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Highline

by Swedex

Made in Sweden

SWEDEX

SAW BLADES

INDEX

MISSION & VISION

Swedex develops, manufactures and markets circular saw blades for the global wood, aluminium, plastic and metal processing industry.
Swedex aim is to be a leading manufacturer of circular sawblades through high expertise and customised solutions. This, together with a focus on improving performance and quality, will result in increased profitability for our customers.
Through close and personal collaboration with our customers, Swedex develops & creates value in their selected product areas.

We will lead the development of circular sawblades for all applications by:

Investing in the development of skills within our business. The pursuit of issues of quality, safety and care for our environment.

Maintaining an interesting and secure workplace and ensuring the safety and care of our employees.

Working with enthusiasm, passion and respect for the individual.

Swedex vision is to lead the development of solutions with a focus on speciality and customised solutions for the global industry in wood, aluminium, plastic and metal processing.

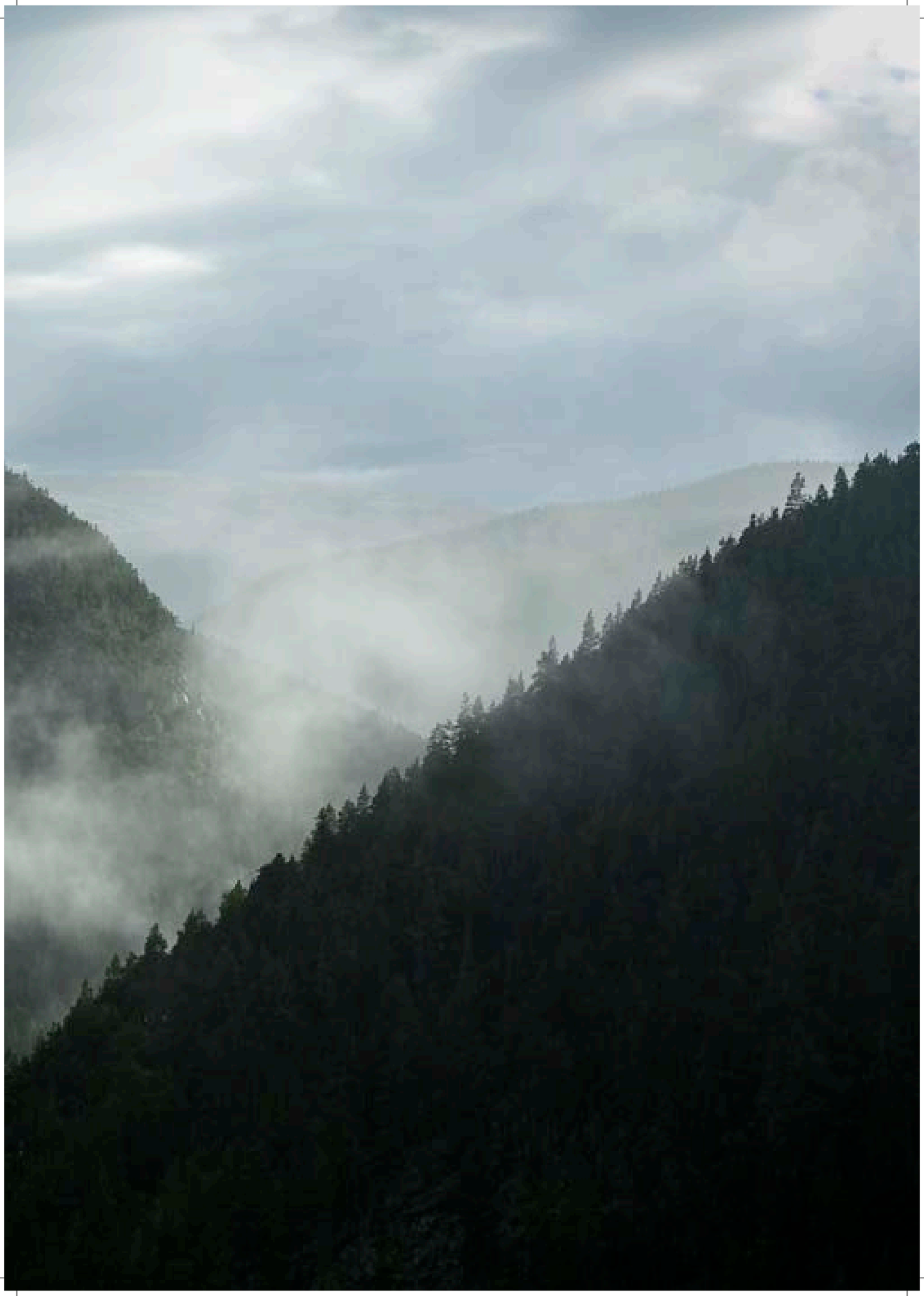
Per Johansson, CEO

THE COMPANY

Swedex is one of the leading manufacturers of saw blades in the northern Europe. Our long-term investments in quality, competence and customer service have given us the confidence of our customers and have contributed to our market leading position.

Our saw blades are sold via distributors and resellers all across Sweden.. About 50% of our sales are sold via export to areas such as Norway, Denmark, Finland, Poland, Great Britain, Germany, Spain, Russia, South America and Australia.

We have more than 40 000 saw blades in stock for immediate delivery. Furthermore we produce customer specific saw blades adapted to the customer´s needs and area of use. Our salespeople dedicate a lot of their time to adivse our customers regarding the choice of saw blade along with the development of saw blades for specific purposes. .



HISTORY

Our sister company, Swedex AB was founded in 1983 and has developed from an ambitious small company to being one of Sweden's leading manufacturers of circular saw blades.
The UK company was founded in 2002 and has grown substantially since then. Our sales & technical staff have a vast product knowledge and many years of experience within the saw blade industry.

Peter Granath, 56 years.

Peter has been working at Swedex since 1991 with production planning and construction.
He has seen the company grow as a successful company in the metal industry.

