



AMACUT[®]



**BAND
SAW
BLADE**

»»»»

Ideal Solutions
For Professionals..

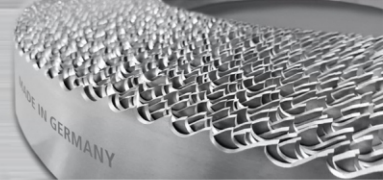
Made In Germany

Ideal Solutions for Professionals in Band Saw Production



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			AC 1101	AC 1102	AC 1103	AC 1104	AC 1110	AC 1201
1	GENERAL STRUCTURE AUTOMATIC STEELS	1.0037 ST37 S235JR 1.0040 ST44 S275J2G3 1.0301 C10 1.0721 10S20						
2	GENERAL STRUCTURE IMPROVEMENT STEELS	1.0050 ST50 E295 1.0060 ST60 E335 1.0501 C35 1.0503 C45						
3	CEMENTATION STEELS	1.7131 16MnCr5 1.7225 42CrMo4 1.8159 51CrV4 1.6582 34CrNiMo6						
4	BEARING STEEL UNALLOYED CARBON STEEL BALL STEEL	1.3505 100Cr6 1.1663 C125W						
5	HIGH SPEED STEEL	1.3343 S6-5-2 1.3247 S2-10-1-8						
6	COLD WORK TOOL STEEL	1.2436 X210CrW12 1.2379 X153CrVMoV12						
7	ALLOY CARBON	1.2311 40CrMnMo7 1.2714 56NiCrMoV7 1.2344 X40CrMnV51 1.8504 34CrAl6						
8	STAINLESS STEEL	1.4301 X10CrNi1810 1.4462 X2CrNiMoN22 1.4571 X6CrNiMoTi17						
9	DURABLE STEEL	1.4841 X15CrNiSi25 2.4816 NiCr15Fe						
10	NICKEL ALLOYS	2.4668 NiCr19NbMo 2.4610 NiMo16Cr16Ti 2.4632 NiCr20Co18Ti						
11	CAST IRON CASTING	0.6020 GG-20 0.6030 GG-30 0.7070 GGG-70						
12	TITANIUM BRONZE ALUMINIUM BRONZE AMPCO	3.7065 Ti 3.7115 TiAl5Sn2F79						
13	ALUMINIUM ALLOYS	EN AW-1200 AL 99 EN AW-6082 Al Si1MgMn EN AC-AIMg5Si						
14	BRASS	2.0321 CuZn37 2.0402 CuZn40Pb2 2.0550 Cu Zn 40 Al 2						
S	SPECIAL MATERIALS							
Fe	NON-FERROUS MATERIALS							



AC 1202	AC 1109	AC 1112	AC 1107	AC 1108	AC 1401	AC 1403	AC 1404	AC 1408	AC 1406
		HUL							
		HUL							

AMACUT BiMetal M42S
AC 1101

Bi-metal band saw blades made of HSS M42,

Material no: 1.3247

- To cut small solid materials of steel and small profiles
- Strength up to 1400 N/mm²

Sizes mm	Teeth				
	4	6	10	14	18
6 x 0,9			S-0	S-0	
10 x 0,9			S-0	S-0	
13 x 0,65			S-0	S-0	S-0
20 x 0,9				S-0	S-0
27 x 0,9	S-0	S-0		S-0	

S-0= Standard tooth 0°

AMACUT BiMetal M42K
AC 1102

Bi-metal band saw blades made of HSS M42,

Material no: 1.3247

- For several materials and cutting purposes
- Strength up to 1400 N/mm²

Sizes mm	Teeth		
	3	4	6
6 x 0,9			K-2
10 x 0,9		K-2	K-2
13 x 0,65		K-2	K-2
13 x 0,9	K-2	K-2	K-2
20 x 0,9	K-2		K-2
27 x 0,9	K-2		

K-2 = Claw tooth 10° positive

AMACUT BiMetal M42V
AC 1103

Bi-metal band saw blades made of HSS m42,

Material no: 1.3247

- The cut profiles and tubes of steel
- Strength up to 1400 N/mm²

Sizes mm	Teeth					
	3/4	4/6	5/8	6/10	8/12	10/14
6 x 0,9						V-0
10 x 0,9						V-0
13 x 0,65			V-0*	V-0	V-0	V-0
13 x 0,9				V-0	V-0	V-0
20 x 0,9		V-0	V-0	V-0	V-0	V-0
27 x 0,9	V-0	V-0	V-0	V-0	V-0	V-0
34 x 1,1	V-0	V-0	V-0	V-0	V-0	
41 x 1,3	V-0	V-0	V-0	V-0		

V-0= Vario tooth 0° *on request

AMACUT BiMetal M42 SV
AC 1104

Bi-metal band saw blades made of HSS m42,

Material no: 1.3247

- For cutting medium to large cross sections of various material types
- For aluminium up to stainless steel
- Strength up to 1400 N/mm²

