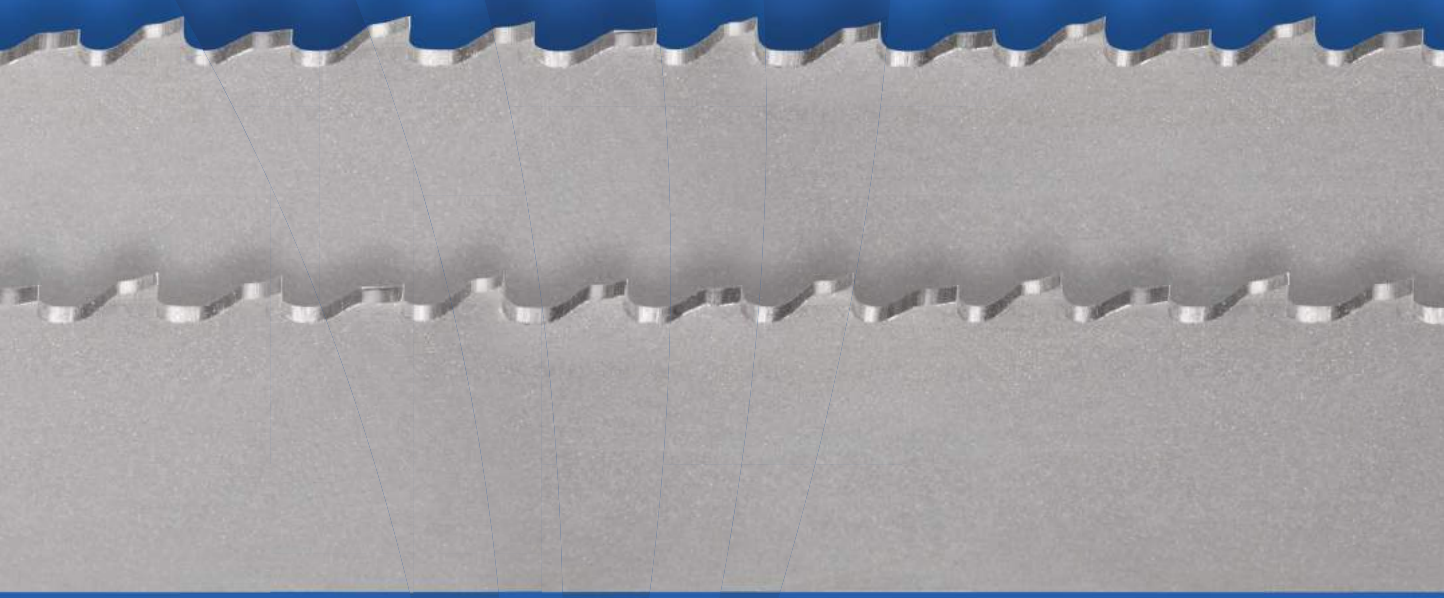
30 YEARS EXPERIENCE IN METAL CUTTING INDUSTRY!

WEILISHI

BANDSAW BLADE

Bi-Metal Bandsaw Blade Product Manuals

双金属锯条产品手册



浙江威力士机械有限公司

ZHEJIANG WEILISHI MACHINE CO.,LTD

30 years experience in metal cutting industry!
30 年行业经验更为您用心服务！

Company Information
公司简介

浙江威力士机械有限公司成立于 1993 年，位于浙江省机床特色小镇 - 壶镇，占地 20000 平方米，投资 5000 万人民币，地理位置优越，临近上海和宁波港口。

公司成立以来专业生产锯床、锯条和工业缝纫机。我司生产的带锯条包括双金属带锯条和食品带锯条，规格包含13mm宽到80mm宽，材质分为M42, M51和锰钢带。公司拥有轧平，焊接，校直，铣齿，热处理，包装等全自动生产线。同时我们设有新产品的设计开发部门。 发展到今天， 我司除 TACHUANG, GOLDWELL, AMASS 和 ALTON 四大品牌外， 同时也承接 OEM 服务， 产品远销世界各国。

我司已过通 ISO9001 和 CE 认证。

We, ZHEJIANG WEILISHI MACHINE CO., LTD, established in 1993, located at Huzhen industrial zone, occupy 20,000square meter and capital RMB60 million. Near Ningbo port and Shanghai port.

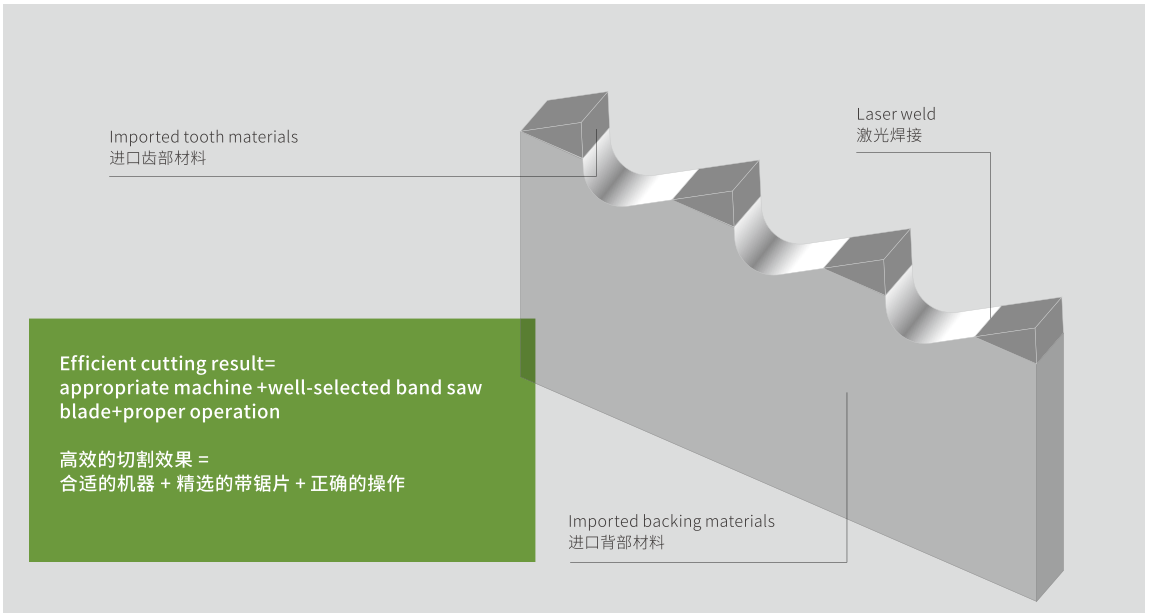
We are a professional manufacturer of bandsaw machine, bandsaw blade and sewing machines for more than 30 years. For the blade, we have all the range from 13mm to 80mm with M42 and M51 material. Our company have six production blocks: such as casting, shape processing, painting, assembly, testing, new product development. We can design, development and production of high-precision cutting .

