

# **M42 BI-METAL**

*BANDSAW BLADES*

*We are the authorised distributors of:*



Call any of our Blade Pit Crew on **Speed Dial 08610 STEEL**  
or visit us at [www.sovereignsteel.com](http://www.sovereignsteel.com)

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*Earth's fastest steel company™*



**SOVEREIGNSTEEL**

**SPEED MERCHANTS™**

13 x 14

19 x 4/6

27 x 2/3

34 x 4/6

41 x 2/3

54 x 1.0/1.3

### DIAMETER OF MATERIAL

mm ø	0 – 15	16 – 25	26 – 50	51 – 75	76 – 125	126 – 250	251 – 450	451 – 1000
<b>TOOTH PITCH PER 25mm/INCH</b>								
● SOLID ROUND BAR	8/12 10/14	6/10 8/12	5/8 4/6	4/6 3/4	3/4 2/3	2/3 1.4/2.0	1.4/2.0	1.0/1.3
■ SOLID SQUARE BAR	8/12 10/14	6/10 8/12	4/6 5/8	4/6 3/4	2/3 3/4	2/3 1.4/2.0	1.4/2.0	1.0/1.3
○ □ ▭ TUBING/STRUCTURAL	10/14 8/12	8/12 6/10	4/6 5/8	4/6 3/4	2/3 3/4	2/3 1.4/2.0	1.4/2.0	1.0/1.3

### HOW TO USE CHART

- Identify material on chart (solid, round, square, structural/tubing)
- Select tooth pitch from chart according to material size : eg. 250mm solid round bar = 2/3 tooth – 1.4/2.0

### TUBING AND STRUCTURALS

Multiply wall thickness by 3 times the wall thickness : eg. 25mm x 3mm pipe : 9mm ie. 10/14 or 8/12 tooth

### RUNNING-IN PROCEDURE

Feed rate should be reduced by 1/3 normal rate for first 450mm<sup>3</sup>

### PLEASE ENQUIRE WITH OUR SALES TEAM

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