Sizes mm	Teeth					
	0,75/1,25	1,4/2	2/3	3/4	4/6	
20 x 0,9						V-2
27 x 0,9			V-2	V-2	V-2	V-2
34 x 1,1		V-2	V-2	V-2	V-2	V-2
41 x 1,3		V-2	V-2	V-2	V-2	V-2
54 x 1,3		V-2	V-2	V-2	V-2	V-2
54 x 1,6	V-2	V-2	V-2	V-2	V-2	V-2
67 x 1,6	V-2	V-2	V-2			
80 x 1,6	V-2	V-2				

V-2 = Vario tooth 10° positive

AMACUT BiMetal M42 SV SG
AC 1110

Bi-metal band saw blades made of HSS M42,

Material no: 1.3247 with specially ground vario tooth

- For production cutting of medium to large cross sections of various material types
- Precise ground tooth pitch for smooth surface finish and long blade life

Sizes mm	Teeth			
	0,75/1,25	1,4/2	2/3	3/4
27 x 0,9			V2	V2
34 x 1,1		V2	V2	V2
34 x 1,1		V2	V2	V2
54 x 1,3		V2	V2	V2
54 x 1,6	V2	V2	V2	V2
67 x 1,6	V2	V2	V2	
80 x 1,6	V2	V2		

V-2= Vario tooth 10° positive ground teeth



AMACUT BiMetal M51 SV
AC 1201

Bi-metal band saw blades made of HSS M51,
Material no: 1.3207

- To cut solid steel up to 1700 N/mm² strength
- Developed to cut difficult materials

Sizes mm	Teeth					
	0,75/1,25	1/1,3	1,4/2	2/3	3/4	4/6
27 x 0,9				V-3	V-3	V-3
34 x 1,1				V-3	V-3	V-3
41 x 1,3			V-3	V-3	V-3	
54 x 1,6		V-3	V-3	V-3		
67 x 1,6	V-3	V-3	V-3	V-3		
80 x 1,6	V-3	V-3	V-3*			

V-3= Vario tooth approx 15° positive *on request

AMACUT BiMetal M51 SV SG
AC 1202

Bi-metal band saw blades made of HSS M 51,
Material no: 1.3207

- Developed for high-alloy and tough solid materials up to 1700 N/mm² strength
- Precise ground tooth
- Extreme positive rake angle

Sizes mm	Teeth				
	0,75/1,25	1/1,3	1,4/2	2/3	3/4
27 x 0,9				V-3	V-3
34 x 1,1				V-3	V-3
41 x 1,3			V-3	V-3	V-3
54 x 1,6		V-3	V-3	V-3	V-3
67 x 1,6	V-3	V-3	V-3	V-3	
80 x 1,6	V-3	V-3	V-3*		

V-3= Vario tooth approx 15° positive *on request

AMACUT BiMetal M51 PS
AC 1220

Bi-metal band saw blades with tooth tips made of HSS M51,
Material no: 1.3207

- Universal application for solid materials and structurals.
- High profitability especially cutting with minimum quantity cooling lubrication.

Sizes mm	Teeth	
	2/3	3/4
34 x 1,1	V-7	V-7
41 x 1,3	V-7	V-7
54 x 1,6		V-7
67 x 1,6	V-7	V-7

V-1= Vario tooth 5° positive

AMACUT BiMetal M42 PS1
AC 1120

Bi-metal band saw blades made of HSS M42,
Material no: 1.3247

- For small and medium scissor arm machines
- For soft and medium hard steel up to 1400 N/mm² strength
- For small up to medium beams and profiles single and bundle cutting

Sizes mm	Teeth				
	2/3	3/4	4/6	5/7	8/11
20 x 0,9					V7
27 x 0,9		V7	V7	V7	V7
34 x 1,1	V7	V7	V7	V7	
41 x 1,3	V7	V7	V7		
54 x 1,3		V7	V7		
54 x 1,6	V7	V7	V7		
67 x 1,6	V7	V7			

V-7= Vario tooth 5° - 7° positive

AMACUT BiMetal M42 PS2
AC 1109

Bi-metal band saw blades made of HSS M42,
Material no: 1.3247

- For cutting medium and large structural steels, tubes and profiles with clamping
- Special set and tooth profile reduces tooth chipping
- Ideal for interrupted cutting

Sizes mm	Teeth	
	2/3	3/4
34 x 1,1		V-4
41 x 1,3	V-4	V-4
54 x 1,6	V-4	V-4
67 x 1,6	V-4	V-4

V-4= Vario tooth 5° positive with special setting

AMACUT BiMetal M42 ALU1 AC 1107

Bi-metal band saw blades made of HSS M42,

Material no: 1.3247

- Special design in combination with extreme sharp cutting edges
- Developed for cutting aluminium
- Standard tooth pitch

