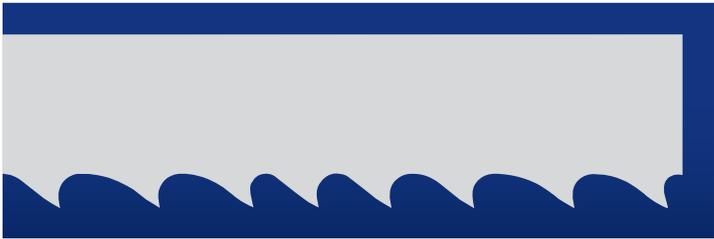


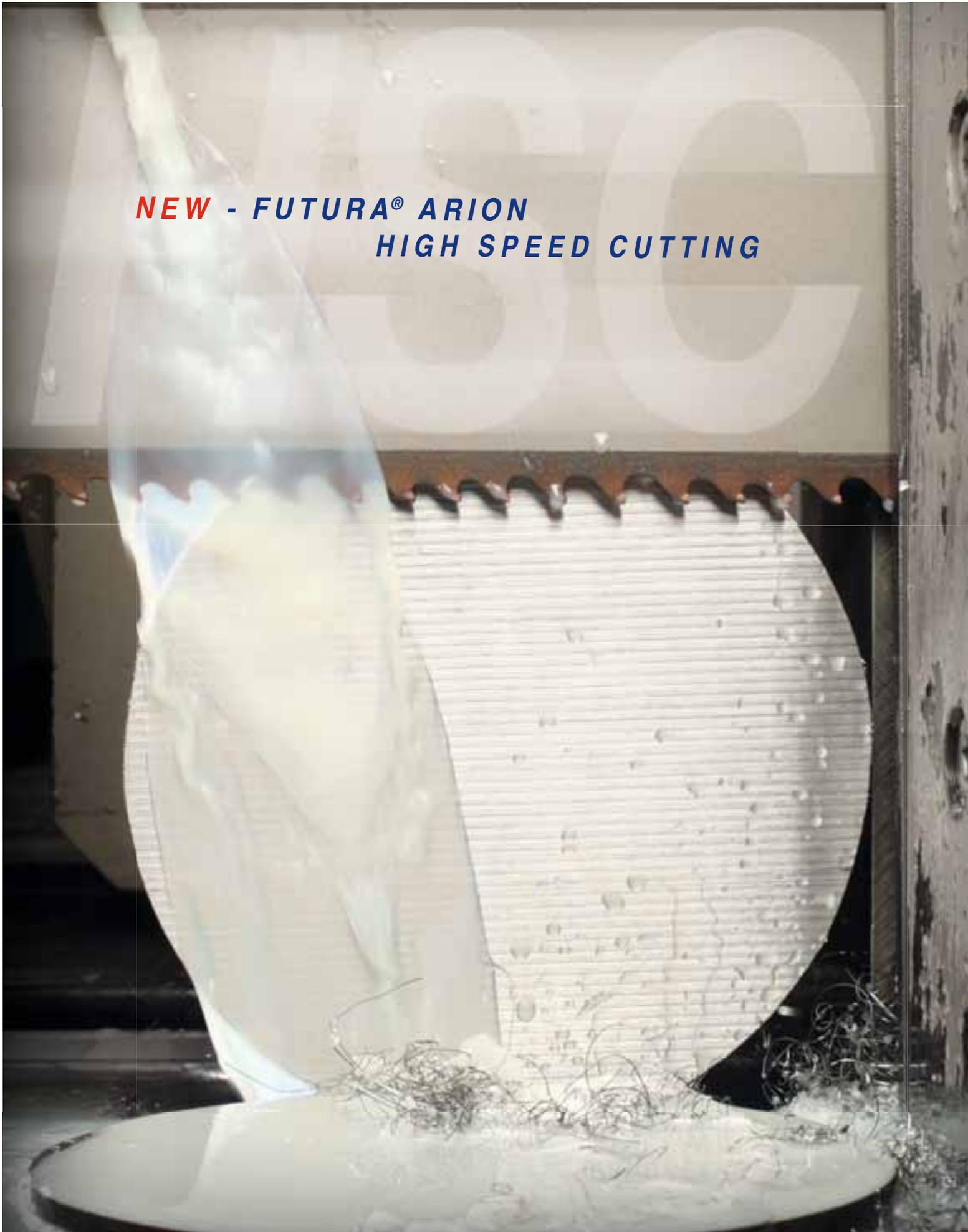


2011/12



PRECISION
BAND SAW BLADES

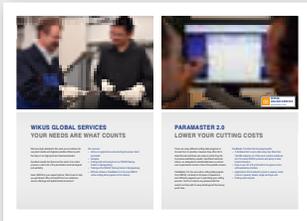
NEW - FUTURA® ARION
HIGH SPEED CUTTING



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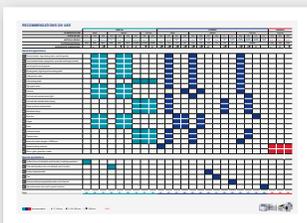
WIKUS Global Services

6



NEW - FUTURA ARION
High Speed Cutting

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Made in Spangenberg

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WIKUS GLOBAL SERVICES

YOUR NEEDS ARE WHAT COUNTS

We have high standards. We want you to achieve the very best results and highest possible efficiency with the help of our high-precision band saw blades.

Excellent results like these are the result of an entire process in which all of the parameters must be aligned just perfectly.

Here, WIKUS is your expert partner. We're here to help you get ahead. Why not benefit from our extensive service offerings and global technical service?

Our services:

- » Advice on applications and selecting the proper band saw blade
- » Samples
- » Cutting tests and analysis at our WIKUS Sawing Center in Spangenberg
- » Training at the WIKUS Training Center in Spangenberg
- » Efficient software: ParaMaster 2.0, the new WIKUS online cutting data program on the Internet



PARAMASTER 2.0

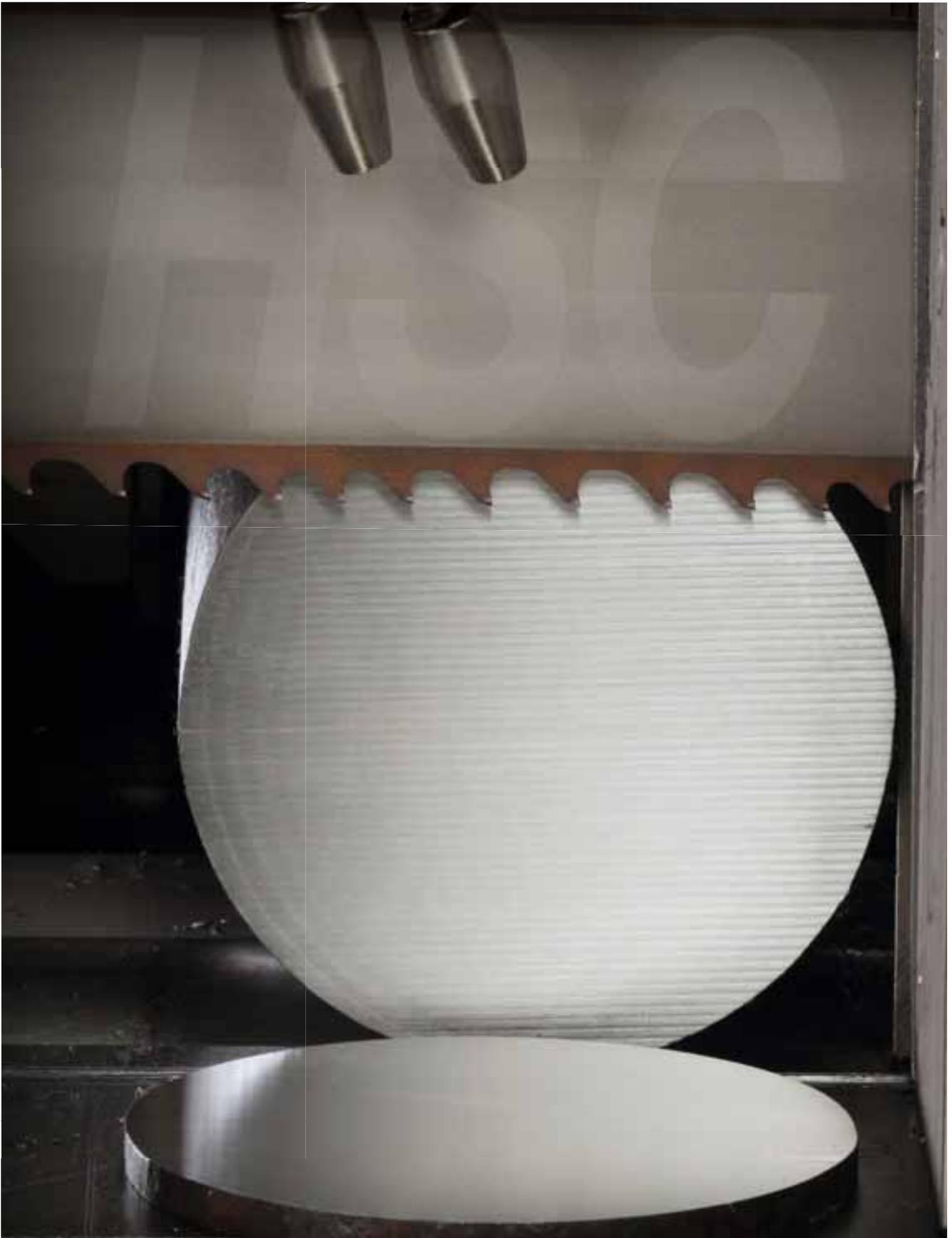
LOWER YOUR CUTTING COSTS

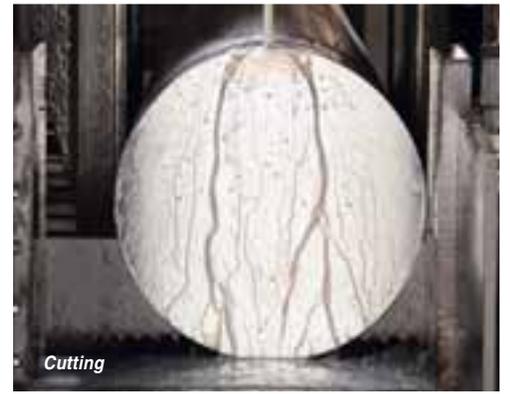
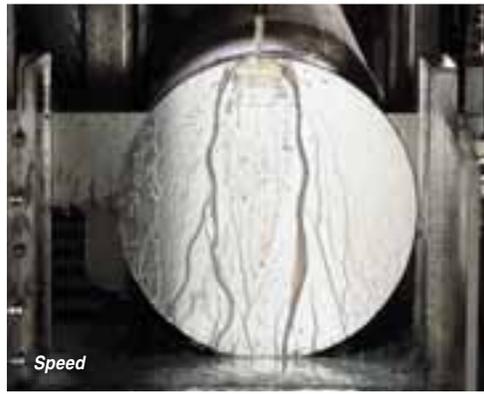
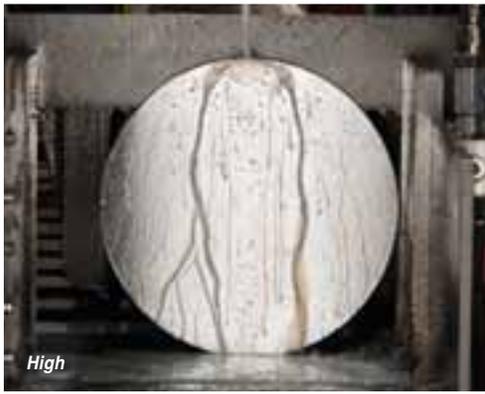
There are many different cutting data programs to choose from. In practice, however, they often fail to stand the test and there are cases in which they fail to produce satisfactory results. Insufficient technical basics, an antiquated or limited data base or unclear user requirements are but a few of the possible causes.

ParaMaster 2.0, the new online cutting data program from WIKUS, is based on 50 years of experience and efficiently supports you in optimizing your cutting process. You'll not only be very pleased with the results, but also with its easy handling and the money you'll save.

ParaMaster 2.0 offers the following benefits:

- » A database that is up-to-date every day: More than 150,000 materials, all of the most common machines, all of the latest WIKUS products and plenty of additional information
- » Easy to use: All of the information at a glance and a self-explanatory interface
- » Applications: Solid materials (round or square), tubes (round or square), beams, single and layer cuts
- » Cutting costs analysis





HIGH SPEED CUTTING

NEW - FUTURA[®] ARION: THE SPEED REVOLUTION

The new high-performance band saw blade FUTURA ARION offers outstanding performance data that is unrivalled in the market.

Thanks to maximum synergy effects, FUTURA ARION allows for the highest possible efficiency, speed and quality. This can be attributed to its design and the special carrier band quality of the coated carbide band saw blade.

Discover the advantages it offers for your application together with our experts.

All of the dimensions and tooth pitches that are currently available can be found on page 28.

