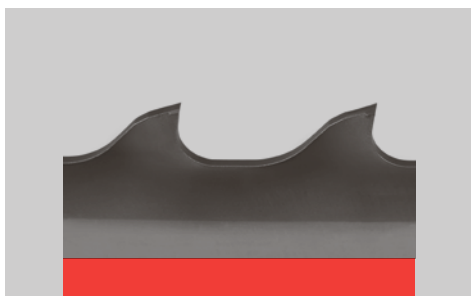
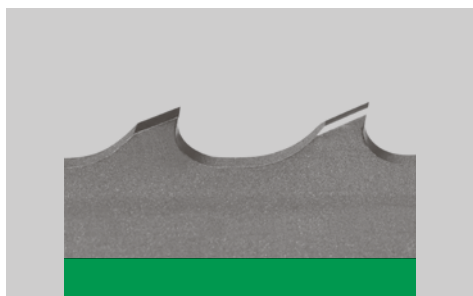


US 2015 / 2016



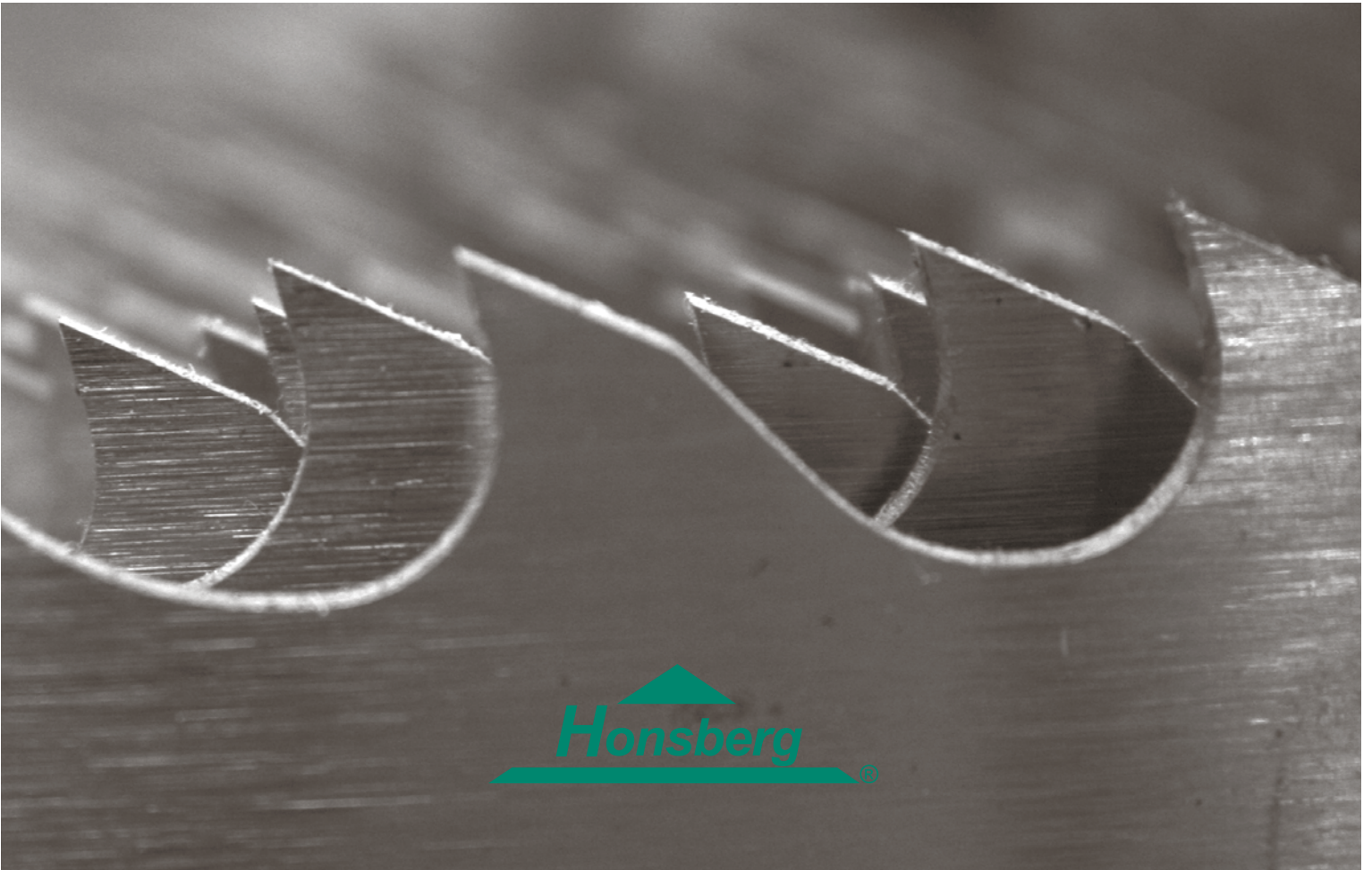
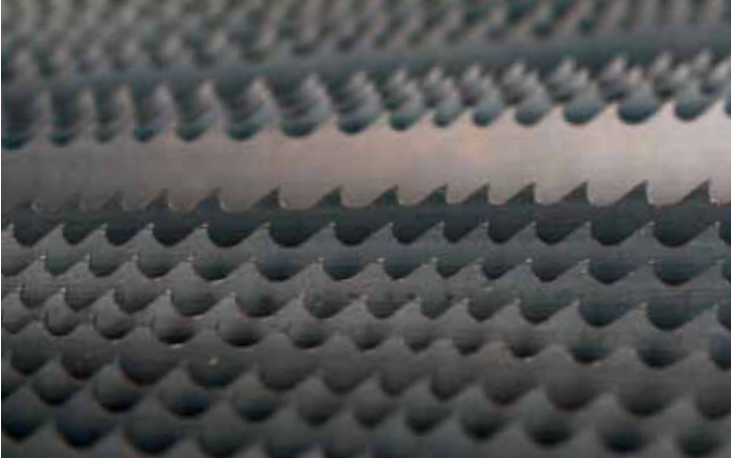
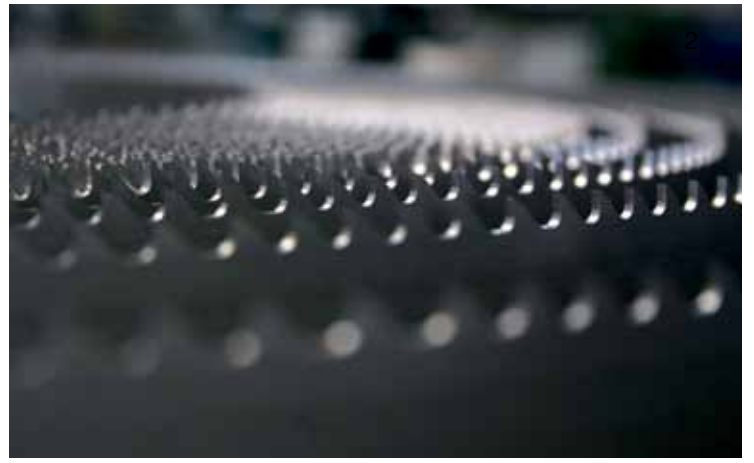


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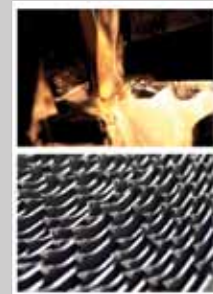
Honsberg 2015 – 2016

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34



Material Key

1

Structural steels, deep drawing steels, machining steels

2

Structural steels, quenched and tempered steels

3

Case hardened steels, spring steels, quenched and tempered steels

4

Low alloyed hot-working steels

5

Nitriding steels, high alloyed hot working steels

6

Unalloyed tool steels

7

Cold work steels

8

High-speed steels

9

Cast iron

10

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Duplex and heat resistant steels

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Nickle-base alloys

14

Induction hardened and chrome coated shafts

15

Aluminium

16

Copper

17

Brass

18

Aluminium bronze

19

Titanium alloys

Quality

LRQA
Business Assurance

CERTIFICATE OF APPROVAL

This is to certify that the Quality Management System of:

Honsberg Metallsägen GmbH
Auf dem Knapp 42, 42855 Remscheid
Germany



has been approved by Lloyd's Register Quality Assurance to the following Quality Management System Standards:

ISO 9001:2008

The Quality Management System is applicable to:

Production and sales of band saw blades, power hacksaw blades, hand hacksaw blades, reciprocating saws and circular saw blades.

