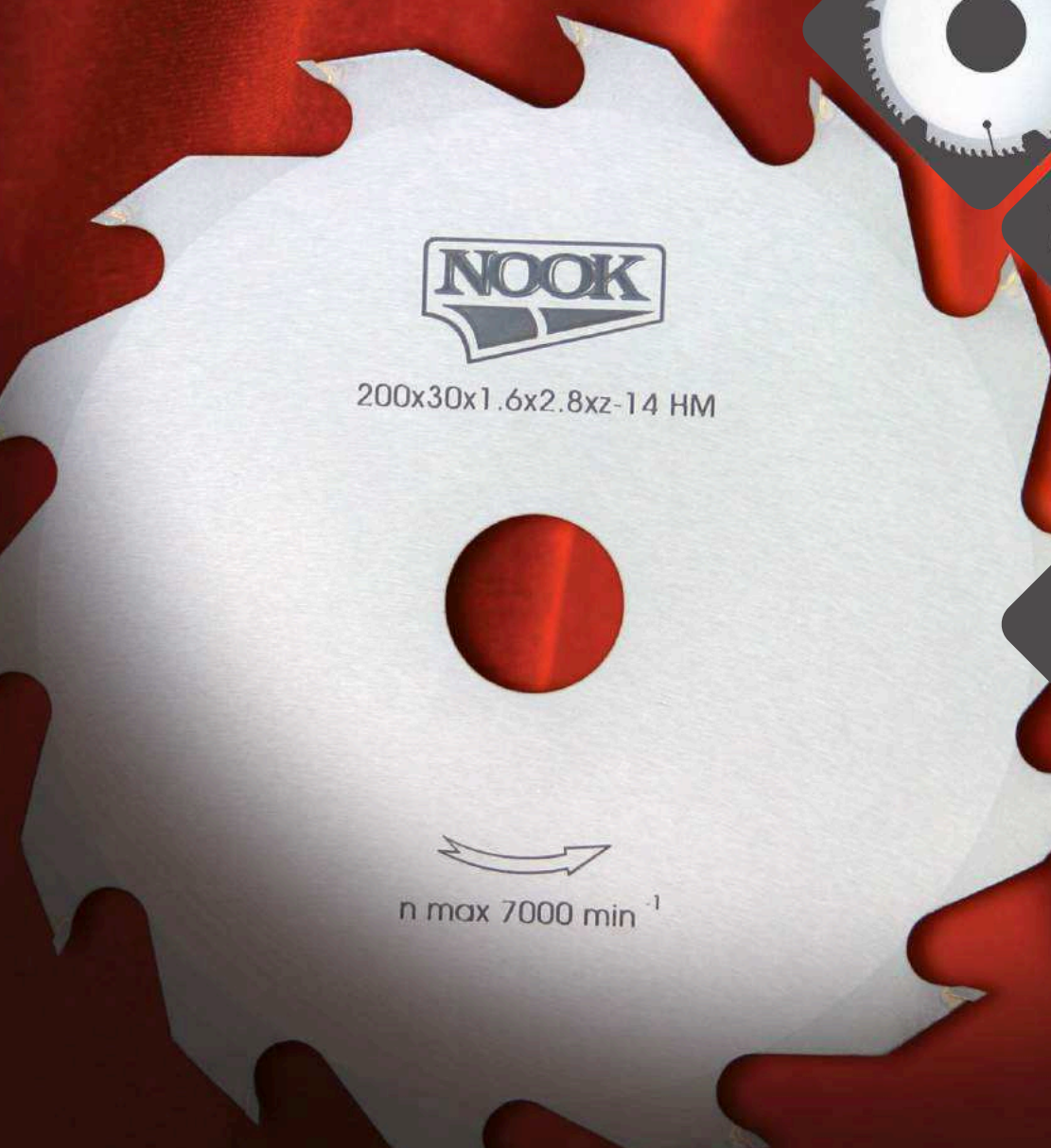


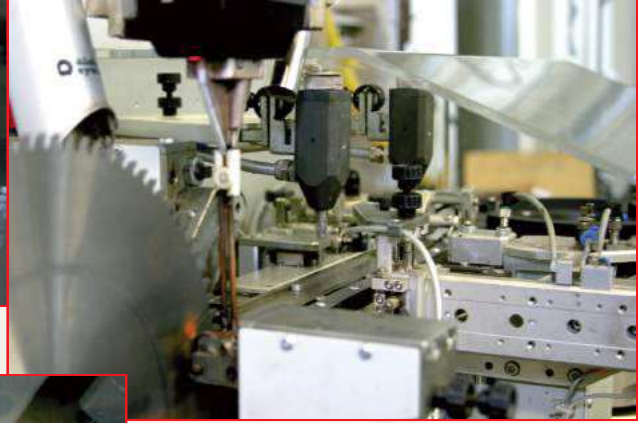
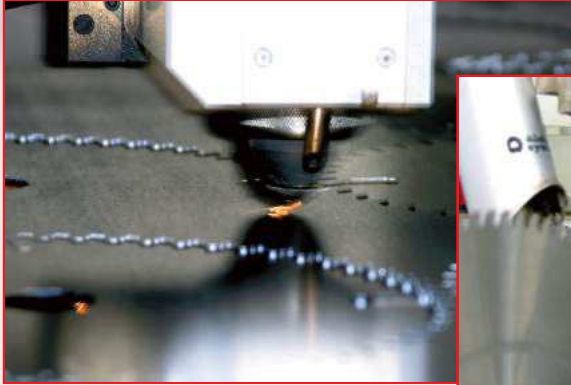