Advantages of FUTURA ARION:

- » Maximum speed - High speed cutting
- » Considerable time savings
- » Increase in machine productivity
- » Highly productive manufacturing
- » Highest quality saw cuts
- » Fewer cutting channels results in high material savings
- » Unrivalled cutting power that meets the highest demands
- » Lower costs per cut



SELECTING THE RIGHT BAND SAW BLADE

1. Band length

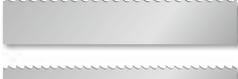
The dimensions of the band will depend on the band saw machine that has been installed.

2. Band width

With horizontal machines, the band width is specified by the manufacturer. Vertical band saw machines allow for higher variations in the band width.

The wider the band saw blade is, the more stability it will have. In case of contour cuts, the smallest radius to be cut is the limiting factor for the band width.

Band widths and smallest radius

	3/4 inch; r = 140
	5/8 inch; r = 95
	1/2 inch; r = 65
	3/8 inch; r = 40
	5/16 inch; r = 30
	1/4 inch; r = 16
	5/32 inch; r = 8
	1/8 inch; r = 3

3. Cutting edge material

WIKUS offers four main groups of cutting edge materials:

- Carbon steel
- Bimetal
- Carbide
- Diamond

The machinability of the material to be cut determines the cutting edge material.

4. Tooth pitch

At WIKUS, you can choose between constant and variable tooth pitch. The main factor here is the contact length of the blade in the workpiece. Both tables to the right show the respective upper and lower limits

5. Tooth shape

Our technologists have combined the different tooth shapes we offer with our cutting edge materials and band saw dimensions to ensure a perfect fit.

Constant tooth pitch tpi	Contact length (inch)	
	from	to
24		1/4
18		3/8
14		9/16
10	9/16	1-1/8
8	1-1/8	2
6	2	3-1/8
4	3-1/8	4-3/4
3	4-3/4	7-7/8
2	7-7/8	15-3/4
1.25	11-3/4	31-1/2

Variable tooth pitch tpi	Contact length (inch)	
	from	to
10-14		3/4
8-12	3/8	1-1/8
6-10	3/4	2
5-8	1-1/8	2-3/8
4-6	2	3-1/2
3-4	3-1/8	5-7/8
2-3	4-3/4	11-3/4
1.4-2	9-7/8	23-5/8
1.0-1.4	15-3/4	39-3/8
0.85-1.15	23-5/8	78-3/4
0.75-1.25	23-5/8	78-3/4
0.7-1.0	39-3/8	118-1/8



s	Cutting of tubes																
	Outer diameter of the tube (inch) / Tooth pitch Tz in tpi																
inch	3/4	1-5/8	2-3/8	3-1/8	4	4-3/4	5-7/8	7-7/8	11-3/4	15-3/4	19-5/8	23-5/8	27-9/16	31-1/2	35-3/8	39-3/8	59
1/16	14	14	14	14	14	14	10-14	10-14	8-12	8-12	6-10	6-10	5-8	5-8	5-8	5-8	5-8
1/8	14	14	10-14	10-14	10-14	10-14	8-12	8-12	6-10	6-10	5-8	5-8	5-8	4-6	4-6	4-6	4-6
5/32	14	14	10-14	10-14	8-12	8-12	8-12	8-12	5-8	5-8	4-6	4-6	4-6	4-6	4-6	4-6	3-4
3/16	14	10-14	10-14	10-14	8-12	8-12	8-12	6-10	5-8	5-8	4-6	4-6	4-6	4-6	3-4	3-4	3-4
1/4	14	10-14	10-14	8-12	8-12	8-12	8-12	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4	3-4	3-4
5/16	14	10-14	8-12	8-12	8-12	6-10	6-10	5-8	4-6	4-6	4-6	3-4	3-4	3-4	3-4	2-3	2-3
3/8		8-12	6-10	6-10	6-10	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4	3-4	2-3	2-3	2-3
1/2		8-12	6-10	6-10	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4	3-4	2-3	2-3	2-3	2-3
9/16		8-12	6-10	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3	2-3	2-3	2-3	2-3
3/4			6-10	5-8	4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3	2-3	2-3	2-3	2-3	2-3
1-1/8				4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3	2-3	2-3	2-3	2-3	2-3	1-4-2
2						3-4	3-4	3-4	2-3	2-3	2-3	2-3	2-3	2-3	1-4-2	1-4-2	1-4-2
3								2-3	2-3	2-3	2-3	2-3	1-4-2	1-4-2	1-4-2	1-4-2	1-4-2
4									2-3	2-3	1-4-2	1-4-2	1-4-2	1-4-2	1-4-2	1-4-2	1-4-2
5-7/8										2-3	1-4-2	1-4-2	1-4-2	1-4-2	1-0-1-4	1-0-1-4	1-0-1-4
7-7/8											1-4-2	1-4-2	1-4-2	1-0-1-4	1-0-1-4	1-0-1-4	0-75-1-25
9-7/8												1-4-2	1-0-1-4	1-0-1-4	1-0-1-4	0-75-1-25	0-75-1-25
11-3/4													1-0-1-4	1-0-1-4	0-75-1-25	0-75-1-25	0-75-1-25
13-3/4														1-0-1-4	0-75-1-25	0-75-1-25	0-7-1-0
15-3/4															0-75-1-25	0-75-1-25	0-7-1-0
17-3/4																0-7-1-0	0-7-1-0
19-5/8																	0-7-1-0

s = Wall thickness

If you need to cut two or more tubes that are lying side by side, please use this table that takes the double wall thickness into consideration (s).



TOOTH SHAPES

Skip tooth (L)



Rake angle: 0°, for:

- » flexible materials (aluminum and wood)
only available in carbon steel

Standard tooth (S)



Rake angle: 0°, for:

- » short-chipping materials
- » steels with high carbon content
- » tool steel and cast iron
- » materials with small cross-sections
- » thin-walled profiles

Profile tooth (P)



Rake angle: positive, for:

- » hollow and angle profiles
- » steel beams
- » bundle and layer cuts
- » applications that are susceptible to vibrations

Hook tooth (K)



Rake angle: positive, for:

- » universal use
- » non-ferrous metals and steels
- » profiles and solid materials

Tooth shape (HV)



Rake angle: positive and there is a distinct difference in tooth, for:

- » high cutting performance
- » solid material
- » short chip materials
- » tempered steels

Tooth shape (VA)



Rake angle: positive and there is a distinct difference in tooth, for:

- » high cutting performance
- » solid material
- » long chip materials
- » rust and acid-resistant steels
- » superalloys

Trapezoid tooth (T)



Rake angle: positive, for:

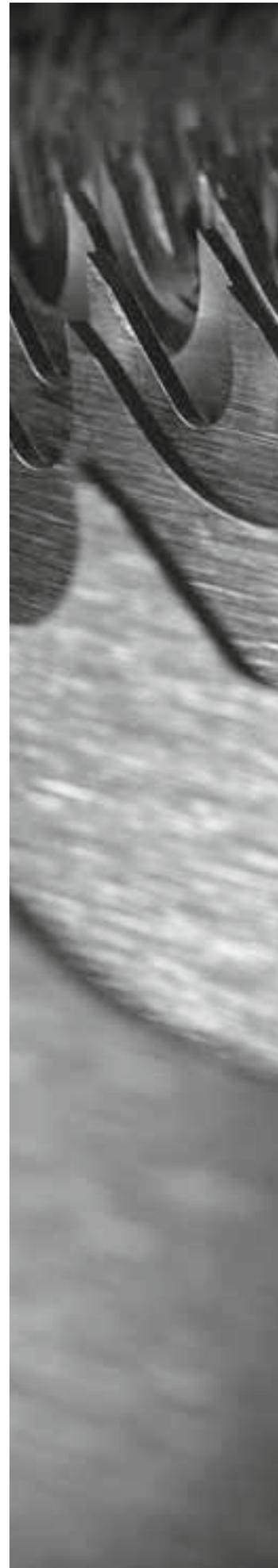
- » high cutting performance
- » best surface finishes

Tooth shape TSN (Trapezoid tooth)



Rake angle: negative, especially for:

- » surface-hardened shafts
- » hardened steels up to 62 HRC, hard manganese steels, hard-chrome plated workpieces
- » diameters up to 11-3/4 inch

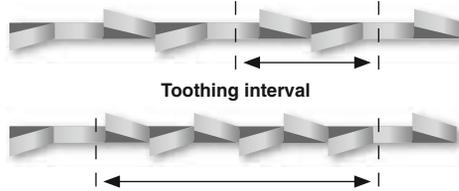




TYPES OF TOOTH SET

The free-cutting action of the band saw blade is achieved by means of the tooth set, where the teeth protrude alternately left and right beyond the blade body.

Standard set (SD)



The standard set is an all-purpose set for cutting thicknesses of more than 0.200 inch with steels, castings and hard non-ferrous metals. With constant tooth pitch, the set sequence is left/right/straight. With variable tooth pitch, one tooth in each toothing interval is unset. The remaining teeth in the interval are recurrently set left/right.

Staggered set (SFN)



The various set widths make it possible to divide the cutting channel more effectively and this, in turn, helps improve performance and extends the blade life.

Group set (GS)



For band saw blades in the tooth pitch range of 4-18 tpi, improved surface quality is obtained with group set.

Wavy set (WS)



We recommend wavy set for material dimensions of up to 0.200 inch, like sheets, thin-walled tubes and profiles.

TOOTH PITCH (T_z)

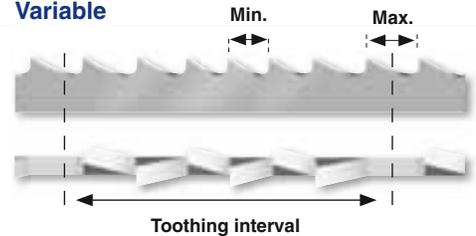
Tooth pitch is defined as the number of teeth per inch (tpi). 1 inch equates to 25.4 mm.

Constant



A distinction is made between constant tooth pitches with a uniform tooth distance and variable tooth pitches with different tooth distances within one toothing interval.

Variable



Variable tooth pitches can be characterized by two measures, e.g. 2-3 tpi. Here, 2 tpi stands for the maximum tooth distance and 3 tpi stands for the minimum tooth distance in the toothing interval.

PRODUCT RANGE



CARBON STEEL BAND SAW BLADES

Sales units:	- coils in fixed lengths and manufacturing coils up to 400 feet, depending on the band width - welded-to-length band saw blades
Band widths:	1/8 to 1-1/2 inches
Constant tooth pitches:	2 to 18 teeth per inch (tpi)
Tooth shapes:	L, S, K
Types of tooth set:	SD, WS, GS



BIMETAL BAND SAW BLADES

Sales units:	- coils in fixed lengths and manufacturing coils up to 400 feet, depending on the band width - welded-to-length band saw blades
Band widths:	5/32 to 4 inches
Constant tooth pitches:	1.25 to 18 teeth per inch (tpi)
Variable tooth pitches:	0.7 - 1.0 to 12 - 16 tpi
Tooth shapes:	S, P, K, HV, VA
Types of tooth set:	SD, GS
Qualities:	HSS-M42: 68 - 69 HRC, approx. 940 - 1,000 HV X3000: approx. 70 HRC, approx. 1,000 HV
Special designs:	PW, PE



CARBIDE BAND SAW BLADES

Sales units:	- coils of 164 feet at max. - welded-to-length band saw blades
Band widths:	1/2 to 4 inches
Constant tooth pitches:	1.25 to 4 teeth per inch (tpi)
Variable tooth pitches:	0.7 - 1.0 to 3 - 4 tpi
Tooth shapes:	S, K, T, TSN
Special designs:	PW



DIAMOND COATED BAND SAW BLADES

Sales units:	- welded-to-length band saw blades
Band widths:	3/8 to 4 inches
Diamond coating:	constant (K), segmented (S), intermittent (U), with 6 to 30 mm pitch
Grit sizes:	D91, D126, D181, D252, D356, D427, D601

N

NORMAL

- 500 EXTRA
- 510 DIAMANT
- 515 JET

B

BASIC

S

SPECIAL

T

TOP LINE

523 ECOFLEX M42

524 PROFLEX M42*

526 BIFLEX M42

528 VARIO M42

529 MARATHON M42

529 MARATHON M42 RS

532 GIGANT M42

534 VECTOR M42

631 MARATHON X3000

633 GIGANT X3000

639 VECTOR X3000

540 TCT

541 DUROSET

542 ECODUR

545 FUTURA

546 FUTURA PLUS

547 FUTURA SN

549 TCTYRE

645 FUTURA VA*

646 FUTURA PLUS SU*

548 FUTURA PREMIUM

648 FUTURA PREMIUM VA

658 FUTURA PREMIUM AL*

668 FUTURA ARION*

* NEW

570 DIAGRIT K

572 DIAGRIT S

574 DIAGRIT U

RECOMMENDATIONS ON USE

CLASSIFICATION	BIMETAL								
	Basic			Special				Top Line	
ARTICLE NO.	524*	528	529	529	532	534	631	633	639
ARTICLE GROUP	PROFLEX	VARIO	MARATHON	MARATHON RS	GIGANT	VECTOR	MARATHON	GIGANT	VECTOR
CUTTING MATERIAL	M42	M42	M42	M42	M42	M42	X3000	X3000	X3000
WORKPIECE DIMENSIONS		●●●	●●●●		●●●	●●●	●●●	●●●	●●●