"AT SWEDEX YOU´RE FLEXIBLE AND OPEN FOR NEW IDEAS "

"At my time at Swedex I have hade the opportunity to grow through facing new challanges"

/Marie- Anne, acconunting

Anders Krappe, 62 years.
Works at Swedex as a production manager.
His job is to control the production and develop products that keep the highest standards after your request.
He sees the continiuous development of production, through investments in personnel and equipment.

COMPETENCE, CONTINUITY AND QUALITY.

”To me, development is a desire to be a team and dare to have ambitions”
/ Magnus Karlsson, sales/ technical support

CONTACT US

For further information, or to discuss your requirements our telephone number is 08000509633 .

Alternatively you may fax us on 01302 751807.
Our email address is

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TECHNICAL HANDBOOK


2525M12

SWEDEX CODE SYSTEM

Swedex code system specifies the composition of the saw blade.

First the rake angle is specified, in this example 6 degrees. Negative rake angle is indicated by N, e.g. N2.

Tooth shape is specified by two or three letters.

Tooth pitch is the distance between two adjacent teeth.

Special indicates different features of the saw blade, e.g. T2 states that the saw blade has smaller kerf and SP states that it is a special saw blade.

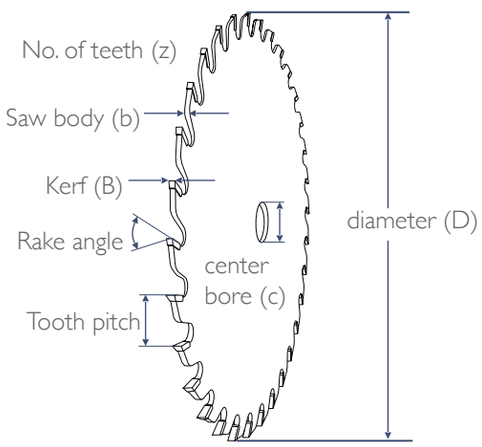
Thereafter the diameter is specified (in mm like the other measures).

Kerf is the width of the TCT tooth.

Saw body is the thickness of the steel body.

The centre bore is specified with the general tolerance H7

No. of teeth is always written after the letter z.



6 BA 10 T2 350 3,2/2,2 30 Z112

- 6 — Toothshape Hook angle
- BA — Toothshape
- 10 — Tooth pitch
- T2 — Special
- 350 — Diameter
- 3,2/2,2 — Kerf/ saw-body
- 30 — Center bore
- Z112 — No. of teeth

RAKE ANGLE

The rake angle depends on the material, type of cutting and machine type.

Negative 5-10°
Crosscutting of wood in pendulum and parallel saws, edge band cutting and trimmer machines using down cut feed.

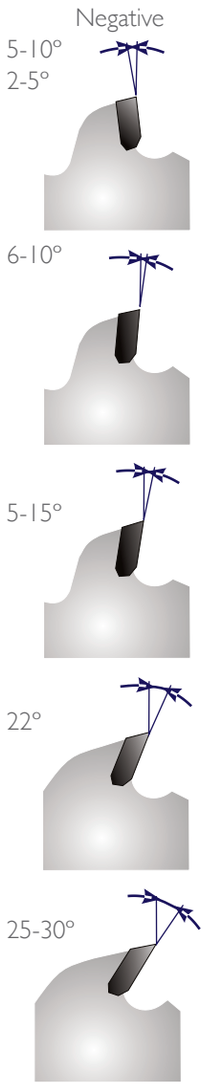
Negative 2-5°
Cutting of metals with manual feed, plastics and laminates.

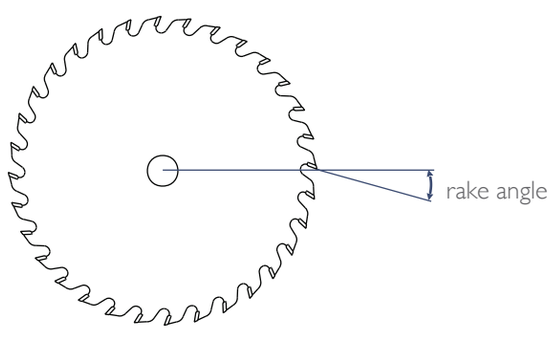
6-10°
Crosscutting of wood, hard plastics and veneered and laminated boards. Metal sawing with automatic feed.

5-15°
Crosscutting of wood. Panel sizing of chipboards, plastics, plywood and veneered boards.

22°
Ripping of dry or green wood.

25-30°
Ripping and edging of green wood.

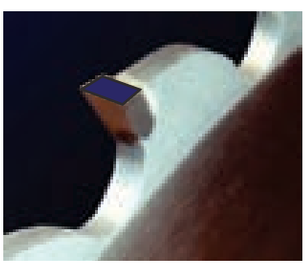




TOOTH SHAPE

Tooth shape indicates what kind of top grinding the saw blade has. Here the most common types are shown. Although there are several other types and combinations than the ones listed below.

AA. Straight teeth
For ripping wood, including multirip sawing. Can be used with high feed speeds where an average surface finish is required.

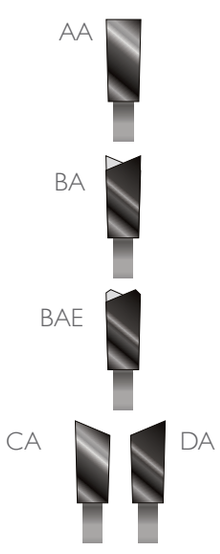


BA. Alternately bevelled teeth.
For ripping and crosscutting wood. Panel size sawing, e.g. of plywood. Gives good finish.

BAE. Alternately bevelled teeth with chamfer.
For sawing of thin and hard plastics.

CA. Right hand bevelled teeth.

DA. Left hand bevelled teeth.
All teeth are bevelled in the same direction. Gives good finish. Used for pre-sawing, scribing, tenoning, and panel sizing.