Sizes mm	Teeth		
	3	4	6
10 x 0,9		K-2	K-2
13 x 0,65		K-2	K-2
13 x 0,9	K-2	K-2	K-2
20 x 0,9	K-2		
27 x 0,9	K-2		

K-2= Claw tooth 10° positive

AMACUT BiMetal M42 ALU2 AC 1108

Bi-metal band saw blades made of HSS M42,

Material no: 1.3247

- Special design in combination with extreme sharp cutting edges
- Developed for cutting aluminium
- Variable tooth pitch

Sizes mm	Teeth	
	2/3	3/4
27 x 0,9	V-2	V-2
34 x 1,1	V-2	V-2

V-2 = Vario tooth 10° positive

AMACUT TRICARBIDE AC 1401

Carbide tipped band saw blades with triple chip geometry and tooth tips made of wear resistant carbide

- For difficult to cut and abrasive materials such as stainless steel, special alloys, titanium alloys, aluminum bronze and ampco

Sizes mm	Teeth					
	0,75/1,25	1/1,3	1,4/2	2/3	3/4	4/6
27 x 0,9				V	K	V
34 x 1,1				V		
41 x 1,3			V	V		
54 x 1,3			V	V		
54 x 1,6	V	V	V	V		
67 x 1,6	V	V	V	V		

V= Positive vario tooth K= Claw tooth positive

AMACUT ORICARBIDE AC 1403

Carbide tipped premium band saw blades with multi chip geometry fullfilling the highest requirement of tools

- Designed for high efficiency cutting in solid steel and non-ferrous alloys

Sizes mm	Teeth				
	0,75/1,25	1/1,5	1,4/2	2/3	3/4
27 x 0,9				V	V
34 x 1,1			V	V	V
41 x 1,3			V	V	V
54 x 1,3			V	V	
54 x 1,6	V	V	V	V	V
67 x 1,6	V	V	V	V	
80 x 1,6	V		V		

V= Positive vario tooth

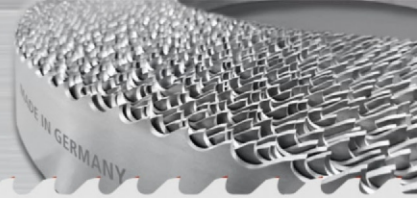
AMACUT ORISUPERCARBIDE AC 1404

Carbide tipped band saw blades with multi chip geometry and negative rake angle, tooth tips made of wear resistant carbide

- Perfect for cutting hardchrome piston rods and surface hardened materials

Sizes mm	Teeth		
	1,4/2	2/3	3/4
27 x 0,9		VN	VN
34 x 1,1		VN	VN
41 x 1,3	VN	VN	VN
54 x 1,6	VN	VN	VN

V-N= Negative vario tooth



AMACUT NEPCARBIDE AC 1408

Carbide tipped band saw blades with special chip geometry and tooth tips made of wear resistant carbide

- For difficult to cut and abrasive non ferrous materials such as copper alloys, aluminum alloys, graphite, sand cast aluminum and aluminum bronze

Sizes mm	Teeth				
	0,75/1,25	1,4/2	2/3	3	3/4
20 x 0,9				K	
27 x 0,9			V	K	V
34 x 1,1		V	V	K	V
41 x 1,3		V	V		V
54 x 1,3		V	V		
54 x 1,6	V	V	V		
67 x 1,6		V			
80 x 1,6	V				

V = Vario tooth positive K= Claw tooth positive

AMACUT HYDCARBIDE AC 1406

Carbide tipped band saw blades with setting with special chip geometry and tooth tips made of wear resistant carbide

- For difficult to cut and abrasive non-ferrous materials such as titanium alloys, stainless steel metals with high residual stress, graphite

Sizes mm	Teeth				
	0,75/1,25	1,4/2	2/3	3	3/4
20 x 0,9				V-S	V-S
27 x 0,9			V-S	V-S	V-S
34 x 1,1		V-S	V-S		V-S
41 x 1,3		V-S	V-S		
54 x 1,3		V-S	V-S		
54 x 1,6	V-S	V-S	V-S		
67 x 1,6	V-S	V-S	V-S		
80 x 1,6	V-S	V-S			

V-S = Vario tooth with special setting

AMACUT ZENCARBIDE AC 1409

The multi-chip geometry ensures optimal chip division in the sawing process. This leads to a long service life and prevents tooth breakages. Also coated available C-TEC for extremely increased feed rates, significantly reduced cutting times and maximized blade life.

- Standard steel
- Stainless steel
- Non-ferrous steel

Sizes mm	Teeth				
	0,75/1,25	1/1,5	1,4/2	2/3	3/4
27x0,90					K
34x1,10			K	K	K/C-TEC
41x1,30			K/C-TEC		K/C-TEC
54x1,30			K/C-TEC		
54x1,60	K/C-TEC	K/C-TEC	K/C-TEC		K/C-TEC
67x1,60	K/C-TEC	K/C-TEC	K/C-TEC		
80x1,60	K/C-TEC		K/C-TEC		

K= Variable tooth

AMACUT PROCARBIDE AC 1407

Carbide tipped band saw blade with set tooth. The expert in castings especially for sawing jobs in non-ferrous foundries.