Standard applications

1	Structural steels, deep drawing steels, machining steels								
2	Case hardened steels, spring steels, quenched and tempered steels								
3	Low alloyed hot-working steels								
4	Nitriding steels, high alloyed hot-working steels								
5	Unalloyed tool steels								
6	Cold working steels								
7	High-speed steels								
8	Cast iron								
9	Rust and acid-resistant steels (light)								
10	Rust and acid-resistant steels (heavy)								
11	Duplex and heat-resistant steels								
12	Nickel-base alloys								
13	Aluminum								
14	Copper								
15	Brass								
16	Aluminum bronze								
17	Titanium alloys								
18	Steels with tensile strength > 1000N/mm ²								
19	Abrasive building materials								
20	Silicon, glass, glass fiber, marble								

Special applications

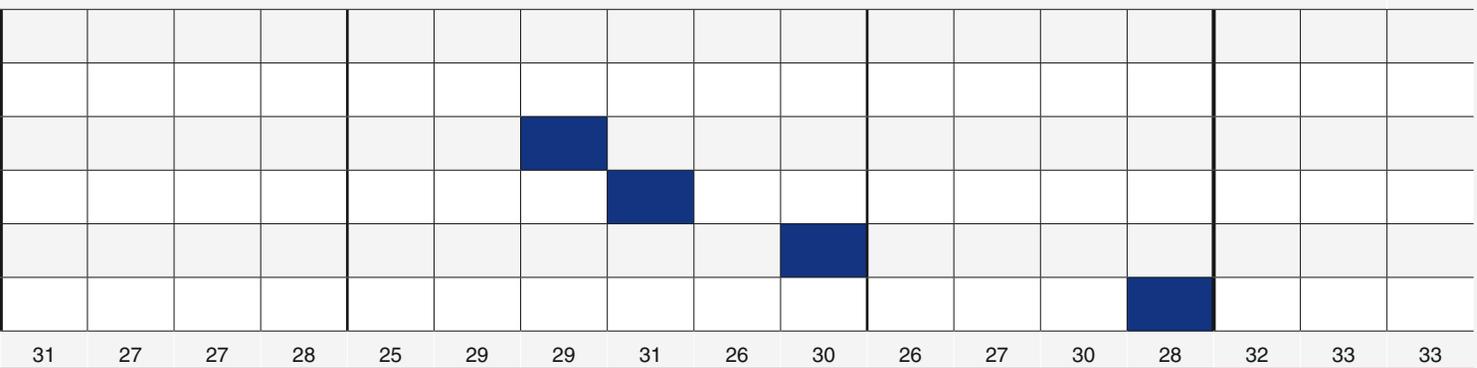
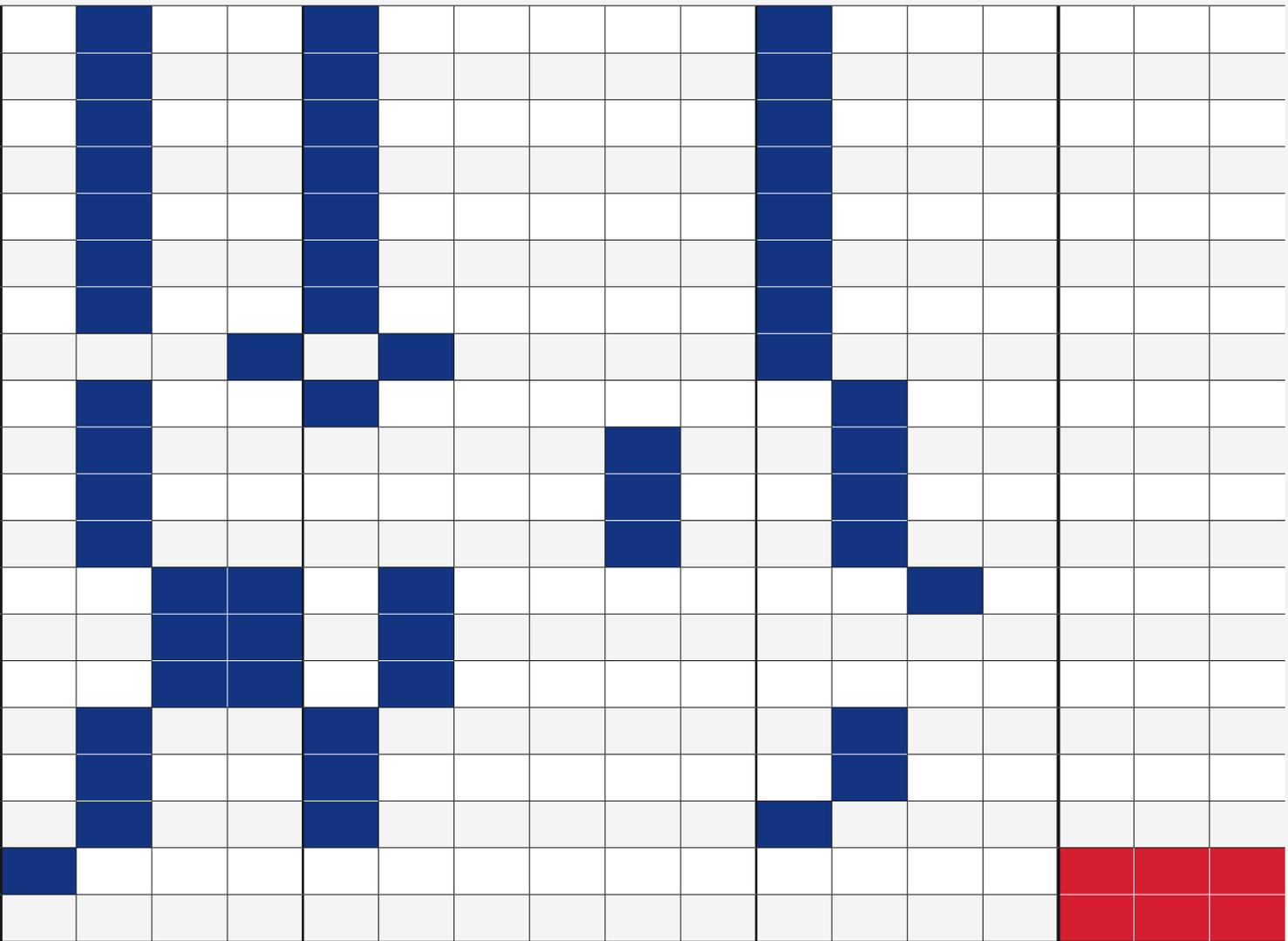
★	Profiles to be cut individually and in bundles / workshop operations								
★	Thick-walled profiles to be cut individually and in bundles								
★	Surface hardened shafts								
★	Tires								
★	Aluminum that places special demands on the chip form								
★	High-performance saws used in special machines								

Page	23	22	19	24	21	20	19	21	20
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Recommendation
 ●●● < 2 inches
●●●● = 2 - 9-3/4 inches
●●●●● > 9-3/4 inches

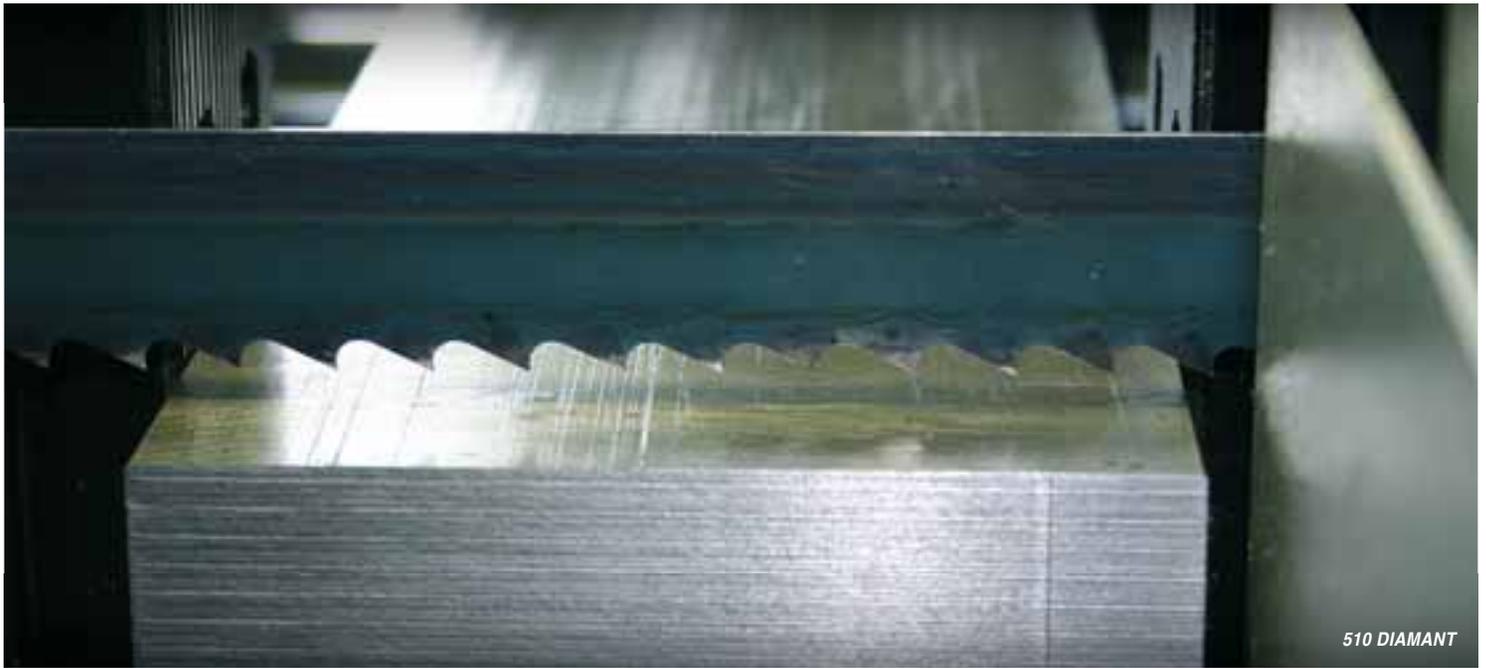
* NEW

CARBIDE														DIAMOND		
Basic				Special						Top Line				Top Line		
540	541	541	542	545	546	547	549	645*	646*	548	648	658*	668*	570	572	574
TCT	DUROSET	DUROSET NE	ECODUR	FUTURA	FUTURA PLUS	FUTURA SN	TCTYRE	FUTURA VA	FUTURA PLUS SU	FUTURA PREMIUM	FUTURA PREMIUM VA	FUTURA PREMIUM AL	FUTURA ARION	DIAGRIT K	DIAGRIT S	DIAGRIT U
Ca	Ca	Ca	Ca	Ca	Ca	Ca	Ca	Ca	Ca	Coated				Dia	Dia	Dia
●●●	●●●	●●●	●●●	●●●	●●●	●●●		●●●		●●●	●●●	●●●	●●●	●●●	●●●	●●●



31 27 27 28 25 29 29 31 26 30 26 27 30 28 32 33 33





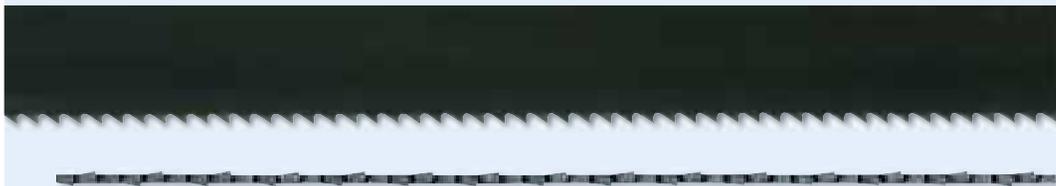
510 DIAMANT

CARBON STEEL PROGRAM

The WIKUS carbon steel program is particularly well-suited for tasks that include everything from basic workshop operations to machining of composite materials.

Hardened tooth tips and an extremely flexible blade body ensure high reliability.