WEILISHI has passed **ISO9001**, **CE** certification, China's mechanical safety certification. We always keep quality and technology at the first place, and try to make first-class products.

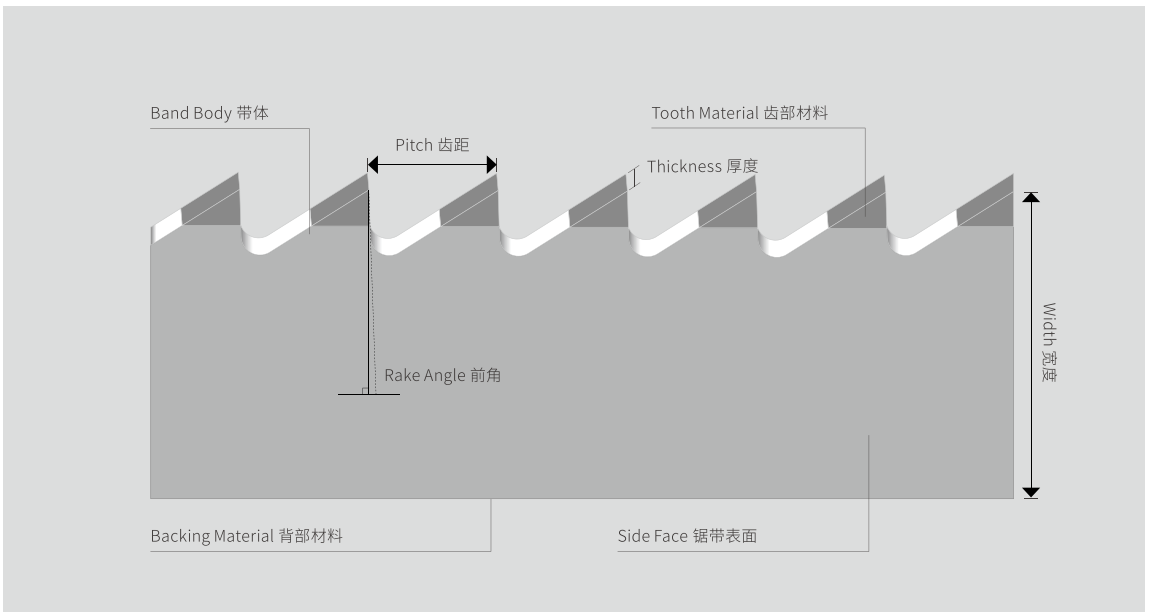
Looking forward to the future, WEILISHI will always keep blazing new trails in a pioneering spirit to create more brilliant tomorrow with customers hand in hand.

Tooth Types, Features & Applications
金属带锯条概述

Blade Construction
锯条的组成



Tooth Structure
齿的结构



TPI Calculation
齿距计算

Tooth Pitch: The number of teeth per inch or per 25.4mm in a saw blade.

齿距是以单位英寸（25.4mm）所包含的齿数表示（TPI）的，如两相邻齿尖之间的距离为 6.35mm，则齿距为 4TPI；两相邻齿尖之间的距离为 2.54mm，则齿距为 10TPI。

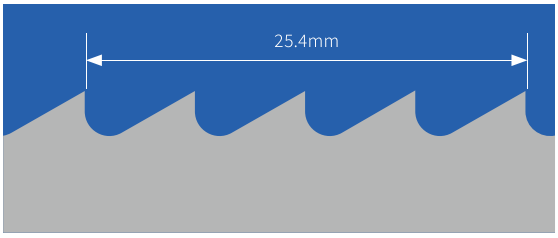
$$TPI = \frac{25.4}{\text{The distance between two adjacent teeth(mm)}\ \text{两相邻齿尖之间的距离}}$$

There are two kinds of tooth pitch, constant tooth pitch and variable tooth pitch.

齿距形式分为等齿距和变齿距。

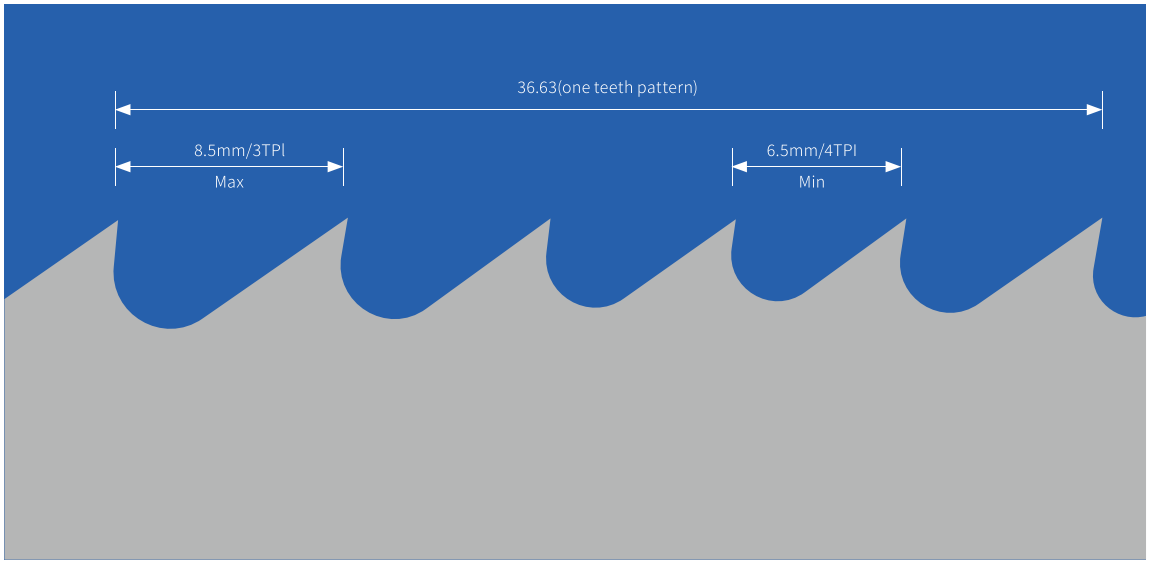
Constant Tooth: blades have a tooth distance which is equally spaced. Number of teeth per inch denotes the tooth of the saw blade. If the distance of two adjacent teeth is 6.35mm, the pitch is 4TPI.