**NOOK**<sup>®</sup>



**NOOK**  
200x30x1.6x2.8xz-14 HM  
n max 7000 min<sup>-1</sup>

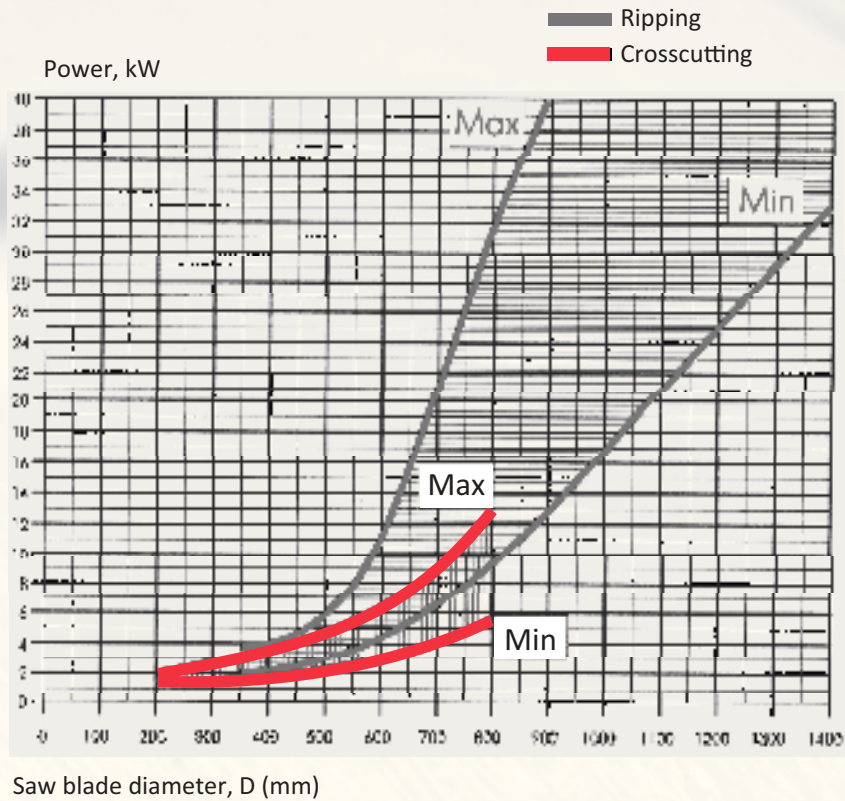




## POWER DIAGRAM

Diagram shows necessary power's subjection from saw blade diameter.

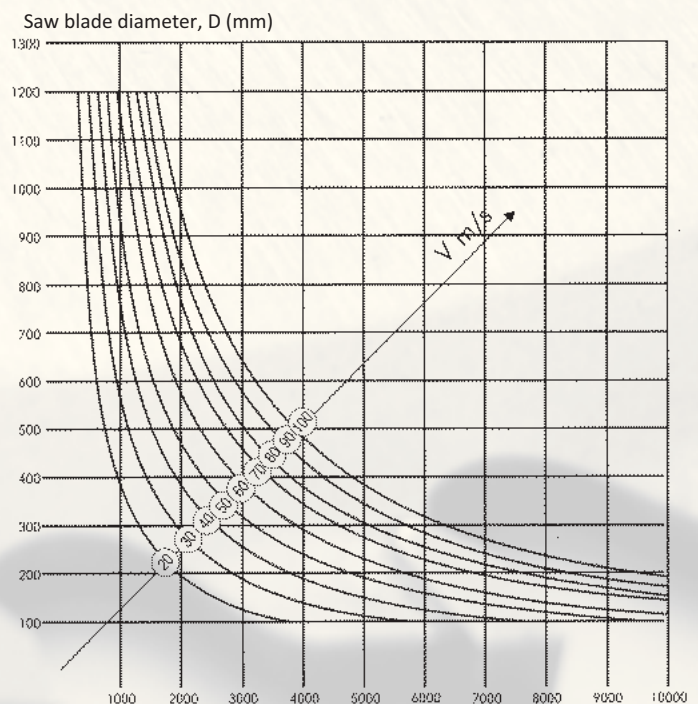
Power is measured for one saw blade.



Recommended amount of maximum and optimal rpm for a saw blade based on it's diameter (D, mm).

D	n max	n opt
250	7000	5500
300	6000	4600
350	4900	3500
400	4300	3000
450	3800	2800
500	3400	2500
550	3100	2250
600	2800	2000
650	2600	1850
700	2400	1700
750	2250	1600
800	2100	1550
900	1700	1400

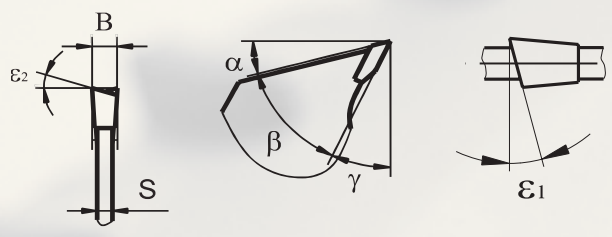
Diagram shows cutting speed dependence from saw blade outside diameter and spindle revolution.



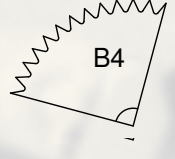
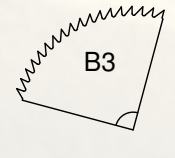
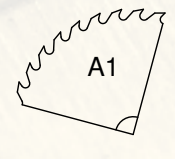
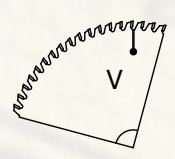
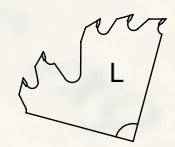
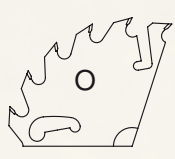
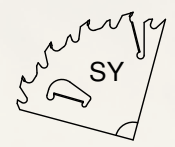
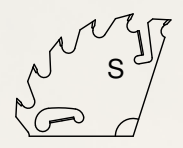




