



# SAW BLADES

## PRODUCT OVERVIEW

Bimetal & Carbide Tipped Band Saw Blades



# A HISTORY OF CUTTING-EDGE MANUFACTURING

Since we began building machine tools many decades ago, our goals have always been to provide our customers with increased accuracy and productivity. Throughout our history, we've maintained our time-honored tradition of hand-fitting our solutions to deliver the ultimate in quality and precision.

As technology has evolved, we've embraced CNC automation as a core strength, improving throughput and helping new operators become productive more quickly. Today, combining the legacies of AMADA Cutting Technologies and our Grinding Business unit, we are uniquely positioned to help you expand your capabilities and grow your business maintaining our philosophy of **"GROWING WITH OUR CUSTOMERS"**.



1956  
■ AM C 225



1962  
■ Carbon Steel Saw Blades

1965  
■ RH 300

1968  
■ Bimetal Saw Blades

1971  
■ Carbide Saw Blades

1990  
■ CTB 400  
First Fully Automatic Carbide CNC Machine  
■ SIGMA Bimetal Saw Blade

2005  
■ Double-Pulse-Cutting Automated Band Saw  
■ Carbide Saw Blades  
- AXCELA G  
- AXCELA H  
■ SMART CUT BAND Thiner Bimetal Saw Blades

2012  
■ 2nd-Generation PCSAW  
■ Carbide Saw Blades  
- AXCELA S  
- AXCELA B

2013  
■ Carbide Saw Blades  
- AXCELA ALB  
- AXCELA HMAX  
- AXCELA A

2014  
■ DYNASAW 530  
■ Bimetal Saw Blade  
- DYNABAND G  
- SUPER 8

2016  
■ Bimetal Saw Blades  
- New Protector M42 Design  
■ Carbide Saw Blades  
- SMART CUT AXCELA S  
- SMART CUT AXCELA B  
- SMART CUT AXCELA G

2017  
■ HPSAW 310  
■ Carbide Saw Blades  
- AXCELA HP/HP1  
- AXCELA C-S7

2019  
■ Carbide Saw Blades  
- AXCELA STRIKER  
- AXCELA BOOSTER  
■ DBSAW 500 Diamond Saw  
■ VT 3850 / VT 4555 Mitre-Box Saws



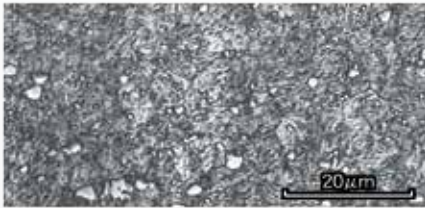
# BLADE INFORMATION

## Edge material



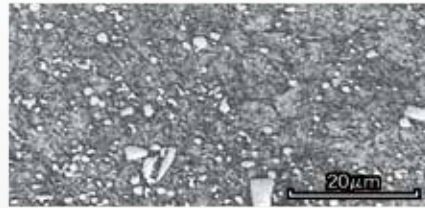
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AMADA Modified M42 HSS



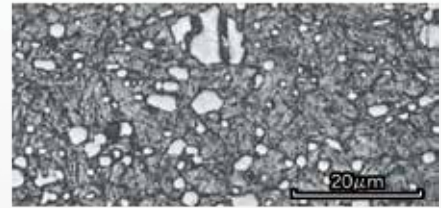
AMADA's original matrix high-speed steel, produced based on M42 cobalt high-speed steel. With toughness greatly improved, this steel exhibits its greatest performance under cutting conditions involving vibration and shock.

M42 Cobalt HSS



M42 cobalt high-speed steel that provides superior wear resistance. Being treated with AMADA's unique heat treatment technology, this steel exhibits a performance that is highest in the class. It is broadly suitable for cutting general steel through difficult to cut materials.

AMADA M71 Original HSS



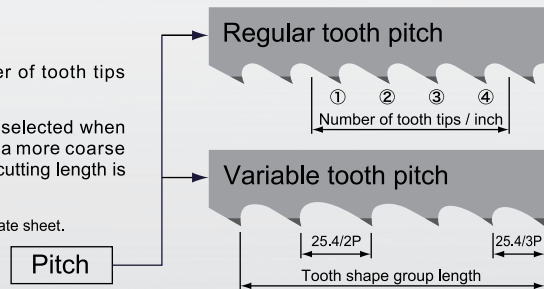
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## Selection

### Pitch

- Pitch is expressed by the number of tooth tips within one inch (25.4mm).
- Generally, a finer pitch should be selected when the cutting length is shorter and a more coarse pitch should be selected when the cutting length is longer.

\*See "Blade pitch selection guide" on separate sheet.



Tooth tips are located at equal intervals. The regular tooth pitch is expressed as "00P(00=number of teeth/inch)". The example shown on the left is 4P, and the tooth tip interval in this case is  $25.4 \div 4P = 6.35\text{mm}$ .

Multiple different pitches are combined within one inch. The variable tooth pitch is expressed by two figures such as "2/3P" in the example shown on the left. It means that the maximum tooth tip interval is equivalent to 2P in a tooth shape group (minimum unit of repetition) and that the minimum tooth interval is equivalent to 3P.

Use of this pitch can suppress vibration, and is applicable to cutting in wide range.

### Blade pitch selection table by materials to be cut

Material to be cut		Maximum cutting length										
		50	100	150	200	250	300	400	500	700	1000 (mm)	
		2"	4"	6"	8"	10"	12"	16"	20"	28"	40" (Inch)	
HSS Bi-Metal Blades	Roll-formed section steels	6/10P		5/7P & 4/6P								
	Structural steel, Bundled tubes											
	Solid material	Bundled small Diameter material, Mild steel			3/4P			2/3P		1.5/2P		
		Tool steel, Prehardened steel										
		Hot work die steel, Stainless steel										
	Super heat resisting alloy								1.1/1.5P		0.75/1P	
Carbide Tipped Blades	Solid material		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P	

Note1 : It is recommended for optimum cutting to select a pitch to allow for 20 to 30 teeth to correspond to the cutting length.

Note2 : When cutting deformed material or like that varies in the cutting length suddenly, it is desirable that at least 2 teeth are in contact with the material constantly while cutting.

Note3 : The above table based on "SGLB" should be used as guide. Specific applicability varies somewhat depending on the characteristics of the blades.

For example, 3/4P of "PROTECTOR" is capable of cutting materials in the range including 4/6P in the above table.

# TOTAL SOLUTION

- **A Total Manufacturer of Band Saws and Blades**

AMADA has a full line of Band Saws and Blades to provide the maximum possible sawing performance.

We are engaged not only in development and manufacturing, but also in marketing and after-sales service. Our customers' opinions are fed back directly to our development and manufacturing teams to meet their specific sawing needs.

- **Band Saw Blade History and R&D**

We started manufacturing and marketing Contour Saws in 1955 and commercialized Bi-metal Blades in 1968. We then innovated technologies in all areas of blade materials, shapes, and coatings and developed the high-performance Carbide-Tipped Band Saw Blade series AXCELA in 2007.

The sawing know-how and latest sawing technologies accumulated over many years, allowing us to develop products that meet our customers needs.

Manufacturing



AMADA LIANYUNGANG  
MACHINE TOOL CO.,LTD. (China)



AMADA AUSTRIA GmbH  
(Austria)



ONO WORKS (Ono-Japan)