等齿距即锯条上任意相邻的两个齿之间的距离是相等的，如 3TPI，4TPI，14TPI，等齿距大多情况下用于木头，冷冻食品和有色金属的切割。
请参看下图的 4TPI。



Variable tooth: blades are indicated by two numbers since the tooth pitch and the gullet vary. Distances vary within a group of teeth. Smallest to largest tooth pitch denotes the tooth variable of the saw blade. Variable tooth pitch reduces noise and vibration of cut while also increasing the life of the blade.

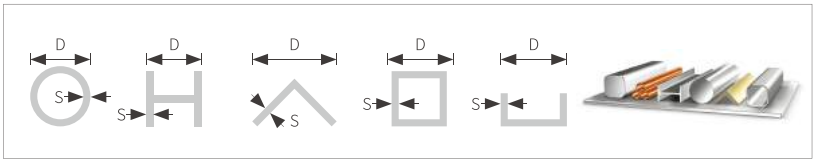
变齿距即锯条两相邻两个齿之间的距离不相等，齿与齿之间的距离按照某种规律组合排列。具体标识方法为一组齿中两齿距离最大的齿距和两齿距离最小的齿距来进行分别，比方说：3/4TPI 表示该组齿中不同齿之间的齿距在 3TPI（两齿距离为 8.5mm）和 4TPI（两齿距离为 6.5mm）之间变化，其他的齿距介于 3~4TPI 间，我们称之为 3/4TPI。采用变齿距的锯条能够大大减少因共振造成的锯条振动，从而延长锯条的使用寿命。
请参看下图 3/4TPI。



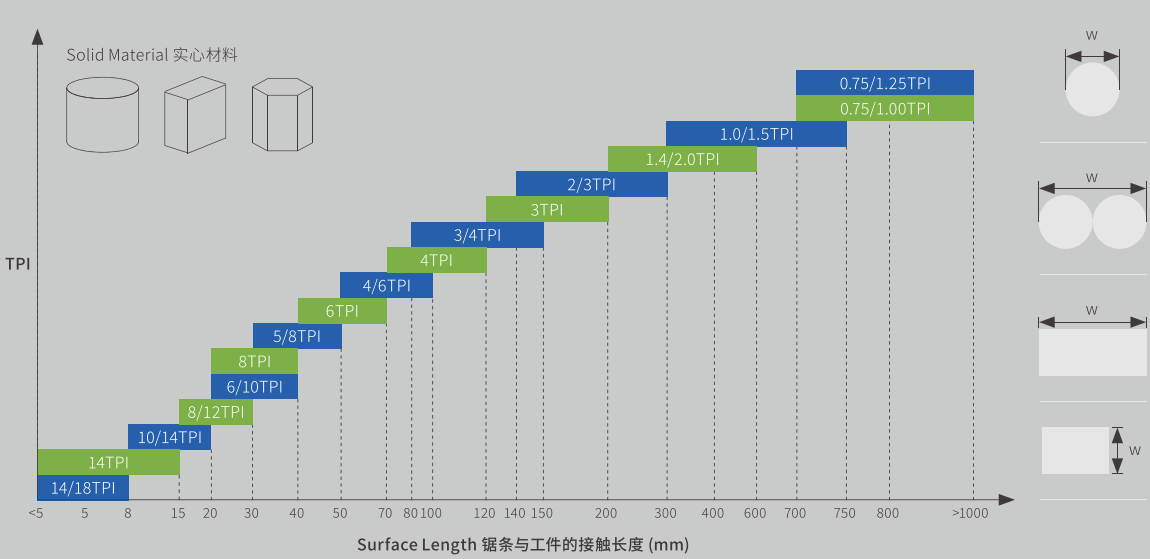
Tooth Pitch Selection Chart For Pipes And Profiles
管材和型材的 TPI 选择

Thichness 壁厚（mm）	Dlamter 外径（mm）													
	15	20	40	60	80	100	120	150	200	300	400	500	00	>700
2	14/18	14/18	14/18	10/14	10/14	10/14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	5/8
3	14/18	14/18	10/14	10/14	10/14	8/12	8/12	8/12	8/12	6/10	6/10	6/10	5/8	5/8
4	14/18	10/14	10/14	10/14	8/12	8/12	6/10	6/10	6/10	5/8	5/8	4/6	4/6	4/6
5	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	4/6
6	10/14	10/14	8/12	8/12	6/10	5/8	5/8	5/8	4/6	4/6	4/6	4/6	4/6	3/4
8		10/14	8/12	6/10	6/10	5/8	5/8	4/6	4/6	4/6	4/6	4/6	4/6	3/4
10			6/10	6/10	5/8	5/8	5/8	4/6	4/6	4/6	4/6	3/4	3/4	3/4
12			6/10	5/8	5/8	4/6	4/6	4/6	4/6	4/6	3/4	3/4	3/4	3/4
15			6/10	4/6	4/6	4/6	4/6	4/6	3/4	3/4	3/4	3/4	3/4	2/3
20				4/6	4/6	3/4	3/4	3/4	2/3	2/3	2/3	2/3	2/3	2/3
30					3/4	3/4	3/4	3/4	2/3	2/3	2/3	2/3	2/3	2/3
50							2/3	2/3	2/3	2/3	2/3	2/3	2/3	1.4/2.0
75									2/3	2/3	2/3	1.4/2.0	1.4/2.0	1.4/2.0
100											1.4/2.0	1.4/2.0	1.0/1.5	1.0/1.5
150											1.4/2.0	1.4/2.0	1.0/1.5	1.0/1.5
200												1.0/1.5	0.75/1.25 0.75/1.00	0.75/1.25 0.75/1.00
250													0.75/1.25 0.75/1.00	0.75/1.25 0.75/1.00
>300														0.75/1.25 0.75/1.00