510 DIAMANT



Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

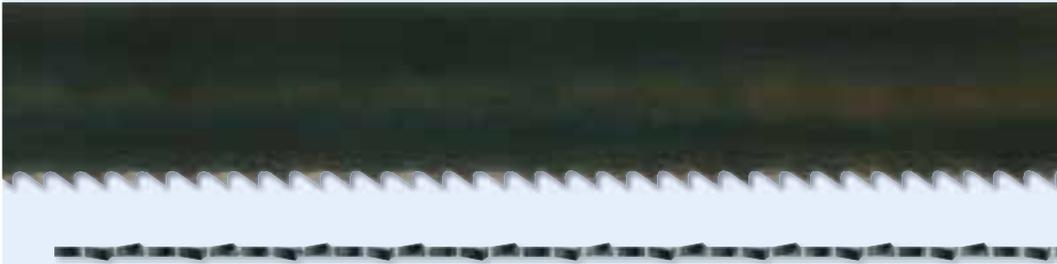
- » For basic workshop operations
- » For low alloy, medium strength steels

Article group 510 DIAMANT (approx. 66-67 HRC)

Dimensions		Tooth pitch in tpi										
Width x Thickness	mm	SD								WS		GS 4
		2	3	4	6	8	10	14	18	14	24	
3 x 0.65	1/8 x 0.025						S	S	S		S	
4 x 0.65	5/32 x 0.025						S	S	S		S	
5 x 0.40	3/16 x 0.016							S			S	
5 x 0.65	3/16 x 0.025						S	S	S		S	
6 x 0.40	1/4 x 0.016				K							
6 x 0.65	1/4 x 0.025			L	S-K	S	S	S	S		S	K
8 x 0.65	5/16 x 0.025			K	S-K	S	S	S	S		S	K
10 x 0.65	3/8 x 0.025		K	K-L	S-K	S	S	S	S		S	
13 x 0.65	1/2 x 0.025		K	S-K	S-K	S	S	S	S		S	
16 x 0.50	5/8 x 0.020					S		S				
16 x 0.65	5/8 x 0.025		K	S-K-L	S-K	S	S			S		
16 x 0.80	5/8 x 0.032		K	K	S-K	S	S			S	S	
20 x 0.80	3/4 x 0.032		S-K	K	S-K	S	S			S		
25 x 0.90	1 x 0.035	K	S-K	S-K	S-K	S	S			S		
32 x 1.10	1-1/4 x 0.042		K	S	S							

L = Skip tooth, S = Standard tooth, K = Hook tooth

500 EXTRA



Article group **500 EXTRA** (approx. 65-66 HRC)

Dimensions Width x Thickness		Tooth pitch in tpi SD							
mm	Inch	2	3	4	6	8	10	14	18
8 x 0.65	5/16 x 0.025			L	S	S	S	S	
10 x 0.65	3/8 x 0.025		L	S-L	S	S	S	S	S
13 x 0.65	1/2 x 0.025		L	S-L	S	S	S	S	S
16 x 0.80	5/8 x 0.032		L	S	S	S	S		
20 x 0.80	3/4 x 0.032		L	S-L	S	S			
25 x 0.90	1 x 0.035	L	L	S-L	S				
32 x 1.10	1-1/4 x 0.042			S	S				
38 x 1.30	1-1/2 x 0.050					S			

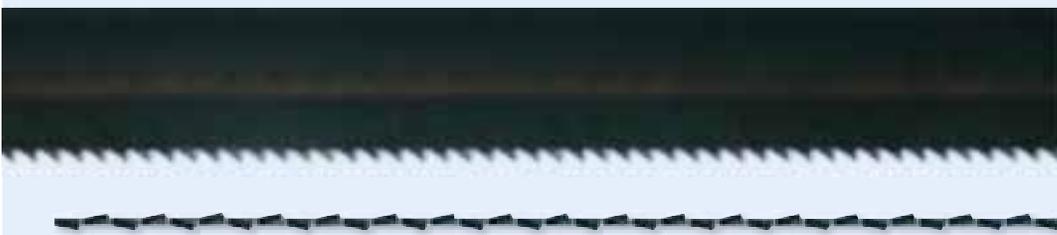
L = Skip tooth, S = Standard tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	★			

- » For basic sawing applications
- » For unalloyed steels of low strength

515 JET



Article group **515 JET** (approx. 63-65 HRC)
Friction band saw blade

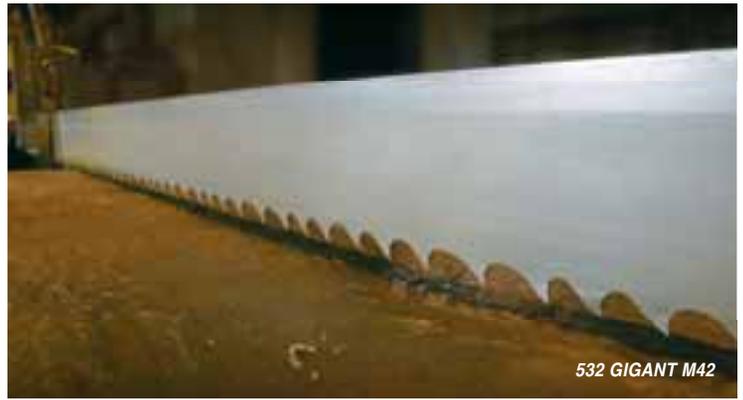
Dimensions Width x Thickness		SD	Tooth pitch in tpi RL			GS
mm	Inch	14	6	8	10	4
10 x 0.65	3/8 x 0.025	S				
16 x 0.80	5/8 x 0.032	S			S	
20 x 0.80	3/4 x 0.032	S			S	
25 x 0.90	1 x 0.035	S	S	S	S	S
32 x 1.10	1-1/4 x 0.042					S

L = Skip tooth, S = Standard tooth, K = Hook tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	★			

- » For friction cutting operations involving special purpose machines
- » For steels of up to 1-1/8 inch in thickness
- » For composite materials



BIMETAL PROGRAM

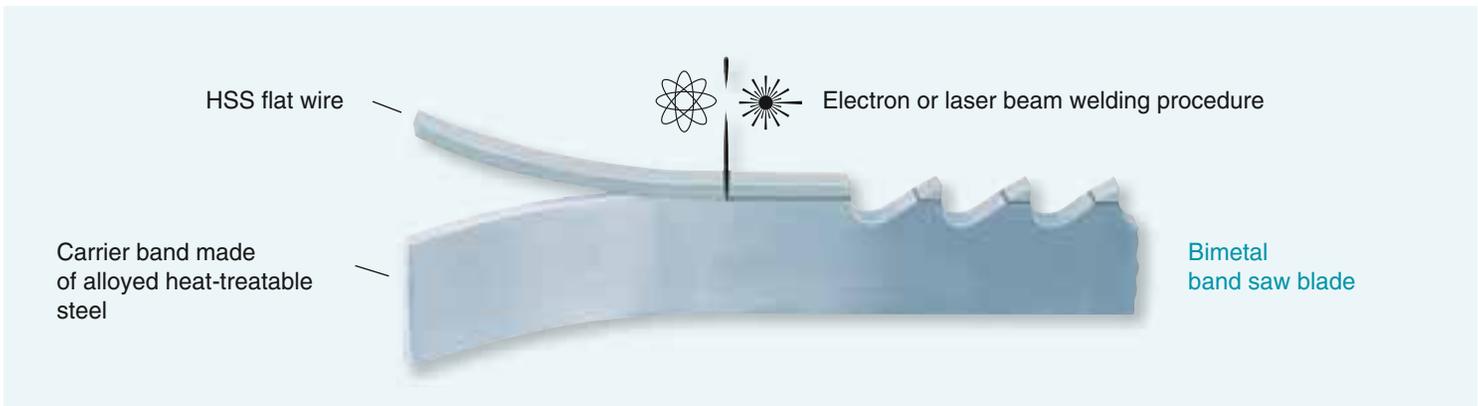
BIMETAL QUALITIES

M42

Wear resistance is the most important characteristic of the cutting material M42. The carbide sizes and their distribution is really what make the difference. The extremely hard special carbides lie embedded inside a temperature-resistant martensitic matrix within a tempering structure. Thanks to our sophisticated heat treatment technique, we were able to achieve an outstanding structural condition.

X3000

The new cutting material generation from WIKUS was designed especially for machining difficult-to-machine materials, rust and acid-resistant materials, as well as nickel-based alloys and highly tempered materials. Extremely high hardness and high resistance are the key characteristics of X3000. This is achieved using a unique heat treatment technique developed by WIKUS.



SPECIAL DESIGNS

Design PW

- Outstanding machining performance and blade life
- For rust and acid-resistant steels, as well as exotic alloys
- Shorter cutting times and a longer lifespan than larger material cross-sections

Available for the item groups: 529, 532, 534, 631, 633, 639

Design PE

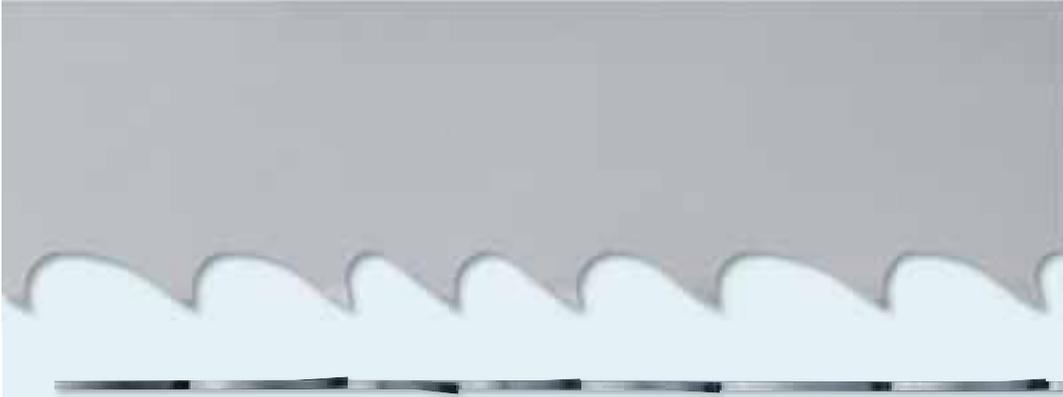
- The highest quality surface thanks to ground tooth sides on both sides
- Adjustment of the cutting widths upon request

Only available with endlessly welded band saw blades.

Available for the item groups: 528, 529, 631

Tooth pitch: 3 - 4 to 10 -14

529 MARATHON® M42



Article group **529 MARATHON M42** (approx. 68-69 HRC)

Dimensions Width x Thickness		Tooth pitch in tpi SD							
mm	Inch	0.75 - 1.25	1.0 - 1.4	1.4 - 2	2 - 3	3 - 4	4 - 5	4 - 6	5 - 8
27 x 0.90	1-1/16 x 0.035				K	K	K	K	K
27 x 1.10	1-1/16 x 0.042					K			
34 x 1.10	1-3/8 x 0.042			K	K	K	K	K	K
38 x 1.30	1-1/2 x 0.050				K*	K*			
41 x 1.30	1-5/8 x 0.050			K	K	K		K	K
54 x 1.30	2-1/8 x 0.050			K	K	K		K	
54 x 1.60	2-1/8 x 0.063	K	K	K	K	K		K	
67 x 1.60	2-5/8 x 0.063	K	K	K	K	K		K	
80 x 1.60	3-1/8 x 0.063	K	K	K	K	K			

K = Hook tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » For universal use and serial cutting
- » For large profiles and solid materials
- » For layer and bundle cutting
- » For steels of up to 40 HRC and non-ferrous metals

* will be discontinued

631 MARATHON® X3000



Article group **631 MARATHON X3000** (approx. 70 HRC)

Dimensions Width x Thickness		Tooth pitch in tpi SD				
mm	Inch	1.4 - 2	2 - 3	3 - 4	4 - 6	5 - 8
27 x 0.90	1-1/16 x 0.035			K	K	K
34 x 1.10	1-3/8 x 0.042		K	K	K	
41 x 1.30	1-5/8 x 0.050		K	K	K	
54 x 1.60	2-1/8 x 0.063	K	K	K	K	
67 x 1.60	2-5/8 x 0.063		K			

K = Hook tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » For materials that are difficult to machine
- » For profiles and solid materials
- » For layer and bundle cutting
- » For high alloy steels of up to 45 HRC

534 VECTOR® M42



Article group **534 VECTOR M42** (approx. 68-69 HRC)

Dimensions		Tooth pitch in tpi		
Width x Thickness		Variable tooth pitch		
mm	Inch	2 - 3	3 - 4	4 - 6
27 x 0.90	1-1/16 x 0.035		HV, VA	HV
34 x 1.10	1-3/8 x 0.042	HV, VA	HV, VA	HV
41 x 1.30	1-5/8 x 0.050	HV, VA	HV, VA	HV
54 x 1.30	2-1/8 x 0.050	HV, VA	HV, VA	
54 x 1.60	2-1/8 x 0.063	HV, VA	HV, VA	
67 x 1.60	2-5/8 x 0.063	HV, VA		

HV = Tooth shape HV, VA = Tooth shape VA

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » For performance-related use
- » For average workpiece dimensions
- » For rustproof and acid-resistant steels (VA)
- » For engineering, heat-treatable and tool steels (HV)
- » For steels of up to 40 HRC

639 VECTOR® X3000



Article group **639 VECTOR X3000** (approx. 70 HRC)

Dimensions		Tooth pitch in tpi		
Width x Thickness		Variable tooth pitch		
mm	Inch	2 - 3	3 - 4	4 - 6
27 x 0.90	1-1/16 x 0.035		HV, VA	HV
34 x 1.10	1-3/8 x 0.042	HV, VA	HV, VA	HV
41 x 1.30	1-5/8 x 0.050	HV, VA	HV, VA	HV
54 x 1.60	2-1/8 x 0.063	HV, VA	HV, VA	
67 x 1.60	2-5/8 x 0.063	HV, VA	HV	
80 x 1.60	3-1/8 x 0.063	HV		