This certificate forms part of the approval identified by certificate number KLN 0201738

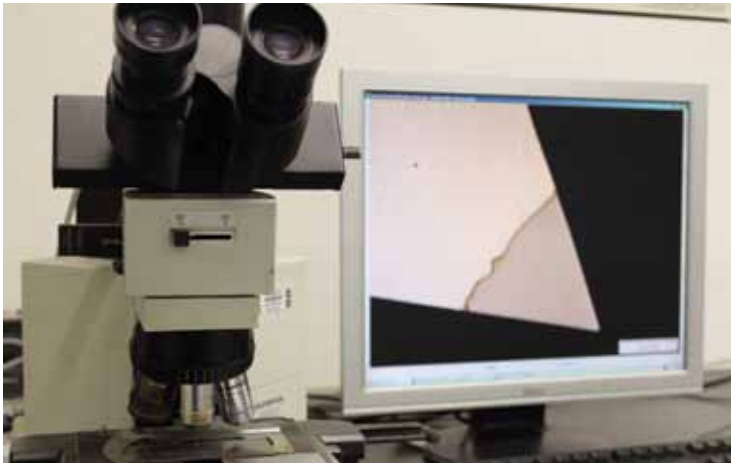
Approval	Original Approval:	28 July 1995
Certificate No: KLN 0201738/C	Current Certificate:	01 August 2013
	Certificate Expiry:	31 July 2016

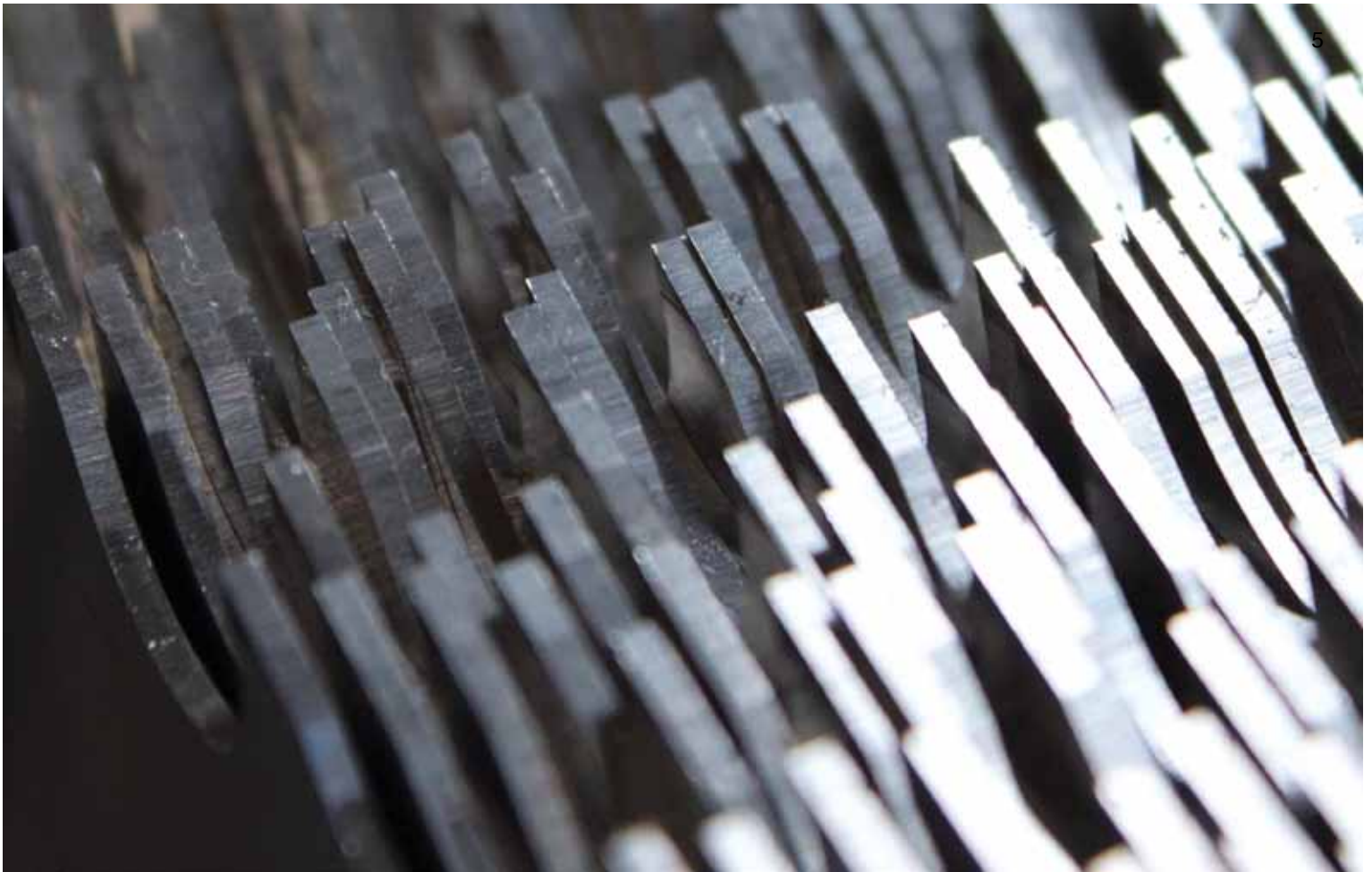


Issued by: Lloyd's Register Quality Assurance GmbH
For and on behalf of: Lloyd's Register Quality Assurance Limited