*For 2 or more material, add up all wall thickness.
* 若多个工件成捆 / 成束切割，请将工件的壁厚乘以 2 后作为整体 S 的厚度。



Tooth Pitch Selection Chart For Solid Materials
实心材料 TPI 选择



Standard Tooth: N
标准齿

Standard tooth within 9° or relatively small positive rake angle, efficient cutting, smooth finish, less noise.
Widely used in small to medium pitch(<2/3 pitch) band saw blades, suitable for general purpose cutting and materials with small to medium cross sections.

由前面、后面和齿底圆弧构成齿槽的齿形。通常前角在 0-9 度，锋利度良好，效率高，切面平滑，减少噪音。
尖齿广泛用于中小齿距（<2/3 齿）的带锯条，适合锯切一般难度和中小截面的材料。

Width 宽度 x Thickness 厚度		TPI												
mm 毫米	Inches 英寸	0.75/1.25	1.0/1.5	1.4/1.8	1.4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14	14	14/18
13*0.65	1/2*.025							▲	▲	▲	▲	▲	▲	▲
19*0.9	3/4*.035							▲	▲	▲	▲	▲		
27*0.9	1*.035					▲	▲	▲	▲	▲	▲	▲		
34*1.1	1-1/4*.042					▲	▲	▲	▲	▲	▲			
41*1.3	1-1/2*.052			▲	▲	▲	▲	▲	▲					
54*1.6	2*.063	▲	▲	▲	▲	▲	▲	▲						
67*1.6	2-5/8*.063	▲	▲	▲	▲	▲	▲							
80*1.6	3*.063	▲												

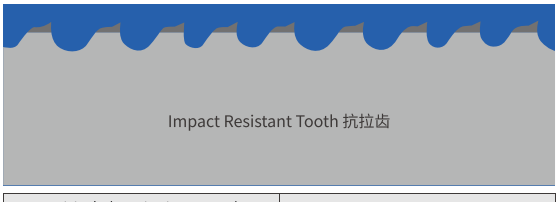
Rounded Rack Tooth: H
龟背齿

Ultimate all-round back flank of the tooth tip wider gullets, and efficient chip removal.
Suitable for medium pitch band saw blades, high shock resistance good performance on cutting high-hardness materia ls. like stainless steel , bundle material or mould steel.

近似于双后角齿，两后角差稍大些，故齿深相对双后角齿更深，排屑空间大。
龟背齿，适用于成捆束材，冲击大，硬度高的金属材料。

Width 宽度 x Thickness 厚度		TPI	
mm 毫米	Inches 英寸	2/3	3/4
13*0.65	1/2*.025		
19*0.9	3/4*.035		
27*0.9	1*.035		▲
34*1.1	1-1/4*.042		▲
41*1.3	1-1/2*.052	▲	▲
54*1.6	2*.063		
67*1.6	2-5/8*.063		
80*1.6	3*.063		

Impact Resistance Tooth:P
抗拉齿



Unique design tooth form, strong tooth profile, high cutting precision, high wear resitance, longer lifttime.
With a protective tooth geometry, especisally developed for cutting profiles and tubes, structural steel, bundled small bars and other shaped materials, etc.

接近于尖齿和龟背齿的组合，具有锋利的齿尖和高强度的齿背。齿部有小平台，这种设计增加了抗冲击能力了，减少拉齿的可能性。主要用于切割承受连续冲击的材料， 像大中型管材，型材及成束的小规格棒料等。注意，在切割壁厚超薄的材料时，应降低进刀速度。

Width 宽度 x Thickness 厚度		TPI	
mm 毫米	Inches 英寸	3/4	4/6
13*0.65	1/2*.025		
19*0.9	3/4*.035		
27*0.9	1*.035	▲	▲
34*1.1	1-1/4*.042	▲	▲
41*1.3	1-1/2*.052	▲	▲
54*1.6	2*.063	▲	
67*1.6	2-5/8*.063		
80*1.6	3*.063		

HI-LOW Pack Tooth:HL
高低齿

The combination design of high and low teeth has high penetration and high chip separation ability. Suitable for cutting solid materials with higher hardness, such as stainless steel ,mold steel, tool steel, etc., not suitable for cutting ordinary materials.

采用高低齿的组合的设计，具有较高的穿透性和高分屑能力。适合切较高硬度的实心材料，如不锈钢、模具钢、工具钢等 , 不适合切普通材料。

Width 宽度 x Thickness 厚度		TPI												
mm 毫米	Inches 英寸	0.75/1.25	1.0/1.5	1.4/1.8	1.4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14	14	14/18
13*0.65	1/2*.025													
19*0.9	3/4*.035													
27*0.9	1*.035													
34*1.1	1-1/4*.042					▲	▲							
41*1.3	1-1/2*.052					▲	▲							
54*1.6	2*.063													
67*1.6	2-5/8*.063													
80*1.6	3*.063													

SH tooth:SH
双后角齿

The tooth shape formed by two rear corners at the back, with a difference of 9-13 degrees, can increase the strength of the tooth. The main purpose of the double rear corners is to enhance the strength of the tooth tip and prevent tooth pulling. However, compared to the turtle back teeth, the space for holding debris is small. The advantages are low cutting noise, wear-resistant teeth, strong versatility, and the ability to cut both soft and hard materials,