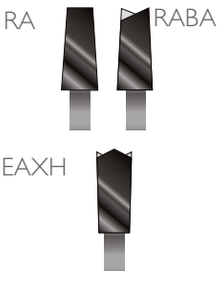


EA. Trapezoidal teeth
Roughing and finishing teeth. For sawing of coated and non-coated woodblocks e.g. chip-, fibre-, MDF- and HDF-boards. Also suitable for plastic and laminated boards.

EAM. Trapezoidal teeth.
EAM for sawing of metal.

RA. Straight teeth with conical sides.
Used as a scribing saw blade when fractioning boards, prior to panel sizing.

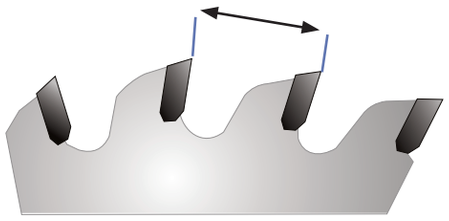
RABA. Alternately bevelled teeth with conical sides.
Often used for plastics.



EAXH. Alternately straight and inverted V tooth, with hollow ground front.
For sawing of varnished and coated boards.

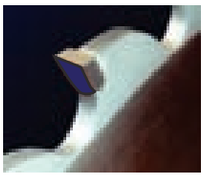
TOOTH PITCH

Tooth pitch is an important factor when choosing blades for different types of work. The pitch is the distance between the front faces of adjacent teeth and is given in mm. The tooth pitch is determined by the thickness of the material to be cut. Generally, the thinner the material the smaller the tooth pitch, and the thicker the material the larger the tooth pitch.
The formula to the right can be used for calculating the tooth pitch.

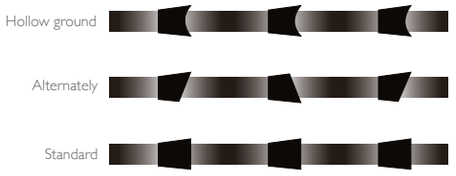


$$\text{TOOTH PITCH} = \frac{\text{DIAMETER} * \varpi}{\text{NO. OF TEETH}}$$

FRONT GRIND



The front of the tooth is straight as standard. To get maximum sharpness and the best cutting performance the teeth can also be alternately bevelled or hollow ground.



KEYWAYS & SCREW/PIN HOLES

Pin holes (PH) are specified by the pitch circle (DC) or "edge to edge" (kk), as shown in the picture.

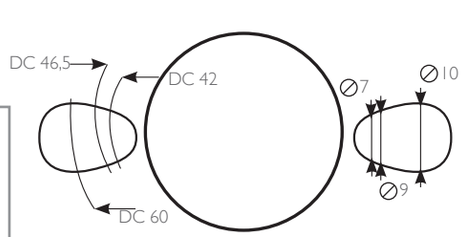
Screw holes (FH) are specified by the pitch circle (DC), see the picture above. For screw holes state Di and the countersunk angle or Dy or screw type (ex. M5).

When ordering screw holes always state the side of the countersink. Hold the saw blade with the teeth on the top faced towards you as shown in the picture. The picture shows a right hand countersink.

When ordering keyways state information about width (x), depth (y) and number of keyways.

If the saw blade only has one pin hole specify "centre / centre" distance between D and d.

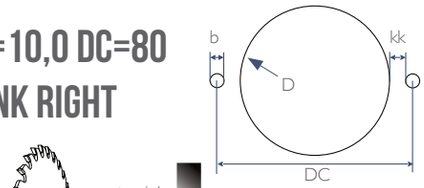
PH Combi/keyhole
2/7/42 + 2/9/46,5 +2/10/60
These holes you find on marked items in the catalogue.

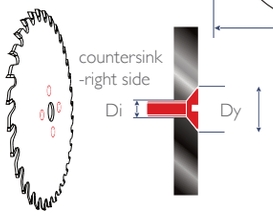


Exemple:

A blade has 4 screw holes, with inner diameter Di=6, outer diameter Dy=10 mm and DC=80 mm. The countersink is on the right hand side.

4FH 6,0 DY=10,0 DC=80 COUNTERSINK RIGHT

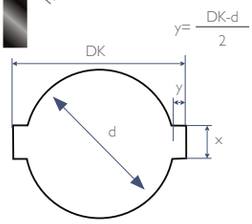




Example:

A blade has 2 keyways with width 11mm and depth 6mm.
2ks11x6
(x=11mm, y=6mm)

2KS11X6



SPECIAL

"Special" states specific features of a saw blade. In the table below some common special saw blades are listed. If the saw blade is totally customised the note "sp" is stated.

B2 = Large kerf

T2 = Small kerf

T3 = Extra small kerf

T4 = Extra small kerf (with limited cutting depth)

S = Blade with guard teeth

R = Wiper slot blade

SR = Wiper slot blade with guard teeth

E = Reduced gullet for noise reduction

L = Laser dampened saw body (The saw blades have laser tracks filled with damp mass. Noise and vibrations are therefore reduced by up to 40%).

BO = Bombastic side grinding

SPECIAL SAW BLADE

If we do not have the saw blade you are looking for, among our 40 000 articles in stock, we manufacture the saw blade according to your requirements. When ordering special saw blades a drawing should if possible be enclosed. If not, please provide the following information:

-Type of machine

-Speed (rpm)

-Feed speed (m/min)

-Diameter

-Centre bore

-Flange diameter

-Keyways, pin holes, screw holes

-Wiper slots, open or closed

-Chip limiter

-Material to be cut (green or dry)

-Saw height (mm/blade)

-Type of cutting edge

INQUIRY SPECIAL SAW BLADE CAN BE DOWNLOADED FROM WWW.SWEDEX.COM

CARBIDE TIP

Carbide tips are made out of a metallic material consisting of hard grains of carbide held together by a binding agent. The most common carbide is tungsten carbide and the most common binding agent is cobalt. To improve toughness, the binding agent is sometimes alloyed with other metallic elements. Carbides are chemical alloys of one or more metals and consist of very small grains. The grain size varies from 1 to around 7 microns (1 micron = 0.001 mm). The hardness of the carbide tip is adjusted by the size of grain. Harder carbide gives a longer wear resistance but will be more brittle. Larger grains generally result in greater toughness.

