



# junior

Junior Metallsägenwerk  
C. Mesenhöller GmbH & Co. KG



MADE  
IN  
GERMANY

## BAND SAW BLADE SELECTION & TECHNICAL SERVICE

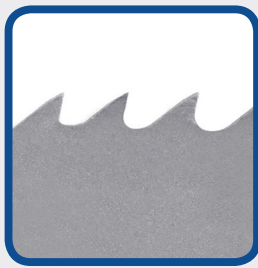
### 1 How to select the right blade size



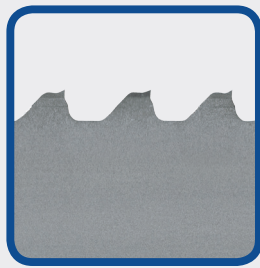
**LENGTH I  
WIDTHS I  
THICKNESS**

Best to be found in the machine manual.

### 2 How to select the right product grade



**MULTICUT M42**  
General cutting of solid and structural materials.



**PROBEAM M42**  
Special blade to cut structural materials and smaller work pieces.



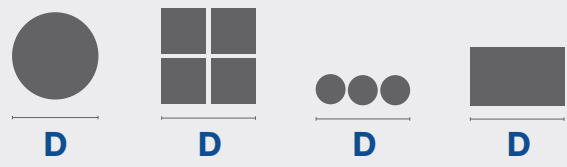
**DUROCUT M51**  
Special blade to cut high and highest alloyed solid materials.

Interested in Tungsten Carbide Products / TCT ?  
Please let us have details on your sawing application to work out the best & customized solution for you.

General advice for Bimetal Band Saw Blades

### 3 How to select the right tooth pitch

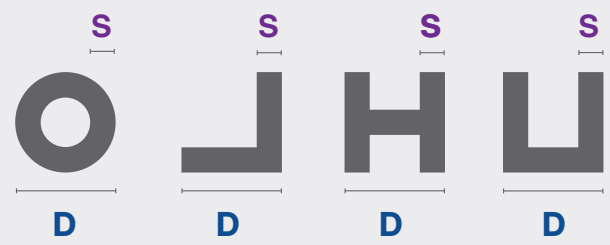
Solid material



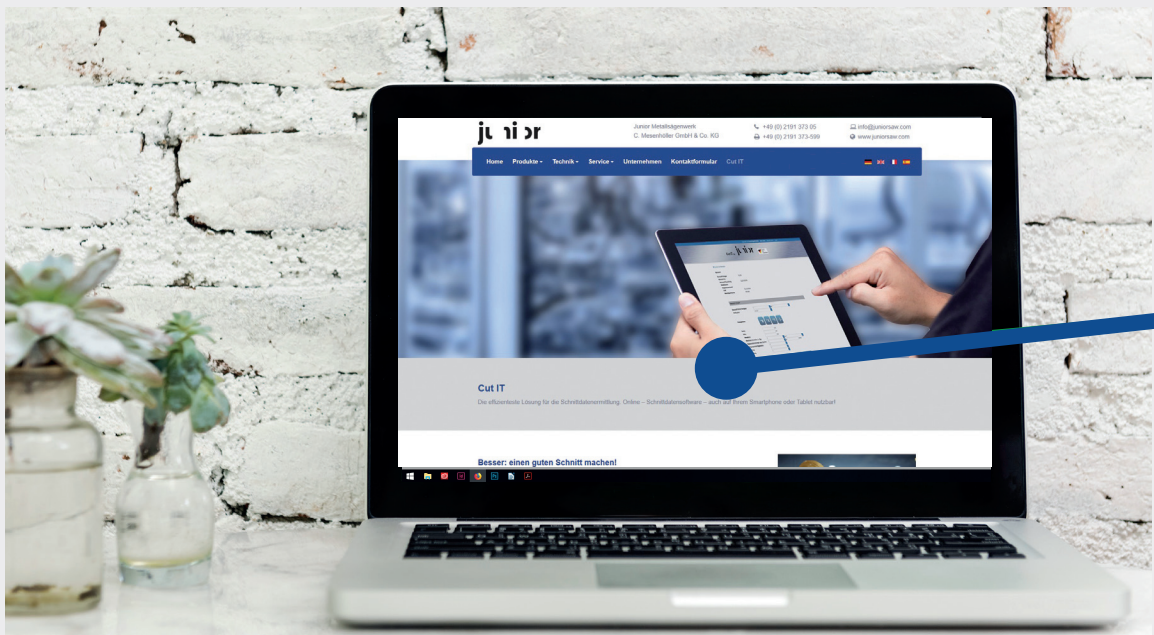
D	tpi
< 25 mm	10/14
15 – 40 mm	8/12
25 – 50 mm	6/10
35 – 70 mm	5/8
40 – 90 mm	5/6
50 – 120 mm	4/6
80 – 150 mm	3/4
130 – 350 mm	2/3
150 – 450 mm	1,5/2
200 – 600 mm	1,1/1,6
> 500 mm	0,75/1,25