后面由两个后角构成的齿形，两者差 9-13- 度，可增加齿部强度，双后角的目的主要是加强齿尖强度，预防拉齿。但相对龟背齿来说，容屑空间小。优点是切削噪音小及锯齿耐磨 , 通用性强，软硬材料都能切。

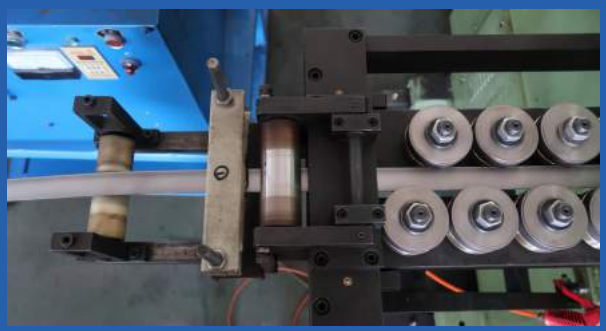
Width 宽度 x Thickness 厚度		TPI			
mm 毫米	Inches 英寸	1.4/1.8	1.4/2	2/3	3/4
13*0.65	1/2*.025				
19*0.9	3/4*.035				
27*0.9	1*.035				
34*1.1	1-1/4*.042			▲	▲
41*1.3	1-1/2*.052	▲		▲	▲
54*1.6	2*.063		▲	▲	
67*1.6	2-5/8*.063				
80*1.6	3*.063				

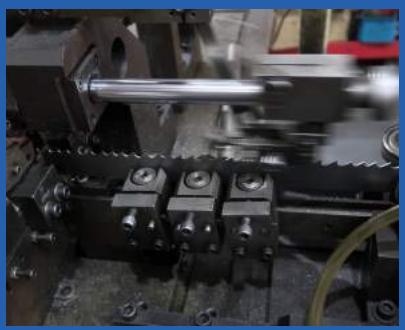
QUICK TIPS
小贴示

Bandsaw Blades Size Specification:
公 / 英制规格的转换

mm 毫米	Inches 英寸	mm 毫米	Inches 英寸
13x0.65	1/2*0.025	41x1.30	1-1/2*0.050
13x0.90	1/2*0.035	54x1.60	2*0.063
19x0.90	3/4*0.035	67x1.60	2-5/8*0.063
27x0.90	1*0.035	80x1.60	3*0.063
34x1.10	1-1/4*0.042		








Brand Introduction
品牌介绍

Tachuang

Using high-performance M42 tooth material and high-quality spring steel backing material, implementing high standard thermal processing technology in the industry.
Not only does it have good cutting performance, but it also allows you to achieve "low cost".

Applications:
Carbon Steel, Strcutural steel.

采用高性能的 M42 齿部材料和优质弹簧钢带体材料， 执行行业内高标准的热理工艺。不仅拥有良好的切割表现，更让你达到“低成本”的需求。

适用材料:
碳钢，型钢。

GOLDWELL

Adopting original imported German backing material combined with laser welding technology，Perfect combination of tooth materials. Show perfect cutting strength,More stable and reliable performance. Strong adaptability to materials, deeply influenced by Popular among customers.

Applications:
Carbon Steel, Strcutural Steel, Tool Steel.

采用原装进口德国背材，结合激光焊接技术将齿部材料完美结合。展现完美的切削实力，性能更能稳定，可靠。对材料适应性强，深受广大客户喜爱。

适用材料:
碳钢，结构钢和工具钢。

ALTON

The tooth material is made of high-performance powder high-speed steel (M51), and the back material is made of imported X32 high-quality high alloy spring steel. It has high red hardness, high wear resistance, and a wide range of specifications to choose from, with a wide range of applications.

Applications:
Die Steel, Stainless Steel.

此款为 M51 材料，具有高红硬性、高耐磨性，全系列规格选择，应用范围广泛。

适用材料:
模具钢，不锈钢，结构钢和轴承钢等。

AMASS

The back material is a powder alloy imported from Europe, which has high red hardness, high wear resistance, longer working life, and higher hardness.

Applications :
High hardness tool steel, mold steel, high wear resistant stainless steel, etc.

背部材料为欧洲进口，M51 锯条合金含量大大高于 M42 锯条,具有高红硬性、高耐磨性，具有更长的工作寿命，较高的硬度 。

适用材料:
高硬度的工具钢、模具钢、高耐磨的不锈钢等。

QUICK TIPS
小贴示

Bandsaw Blades Coil Specification:
盘带介绍 :

We can supply welded loops to your specification. We also provide coil stock in the following lengths:

我们也为批发客户提供盘带，方便自主截取长度 :

Packing 包装情况	
13mm-100+/-5m per coil	41mm-75+/-5m per coil
19mm-100+/-5m per coil	54mm-55+/-5m per coil
27mm-100+/-5m per coil	67mm-55+/-5m per coil
34mm-85+/-5m per coil	