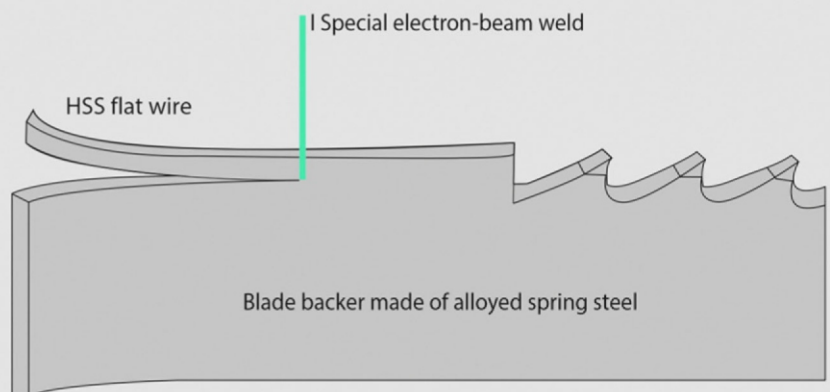
- Castings made out of aluminium and bronze

Sizes mm	Teeth	
		3
13x0,90		H
20x0,90		H
27x0,90		H

H= Hook tooth

WHAT IS BI-METAL?

The main components of bi-metal band saw blades are two materials that have been permanently bonded. First there is a highly flexible backing material for the band saw blades. This special chromium and molybdenum alloy is hardened in a permanently monitored process to a hardness of 50 HRC. The second material in the bi-metal band saw is a HSS strip in two different qualities- M42(1.3207) or M51 (1.3207) Both of these components the high-quality backing material and the optimally hardened HSS strip are inseparably bonded using an electron-beam welding technique.

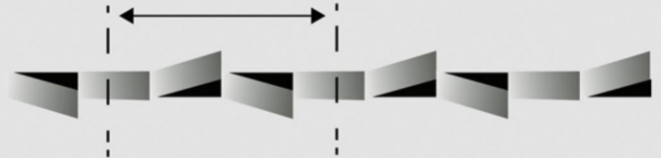
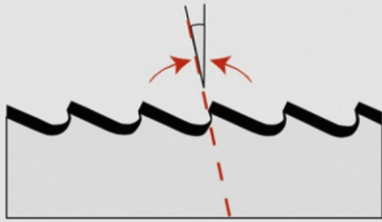


Tooth Shapes

In order to ensure maximum cutting performance and set life, as well as number of tooth and qualified saw selection, shape of the tooth is significantly important. Very well cutting value is obtained in the provided that geometry of the saw tooth is fit to the material to be cut.

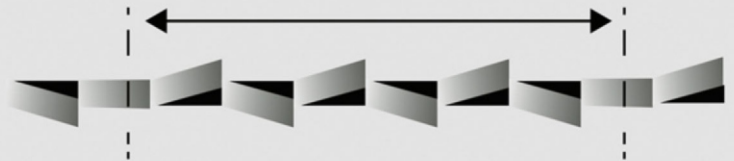
Standard Tooth

It has two types; with 0° angle (S) and positive angle (K). Tooth with 0° angle (S) is used in cutting of filled material in small and middle section, pipes and slabs on general applications. Tooth with positive angle (K) is used in cutting of non-ferrous metals with steels containing low carbon and leaving long chips.



Variable Tooth

In this tooth shape, teeth are aligned as different number of tooth in groups. Thanks to variable tooth shape, vibration and noise are diminished during cutting quality of surface cut and set life are increased. It is used in cutting of many different filled materials.



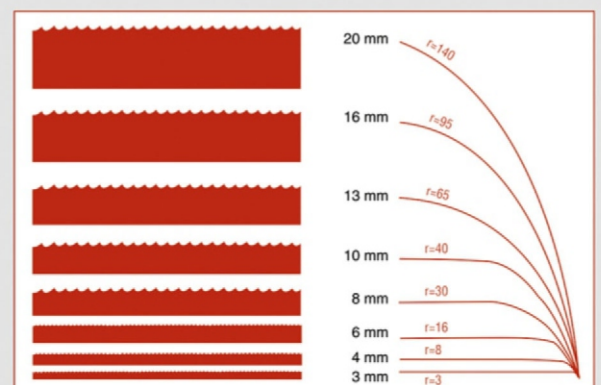
Recommendation Related to Number and Shape of Tooth

The correct choice is very important in order to obtain desired result in cutting process and reach values of optimum cost and set life.