Development

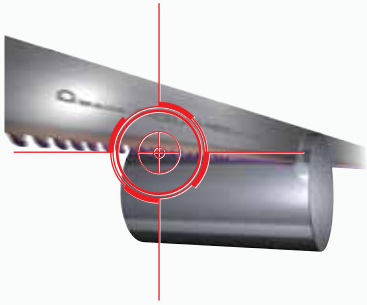


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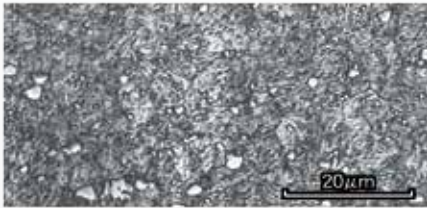
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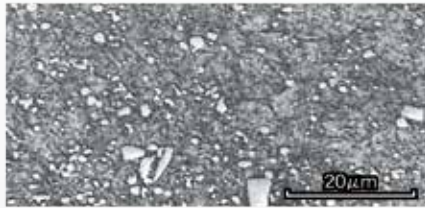
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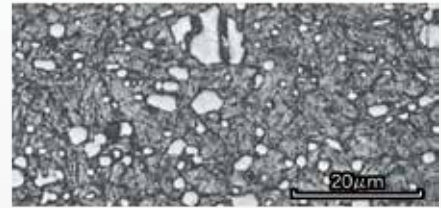
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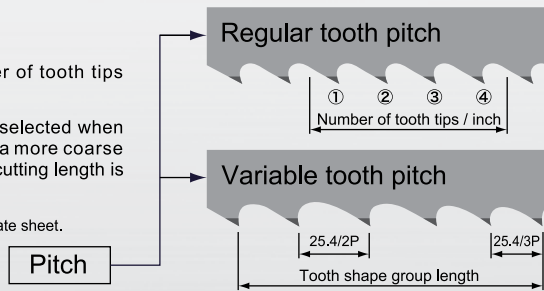
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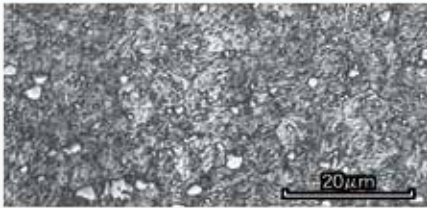
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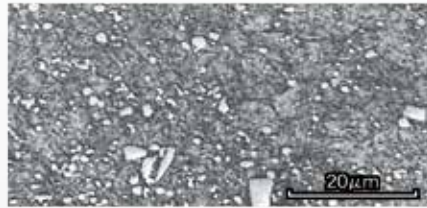
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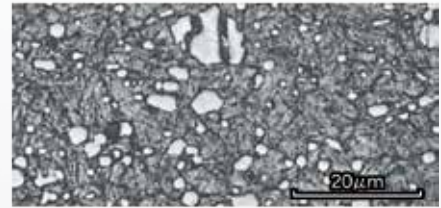
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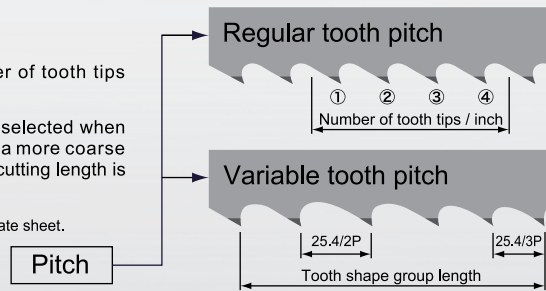
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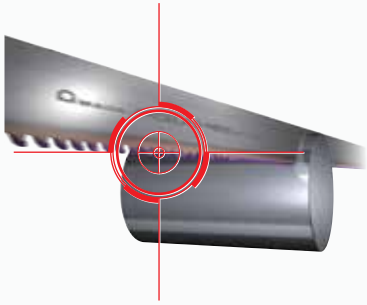
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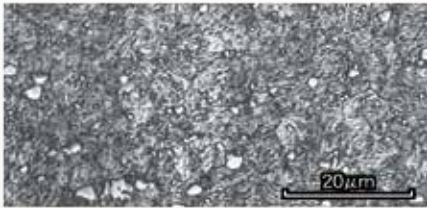
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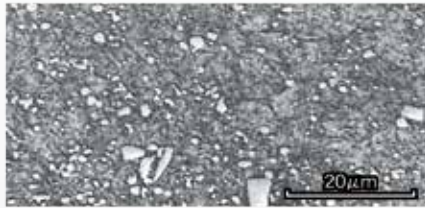
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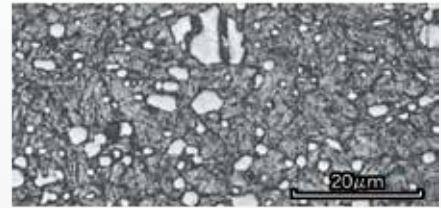
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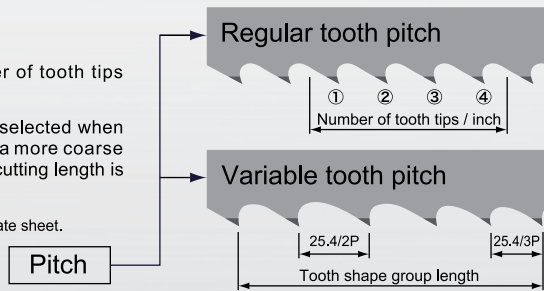
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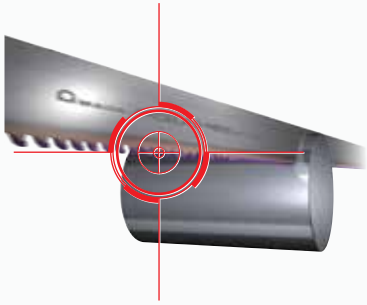
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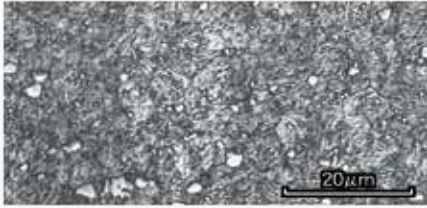
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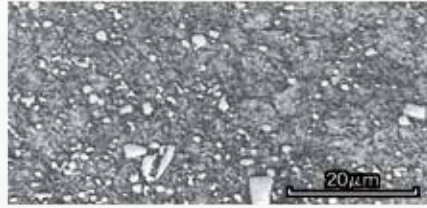
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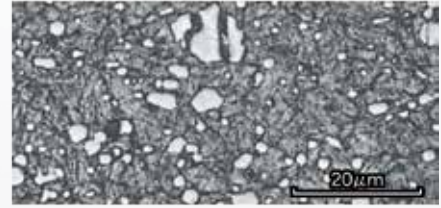
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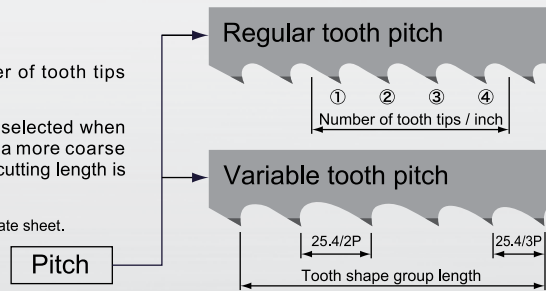
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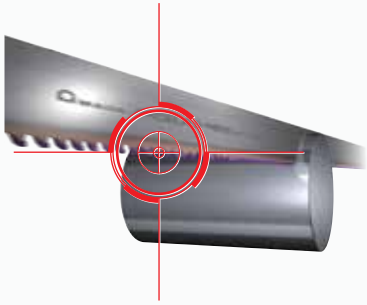
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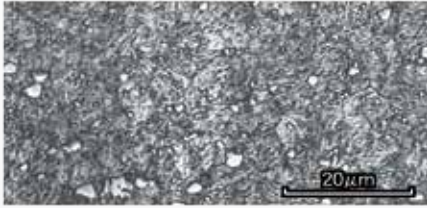
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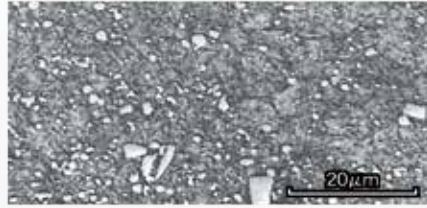
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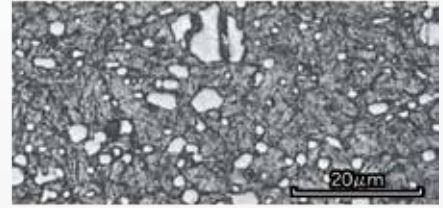
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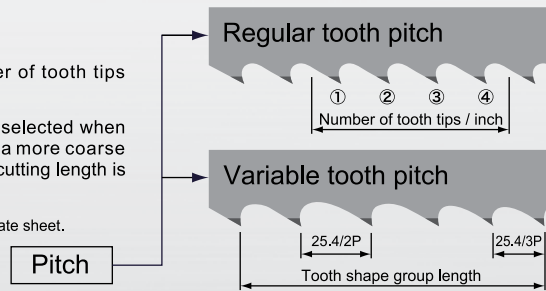
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Multiple different pitches are combined within one inch. The variable tooth pitch is expressed by two figures such as "2/3P" in the example shown on the left. It means that the maximum tooth tip interval is equivalent to 2P in a tooth shape group (minimum unit of repetition) and that the minimum tooth interval is equivalent to 3P.

Use of this pitch can suppress vibration, and is applicable to cutting in wide range.

### Blade pitch selection table by materials to be cut

		Material to be cut		Maximum cutting length										
				50	100	150	200	250	300	400	500	700	1000 (mm)	
			2"	4"	6"	8"	10"	12"	16"	20"	28"	40"	(Inch)	
HSS Bi-Metal Blades	Roll-formed section steels		6/10P		5/7P & 4/6P									
	Structural steel, Bundled tubes													
	Solid material	Bundled small Diameter material, Mild steel			3/4P				2/3P		1.5/2P			
		Tool steel, Prehardened steel												
		Hot work die steel, Stainless steel												
Super heat resisting alloy										1.1/1.5P		0.75/1P		
Carbide Tipped Blades	Solid material	Mild steel, Tool steel Prehardened steel Hot work die steel, Stainless steel Super heat resisting alloy		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P		

Note1 : It is recommended for optimum cutting to select a pitch to allow for 20 to 30 teeth to correspond to the cutting length.

Note2 : When cutting deformed material or like that varies in the cutting length suddenly, it is desirable that at least 2 teeth are in contact with the material constantly while cutting.

Note3 : The above table based on "SGLB" should be used as guide. Specific applicability varies somewhat depending on the characteristics of the blades.

For example, 3/4P of "PROTECTOR" is capable of cutting materials in the range including 4/6P in the above table.

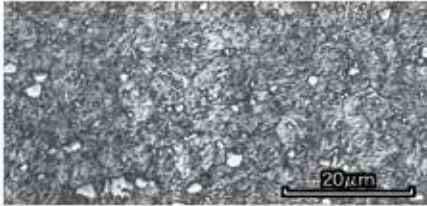
# BLADE INFORMATION

## Edge material



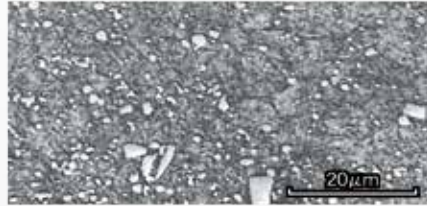
It is not necessarily true that the harder the edge, the longer the service life and the higher the efficiency. In case of cutting that involves high vibration and a large shock, edge material of high toughness are more advantageous because drop-off wear occurs before friction wear.

AMADA Modified M42 HSS



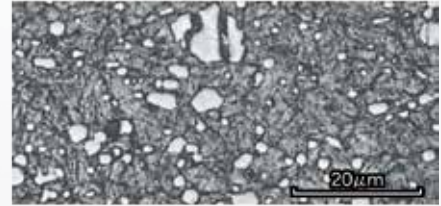
AMADA's original matrix high-speed steel, produced based on M42 cobalt high-speed steel. With toughness greatly improved, this steel exhibits its greatest performance under cutting conditions involving vibration and shock.

