

CIRCULAR SAW BLADES

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TECHNOLOGY

SoWa . Our road to perfect sawmill tools

A circular saw blade – or broadly speaking – a sawmill tool can only convince with optimal performance and high stability if the sawmill tool is designed as closely as possible to the special working conditions at the sawmill. “Sawmill Optimised Tool Design”, “SoWa” for short, is therefore also the essence of our HDS philosophy. We’re convinced this is the only way to achieve outstanding sawmill tool quality. The fact HDS-Sawmill Tools are being used in high capacity sawmills domestically and internationally confirms this approach. Benefit from our “SoWa Sawmill Optimised Tool Design” for your saw line.



HDS circular saw blade for rough cuts

Rough cutting exposes circular saw blades to extreme strain. Increasing feed rates and large cutting heights not only require an optimal design, but also an extremely durable material quality as well as precise machining. It's not a surprise, since speed, kerfs and cutting heights greatly contribute to productivity, thus the profitability of the saw line.

The goal is for each sawmill to be identical at the core, since generally the same success factors apply:

- + Reducing kerfs
- + Increasing feed rates
- + Increasing cutting heights
- + Increasing the cutting quality

The competing goals can only be realised at a balanced ratio. Today, the “AST Graduated Saw Blade Technology” allows us to optimise this magic ratio even more. The introduction of the “graduated” STABILO circular saw blade has allowed sawmills to operate much more efficiently.

To achieve the greatest lumber yield possible with also a preferably high feed rate in rough cutting, we only recommend STABILO class circular saw blades with Graduated Saw Blade Technology (AST) designed specifically for your cutting jobs. Featuring high dynamic rigidity, our STABILO can handle even extreme strain such as in rough cutting due to the different cutting heights combined with high feed rates. The high stability of the circular saw blade body allows for the minimal kerf design in STABILO. Reducing the kerf in turn results in lower cutting force, thus reducing the energy requirement. In addition, the lumber yield is increased so that with certain cutting programs, moving to the next greater log diameter or the next larger box in the log yard can be avoided – or more fittingly – “spared”.

Trust in the highly efficient STABILO with “AST Graduated Saw Blade Technology” for rough cuts and use our “SoWa Sawmill Optimised Tool Design” for a premium product to best fit your cutting program, thus already guaranteeing a crucial competitive advantage in rough cutting.





Reducer line with HDS circular saw blades



(1.1) Rough cut

STABILO-Profile

Gradation type ESZF, one side with dual-graduated blade profile

Internal saws/S-saws

Largest cutting height and highest resilience

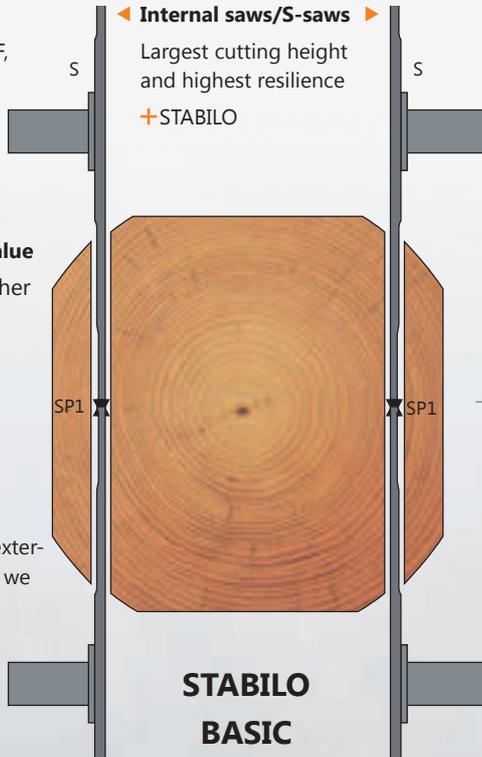
+ STABILO

STABILO-Added value

Smaller kerf or higher feed rates

For cutting patterns which also require external saws or N-saws, we recommend:

- + STABILO
- + BASIC



(1.2) Rough cut

STABILO-Profile

Gradation type ESEF, one side with single graduated blade profile

Internal saws/S-saws

Large cutting height and high resilience

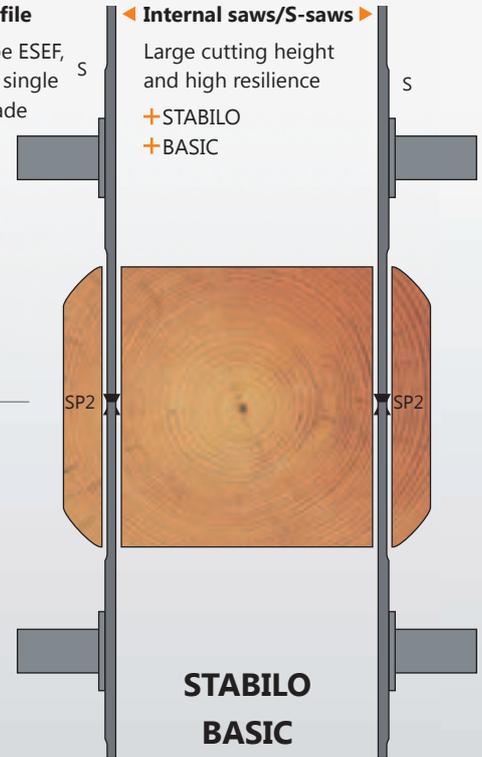
- + STABILO
- + BASIC

STABILO-Added value

Smaller kerf or higher feed rates

For cutting patterns which also require external saws or N-saws, we recommend:

- + STABILO
- + BASIC



(2) Fine cut

Fine cut circular saw blades

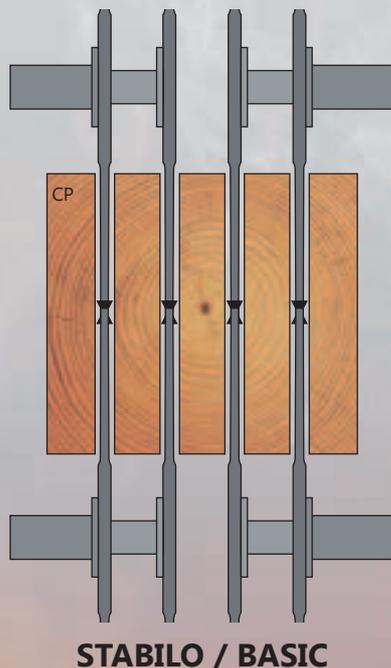
- + STABILO
- + BASIC

STABILO-Profile

Gradation type BSEF, both sides with single graduated blade profile

BASIC for fine cut

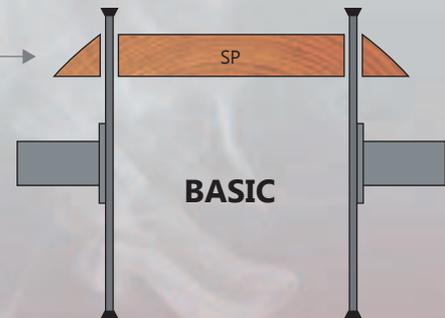
Use for medium feed rates and medium cutting heights



(3) Trim cut

Side products

Trim cut with + BASIC





TECHNOLOGY

AST . Graduated Saw Blade Technology

No innovation has impacted the development of high-performance circular saw blades for use in sawmills in recent years as much as "AST Graduated Saw Blade Technology". Now, mature and proven designs are available to ensure maximum performance Sawmill Optimised Tool Design (SoWa) with outstanding stability.

Our STABILO combines the AST performance advantages in a circular saw blade designed to our standard in performance and quality.



HDS circular saw blade for fine cut

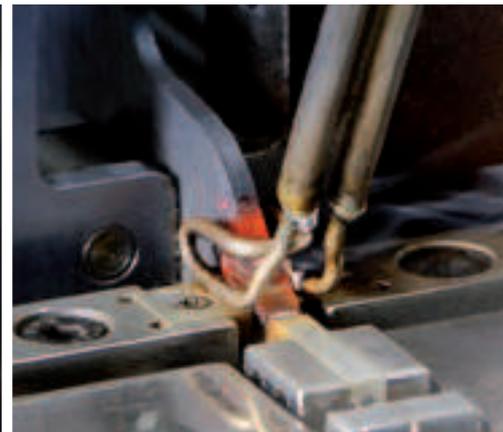
For efficient fine cuts with a high feed rate we always recommend our STABILO fine cut circular saw blade graduated on one or both sides. The STABILO blade profile developed specifically for fine cutting effectively compensates the laterally balanced relative strength which occurs when sawing consistent medium to high cutting heights with. This even allows minimal kerfs in fine cuts.

After increasing lumber yield in rough cutting, STABILO – the second time now – increases the recovery rate in fine cuts. Over the year you virtually benefit from this competitive edge in double.

Our tried and tested BASIC is excellent for trim cuts with low cutting heights and high feed rates. Our "SoWa Sawmill Optimised Tool Design" philosophy also applies here. It requires analysing your machine data, the desired feed rates, the cutting height of the primary product, as well as the type of wood to be cut for us to design a particularly efficient circular saw blade.

Take advantage of this development concept, since high-quality HDS-Sawmill Tools offer profitable advantages, shift after shift, day after day, and year after year!