The Carbide grade is chosen for the application. One example is chipboard or MDF which are very abrasive materials and require a hard grade of carbide. A hard carbide usually has a high percentage of small grains and a small proportion of adhesive, while a softer carbide comprises of larger grains and a high proportion of adhesive. A common application for a soft variant of carbide is the cutting of steel.

The carbide hardness is measured in Vickers. The table below states some common carbide grades:
H45 1.170 HV
H20 1.440 HV
H10 1.760 HV
Longlife 2.150 HV
SMA 1.400 HV

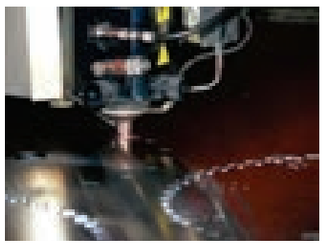
SILVER BRAZE

The carbide tooth is brazed on the steel core with silver braze. It is very important that the surfaces are clean to give a strong bond.

We use several different silver braze grades. The most common is a three layer type with copper inlay. This reduces the risk of cracks in the carbide during the brazing.

STEEL

The steel used in our saw blades is of the highest quality. It is hardened to give a combination of high strength and stability to the saw blade. The steel is laser cut and tempered to the correct hardness depending on the saw blade's area of use. It is very important to perform the heat treatment correctly in order to get the hardness, toughness and evenness to harmonize with each other. With an all too hard raw saw blade, cracks can develop by high stress, but on the other hand an all too soft raw saw blade tends to bend by side pressure.



CUTTING SPEED

Generally you should choose a blade with the smallest diameter possible (to maximize the stability) and the smallest kerf possible. At the same time the diameter must be adapted to the machine's speed of revolution to receive the most suitable cutting speed (if the speed of the machine is non-adjustable).

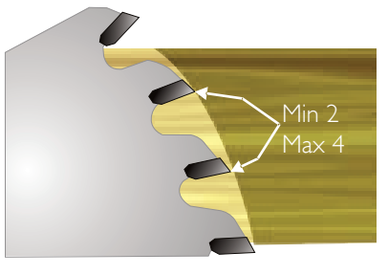
Carbide tipped saw blades require relatively high cutting speeds. The recommended speed for working in wood-based materials is about 70 m/sec. See the table below for recommended cutting speeds depending on the material to be cut. Avoid cutting speeds above 85 m/sec!

$$\text{CUTTING SPEED} = \frac{\text{DIAMETER} * \text{RPM} * \varpi}{60 * 1000}$$

Material		Cutting speed (m/sec)
Wood:	cross-cutting	50-80
	ripping dry	60-100
	ripping green	60-100
	pre-sawing and edging	60-100
Vaneered and laminated board		60-80
Fibre board		70-80
Platser- and chipboard		50-80
Vaneers, cardboard rolls (tubes)		50-80
Hard plastic		50-75
Plexiglass, PVC, bakelite		50-85
Plastic laminates		50-75
Soft plastics		15-50
Aluminium		60-80
Copper		50-70
Brass		50-70
Light concrete		40-60
Steel (not hardened- mild)		5-30

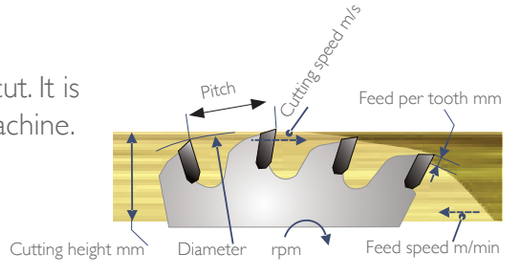
NUMBER OF TEETH

The tooth pitch is determined by the thickness of material to be cut. Generally , the thinner the material the smaller the tooth pitch, and the larger the material the larger tooth pitch. At least two and no more than four teeth must be engaged at all times when cutting in solid wood. For other materials two to six should be engaged.



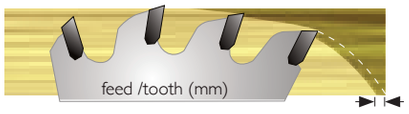
CALCULATION OF CUTTING DATA

It is important that the saw blade is optimized for the material to be cut. It is also necessary to adjust the correct speed of feed and RPM of the machine. Stated in picture:



FEED PER TOOTH

To optimize the saw blade´s service life and cutting performance the usage of a correct feed per tooth is required. Too low feed speed causes rapid wear of the cutting edge. Too fast feed speed on the other hand could cause teeth to break (as result of lacking chip pocket volume).
The table shows the recommended feed per tooth for different materials.
You can also calculate the feed per tooth by using the formula below:



$$\frac{\text{FEED SPEED} * 1000}{\text{SPEED OF REVOLUTION} * \text{NO. OF TEETH}}$$

Material		Cutting speed (m/sec)
Wood:	cross-cutting	0,10-0,35
	ripping dry	0,30-0,50
	ripping green	0,40-1,00
	pre-sawing and edging	0,70-1,50
Vaneered and laminated board		0,05-0,12
Fibre board		0,08-0,25
Platser- and chipboard		0,08-0,25
Vaneers, cardboard rolls (tubes)		0,08-0,25
Hard plastic		0,05-0,12
Plexiglass, PVC, bakelite		0,05-0,12
Plastic laminates		0,03-0,06
Soft plastics		0,05-0,08
Aluminium		0,02-0,05
Copper		0,03-0,08
Light concrete		0,03-0,08
Steel (not hardened- mild)		0,01-0,03

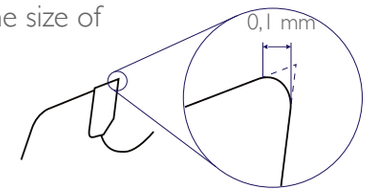
FEED SPEED

The feed speed (S) is determined by the speed of revolution (n), the number of teeth (z) and the feed per tooth (Sz).

