junior

Junior Metallsägenwerk
C. Mesenhöller GmbH & Co. KG

LRQA CERTIFIED — ISO 9001 · ISO 50001
UKAS MANAGEMENT SYSTEMS 0001

MADE IN GERMANY

BAND SAW BLADE SELECTION & TECHNICAL SERVICE

1 How to select the right blade size
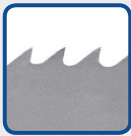
LENGTH I WIDTHS I THICKNESS

Best to be found in the machine manual.

2 How to select the right product grade

General advice for Bimetal Band Saw Blades

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.
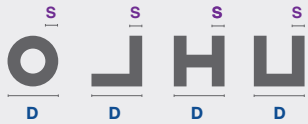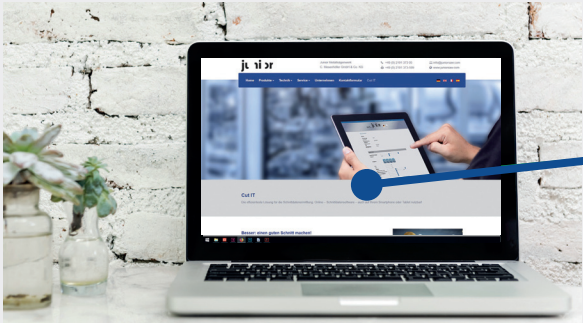
3 How to select the right tooth pitch

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

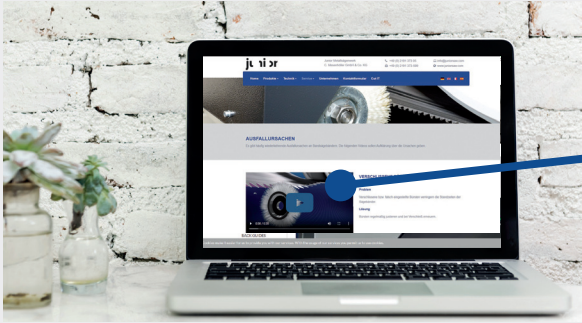| ↓ S mm / → D mm	20	40	60	80	100	120	150	200	300	500
2	14	12/16 P	12/16 P	12/16 P	12/16 P	8/11P	8/11P	8/11P	8/11P	5/7P
3	14	12/16 P	12/16 P	8/11P	8/11P	8/11P	8/11P	5/7P	5/7P	5/7P
4	12/16 P	12/16 P	8/11P	8/11P	8/11P	5/7P	5/7P	5/7P	5/7P	4/6P
5	12/16 P	12/16 P	8/11P	8/11P	5/7P	5/7P	5/7P	4/6P	4/6P	4/6P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

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