M42 Cobalt HSS



M42 cobalt high-speed steel that provides superior wear resistance. Being treated with AMADA's unique heat treatment technology, this steel exhibits a performance that is highest in the class. It is broadly suitable for cutting general steel through difficult to cut materials.

AMADA M71 Original HSS



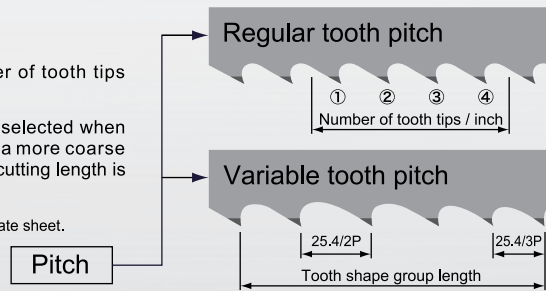
Original highest grade, high-speed steel, developed jointly with a leading steel manufacturer. This steel has hardness of 1000Hv, which is the highest ever recorded in ingot high-speed steel. It is suitable for cutting difficult to cut materials.

## Selection

### Pitch

- Pitch is expressed by the number of tooth tips within one inch (25.4mm).
- Generally, a finer pitch should be selected when the cutting length is shorter and a more coarse pitch should be selected when the cutting length is longer.

\*See "Blade pitch selection guide" on separate sheet.



Tooth tips are located at equal intervals. The regular tooth pitch is expressed as "00P(00=number of teeth/inch)". The example shown on the left is 4P, and the tooth tip interval in this case is  $25.4 \div 4P = 6.35\text{mm}$ .

Multiple different pitches are combined within one inch. The variable tooth pitch is expressed by two figures such as "2/3P" in the example shown on the left. It means that the maximum tooth tip interval is equivalent to 2P in a tooth shape group (minimum unit of repetition) and that the minimum tooth interval is equivalent to 3P.

Use of this pitch can suppress vibration, and is applicable to cutting in wide range.

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Material to be cut		Maximum cutting length										
		50	100	150	200	250	300	400	500	700	1000 (mm)	
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HSS Bi-Metal Blades	Roll-formed section steels	6/10P		5/7P & 4/6P								
	Structural steel, Bundled tubes											
	Solid material	Bundled small Diameter material, Mild steel			3/4P			2/3P		1.5/2P		
		Tool steel, Prehardened steel										
		Hot work die steel, Stainless steel										
	Super heat resisting alloy								1.1/1.5P		0.75/1P	
Carbide Tipped Blades	Solid material		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P	

Note1 : It is recommended for optimum cutting to select a pitch to allow for 20 to 30 teeth to correspond to the cutting length.

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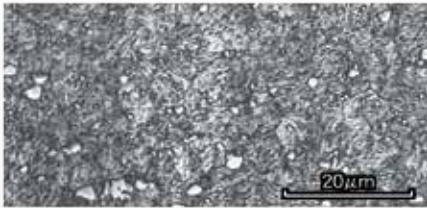
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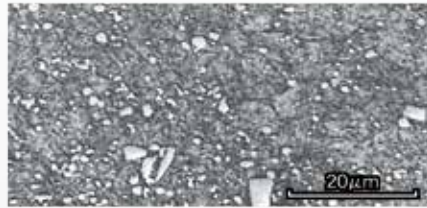
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**AMADA Modified M42 HSS**



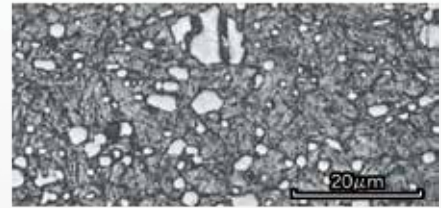
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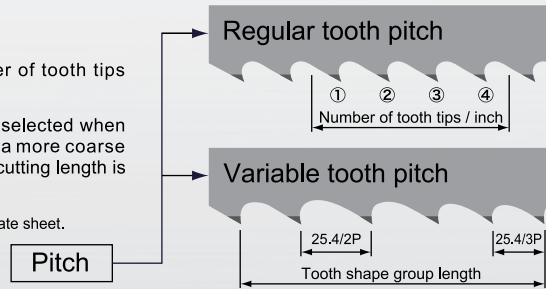
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HSS Bi-Metal Blades	Roll-formed section steels	6/10P		5/7P & 4/6P								
	Structural steel, Bundled tubes											
	Solid material	Bundled small Diameter material, Mild steel			3/4P			2/3P		1.5/2P		
		Tool steel, Prehardened steel										
		Hot work die steel, Stainless steel										
	Super heat resisting alloy								1.1/1.5P		0.75/1P	
Carbide Tipped Blades	Solid material		3/4P		2/3P	1.8/2P	1.4/1.6P				0.9/1.1P	

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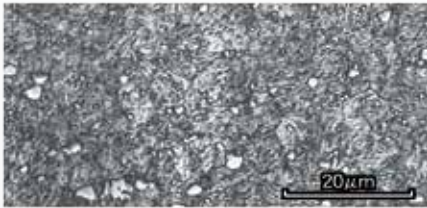
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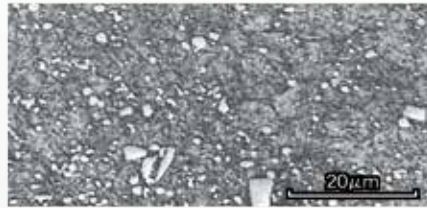
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AMADA Modified M42 HSS



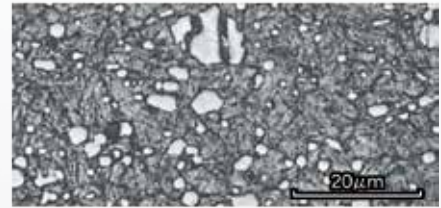
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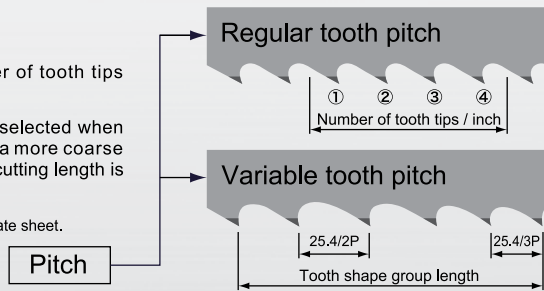
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	Structural steel, Bundled tubes											
	Solid material	Bundled small Diameter material, Mild steel			3/4P			2/3P		1.5/2P		
		Tool steel, Prehardened steel										
		Hot work die steel, Stainless steel										
	Super heat resisting alloy								1.1/1.5P		0.75/1P	
Carbide Tipped Blades	Solid material		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P	

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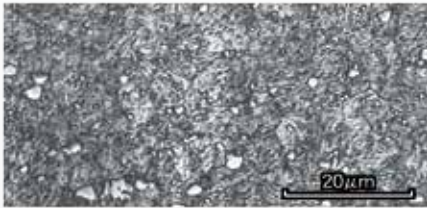
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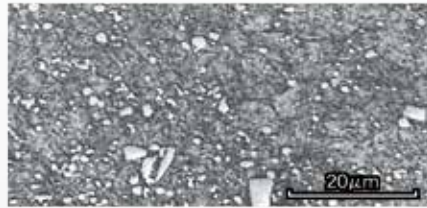
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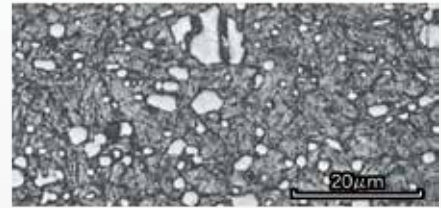
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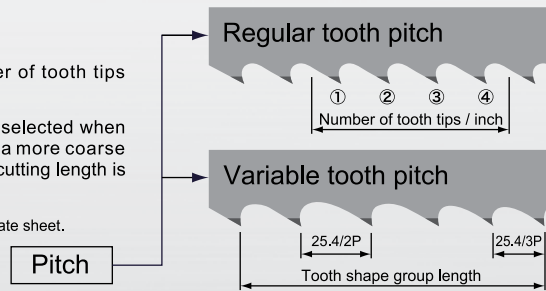
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	Structural steel, Bundled tubes												
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Carbide Tipped Blades	Solid material		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P		

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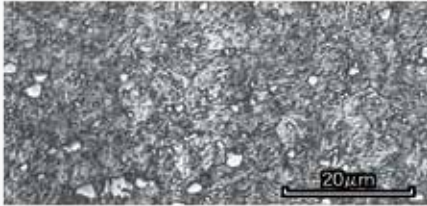
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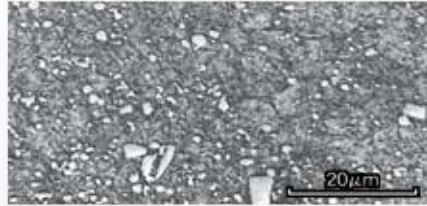
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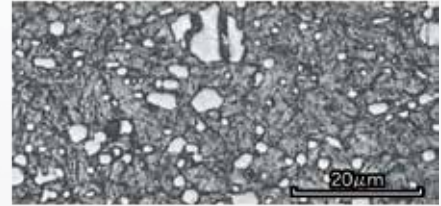
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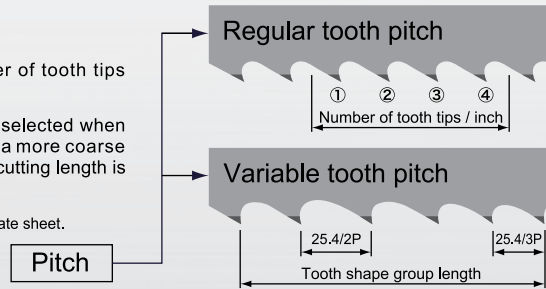
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Carbide Tipped Blades	Solid material	Mild steel, Tool steel Prehardened steel Hot work die steel, Stainless steel Super heat resisting alloy		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P	