CIRCULAR SAW BLADES



Profiler line with HDS circular saw blades



(1.1) Rough cut

External saws / N-saws

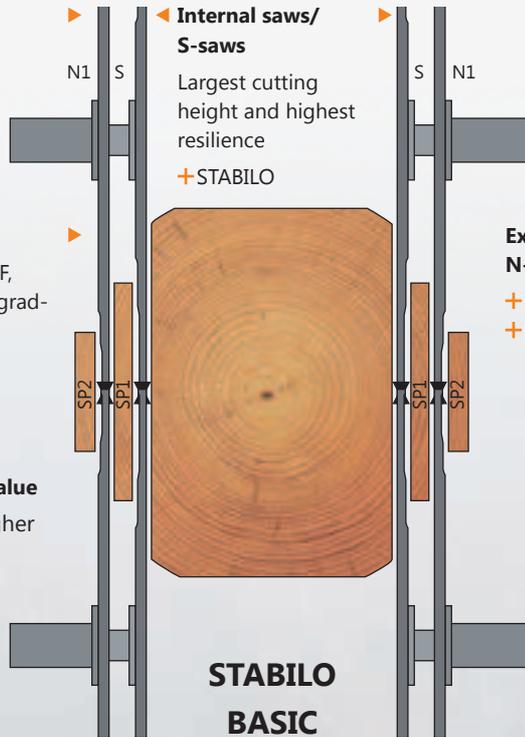
- +STABILO
- +BASIC

STABILO-Profile

Gradation type ESZF, one side with dual graduated blade profile

STABILO-Added value

Smaller kerf or higher feed rates



(1.2) Rough cut

Internal saws/S-saws

Large cutting height and high resilience

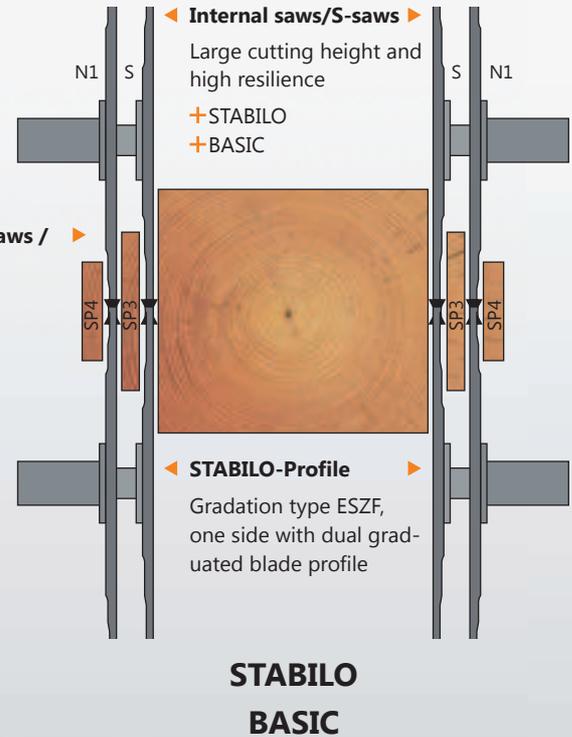
- +STABILO
- +BASIC

External saws / N-saws

- +STABILO
- +BASIC

STABILO-Profile

Gradation type ESZF, one side with dual graduated blade profile



(2.1) Fine cutting using telescopic shafts

Fine cut circular saw blades

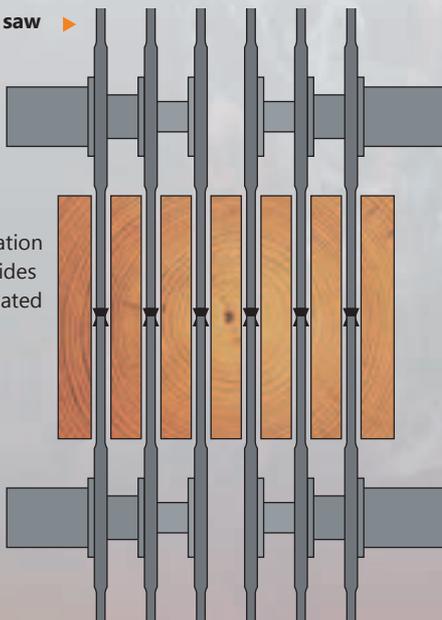
- +STABILO
- +BASIC

STABILO-Profile

for fine cut, gradation type BSEF, both sides with single graduated blade profile

BASIC

for fine cut for moderate feed rates and medium cutting heights



(2.2) Fine cutting with fixed mount

Fine cut circular saw blades

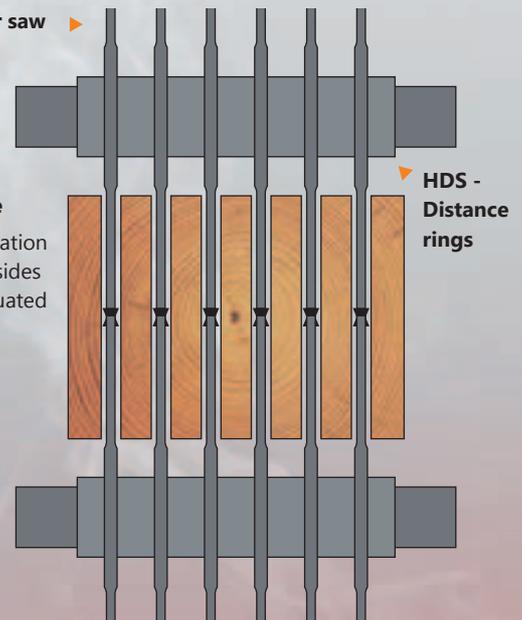
- +STABILO
- +BASIC

STABILO-Profile

for fine cut, gradation type BSEF, both sides with single graduated blade profile

BASIC

for fine cut for moderate feed rates and medium cutting heights

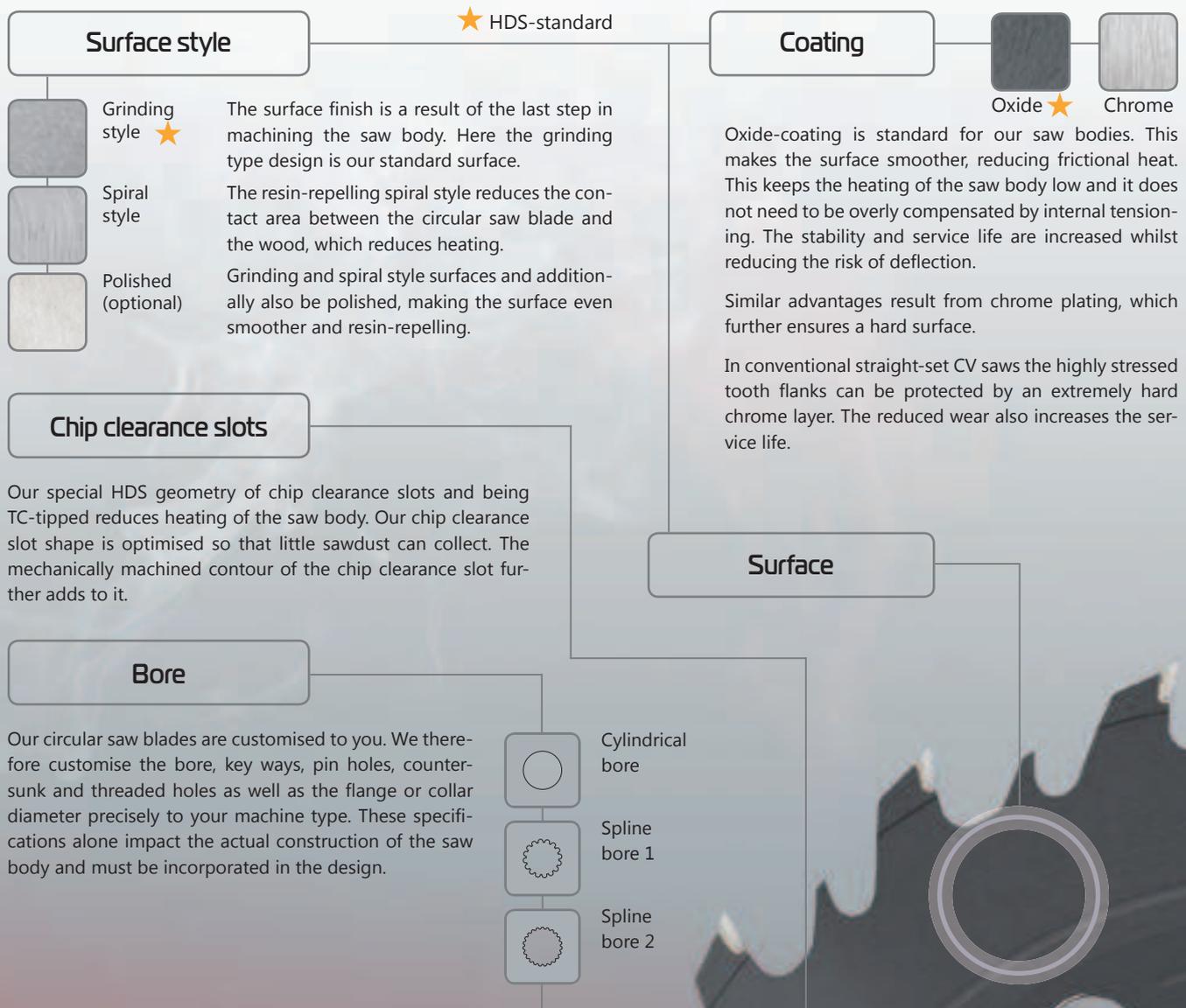
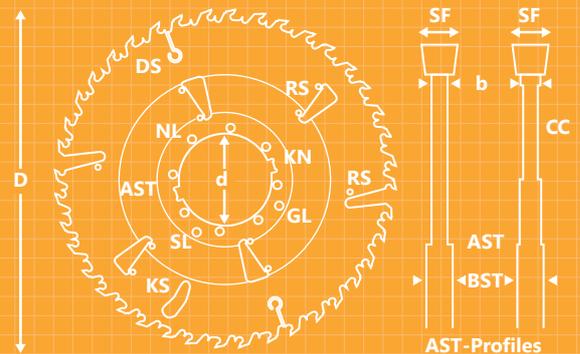


TECHNOLOGY

Body of circular saw blade

A circular saw blade for heavy duty use in sawmills is the result of constructing countless design characteristics to the exact conditions at your sawmill based on the specific cutting program, machine type and the type of wood. It requires a precise analysis of the application for us to design a circular saw blade optimal for its subsequent application.