HV = Tooth shape HV, VA = Tooth shape VA

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » For performance-related use
- » For average workpiece dimensions
- » For rustproof and acid-resistant steels, as well as nickel-base alloys (VA)
- » For high alloy steels of up to 45 HRC

532 GIGANT® M42



Article group **532 GIGANT M42** (approx. 68-69 HRC)

Dimensions		Tooth pitch in tpi			
Width x Thickness mm	Inch	Variable tooth pitch			
		0.7 - 1.0	0.75 - 1.25	1.0 - 1.4	1.4 - 2
41 x 1.30	1-5/8 x 0.050				HV, VA
54 x 1.30	2-1/8 x 0.050				HV, VA
54 x 1.60	2-1/8 x 0.063		HV, VA	HV, VA	HV, VA
67 x 1.60	2-5/8 x 0.063		HV, VA	HV, VA	HV, VA
80 x 1.60	3-1/8 x 0.063		HV, VA	HV, VA	HV, VA
100 x 1.60	4 x 0.063	HV			

HV = Tooth shape HV, VA = Tooth shape VA

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » For performance-related use
- » For large workpiece dimensions
- » For rustproof and acid-resistant steels (VA)
- » For engineering, heat-treatable and tool steels (HV)
- » For steels of up to 40 HRC

633 GIGANT® X3000



Article group **633 GIGANT X3000** (approx. 70 HRC)

Dimensions		Tooth pitch in tpi		
Width x Thickness mm	Inch	Variable tooth pitch		
		0.7 - 1.0	1.0 - 1.4	1.4 - 2
41 x 1.30	1-5/8 x 0.050			HV, VA
54 x 1.60	2-1/8 x 0.063		HV, VA	HV, VA
67 x 1.60	2-5/8 x 0.063	HV, VA	HV, VA	HV, VA
80 x 1.60	3-1/8 x 0.063	HV, VA	HV, VA	HV, VA
100 x 1.60	4 x 0.063	HV		

HV = Tooth shape HV, VA = Tooth shape VA

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » For performance-related use
- » For large workpiece dimensions
- » For rustproof and acid-resistant steels, as well as nickel-base alloys (VA)
- » For high alloy steels of up to 45 HRC

528 VARIO® M42



Article group **528 VARIO M42** (approx. 68-69 HRC)

Dimensions Width x Thickness mm Inch		Tooth pitch in tpi SD					
		3 - 4	4 - 6	5 - 8	6 - 10	8 - 12	10 - 14
6 x 0.65	1/4 x 0.025						S
6 x 0.90	1/4 x 0.035						S
10 x 0.90	3/8 x 0.035						S
13 x 0.65	1/2 x 0.025				S	S	S
13 x 0.90	1/2 x 0.035		S	S	S	S	S
20 x 0.90	3/4 x 0.035		S	S	S	S	S
27 x 0.90	1-1/16 x 0.035	S	S	S	S	S	S
34 x 1.10	1-3/8 x 0.042	S	S	S	S	S	
41 x 1.30	1-5/8 x 0.050	S	S	S	S		
54 x 1.30	2-1/8 x 0.050				S		

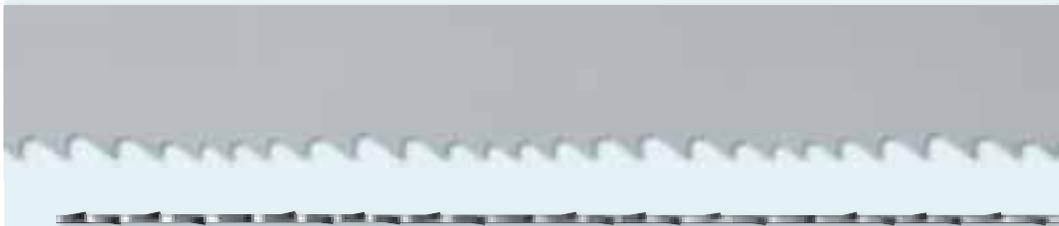
S = Standard tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » For universal use and serial cuts
- » For small and medium-sized workpiece dimensions
- » For steels of up to 40 HRC and non-ferrous metals

523 ECOFLEX® M42



Article group **523 ECOFLEX M42** (approx. 68-69 HRC)

Dimensions Width x Thickness mm Inch		Tooth pitch in tpi SD						
		2 - 3	3 - 4	4 - 6	5 - 8	6 - 10	8 - 12	10 - 14
13 x 0.65	1/2 x 0.025					S	S	S
20 x 0.90	3/4 x 0.035			K	S	S	S	S
27 x 0.90	1-1/16 x 0.035		K	K	S	S	S	S
34 x 1.10	1-3/8 x 0.042	K	K	K	S	S	S	
41 x 1.30	1-5/8 x 0.050	K	K	K	S			

S = Standard tooth, K = Hook tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » For basic workshop operations
- » For small and medium-sized workpiece dimensions
- » For profiles and solid materials

Article group **523 ECOFLEX M42 NE** (approx. 68-69 HRC)

Dimensions Width x Thickness mm Inch		Tooth pitch in tpi Extra wide set		
		2	3	4
20 x 0.90	3/4 x 0.035		K	K
27 x 0.90	1-1/16 x 0.035	K	K	K
34 x 1.10	1-3/8 x 0.042		K	

K = Hook tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » Extra wide set bimetal band saw blade for machining non-ferrous metals

526 BIFLEX® M42



Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	★			

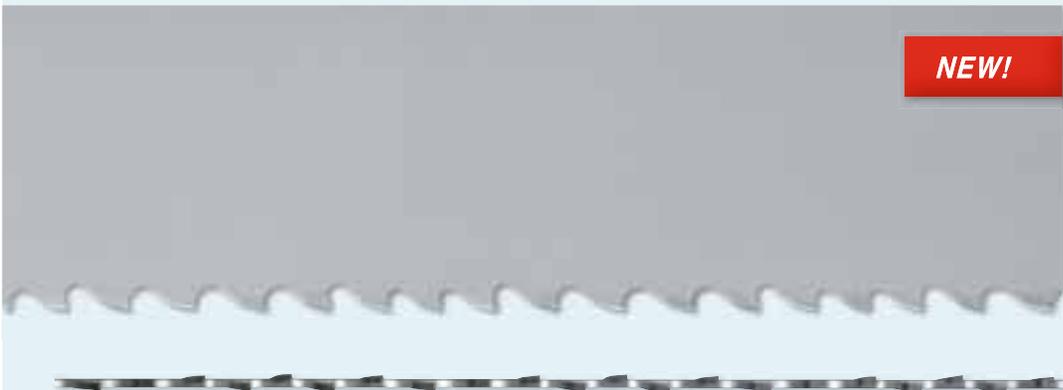
- » For steels of up to 40 HRC and non-ferrous metals
- » For contour cuts

Article group 526 BIFLEX M42 (approx. 68-69 HRC)

Dimensions Width x Thickness mm Inch		Tooth pitch in tpi							
		SD				GS			
		1.25	2	3	4	6	14	14	18
4 x 0.90	5/32 x 0.035						S		
6 x 0.65	1/4 x 0.025					K	S		
6 x 0.90	1/4 x 0.035					K	S		
10 x 0.90	3/8 x 0.035					K	S		
13 x 0.65	1/2 x 0.025				K	K	S		S
13 x 0.90	1/2 x 0.035			K	K	K	S		S
20 x 0.90	3/4 x 0.035			K	K	K	S		S
27 x 0.90	1-1/16 x 0.035			K	K	K		S	S
27 x 1.10	1-1/16 x 0.042			K					
34 x 1.10	1-3/8 x 0.042	K	K	K					
41 x 1.30	1-5/8 x 0.050	K	K	K					

S = Standard tooth, K = Hook tooth

524 PROFLEX® M42



Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	★			

- » Suited for universal workshop operations
- Special tooth geometry for:
 - » Profiles for single, layer and bundle cutting
 - » Steel girders

Article group 524 PROFLEX M42 (approx. 67-68 HRC)

Dimensions Width x Thickness mm Inch		Tooth pitch in tpi				
		2 - 3	3 - 4	5 - 7	8 - 11	12 - 16
20 x 0.90	3/4 x 0.035			P	P	P
27 x 0.90	1-1/16 x 0.035		P	P	P	P
34 x 1.10	1-3/8 x 0.042	P	P	P	P	
41 x 1.30	1-5/8 x 0.050	P	P	P	P	
54 x 1.30	2-1/8 x 0.050	P	P			
54 x 1.60	2-1/8 x 0.063	P	P			
67 x 1.60	2-5/8 x 0.063	P	P			

P = Profile tooth

New tooth geometry

529 MARATHON® M42 RS



Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	★			

» Special geometry for thick-walled tubes with no internal stress

Article group **529 MARATHON M42 RS** (approx. 68-69 HRC)

Dimensions		Tooth pitch in tpi	
Width x Thickness		SD	
mm	Inch	2 - 3	3 - 4
34 x 1.10	1-3/8 x 0.042		K
41 x 1.30	1-5/8 x 0.050	K	K
54 x 1.60	2-1/8 x 0.063	K	K

K = Hook tooth



529 MARATHON M42 RS



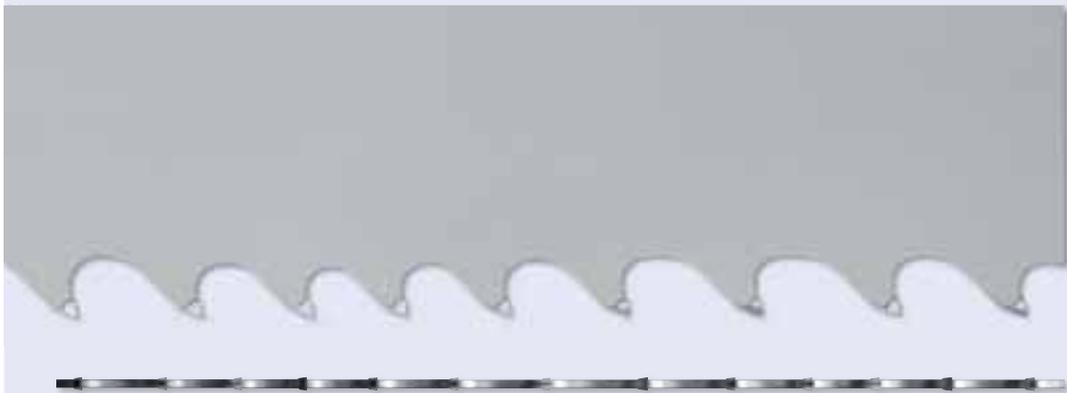
545 FUTURA

CARBIDE PROGRAM

Carbide band saw blades from WIKUS have set teeth and are available with a special trapezoid tooth. Thanks to the different degrees of hardness and compositions, the carbides used deliver excellent results every time they're put to use.

The long blade life and extremely high performances our premium products offer are made possible by using the best possible backing material. The following article groups are also available in the special design PW: 541, 545, 548, 645, 648

545 FUTURA®



Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

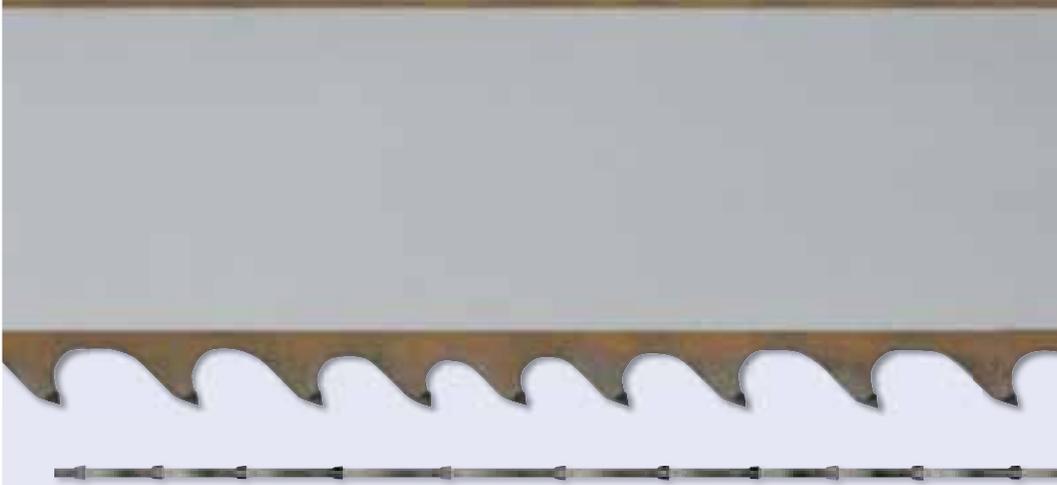
- » Innovative tooth geometry for high cutting power
- » For universal use with steels

Article group 545 FUTURA (approx. 1600 HV)

Dimensions		Tooth pitch in tpi					
Width x Thickness							
mm	Inch	0.85 - 1.15	1.0 - 1.4	1.4 - 2	2 - 3	3	3 - 4
27 x 0.90	1-1/16 x 0.035					T	T
34 x 1.10	1-3/8 x 0.042				T		T
41 x 1.30	1-5/8 x 0.050			T	T		T
54 x 1.30	2-1/8 x 0.050			T	T		T
54 x 1.60	2-1/8 x 0.063	T	T	T	T		
67 x 1.60	2-5/8 x 0.063	T	T	T	T		
80 x 1.60	3-1/8 x 0.063	T	T	T			