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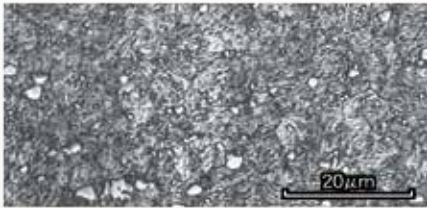
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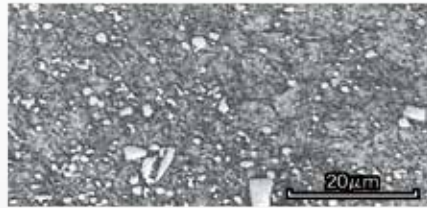
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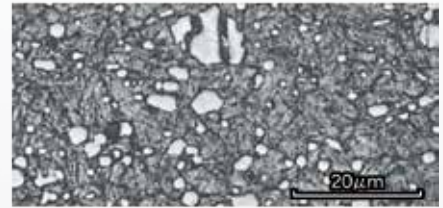
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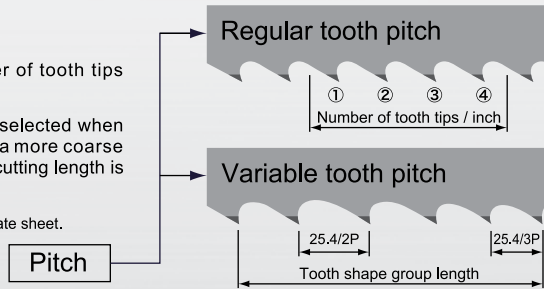
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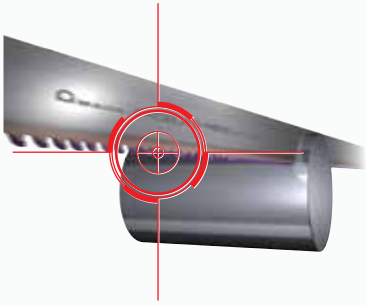
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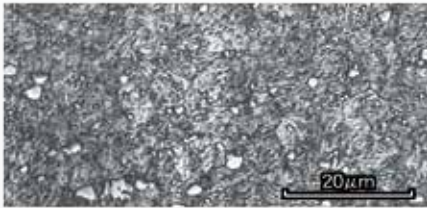
# BLADE INFORMATION

## Edge material



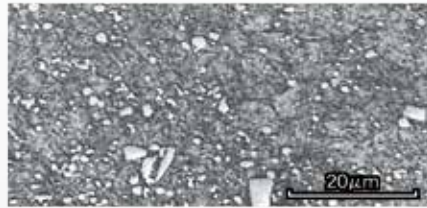
It is not necessarily true that the harder the edge, the longer the service life and the higher the efficiency. In case of cutting that involves high vibration and a large shock, edge material of high toughness are more advantageous because drop-off wear occurs before friction wear.

AMADA Modified M42 HSS



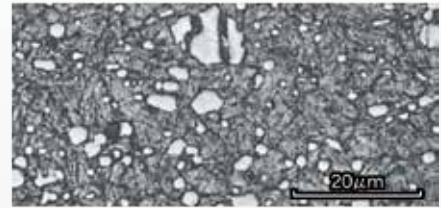
AMADA's original matrix high-speed steel, produced based on M42 cobalt high-speed steel. With toughness greatly improved, this steel exhibits its greatest performance under cutting conditions involving vibration and shock.

M42 Cobalt HSS



M42 cobalt high-speed steel that provides superior wear resistance. Being treated with AMADA's unique heat treatment technology, this steel exhibits a performance that is highest in the class. It is broadly suitable for cutting general steel through difficult to cut materials.

AMADA M71 Original HSS



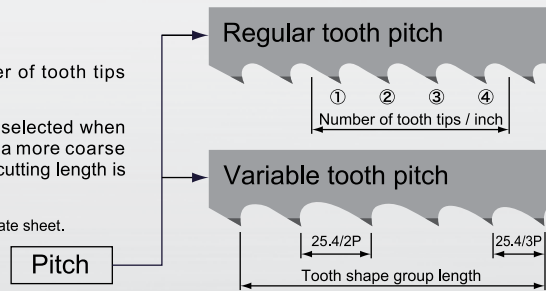
Original highest grade, high-speed steel, developed jointly with a leading steel manufacturer. This steel has hardness of 1000Hv, which is the highest ever recorded in ingot high-speed steel. It is suitable for cutting difficult to cut materials.

## Selection

### Pitch

- Pitch is expressed by the number of tooth tips within one inch (25.4mm).
- Generally, a finer pitch should be selected when the cutting length is shorter and a more coarse pitch should be selected when the cutting length is longer.

\*See "Blade pitch selection guide" on separate sheet.



Tooth tips are located at equal intervals. The regular tooth pitch is expressed as "00P(00=number of teeth/inch)". The example shown on the left is 4P, and the tooth tip interval in this case is  $25.4 \div 4P = 6.35\text{mm}$ .

Multiple different pitches are combined within one inch. The variable tooth pitch is expressed by two figures such as "2/3P" in the example shown on the left. It means that the maximum tooth tip interval is equivalent to 2P in a tooth shape group (minimum unit of repetition) and that the minimum tooth interval is equivalent to 3P. Use of this pitch can suppress vibration, and is applicable to cutting in wide range.

### Blade pitch selection table by materials to be cut

	Maximum cutting length		Material to be cut											
			50 2"	100 4"	150 6"	200 8"	250 10"	300 12"	400 16"	500 20"	700 28"	1000 40"		
HSS Bi-Metal Blades	Roll-formed section steels		6/10P		5/7P & 4/6P									
	Structural steel, Bundled tubes													
	Solid material	Bundled small Diameter material, Mild steel			3/4P				2/3P		1.5/2P			
		Tool steel, Prehardened steel												
		Hot work die steel, Stainless steel												
	Super heat resisting alloy									1.1/1.5P		0.75/1P		
Carbide Tipped Blades	Solid material	Mild steel, Tool steel Prehardened steel Hot work die steel, Stainless steel Super heat resisting alloy		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P		

Note1 : It is recommended for optimum cutting to select a pitch to allow for 20 to 30 teeth to correspond to the cutting length.

Note2 : When cutting deformed material or like that varies in the cutting length suddenly, it is desirable that at least 2 teeth are in contact with the material constantly while cutting.

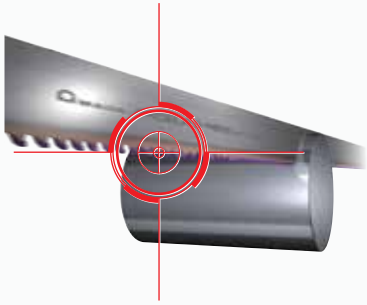
Note3 : The above table based on "SGLB" should be used as guide. Specific applicability varies somewhat depending on the characteristics of the blades.

For example, 3/4P of "PROTECTOR" is capable of cutting materials in the range including 4/6P in the above table.



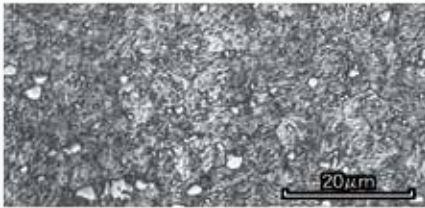
# BLADE INFORMATION

## Edge material



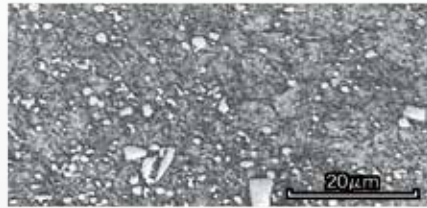
It is not necessarily true that the harder the edge, the longer the service life and the higher the efficiency. In case of cutting that involves high vibration and a large shock, edge material of high toughness are more advantageous because drop-off wear occurs before friction wear.

**AMADA Modified M42 HSS**



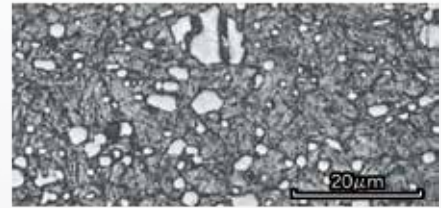
AMADA's original matrix high-speed steel, produced based on M42 cobalt high-speed steel. With toughness greatly improved, this steel exhibits its greatest performance under cutting conditions involving vibration and shock.

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**AMADA M71 Original HSS**



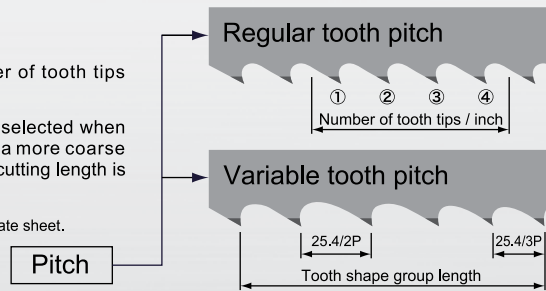
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Multiple different pitches are combined within one inch. The variable tooth pitch is expressed by two figures such as "2/3P" in the example shown on the left. It means that the maximum tooth tip interval is equivalent to 2P in a tooth shape group (minimum unit of repetition) and that the minimum tooth interval is equivalent to 3P.

Use of this pitch can suppress vibration, and is applicable to cutting in wide range.

### Blade pitch selection table by materials to be cut

	Maximum cutting length		Material to be cut										
			50	100	150	200	250	300	400	500	700	1000 (mm)	
			2"	4"	6"	8"	10"	12"	16"	20"	28"	40"	(Inch)
HSS Bi-Metal Blades	Roll-formed section steels		6/10P		5/7P & 4/6P								
	Structural steel, Bundled tubes												
	Solid material	Bundled small Diameter material, Mild steel			3/4P				2/3P		1.5/2P		
		Tool steel, Prehardened steel											
		Hot work die steel, Stainless steel											
	Super heat resisting alloy									1.1/1.5P		0.75/1P	
Carbide Tipped Blades	Solid material	Mild steel, Tool steel Prehardened steel Hot work die steel, Stainless steel Super heat resisting alloy		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P	

Note1 : It is recommended for optimum cutting to select a pitch to allow for 20 to 30 teeth to correspond to the cutting length.