Here we will briefly introduce you to the key design characteristics of the saw body.



Surface style

★ HDS-standard

- Grinding style ★** The surface finish is a result of the last step in machining the saw body. Here the grinding type design is our standard surface.
- Spiral style** The resin-repelling spiral style reduces the contact area between the circular saw blade and the wood, which reduces heating.
- Polished (optional)** Grinding and spiral style surfaces and additionally also be polished, making the surface even smoother and resin-repelling.

Coating



Oxide-coating is standard for our saw bodies. This makes the surface smoother, reducing frictional heat. This keeps the heating of the saw body low and it does not need to be overcompensated by internal tensioning. The stability and service life are increased whilst reducing the risk of deflection.

Similar advantages result from chrome plating, which further ensures a hard surface.

In conventional straight-set CV saws the highly stressed tooth flanks can be protected by an extremely hard chrome layer. The reduced wear also increases the service life.

Chip clearance slots

Our special HDS geometry of chip clearance slots and being TC-tipped reduces heating of the saw body. Our chip clearance slot shape is optimised so that little sawdust can collect. The mechanically machined contour of the chip clearance slot further adds to it.

Bore

Our circular saw blades are customised to you. We therefore customise the bore, key ways, pin holes, counter-sunk and threaded holes as well as the flange or collar diameter precisely to your machine type. These specifications alone impact the actual construction of the saw body and must be incorporated in the design.

- Cylindrical bore
- Spline bore 1
- Spline bore 2

STABILO Hexa CC

- Dimensions** 510 x 4.7/3.5/4.9 x 150 mm
- Teeth** 18 TCT teeth . Tooth form flat tooth . Tooth type 4 Plus Hexa style with 6 chip clearance slots
- Features** AST Graduated Saw Blade Technology, gradation type ESEF one side with single gradation from 4.9 to 3.5 mm . CoolCut CC

TECHNOLOGY

GRADUATED
SAW BLADE TECHNOLOGY **AST**

STABILO for rough cut



Individual blade profile

The blade profile crucial for dynamic rigidity is calculated specifically to your cutting program according to "SoWa Sawmill Optimised Tool Design" for each STABILO circular saw blade, incorporating over 30 factors. Here we offer two basic designs, the blade profile graduated on one side or on both sides.

For rough cut: STABILO featuring one side with graduated blade profile

The profile with single or dual gradation on one side is usually used in rough cutting. The different cutting heights result in lateral, varying secondary forces. The blade profile gradation on one side compensates this imbalance so the extreme dynamic rigidity has a positive effect.

For fine cut: STABILO featuring both sides with graduated blade profile

The reduced and nearly even cutting heights in fine cutting result in a more balanced relative strength. The high dynamic rigidity also has an extremely positive effect here, allowing for a reduction of the kerf.

STABILO for fine cut



The HDS plus factors of STABILO

- + **Individual blade profile**
is crucial for the dynamic rigidity and is designed and calculated individually considering all factors
- + **Smaller kerf or higher feed rate**
by dynamic rigidity of the tried and tested "AST Graduated Saw Blade Technology"
- + **Energy saving**
compared to straight circular saw blades by reducing the kerf
- + **Long service life**
due to the extremely massive saw body, hence suitable for several regeneration cycles
- + **Reduced bearing load**
through the use of smaller distance rings
- + **Lower level of heating**
in the tooth area, which is the thinnest area of the circular saw blade, thus minimising the frictional heat of sawdust
- + **Chip clearance slots facing**,
protecting the collar from excessive heating, thus burns, on the model end

AST-Gradation types

ESEF : single gradation on one side
ESZF : dual gradation on one side

AST-Gradation types

BSEF : single gradation on both sides
BSZF : dual gradation on both sides

CoolCut CC

CoolCut ▶

Our BASIC and STABILO circular saw blades are available with "CoolCut" option on request. Here a slight reduction is added to the outside of the circular saw blade.

Just as AST, CoolCut provides thermal relief of the saw body, allowing a reduction in the kerf or selecting very high feed rates.

The reduction at the tooth base can be scaled back, enlarging the solder area for TCT and stellite teeth, thus ensuring more sturdy tooth tipping.

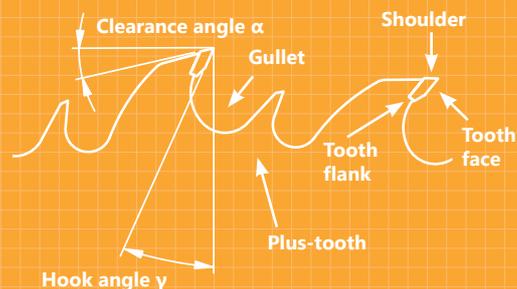
The "double CoolCut" option is available to increase the CoolCut effect.

double
CoolCut dCC

Tooth geometry

There's a lot happening at the tooth area of a circular saw blade. The small tungsten carbide or stellite saw teeth chip away the shavings which then seemingly storm about the gullet, are again broken up by the Plus-tooth and then hastily ejected by the spin of the circular saw blade.

The better the cutting material, tooth form, tooth type and tooth geometry are coordinated for the subsequent application, the higher the performance of the circular saw blade.



Cutting materials

In the sawmill industry, tungsten carbide (TC), stellite (ST) and chromium-vanadium steel (CV) are three cutting materials used for saw teeth, where an inexpensive CV tooth comes directly from the straight-set circular saw body and therefore cannot be tipped. Available for HDS circular saw blades:

- + TC - application-optimised tungsten carbide styles in three quality levels HWQ: HDS01 to HDS03
- + ST - stellite, particularly tough and robust cutting material
- + CV - chromium-vanadium steel for inexpensive straight-set standard circular saw blades

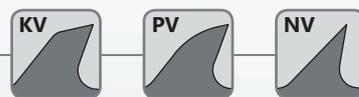


Tooth forms

HDS circular saw blades primarily feature universal, easy to sharpen flat teeth. Other shapes are available for special applications.

- + F Flat tooth
- + W Alternate top bevel tooth
- + H Hollow tooth
- + TF Triple chip - flat tooth
- + TT Triple chip - triple chip tooth
- + FS Flat tooth with protective chamfer

Saw tooth



General tooth types

In addition to tipping and the construction of the saw body, the tooth type is an important factor in optimising the cutting performance and cutting quality as well as stability and service life.

- + KV - tooth type (peg tooth)
Long- and cross-cut, tungsten carbide/stellite tipped
- + PV - tooth type (curved tooth)
Long- and cross-cuts, primarily stellite tipped
- + NV - Tooth type (pointed tooth)
mostly for cross-cuts and for straight-set circular saw blades

The KV tooth type was greatly modified for high-performance areas at the sawmill. This resulted in special, extremely powerful sawmill tooth types.

General tooth types

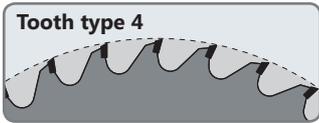
STABILO Hexa CC

Dimensions 510 x 4.7/3.5/4.9 x 150 mm

Teeth 18 TCT teeth . Tooth form flat tooth . Tooth type 4 Plus Hexa style with 6 chip clearance slots

Features AST Graduated Saw Blade Technology, gradation type ESEF one side with single gradation from 4.9 to 3.5 mm . CoolCut CC

TECHNOLOGY



★ HDS-standard

Tooth type 4

The universal tooth type 4 suitable for rough and fine cuts as well as long and cross cuts is the standard tooth type and characterised by the particularly large gullet. The gullet is even able to collect and eject an adequate amount of sawdust with high feed rates or large cutting heights. The radial shape of the gullet aids in ejecting the sawdust.

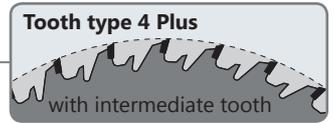
- Profile
- + Consistent tooth heights
 - + Consistent pitch
 - + Large gullet



HT High-Low

The modified tooth type 4 allows for different cutting heights to be processed with greatly varying feed rates using a single circular saw blade type. This eliminates the blade change and the associated set-up costs. It further reduces the expenditure of acquisition and storage, since a limited cutting area only uses one specific circular saw blade type. The tooth type therefore greatly contributes to the profitability of your production line.

- Profile
- + Varying tooth heights
 - + Consistent pitch
 - + Large gullet



Tooth type 4 Plus

When we developed "tooth types 4 Plus" our focus was on optimising chip removal. The striking "Plus-tooth", also referred to as intermediate tooth, splits the gullet and improves saw dust ejection as well as the chip flying outward. This eliminates sawdust friction between the circular saw blade and material being cut, as well as the sawdust clumping together in the gullet. Reducing the strain on the circular saw blade allows for a smaller kerf.

- Profile
- + Consistent tooth heights
 - + Consistent pitch
 - + Plus-tooth for improved chip ejection & chipping



HT High-Low Plus

The "HT Plus" tooth type combines the strengths of HT teeth and the "Plus-tooth". On one hand this allows a wide range of different cutting heights and different feed rates to be processed without changing the circular saw blade, and on the other hand the intermediate tooth the improved sawdust ejection from the additional tooth in the gullet minimises the thermal strain on the circular saw blade.