- If the number of tooth is smaller than required tooth, an unstable cutting is formed. The chip is stuck through cutting line. Life of the set is decreasing due to the excess friction.
- If the number of tooth is greater than required number, because cutting pressure corresponding to tooth would increase, teeth are cracked and broken, life of the set is decreasing.
- To determine the optimum number of teeth, like you can use the following tables prepared in experienced knowledge, you can determine the number of teeth in the condition of ensuring at least 3 teeth on contact during cutting.

Selection of Saw Wideness in Decoupage Cutting

Band wideness to be selected is given sideways as per minimum radius to be formed in the cutting material at the decoupage cutting.



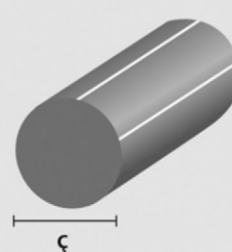
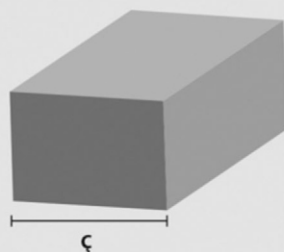
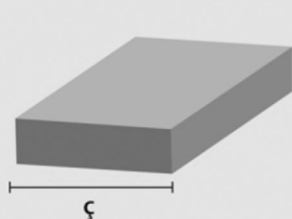
BAND SAW BLADES WITH SPECIAL COATING

CARBIDE TIPPED	Dimensions mm	Toothing				
		0,75/1,25	1/1,5	1,4/2	2/3	3/4
AC 2403 ORION NANO Multi chip geometry with TIALN-Coating	41 x 1,30			V	V	V
	54 x 1,30			V	V	
	54 x 1,60		V	V	V	V
	67 x 1,60		V	V	V	
	80 x 1,60	V		V		
V= Vario tooth positive						
AC 2406 HYDRA NANO Special geometry with setting. with TIALN-Coating	41 X 1,30			V-S	V-S	
	54 X 1,30			V-S	V-S	
	54 X 1,60			V-S	V-S	
	67 X 1,60			V-S		
	80 X 1,60			V-S		
V-S = Vario tooth positive with setting						

BI-METAL	Dimensions mm	Toothing					
		0,75/1,25	1/1,3	1/4,2	2/3	3/4	4/6
AC 2109-M42 NANO	41 x 1,30				V-4	V-4	
	54 x 1,60				V-4	V-4	
	67 x 1,60				V-4	V-4	
V-4 = Vario tooth 7° positive with special setting							
AC 2120-M42 NANO	41 x 1,30				V-7	V-7	
	54 x 1,60				V-7	V-7	V-7
	67 x 1,60				V-7	V-7	
V-7 = aggressive Vario tooth 7° positive							
AC 2104-M42 NANO	41 x 1,30			V-2	V-2		
	54 x 1,30			V-2	V-2		
	54 x 1,60			V-2	V-2		
	67 x 1,60			V-2	V-2		
	80 x 1,60	V-2		V-2			
V-2 = Vario tooth 10° positive							
AC 2110-M42 NANO Special ground teeth	41 x 1,30			V-2	V-2	V-2	
	54 x 1,30			V-2	V-2		
	54 x 1,60			V-2	V-2	V-2	
	67 x 1,60			V-2	V-2		
	80 x 1,60			V-2			
V-2 = Vario tooth 10° positive							
AC 2111-M42 NANO Special ground teeth	41 x 1,30				V-3		
	54 x 1,30				V-3		
	54 x 1,60		V-3		V-3		
	67 x 1,60		V-3				
V-3 = Vario tooth 15° positive							
AC 2202-M51 NANO Special ground teeth	41 x 1,30			V-3	V-3		
	54 x 1,60		V-3	V-3	V-3		
	67 x 1,60	V-3	V-3	V-3	V-3		
	80 x 1,60	V-3	V-3				
V-3 = Vario tooth 15° positive							

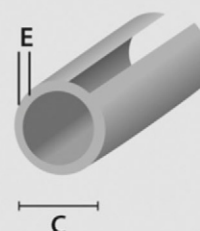
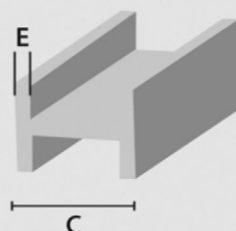
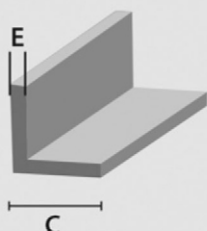
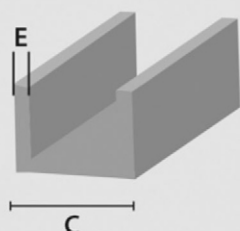
Cutting of filled materials