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Lloyd's Register Quality Assurance, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100, 101, 102, 103, 104, 105, 106, 107, 108, 109, 110, 111, 112, 113, 114, 115, 116, 117, 118, 119, 120, 121, 122, 123, 124, 125, 126, 127, 128, 129, 130, 131, 132, 133, 134, 135, 136, 137, 138, 139, 140, 141, 142, 143, 144, 145, 146, 147, 148, 149, 150, 151, 152, 153, 154, 155, 156, 157, 158, 159, 160, 161, 162, 163, 164, 165, 166, 167, 168, 169, 170, 171, 172, 173, 174, 175, 176, 177, 178, 179, 180, 181, 182, 183, 184, 185, 186, 187, 188, 189, 190, 191, 192, 193, 194, 195, 196, 197, 198, 199, 200, 201, 202, 203, 204, 205, 206, 207, 208, 209, 210, 211, 212, 213, 214, 215, 216, 217, 218, 219, 220, 221, 222, 223, 224, 225, 226, 227, 228, 229, 230, 231, 232, 233, 234, 235, 236, 237, 238, 239, 240, 241, 242, 243, 244, 245, 246, 247, 248, 249, 250, 251, 252, 253, 254, 255, 256, 257, 258, 259, 260, 261, 262, 263, 264, 265, 266, 267, 268, 269, 270, 271, 272, 273, 274, 275, 276, 277, 278, 279, 280, 281, 282, 283, 284, 285, 286, 287, 288, 289, 290, 291, 292, 293, 294, 295, 296, 297, 298, 299, 300, 301, 302, 303, 304, 305, 306, 307, 308, 309, 310, 311, 312, 313, 314, 315, 316, 317, 318, 319, 320, 321, 322, 323, 324, 325, 326, 327, 328, 329, 330, 331, 332, 333, 334, 335, 336, 337, 338, 339, 340, 341, 342, 343, 344, 345, 346, 347, 348, 349, 350, 351, 352, 353, 354, 355, 356, 357, 358, 359, 360, 361, 362, 363, 364, 365, 366, 367, 368, 369, 370, 371, 372, 373, 374, 375, 376, 377, 378, 379, 380, 381, 382, 383, 384, 385, 386, 387, 388, 389, 390, 391, 392, 393, 394, 395, 396, 397, 398, 399, 400, 401, 402, 403, 404, 405, 406, 407, 408, 409, 410, 411, 412, 413, 414, 415, 416, 417, 418, 419, 420, 421, 422, 423, 424, 425, 426, 427, 428, 429, 430, 431, 432, 433, 434, 435, 436, 437, 438, 439, 440, 441, 442, 443, 444, 445, 446, 447, 448, 449, 450, 451, 452, 453, 454, 455, 456, 457, 458, 459, 460, 461, 462, 463, 464, 465, 466, 467, 468, 469, 470, 471, 472, 473, 474, 475, 476, 477, 478, 479, 480, 481, 482, 483, 484, 485, 486, 487, 488, 489, 490, 491, 492, 493, 494, 495, 496, 497, 498, 499, 500, 501, 502, 503, 504, 505, 506, 507, 508, 509, 510, 511, 512, 513, 514, 515, 516, 517, 518, 519, 520, 521, 522, 523, 524, 525, 526, 527, 528, 529, 530, 531, 532, 533, 534, 535, 536, 537, 538, 539, 540, 541, 542, 543, 544, 545, 546, 547, 548, 549, 550, 551, 552, 553, 554, 555, 556, 557, 558, 559, 560, 561, 562, 563, 564, 565, 566, 567, 568, 569, 570, 571, 572, 573, 574, 575, 576, 577, 578, 579, 580, 581, 582, 583, 584, 585, 586, 587, 588, 589, 590, 591, 592, 593, 594, 595, 596, 597, 598, 599, 600, 601, 602, 603, 604, 605, 606, 607, 608, 609, 610, 611, 612, 613, 614, 615, 616, 617, 618, 619, 620, 621, 622, 623, 624, 625, 626, 627, 628, 629, 630, 631, 632, 633, 634, 635, 636, 637, 638, 639, 640, 641, 642, 643, 644, 645, 646, 647, 648, 649, 650, 651, 652, 653, 654, 655, 656, 657, 658, 659, 660, 661, 662, 663, 664, 665, 666, 667, 668, 669, 670, 671, 672, 673, 674, 675, 676, 677, 678, 679, 680, 681, 682, 683, 684, 685, 686, 687, 688, 689, 690, 691, 692, 693, 694, 695, 696, 697, 698, 699, 700, 701, 702, 703, 704, 705, 706, 707, 708, 709, 710, 711, 712, 713, 714, 715, 716, 717, 718, 719, 720, 721, 722, 723, 724, 725, 726, 727, 728, 729, 730, 731, 732, 733, 734, 735, 736, 737, 738, 739, 740, 741, 742, 743, 744, 745, 746, 747, 748, 749, 750, 751, 752, 753, 754, 755, 756, 757, 758, 759, 760, 761, 762, 763, 764, 765, 766, 767, 768, 769, 770, 771, 772, 773, 774, 775, 776, 777, 778, 779, 780, 781, 782, 783, 784, 785, 786, 787, 788, 789, 790, 791, 792, 793, 794, 795, 796, 797, 798, 799, 800, 801, 802, 803, 804, 805, 806, 807, 808, 809, 810, 811, 812, 813, 814, 815, 816, 817, 818, 819, 820, 821, 822, 823, 824, 825, 826, 827, 828, 829, 830, 831, 832, 833, 834, 835, 836, 837, 838, 839, 840, 841, 842, 843, 844, 845, 846, 847, 848, 849, 850, 851, 852, 853, 854, 855, 856, 857, 858, 859, 860, 861, 862, 863, 864, 865, 866, 867, 868, 869, 870, 871, 872, 873, 874, 875, 876, 877, 878, 879, 880, 881, 882, 883, 884, 885, 886, 887, 888, 889, 890, 891, 892, 893, 894, 895, 896, 897, 898, 899, 900, 901, 902, 903, 904, 905, 906, 907, 908, 909, 910, 911, 912, 913, 914, 915, 916, 917, 918, 919, 920, 921, 922, 923, 924, 925, 926, 927, 928, 929, 930, 931, 932, 933, 934, 935, 936, 937, 938, 939, 940, 941, 942, 943, 944, 945, 946, 947, 948, 949, 950, 951, 952, 953, 954, 955, 956, 957, 958, 959, 960, 961, 962, 963, 964, 965, 966, 967, 968, 969, 970, 971, 972, 973, 974, 975, 976, 977, 978, 979, 980, 981, 982, 983, 984, 985, 986, 987, 988, 989, 990, 991, 992, 993, 994, 995, 996, 997, 998, 999, 1000.





Customer satisfaction is the goal of our daily work

Made by Honsberg – our products are considered to be world leading technology. Our quality control system is certified by DIN EN ISO 9001:2008 since 1995 and is dynamically implemented focusing on continuously improvement.



Global



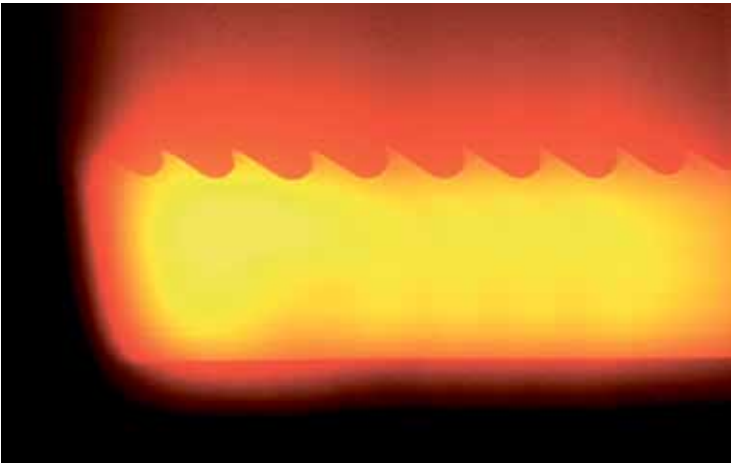


Welcome to Our World

You can find our products through our headquarters, our branches and distribution partners in every important industrial countries.

Qualified service makes our precision saw blades a reliable tool for the daily use of professionals. We train our staff and our partners worldwide so that any cutting problem is addressed and solutions are implemented smoothly. Understanding is the key for service – worldwide, every day.