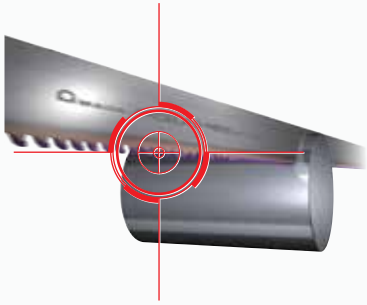
Note2 : When cutting deformed material or like that varies in the cutting length suddenly, it is desirable that at least 2 teeth are in contact with the material constantly while cutting.

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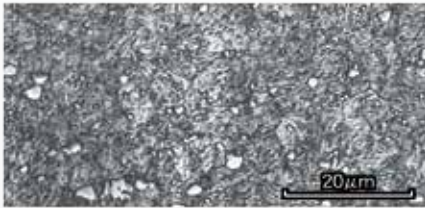
# BLADE INFORMATION

## Edge material



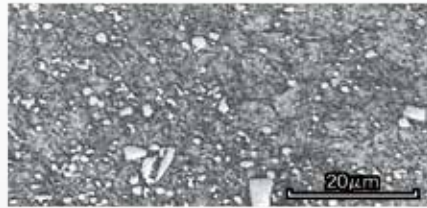
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AMADA Modified M42 HSS



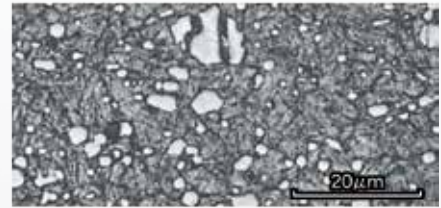
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AMADA M71 Original HSS



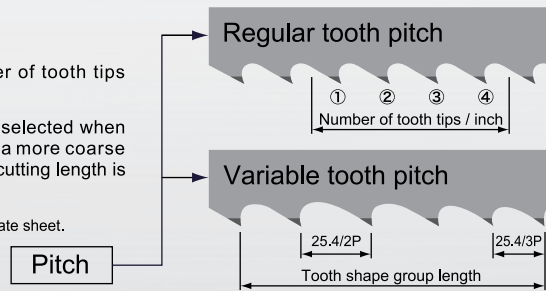
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Use of this pitch can suppress vibration, and is applicable to cutting in wide range.

### Blade pitch selection table by materials to be cut

Material to be cut		Maximum cutting length											
		50	100	150	200	250	300	400	500	700	1000 (mm)		
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HSS Bi-Metal Blades	Roll-formed section steels	6/10P		5/7P & 4/6P									
	Structural steel, Bundled tubes												
	Solid material	Bundled small Diameter material, Mild steel			3/4P			2/3P		1.5/2P			
		Tool steel, Prehardened steel											
		Hot work die steel, Stainless steel											
	Super heat resisting alloy								1.1/1.5P		0.75/1P		
Carbide Tipped Blades	Solid material		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P		

Note1 : It is recommended for optimum cutting to select a pitch to allow for 20 to 30 teeth to correspond to the cutting length.

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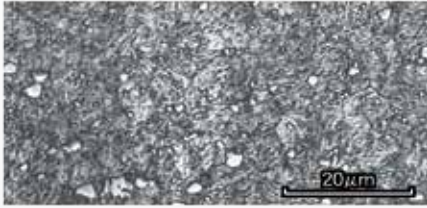
# BLADE INFORMATION

## Edge material



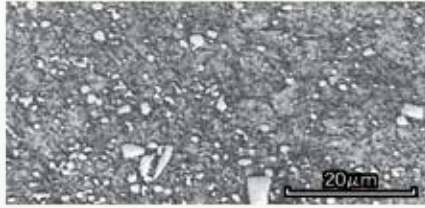
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AMADA Modified M42 HSS



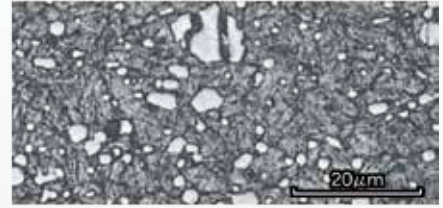
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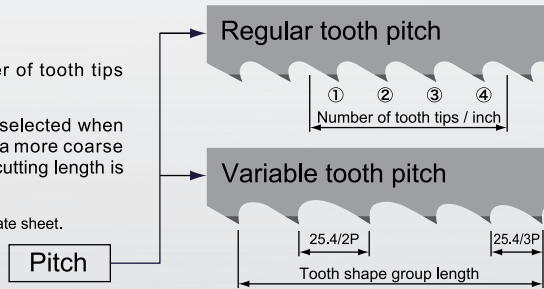
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			Number of teeth / inch												
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	Structural steel, Bundled tubes														
	Solid material	Bundled small Diameter material, Mild steel			3/4P				2/3P		1.5/2P				
		Tool steel,Prehardened steel													
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	Super heat resisting alloy									1.1/1.5P			0.75/1P		
Carbide Tipped Blades	Solid material	Mild steel, Tool steel Prehardened steel Hot work die steel, Stainless steel Super heat resisting alloy		3/4P		2/3P	1.8/2P		1.4/1.6P				0.9/1.1P		

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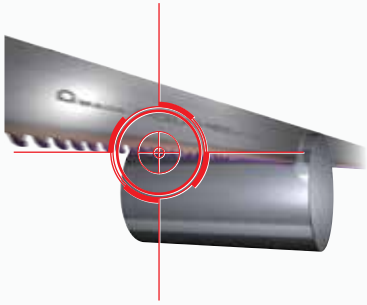
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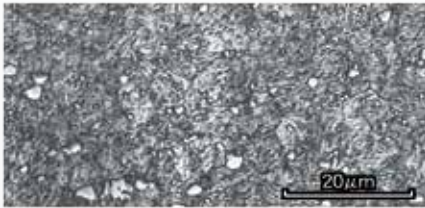
# BLADE INFORMATION

## Edge material



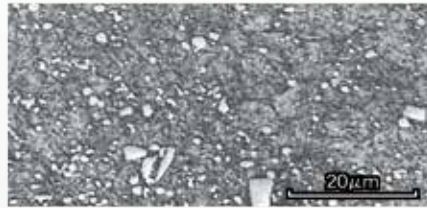
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AMADA Modified M42 HSS



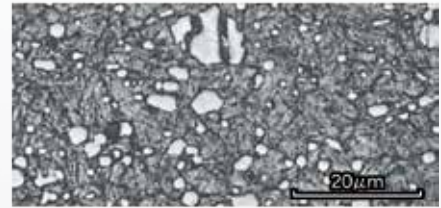
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AMADA M71 Original HSS



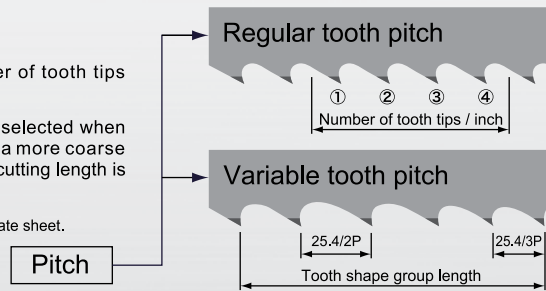
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	Structural steel, Bundled tubes												
	Solid material	Bundled small Diameter material, Mild steel			3/4P			2/3P		1.5/2P			
		Tool steel, Prehardened steel											
		Hot work die steel, Stainless steel											
	Super heat resisting alloy								1.1/1.5P		0.75/1P		
Carbide Tipped Blades	Solid material		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P		

Note1 : It is recommended for optimum cutting to select a pitch to allow for 20 to 30 teeth to correspond to the cutting length.

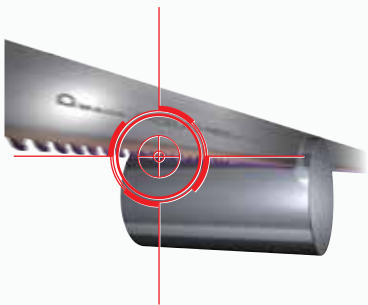
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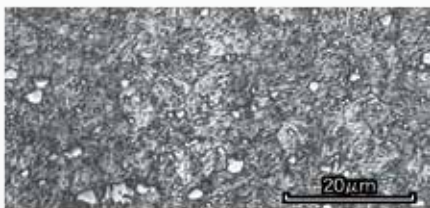
# BLADE INFORMATION

## Edge material



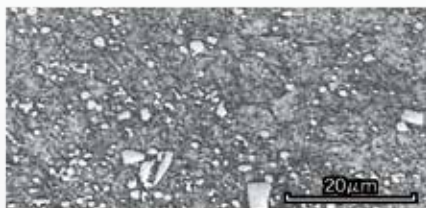
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**AMADA Modified M42 HSS**



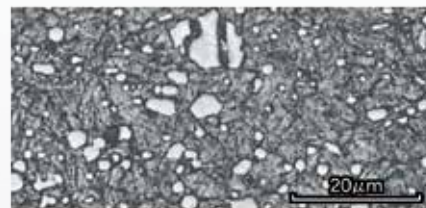
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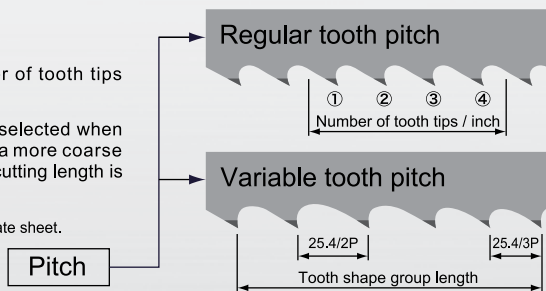
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Carbide Tipped Blades	Solid material	Mild steel, Tool steel, Prehardened steel, Hot work die steel, Stainless steel, Super heat resisting alloy		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P		

Note1 : It is recommended for optimum cutting to select a pitch to allow for 20 to 30 teeth to correspond to the cutting length.