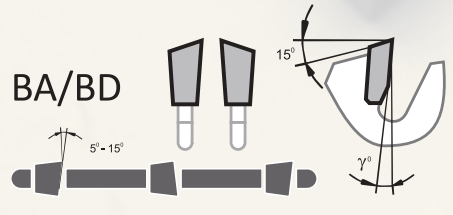
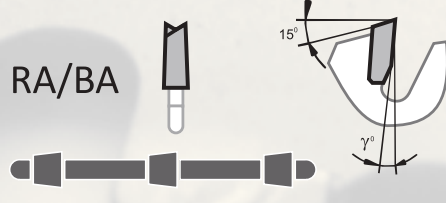
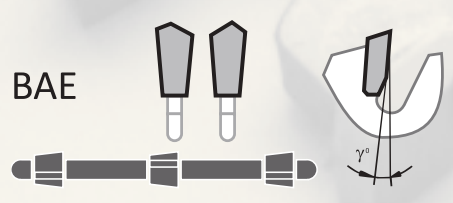
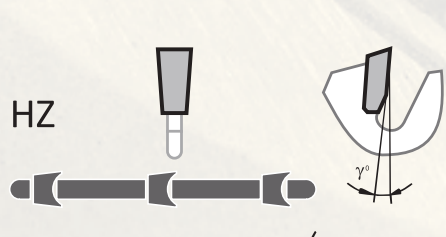
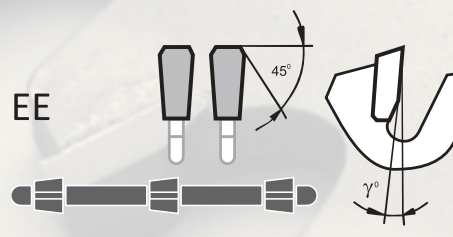
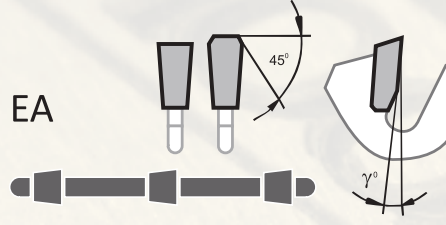
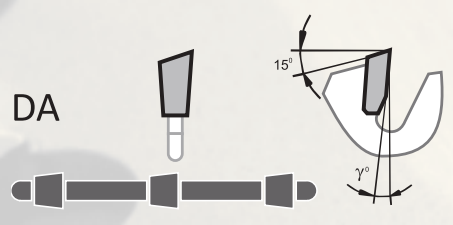
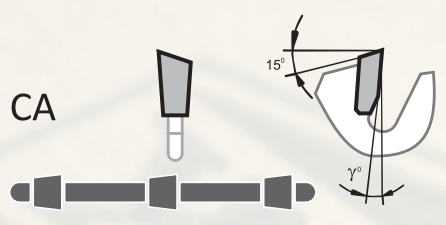
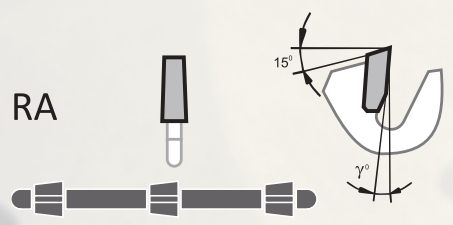
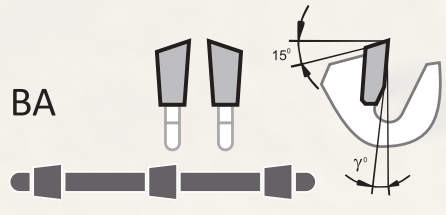
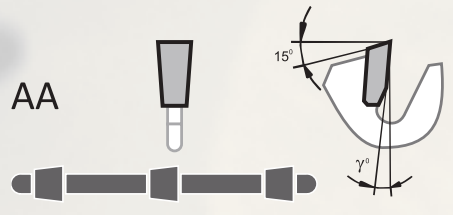
## SAWS CONSTRUCTION



$\gamma$  – rake angle -  $5^{\circ} + 30^{\circ}$   
 $\alpha$  – clearance angle  
 $\beta$  – tooth point angle  
 $\epsilon$  – back and front bevel angle



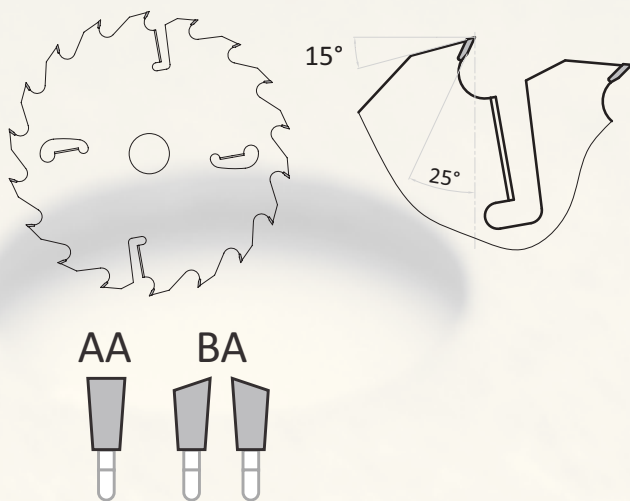
## SHARPENING TYPES



## DESIGNATIONS

- D** - Saw blade diameter
- d** - Bore diameter
- z** - Number of teeth
- S** - Blade thickness
- B** - Kerf width

## SAW BLADES WITH CARBIDE TIPS AND WITH WIPER SLOTS

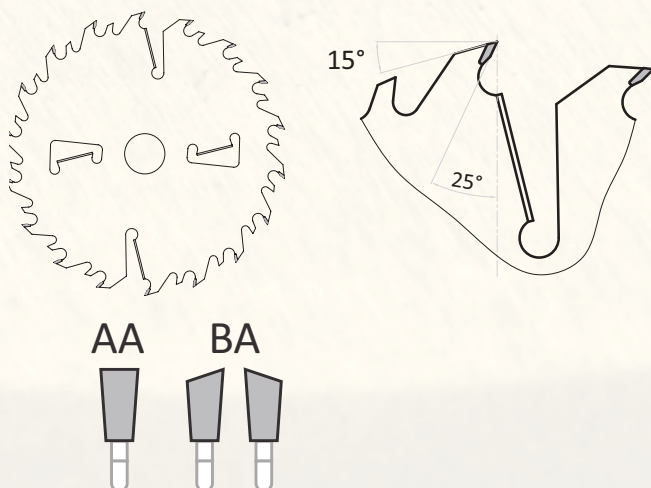


Saw blade with wiper slots is intended for ripping damp and soft wood on MULTIBLADE machines with one or two shafts.