Bandsaw Blade Speed Chart
锯切带速表

Materials 材 料	Trade Name 分类名称及相应中国牌号	USA 美 国	German DIN 德 国	Japan JIS 日 本	Bimetal Bandsaw Blade m/min 双金属带锯条	Carbide Bandsaw Blade m/min 硬质合金带锯条
Aluminum And Aluminum Alloy 铝及铝合金	5052	5052	3.1355	5052	70~105	1000-2600
Copper Alloy 铜合金系列	GB H96	CDA220	2.023	C2200	65	65
	HPb36-3	CDA360	2.0375	C3601	90	90
	B30	Cu Ni (30%)	2.0835	-	65	65
	Qbe2,QBe1.7	Be Cu	-	C1700	50	50
Bronze Alloys 青铜合金系列	Wear Resistance Aluminium Bronze 耐磨铝青铜	AMPCO18	-	-	55	55
	Wear Resistance Bronze 耐磨青铜 (13% Al)	AMPCO21	-	-	50	50
	Deep Drawn Aluminium Bronze 深拉铝青铜	AMPCO25	-	-	35	35
	Low Leaded Tin Bronze 低铅锡青铜	-	2.1177	-	90	90
	CuAl10Ni	AlBronze 865	2.0976	AlBCIn1	50	50
	CuZn35AL1	-	2.0602	-	65	70
	CuSn7Zn4Pb7	932	-	-	85	85
	CuSn10Pb10	937	-	-	80	80
Brass Alloys 黄铜系列	Cartridge-Case Brass 弹壳黄铜 (85%Cu)	Red Brass(85%)	-	BC6	70	70
	Copper Zinc Tin Alloy 铜锌锡合金	Naval Brass	-	YCuZnSn	65	65
Leaded,Free Machining Low Carbon Steels 易加工钢，低碳钢	Y45	1145	-		85	90
	Y08MnS	1215	1.0736	SUM25	100	100
	Y15Pb	12L14	1.0718	SUM24L	110	110
Structural Steels 结构钢	Q255	A36	1.0132	-	80	-
Low Carbon Steels 低碳钢	10 # Steels	1008	1.031	S9CK	85	80
Medium Carbon Steels 中碳钢	30	1030	1.1.178	S30C	80	75
	35	1035	1.0501	S35C	75	70
	45	1045	1.1191	S45C	70	70
High Carbon Steels 高碳钢	60	1060	1.0601	S58C	65	-
	80	1080	1.1259	1080	60	-
	C92D2B	1095	1.0618	SUP4	60	-
Min Steels 锰钢	40MnB	1541	1.1167	SMn 438(H)	65	-
	20Mn2	1524	1.0499	SCMn1	55	-
Cr-Mo Steels 铬钢	40CrMnMo	4140	1.7225	SCM 440(H)	70	-
	40CrMnMo	41L50	-	-	75	-
	50CrMo4	4150H	-	-	65	-
Cr Alloy Steels 铬合金钢	50CrVA	6150	1.8159	SUP10	60	-
	GCr15	52100	1.3505	SUJ2	50	-
	60CrMnA	5160	1.7176	SUP9(A)5	60	-
Ni-Cr-Mo Steels 镍铬钢	45CrNiMoVA	4340	1.6565	SNCM439	60	-
	20CrNiMo	8620	1.6523	SNCM 220H	65	-
	40CrNiMoA	8640	1.6546	SNCM 240	60	-
	12CrNi3	E9310	1.6657	-	50	-
低合金工具钢 Low Alloy Tool Steel	5CrNiMo	L-6	1.2714	SKT4	45	60
Water-Hardening Tool Steel 水淬硬化工具钢	T13	W-1	1.1673	SK1	45	55

Materials 材 料	Trade Name 分类名称及相应中国牌号	USA 美 国	German DIN 德 国	Japan JIS 日 本	Bimetal Bandsaw Blade m/min 双金属带锯条	Carbide Bandsaw Blade m/min 硬质合金带锯条
Cold-Work Tool Steel 冷作工具钢	Cr12Mo1V1	D-2	1.2379	SKD11	30	55
Air-Hardening Tool Steels 空淬硬化工具钢	Cr5Mo1V	A-2	1.2363	SHD12	50	60
	-	A-6	-	-	45	55
	5CrNiMo	A-10	-	-	30	40
Hot Work Tool Steels 热作工具钢	4Cr5MoSiV1	H-13	1.2344	SKD61	45	55
	-	H-25	-	-	30	40
Oil-Hardening Tool Steels 油淬工具钢	9CrWMn	O-1	1.251	SKS3	45	60
	9Cr2V	O-2	1.2842	-	45	55
High Speed Tool Steels 高速工具钢	W6Mo5Cr4V2	M-2, M-10	1.3343	SKH9	35	30
	W6Mo5Cr4V4	M-4	1.3348	SKH54	30	30
	W18Cr4V	T-1	1.3355	SKH2	30	25
	W12Cr4V5Co5	T-15	1.3202	SKH 10	20	20
Mold Steels 模具钢	-	P-3	-	-	55	50
	3Cr2Mo	P-20	1.2328	-	50	40
Shock Resistant Tool Steels 抗冲击工具钢	5CrW2Si	S-1	1.2542	SKS41	45	-
	5Cr3Mn1SiMo1V	S-5, S-7	1.2823	-	40	-
Stainless Steels 不锈钢	0Cr18Ni9	304	1.4301	SUS304	25	50
	0Cr17Ni12Mo2	316	1.4401	SUS316	30	40
	1Cr13, 2Cr13	410	1.4006	SUS410	45	55
	7Cr17	440A	1.4109	SUS440 A	25	45
	8Cr18	440C	1.4125	SUS440 C	25	45
Precipitation Hardening Stainless Steels 沉淀硬化不锈钢	0Cr17Ni4Cu4Nb	17-4PH	1.4542.1.4568	SUS630, SUS631	25	35
	0Cr15Ni5Cu4Nb	15-5PH	1.4545	-	25	30
Free Machining Stainless Steels 易加工不锈钢	Y3Cr13	420F	-	-	50	60
	1Cr17Ni7	301	1.431	-	40	50
Nichel Alloys 镍合金	Nickel Copper Alloy 镍铜合金	Monel ® K-500	2.4375	-	25	30
	Nichrome 镍铬合金	Duranickel 301	-	-	20	25
Iron Based Super Alloys 铁基高温合金	GH2132,NS142	A286	1.498	SUH660	25	25
	-	Incoloy ® 600	-	-	20	25
	NiCo Alloys 镍钴合金	Pyromet X-15	-	-	25	30
Nickel Based Alloys 镍基高温合金	Gh600,GH4169,GH169,GH90	Inconel ® 600	2.4816,2.4668	NCF-600	20	30
	GH141	RENE41	2.4973	-	20	30
	0Cr20NI65Mo10Nb4	Inconel ® 625	2.4831	-	25	35
	0Ni65Mo28Fe5V	Hastalloy B	2.4800	Ni-Mo28	20	25
	-	RENE 88	2.4951	-	20	25
Titanium Alloys 钛合金	工业纯钛 TAO	-	3.7025	-	25	50
	TC4	Ti-6AI-4V	3.7615	-	20	50
Cast Irons 铸铁	QT400-18	A536(60-40-18)	0.704	FCD40	70	-
	QT800-2	A536(120-90-02)	0.708	-	35	-
	HT150	A48(20)	0.601	FC10	50	-
	HT250	A48(40)	0.6025	FC25	25	-
	-	A48(60)	0.604	-	30	-