Standard Tooth		Vario tooth	
Diameter (mm)	Number of teeth and type	Diameter (mm)	Number of teeth and type
<12	14 S	<25	10 / 14 V
12 - 30	10 S	20 - 40	8 / 12 V
30 - 50	8 S	25 - 70	6 / 10 V
50 - 80	6 S	35 - 90	5 / 8 V
80 - 100	4K	50 - 100	4 / 6 SV
110 - 200	3K	80 - 150	3 / 4 SV
200 - 350	2K	120 - 350	2 / 3 SV
300 - 700	1.25K	120 - 350	1.33 / 2 SV
>700	0.75K	>500	0.75 / 1.25 SV

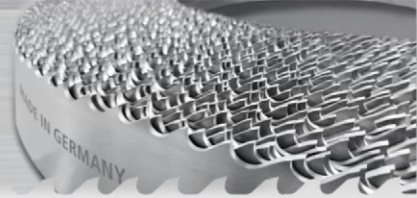


Pipe material cutting

Thickness (mm)	Diameter (mm)											
	20	40	60	80	100	120	150	200	300	500	750	1000
2	32	24	18	18	14	14	10/14	10/14	8/12	6/10	5/8	5/8
3	24	18	14	14	10/14	10/14	8/12	8/12	6/10	5/8	4/6	4/6
4	18	10/14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	4/6 0°	4/6	4/6
5	18	10/14	10/14	10/14	6/10	6/10	6/10	5/8	4/6 °	4/6 0°	4/6	4/6
6	14	8/12	8/12	8/12	6/10	6/10	5/8	5/8	4/6 °	4/6 0°	3/4	3/4
8		6/10	6/10	8/12	5/8	5/8	5/8	4/6 0°	4/6 °	3/4 0°	3/4	3/4
10		6/10	6/10	6/10	5/8	5/8	4/6 0°	4/6 0°	4/6 °	3/4 0°	3/4	3/4
12		5/8	5/8	5/8	4/6+	4/6+	4/6+	4/6+	3/4+	3/4 +	2/3	2/3
15			5/8	4/6+	4/6+	4/6+	3/4+	3/4+	3/4+	2/3	2/3	2/3
20			4/6+	4/6+	4/6+	4/6+	3/4+	3/4+	2/3+	2/3	2/3	2/3
30				3/4+	3/4+	3/4+	2/3+	2/3+	2/3+	2/3	1.33/2	1.33/2
50						3/4+	2/3+	2/3+	2/3+	1.33/2	1.33/2	1.33/2
75							2/3+	2/3+	1.33/2	1.33/2	1.33/2	1.33/2
100									1.33/2	0.75/1.25	0.75/1.25	0.75/1.25
150										0.75/1.25	0.75/1.25	0.75/1.25
200										0.75/1.25	0.75/1.25	0.75/1.25



Get 2 thickness in more than one section



LINE SECTION FOR FILLED MATERIALS

MATERIAL SECTION		STEEL 50 kg mm ²	STEEL 50-80 kg mm ²	STEEL 80-100 kg mm ²	STAINLESS STEEL	COPPER AND ALUMINIUM	BRONZE	BRASS AND ZINC ALLOYS
	10 - 15 mm	43		2.52	.5	65		5
	15 - 20 mm	5433				65		5
	20 - 35 mm	8644				88		8
	35 - 55 mm	10	86		61	21	01	0
	55 - 80 mm	12	10	88		14	12	12
	80 - 105 mm	14	14	12	12	16	14	16
	105 - 125 mm	16	16	14	14	18	16	18
	125 - 145 mm	16	16	14	14	20	18	18

LINE SECTION FOR PIPE AND PROFILE

PIPE AND PROFILE									
	Pipe and Profile	10 - 25	20 - 35	35 - 55	55 - 80	80 - 105	105 - 125	125 - 145	145 - 145
D= Wall thickness Diameter	Distance between 2 teeth								
	D=01	3 mm	5 mm	6 mm	8 mm	8 mm	10 mm	12 mm	14 mm
	D=0.05	5 mm	4 mm	5 mm	6 mm	6 mm	8 mm	10 mm	12 mm
	D=0.25	2 mm	3 mm	4 mm	5 mm	5 mm	6 mm	8 mm	10 mm