Wiper slots improve sawdust removal from cutting surfaces, it also reduces overheating, improves heat output, prevents saw blades from trapping and protects it from damage and deformation.

	Code				Flange
	D	z	S	B	D
S	300	20+4	2.5	3.8	85-100
S	350	18+4	2.6	4.0	100-105
S	350	24+4	2.6	4.0	100-110
S	400	18+4	2.6	4.0	110-115
S	400	24+4	2.6	4.0	110-115
S	450	24+4	2.8	4.2	125-150
S	500	24+4	3.0	4.5	140-160
S	500	36+4	3.0	4.5	140-160
S	600	24+6	3.6	5.1	165-190
S	600	36+6	3.6	5.1	165-190
S	600	42+6	3.6	5.1	165-190
S	700	42+6	3.6	5.1	200-225
S	800	48+8	4.0	5.5	220-250
S	800	36+8	5.0	7.0	220-250

## SAW BLADES WITH CARBIDE TIPS, WIPER SLOTS AND INTERMEDIATE TOOTH

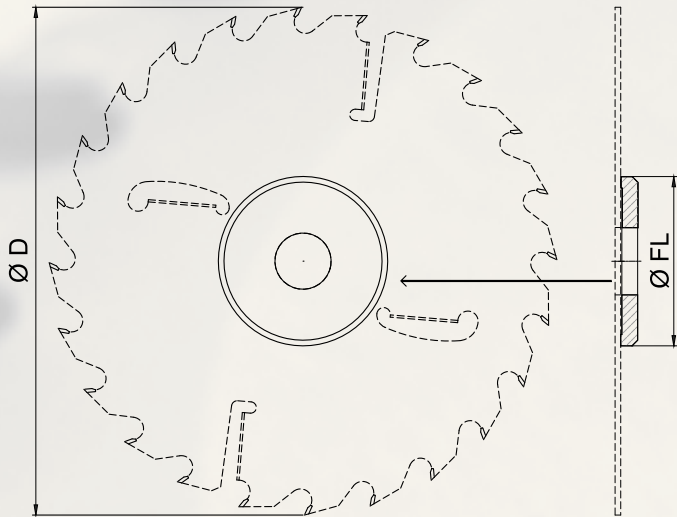


Saw blade is intended for ripping damp wood. Intermediate tooth without carbide tip improves sawdust removal from in-between the teeth.

	Code				Flange
	D	z	S	B	D
SY(M)	350	18+4	2.6	4.2	100-110
SY(M)	350	18+4	2.8	4.3	100-110
SY(M)	400	18+4	2.8	4.4	110-115
SY(M)	450	18+6	3.0	4.6	125-150
SY(M)	450	18+6	3.2	4.8	125-150
SY(M)	500	18+6	3.2	5.0	140-160
SY(M)	500	18+6	3.5	5.2	140-160
SY(M)	550	18+6	3.5	5.2	150-175
SY(M)	560	18+6	3.5	5.2	155-185
SY(M)	600	18+6	4.0	5.6	165-190
SY(M)	610	18+6	4.0	6.3	170-190
SY(M)	630	18+6	3.8	5.8	175-210
SY(M)	630	24+6	4.0	6.3	175-210
SY(M)	800	36+8	5.0	7.0	220-250



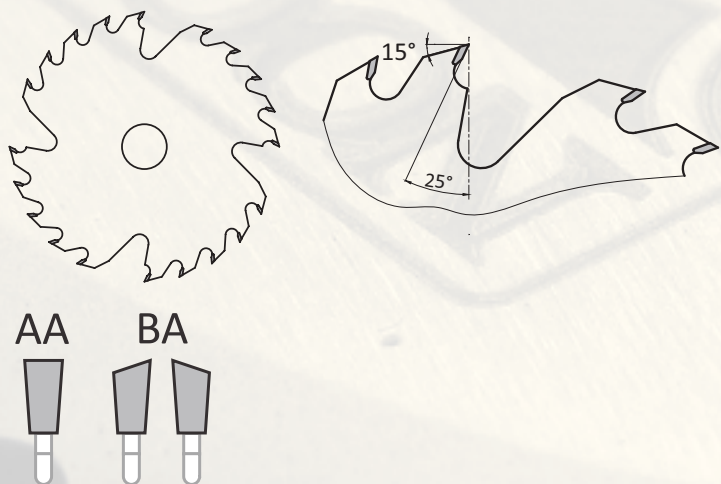
### FLANGE FOR SAW BLADES WITH WIPER SLOTS



Flanges are meant to fasten the saw blade and they should be equal in diameter which is approximately 1/3 of the saw blade diameter. Flanges must be tempered! Supporting bands of the flange must be polished, clean and have minimal runout on the shaft.

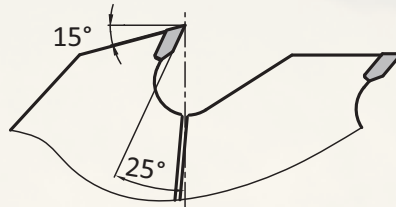
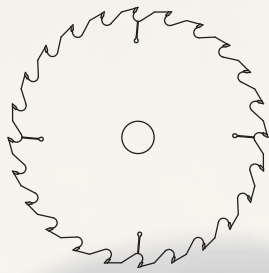
### SAW BLADES WITH CARBIDE TIPS, WITH GROUPED TEETH AND MAXIMUM DEPTH OF CUTTING

	D	z	S	B
L	300	20	2.5	3.8
L	350	20	2.6	4.0
L	350	24	2.6	4.0
L	400	20	2.6	4.0
L	400	24	2.6	4.0
L	450	20	2.8	4.2
L	450	24	2.8	4.2
L	500	20	3.0	4.5
L	500	24	3.0	4.5
L	600	30	3.6	5.1
L	600	36	3.6	5.1
L	700	36	3.6	5.1
L	800	42	4.0	5.5
L	800	42	4.5	6.0
L	800	42	5.0	6.5

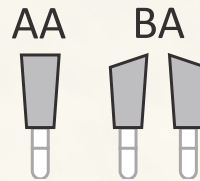


Saw blade is intended for ripping soft wood with humidity above 30%. It is used in sawing machines with one or two shaft. Grouped form of teeth improves faster sawdust removal from cutting surfaces and improves heat output.