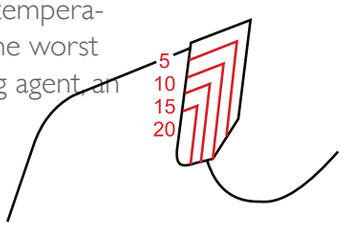
$$\frac{\text{FEED PER TOOTH} * \text{NO. OF TEETH} * \text{SPEED OF REVOLUTION}}{1000}$$

TOOL CARE

A carbide tipped blade is a precision tool that requires careful maintenance to ensure a long service life and a good performance throughout its life. Blades must be re-sharpened at the right time, i.e. when the surface of the tip becomes unacceptable, when the tip edge radius exceeds 0.1 mm, or when the cutting edge becomes chipped. Normally a carbide tipped saw blade can be re-sharpened 20-25 times depending on the size of the carbide tips.



During servicing, shims should always be placed between the blades. Teeth are very sensitive to knocks and impacts.
Clean the blade regularly to remove the coating of chips and resin that sticks to cutting edges, gullets and saw body. The coating increases the friction as well as the temperature and causes the blade to run hot and twist. The increased wear may in the worst case cause the blade to crack. We recommend the usage of Swedex cleaning agent, an efficient and environmental friendly solution.



MEASURING EQUIPMENT

It is important to have good quality measuring equipment to control the saw blade's dimensions. Swedex provides complete sets containing all the equipment needed for measuring a saw blade. Contact us for more information.

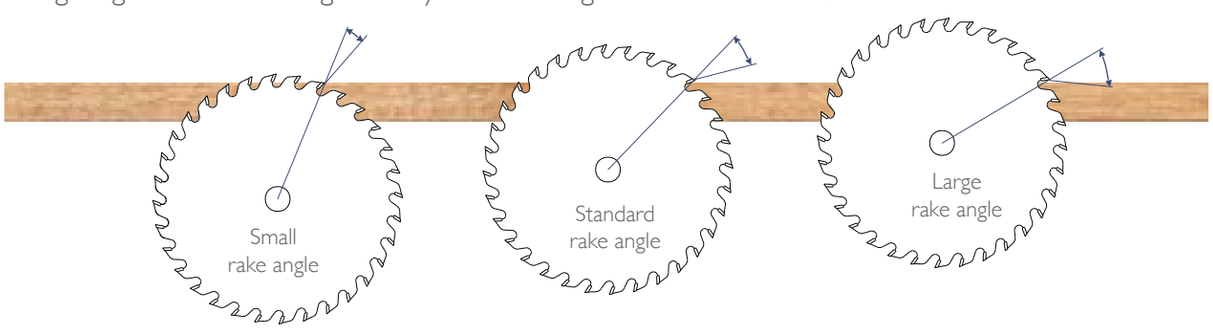
GULLET FEED INDEX

If the feed per tooth is very high the gullet volume needs to be calculated. A small gullet volume increases the risk of cracks. It is difficult to calculate the volume needed for the gullet. Swedex technical sales staff will gladly help you with this. We have developed an optimization program in Microsoft Excel for calculation of saw data. Please contact your Swedex reseller for further information.

HEIGHT OF BLADE ABOVE WORK PIECE

Tool and machine manufacturers recommend a certain rake angle for the material to be cut. Saw blades are usually designed for a standard working height of 10-25 mm above the material to be cut.

The sketches show that the rake angle varies with the cutting set-up. If the working height is increased significantly the rake angle must be modified.

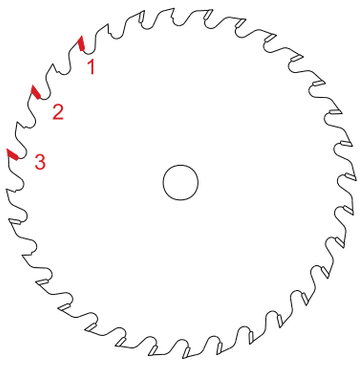


MAINTENANCE

CLEANING THE BLADE

Start by cleaning the blade thoroughly. Use a cleaning agent that will remove resin. We recommend Swedex "Avhartsningsmedel" (''Resin remedy'')

Do not scrape the blade with a sharp object as this can cause burrs and accelerate coating of the blade. Instead wipe the blade clean and dry with a soft rag or cotton wool.



REPLACE DAMAGED CARBIDE TIPS

Check if any of the teeth are damaged or missing. Replace them with teeth of the same type.

If several damaged teeth are close together they should not be brazed in sequence as this increases the risk of over heating which in turn can cause tempereing and an increased risk of the saw blade to crack. Instead you should braze alternate teeth (1, 3, 5) and then go back (2, 4, 6, etc.)

The procedure for brazing carbide tips is briefly as follows:

Remove any particles of carbide by heating and grind all traces of braze from the seat.

If necessary to degrease, wash with acetone or the like.

Brush the tooth seat with flux.

Place the braze on the tooth seat using pliers and brush with flux.

Line up the tooth with the seat using pliers.

Hold the tooth on the seat during brazing. If using high frequency brazing we recommend a temperature of 730°C. If gas brazing, heat gently with a flame until the braze melts.

Wash off any traces of flux in warm water.

Check that the teeth are placed straight.

LEVELLING AND TENSIONING

Check that the blade is flat and correctly tensioned. Levelling is easier if you have a well organised work area and accurate measuring tools.

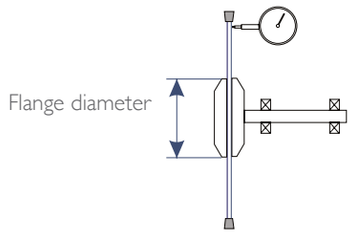
If the saw blade has been in use, it must first be straightened.

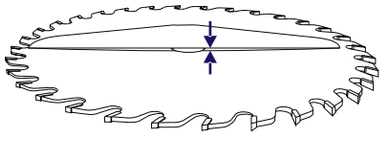
Inspect the saw blade with a steel rule or an indication clock. Use the same size of flanges as in the saw machine. If using an indication clock position it directly under the gullet. Place the blade on an anvil and check that it is flat on both sides using a long ruler. If the blade has high spots or is uneven it should be levelled using a cross-faced hammer. The table shows the tolerance of a new saw blade.