Tubes & Profiles

↓ S mm	→ D mm	20	40	60	80	100	120	150	200	300	500
2	14	12/16 P	12/16 P	12/16 P	12/16 P	12/16 P	8/11 P	8/11 P	8/11 P	8/11 P	5/7 P
3	14	12/16 P	12/16 P	12/16 P	8/11 P	8/11 P	8/11 P	8/11 P	5/7 P	5/7 P	5/7 P
4	12/16 P	12/16 P	8/11 P	8/11 P	8/11 P	8/11 P	5/7 P	5/7 P	5/7 P	5/7 P	4/6 P
5	12/16 P	12/16 P	8/11 P	8/11 P	8/11 P	5/7 P	5/7 P	5/7 P	4/6 P	4/6 P	4/6 P
6	12/16 P	8/11 P	8/11 P	5/7 P	5/7 P	5/7 P	5/7 P	5/7 P	4/6 P	4/6 P	4/6 P
8	12/16 P	8/11 P	8/11 P	5/7 P	5/7 P	5/7 P	5/7 P	4/6 P	4/6 P	4/6 P	4/6 P
10		8/11 P	5/7 P	5/7 P	4/6 P	4/6 P	4/6 P	4/6 P	4/6 P	4/6 P	4/6 P
12		8/11 P	5/7 P	4/6 P	4/6 P	4/6 P	4/6 P	4/6 P	4/6 P	4/6 P	4/6 P
15		8/11 P	5/7 P	4/6 P	4/6 P	4/6 P	4/6 P	4/6 P	4/6 P	4/6 P	4/6 P
20			4/6 P	4/6 P	4/6 P	4/6 P	4/6 P	4/6 P	4/6 P	4/6 P	3/4 P
30				4/6 P	4/6 P	4/5 P	4/6 P	4/6 P	4/6 P	4/6 P	2/3 P
50							4/6 P	3/4 P	2/3 P	2/3 P	2/3 P
80								3/4 P	2/3 P	2/3 P	2/3 P
>100									2/3 P	1,5/2	1,5/2



### 4 How to find the best cutting parameters



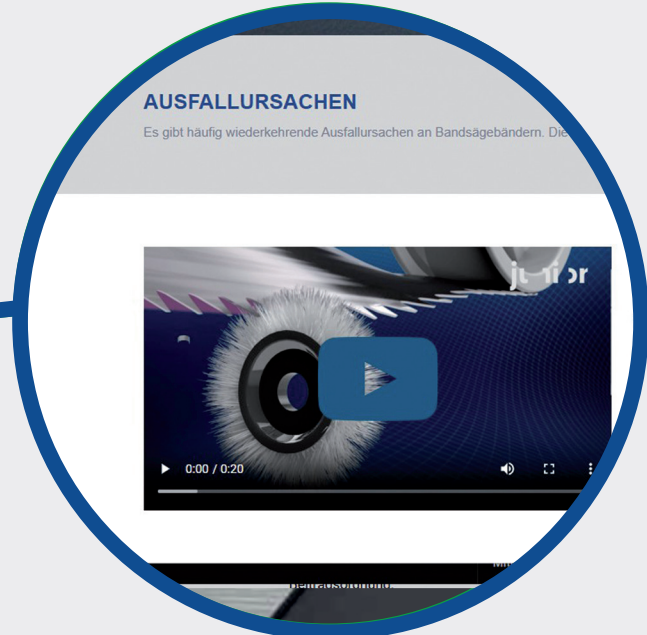
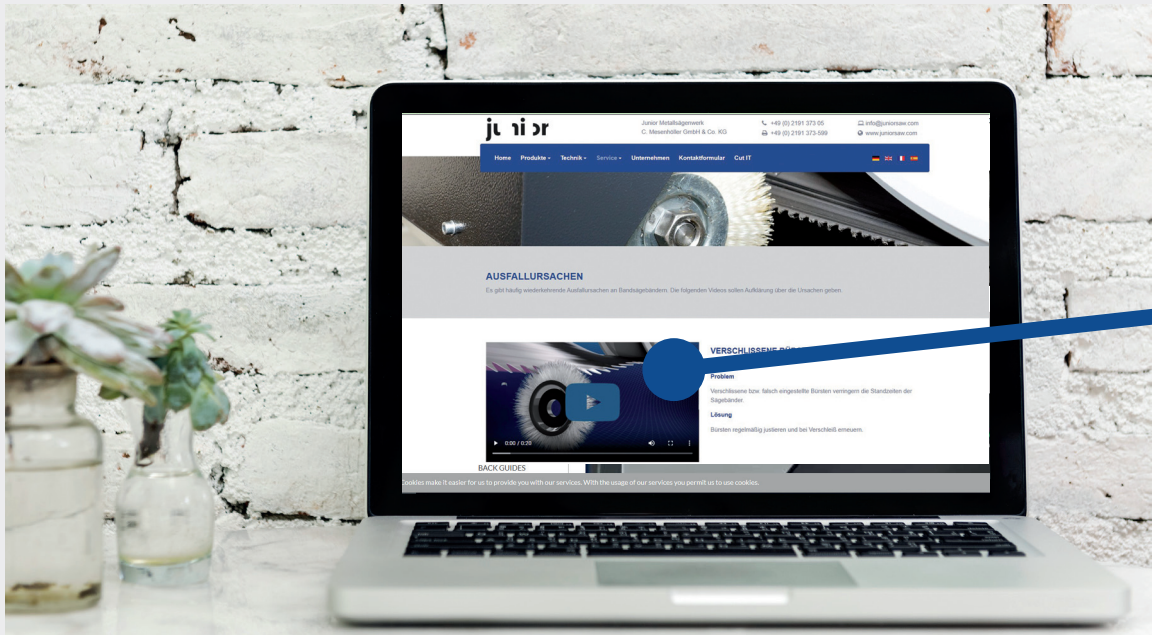
**SPEED & FEED RATES, COOLANT**  
Based on your application.

See you at **Cut IT**, the cutting database by Junior.



Scan me

### 5 How to get technical support



**VISIT THE JUNIOR SERVICE AREA**

Videos to help you with your challenges.  
If you have any questions, your distributor will be happy to help.



Scan me



MORE INFORMATION



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