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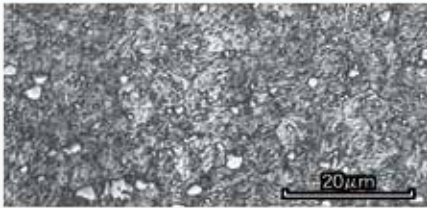
# BLADE INFORMATION

## Edge material



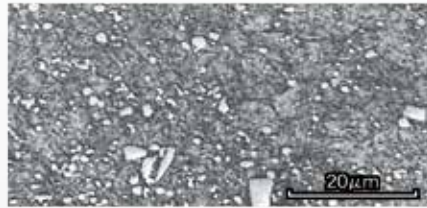
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**AMADA Modified M42 HSS**



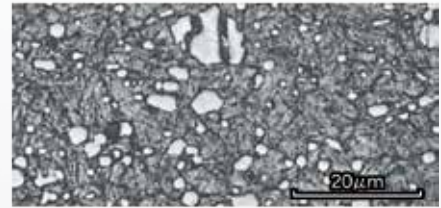
AMADA's original matrix high-speed steel, produced based on M42 cobalt high-speed steel. With toughness greatly improved, this steel exhibits its greatest performance under cutting conditions involving vibration and shock.

**M42 Cobalt HSS**



M42 cobalt high-speed steel that provides superior wear resistance. Being treated with AMADA's unique heat treatment technology, this steel exhibits a performance that is highest in the class. It is broadly suitable for cutting general steel through difficult to cut materials.

**AMADA M71 Original HSS**



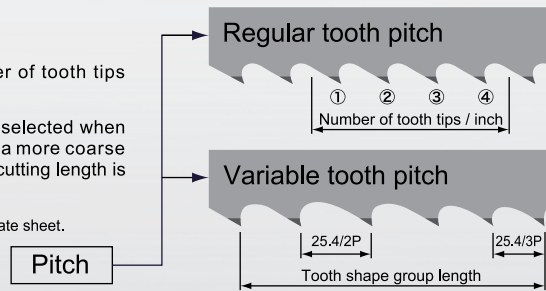
Original highest grade, high-speed steel, developed jointly with a leading steel manufacturer. This steel has hardness of 1000Hv, which is the highest ever recorded in ingot high-speed steel. It is suitable for cutting difficult to cut materials.

## Selection

### Pitch

- Pitch is expressed by the number of tooth tips within one inch (25.4mm).
- Generally, a finer pitch should be selected when the cutting length is shorter and a more coarse pitch should be selected when the cutting length is longer.

\*See "Blade pitch selection guide" on separate sheet.



Tooth tips are located at equal intervals. The regular tooth pitch is expressed as "00P(00=number of teeth/inch)". The example shown on the left is 4P, and the tooth tip interval in this case is  $25.4 \div 4P = 6.35\text{mm}$ .

Multiple different pitches are combined within one inch. The variable tooth pitch is expressed by two figures such as "2/3P" in the example shown on the left. It means that the maximum tooth tip interval is equivalent to 2P in a tooth shape group (minimum unit of repetition) and that the minimum tooth interval is equivalent to 3P.

Use of this pitch can suppress vibration, and is applicable to cutting in wide range.

### Blade pitch selection table by materials to be cut

Material to be cut		Maximum cutting length											
		50 2"	100 4"	150 6"	200 8"	250 10"	300 12"	400 16"	500 20"	700 28"	1000 40"	(mm) (Inch)	
HSS Bi-Metal Blades	Roll-formed section steels	6/10P		5/7P & 4/6P									
	Structural steel, Bundled tubes												
	Solid material	Bundled small Diameter material, Mild steel			3/4P			2/3P		1.5/2P			
		Tool steel,Prehardened steel											
		Hot work die steel,Stainless steel											
	Super heat resisting alloy								1.1/1.5P		0.75/1P		
Carbide Tipped Blades	Solid material		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P		
	Mild steel, Tool steel Prehardened steel Hot work die steel, Stainless steel Super heat resisting alloy												

Note1 : It is recommended for optimum cutting to select a pitch to allow for 20 to 30 teeth to correspond to the cutting length.

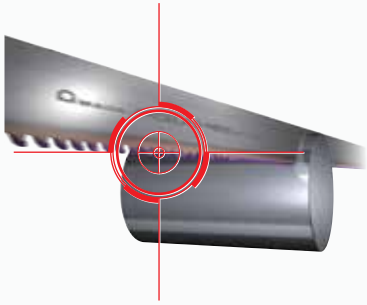
Note2 : When cutting deformed material or like that varies in the cutting length suddenly, it is desirable that at least 2 teeth are in contact with the material constantly while cutting.

Note3 : The above table based on "SGLB" should be used as guide. Specific applicability varies somewhat depending on the characteristics of the blades.

For example, 3/4P of "PROTECTOR" is capable of cutting materials in the range including 4/6P in the above table.

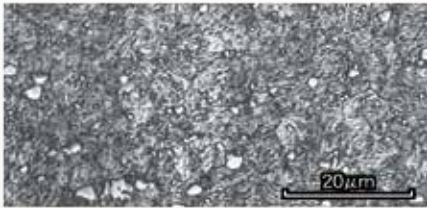
# BLADE INFORMATION

## Edge material



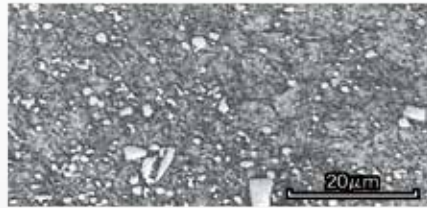
It is not necessarily true that the harder the edge, the longer the service life and the higher the efficiency. In case of cutting that involves high vibration and a large shock, edge material of high toughness are more advantageous because drop-off wear occurs before friction wear.

**AMADA Modified M42 HSS**



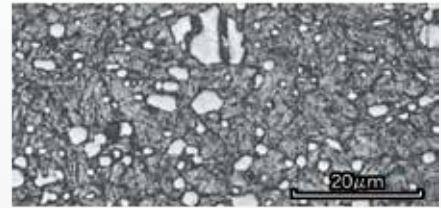
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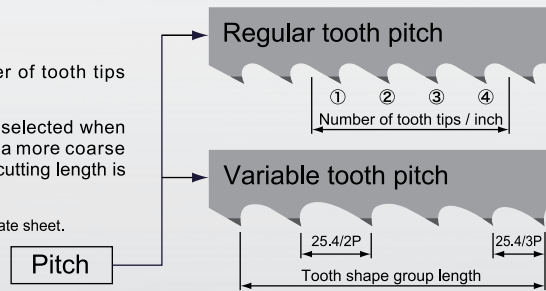
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HSS Bi-Metal Blades	Roll-formed section steels		6/10P		5/7P & 4/6P								
	Structural steel, Bundled tubes												
	Solid material	Bundled small Diameter material, Mild steel			3/4P				2/3P		1.5/2P		
		Tool steel, Prehardened steel											
		Hot work die steel, Stainless steel											
Super heat resisting alloy										1.1/1.5P		0.75/1P	
Carbide Tipped Blades	Solid material	Mild steel, Tool steel Prehardened steel Hot work die steel, Stainless steel Super heat resisting alloy		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P	

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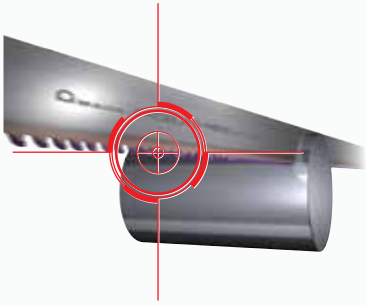
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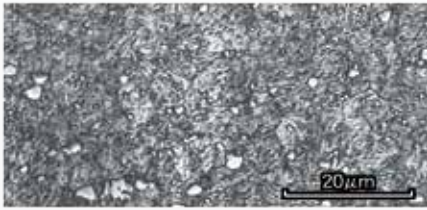
# BLADE INFORMATION

## Edge material



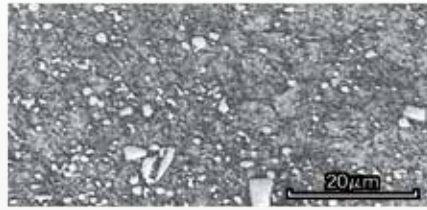
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AMADA Modified M42 HSS



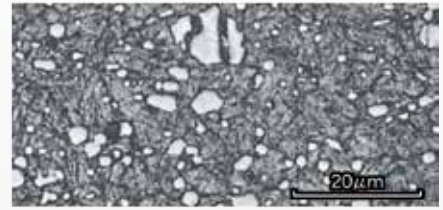
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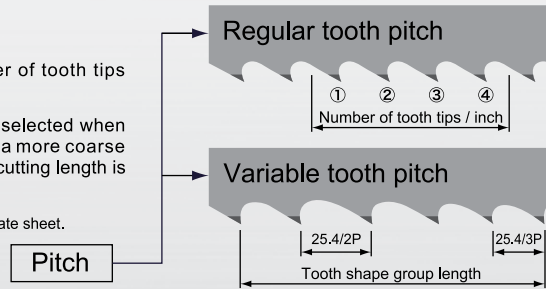
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	Structural steel, Bundled tubes														
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Super heat resisting alloy											1.1/1.5P		0.75/1P		
Carbide Tipped Blades	Solid material	Mild steel, Tool steel Prehardened steel Hot work die steel, Stainless steel Super heat resisting alloy		3/4P		2/3P	1.8/2P		1.4/1.6P				0.9/1.1P		