### SAW BLADES FOR RIPPING SOFT WOOD

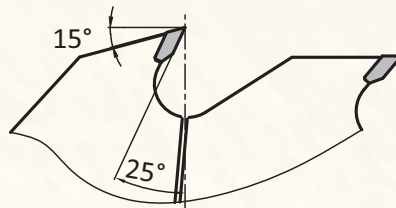
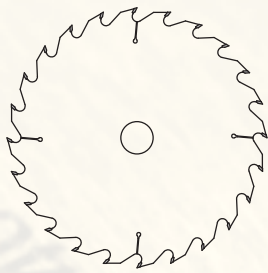


Saw blade is intended for splitting soft wood in one shaftmachines with kerf depth being 50 mm at most. Saw blade is equipped with expansion slots which provides excellent heat dispersion and eliminates chances of overheating.

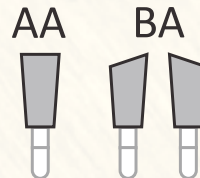


D	z	S	B
250	10	2.2	3.4
250	18	2.2	3.4
300	24	2.5	3.8
300	30	2.6	4.0
400	36	2.6	4.0
450	36	2.8	4.2
500	42	3.0	4.5
600	60	3.6	5.1
700	60	3.6	5.1

### SAW BLADES FOR RIPPING WOOD WITH MAXIMUM DEPTH OF CUTTING

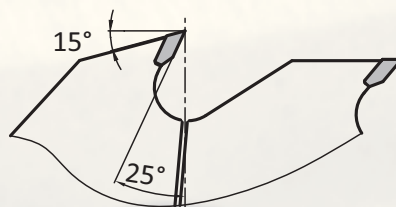
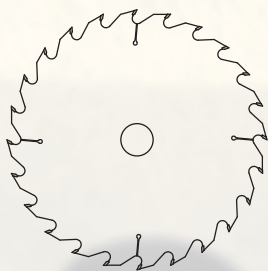


Saw blade is intended for splitting damp wood with humidity above 30%. Saw blade is equipped with expansion slots which provides excellent heat dispersion and eliminates chances of overheating.



D	z	S	B
300	20	2.5	3.8
300	20	2.5	3.0
350	18	2.6	4.0
350	24	2.6	4.0
400	18	2.6	4.0
400	24	2.6	4.0
450	24	2.8	4.2
500	24	3.0	4.5
500	36	3.0	4.5
600	36	3.6	5.1
600	42	3.6	5.1
700	36	3.6	5.1
700	42	3.6	5.1
800	48	4.0	5.5
800	42	4.5	6.0

### SAW BLADES FOR RIPPING DAMP, HARD WOOD



Saw blade is intended for splitting damp, hard wood with kerf depth being 50 mm at most. Saw blade is equipped with expansion slots which provides excellent heat dispersion and eliminates chances of overheating.



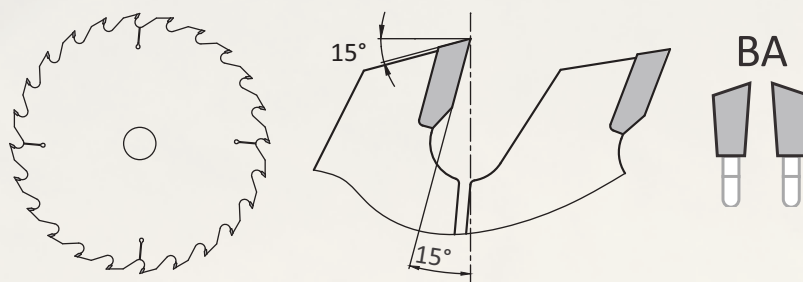
D	z	S	B
250	24	2.0	3.2
300	30	2.5	3.8
350	36	2.6	4.0
400	42	2.6	4.0
450	48	2.8	4.2
500	48	3.0	4.5
900	48	4.0	5.5
900	48	4.5	6.0
900	48	5.0	6.5





### SAW BLADES FOR CROSSCUTTING WOOD WITH MAXIMUM DEPTH OF CUTTING

D	z	S	B
250	24	2.0	3.2
300	30	2.5	3.8
350	36	2.6	4.0
400	42	2.6	4.0
450	48	2.8	4.2
500	48	3.0	4.5

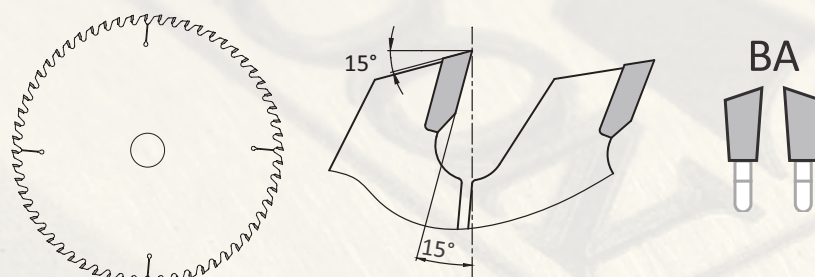


Saw blade is intended for crosscutting soft and hard natural wood, chipboard without coating, plywood and also high quality glued parts.

### SAW BLADES FOR RIPPING AND CROSSCUTTING DRY WOOD

D	z	S	B
250	36	2.2	3.2
300	48	2.5	3.5
350	54	2.6	3.6
400	60	2.6	3.8
400	72	2.6	3.8
450	60	2.8	4.0
450	72	2.8	4.0
500	72	3.0	4.2
600	90	3.6	4.8
600	72	3.6	4.8
600	72	4.0	5.5
800	72	4.0	5.5
800	72	4.5	6.0
800	72	5.0	6.5
900	60	4.0	5.5
900	60	4.5	6.0
900	60	5.0	6.5

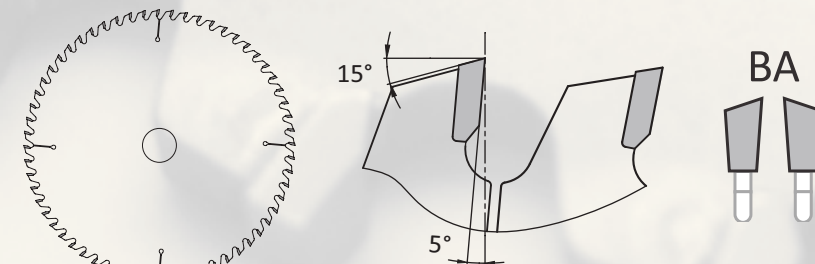
D	z	S	B
900	72	4.0	5.5
900	72	4.5	6.0
900	72	5.0	6.5
900	80	4.0	6.0
900	80	4.5	6.5
900	80	5.0	7.0



Saw blade is intended for ripping and crosscutting dry wood, plywood, fiber-board and drywall on dimensioning machines with kerf depth being 50 mm at most.