- Profile
- + Varying tooth heights
 - + Consistent pitch
 - + Plus-tooth for improved chip ejection & chipping

Sawmill tooth types



UZ Varying tooth pitch

The UZ tooth type is of particular interest for trim- and fine cutting units. The alternating tooth heights and the uneven pitch allow the UZ tooth type to be used efficiently for fine cuts for large cutting heights with low feed rates as well as for trimming with significantly lower cutting heights at high feed rates.

- Profile
- + Varying tooth heights
 - + Varying pitches
 - + Large gullet



UZ Plus

Tooth type "UZ Plus" combines the advantages of this tooth type with the benefits of the "Plus-tooth". The effective chip ejection and the improved chip break reduce friction and heat so the circular saw blade allows a reduced kerf.

- Profile
- + Varying tooth heights
 - + Varying pitches
 - + Plus-tooth for improved chip ejection & chipping

HDS CIRCULAR SAW BLADE

		BASIC	STABILO	TRIMCUT	CROSSCUT	
 SAWMILL OPTIMISED TOOL DESIGN	Diameter max.	●	●	●	●	
		1.200 mm	900 mm	1.900 mm	2.800 mm	
	Application	Rough cut	○	●		
		Fine cut	●	●	○	
Trimm/cross cut			○	●	●	
 GRADUATED SAW BLADE TECHNOLOGY	AST one side		●			
	AST both sides		●			
	CoolCut CC	●	●			
	double CoolCut dCC	●	●			
TCT Chip clearance slots	Without chip clearance slots	○	○	●	●	
	2 Duo / 3 Tria / 4 Tetra / 6 Hexa / 8 Octo / 10 Deka	●	●			
Vibration and Noise Reduction	Expansion slots	●	●	●	●	
	Copper rivets	○		●	●	
	Noise reduction slots	○		●	●	
Sawmill tooth types	Tooth type 4	●	●	●	●	
	HT High-Low	○	○			
	UZ Varying tooth pitch	○	○			
Plus-Tooth	Intermediate tooth ZZ	○	○			
Cutting material	CV chromium-vanadium	○		○		
	TC tungsten carbide	●	●	●	●	
	ST stellite	●	●	○		
	TC tipped insert				●	
Surface style	Grinding style	●	●	●	●	
	Spiral style	●	●	○		
	Polished	○	○	○		
Surface coating	Oxide	●	●	●		
	Chrome	○	○	○		

● Very suitable / absolutely true

○ Somewhat suitable / sometimes true



REGENERATION

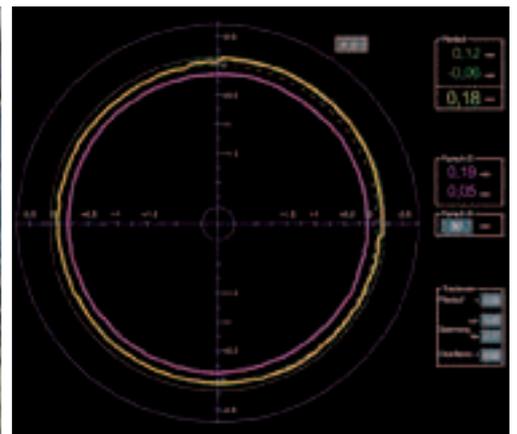
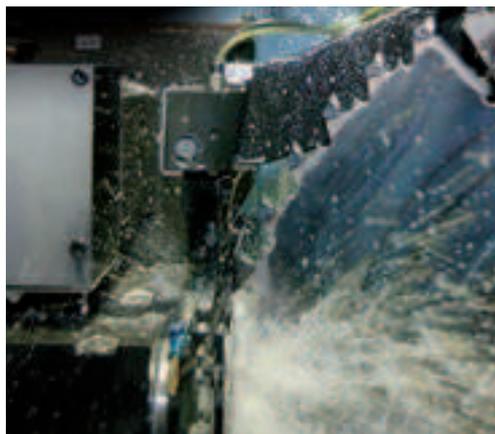
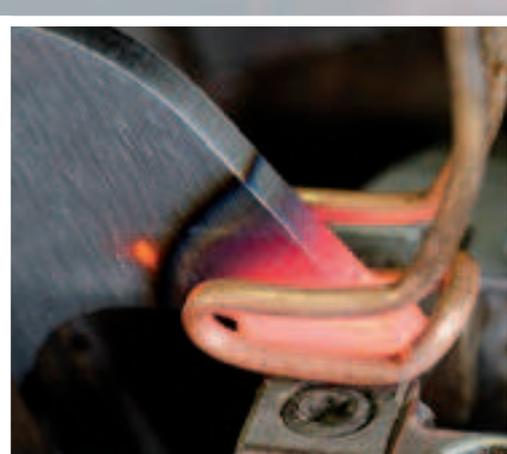
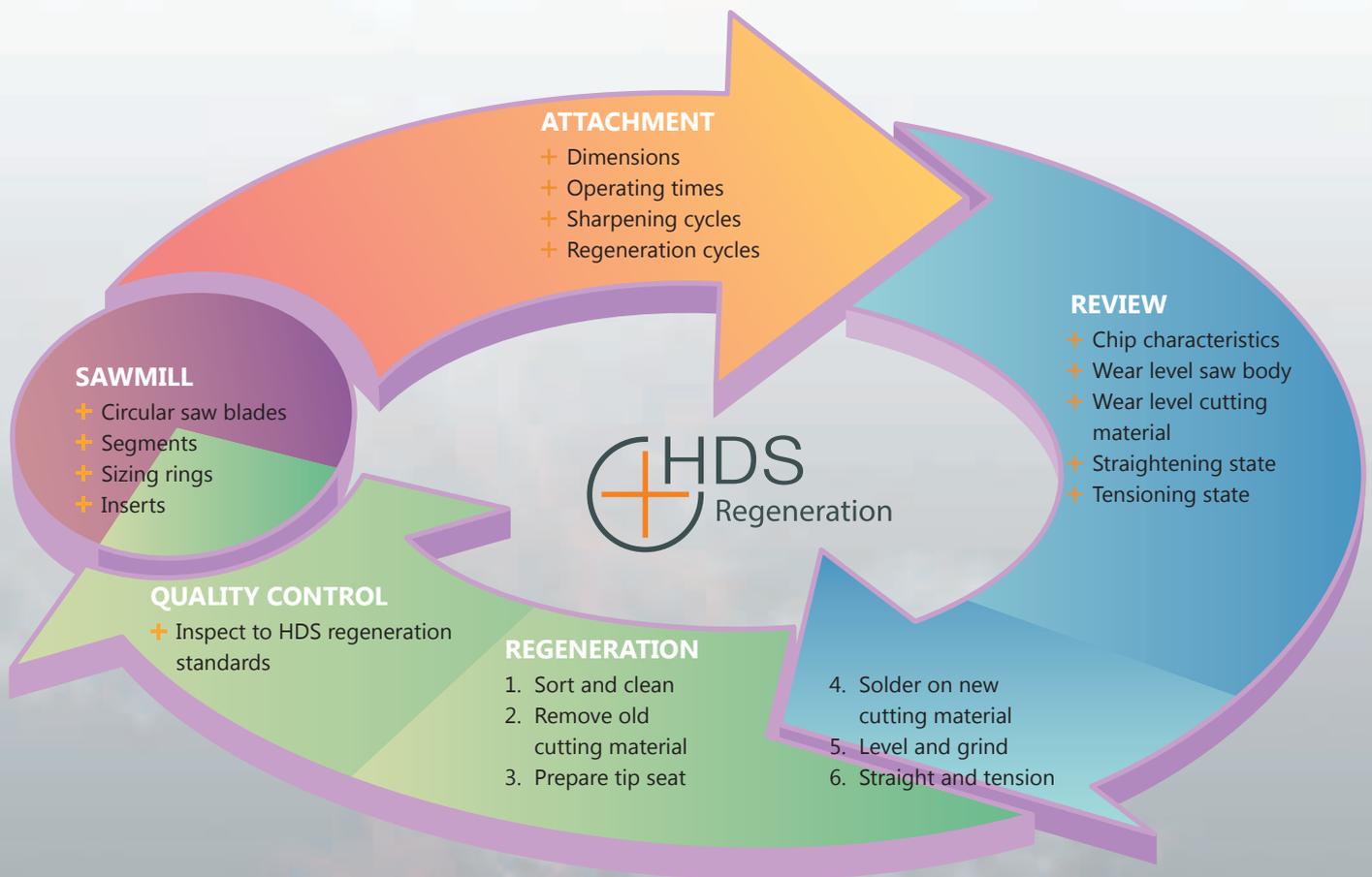
A second life for your used sawmill tools

Used doesn't mean used up, since your sawmill tool can often be repaired or regenerated, which is much more economical compared to a new purchase.

Sawmill tools can be repaired to HDS quality standards straight at our factory. For particularly high quality circular saw blades, segments and sizing rings, usually equipped with a particularly robust "AST Graduated Saw Blade Technology" saw body, complete

regeneration is usually wise and offers great economic benefits. This process can be repeated several times, increasing the life of your sawmill tool by x-fold.

Let us repair or regenerate your sawmill tool. In most cases this will delay a new purchase and we will return your "used ones" like new!



