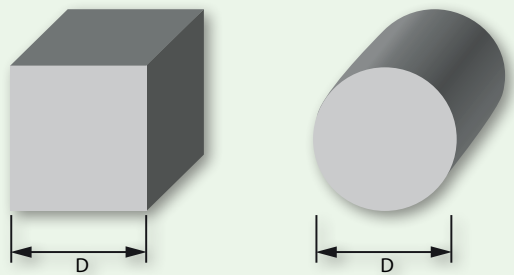
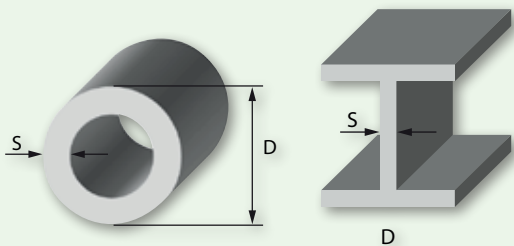


Zahnteilungsempfehlung



Variable Zahnungen bei Vollmaterial

D (mm)	Materialquerschnitt in mm																			
	0	15	20	25	35	40	50	70	80	90	120	130	150	180	200	220	350	450	500	>600
ZpZ	10/14																			
		8/12																		
			6/10																	
				5/8																
					5/6															
						4/6														
							4/5													
								3/4												
									2/3											
										1.5/2										
											1/2									
																0.75/1.25				



Variable Zahnungen bei Rohren und Profilen

D (mm)	20	40	60	80	100	150	200	300	500
S (mm)	Zähne pro Zoll (ZpZ)								
2	14				10/14				8/12
3	14	10/14		8/12			6/10		5/8
4	14	10/14		8/12		6/10		5/8	4/6
5	14	10/14		8/12	6/10		5/8	4/6	
6	14	10/14	8/12		6/10	5/8		4/6	
8	14	8/12	6/10			5/8		4/6	
10		6/10		5/8		4/6			3/4
12		6/10	5/8	4/6				3/4	
15				4/6		3/4			2/3
20				4/6		3/4			2/3
30				3/4			2/3		
50						2/3			1.5/2.0
75							2/3	1.5/2.0	
100								1/2	0.75/1.25
150									0.75/1.25