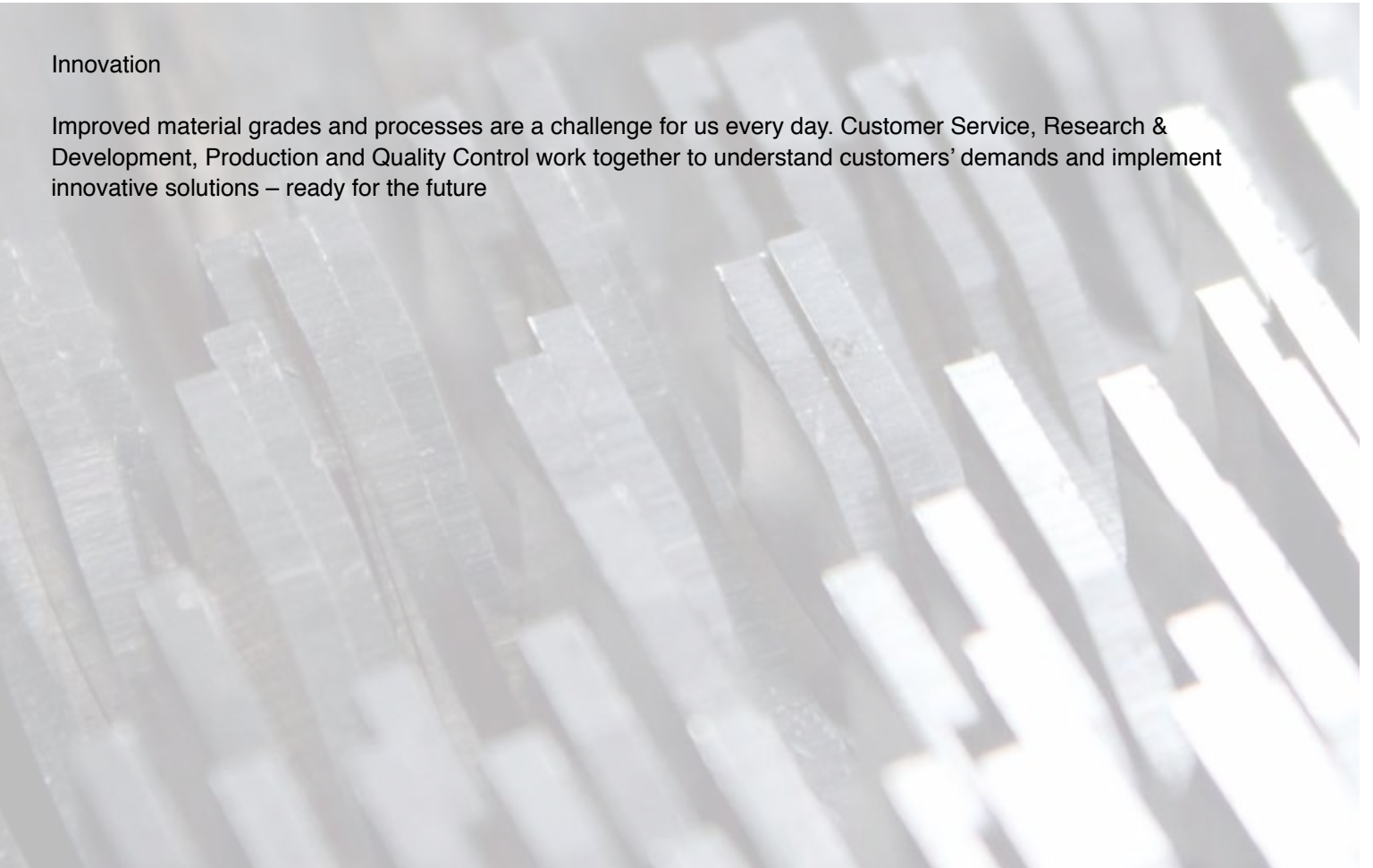
Innovation



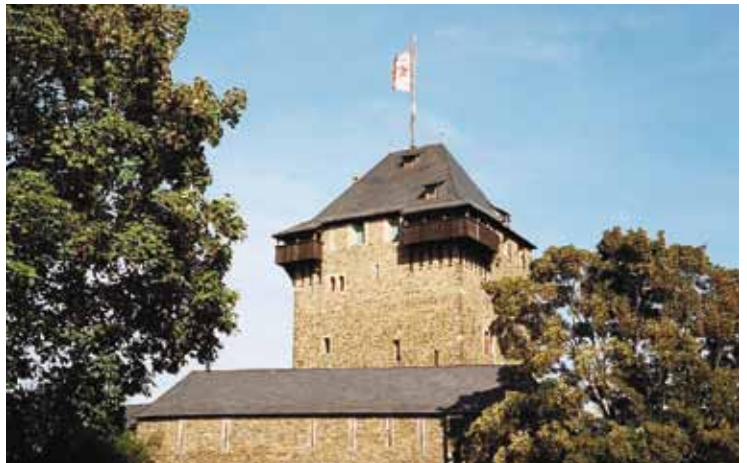


Innovation

Improved material grades and processes are a challenge for us every day. Customer Service, Research & Development, Production and Quality Control work together to understand customers' demands and implement innovative solutions – ready for the future



History

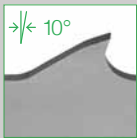




Produced in Remscheid, Germany since 1798

As a privately held corporation we only develop and produce our precision saw blades at our headquarters in Remscheid, the founding and historical city of the German tool industry.

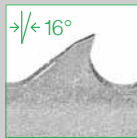
Bimetal



Hook Tooth K
Rake angle positive

Suitable for:

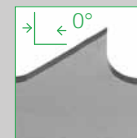
- universal use
- profiles and solid materials
- non-ferrous metals and steels



Delta Tooth D
Cutting angle extremely positive

Suitable for:

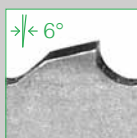
- rustproof and acid-resistant steels
- high cutting performance
- long-chipping materials
- solid materials



Standard Tooth S
Cutting angle 0°

Suitable for:

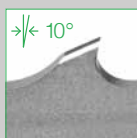
- thin-walled profiles
- short-chipping materials
- steels with a high carbon content
- materials with small cross-sections
- cast iron



Profile Tooth P
Profile Tooth positive

Suitable for:

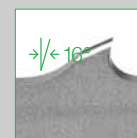
- hollow and angle profiles
- steel beams
- bundle and layer cuts
- applications that are sensitive to vibrations



Master Tooth M
Cutting angle is positive with defined tooth height difference

Suitable for:

- rustproof and acid-resistant steels
- high cutting performance
- long-chipping materials
- solid materials



Radial Tooth R
Cutting angle is extremely positive with a defined tooth height variation

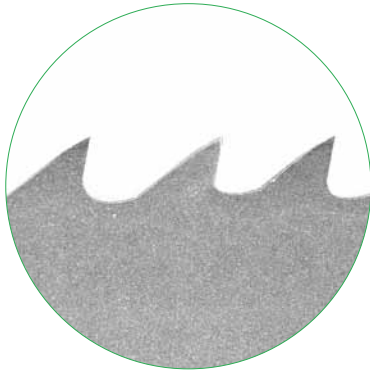
Suitable for:

- rustproof and acid-resistant steels
- high cutting performance
- long-chipping materials
- solid materials
- longer service life (Honsberg Aurum)



Honsberg Spectra

No. 700720



Materials



1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

Features



68 HRC 

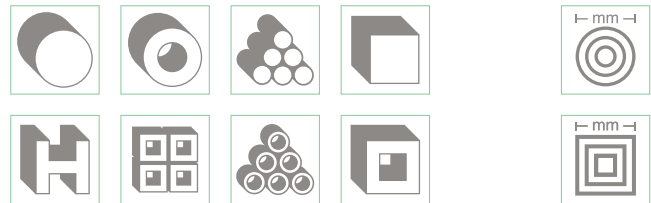
Options

54-80 mm 

Machines



Shapes

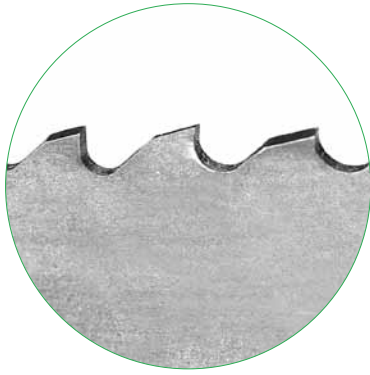


mm	Inches	0,75/ 1,25	1,1/ 1,6	1,5/ 2	2/3	3/4	3/4	4/5	4/6	4/6	5/8	6/10	8/12	10/14	tpi
6 x 0,6	1/4 x .025														S
6 x 0,9	1/4 x .035														S
10 x 0,6	3/8 x .025														S
10 x 0,9	3/8 x .035														S
13 x 0,6	1/2 x .025											S	S	S	
13 x 0,9	1/2 x .035											S		S	
20 x 0,9	3/4 x .035									K	S	S	S	S	
27 x 0,9	1 1/16 x .035				K	S	K ¹⁾	K	S	K ¹⁾	S	S	S	S	
34 x 1,1	1 3/8 x .042			K	K ¹⁾	S	K ¹⁾	K	S	K ¹⁾	S	S	S		
41 x 1,3	1 5/8 x .050			K	K ¹⁾	S	K ¹⁾	K	S	K ¹⁾	S	S			
54 x 1,3	2 1/8 x .050			K	K ¹⁾		K ¹⁾	K		K					
54 x 1,6	2 1/8 x .063	K	K	K	K ¹⁾		K ¹⁾	K		K ¹⁾					
67 x 1,6	2 5/8 x .063	K	K	K	K ¹⁾		K ¹⁾								
80 x 1,6	3 1/8 x .063	K	K	K	K										

¹⁾ Also available in Extra Heavy Set (EHS)

Honsberg Secura

No. 700724



Materials 3

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

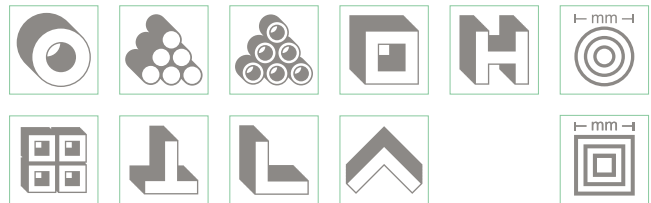
Features 12



Machines

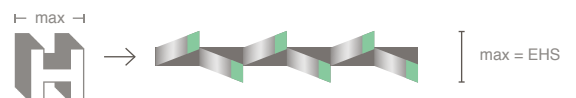


Shapes



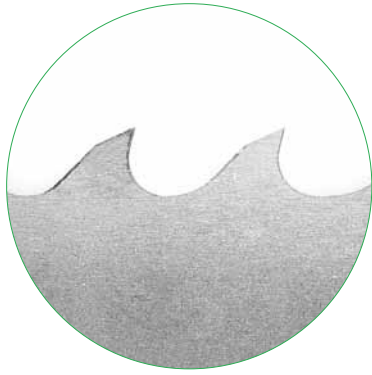
mm	Inches	3/4	4/6	5/7	8/11	12/16	tpi
13 x 0,6	1/2 x .025				P		
20 x 0,9	3/4 x .035				P	P	
27 x 0,9	1/16 x .035	P	P	P	P	P	
34 x 1,1	1 3/8 x .042	P	P	P	P		
41 x 1,3	1 5/8 x .050	P	P	P			
54 x 1,3	2 1/8 x .050						
54 x 1,6	2 1/8 x .063	P	P				
67 x 1,6	2 5/8 x .063	P	P				

mm	Inches	2/3 EHS	3/4 EHS	tpi
27 x 0,9	1/16 x .035		P-EHS	
34 x 1,1	1 3/8 x .042	P-EHS	P-EHS	
41 x 1,3	1 5/8 x .050	P-EHS	P-EHS	
54 x 1,3	2 1/8 x .050	P-EHS		
54 x 1,6	2 1/8 x .063	P-EHS	P-EHS	
67 x 1,6	2 5/8 x .063	P-EHS	P-EHS	



