

HIGH-TECH BAND SAW BLADES FOR YOUR APPLICATION

Product overview



INNOVATIVE HIGH-PERFORMANCE BAND SAW BLADES FOR ALMOST ALL APPLICATIONS

WIKUS stands for precision, quality and very high performance. With the best materials, state-of-the-art manufacturing processes made in Germany and continuous quality controls, we have been guaranteeing the highest standards in the manufacture of our high-tech band saw blades since 1958.

BIMETAL BAND SAW BLADES

The optimum product portfolio for standard and special applications. Our bimetal product range is available in two cutting materials:

Cutting material M42

- The blade backing material is made of alloyed steel that offers excellent continuous operation properties
- Superior wear resistance in conventional applications
- Hard-coated PREMIUM version for highest cutting rates and tool life

Cutting material X3000®

- Modified cutting material X3000® (exclusive to WIKUS) with high hardness and excellent toughness with high cutting edge stability
- Ideal for materials that are difficult to machine and special alloys



CARBIDE BAND SAW BLADES

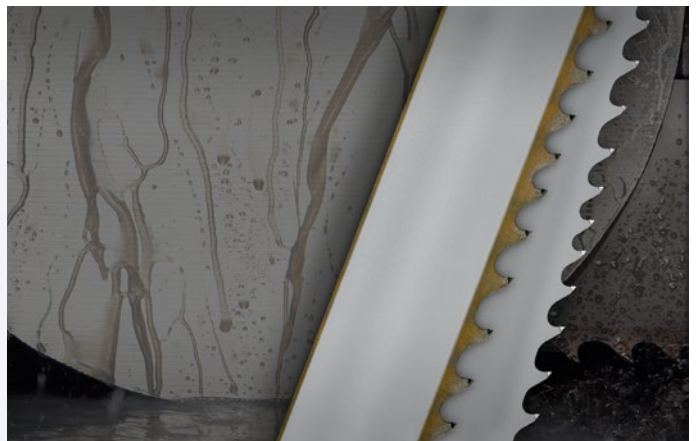
To increase cutting performance and productivity, available in two qualities:

Carbide-tipped

- Excellent results thanks to the different degrees of hardness and compositions of the carbides used
- Available in specially ground and / or set tooth geometries
- Long running times and extremely high performance thanks to the optimum carrier material for increased performance

Carbide-tipped with hard coating

- Optimum properties thanks to different coating types in combination with the carbides used for this purpose
- Availability for specially ground and/or straight-set tooth geometries
- Considerable increase in machining performance in case of capacity bottlenecks



RECOMMENDATION FOR USE BIMETAL

ASSORTMENT	BIMETAL BAND SAW BLADES			
APPLICATION				
Nickel-based alloys	MARATHON® X3000®		SKALAR® X3000® SELEKTA® GS X3000®	
Duplex and heat-resistant steels				
Titanium, titanium alloys				
Aluminum bronze				PRIMAR® M42
Hardened and tempered steels (over 1000 N/mm²)				
Stainless and acid-resistant steels (austenitic)				
Stainless and acid-resistant steels (ferritic)				
Tool steels (heat resistant-, cold work steels and HSS)	PROFLEX® M42* PROFLEX® SW M42*	SKALAR® M42* SELEKTA® GS M42*		
Spring steels and ball bearing steels				
Carbon, case-hardening, tempered & nitriding steels				
Construction, deep-drawing and cutting steels				
Cast iron				
Non-ferrous metals				
Aluminum / aluminum alloys				
Surface hardened components				
Mineral materials				
Tyres				
CLASSIFICATION	Level 2		Level 3	Level 1

* Also available in hard-coated PREMIUM version

■● Solid material □○HΛ Profiles very good sufficient

PRIMAR® M42

The versatile tool for small and medium workpieces



- **Product level 1, Bimetal band saw blades**
- **Standard tooth (S) + Hook tooth (K)**
- Workshop and lighter industrial applications
- Small to medium cross-sections with Ø up to 900 mm
- All metals up to 1000 N/mm² tensile strength
- Solid materials and profiles

Dimensions		Tooth pitch in tpi														
Width x thickness		variable									constant					
mm	Inch	10 - 14	8 - 12	6 - 10	5 - 8	4 - 6	3 - 4	2 - 3	1.4 - 2	1 - 1.4	18	14	6	4	3	2
6 x 0.65	1/4 x 0.025	S														
6 x 0.90	1/4 x 0.035	S											K			
10 x 0.90	3/8 x 0.035	S											K	K		
13 x 0.50	1/2 x 0.020											S				
13 x 0.65	1/2 x 0.025	S	S	S							S	S	K			
20 x 0.90	3/4 x 0.035	S	S	S	S	K					S			K*	K*	
27 x 0.90	1-1/16 x 0.035	S	S	S	S	K	K	K			S	S		K*	K*	K*
34 x 1.10	1-3/8 x 0.042		S	S	S	K	K	K							K*	
41 x 1.30	1-5/8 x 0.050					K	K	K	K							
54 x 1.30	2-1/8 x 0.050						K	K								
54 x 1.60	2-1/8 x 0.063						K	K	K	K						
67 x 1.60	2-5/8 x 0.063							K	K	K						
Contact length	[mm]	< 20	10-30	20-50	30-60	50-100	80-170	150-300	250-550	500-1000	< 10	< 15	50-80	80-120	120-200	200-400
	[Inch]	< 0.8	0.4-1.2	0.8-2	1.2-2.4	2-3.9	3.1-6.7	5.9-11.8	9.8-21.6	19.7-39.4	< 0.4	< 0.6	2-3.1	3.1-4.7	4.7-7.9	7.9-15.7