Bandsägen-Schnittparameter

Material	DIN	USA	JIS	bi-alfa cobalt	bi-alfa cobalt RP	bi-alfa Master	bi-alfa RP Master	bi-alfa cobalt M51	Master Superme	Bandbreite (mm) 27 x 0.9 bis 34 x 1.1		Bandbreite (mm) 41 x 1.3 bis 54 x 1.6		Bandbreite (mm) 67 x 1.6 bis 80 x 1.6		
										Sägebandempfehlung	Vc (m/min)	Vz (cm²/min)	Vc (m/min)	Vz (cm²/min)	Vc (m/min)	Vz (cm²/min)
											Vollmat. Ø 50–350 mm		Vollmat. Ø 100–500 mm		Vollmat. Ø 400–2000 mm	
1.0060	St 60-2	A 572 Gr.65	SM 58	✓						65 – 70	35 – 40	60 – 65	40 – 45	40 – 50	20 – 30	
1.0401	C15	1016	S 15C	✓						65 – 70	35 – 40	60 – 65	40 – 45	40 – 50	20 – 30	
1.0503	C45	1045	S 45C	✓						68 – 74	40 – 45	65 – 70	45 – 50	40 – 55	20 – 35	
1.0570	St 52-3	A572 Gr.50	SM 490	✓						68 – 74	40 – 45	65 – 70	45 – 50	40 – 55	20 – 35	
1.1158	Ck25	1025	S25C	✓						68 – 74	40 – 45	60 – 70	45 – 50	40 – 55	20 – 30	
1.1221	Ck60	1060	S58C	✓						68 – 74	40 – 45	60 – 70	40 – 45	35 – 45	15 – 25	
1.2080	X210Cr12	D3	SKD 1	✓	✓					33 – 37	10 – 18	25 – 35	15 – 20	15 – 20	5 – 10	
1.2312	40CrMnMoS 8-6			✓	✓					49 – 53	22 – 30	45 – 50	28 – 32	25 – 30	10 – 15	
1.2343	X38CrMoV5-1	H11	SKD 6	✓	✓					41 – 45	18 – 24	36 – 40	22 – 26	22 – 30	10 – 20	
1.2363	X100CrMoV5-1	A2	SKD 12	✓	✓					38 – 42	15 – 20	30 – 36	18 – 22	20 – 26	8 – 14	
1.2379	X155CrVMo12-1	D2	SKD 11	✓	✓					33 – 37	10 – 18	25 – 35	15 – 20	15 – 20	5 – 10	
1.2510	100 MnCrW4	O1	SKS 3	✓	✓					42 – 46	18 – 24	36 – 42	22 – 26	26 – 30	12 – 18	
1.2606	X37CrMoW 5-1	H12	SKD 62	✓	✓					42 – 46	18 – 24	36 – 42	22 – 26	20 – 28	8 – 16	
1.2714	56 NiCrMoV7	L6	SKT 4	✓	✓					42 – 46	20 – 26	40 – 45	25 – 30	26 – 34	12 – 18	
1.2842	90 MnCrV 8	O2		✓	✓					42 – 45	18 – 24	36 – 42	24 – 28	24 – 32	12 – 18	
1.3343	S 6-5-2	M2	SKH 51	✓	✓					36 – 40	16 – 20	30 – 35	16 – 20	26 – 30	12 – 18	
1.3247	S 2-20-1-8	M42	SKH 59	✓	✓					36 – 40	16 – 20	30 – 35	16 – 20	26 – 30	12 – 18	
1.3965	X8CrMnNi 18-8	Nitronic 50		✓	✓	✓	✓	✓	✓	30 – 32	8 – 12	26 – 28	12 – 18	12 – 18	4 – 8	
1.4006	X10Cr13	SUS410	410	✓	✓	✓	✓	✓	✓	32 – 34	12 – 16	30 – 34	16 – 22	20 – 26	8 – 14	
1.4028	X 20 Cr 13	420	SUS 420J1	✓	✓	✓	✓	✓	✓	36 – 38	15 – 20	32 – 36	18 – 22	26 – 30	6 – 10	
1.4125	X105CrMo17	440 C	SUS 440 C	✓	✓	✓	✓	✓	✓	34 – 37	12 – 18	28 – 32	16 – 18	16 – 22	6 – 10	
1.4301	X5CrNi 18-10	304	SUS 304	✓	✓	✓	✓	✓	✓	36 – 38	15 – 20	32 – 36	18 – 22	16 – 22	6 – 10	
1.4401	X5CrNiMo 17-12-2	316	SUS 316	✓	✓	✓	✓	✓	✓	34 – 36	14 – 18	28 – 32	16 – 18	16 – 22	6 – 10	
1.4462	X2VrNiMoN 22-5-3	2205	SUS 329J3L	✓	✓	✓	✓	✓	✓	32 – 34	10 – 14	28 – 32	16 – 20	16 – 22	6 – 10	
1.4571	X6 CrNiMoTi17-12-2	316 Ti	SUS 316	✓	✓	✓	✓	✓	✓	32 – 34	10 – 14	28 – 32	16 – 20	16 – 22	6 – 10	
1.4841	X15CrNiSi 25-20	314	SUH 310		✓	✓	✓	✓	✓	28 – 32	8 – 12	26 – 30	12 – 16	14 – 20	4 – 8	
1.4864	X12NiCrSi 36-16	330	SUH 330		✓	✓	✓	✓	✓	28 – 32	8 – 12	26 – 30	12 – 16	14 – 20	4 – 8	
1.4923	X22 CrMoV 12-1				✓	✓	✓	✓	✓	28 – 32	8 – 12	26 – 30	12 – 16	14 – 20	4 – 8	
1.4980	X5 NiCrTi 26-15	A286	SUH 660		✓	✓	✓	✓	✓	28 – 32	8 – 12	26 – 30	12 – 16	14 – 20	4 – 8	
1.5710	36 NiCr6	(X)3140		✓	✓					48 – 52	22 – 28	44 – 48	28 – 32	26 – 34	12 – 18	
1.5755	31 NiCr14	3415	SNC 815	✓	✓					50 – 54	24 – 30	46 – 52	30 – 36	30 – 36	14 – 20	
1.6310	20 MnMoNi-5			✓	✓					48 – 52	22 – 28	44 – 48	28 – 32	26 – 34	12 – 18	
1.6523	20 NiCrMo2	8620	SNCM 220	✓	✓					50 – 54	24 – 30	44 – 50	30 – 34	26 – 34	14 – 20	
1.6546	40 NiCrMo 2-2	8640	SNCM 240	✓	✓					50 – 54	24 – 30	44 – 50	30 – 34	30 – 34	10 – 18	
1.6562	40 NiCrMo7	E4340	SNB24-1-5	✓	✓					50 – 54	24 – 30	44 – 50	30 – 34	30 – 34	10 – 18	
1.6749	23 CrNiMo 7-4-7			✓	✓					50 – 54	24 – 28	44 – 50	28 – 32	30 – 34	10 – 16	
1.6985	28 CrMoNiV 4-9			✓	✓					54 – 58	28 – 34	48 – 54	32 – 38	36 – 40	16 – 22	
1.7147	20 MnCr5	SMnCr420H	5120	✓	✓					58 – 62	28 – 36	52 – 56	32 – 38	38 – 46	18 – 26	
1.7225	42 CrMo4	4140	SCM 440	✓	✓					54 – 58	28 – 34	48 – 54	32 – 38	36 – 40	16 – 22	
1.7228	50 CrMo4	4150	SCM 445	✓	✓					56 – 60	30 – 36	52 – 56	34 – 40	34 – 40	16 – 20	
1.7335	13CrMo 4-4	SFVA F 12	A387 Gr. 12	✓	✓					62 – 64	32 – 38	56 – 60	36 – 44	40 – 46	18 – 26	
1.7707	30 CrMoV9			✓	✓					54 – 58	28 – 34	44 – 50	28 – 34	28 – 34	16 – 20	
1.8159	50 CrV4	6150	SUP10	✓	✓					52 – 54	24 – 30	52 – 48	32 – 38	32 – 40	12 – 20	
1.8509	41 CrAlMo 7	A 355 Cl. A	SACM 645	✓	✓					42 – 45	18 – 24	36 – 40	22 – 26	18 – 24	8 – 14	