Honsberg Duratec

No. 700700



Materials



- 1
2
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Features



**68-69
HRC**

Options

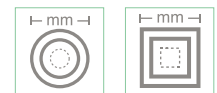
54-80 mm

 Impact Plus

Machines



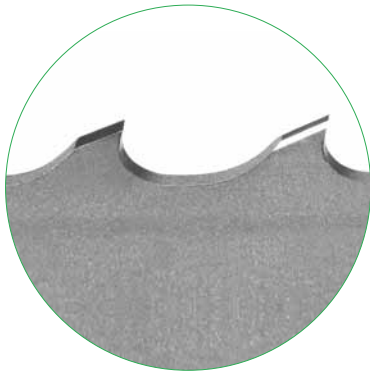
Shapes



mm	Inches	0,75/1,25	1,1/1,6	1,5/2	2/3	3/4	4/5	4/6	tpi
27 x 0,9	1 1/16 x .035				K	K	K	K	
34 x 1,1	1 3/8 x .042				K	K		K	
41 x 1,3	1 5/8 x .050			K	K	K		K	
54 x 1,6	2 1/8 x .063	K		K	K	K			
67 x 1,6	2 5/8 x .063	K	K	K	K				
80 x 1,6	3 1/8 x .063	K	K						

Honsberg Aurum

No. 700780



Materials → 3

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

Features → 12

68-69 HRC

Machines

Shapes

Options

mm	Inches	0,6/0,7	0,75/1,25	0,9/1,1	1,1/1,6	1,5/2	2/3	3/4	tpi
34 x 1,1	1 3/8 x .042						R	R	
41 x 1,3	1 5/8 x .050					R	R		
54 x 1,3	2 1/8 x .050					R	R		
54 x 1,6	2 1/8 x .063				R	R	R		
67 x 1,6	2 5/8 x .063		R		R	R			
80 x 1,6	3 1/8 x .063		R		R				
100 x 1,6	4 x .063	R		R					

Accessories

Webcut Software



Saw Blade Tension Gauge



Honsberg Sawing Fluid



Swarf Brushes



Data Disk



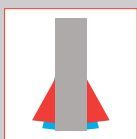
Refractometer



Feed Measuring System



Tungsten Carbide

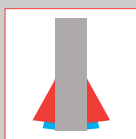


Trapezoid tooth TNF-A

Positive cutting angle and sectional chipping zones

Suitable for:

- non-ferrous materials
- low vibration also on manual applications
- defined surface finish

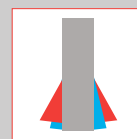


Trapezoid tooth TNF-B

Positive cutting angle and sectional chipping zones

Suitable for:

- defined surface finish
- non-ferrous materials
- increased cutting rates

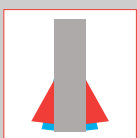


Trapezoid tooth Set TSS

Positive cutting angle and sectional chipping zones

Suitable for:

- universal usage
- solid materials with inner stress
- alloyed steel grades
- increase of service life and cutting rates

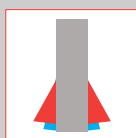


Trapezoid tooth TAP

Positive cutting angle and sectional chipping zones

Suitable for:

- optimized high cutting performance
- optimal surface finishes

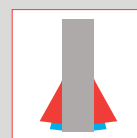


Trapezoid tooth TSN

Negative cutting angle and sectional chipping zones

Suitable for:

- hardened steels up to 68 HRC
- surface-hardened shafts
- diameters up to 275 mm
- hard manganese steels, hard-chrome plated

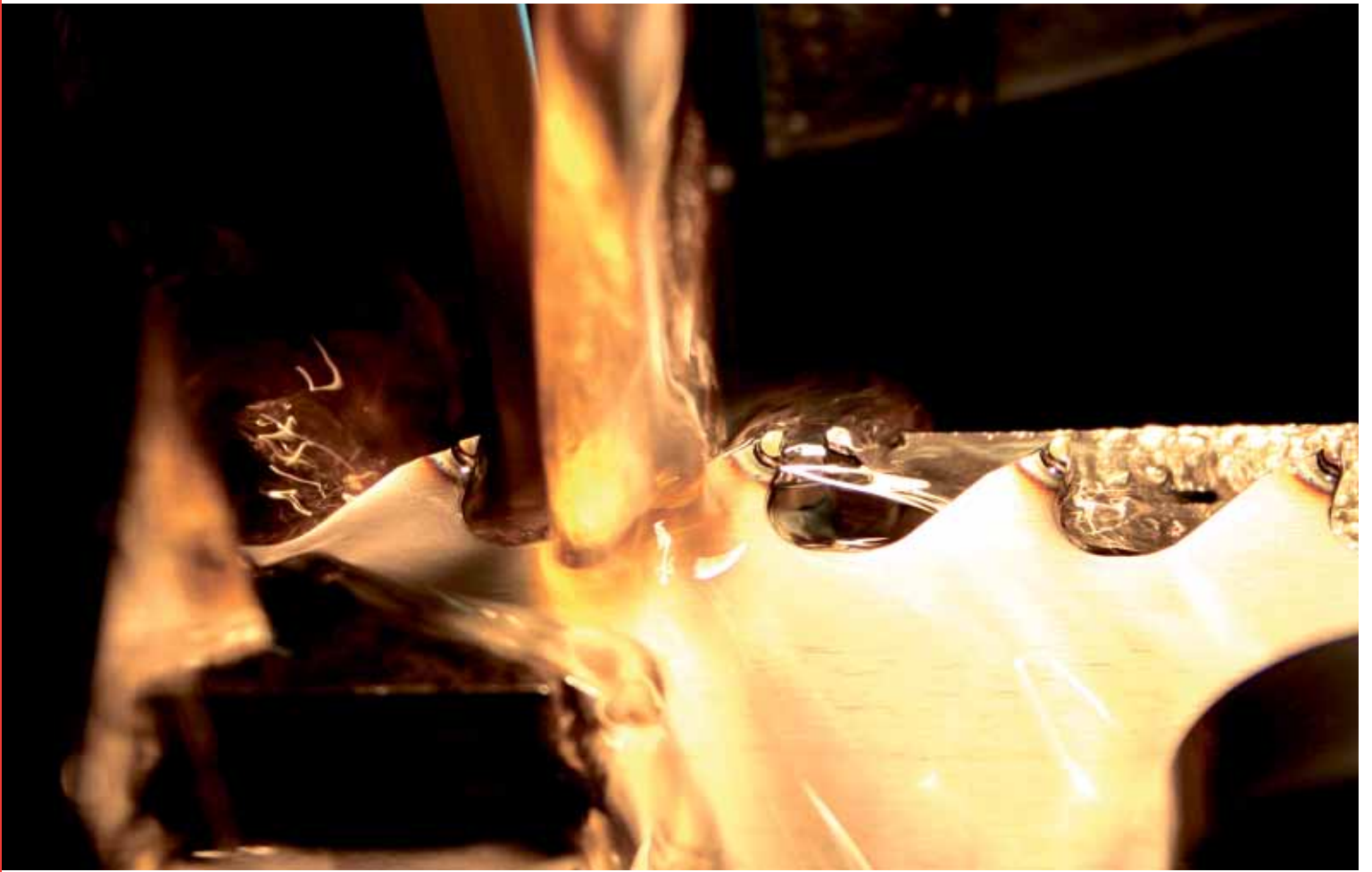


Trapezoid tooth TSN ENR

Extreme negative cutting angle and sectional chipping zones

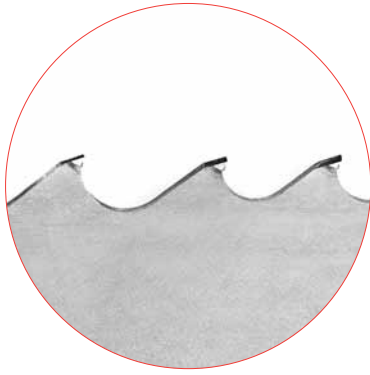
Suitable for:

- hardened steels up to 68 HRC
- surface-hardened shafts
- diameters of up to 275 mm
- hard manganese steels, hard-chrome plated



Sinus Set

No. 800600



Materials



- | | | | | |
|----|----|----|----|----|
| 1 | 2 | 3 | 4 | 5 |
| 6 | 7 | 8 | 9 | 10 |
| 11 | 12 | 13 | 14 | 15 |
| 16 | 17 | 18 | 19 | |

Features



- 1600 HV
- TCT
- Impact Plus

Options

- 54-80 mm
- Impact Plus

Machines

- Machine 1
- Machine 2
- Machine 3

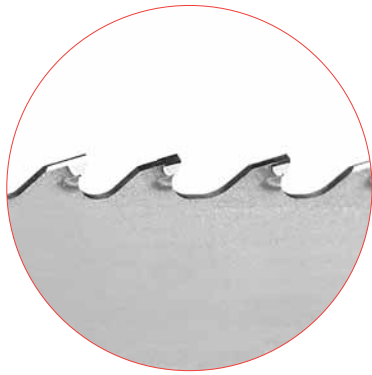
Shapes

- Shape 1
- Shape 2
- Shape 3
- Shape 4

mm	Inches	0,85/1,15	1,1/1,6	1,5/2	2/3	tpi
34 x 1,1	1 3/8 x .042					TSS
41 x 1,3	1 5/8 x .050					TSS
54 x 1,3	2 1/8 x .050					TSS
54 x 1,6	2 1/8 x .063					TSS
67 x 1,6	2 5/8 x .063		TSS	TSS		
80 x 1,6	3 1/8 x .063	TSS				

Sinus TAP

No. 800100



Materials



- | | | | | |
|----|----|----|----|----|
| 1 | 2 | 3 | 4 | 5 |
| 6 | 7 | 8 | 9 | 10 |
| 11 | 12 | 13 | 14 | 15 |
| 16 | 17 | 18 | 19 | |

Features



- 1600 HV
- TCT
- Impact Plus

Options

- 54-80 mm
- Impact Plus

Machines



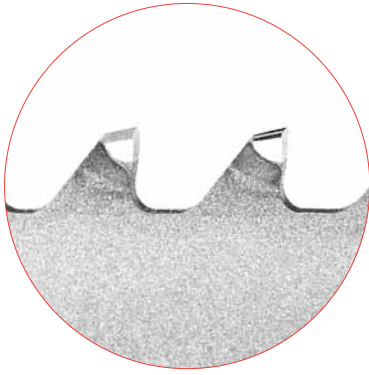
Shapes



mm	Inches	0,85/1,15	1,1/1,6	1,5/2	2/3	3/4	tpi
27 x 0,9	1 1/16 x .035				TAP	TAP	
34 x 1,1	1 3/8 x .042				TAP	TAP	
41 x 1,3	1 5/8 x .050			TAP	TAP	TAP	
54 x 1,3	2 1/8 x .050	TAP	TAP	TAP	TAP		
54 x 1,6	2 1/8 x .063	TAP	TAP	TAP	TAP		
67 x 1,6	2 5/8 x .063	TAP	TAP	TAP			
80 x 1,6	3 1/8 x .063	TAP	TAP				

Sinus TSN

No. 800300



Materials



- | | | | | |
|----|----|----|-----------|----|
| 1 | 2 | 3 | 4 | 5 |
| 6 | 7 | 8 | 9 | 10 |
| 11 | 12 | 13 | 14 | 15 |
| 16 | 17 | 18 | 19 | |

Features



- 1600 HV**
- TCT**

Machines

-
-
-

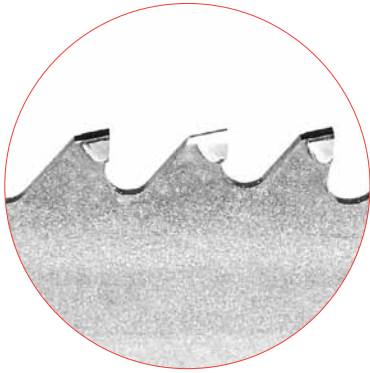
Shapes

- 50-68 HRC
- 50-68 HRC
-
-

mm	Inches	1,5/2	2/3	3/4	tpi
27 x 0,9	1 1/16 x .035			TSN	
34 x 1,1	1 3/8 x .042		TSN	TSN	
41 x 1,3	1 5/8 x .050	TSN	TSN	TSN	
54 x 1,3	2 1/8 x .050		TSN		
54 x 1,6	2 1/8 x .063		TSN		

Sinus TSN ENR

No. 800350



Materials



1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

Features







1600 HV		
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Machines



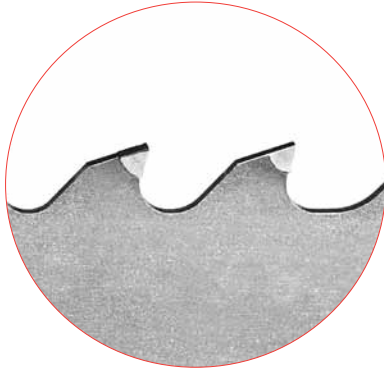
Shapes

 50-68 HRc	 50-68 HRc		
--	---	---	---

mm	Inches	1,5/2	2/3	3/4	tpi
34 x 1,1	1 3/8 x .042			TSN ENR	
41 x 1,3	1 5/8 x .050	TSN ENR	TSN ENR	TSN ENR	

Sinus TNF A

No. 800250



Materials



- 1
- 2
- 3
- 4
- 5
- 6
- 7
- 8
- 9
- 10
- 11
- 12
- 13
- 14
- 15**
- 16
- 17
- 18
- 19

Features



1700 HV



TCT



Machines









Shapes







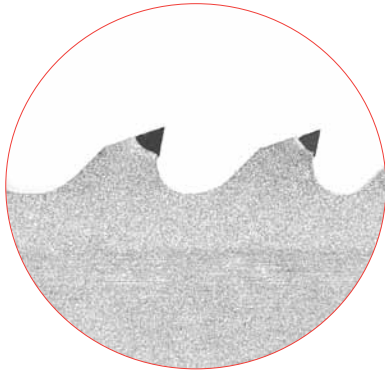




mm	Inches	2	3	0,85/1,15	1,1/1,6	1,5/2	2/3	tpi
27 x 0,9	1 1/16 x .035		TNF-A				TNF-A	
34 x 1,1	1 3/8 x .042	TNF-A	TNF-A			TNF-A	TNF-A	
41 x 1,3	1 5/8 x .050				TNF-A	TNF-A	TNF-A	
54 x 1,3	2 1/8 x .050			TNF-A		TNF-A		
54 x 1,6	2 1/8 x .063			TNF-A	TNF-A			
67 x 1,6	2 5/8 x .063				TNF-A			
80 x 1,6	3 1/8 x .063			TNF-A				

Sinus TNF B

No. 800200



Materials



1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

Features

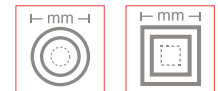


1700 HV

Machines



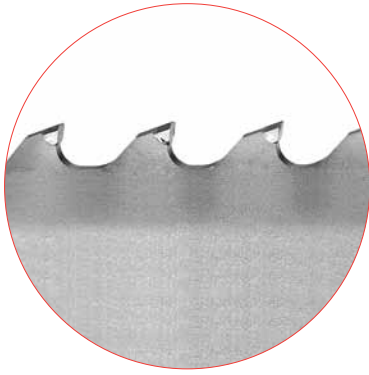
Shapes



mm	Inches	2	3	0,85/1,15	1,1/1,6	1,5/2	2/3	tpi
20 x 0,9	3/4 x .035		TNF-B					
27 x 0,9	1 1/16 x .035		TNF-B				TNF-B	
34 x 1,1	1 3/8 x .042	TNF-B	TNF-B			TNF-B		
41 x 1,3	1 5/8 x .050					TNF-B	TNF-B	
54 x 1,3	2 1/8 x .050			TNF-B		TNF-B		
54 x 1,6	2 1/8 x .063			TNF-B	TNF-B	TNF-B		
80 x 1,6	3 1/8 x .063			TNF-B				

Sinus Black TAP

No. 800400



Materials



- 1
- 2
- 3
- 4
- 5
- 6
- 7
- 8
- 9
- 10
- 11
- 12
- 13
- 14
- 15
- 16
- 17
- 18
- 19