CIRCULAR SAW BLADES



BASIC

Dimensions 655 x 5.1/4.0 x 142 mm

Teeth 30 TCT teeth . Tooth form flat tooth . Tooth type 4
Style with 9 chip clearance slots

Features 9 pin holes 11 mm on pitch circle 248 mm . 6 pin holes
11 mm on pitch circle 165 mm . 3 knife slots



BASIC CIRCULAR SAW BLADES

Our BASIC already defines the HDS quality standard

BASIC is the result of decades of experience which continuously impacted the development process of the technologies used. So you now have a highly optimised, and tried and tested circular saw blade with numerous optional refinements.

We already draw on the highest quality materials when manufacturing the saw body. The respective heat treatments we select support the high HDS standard.

BASIC is manufactured precisely to your needs, so every piece of information about the specific operating conditions at your sawmill impacts the construction of your BASIC.

The additional application of our CoolCut option further perfects the performance of the circular saw blade with regard to optimal chip transport, preventing excess heating, reducing the kerf, extending the service life and/or increasing the feed rate.

The HDS plus factors of BASIC

+ Extremely smooth running

Even our BASIC is extremely smooth running, achieved by incorporating the internal tensioning in the special saw body style. These exemplary running properties contribute to increasing the stability of the circular saw blade.

+ Deflection-free cuts

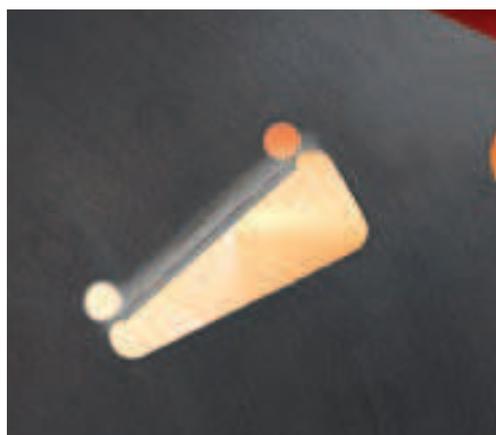
Even at a peak load our BASIC keeps its shape, since the optional expansion slots with optional end hole or expansion slots with copper rivets limit thermal expansion. This ensures deflection-free cuts.

+ Reduced blade heating

In most cases the BASIC blade features TCT chip clearance slots, significantly reducing heating of the saw body. Our special geometry and the machined contour of the chip clearance slots ensure very little sawdust collects.

+ Reduced kerf

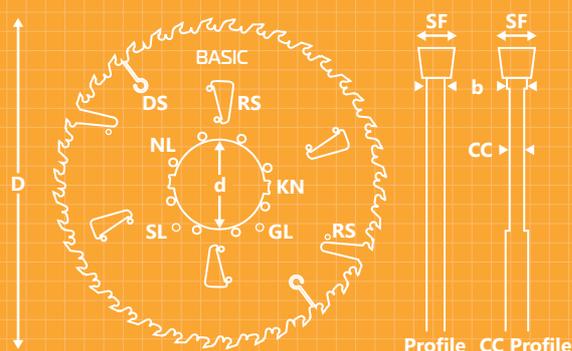
Select the option "CoolCut" or "double CoolCut" to reduce the kerf. A reduction is then applied to the outside of the saw blade, reducing excessive heating to the point the overall construction can be designed with an even thinner kerf.



BASIC CIRCULAR SAW BLADES

The "SoWa Sawmill Optimised Tool Design" make for maximum level circular saw blades for industrial sawmill use. Your circular saw blades are coordinated to your specific requirements and operating conditions. Using the technical data in our database and 3D CAD models production of your circular saw blades can always be automated and is reproducible.

b Saw body thickness . CC CoolCut . D Diameter . d Bore
 DS Expansion slot . GL Threaded hole . KN Key way . NL Pin hole
 RS Chip clearance slot . SF Kerf . SL Countersunk hole



	<p>BASIC HDS-No. 15020</p> <table border="0"> <thead> <tr> <th>Dimensions</th> <th>Cutting material</th> <th>TCT</th> <th>Features</th> </tr> </thead> <tbody> <tr> <td>Diameter 350.0 mm</td> <td>Number of teeth 62</td> <td>FS</td> <td>Expansion slots 4</td> </tr> <tr> <td>Kerf 4.8 mm</td> <td>Tooth form FS</td> <td></td> <td></td> </tr> <tr> <td>Saw body thickness 3.2 mm</td> <td>Tooth type 4</td> <td></td> <td></td> </tr> <tr> <td>Bore 100.0 mm</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Key ways 0</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Pin-/countersunk holes 3</td> <td></td> <td></td> <td></td> </tr> </tbody> </table>	Dimensions	Cutting material	TCT	Features	Diameter 350.0 mm	Number of teeth 62	FS	Expansion slots 4	Kerf 4.8 mm	Tooth form FS			Saw body thickness 3.2 mm	Tooth type 4			Bore 100.0 mm				Key ways 0				Pin-/countersunk holes 3			
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BASIC CIRCULAR SAW BLADES

TCT- and ST-Circular saw blades

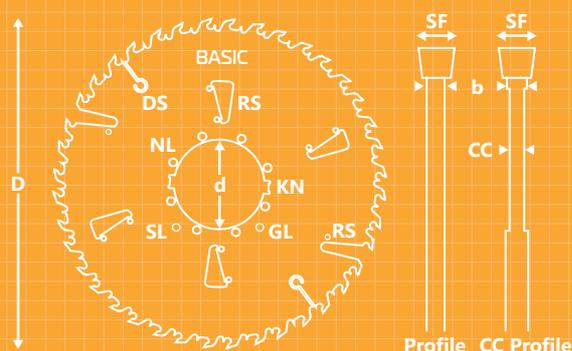


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BASIC CIRCULAR SAW BLADES

The "SoWa Sawmill Optimised Tool Design" make for maximum level circular saw blades for industrial sawmill use. Your circular saw blades are coordinated to your specific requirements and operating conditions. Using the technical data in our database and 3D CAD models production of your circular saw blades can always be automated and is reproducible.

b Saw body thickness . CC CoolCut . D Diameter . d Bore
 DS Expansion slot . GL Threaded hole . KN Key way . NL Pin hole
 RS Chip clearance slot . SF Kerf . SL Countersunk hole



	<h2>BASIC Tetra</h2> <p style="text-align: right;">HDS-No. 15416</p> <table border="0"> <thead> <tr> <th colspan="2">Dimensions</th> <th colspan="2">Cutting material</th> <th>TCT</th> <th>Features</th> </tr> </thead> <tbody> <tr> <td>Diameter</td> <td>470.0 mm</td> <td>Number of teeth</td> <td>52+4</td> <td></td> <td rowspan="4">Bevelled gullet</td> </tr> <tr> <td>Kerf</td> <td>5.0 mm</td> <td>Tooth form</td> <td>W</td> <td></td> </tr> <tr> <td>Saw body thickness</td> <td>3.4 mm</td> <td>Tooth type</td> <td>4</td> <td></td> </tr> <tr> <td>Bore</td> <td>130.0 mm</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Key ways</td> <td>2</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Pin-/countersunk holes</td> <td>12</td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>	Dimensions		Cutting material		TCT	Features	Diameter	470.0 mm	Number of teeth	52+4		Bevelled gullet	Kerf	5.0 mm	Tooth form	W		Saw body thickness	3.4 mm	Tooth type	4		Bore	130.0 mm				Key ways	2					Pin-/countersunk holes	12				
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BASIC CIRCULAR SAW BLADES

TCT- and ST-Circular saw blades



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STABILO Deka CC

Dimensions 648 x 5.4/3.65/6.8 x 160 mm

Teeth 14 TCT teeth . Tooth form alternate top bevel tooth . Tooth type 4 Plus
Deka style with 10 chip clearance slots

Features AST Graduated Saw Blade Technology, gradation type ESZF
one side dual gradation from 6.8 to 3.65 mm . CoolCut

STABILO . Graduated to the advanced technology saw class

Developing the Graduated Saw Blade Technology AST first allowed sawmills to optimise their productivity long term. Now, high-capacity reducing and profiling lines primarily use the Graduated Saw Blade Technology AST.

The striking STABILO circular saw blades allow for small kerfs in rough and fine cutting, particularly with markedly high feed rates and large cutting heights, and feature a high durability to

convince you. Renowned machine manufacturers therefore equip their particularly strong rough cutting aggregates, and increasingly even fine cutting units, with graduated circular saw blades. Just as our BASIC circular saw blades, we can additionally integrate CoolCut into the STABILO graduated blade profile.

The HDS plus factors of STABILO

+ Individual blade profile

No two STABILO are alike, since each circular saw blade has a custom blade profile taking your cutting program into account, with single or dual gradation on one or both sides. This always ensures the optimal dynamic rigidity which the outstanding performance of the STABILO class is based on.

+ Reduced kerf or increased feed rate

The particularly high dynamic rigidity of the core achieved using the Graduated Saw Blade Technology yields two particularly beneficial options. For one, the kerf can be reduced whilst maintaining the feed rate, and on the other hand the feed rate can be reduced whilst maintaining the kerf. Both result in a significant increase in efficiency.

+ Energy saving

Compared to a straight circular saw blade, STABILO is a true energy saver, since the kerf reduction generates less pressure, which in turn results in energy savings for you.

+ Long service life

The name "STABILO" alone suggests the extremely solid and robust saw body, which in and of itself already means a long life and further allows for multiple regenerations.

+ Low level of heating

With the thinnest point of the STABILO circular saw blade being at the tooth area, the frictional heat generated by sawdust here is reduced significantly. This factor, which is so critical in stability, can be further enhanced by the CoolCut option.

