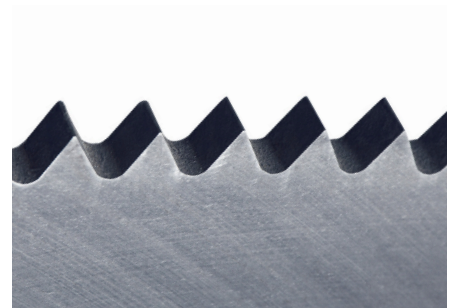
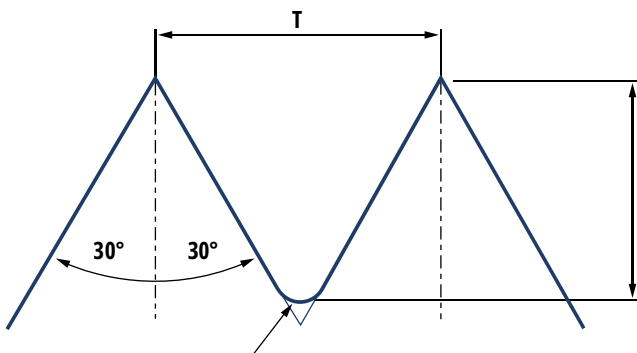
Below are the main tooth shapes:

> BP (PARROT'S BEAK)



Suitable for friction cutting of carbon steels at temperatures below 100°C. Provides good performance and service life in operations with lower thermal demands.

> T OU 60° (TRIANGULAR)



A tooth suitable for hot cutting in rolling mills for billets, tubes, and structural profiles, with workpiece temperatures up to 600°C. It offers resistance to heat and abrasion.



SEGMENTED

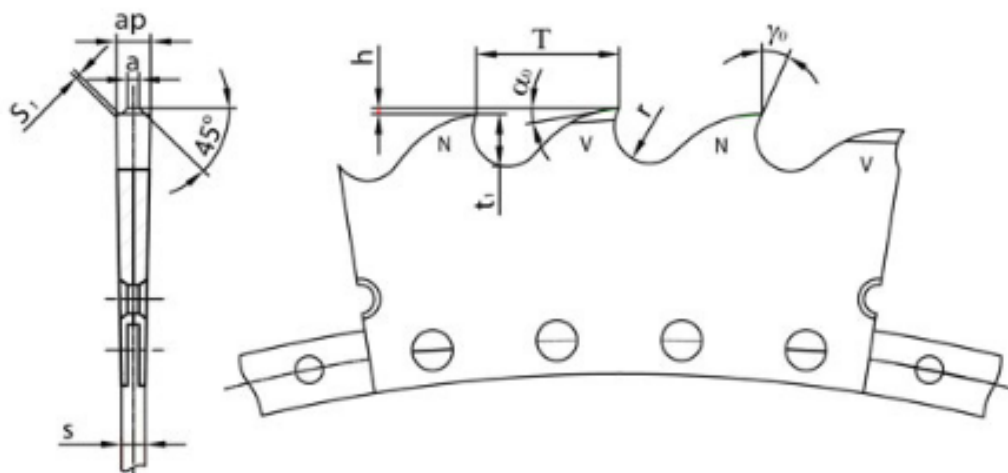
VERSATILITY AND ROBUSTNESS FOR
HIGH-PRECISION CUTS.





SEGMENTED SAW BLADE

Designed specifically for cutting solid billets of non-ferrous metals and other materials, the segmented saw offers maximum efficiency and high performance in the most demanding industrial processes.



V= Dente de desbaste
N= Dente de acabamento
r= Throat lightning
h= Height difference
ap= Largura do corte
s= Espessura da alma
T= Tooth step
a= Largura do dente de desbaste

y= Angle of attack
 α = Ângulo de saída
ti= Tooth height

ti= 0,4 -T
r= 0,25 -T
a= 0,33 -ap
s1= 0,07-ap



DIÂMETRO [MM]	CUT WIDTH [MM]	BLADE THICKNESS [MM]	BLADE WEIGHT KG	SEGMENT NUMBER	MAIN HOLE HB FURO SECUNDARIOS NL	DIVISION [T] BY NUMBER OF TEETH PER SEGMENT							
						2	3	4	5	6	8	10	12
630	5,0	3,8	9,0	20	80 4/22/120 + 4/27/160	49,5	33,0	24,7	19,8	16,5	12,4	9,9	8,2
630	6,0	4,5	11,0		80 8/22/142								
660	6,0	4,5	12,0	20	80 4/22/120 + 4/27/160	51,8	34,4	25,9	20,7	17,3	13	10,4	8,6
					80 8/22/142								
710	6,2	4,5	14,0	24	80 4/22/120 + 4/27/160	46,5	30,9	23,2	18,6	15,5	11,6	9,3	7,7
760	6,3		16,0			49,7	33,1	24,9	19,9	16,6	12,4	9,9	8,2
810	6,8	5,0	17,5			53,0	35,3	26,5	21,2	17,7	13,2	10,6	8,8
860	6,5	4,5				56,3	37,5	28,1	22,5	18,8	14,1	11,3	9,4
910	7,0	5,0	26,0	30	80 4/22/120 + 4/27/160	47,6	31,7	23,8	19,0	15,9	11,9	9,5	7,9
920			27,0		100 8/27/186	48,1	32,1	24,1	19,3	16,0	12,0	9,6	8,0
960			29,0		100 4/32/200	50,2	33,5	25,1	20,1	16,7	12,6	10,0	8,4
1010			38,0	30		52,9	35,2	26,4	21,1	17,6	13,2	10,6	8,8
1110	8,0	6,0	45,0	36	100 4/32/200 + 4/32/250	48,4	32,3	24,2	19,4	16,1	12,1	9,7	8,1
1120	8,2		48,0			48,8	32,6	24,4	19,5	16,3	12,2	9,8	8,1
1250	9,0	7,0	67,0	36	100 4/32/250	54,5	36,3	27,3	21,8	18,2	13,6	10,9	9,1
1310	9,0	7,0	74,0	36	100 4/32/250	57,1	38,1	28,6	22,9	19,0	14,3	11,4	9,5
1320			75,0										
1320			55,0			57,6	38,4	28,8	23,0	19,2	14,4	11,5	9,5
1410	9,0	7,0	86,0	36	100 4/32/250	61,5	41,0	30,7	24,6	20,5	15,4	12,3	10,2
1430	9,5		88,0			62,4	41,6	31,2	24,9	20,8	15,6	12,5	10,4
1510	9,0	7,0	98,0	36	100 4/32/250	65,9	43,9	32,9	26,3	22,0	16,5	13,2	11,0
1610	11,0	8,0	128,0	40	100 4/33/315	63,2	42,1	31,6	25,3	21,1	15,8	12,6	10,5

SEE MORE



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