The number of teeth that correspond to the lines according to the saw diameter

○ profiles	● solid	Φ 175	Φ 200	Φ 210	Φ 225	Φ 250	Φ 275	Φ 300	Φ 315	Φ 325	Φ 350	Φ 370	Φ 400	Φ 425	Φ 450	Φ 500	Φ 525	Φ 550	Φ 570	Φ 600																						
																					○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●		
0.5	3	10	5	180	110	200	130	210	130	220	140	250	160	280	160	300	180	300	200	320	200	350	220	220	250	260	280	310	330	340	360	330										
1.0	4	20	6	140	90	160	100	160	110	180	120	200	128	220	140	220	160	240	160	250	170	280	180	280	190	310	200	320	220	350	230	260	410	270	440	280	450	300	480	320		
2.0	5	30	8	110	70	130	80	130	80	140	90	160	100	180	110	180	120	200	120	200	128	220	140	220	140	250	160	260	160	280	180	310	200	330	210	340	220	360	220	380	240	
3.0	5	50	8							140	90	160	100	180	110	180	120	200	120	200	128	220	140	220	140	250	160	260	160	280	180	310	200	330	210	340	220	360	220	380	240	
3.5	6	70	10							140	90	160	94	160	100	170	100	180	110	190	110	200	120	220	130	230	140	260	160	270	184	280	170	300	180	320	190	190				
5.0	8	90	12							120	80	120	80	128	80	140	90	140	90	160	110	160	110	180	120	200	130	210	140	220	140	220	150	240	160	160	160					
6.5	10	110	14											110	80	120	90	130	90	140	100	160	110	164	110	180	120	200	130	210	140	220	140	220	150	240	160	190	130			
7.5	10	130	14											120	90	130	90	140	100	160	110	164	110	170	120	180	120	190	130	190	130	130	130	130	130	130	130	130	130			
8.5	12	150	16																	120	90	130	100	140	104	140	110	150	110	160	120	120	120	120	120	120	120	120	120			
9.5	12	160	18																																							
11.0	14	180	18																																							
12.0	14	200	20																																							
13.0	14	200	20																																							

RECOMMENDED CUTTING SPEED VALUES

Group of material	DIN No	Material No	Bi Metal	Amacut Redline & Amacut Blackline	Coolant (Boron oil)	Cutting oil (Pure oil)
			Speed of cutting (m/minute)			
Structural steels	S 235 JR (ST37-2)	1.0037	60 - 80	80 - 105	01:10	var
	S 235 JR (ST44-2)	1.0044	60 - 80	80 - 105	01:10	var
	E 295 (ST 50-2)	1.0050	50 - 70	65 - 90	01:20	var
	E 360 (ST 70-2)	1.0070	50 - 70	65 - 90	01:20	var
	C 10 - C 15	1.0301 - 0401	60 - 90	78 - 120	01:10	var
	14NiCr14	1.5752	40 - 50	78 - 120	01:10	var
	21NiCrMo2	1.6523	45 - 55	60 - 70	01:10	var
	20CrMo5	1.7246	55 - 60	70 - 78	01:10	var
	16MnCr5	1.7131	50 - 65	65 - 85	01:10	var
Free-Cutting steels	9S20	1.0711	70 - 120	91 - 156	01:10	var
Nitration steels	34CrAl6	1.8504	20 - 35	26 - 45	01:20	yok
	34CrAlNi7	1.8550	20 - 35	26 - 45	01:20	yok
Tempered steels	C 35 - C 45	1.0501 - 0503	55 - 75	70 - 100	01:20	yok
	41Cr4	1.7035	40 - 60	52 - 78	01:20	yok
	40Mn4	1.5038	50 - 65	65 - 85	01:20	yok
	42CrMo4	1.7225	35 - 50	45 - 65	01:20	yok
	36NiCr6	1.5710	50 - 60	65 - 78	01:20	yok
	24NiCr14	1.5754	40 - 60	52 - 78	01:20	yok
	34CrNiMo6	1.6582	35 - 50	45 - 65	01:20	yok
Bearing steels	100Cr6	1.3505	50 - 65	65 - 85	01:30	yok
	105Cr4	1.3503	50 - 65	65 - 85	01:30	yok
	100CrMn6	1.3520	40 - 50	52 - 65	01:30	yok
	100CrMo6	1.3536	25 - 35	33 - 45	01:30	yok
Spring steels	65Si7	1.0906	40 - 60	52 - 78	01:30	yok
	50CrV4	1.8159	40 - 60	52 - 78	01:30	yok
Non-alloyed carbon steel	C80W1	1.1525	40 - 55	52 - 72	01:30	yok
	C125W1	1.1560	35 - 45	46 - 60	01:30	yok
	C105W2	1.1645	40 - 50	52 - 65	01:30	yok
Alloyed carbon steels	105Cr5	1.2060	50 - 60	65 - 78	01:30	yok
	X210Cr12	1.2080	25 - 35	26 - 46	-	yok
	X40CrMoV51	1.2344	30 - 40	39 - 52	01:30	yok
	X210Cr12	1.2436	20 - 30	26 - 39	-	yok
	X160CrMoV12	1.2601	20 - 35	26 - 46	01:30	yok
	56NiCrMoV	1.2714	20 - 40	26 - 52	01:30	yok
	100CrMo5	1.2303	35 - 45	46 - 60	01:30	yok
	X32CrMoV33	1.2365	30 - 45	39 - 60	01:30	yok
	X155CrMoV121	1.2379	30 - 35	39 - 45	01:30	yok
	90MnCrV8	1.2842	35 - 45	46 - 60	01:30	yok
	40CrMnMo4	1.2311	20 - 30	26 - 39	01:30	yok
	40CrMnNiMo8-6-4v	1.2738	20 - 30	26 - 39	01:30	yok