+ Chip clearance slots facing

The STABILO can optionally also use facing chip clearance slots, which protects the collar from excessive heating, thus burns, on the model end.

+ Reduced bearing load

Using smaller distance rings significantly reduces strain on the bearing load on the shaft. In addition it makes it easier to handle when changing the circular saw blade, since it only requires distance rings in the machine flange diameter.

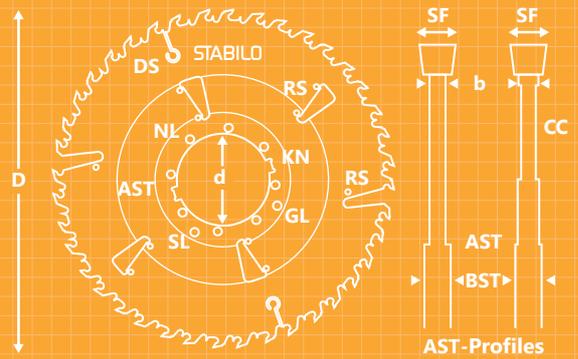


STABILO CIRCULAR SAW BLADES



Our "SoWa Sawmill Optimised Tool Design" ensures you will have a top class STABILO circular saw blade customised for industrial use at your sawmill. Here we draw on our decades of experience and incorporate every single detail of your requirements such as machine model, cutting program, and the type of wood. This optimisation process ensures you receive a STABILO which is best matched to your cutting production, thus extremely efficient.

b Saw body thickness . **BST** Collar thickness . **CC** CoolCut . **D** Diameter
d Bore . **DS** Expansion slot . **GL** Threaded hole . **KN** Key way
NL Pin hole . **RS** Chip clearance slot . **SF** Kerf . **SL** Countersunk hole



	<h2>STABILO Tetra CC</h2> <p style="text-align: right;">HDS-No. 14899</p> <table border="0"> <thead> <tr> <th>Dimensions</th> <th>Cutting material</th> <th>ST</th> <th>AST-Type</th> <th>BSEF</th> </tr> </thead> <tbody> <tr> <td>Diameter</td> <td>490.0 mm</td> <td>Number of teeth</td> <td>32+4</td> <td>Collar diameter</td> <td>313.0 mm</td> </tr> <tr> <td>Kerf</td> <td>3.3 mm</td> <td>Tooth form</td> <td>F</td> <td>Collar thickness</td> <td>5.3 mm</td> </tr> <tr> <td>Saw body thickness</td> <td>2.3 mm</td> <td>Tooth type</td> <td>4</td> <td></td> <td></td> </tr> <tr> <td>Bore</td> <td>150.0 mm</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Key ways</td> <td>2+2</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Pin-/countersunk holes</td> <td>0</td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table> <p style="text-align: right;">CoolCut CC</p>	Dimensions	Cutting material	ST	AST-Type	BSEF	Diameter	490.0 mm	Number of teeth	32+4	Collar diameter	313.0 mm	Kerf	3.3 mm	Tooth form	F	Collar thickness	5.3 mm	Saw body thickness	2.3 mm	Tooth type	4			Bore	150.0 mm					Key ways	2+2					Pin-/countersunk holes	0				
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CIRCULAR SAW BLADES



TCT- and ST-Circular saw blades

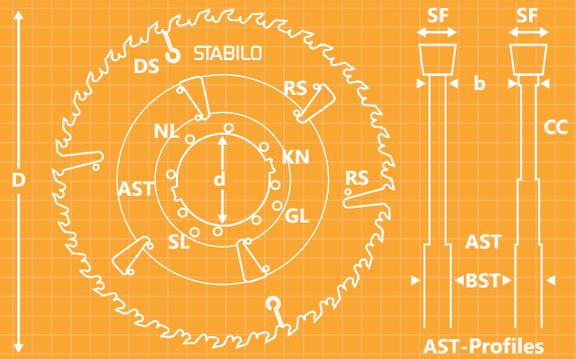
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STABILO CIRCULAR SAW BLADES



Our "SoWa Sawmill Optimised Tool Design" ensures you will have a top class STABILO circular saw blade customised for industrial use at your sawmill. Here we draw on our decades of experience and incorporate every single detail of your requirements such as machine model, cutting program, and the type of wood. This optimisation process ensures you receive a STABILO which is best matched to your cutting production, thus extremely efficient.

b Saw body thickness . **BST** Collar thickness . **CC** CoolCut . **D** Diameter
d Bore . **DS** Expansion slot . **GL** Threaded hole . **KN** Key way
NL Pin hole . **RS** Chip clearance slot . **SF** Kerf . **SL** Countersunk hole



	<h2>STABILO Hexa</h2> <p style="text-align: right;">HDS-No. 11614</p> <table border="0"> <thead> <tr> <th colspan="2">Dimensions</th> <th colspan="2">Cutting material</th> <th>TCT</th> <th>AST-Type</th> <th>BSEF</th> </tr> </thead> <tbody> <tr> <td>Diameter</td> <td>565.0 mm</td> <td>Number of teeth</td> <td>42+6</td> <td></td> <td>Collar diameter</td> <td>205.0 mm</td> </tr> <tr> <td>Kerf</td> <td>5.2 mm</td> <td>Tooth form</td> <td>F</td> <td></td> <td>Collar thickness</td> <td>7.0 mm</td> </tr> <tr> <td>Saw body thickness</td> <td>3.4 mm</td> <td>Tooth type</td> <td>4</td> <td></td> <td>Features</td> <td></td> </tr> <tr> <td>Bore</td> <td>160.0 mm</td> <td></td> <td></td> <td></td> <td>Expansion slots</td> <td>2</td> </tr> <tr> <td>Key ways</td> <td>2</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Pin-/threaded holes</td> <td>6+12</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>	Dimensions		Cutting material		TCT	AST-Type	BSEF	Diameter	565.0 mm	Number of teeth	42+6		Collar diameter	205.0 mm	Kerf	5.2 mm	Tooth form	F		Collar thickness	7.0 mm	Saw body thickness	3.4 mm	Tooth type	4		Features		Bore	160.0 mm				Expansion slots	2	Key ways	2						Pin-/threaded holes	6+12					
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CIRCULAR SAW BLADES



TCT- and ST-Circular saw blades

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TRIMCUT

Dimensions 660 x 6.0/4.5 x 30 mm

Teeth 80 TCT teeth . Tooth form alternate top bevel tooth
Tooth type 4

Features 5 expansion slots
9 noise reduction slots



TRIMCUT CIRCULAR SAW BLADES

Trimmed for cutting precision and stability

TRIMCUT is a very robust circular saw blade designed specifically for trimming. TRIMCUT delivers outstanding cutting precision with particularly high stability in trimming square timber and slab timber as well as trimming round timbers.

Along with it, the special saw body and the purposefully incorporated internal tension ensure extremely smooth operation. With the tooth geometry adapted specifically for trimming and cross cutting prevent the bottom of the wood from fraying.

The expansion slots near the tooth area, copper riveted or with end hole, prevent deflection of the circular saw blade on heating, ensuring maximum cutting precision. Additional, optionally copper riveted, vibration-reducing laser patterns in the saw body ensure lasting noise reduction.

The HDS plus factors of TRIMCUT

+ Extremely smooth running

The internal tensioning incorporated into the special saw body styles is the reason for the extremely smooth operation of TRIMCUT. And the smoothness has a positive impact on the stability of the circular saw blade.

+ Tear-free cutting results

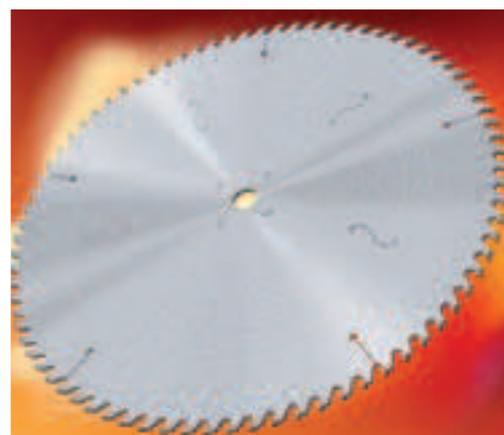
Torn edges are a thing of the past; our TRIMCUT not only cuts the top but also the bottom clean without tearing, guaranteeing a perfect cut in trimming and cutting to length.

+ Deflection-free cuts

Even with the circular saw blade running at maximum load at full speed and expanding from the frictional heat which occurs, expansion slots with end holes or optionally copper riveted, keep TRIMCUT in shape. This effectively eliminates the risk of deflection.

+ Maximum noise reduction

Riveted laser patterns specifically spread across the saw body and directly absorbing the majority of vibration responsible for the noise level, ensure noise reduction.

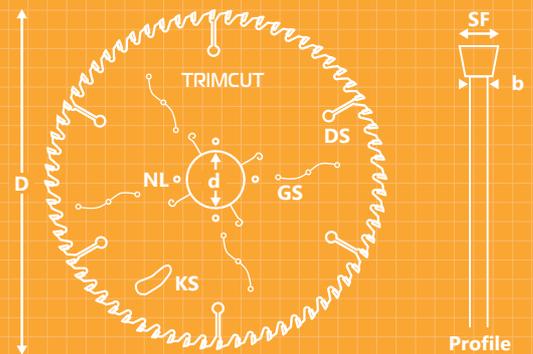


TRIMCUT CIRCULAR SAW BLADES

Our "SoWa Sawmill Optimised Tool Design" ensures you will receive a TRIMCUT customised to your specific requirements.