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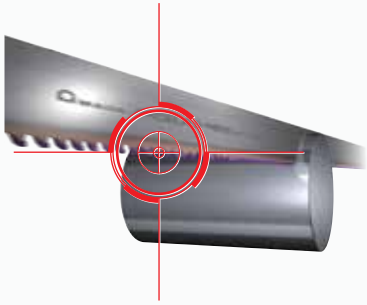
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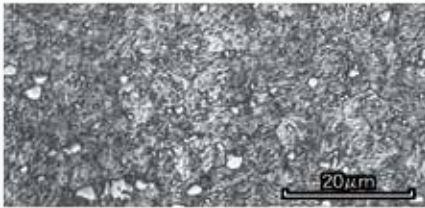
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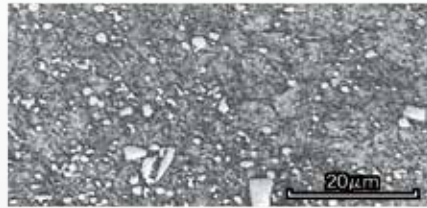
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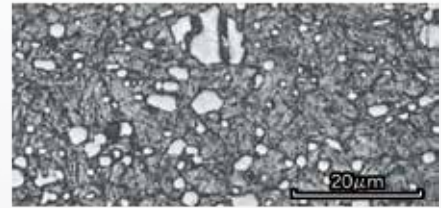
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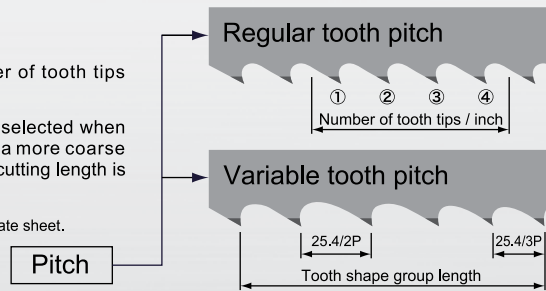
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Carbide Tipped Blades	Solid material	Mild steel, Tool steel, Prehardened steel, Hot work die steel, Stainless steel, Super heat resisting alloy		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P	

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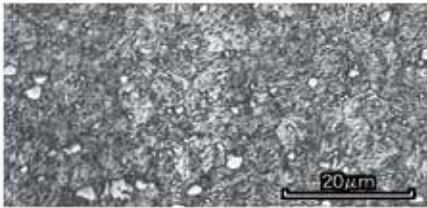
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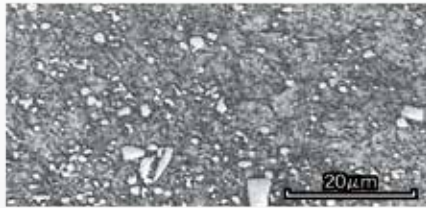
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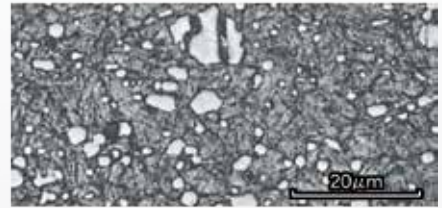
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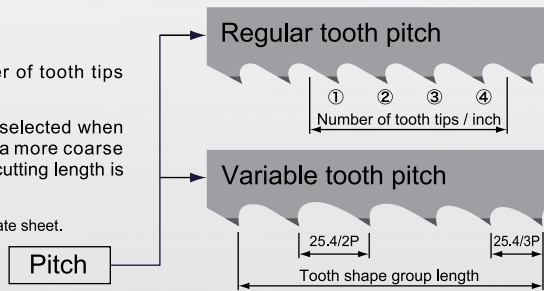
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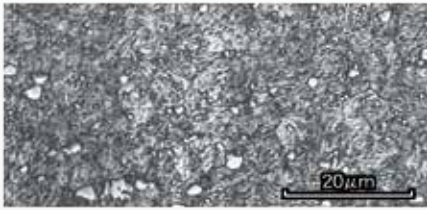
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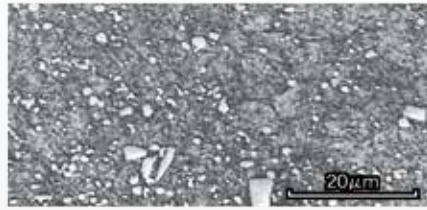
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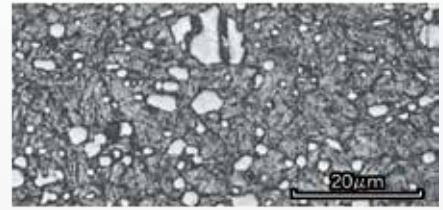
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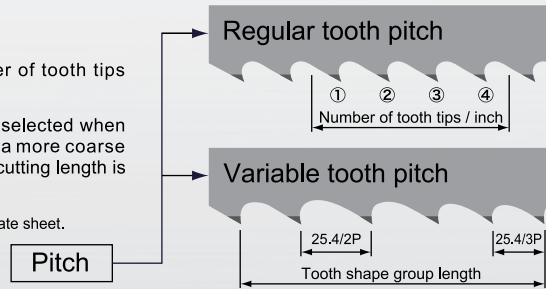
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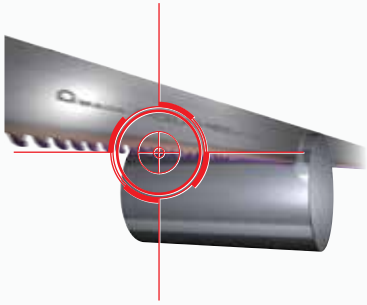
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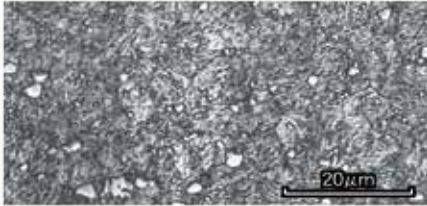
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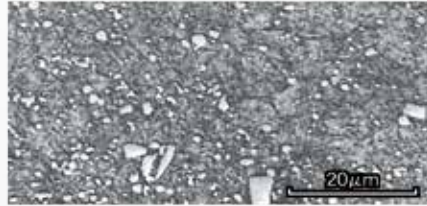
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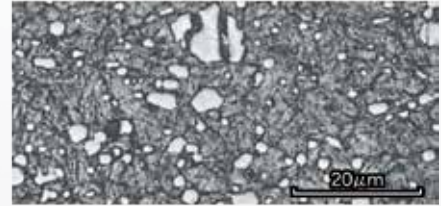
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AMADA M71 Original HSS



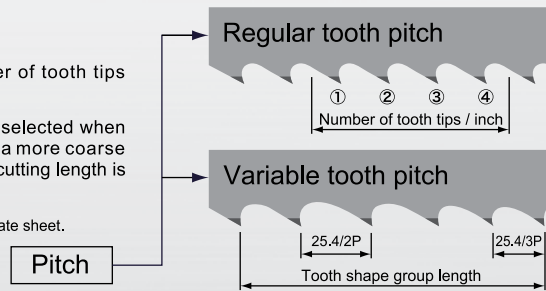
Original highest grade, high-speed steel, developed jointly with a leading steel manufacturer. This steel has hardness of 1000Hv, which is the highest ever recorded in ingot high-speed steel. It is suitable for cutting difficult to cut materials.

## Selection

### Pitch

- Pitch is expressed by the number of tooth tips within one inch (25.4mm).
- Generally, a finer pitch should be selected when the cutting length is shorter and a more coarse pitch should be selected when the cutting length is longer.

\*See "Blade pitch selection guide" on separate sheet.



Tooth tips are located at equal intervals. The regular tooth pitch is expressed as "00P(00=number of teeth/inch)". The example shown on the left is 4P, and the tooth tip interval in this case is  $25.4 \div 4P = 6.35\text{mm}$ .

Multiple different pitches are combined within one inch. The variable tooth pitch is expressed by two figures such as "2/3P" in the example shown on the left. It means that the maximum tooth tip interval is equivalent to 2P in a tooth shape group (minimum unit of repetition) and that the minimum tooth interval is equivalent to 3P.

Use of this pitch can suppress vibration, and is applicable to cutting in wide range.

### Blade pitch selection table by materials to be cut

Material to be cut		Maximum cutting length											
		50	100	150	200	250	300	400	500	700	1000 (mm)		
		2"	4"	6"	8"	10"	12"	16"	20"	28"	40"	(Inch)	
HSS Bi-Metal Blades	Roll-formed section steels	6/10P		5/7P & 4/6P									
	Structural steel, Bundled tubes												
	Solid material	Bundled small Diameter material, Mild steel			3/4P			2/3P		1.5/2P			
		Tool steel, Prehardened steel											
		Hot work die steel, Stainless steel											
	Super heat resisting alloy								1.1/1.5P		0.75/1P		
Carbide Tipped Blades	Solid material		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P		

Note1 : It is recommended for optimum cutting to select a pitch to allow for 20 to 30 teeth to correspond to the cutting length.

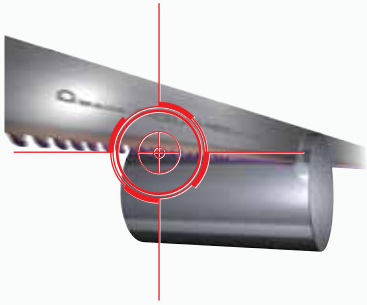
Note2 : When cutting deformed material or like that varies in the cutting length suddenly, it is desirable that at least 2 teeth are in contact with the material constantly while cutting.

Note3 : The above table based on "SGLB" should be used as guide. Specific applicability varies somewhat depending on the characteristics of the blades.

For example, 3/4P of "PROTECTOR" is capable of cutting materials in the range including 4/6P in the above table.