T = Trapezoid tooth

548 FUTURA® PREMIUM



Article group **548 FUTURA PREMIUM** (approx. 3800 HV)

Dimensions		Tooth pitch in tpi				
Width	Thickness	SD				
mm	Inch	0.85 - 1.15	1.0 - 1.4	1.4 - 2	2 - 3	3 - 4
34 x 1.10	1-3/8 x 0.042				T	T
41 x 1.30	1-5/8 x 0.050			T	T	T
54 x 1.60	2-1/8 x 0.063		T	T	T	
67 x 1.60	2-5/8 x 0.063	T	T	T	T	T
80 x 1.60	3-1/8 x 0.063	T	T			

T = Trapezoid tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » Coated carbide band saw blade for outstanding cutting performance
- » For engineering, heat-treatable and tool steels

645 FUTURA® VA



Article group **645 FUTURA VA** (approx. 1600 HV)

Dimensions		Tooth pitch in tpi				
Width	Thickness	SD				
mm	Inch	0.85 - 1.15	1.0 - 1.4	1.4 - 2	2 - 3	3 - 4
34 x 1.10	1-3/8 x 0.042				T	
41 x 1.30	1-5/8 x 0.050			T	T	T
54 x 1.30	2-1/8 x 0.050			T	T	
54 x 1.60	2-1/8 x 0.063	T		T	T	
67 x 1.60	2-5/8 x 0.063	T	T	T		
80 x 1.60	3-1/8 x 0.063	T				

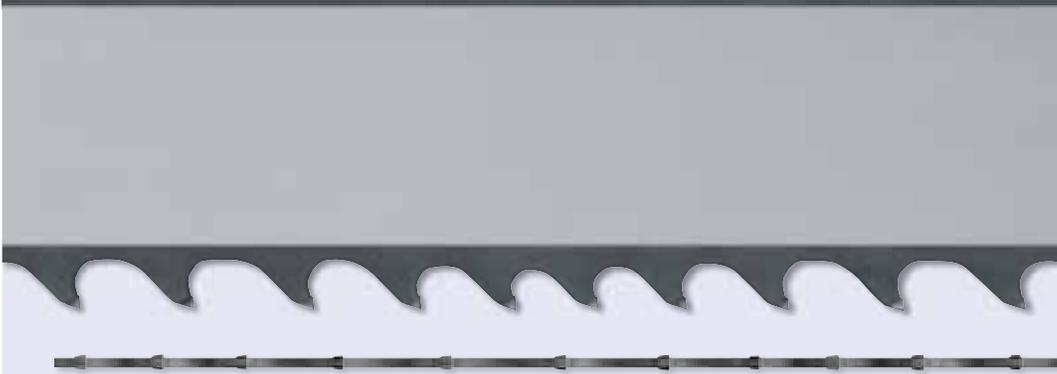
T = Trapezoid tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- Optimized tooth geometry for:
- » Rustproof and acid-resistant steels, as well as nickel-base alloys (VA)
 - » Titanium and special alloys

648 FUTURA® PREMIUM VA



Article group **648 FUTURA PREMIUM VA** (approx. 3800 HV)

Dimensions		Tooth pitch in tpi				
Width	Thickness	SD				
mm	Inch	0.85 - 1.15	1.0 - 1.4	1.4 - 2	2 - 3	3 - 4
41 x 1.30	1-5/8 x 0.050			T	T	T
54 x 1.60	2-1/8 x 0.063			T	T	
67 x 1.60	2-5/8 x 0.063		T	T		
80 x 1.60	3-1/8 x 0.063	T				

T = Trapezoid tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » Coated carbide band saw blade for outstanding cutting performance
- » For rustproof and acid-resistant steels, as well as nickel-base alloys (VA)
- » For titanium and special alloys

541 DUROSET®



Article group **541 DUROSET** (approx. 1600 HV)

Dimensions		Tooth pitch in tpi				
Width	Thickness	SD				
mm	Inch	0.7 - 1.0	1.0 - 1.4	1.4 - 2	2 - 3	3 - 4
27 x 0.90	1-1/16 x 0.035					K
34 x 1.10	1-3/8 x 0.042				K	K
41 x 1.30	1-5/8 x 0.050			K	K	K
54 x 1.60	2-1/8 x 0.063			K	K	K
67 x 1.60	2-5/8 x 0.063		K	K		
80 x 1.60	3-1/8 x 0.063	K	K			

K = Hook tooth

Article group **541 DUROSET NE** (approx. 1600 HV)

Dimensions		Tooth pitch in tpi	
Width	Thickness	Extra wide set	
mm	Inch	2	3
20 x 0.80	3/4 x 0.032		K
27 x 0.90	1-1/16 x 0.035		K
34 x 1.10	1-3/8 x 0.042	K	K

K = Hook tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

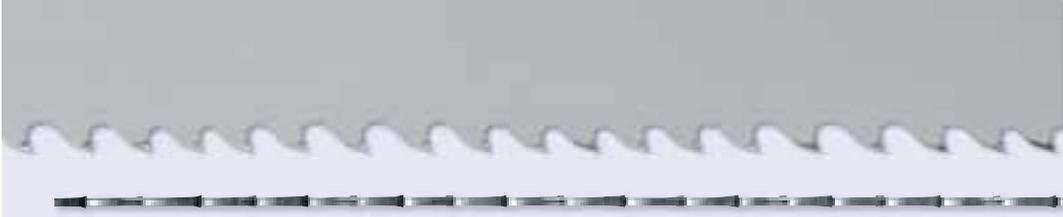
- » Set carbide band saw blade for machining steels
- » For band saw machines without a carbide package

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » Extra wide set carbide band saw blade for machining non-ferrous metals
- » For manual foundry applications

542 ECODUR®



Article group **542 ECODUR** (approx. 1700 HV)

Dimensions Width x Thickness mm Inch		Tooth pitch in tpi SD			
		0.85 - 1.15	1.4 - 2	2 - 3	3 - 4
13 x 0.80	1/2 x 0.032				T
20 x 0.80	3/4 x 0.032				T
27 x 0.90	1-1/16 x 0.035				T
34 x 1.10	1-3/8 x 0.042		T	T	T
41 x 1.30	1-5/8 x 0.050		T	T	T
54 x 1.30	2-1/8 x 0.050		T	T	
54 x 1.60	2-1/8 x 0.063	T	T	T	
67 x 1.60	2-5/8 x 0.063		T		

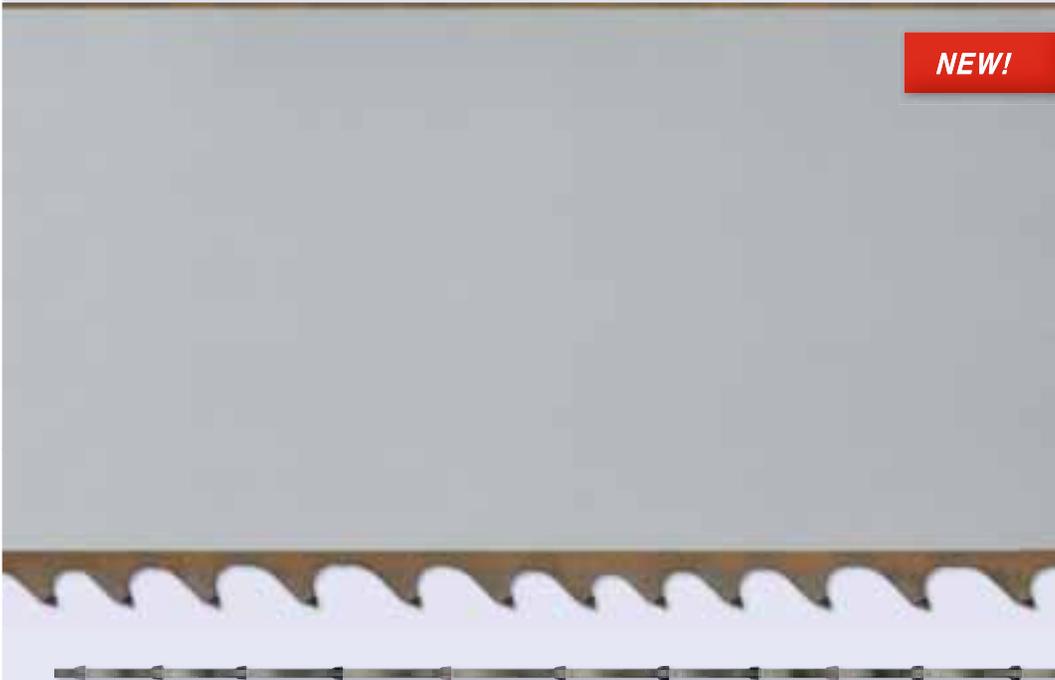
T = Trapezoid tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

» Universal use in steels and non-ferrous metals

668 FUTURA® ARION



Article group **668 FUTURA ARION** (approx. 3800 HV)

Dimensions Width x Thickness mm Inch		Tooth pitch in tpi SD	
		1.4 - 2	2 - 3
80 x 1.10	3-1/8 x 0.042	T	T
100 x 1.10	4 x 0.042	T	T

T = Trapezoid tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » Coated carbide band saw blade for outstanding cutting performance and high productivity on special machines
- » For mass cuts and manufacturing short products from solid materials
- » For engineering, heat-treatable and tool steels

547 FUTURA® SN



Article group **547 FUTURA SN** (approx. 1600 HV)

Dimensions Width x Thickness		Tooth pitch in tpi	
mm	Inch	2 - 3	3 - 4
27 x 0.90	1-1/16 x 0.035		TSN
34 x 1.10	1-3/8 x 0.042	TSN	TSN
41 x 1.30	1-5/8 x 0.050	TSN	TSN
54 x 1.60	2-1/8 x 0.063	TSN	TSN

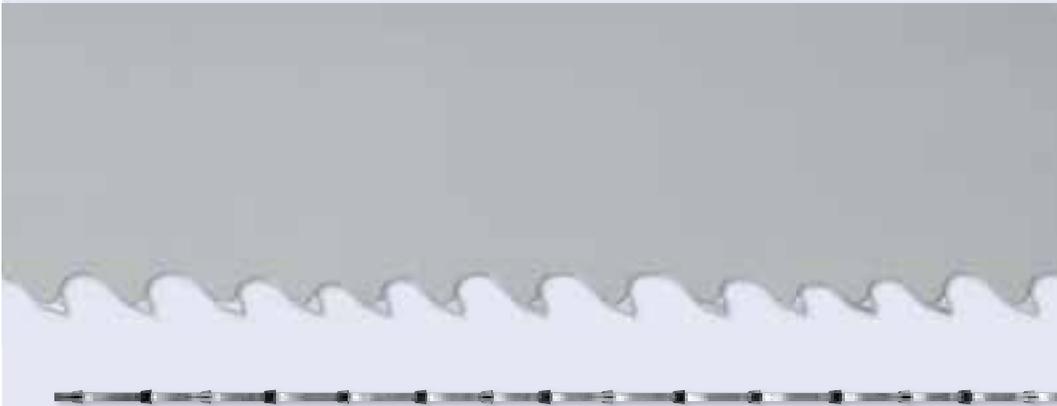
TSN = Tooth shape TSN

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	★			

- » Special geometry for meeting the highest demands for performance with surface hardened components
- » Suited for up to 65 HRC

546 FUTURA® PLUS



Article group **546 FUTURA PLUS** (approx. 1700 HV)

Dimensions Width x Thickness		Tooth pitch in tpi						
mm	Inch	0.85 - 1.15	1.0 - 1.4	1.4 - 2	2	2 - 3	3	3 - 4
27 x 0.90	1-1/16 x 0.035						T	T
34 x 1.10	1-3/8 x 0.042			T	T	T		T
41 x 1.30	1-5/8 x 0.050			T	T	T		T
54 x 1.30	2-1/8 x 0.050		T	T		T		
54 x 1.60	2-1/8 x 0.063	T	T	T		T		
67 x 1.60	2-5/8 x 0.063	T	T	T				
80 x 1.60	3-1/8 x 0.063	T	T					

T = Trapezoid tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	★			

- » High cutting performance with non-ferrous metals
- » For excellent finish qualities
- » For foundry applications

646 FUTURA® PLUS SU



Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	★			

- » Special geometry for optimum chip formation with aluminum alloys
- » High cutting performance
- » For excellent finish qualities

Article group **646 FUTURA PLUS SU** (approx. 1600 HV)

Dimensions		Tooth pitch in tpi			
Width x Thickness		0.7 - 1.0	0.85 - 1.15	1.4 - 2	2 - 3
mm	Inch				
41 x 1.30	1-5/8 x 0.050			T	T
54 x 1.30	2-1/8 x 0.050		T	T	
54 x 1.60	2-1/8 x 0.063		T		
67 x 1.60	2-5/8 x 0.063	T	T		
80 x 1.60	3-1/8 x 0.063	T			