When designing the blade, in addition to the technical characteristics such as machine model, bore and bore pattern, we particularly incorporate your desired cutting quality. Your TRIMCUT will therefore provide maximum efficiency cuts at your sawmill.

b Saw body thickness . **D** Diameter . **d** Bore . **DS** Expansion slot
GS Noise reduction slot . **KS** Cooling slot . **NL** Pin hole . **SF** Kerf



TRIMCUT

HDS-No. 12193

Dimensions

Diameter	550.0 mm
Kerf	4.0 mm
Saw body thickness	2.8 mm
Bore	30.0 mm
Key ways	0
Pin-/countersunk holes	0

Cutting material

Number of teeth	96
Tooth form	W
Tooth type	4

TCT

Number of teeth	96
Tooth form	W
Tooth type	4

Features

Expansion slots with copper rivet	6
Noise reduction slots with copper rivet	12
Cooling slots	0



TRIMCUT

HDS-No. 13968

Dimensions

Diameter	600.0 mm
Kerf	5.7 mm
Saw body thickness	4.0 mm
Bore	30.0 mm
Key ways	0
Pin-/countersunk holes	4

Cutting material

Number of teeth	108
Tooth form	W
Tooth type	PV

TCT

Number of teeth	108
Tooth form	W
Tooth type	PV

Features

Expansion slots with copper rivet	8
Noise reduction slots with copper rivet	4
Cooling slots	0



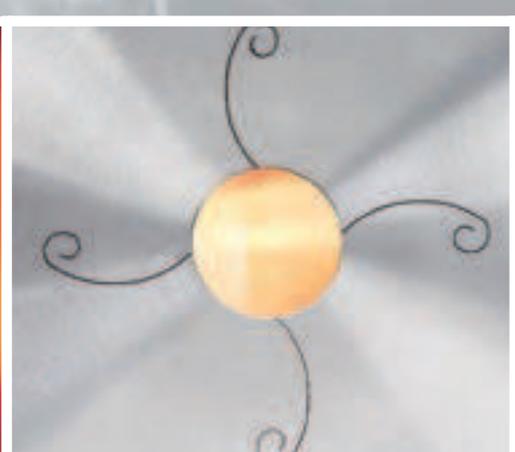


TRIMCUT CIRCULAR SAW BLADES

TCT- and ST-Circular saw blades



	<p style="text-align: right;">TRIMCUT HDS-No. 11604</p> <table border="0"> <thead> <tr> <th colspan="2">Dimensions</th> <th colspan="2">Cutting material</th> <th>TCT</th> <th colspan="2">Features</th> </tr> </thead> <tbody> <tr> <td>Diameter</td> <td>600.0 mm</td> <td>Number of teeth</td> <td></td> <td>102</td> <td>Expansion slots with copper rivet</td> <td>6</td> </tr> <tr> <td>Kerf</td> <td>5.6 mm</td> <td>Tooth form</td> <td></td> <td>F</td> <td>Noise reduction slots with copper rivet</td> <td>12</td> </tr> <tr> <td>Saw body thickness</td> <td>4.0 mm</td> <td>Tooth type</td> <td></td> <td>4</td> <td>Cooling slots</td> <td>0</td> </tr> <tr> <td>Bore</td> <td>30.0 mm</td> <td></td> <td></td> <td></td> <td></td> <td>0</td> </tr> <tr> <td>Key ways</td> <td>0</td> <td></td> <td></td> <td></td> <td></td> <td>0</td> </tr> <tr> <td>Pin-/countersunk holes</td> <td>0</td> <td></td> <td></td> <td></td> <td></td> <td>0</td> </tr> </tbody> </table>	Dimensions		Cutting material		TCT	Features		Diameter	600.0 mm	Number of teeth		102	Expansion slots with copper rivet	6	Kerf	5.6 mm	Tooth form		F	Noise reduction slots with copper rivet	12	Saw body thickness	4.0 mm	Tooth type		4	Cooling slots	0	Bore	30.0 mm					0	Key ways	0					0	Pin-/countersunk holes	0					0
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CIRCULAR SAW BLADES



HDS
CROSSCUT
Remscheid Germany



CROSSCUT

- | | |
|------------|--|
| Dimensions | 2000 x 12.90/9.0 x 75 mm |
| Teeth | 66 interchangeable TCT inserts
Tooth form Hollow tooth . Tooth type 4 |
| Features | 6 expansion slots with copper rivets
6 noise reduction slots with copper rivets |



CROSSCUT CIRCULAR SAW BLADES

Designed for rough log yard applications

CROSSCUT is designed for log yard chopping using interchangeable tungsten carbide tipped inserts. The standard hollow-ground tungsten carbide tooth has a cutting width of 12.9 mm. Varying inserts with ground bevel angle, yielding the classic Alternate Top Bevel tooth, may optionally be used.

Its robust 9 mm thick saw body ensures the CROSSCUT also remains stable under cross forces. It is further true-running and smooth, yielding a significantly longer service life.

The positive locking saw body connection with only one rivet each delivers quick and easy inserts changes. Copper riveted expansion slots and triple copper riveted, vibration-reducing laser patterns yield maximum noise reduction.

The HDS plus factors of CROSSCUT

+ Improved performance under cross-forces

The very robust, 9 mm thick saw body style increases stability to cross-forces which may occur in chopping. Its stability allows CROSSCUT to effectively absorb these impacts.

+ Improved true-running precision

The single piece inserts milled using CNC precision, which accurately fit the precisely milled pockets in the saw body with guide, result in particularly high accuracy, ensuring improved true-running. This significantly extends the service life of CROSSCUT.

+ Quick and easy tooth carrier unriveting

Only one copper rivet guarantees the positive locking saw body connection of each individual inserts. This allows for quick and easy inserts changes.

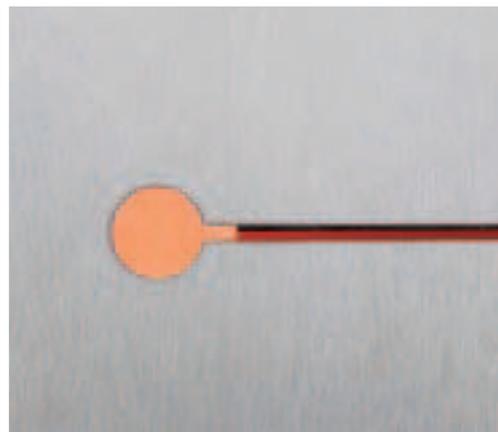
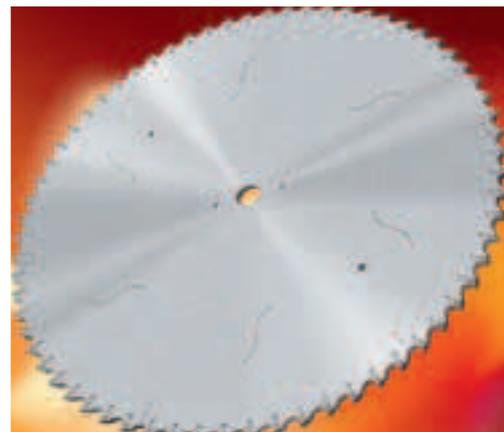
+ Maximum noise reduction

The expansion slots with copper rivets at the end and the triple copper riveted laser patterns, which effectively absorb a majority of the vibration which occurs, effectively lessen noise in the CROSSCUT.

+ HDS-Regeneration

We will regenerate your inserts to our strict quality specifications or – in a hurry – we will exchange them for regenerated inserts.

We manufacture CROSSCUT saw blades Springer, Holtec, and Linck machines, among others.

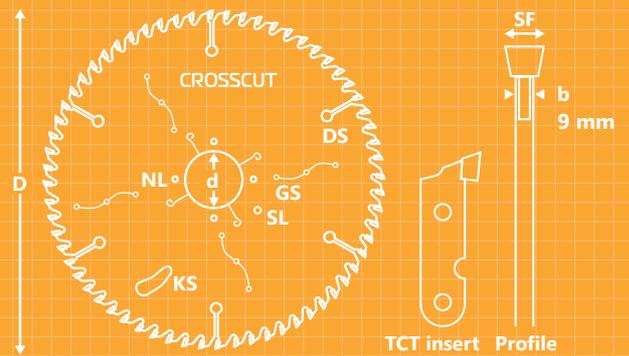


CROSSCUT CIRCULAR SAW BLADES

Our "SoWa Sawmill Optimised Tool Design" ensures you receive a CROSSCUT customised for use in your log yard.