* = Wide set for non-ferrous metals

MARATHON® M42

The all-rounder for small and large cross sections



- **Product level 2, Bimetal band saw blades**
- **Hook tooth (K)**
- Industrial applications
- Medium-sized to large work pieces
- All metals up to 1000 N/mm² tensile strength
- Solid material
- Single, layer and bundle cutting

Dimensions		Tooth pitch in tpi										
Width x thickness		variable							constant			
mm	Inch	5 - 8	4 - 6	3 - 4	2 - 3	1.4 - 2	1 - 1.4	0.75 - 1.25	6	4	3	1.25
13 x 0.65	1/2 x 0.025								K	K		
13 x 0.90	1/2 x 0.035				K				K	K	K	
20 x 0.90	3/4 x 0.035		K		K				K	K	K	
20 x 1.10	3/4 x 0.042				K						K	
27 x 0.90	1-1/16 x 0.035	K	K	K	K							
34 x 1.10	1-3/8 x 0.042	K	K	K	K	K						K
41 x 1.10	1-5/8 x 0.042		K	K	K	K						
41 x 1.30	1-5/8 x 0.042	K	K	K	K	K						
54 x 1.30	2-1/8 x 0.050		K	K	K	K						
54 x 1.60	2-1/8 x 0.063		K	K	K	K	K					
67 x 1.60	2-5/8 x 0.063		K	K	K	K	K	K				
80 x 1.60	3-1/8 x 0.063			K	K	K	K	K				
Contact length	[mm] [Inch]	30-60 1.2-2.4	50-100 2-3.9	80-170 3.1-6.7	150-300 5.9-11.8	250-550 9.8-21.6	500-1000 19.7-39.4	700-1400 27.6-55.1	50-80 2-3.1	80-120 3.1-4.7	120-200 4.7-7.9	300-800 11.8-31.5

PROFLEX® M42

The perfect band saw blade for profiles



- **Product level 2, Bimetal band saw blades**
- **Profile tooth (P)**

- Metal, steel profiles and carriers
- Optimal for cutting with interrupted cutting channel
- Profile tooth with extremely stable tooth geometry
- Special setting

Dimensions		Tooth pitch in tpi								
Width x thickness										
mm	Inch	14 - 18	12 - 16	10 - 14	8 - 11	7 - 9	5 - 7	4 - 6	3 - 4	2 - 3
13 x 0.65	1/2 x 0.025	P		P	P	P				
13 x 0.90	1/2 x 0.035			P	P	P				
20 x 0.90	3/4 x 0.035		P	P	P	P	P	P		
27 x 0.90	1-1/16 x 0.035		P	P	P	P	P	P	P	
34 x 1.10	1-3/8 x 0.042				P	P	P	P	P	P
41 x 1.30	1-5/8 x 0.042				P	P	P	P	P	P
54 x 1.30	2-1/8 x 0.050					P		P	P	P
54 x 1.60	2-1/8 x 0.063							P	P	P
67 x 1.60	2-5/8 x 0.063								P	P
Contact length	[mm]	< 5	< 10	< 15	15-30	20-50	40-70	50-90	80-160	150-310
	[Inch]	< 0.2	< 0.4	< 0.6	0.6-1.2	0.8-2	1.6-2.8	2-3.5	3.1-6.3	5.9-12.2

SKALAR® M42

The high-performer for large cross-sections



- **Product level 3, Bimetal band saw blades**
- **Hook tooth (K)**

- Large blocks in industrial production
- Especially for mixing programs with a large material mix
- Also for difficult-to-machine non-ferrous special alloys
- All metals up to 1000 N/mm² tensile strength
- Short cutting time and lower cutting forces

Dimensions		Tooth pitch in tpi					
Width x thickness							
mm	Inch	2.5 - 3.4	1.8 - 2.5	1.4 - 1.8	1.2 - 1.6	1 - 1.4	0.7 - 1
27 x 0.90	1-1/16 x 0.035	K					
34 x 1.10	1-3/8 x 0.042	K	K				
41 x 1.30	1-5/8 x 0.050	K	K	K			
54 x 1.30	2-1/8 x 0.050	K	K	K			
54 x 1.60	2-1/8 x 0.063	K	K	K	K	K	
67 x 1.60	2-5/8 x 0.063			K	K	K	K
80 x 1.60	3-1/8 x 0.063				K	K	K
Contact length	[mm]	100-220	180-350	300-600	400-700	500-1000	900-2000
	[Inch]	3.9-8.7	7.1-13.8	11.8-23.6	15.7-27.6	19.7-39.4	35.4-78.7

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Innovative precision tools designed
and manufactured in Spangenberg,
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