* For metal cutting saws run between 275 and 350 FPM(88 and 107 FPM); Typically for hardened and case hardened carbon steels up to 61 HRC.
* 普通双金属带锯床锯切速度在 70m/min~110m/min 区间

Troubleshooting
常见故障分析及解决办法

常见向题 Problem Description	常见问题诊断 Problem Cause
锯齿过早钝化 Premature Teeth Wear	■ 新锯带科学地跑合，可提高齿部寿命的 20% 上。 方案：降低切削速度和进给速度至 50-60%，锯切至少 500cm^2 的面积，而后逐步提高参数至正常值 ☐ Insufficient break-in of new blade
	■ 工件硬度高 (表面氧化层更甚) 或既硬还粘，必须大幅降低切削速度和进给力 ☐ High hardness of workpiece
	■ 品牌或齿形、齿距选择不当 ☐ Improper blade selection
	■ 冷却液选择不当，冷却效果不佳 ☐ Improper coolant fluid
偏锯 (切料) Inaccurate Cutting	■ 切削参数选择失当 (带速太快、进给太猛) ☐ Incorrect parameters (blade speed and feed rate too high)
	■ 带锯条张紧力不足 ☐ Band tension too low
	■ 导向块外端与导向轴承严重磨损，导致导向块的磨损，且不平整 ☐ Guide blocks and bearina wear out
	■ 今导向块与带体间的间隙未消除 (往往被忽视），致使导向不良，造成偏距 ☐ Gap between guide blocks and blade body
	■ 两固定导向面不共面 ☐ Two guide surfaces out or alianment
	■ 公共导向面与锯架进给轨迹不平行，必然偏锯 ☐ Guide not parallel with saw frame
	■ 两导向臂距离工件太远，导向不力 ☐ Guide arms set too far apart
	■ 锯达磨损严重时勉强工作，将产生或加大偏距 ☐ Heavy wear on tooth

常见向题 Problem Description	常见问题诊断 Problem Cause
崩刃、拉齿 Tooth Breakage	■ 开始或完成切割的瞬间进给太快而出现打齿、拉齿，甚至断带 ☐ Feed rate too high when begin or complete
	■ 脱落的齿尖嵌入锯缝时易出现拉齿 ☐ Chipped tooth stuckin kert
	■ 新锯条走老锯路极易出现卡锯、拉齿 ☐ Improper break-in when blade replaced
	■ 切割面不连续或切薄壁管材、型材时，进给速度太快易崩刃、拉齿 ☐ Reed rate too high when cutting structural materials or uneven cutting surface
	■ 除屑轮失效（住往被忽视）可将大量粘附在齿尖的切削带至锯缝，产生崩刃、打齿 ☐ Chip brush not working
	■ 因疏忽至带锯条倒装，绝对拉齿 ☐ Incorrect blade installation
带锯条断裂 Blade Breakage	■ 对焊设备不良或参数选择不当，致使焊接不牢或热影响区强度不足而断焊口 ☐ Improper parameters
	■ 张紧力过大将降低带体疲劳寿命 ☐ Blade tension too high
	■ 张紧力过大时，加上齿部承受着巨大的切削抗力，易从薄弱的齿沟处裂、断 ☐ Cracks from gullets due to high band tension
	■ 工件松动极易导致打齿、卡锯、断带 ☐ Workpiece held loosely
	■ 导向效果不佳，零部件磨损严重，导致带体机械损伤，甚至切削进入其中，阻力陡增而断带 ☐ Ineffective guide effect, parts wear out
	■ 工件尺寸超出锯条设定范国，使得导向臂至锯轮太近，带体扭角加大而加速带体疲劳 ☐ Workpiece dimension out of blade working rang
	■ 部分锯床设计时扭角过大（接近或达到 90°），易加速带体疲芳 ☐ Sharpe torsional angle of machine bed (Close or equal to 9o°)

Meat Cutting Quenching Bandsaw Blade
食品带锯条

Features:
1. Special hardening and precision grinding of tooth tip make sawing faster;
2. Universal design, it can easily cut all kinds of frozen or fresh bone and meat foods in a straight line;
3. The variable tooth design is selected to minimize the sawing noise, make the sawing surface smoother and less loss;
4. Japanese SK4 or Swiss c1095 materials are selected to prevent corrosion and rust, and the service life is longer.