The design not only incorporates the technical characteristics such as machine model, bore and bore pattern, but of course also the logs which will be cut. The robust CROSSCUT therefore "works" with exceptionally high stability.

b Saw body thickness . D Diameter . d Bore . DS Expansion slot
 GS Noise reduction slot . KS Cooling slot . NL Pin hole . SF Kerf
 SL Countersunk hole



TCT-Circular saw blades



CROSSCUT

HDS-No. 10865

Dimensions

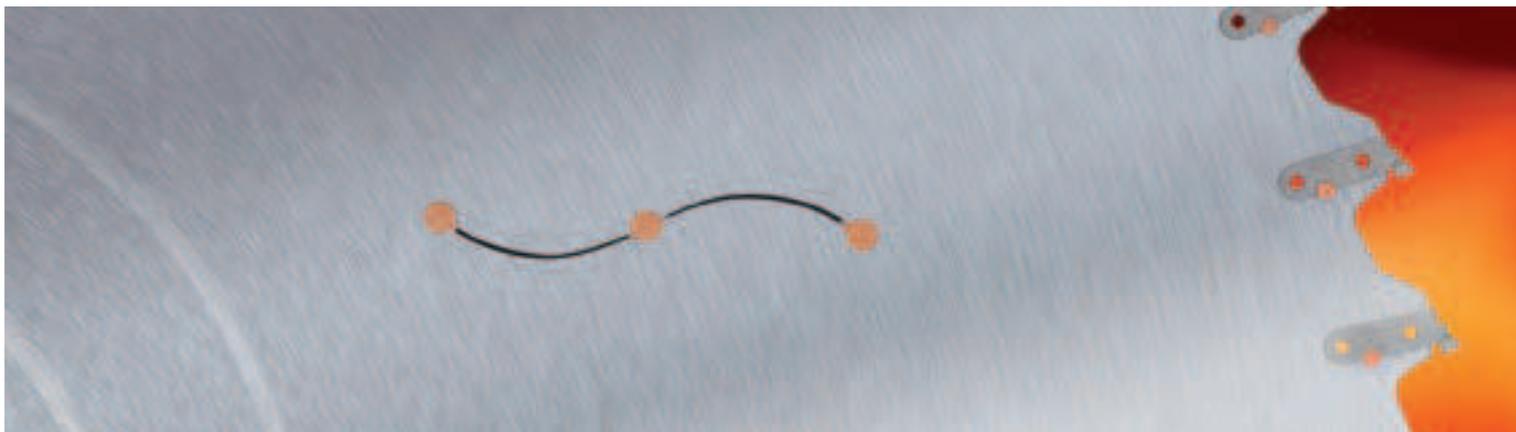
Diameter	1300.0 mm
Kerf	12.9 mm
Saw body thickness	9.0 mm
Bore	75.0 mm
Key ways	0
Pin-/countersunk holes	2

Cutting material

TCT	
Number of teeth	44
Tooth form	H
Tooth type	4

Features

Expansion slots	4	Noise reduction slots	4
with copper rivet	4	with copper rivet	4
Cooling slots	0		





CROSSCUT CIRCULAR SAW BLADES

TCT-Circular saw blades



CROSSCUT

HDS-No. 16588

Dimensions

Diameter	1600.0 mm
Kerf	12.9 mm
Saw body thickness	9.0 mm
Bore	135.0 mm
Key ways	0
Pin-/countersunk holes	6

Cutting material

TCT	
Number of teeth	54
Tooth form	H
Tooth type	4

Features

Expansion slots	6	Noise reduction slots	6
with copper rivet	6	with copper rivet	6
Cooling slots	0		



CROSSCUT

HDS-No. 28584

Dimensions

Diameter	1600.0 mm
Kerf	14.0 mm
Saw body thickness	9.0 mm
Bore	100.0 mm
Key ways	0
Pin-/countersunk holes	1

Cutting material

TCT	
Number of teeth	54
Tooth form	H
Tooth type	4

Features

Expansion slots	6	Noise reduction slots	6
with copper rivet	6	with copper rivet	6
Cooling slots	0		



CROSSCUT

HDS-No. 20072

Dimensions

Diameter	1981.0 mm
Kerf	14.0 mm
Saw body thickness	9.0 mm
Bore	75.0 mm
Key ways	0
Pin-/countersunk holes	2

Cutting material

TCT	
Number of teeth	80
Tooth form	H
Tooth type	4

Features

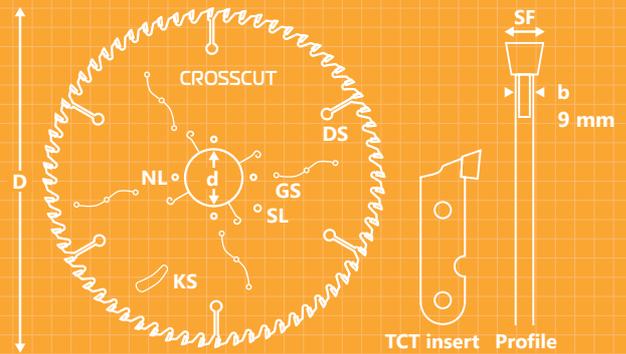
Expansion slots	8	Noise reduction slots	6
with copper rivet	8	with copper rivet	6
Cooling slots	0		

CROSSCUT CIRCULAR SAW BLADES

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The design not only incorporates the technical characteristics such as machine model, bore and bore pattern, but of course also the logs which will be cut. The robust CROSSCUT therefore "works" with exceptionally high stability.

b Saw body thickness . **D** Diameter . **d** Bore . **DS** Expansion slot
GS Noise reduction slot . **KS** Cooling slot . **NL** Pin hole . **SF** Kerf
SL Countersunk hole



TCT-Circular saw blades



CROSSCUT

HDS-No. 11736

Dimensions

Diameter	2000.0 mm
Kerf	12.9 mm
Saw body thickness	9.0 mm
Bore	75.0 mm
Key ways	0
Pin-/countersunk holes	2

Cutting material

Number of teeth	66
Tooth form	H
Tooth type	4

TCT

Features

Expansion slots	6
with copper rivet	6
Cooling slots	0

Noise reduction slots	6
with copper rivet	6

Standard-Dimension for Springer





CROSSCUT CIRCULAR SAW BLADES

TCT-Circular saw blades



CROSSCUT

HDS-No. 15912

Dimensions

Diameter	2000.0 mm
Kerf	12.9 mm
Saw body thickness	9.0 mm
Bore	135.0 mm
Key ways	0
Pin-/countersunk holes	6

Cutting material

Number of teeth	66
Tooth form	H
Tooth type	4

TCT

Features

Expansion slots	6	Noise reduction slots	6
with copper rivet	6	with copper rivet	6
Cooling slots	0		

Standard-Dimension for Holtec



CROSSCUT

HDS-No. 14891

Dimensions

Diameter	2000.0 mm
Kerf	13.0 mm
Saw body thickness	9.0 mm
Bore	75.0 mm
Key ways	0
Pin-/countersunk holes	1

Cutting material

Number of teeth	80
Tooth form	W
Tooth type	4

TCT

Features

Expansion slots	8	Noise reduction slots	6
with copper rivet	8	with copper rivet	6
Cooling slots	0		



CROSSCUT

HDS-No. 24855

Dimensions

Diameter	2200.0 mm
Kerf	14.0 mm
Saw body thickness	9.0 mm
Bore	120.0 mm
Key ways	0
Pin-/countersunk holes	1+6

Cutting material

Number of teeth	72
Tooth form	H
Tooth type	4

TCT

Features

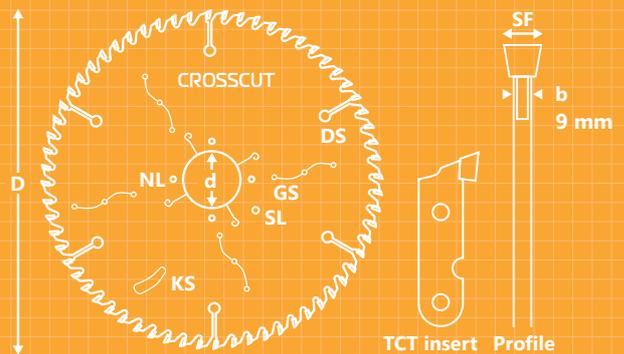
Expansion slots	8	Noise reduction slots	6
with copper rivet	8	with copper rivet	6
Cooling slots	0		

CROSSCUT CIRCULAR SAW BLADES

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The design not only incorporates the technical characteristics such as machine model, bore and bore pattern, but of course also the logs which will be cut. The robust CROSSCUT therefore "works" with exceptionally high stability.

b Saw body thickness . **D** Diameter . **d** Bore . **DS** Expansion slot
GS Noise reduction slot . **KS** Cooling slot . **NL** Pin hole . **SF** Kerf
SL Countersunk hole



TCT-Circular saw blades



CROSSCUT

HDS-No. 10464

Dimensions

Diameter	2500.0 mm
Kerf	12.9 mm
Saw body thickness	9.0 mm
Bore	120.0 mm
Key ways	0
Pin-/countersunk holes	1+6

Cutting material

Number of teeth	88
Tooth form	H
Tooth type	4

TCT

Features

Expansion slots	8	Noise reduction slots	4
with copper rivet	8	with copper rivet	4
Cooling slots	0		



CROSSCUT

HDS-No. 15434

Dimensions

Diameter	2500.0 mm
Kerf	14.0 mm
Saw body thickness	9.0 mm
Bore	120.0 mm
Key ways	0
Pin-/countersunk holes	12+3

Cutting material

Number of teeth	90
Tooth form	H
Tooth type	4

TCT

Features

Expansion slots	6	Noise reduction slots	3
with copper rivet	6	with copper rivet	3
Cooling slots	0		



CROSSCUT CIRCULAR SAW BLADES

TCT-Insert

	TCT-Insert Kerf 12.9 mm Tooth form H Saw body 9 mm System HDS HDS-No. 10117		TCT-Insert Kerf 14.0 mm Tooth form H Saw body 9 mm System HDS HDS-No. 13455
	TCT-Insert Kerf 13.0 mm Tooth form W left Saw body 9 mm System HDS HDS-No. 12682		TCT-Insert Kerf 13.0 mm Tooth form W right Saw body 9 mm System HDS HDS-No. 12681
	TCT-Insert Kerf 12.9 mm Tooth form H Saw body 7 mm System Felde HDS-No. 11229		Hollow rivet system HDS Length 11 mm Diameter 8 mm Saw body 9 mm HDS-No. Copper 10118 Steel 26057

REGENERATION

A second life for your used inserts

Used doesn't mean used up, since your insert can often be repaired or regenerated, which is much more economical compared to a new purchase.

Let us repair or regenerate your insert. In most cases this will delay a new purchase and we will return your "used ones" like new!