Features



- 3200 HV
- TCT
- coating
-

Options

- 54-80 mm
- Impact Plus

Machines

-
-
-

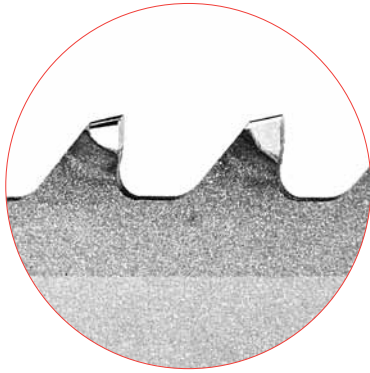
Shapes

-
-
-
-

mm	Inches	0,85/1,15	1,1/1,6	1,5/2	2/3	3/4	tpi
34 x 1,1	1 3/8 x .042				TAP		
41 x 1,3	1 5/8 x .050			TAP	TAP	TAP	
54 x 1,3	2 1/8 x .050	TAP		TAP	TAP		
54 x 1,6	2 1/8 x .063		TAP	TAP	TAP		
67 x 1,6	2 5/8 x .063	TAP	TAP				
80 x 1,6	3 1/8 x .063		TAP				

Sinus Black TSN

No. 800500



Materials



- 1
2
3
4
5
- 6
7
8
9
10
- 11
12
13
14
15
- 16
17
18
19

Features



- 3200 HV**

TCT

coating

Machines

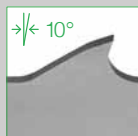
-
-
-

Shapes

- 50-68 HRc
- 50-68 HRc
- mm
- mm

mm	Inches	2/3	3/4	tpi
34 x 1,1	1 3/8 x .042		TSN	
41 x 1,3	1 5/8 x .050	TSN	TSN	
54 x 1,6	2 1/8 x .063			

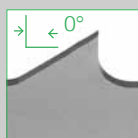
Carbon steel



Hook Tooth K
Rake angle positive

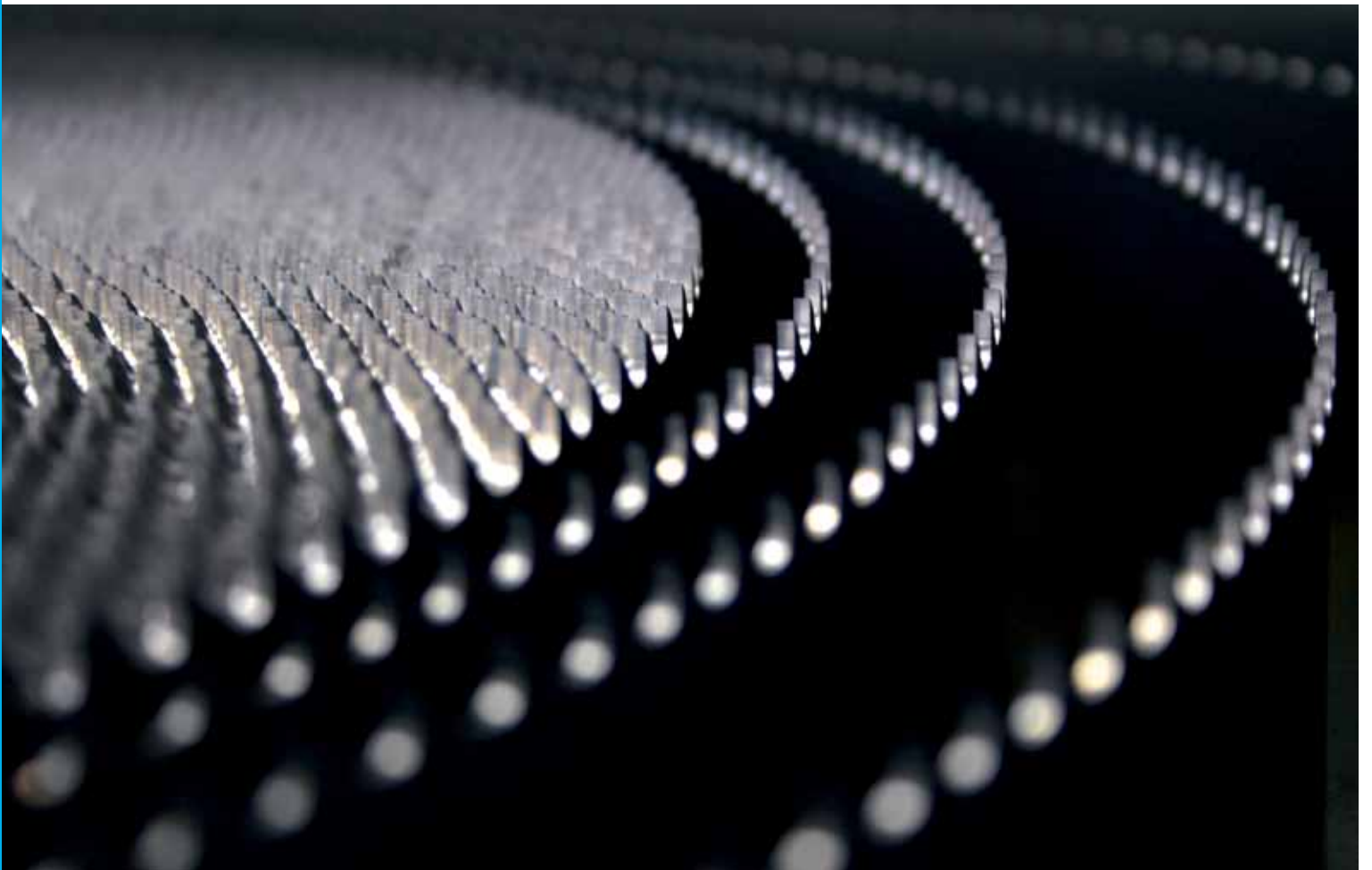
Suitable for:

- universal use
- profiles and solid materials
- non-ferrous metals and steels



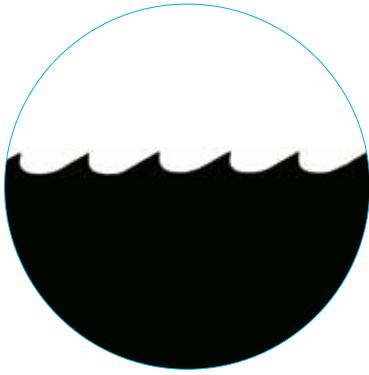
Standard Tooth S
Cutting angle 0°

- Suitable for:
- thin-walled profiles
 - short-chipping materials
 - steels with a high carbon content
 - materials with small cross-sections
 - cast iron



Honsberg Extra

No. 600610



Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

Features



66-67 HRC

Machines



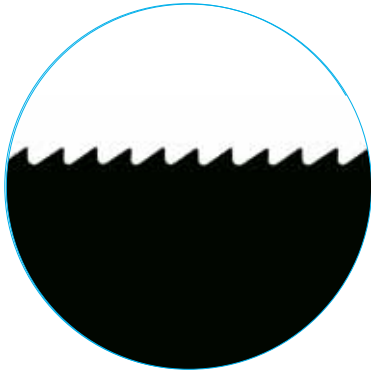
Shapes



mm	Inches	2	3	4	4	6	6	8	10	14	18	24	tpi
06 x 0,65	1/4 x .025					S	K	S	S	S	S	S	
08 x 0,65	5/16 x .025				K	S	K	S	S	S	S	S	
10 x 0,65	3/8 x .025		K		K	S	K	S	S	S	S	S	
13 x 0,65	1/2 x .025		K		K	S	K	S	S	S	S	S	
16 x 0,80	5/8 x .032		K	S	K	S		S	S	S			
20 x 0,80	3/4 x .032				K	S		S	S	S	S		
25 x 0,90	1 x .035	K	K		K	S		S	S	S			

Honsberg Super

No. 600620



Materials

1	2	3	4	5
6	7	8	9	10
11	12	13	14	15
16	17	18	19	

Features



66-67
HRc



Machines



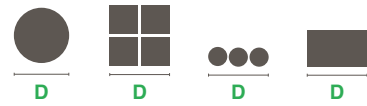
Shapes



mm	Inches	3	4	4	6	6	8	10	14	18	24	tpi
06 x 0,65	1/4 x .025		K		K	S	S	S	S	S	S	
08 x 0,65	5/16 x .025				K	S	S	S	S	S	S	
10 x 0,65	3/8 x .025		K		K	S	S	S	S	S	S	
13 x 0,65	1/2 x .025		K		K	S	S	S	S	S	S	
16 x 0,80	5/8 x .032	K	K	S		S	S	S	S		S	
20 x 0,80	3/4 x .032		K			S	K	S	S	S		
25 x 0,90	1 x .035	K	K	S	K	S	S	S	S			