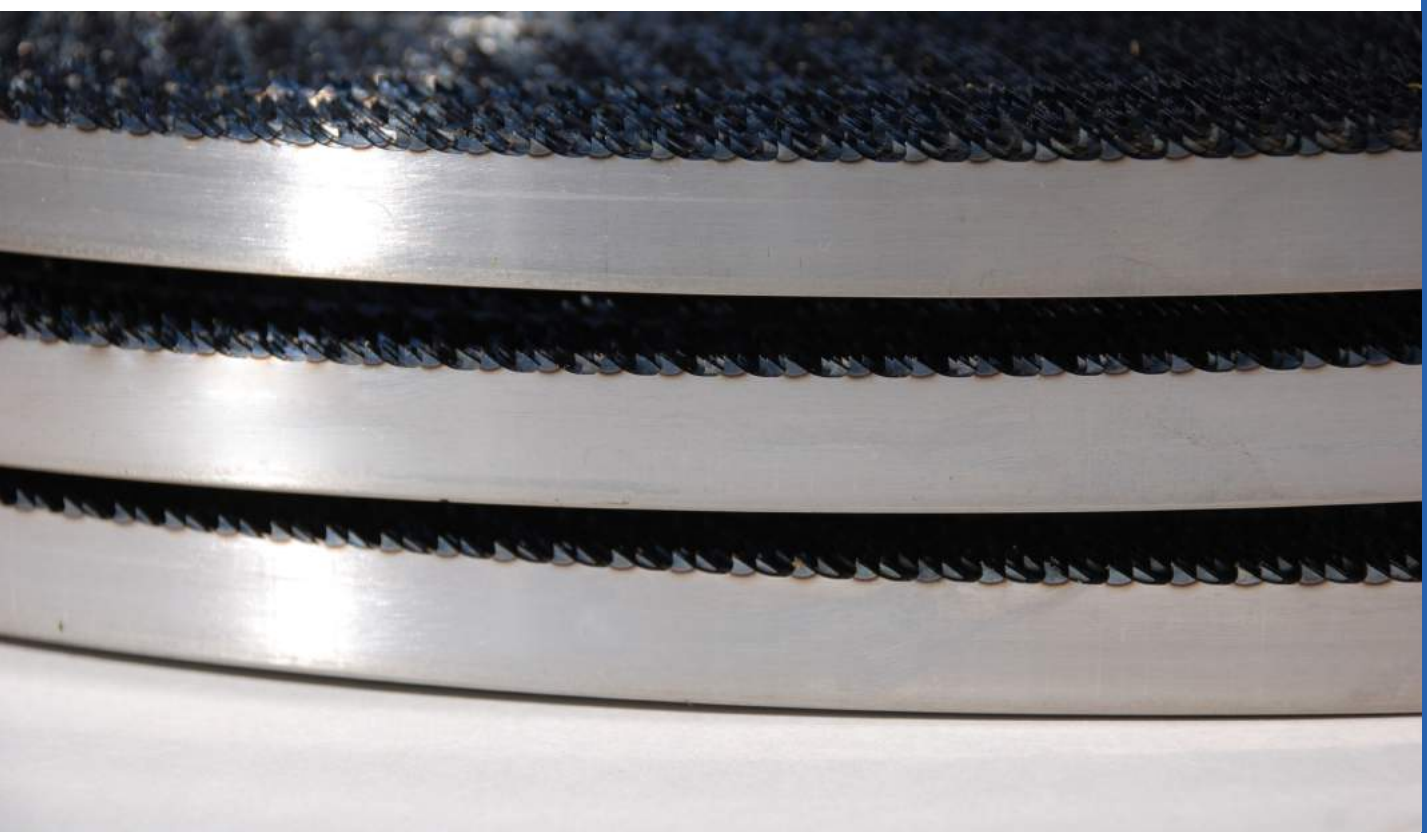
Applications: frozen meat/fish/bone

特　　点:
1. 特殊硬化和精密研磨齿尖，锯切更快速;
2. 通用型设计，可轻松的直线锯切各类冷冻或新鲜的骨肉类食品;
3. 选用变齿设计，锯切噪音降到最低，锯切面更平整，损耗更少;
4. 选用日本 SK4 或瑞士 C1095 材料，防止腐蚀生锈，使用寿命更长。

适用范围 : 冻肉 / 鱼 / 骨头

*We also provide blade by 165m/coil.
* 我司亦可提供盘带，165 米 / 盘。

Length 长度 (mm)	Width 宽度 (mm)	Thickness 厚度 (mm)	TPI 齿形	Machine 适用机型
1650	16-19	0.56/0.65	3t, 4t	270
2210	16-19	0.56/0.65	3t, 4t	300
2640	16-19	0.56/0.65	3t, 4t	600A
2750	16-19	0.56/0.65	3t, 4t	350



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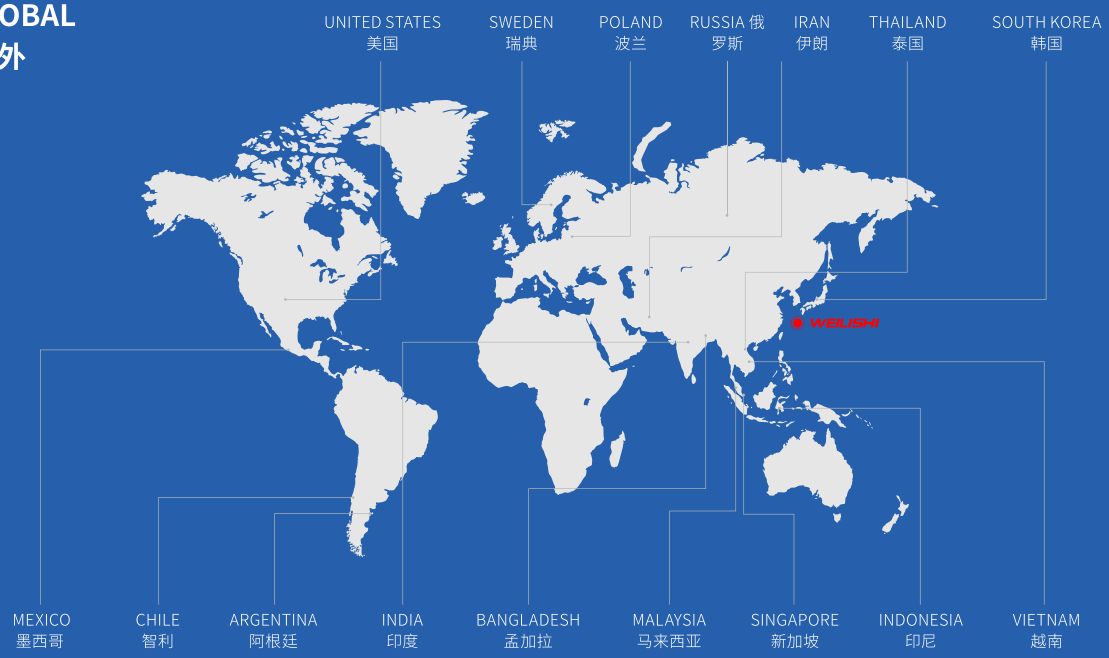

WEILISHI

BANDSAW BLADE

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DEALER