RECOMMENDED CUTTING SPEED VALUES

Group of material	DIN No	Material No	Bi Metal	Amacut Redline & Amacut Blackline	Collant (Boron oil)	Cutting oil (Pure oil)
			Speed of cutting (m/minute)			
HSS (high speed steel)	S 6-5-2	1.3343	25 - 40	33 - 52	01:30	yok
	S 6-5-2-5	1.3243	25 - 40	33 - 52	01:30	yok
	S 18-0-1	1.3355	25 - 40	33 - 52	01:30	yok
	S 18-1-2-10	1.3265	25 - 40	33 - 52	01:30	yok
	S 3-3-2	1.3333	40 - 50	52 - 65	01:30	yok
	S 2-10-1-8	1.3247	30 - 40	39 - 52	01:30	yok
	S 10-4-3-10	1.3207	30 - 40	39 - 52	01:30	yok
Valve steels	X45CrSi 9 3	1.4718	30 - 40	39 - 52	01:20	var
	X45CrNiW18 9	1.4873	30 - 40	39 - 52	01:20	var
High speed steels	CrNi2520	1.4843	25 - 40	33 - 52	01:10	var
	X20CrMoV12 1	1.4922	25 - 40	33 - 52	01:10	var
	X5NiCrTi2615	1.4980	25 - 40	33 - 52	01:10	var
	X12CrCoNi21 20	1.4971	20 - 30	26 - 39	01:10	var
	X20CrMoVW12 1	1.4935	30 - 35	39 - 46	01:10	var
Heat-resisting steels	X10CrA17	1.4713	20 - 30	26 - 39	01:10	var
	X15CrNiSi2520	1.4841	20 - 30	26 - 39	01:10	var
	X10CrSi6	1.4712	20 - 30	26 - 39	01:10	var
	X12NiCrSi3616	1.4864	15 - 25	20 - 33	01:10	var
Stainless steels	X5CrNi189	1.4301	25 - 35	33 - 45	01:10	var
	X10CrNiMoTi18 10	1.4571	25 - 35	33 - 45	01:10	var
	10	1.4006	25 - 35	33 - 45	01:10	var
	X10Cr13	1.4401	25 - 35	33 - 45	01:10	var
	X5CrNiMo1810	1.4021	25 - 35	33 - 45	01:10	var
	X20Cr13	-	-	-	-	var
Tempered steels (aspertension value)	1000 - 1200Nm 2	-	25 - 35	33 - 46	01:10	var
	1200 - 1400Nm 2	-	25 - 30	33 - 39	01:10	var
	1400 - 1600Nm 2	-	25 - 25	26 - 33	01:10	var
Steal casting	GS 38	-	50 - 60	26 - 33	01:50	yok
	GS 60	-	50 - 60	65 - 78	01:50	yok
Cast irons	GG 15	-	40 - 50	52 - 65	-	yok
	GG 30	-	40 - 50	52 - 65	-	yok
	GTW 40	-	40 - 50	52 - 65	-	yok
	GTS 65	-	40 - 50	52 - 65	-	yok
	GGG 50	-	40 - 50	52 - 65	-	yok
	-	-	-	-	-	-
Nickel-based alloys	NiCr20TiAl	2.4631	15 - 20	20 - 33	01:10	var
	NiCr22FeMo	2.4972	15 - 25	20 - 33	01:10	var
Heat-resisting Nickel alloys	Hastalloy C4	2.4611	-	20 - 30	01:10	var
	NiCr15Fe	2.4640	15 - 25	20 - 33	01:10	var
	Monel 400	2.4360	20 - 25	20 - 33	01:10	var
	Waspaloy	2.4645	15 - 20	20 - 26	01:10	var
Aluminum alloys	Al 99.5	3.0255	100 - 700	130 - 910	01:10	yok
	Al Mg 3	3.3535	100 - 700	130 - 910	01:10	yok
	AlMg3, 5Mn	3.3547	150 - 800	195 - 1040	01:10	yok
Bronze titanium alloys	CuSn6	2.1020	70 - 100	91 - 130	01:50	yok
	GCuSn10	2.1050	70 - 100	91-130	01:50	yok
Aluminum bronze alloys	Cu Ai8	2.0920	50 - 70	65 - 91	01:30	yok
	CuAl8Fe38	2.0920.60	40 - 50	52 - 65	01:20	var
Red	G-CuSn10Zn	2.1086.01	70 - 100	91-130	01:50	yok
	G-CuSn5ZnPb	2.1096.01	70 - 100	91-130	01:50	yok
Brass	CuZn10	2.0230	80 - 300	104 - 390	01:50	yok
	CuZn31Si	2.0490	80 - 300	104 - 390	01:50	yok



A series of 28 horizontal lines for writing, spaced evenly down the page.



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