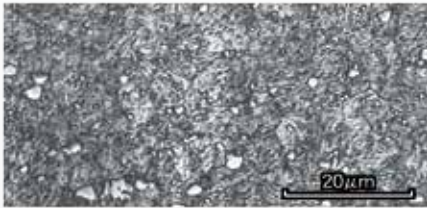
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## Edge material



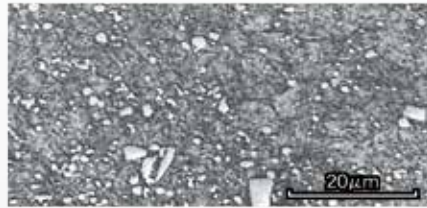
It is not necessarily true that the harder the edge, the longer the service life and the higher the efficiency. In case of cutting that involves high vibration and a large shock, edge material of high toughness are more advantageous because drop-off wear occurs before friction wear.

AMADA Modified M42 HSS



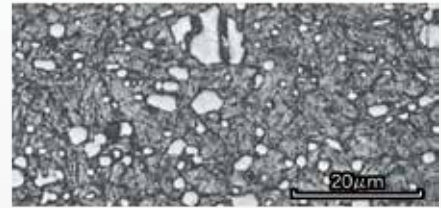
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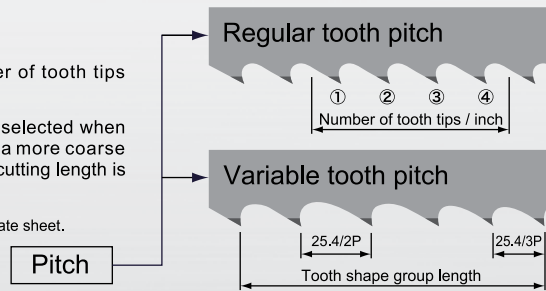
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	Solid material	Bundled small Diameter material, Mild steel			3/4P			2/3P		1.5/2P			
		Tool steel, Prehardened steel											
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	Super heat resisting alloy								1.1/1.5P		0.75/1P		
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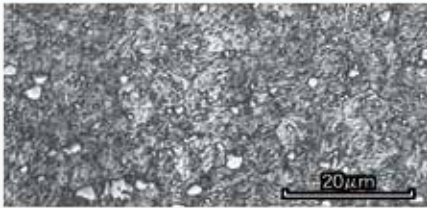
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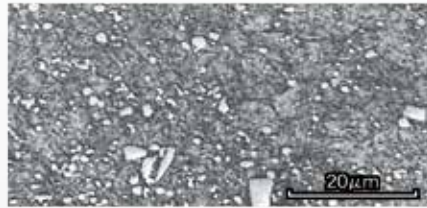
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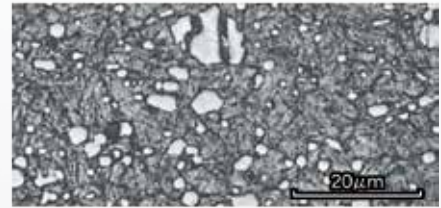
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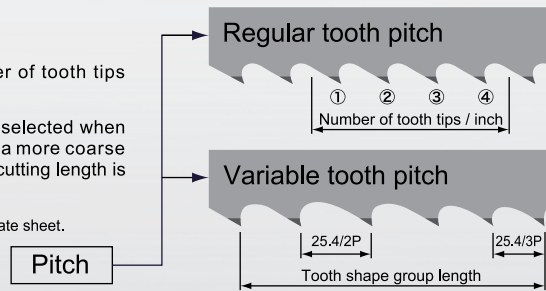
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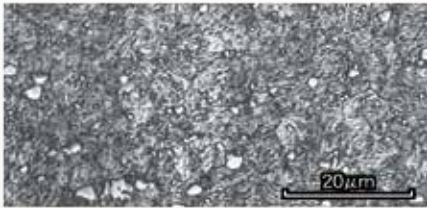
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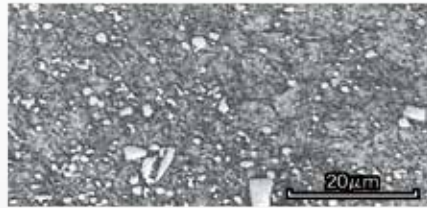
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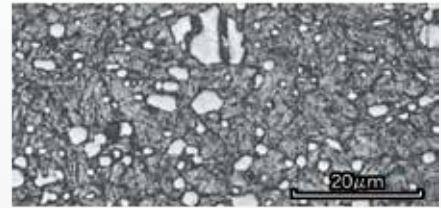
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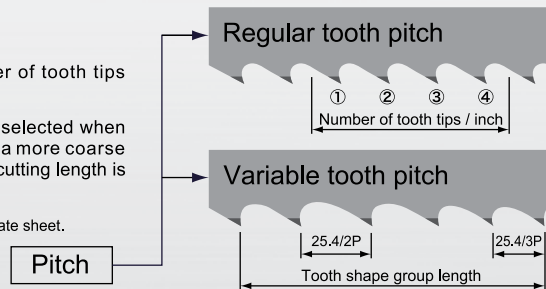
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		Tool steel, Prehardened steel											
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Carbide Tipped Blades	Solid material	Mild steel, Tool steel, Prehardened steel, Hot work die steel, Stainless steel, Super heat resisting alloy		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P	

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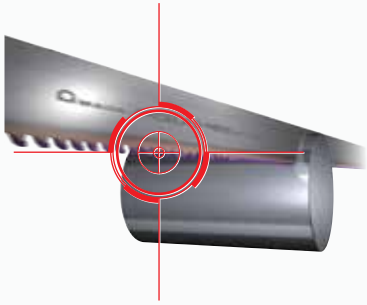
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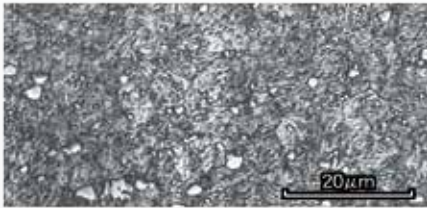
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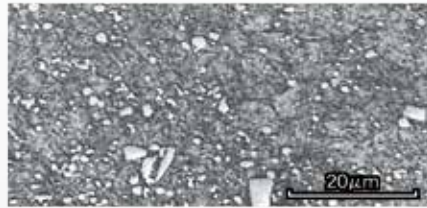
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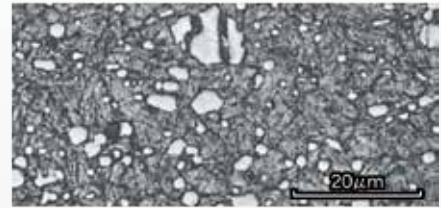
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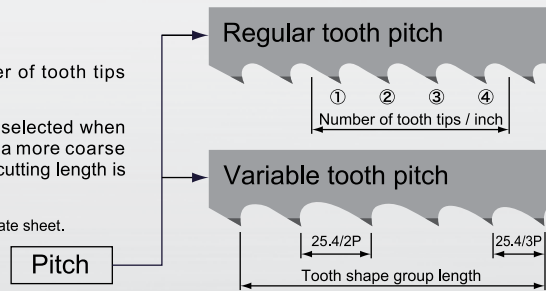
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Carbide Tipped Blades	Solid material	Mild steel, Tool steel Prehardened steel Hot work die steel, Stainless steel Super heat resisting alloy		3/4P		2/3P	1.8/2P		1.4/1.6P			0.9/1.1P	

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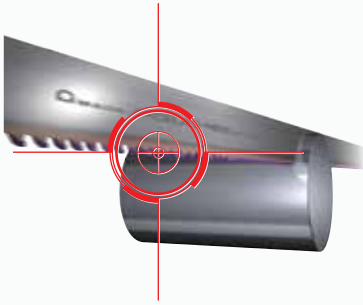
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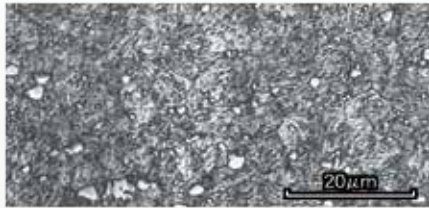
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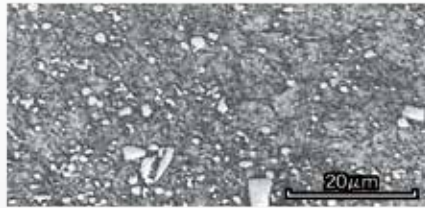
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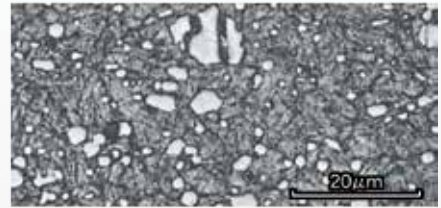
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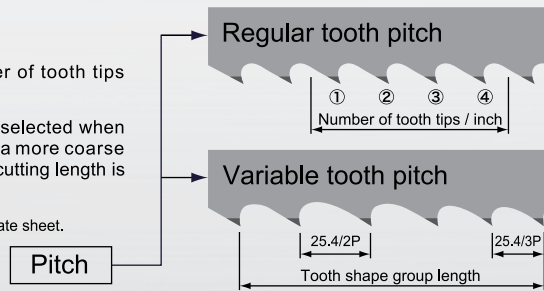
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**Before Using this Product,  
Please Read the Operator's Manual Carefully and Follow all Applicable Instructions.**

※Product availability and product specification subject to change without notice at the discretion of the company.

※Some variation in materials and product specifications may occur according to sales areas.

※"AXCELA, DYNABAND, SGLB, PROTECTOR, DUOS, TCB" - AMADA MACHINERY AMERICA, INC., is a registered trademark of AMADA CO., LTD.

※There may be differences in the specification that has been described in this catalog to the AMADA products which are actually shipped. Please ask our staff for more detail.

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