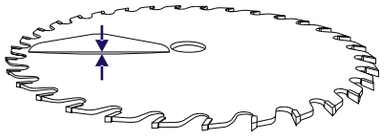
If the blade is correctly tensioned you should see a gap across the full diameter. Check this by using a long ruler (at least as long as the diameter of the saw blade).

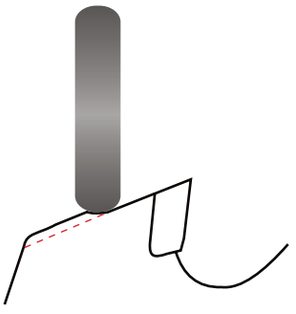
The table shows the clearance of a standard saw blade. A higher tension is required at higher cutting speeds. The blade should be uniformly tensioned across its full diameter. Check with a steel ruler, roughly equal the length of the saw blade's radius. Remove any high or low spots using a roundhead hammer. Otherwise they will cause the blade to run unevenly.

Blade diameter	Max pitch
150-250	0,06
251-300	0,07
301-400	0,10
401-500	0,12
501-600	0,15
601-700	0,18
701-800	0,20







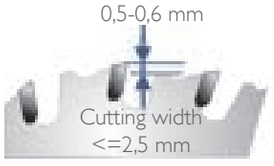


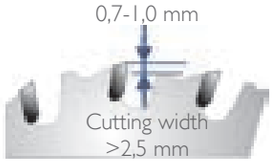
Blade diameter	Clearance
300-400	0,1-0,3
401-500	0,2-0,5
501-610	0,3-0,6
611-650	0,6-0,8
650-800	0,8-1,0

BACK GRINDING

As the carbide tip is ground the steel core also needs to be ground. There are grinding wheels available on the market that can grind both carbide and steel in one operation.

Blades with guard teeth must be ground as to the right:





GRINDING CARBIDE TIPS

These are the most important factors for achieving good results:

A stable grinding machine with good bearings.

The blade must be properly secured in the machine and gripped as close to the point of grinding as possible.

Correct choice of grinding wheel.

Right grinding data.

Good supply of coolant.

If the saw blade has replaced tips it needs to be ground on the sides. Grind to the same radial and tangential clearance angles as the original carbide tips.

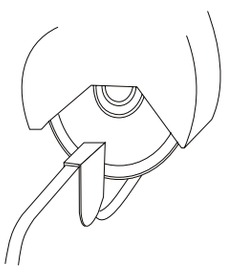
Make sure that the carbide tip has the same thickness as the original tips. Recommended grit size of diamond wheel for side grinding is D91 or D126. A softer diamond wheel gives lower grinding pressure which reduces the risk of burning. The downside is the higher wear of the diamond wheel.

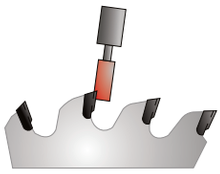
FRONT GRINDING

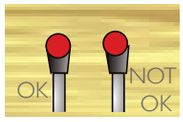
Grind no more than necessary, usually 0,05-0,1 mm.

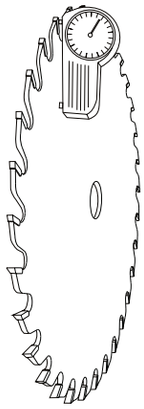
Do not change the original rake angle and make sure to grind the whole tip.

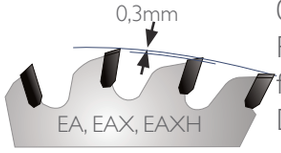
Recommended grit size of diamond wheel for front grinding is D76 or D64 for normal standards of finish.

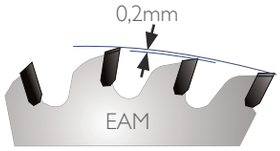












GRINDING HOLLOW GROUND CARBIDE TIPS

Use a grinding tool with a diameter suitable for the kerf of the blade:

Kerf: 3,0 mm
Tool diameter: 7,0 mm

Kerf: 3,6 mm
Tool: diameter: 8,0 mm

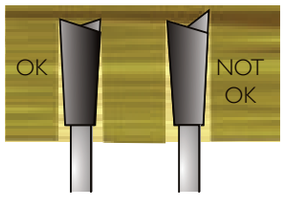
IMPORTANT WHEN GRINDING CARBIDE TIPS

For best results we recommend the following grinding times: Front grinding 8-10 seconds, depending on length of tip Top grinding 5-6 seconds.

NOTE! These times are grinding times. Longer grinding times give a better surface finish and extend tooth life. Always use automatic grinding machines! Use plenty of coolant.

TOP GRINDING

Grind the blade to maintain the original tooth 0,3 mm shape and clearance angle. Check that both teeth are of the same height (tooth shape BA).
The maximum allowable difference is 0,05 mm. A too large difference will cause the saw blade to run skew. In the case of tooth shapes EA, EAX and EAXH EAM there must be a difference of 0,3 mm between straight and trapezoidal teeth. In the case of EAM shape teeth the difference should be 0,2 mm.
Recommended grit size of diamond wheel for top grinding is D54 for single wheel, or D126/D46 for a twin rim wheel. If the blade is used to cut perspex we recommend D20B.



TOLERANCES

Centre hole H7 / H8

The tolerance H7/H8 depends on the centre holes diameter and is always a + tolerance. H7 is used up to centre hole 100 mm there after is H8 applied. Except saw blades for electrial hand saws and saw blades for building industries where H8 is applied.

H7		H8	
6,1 - 10 mm	0 till +0,015 mm	10,1-18 mm	0 till +0,027 mm
10,1-18 mm	0 till +0,018 mm	18,1-30 mm	0 till +0,033 mm
18,1-30 mm	0 till +0,021 mm	30,1-50 mm	0 till +0,039 mm
30,1-50 mm	0 till +0,025 mm	50,1-80 mm	0 till +0,046 mm
50,1-80 mm	0 till +0,030 mm	80,1-120 mm	0 till +0,054 mm
80,1-120mm	0 till +0,035 mm	120,1-180mm	0 till +0,063 mm
120,1-180mm	0 till +0,040 mm		

Keyways

+1/-0 mm Both for height and width.