### SAW BLADES FOR CROSSCUTTING DRY AND HARD WOOD

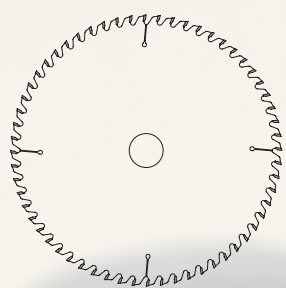
D	z	S	B
250	36	2.0	3.0
300	48	2.5	3.5
350	54	2.6	3.6
400	60	2.6	3.8
400	72	2.6	3.8
450	60	2.8	4.0
450	72	2.8	4.0
500	72	3.0	4.2
600	90	3.6	4.8



Saw blade is intended for crosscutting dry and hard species of wood, chipboards and plastics in trimming and dimensioning machines with kerf depth being 50 mm at most.



## SAW BLADES FOR CROSSCUTTING OF HARD AND SOFT WOOD

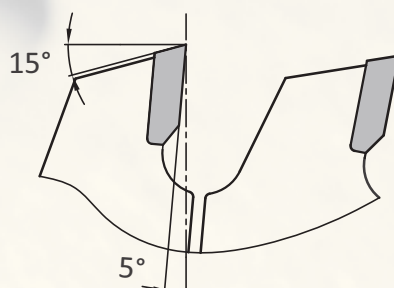


BA



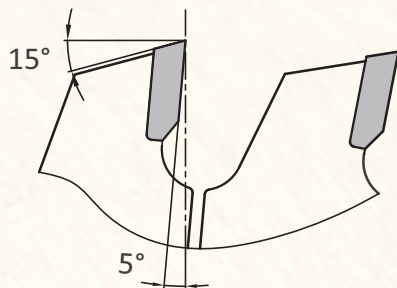
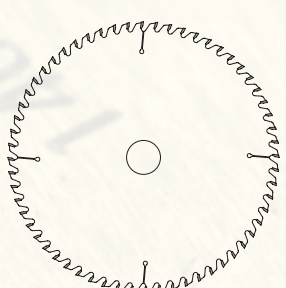
Saw blade is intended for usage in dimensioning machines with mechanical feed.

D	z	S	B
250	40	2.0	3.0
250	48	2.0	3.0
250	60	2.0	3.0
250	72	2.0	3.0
300	48	2.5	3.5
300	60	2.5	3.5
300	80	2.5	3.5



D	z	S	B
300	96	2.5	3.5
350	54	2.6	3.6
350	60	2.6	3.6
350	72	2.6	3.6
350	96	2.6	3.6
350	108	2.6	3.6
400	48	2.6	3.8
400	60	2.6	3.8
400	72	2.6	3.8
450	60	2.8	4.0
450	72	2.8	4.0
500	60	3.0	4.2
500	72	3.0	4.2
600	72	3.6	4.8
600	96	3.6	4.8

## SAW BLADES FOR CROSSCUTTING CHIPBOARD, PLYWOOD AND PLASTICS



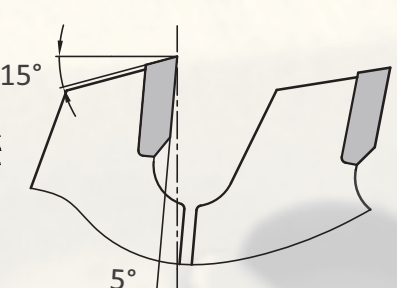
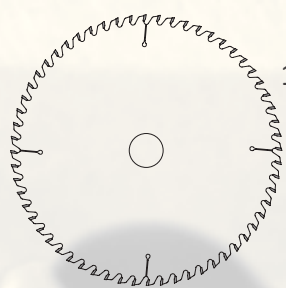
EA



Special saw blade is intended for cutting boards with two-sided laminated coating, chipboard, fiberboard, MDF and for cutting plastics.

D	z	S	B
250	64	2.0	3.0
300	90	2.5	3.5
350	90	2.6	3.6
400	120	2.6	3.8

## SAW BLADES FOR CROSSCUTTING DRY WOOD, CHIPBOARD AND LAMINATED BOARD



BA



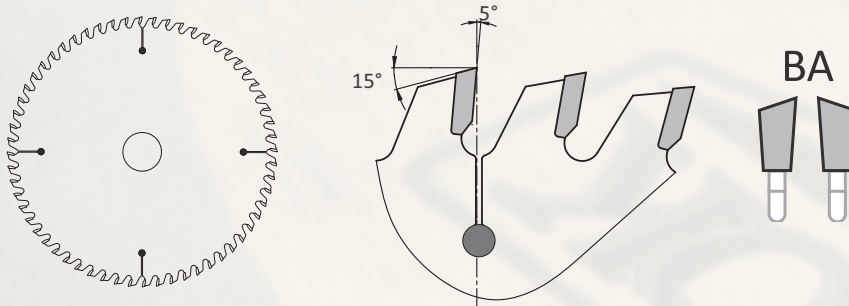
Saw blade is intended for cutting laminated chipboard, plywood with thickness being 30 mm at most and kerf depth being 50 mm at most.