Technique

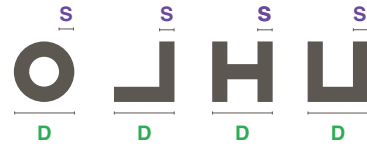
Solid Material



Carbon Steel and Bimetal Bandsaw Blades			
D	tpi	D	tpi
< 3/8 inch	14	< 1 inch	10/14
3/8 – 1 1/4 inch	10	1 – 1 1/2 inch	8/12
1 1/4 – 2 inch	8	1 – 2 inch	6/10
2 – 3 inch	6	1 1/2 – 2 3/4 inch	5/8
3 – 5 inch	4	1 1/2 – 3 1/2 inch	5/6
5 – 8 inch	3	2 – 5 inch	4/6
8 – 16 inch	2	3 – 7 inch	4/5
16 – 28 inch	1,25	4 – 7 inch	3/4
> 24 inch	0,75	5 – 14 inch	2/3
		6 – 18 inch	1,5/2
		8 – 24 inch	1,1/1,6
		> 20 inch	0,75/1,25

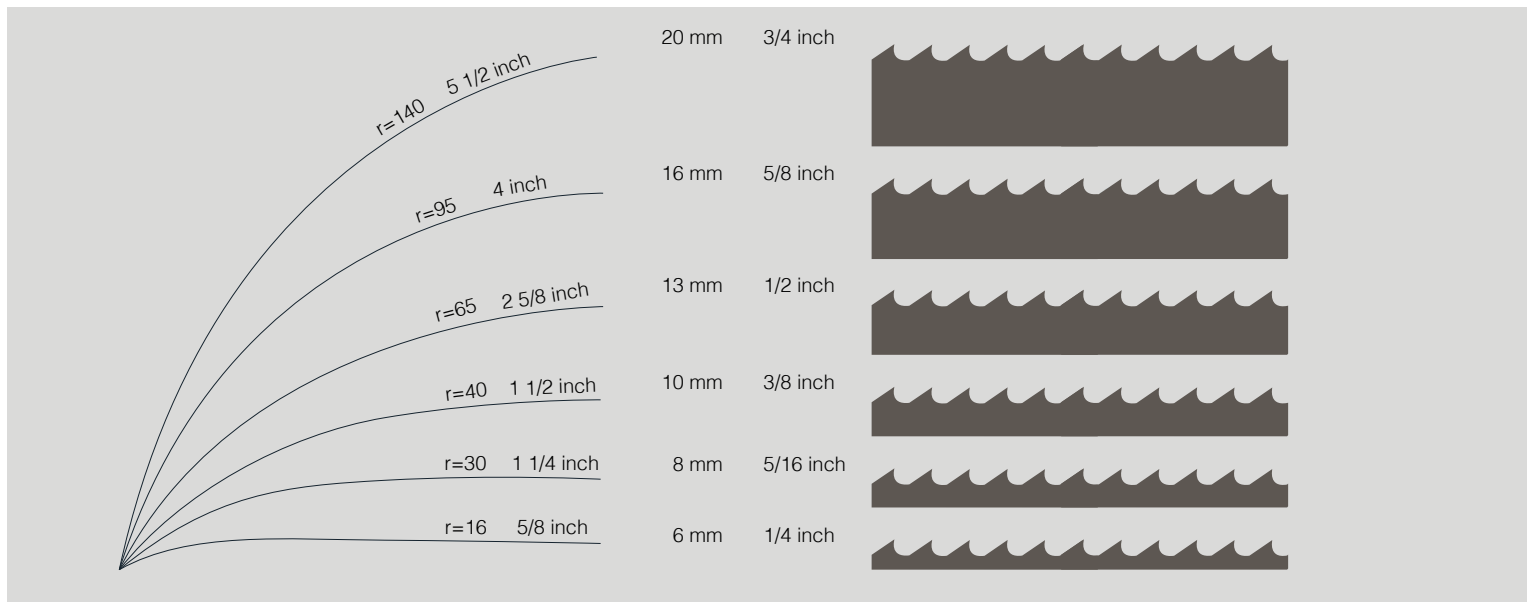
TCT Bandsaw Blades	
D	tpi
2 – 5 inch	3/4
4 – 10 inch	2/3
6 – 16 inch	1,5/2
14 – 24 inch	1,1/1,6
> 20 inch	0,85/1,15

Structurals



↓ S inch → D inch	3/4	1 1/2	2 3/8	3 1/8	4	5	6	8	12	20
5/64	14	12/16P	12/16P	12/16P	12/16P	8/11P	8/11P	8/11P	8/11P	5/7P
1/8	14	12/16P	12/16P	8/11P	8/11P	8/11P	8/11P	5/7P	5/7P	5/7P
5/32	12/16P	12/16P	8/11P	8/11P	8/11P	5/7P	5/7P	5/7P	5/7P	4/6P
3/16	12/16P	12/16P	8/11P	8/11P	5/7P	5/7P	5/7P	4/6P	4/6P	4/6P
1/4	12/16P	8/11P	8/11P	5/7P	5/7P	5/7P	5/7P	4/6P	4/6P	4/6P
5/16	12/16P	8/11P	8/11P	5/7P	5/7P	5/7P	4/6P	4/6P	4/6P	4/6P
3/8		8/11P	5/7P	5/7P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P
1/2		8/11P	5/7P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P
5/8		8/11P	5/7P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P
3/4			4/6P	4/6P	4/6P	4/6P	4/6P	4/6P	4/6P	3/4P
1 1/4				4/6P	4/6P	4/5P	4/6P	4/6P	4/6P	2/3P
2							4/6P	3/4P	2/3P	2/3P
3 1/8								3/4P	2/3P	2/3P
>4									2/3P	1,5/2

Scroll Sawing Table of minimum radiuses



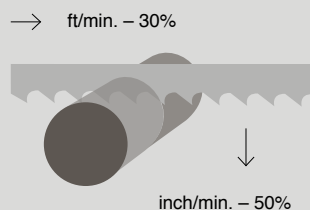
Safety Instructions for the Use of Bandsaw Blades



For your own safety, please follow the safety instructions while you are working with bandsaw blades.

- Be careful opening welded loops as they are packed under tension. You can receive free guidelines from your HONSBERG team.
- While unpacking and installing the tool, always wear safety shoes, gloves and safety glasses.
- Take off tooth protection after installing the blade on the machine.
- Close the cover of the bandsaw during cutting operation.
- If possible, turn off the main switch during blade changes.
- You find additional safety instructions in the manual of your bandsaw machinery manufacturer.

Break-in



Life-time of band saw blades mainly depends on a controlled break-in. We recommend the following break-in procedure:

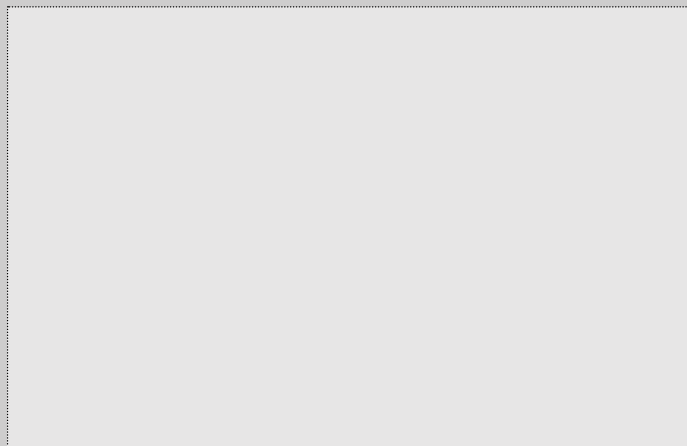
- 1st step
Select the correct speed V_c (ft/min) and cutting rate V_z (inch²/min) based on cutting conditions chart
- 2nd step
You start with 70% of the regular cutting speed and 50% of the regular cutting rate.
- 3rd step
If vibrations still occur, change the speed carefully until the vibrations stop. A permanent chip formation is important during the whole cutting process.
- 4th step
After cutting approx. 62-93 inch² or at least 15 minutes real cutting time for tubes and profiles you can first slowly turn up to the final speed and then up to the normal cutting rate.

Global Industrial Sawing Solutions





 **Made in Germany**



 **24h shipping
nationwide technical service**



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America Corporation

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 847-640-7464

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