T = Trapezoid tooth

658 FUTURA® PREMIUM AL



Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	★			

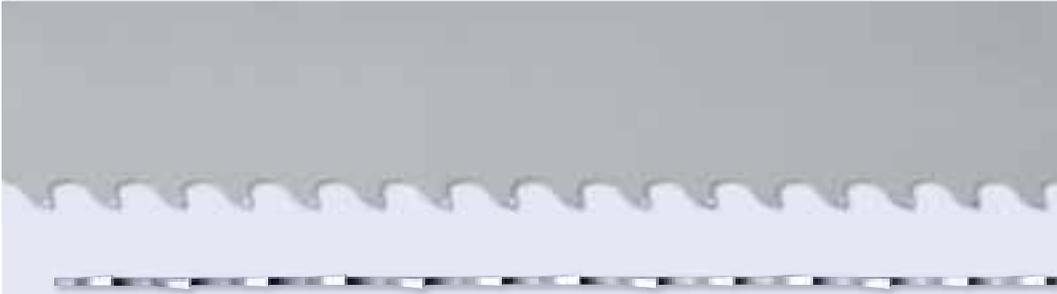
- » Coated carbide band saw blade for excellent cutting performance, particularly with aluminum and aluminum alloys

Article group **658 FUTURA PREMIUM AL** (approx. 3800 HV)

Dimensions		SD
Width x Thickness		1.4 - 2
mm	Inch	
34 x 1.10	1-3/8 x 0.042	T
41 x 1.30	1-5/8 x 0.050	T

T = Trapezoid tooth

540 TCT



Article group **540 TCT** (approx. 1900 HV)

Dimensions Width x Thickness		Tooth pitch in tpi SD			
mm	Inch	1.25	2	3	4
13 x 0.80	1/2 x 0.032				S-K
20 x 0.80	3/4 x 0.032			S-K	S
27 x 0.90	1-1/16 x 0.035		S-K	S-K	S-K
34 x 1.10	1-3/8 x 0.042		K	S-K	
41 x 1.30	1-5/8 x 0.050	K	K	K	

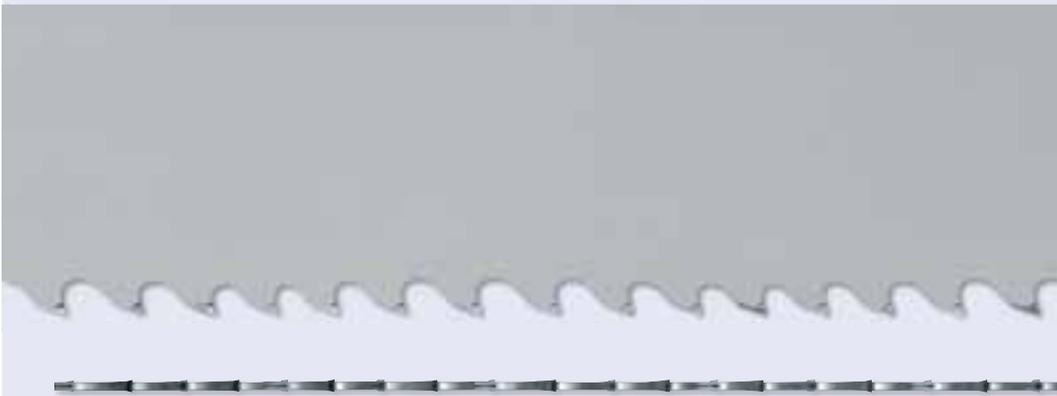
S = Standard tooth, K = Hook tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	★			

- » For abrasive and mineral materials
- » For graphite
- » For sanded gray iron

549 TCTYRE®



Article group **549 TCTYRE** (approx. 1700 HV)

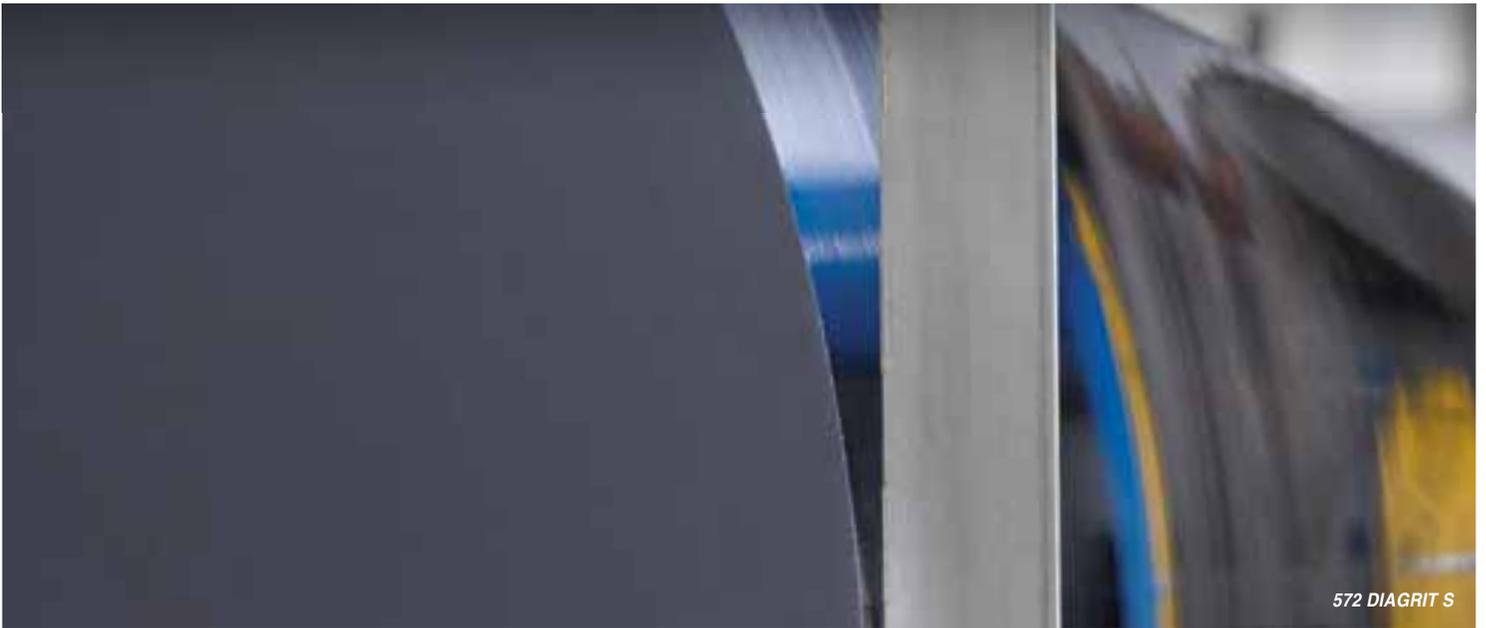
Dimensions Width x Thickness		Tooth pitch in tpi	
mm	Inch	2 - 3	3 - 4
27 x 0.90	1-1/16 x 0.035	T	T
34 x 1.10	1-3/8 x 0.042	T	T
41 x 1.30	1-5/8 x 0.050	T	T
54 x 1.60	2-1/8 x 0.063	T	

T = Trapezoid tooth

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	★			

- » A specially developed band saw blade for tires



572 DIAGRIT S

DIAMOND PROGRAM

As the hardest material known to man, diamonds are capable of cutting any material, as well as alloys.

The unique properties of the backing materials developed for WIKUS are perfectly suited for standing up to the stress these extremely high cutting speeds cause.

The WIKUS Diamond program consists of seven grain sizes: D91, D126, D181, D252, D356, D427, D601

Other dimensions beyond those included in the product program, as well as VA backing materials, are available upon request.

Due to the rather unique applications of DIAGRIT, we generally recommend that you contact us for advice first.

570 DIAGRIT® K



Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » For performance-related use
- » For small workpiece dimensions

Continuous coating K

Alternative band dimensions upon request.

Article group 570 DIAGRIT K (approx. 9000 HV)

Dimensions Width x Thickness		Dimensions Width x Thickness		Dimensions Width x Thickness	
mm	Inch	mm	Inch	mm	Inch
10 x 0.50	3/8 x 0.020	20 x 0.80	3/4 x 0.032	41 x 0.50	1-5/8 x 0.020
10 x 0.65	3/8 x 0.025	25 x 0.65	1 x 0.025	41 x 0.80	1-5/8 x 0.032
13 x 0.65	1/2 x 0.025	27 x 0.50	1-1/16 x 0.020	41 x 1.30	1-5/8 x 0.050
13 x 0.80	1/2 x 0.032	27 x 0.70	1-1/16 x 0.028	50 x 0.90	2 x 0.035
16 x 0.50	5/8 x 0.020	27 x 0.90	1-1/16 x 0.035	54 x 1.10	2-1/8 x 0.042
16 x 0.65	5/8 x 0.025	34 x 0.90	1-3/8 x 0.035		
20 x 0.50	3/4 x 0.020	34 x 1.10	1-3/8 x 0.042		

572 DIAGRIT® S



Article group **572 DIAGRIT S** (approx. 9000 HV)

Dimensions Width x Thickness		Dimensions Width x Thickness		Dimensions Width x Thickness	
mm	Inch	mm	Inch	mm	Inch
10 x 0.50	3/8 x 0.020	20 x 0.80	3/4 x 0.032	41 x 0.50	1-5/8 x 0.020
10 x 0.65	3/8 x 0.025	25 x 0.65	1 x 0.025	41 x 0.80	1-5/8 x 0.032
13 x 0.65	1/2 x 0.025	27 x 0.50	1-1/16 x 0.020	41 x 1.30	1-5/8 x 0.050
13 x 0.80	1/2 x 0.032	27 x 0.70	1-1/16 x 0.028	50 x 0.90	2 x 0.035
16 x 0.50	5/8 x 0.020	27 x 0.90	1-1/16 x 0.035	54 x 1.10	2-1/8 x 0.042
16 x 0.65	5/8 x 0.025	34 x 0.90	1-3/8 x 0.035		
20 x 0.50	3/4 x 0.020	34 x 1.10	1-3/8 x 0.042		

Material groups

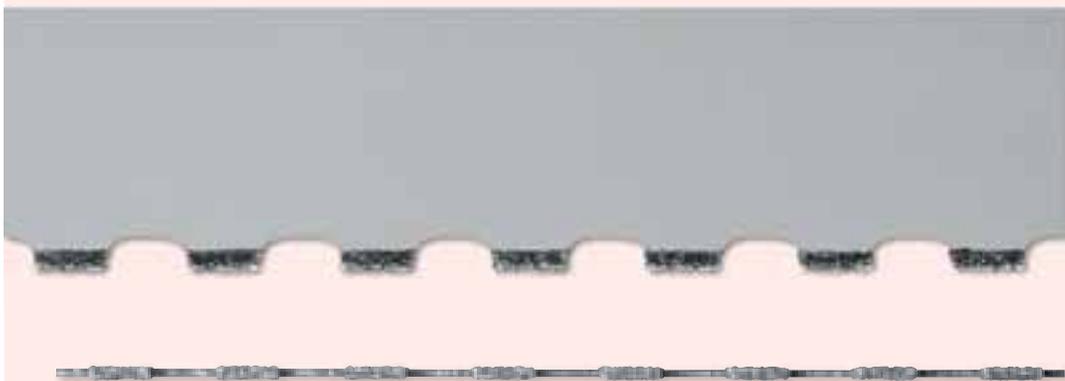
1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » For performance-related use
- » For average workpiece dimensions

Segmented coating S

Alternative band dimensions upon request.

574 DIAGRIT® U



Article group **574 DIAGRIT U** (approx. 9000 HV)

Dimensions Width x Thickness		Gap pitch T	Dimensions Width x Thickness		Gap pitch T
mm	Inch	mm	mm	Inch	mm
10 x 0.50	3/8 x 0.020	6	34 x 1.10	1-3/8 x 0.042	20
10 x 0.65	3/8 x 0.025	6	41 x 0.50	1-5/8 x 0.020	20
13 x 0.65	1/2 x 0.025	8	41 x 0.80	1-5/8 x 0.032	20
16 x 0.65	5/8 x 0.025	8	41 x 1.30	1-5/8 x 0.050	20
20 x 0.50	3/4 x 0.020	8	50 x 0.90	2 x 0.035	20
20 x 0.80	3/4 x 0.032	8	54 x 1.10	2-1/8 x 0.042	20
27 x 0.50	1-1/16 x 0.020	12	54 x 1.60	2-1/8 x 0.063	20
27 x 0.70	1-1/16 x 0.028	12	67 x 1.60	2-5/8 x 0.063	30
27 x 0.90	1-1/16 x 0.035	12	80 x 1.10	3-1/8 x 0.042	12
34 x 0.90	1-3/8 x 0.035	20	100 x 1.10	4 x 0.042	12/30

Material groups

1	2	3	4	5	6	7	8
9	10	11	12	13	14	15	16
17	18	19	20	*			

- » For performance-related use
- » For large workpiece dimensions

Intermittent coating U

Alternative band dimensions upon request.