D	z	S	B
250	48	2.0	3.0
300	60	2.5	3.5
300	60	2.5	3.5
300	80	2.5	3.5
300	80	2.5	3.5
350	72	2.6	3.6
400	80	2.6	3.8
450	72	2.8	4.0
450	90	2.8	4.0
500	90	3.0	4.2
600	120	3.6	4.8



## LOW NOISE SAW BLADES FOR CROSSCUTTING HARD AND SOFT WOOD

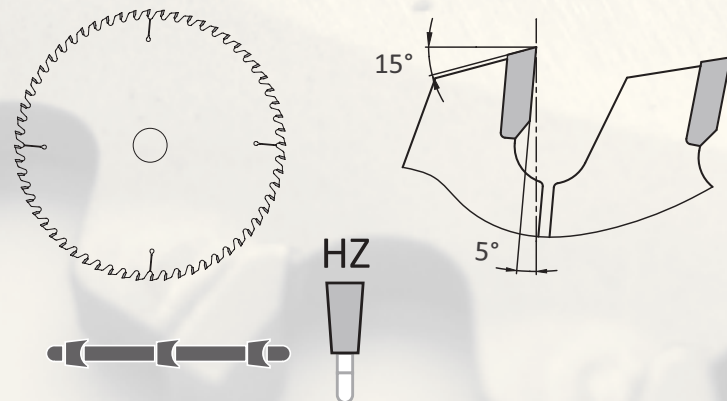
	D	z	S	B
V	250	48; 56; 60; 64; 72; 76; 80; 90; 96	2.0	3.0
V	300	54; 60; 64; 72; 80; 84; 90; 96; 102; 120	2.0	3.5
V	350	54; 60; 72; 80; 84; 90; 96; 100; 108; 120	2.5	3.6
V	400	60; 64; 72; 80; 90; 96; 100; 108; 120	2.6	3.8
V	450	72; 80; 84; 90; 96; 108; 120; 138	2.6	4.0
V	500	72; 80; 90; 96; 106; 108; 112; 120; 132; 144	2.8	4.2
V	600	72; 90; 96; 100; 120; 136; 144; 172	3.6	4.8
V	700	84; 90; 96; 120	3.6	5.1
V	800	96; 120	4.0	5.5



Saw blade is intended for cutting dry and hard species of wood and chipboard. Copper rivets are pressed into round slots to reduced the noise level while operating the saw.

## SAW BLADES FOR FINISH CROSS CUTTING OF WOOD

D	z	S	B
350	72	2.4	3.4
300	72	2.6	3.8
350	90	3.0	4.1
500	108	3.0	4.1
500	112	3.0	4.1
600	96	3.2	4.2
600	120	3.2	4.2



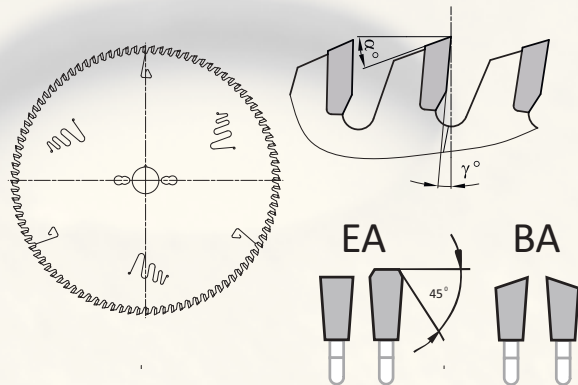
Saw blade is intended for finish cross cutting of wood on optimization line. Special sharpening type provides excellent cutting quality.



## SAW BLADES FOR FURNITURE INDUSTRY

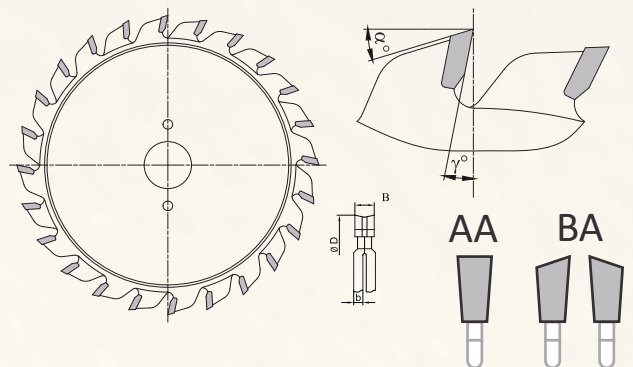
### PANEL SIZING SAW BLADES

	D	z	d	S	B
Z	300	96	30	2.2	3.2

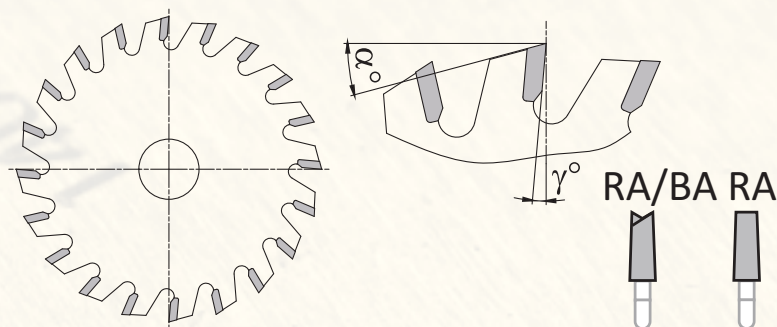


### DOUBLE SCORING SAW BLADE

	D	z	S	B
P	120	12+12	2.0 (2.2)	2.8-3.6
P	125	12+12	2.0 (2.2)	2.8-3.6



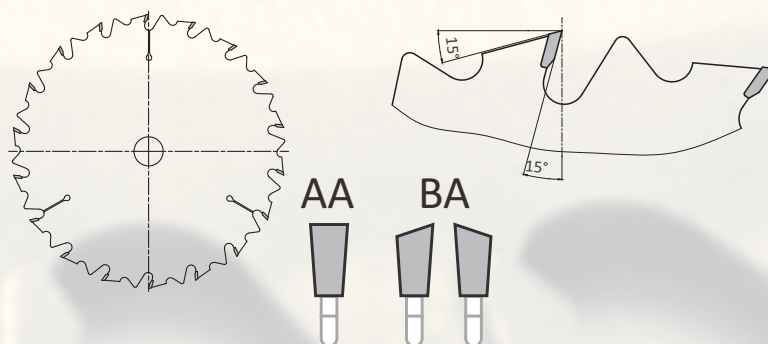
### SAW BLADE WITH CARBIDE TIPS FOR SCORING LAMINATED WOOD



	D	z	S	B
P	80	12	2.8	3.2-3.9
P	80	20	2.8	3.2-3.9
P	100	20	2.8	3.2-3.9
P	100	24	2.8	3.2-3.9
P	120	24	2.8	3.2-3.9
P	125	20	2.8	3.2-3.9

Scoring blades with conical teeth are used with basic saw blade notching the bottom layer of the laminate. It protects the layer from damage on the edges of the cut after main saw has passed.