Pin holes

Diameter +1/-0mm. DC/pitch +/- 0,3mm.

Screw holes

Countersunk, 90 degree +/-1 degree.
Dy +/- 0,1 mm.
DC/pitch +/- 0,1 mm.

Annealing

Hardness of steel HRc 43 +/- 2.

Steel core thickness

Ground flattened saw blade +0,01 / -0,02 mm.

Tensioning

Saw blades are tensioned from 200 mm diameter. Tolerance +2/-1 units.

BLADE DIAMETER	UNITS
200-300	3
301-350	5
351-420	6
421-600	10
601-800	12

Flatness run out

1) = Saw blade in pressure between flanges.
2) = Saw blade not in pressure between flanges.

Blade diameter	Max	Max dished 1	Max dished 2
150- 250	0,03	0,03	0,05
251- 300	0,05	0,04	0,06
301- 400	0,06	0,05	0,07
401- 500	0,08	0,06	0,08
501- 600	0,10	0,07	0,10
601- 700	0,14	0,08	0,12
701- 800	0,18	0,10	0,14

Front grinding

Rake angle +/- 1 degree.
Alternating front +/- 0,5 degree
Hollow ground front difference top +/- 0,05 mm.

Width/ Clearance

Grinded tooth clearance + 0,05 / -0,02 mm. The max variation on the width is 0,03 mm on the same saw blade. The max variation on the clearance from side to side is 0,05 mm and must not affect the width tolerance.

Radial clearance angle

The normal clearance angle is 0,6-1,1 degree but is influenced of different circumstances, for example, clearance, pitch and width. The radial clearance angle is measured on the straight part of the carbide. If measured on the lower angle part of the carbide the clearance is affected by the tangential clearance angle resulting in a too high value.

TOOTH	CLEARANCE MM	STRAIGHT PART MM	DEGREES
5 mm	+0,03/+0,08	4,5 mm	0,6
6 mm	+0,05/+0,10	5,5 mm	0,8
7 mm	+0,05/+0,10	5,5 mm	0,8
8 mm	+0,05/+0,10	5,5 mm	0,8
9 mm	+0,08/+0,14	6,5 mm	1,0
10 mm	+0,10/+0,18	6,5 mm	1,1
13 mm	+0,10/+0,20	9,0 mm	1,1

Tangential clearance angle

The normal clearance angle is 1,8-2,5 degree but is influenced by different circumstances for example, clearance, pitch and width. The tangential clearance angel is measured from the front of the carbide and straight back.

TOOTH	CLEARANCE MM	STRAIGHT PART MM	DEGREES
5 mm	+0,04/+0,08	2,0 mm	1,8
6 mm	+0,04/+0,08	2,0 mm	1,8
7 mm	+0,04/+0,08	2,0 mm	1,8
8 mm	+0,08/+0,12	2,3 mm	2,5
9 mm	+0,08/+0,12	2,7 mm	2,5
10 mm	+0,10/+0,14	3,5 mm	2,5
13 mm	+0,10/+0,16	4,6 mm	2,5

TOOTH SHAPE	RAKE ANGLE	TOP RELEASE ANGLE
EA	all	13
EAM	neg to 10	17
EAM	11-30	13
AA/BA/CA/DA	neg to 17	13
AA/BA/CA/DA	18-24	13
AA/BA/CA/DA	25-35	10

Top grinding

Diameter tolerance is + / - 1 mm.

Exception: Several are mounted on the same axle + / - 0,5 mm.

Tolerance on the different tooth shapes:

AA- Clearance angle + / - 1 degree.

BA- Clearance angle + / - 1 degree, height. difference max 0,04 mm

CA/DA- Clearance angle + / - 1 degree.

EA/EAM- Clearance angle + / - 1 degree, height difference 0,3 mm + / - 0,05 mm.

EAXH- Clearance angle + / - 1 degree, height difference 0,2 mm + / - 0,05 mm.

Wiper slot

Clearance wiper slot = half the normal side clearance, still not over 0,3 mm. Parallel 0,03 mm

Tolerance clearance ± 0,02

Guard teeth

Saw blade for steel 0,6 mm + / - 0,1 mm.
Saw blade for wood 1,3 mm + / - 0,3 mm.

Chamfer

Same dimensions ± 0,01 mm.

Balance (static balance)

Blade diameter	Max gram unbalance
150-250	1
251-300	1
301-400	1
401-500	1,5
501-600	1,5
601-700	2
701-800	3

RECOMENDATION CHART

	OPERATIONS	QUALITY	RECOMMENDED SAWBLADE	PAGE
	Sawmill			p.34-45
	Ripcut Solid wood	Fine Middle Rough	22BA19 22BA26, 22BA30 22AA39, 22AA46R	p.52 p.51 p.49, 47
	Across cut Solid wood	Fine Middle Rough	6BA10, 8BA13 10BA16, 10BA19E 10BA30	p.54, 56 p.57 p.45
	Rip/ Across cut Solid wood	Fine Middle Rough	15BA16T2 22BA19, 15BA16T2 22BA26	p.52 p.52 p.51
	Wood derived boards	Fine Middle Rough	6BA10, 8BA13 10EAXXU,15EAXXU 10EAXH16 15EAXXU	p.54, 56 p.59, 58 p.60 p.58
	Coated boards	Fine Middle Rough	6BA10, 8BA13 10EAXXU,10EAXH16 15EAXXU	p.54, 56 p.35, 36 p.58