BAND SAW BLADE DIMENSIONS AND MACHINE TYPES

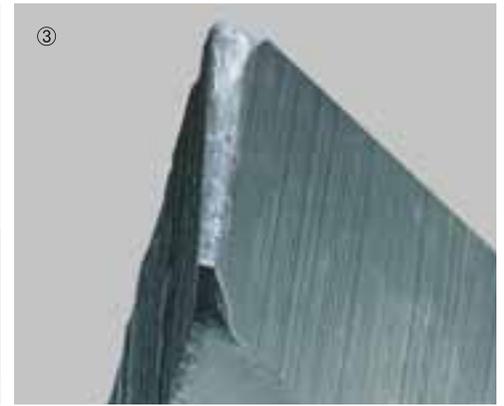
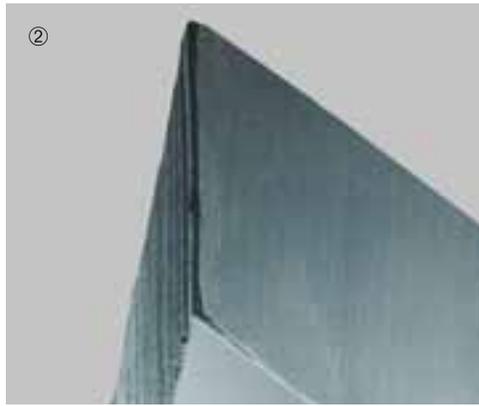
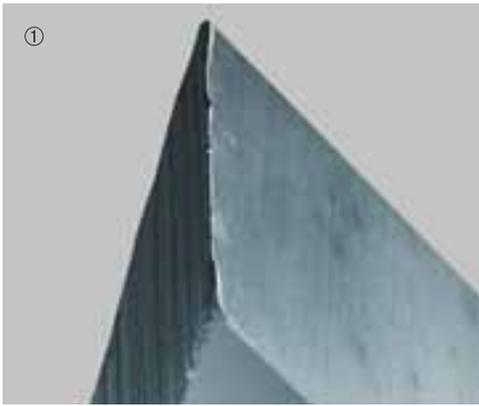
NEW - Effective immediately, we will be offering an interactive overview of the most common band saw machines, including the appropriate saw band dimensions for WIKUS band saw blades, on our website.
www.wikus.com



AMADA, BAUER, BEHRINGER, BERG & SCHMID, BIANCO, BTM, CARIF, COSEN, DAITO, DANOBAT, DELTA, DOALL, EISELE, EVERISING, FMB, FORTE, FRANHO, FRIGGI, HEM, HESKA, HYD MECH, INDORE, INDOTECH MACHINES, PVT. LTD., JAESPA, JJ MACHINE TOOLS, KALTENBACH, KASTO, KLAEGER, MALWA MACHINE TOOLS,

MARVEL, MEBA, MEGA, MEP, METALIN, METORA, MISTRY LAXMAN KADVA & CO., MÖSSNER, MÜLLER, MULTICUT MACHINE TOOLS, PEHAKA, PEDRAZZOLI, RÜSCH, SABI, SPM, THOMAS, TRENNJÄGER. UZAY MAKINA. WAGNER, WAY TRAIN, WOO SUNG, WOO YOUNG, ETC.





Correct break-in procedure guarantees long blade life

1. New cutting edge with very small edge radius
2. Proper break-in of the band saw blade creates a stable cutting edge
3. Excessive strain due to improper breaking-in leads to micro-breakages of the cutting edge

BREAKING-IN YOUR BAND SAW BLADES

Bimetal band saw blades

Sharp cutting edges that have extremely small edge radii are required for high cutting power. WIKUS blades are predestined for that.

To achieve the longest possible blade life, we recommend breaking in the blade properly. Please determine the correct cutting speed (ft/min) depending on the material to be cut and its dimension. Our cutting data slide rule is a helpful tool. It is important to break-in a new blade with only 50% feed rate. Micro breakages caused by excessive chip thicknesses can thus be avoided.

New band saw blades can cause vibrations and make noise. In this case, a slight reduction of cutting speed is also helpful. With small workpiece dimensions, approx. 118 inches² of the material should be cut to break-in the blade. In case of large workpiece dimensions, we recommend breaking-in over a period of about 15 min.

After breaking-in, the feed rate may be increased slowly up to the full value.

Carbide band saw blades

After choosing the optimal parameters for your application by using our carbide data slide rule, you should break-in a carbide-tipped band saw blade with approx. 50% feed rate and 50% cutting speed.

It is very important to avoid vibrations and noise. In such cases, it should help to reduce the cutting speed.

After a breaking-in period of about 15 min or 118 inches², please slowly increase the cutting speed and then the feed rate up to the full value.

Further to the band tension, which should be about 300 N/mm², please also check the oil content of the cooling lubricant before first use. Hand refractometers and band tension gauges are available from WIKUS.

Practical assistance: ParaMaster 2.0 and a cutting data slide

High durability and a long service life of band saw blades can only be guaranteed if they are used properly and exact machining parameters are observed.

We now offer our customers a very special service over the Internet. With **ParaMaster 2.0**, the **online cutting data program from WIKUS**, you'll be able to determine the proper band saw blade for each application and every machine with the help of appropriate parameters. 50 years of experience in a single program with a database that is updated every day!

The **cutting data slide** we developed for bimetal and carbide saw blades also offers practical assistance.

MATERIALS AND STANDARDS

MATERIAL GROUPS	MATERIAL NUMBER	DIN
1 Structural steels, deep drawing steels, machining steels	1.0037, 1.0301, 1.0721, 1.0040, 1.0401	St37, St42, C10, C15, 10 S 20
2 Case hardened steels, spring steels, quenched and tempered steels	1.0050, 1.0060, 1.0501, 1.0503	St 50, St 60, C35, C45
3 Low alloyed hot-working steels	1.7131, 1.7225, 1.8159, 1.2311, 1.2714	16 Mn Cr 5, 42 CrMo 4, 50 Cr V 4, 40 Cr Mn Mo 7, 55 Ni Cr Mo V 6
4 Nitriding steels, high alloyed hot-working steels	1.2344, 1.2738	X 40 Cr Mo V 5 1, 40 Cr Mn Ni Mo 8 6 4
5 Unalloyed tool steels	1.3505, 1.1663	100 Cr 6, C 125 W
6 Cold working steels	1.2080, 1.2379	X 210 Cr 12, X 155 Cr V Mo 12 1
7 High-speed steels	1.3343, 1.3247	S 6-5-2, S 2-10-1-8
8 Cast iron	0.6015, 0.6030, 0.7050	GG 15, GG 30, GGG 50
9 Rust and acid-resistant steels (light)	1.4057, 1.4028, 1.2083	X 17 Cr Ni 16-2, X30Cr 13, X42 Cr 13
10 Rust and acid-resistant steels (heavy)	1.4301, 1.4404, 1.4571	X 5 Cr Ni 18-10, X 2 Cr Ni Mo 17-12-2, X 6 Cr Ni Mo 17-12-2
11 Duplex and heat-resistant steels	1.4462, 1.4841	X2 Cr Ni Mo N 22-5-3, X 15 Cr Ni Si 25-25
12 Nickel-base alloys	2.4668, 2.4610, 2.4632	Ni Cr 19 NbMo, Ni Mo 16 Cr 16 Ti
13 Aluminum	3.0285, 3.3547, 3.2581	AlMg3, AlSi 12, AlMg4,5 Mn
14 Copper	2.0050	Cu 99,9
15 Brass	2.0321, 2.0402	Cu Zn 37, Cu Zn 40 Pb 2
16 Aluminum bronze	2.0976, 2.0941, Ampco	CuAl 10 Ni, CuAl 10 Fe
17 Titanium alloys	3.7025, 3.7164	Ti 1, Ti-6Al-4V
18 Steels with tensile strength > 1000N/mm ²		
19 Abrasive building materials		
20 Silicon, glass, glass fiber, marble		



With **ParaMaster 2.0**, WIKUS offers its customers a superior quality online cutting data program. It contains 150,000 materials based on all of the most common standards and thus helps you to find the perfect band saw blade for your application.

AISI / ASTM / SAE	JIS	BS	AFNOR
1015, 1005, A242, 1212	STKM 12A, SN400 B, SUM 21	En 40 B, En 2 A	E24, E27, XC10, XC 15
1040, 1060, A572	SS490, SM 570, S 45 CM	E355, E395, EN 8	XC 48
5115, 4140, 6150, P20, L6; 4340	SCM 420H, SNCM 22, SCM 440, SUP 10, SKT 4	EnN19, 735 A 51, EN 47, 620, 632	16MC5, 42CD4, 50CV4, 40CMD7, 55 NCDV7
H-13, H-14, H-21, HNV 3	SKD 61, SKD 11, Sk 4	BH11, BH 13	Z40CDV5, 40CMND8
52100, 50100, L3, W2	Sk2, SK5, SUJ 2	BL3, BA2	100C6
D-2, D-3, D-7, O-2, O-6	SKD 1, SKD 11	BD3, Grade 2, GHC 134	Z160CDV12, Z200C12
M-2, M-7, M42, T-5, T-15	SKH 51, SKH 59, SKH 2	BT42, BM 35, BM 2	HS6-5-2, HS2-9-1-8
Class 20, Class 40, Class 60	FC 150, FC 300, FGS 500	Grade 150, Grade 300	GJS500-7U, GS60
431, 430, 403, 405, 420	SUS 420 J1, SDS416, SUS 431	J91151, 416S37	Z 15 CN 16-02, Z 33 C 13, Z 40 C 14
316, 304, 440	SUS 304, SUS316, 17-7PH	EN58E, 301s22, J92590	304L, 316L
309, 310, Incoloy	SUS630, SUH310	NA15, 254SMO, 347	Z 3 CND 22-05, 314
Inconel, Hastelloy, Nimonic, Monel, Rene 41	NCF600	NA13, NA19, Alloy 718	INCO 718 Thermax90
2017, 1000, 7075	A2017, A1050, A7075		A5, AU 4 G, Au 2 GT
101, 172	C1020		Cu 99,9
	C2720P, C2720R		Cu Zn 37, Cu Zn 40 Pb 2
	CAC703, CAC701		CuAl 10 Ni, CuAl 10 Fe, AMPCO
			TA 6V

Standard sizes, not a comparison





Headquarters
in Spangenberg, Germany

TOP QUALITY MADE IN SPANGENBERG

A horse stable in Spangenberg marked the starting point for our company's history way back in 1958. With more than 70 representations today, we are present in close proximity to our customers all over the world.

If you have any questions on our product range or customized expandable solutions that suit your applications, please contact one of our technical service engineers.

You will find current and detailed information on our products as well as many helpful tips on our website: www.wikus.com

- » Over 50 years of experience in developing and manufacturing high-performance tools
- » Highly qualified employees
- » Continuous development of innovative solutions
- » A product range that includes more than 1,400 product variations
- » Europe's largest manufacturer of band saw blades and one of the global market leaders in sawing metal
- » The first European manufacturer of band saw blades to receive DIN EN ISO 9001 certification back in 1994



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ISO 9001:2008 CERTIFIED



Precision at the cutting point

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info@wikus.com

PRECISION AT THE CUTTING POINT

WIKUS has been manufacturing advanced band saw blades for use by industry and trade since 1958. Today, we are one of the global market leaders when it comes to sawing metal and Europe's largest manufacturer of band saw blades. WIKUS band saw blades can be found wherever there is a demand for unsurpassed precision, perfect finish quality and maximum performance.

This is particularly true with even more complex production methods like those used in the automotive industry, for instance. Here, our customers benefit from the outstanding quality of our band saw blades in a variety of different ways, but also from our mission statement "Precision at the cutting point".

We make customer satisfaction our highest priority. This is why we develop and manufacture our products and technologies in Germany to meet the highest standards.

We have clear objectives and visions and this is why we constantly invest in research and development for your future, as well as our own. The experienced engineers who work for our technical service department work very closely with sawing specialists who have more scientific backgrounds.

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Precision at the cutting point

LEGEND

Material groups

- 1 Structural steels, deep drawing steels, machining steels
- 2 Case hardened steels, spring steels, quenched and tempered steels
- 3 Low alloyed hot-working steels
- 4 Nitriding steels, high alloyed hot-working steels
- 5 Unalloyed tool steels
- 6 Cold working steels
- 7 High-speed steels
- 8 Cast iron
- 9 Rust and acid-resistant steels (light)
- 10 Rust and acid-resistant steels (heavy)
- 11 Duplex and heat-resistant steels
- 12 Nickel-base alloys
- 13 Aluminum
- 14 Copper
- 15 Brass
- 16 Aluminum bronze
- 17 Titanium alloys
- 18 Steels with tensile strength > 1000N/mm²
- 19 Abrasive building materials
- 20 Silicon, glass, glass fiber, marble
- ★ Special applications

 Recommendation

 Suitable

Tooth shapes and types of tooth set

For details see pages 10 / 11

Classification

N

Normal:
For standard applications

B

Basic:
Capable all-round tool

S

Special: Special applications
that meet higher demands

T

Top Line: High-tech tool
that meets the highest demands