### SAW BLADES WITH CARBIDE TIPS AND SAFETY TEETH



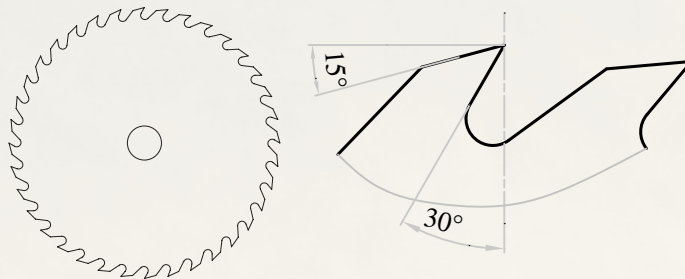
	D	z	S	B
R	125	26	1.6	2.6
R	125	26	2.0	2.6
R	300	18	2.5	3.8
R	350	22	2.6	4.0
R	500	32	3.0	4.5

Saw blade is intended for ripping boards and bars on one-saw machines with manual feed.



## SAW BLADES WITHOUT CARBIDE TIPS FOR RIPPING WOOD

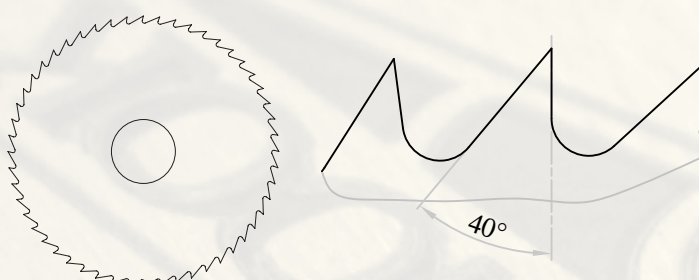
	D	z	S
A1	300	60	2.0; 2.2; 2.5
A1	350	36; 48	2.8; 3.0; 3.2
A1	400	36; 48	2.8; 3.0; 3.2; 3.5
A1	450	60	2.8; 3.0; 3.2; 3.5
A1	500	36; 48	2.8; 3.0; 3.2; 3.5
A1	600	36; 48; 60	3.2; 3.6
A1	700	42; 48	3.2; 3.6
A1	800	48; 60	4.0; 4.5; 5.0
A1	900	48; 60	4.0; 4.5; 5.0



A1 type saw blade is without carbide tips. Intended for ripping soft wood. Easy to sharpen, but requires distribution of the teeth.

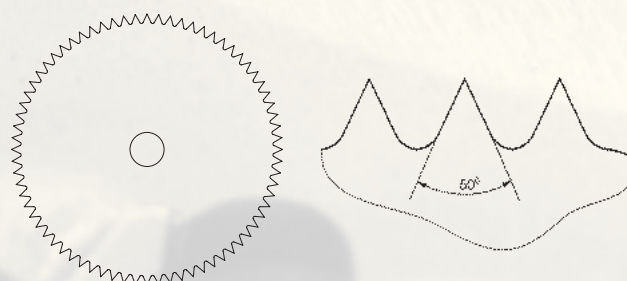
## SAW BLADES WITHOUT CARBIDE TIPS FOR CROSSCUTTING WOOD

	D	z	S
B3	300	72	2.0; 2.2; 2.5
B3	350	72	2.8; 3.0; 3.2
B3	400	72	2.8; 3.0; 3.2; 3.5
B3	450	72	2.8; 3.0; 3.2; 3.5
B3	500	72	2.8; 3.0; 3.2; 3.5
B3	600	72	3.2; 3.6
B3	700	72	3.2; 3.6
B3	800	72	4.0; 4.5; 5.0



B3 type saw blade is without carbide tips. Intended for crosscutting. Used in machines with shafts that are located at the bottom, compared to the cutting material.

	D	z	S
B4	300	48; 70	2.0; 2.2; 2.5
B4	350	60; 70	2.8; 3.0; 3.2
B4	400	60; 72; 96	2.8; 3.0; 3.2; 3.5
B4	450	60; 72; 96	2.8; 3.0; 3.2; 3.5
B4	500	60; 72; 96	2.8; 3.0; 3.2; 3.5
B4	600	60; 72; 96	3.2; 3.6
B4	700	72; 96; 120	3.2; 3.6
B4	800	72; 96; 120	4.0; 4.5; 5.0



B4 type saw blade is without carbide tips. Intended for crosscutting. Used in machines with shafts that are located at the top, compared to the cutting material.





### ORDER FORM FOR SAW BLADES WITH CARBIDE TIPS

Company name: \_\_\_\_\_ Tel. number: \_\_\_\_\_

Delivery type: \_\_\_\_\_

Address of delivery: \_\_\_\_\_

Nr.	Diameter of the saw D, mm	Amount of teeth z	Bore diameter d, mm	Blade thickness S, mm	Kerf width B, mm	Teeth sharpening type	Ripping or crosscutting Rake angle	Amount pcs.

Date: \_\_\_\_\_

Contact person: \_\_\_\_\_

### ORDER FORM FOR SAW BLADES WITHOUT CARBIDE TIPS

Company name: \_\_\_\_\_ Tel. number: \_\_\_\_\_

Delivery type: \_\_\_\_\_

Address of delivery: \_\_\_\_\_

Nr.	Saw blade type	Diameter of the saw D, mm	Amount of teeth z	Bore diameter d, mm	Blade thickness S, mm	Additional comments	Amount pcs.

Date: \_\_\_\_\_

Contact person: \_\_\_\_\_



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