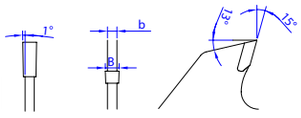
RECOMENDATION CHART

	MATERIAL	QUALITY	RECOMMENDED SAWBLADE	PAGE
	Building boards	Fine	E10, E13	p.78
			Highline	
		Middle	B16T2, B19T2, E19	p.76, 79
		Rough	B31, B26T2, E26	p.76, 79
	Grooving	Fine	6BA10, 8BA13	p.54,56
		Middle	22AA26	p.49
		Rough	22BA30	p.51
	Sandwish Constructions	Fine	N6EA13SP	p.73
		Middle	12EE16SP	p.73
		Rough	Upon request	
	Plastics	Fine	6BA6T3, 6BA8T3	p.66
		Middle	6BA10	p.54
		Rough	22BA30	p.39
	Aluminium	Fin	N2EAM6T2, N2EAM8	p.73
			Highline	
		Middle	5EAM10, 5EAM13	p.68, 69
		Rough	5EAM16, 27EAM30	p.70, 71
	Metal			
	Unhardened steel	S13/ Upon request		p.74
	Stainless steel	S13/ Upon request		p.74

SAWMILL-
PRESAWING PROFILE BLADES

HEWSAW

SÖDERHAMN



Pre-sawing. Rake angle is made according to your needs, 15-25 degree. Chamfered gullets. Surface finishing "oxide coating".

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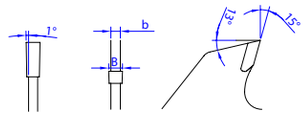
625	4,0	3,2-6,0	480	48	16/16/545-R
625	4,0	3,2-6,0	480	48	16/16/545-L
650	4,4	3,4-6,0	480	48	16/16/545-R
650	4,4	3,4-6,0	480	48	16/16/545-L
660	4,1	3,2-6,0	480	48	16/16/545-R
660	4,1	3,2-6,0	480	48	16/16/545-L
665	4,8	3,0-6,0	480	48	16/16/545-R
665	4,8	3,0-6,0	480	48	16/16/545-L
710	4,4	3,6-6,0	560	72	16/16/605-R
710	4,4	3,6-6,0	560	72	16/16/605-L
720	4,1	3,1-6,0	560	60	18/16/605-R
720	4,1	3,1-6,0	560	60	18/16/605-L

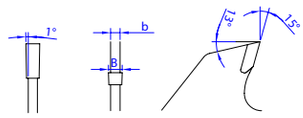
ARI/ VISLANDA



Pre-sawing. Rake angle is made according to your needs, 15-25 degree. Chamfered gullets. Surface finishing "oxide coating".
Post-sawing, can also be manufactured reversible. Surface finishing "oxide coating".

D	B	b	c	z	FH
660	4,0	2,9-7,0	460	60	12/13/530-R
660	4,0	2,9-7,0	460	60	12/13/530-L
660	4,7	3,7-7,0	460	60	12/13/530-R
660	4,7	3,7-7,0	460	60	12/13/530-L
588	8,0	7,0	460	48	6/13/496-R
588	8,0	7,0	460	48	6/13/496-L
630	8,4	7,0	460	60	6/13/530-R
630	8,4	7,0	460	60	6/13/530-L

ARI/ HEINOLA



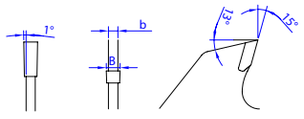
Pre-sawing. Rake angle is made according to your needs, 15-25 degree. Chamfered gullets. Surface finishing "oxide coating"

D	B	b	c	z	FH
735	4,6	3,6-7	460	72	12/28/520-R
735	4,6	3,6-7,1	460	72	12/28/520-L

SAWMILL-
PRESAWING PROFILE BLADES

HEWSAW

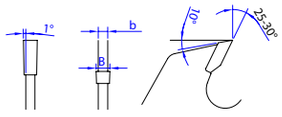
IGGESUND



Pre-sawing. Rake angle is made according to your needs, 15-25 degree. Chamfered gullets. Surface finishing "oxide coating".

D	B	b	c	z	FH
720	4,1	3,2-7,0	520	60	12/13/590-R
720	4,1	3,6-7,0	520	60	12/13/590-L

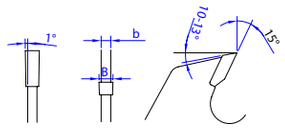
HEWSAW



Pre-sawing. Chamfered gullets. Surface finishing "oxide coated".
Note! Is also avaliable with removable wiper slots to reduce the amount of resin sticking to the blade during winter time, and to limit the risk of getting stuck.

D	B	b	c	z	info
345	3,9	2,9-10,7	144	36	Hub=256 R
345	3,9	2,9-10,7	144	36	Hub=256 L
345	4,6	3,4-10,7	144	36	Hub=256 R
345	4,6	3,4-10,7	144	36	Hub=256 L
390	5,3	4,3-8,7	190	39	Hub=320 R
390	5,3	4,3-8,7	190	39	Hub=320 L
430	4,5	3,5-8,7	190	40	Hub=358 R
430	4,5	3,5-8,7	190	40	Hub=358 L
454	4,0	3,1-8,7	240	42	Hub=390 R
454	4,0	3,1-8,7	240	42	Hub=390 L
460	4,0	3,1-8,7	240	42	Hub=390 R
460	4,0	3,1-8,7	240	42	Hub=390 L

HEWSAW



Profile blades. State pin holes and keyways when ordering.

D	B	b	c	z	info
252	4,0	3,5-6,9	70	22	R
252	4,0	3,5-6,9	70	22	L
316	4,0	3,5-6,9	70	28	R
316	4,0	3,5-6,9	70	28	L

SAWMILL-
RIPPING BLADES HEWSAW VESITO

30AA46R

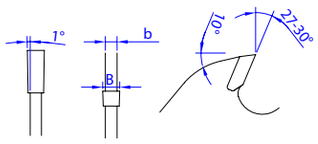
FACT

Swedex continues to grow as a supplier to the sawmill industry. Today we manufacture blades for the wide range of sawmill machines and can customise them entirely according to your needs. All sawblades can be delivered with our surface finishing "oxide coating" if required. Oxide coating reduces friction and helps to reduce residue collecting on the body of the blade.
We also produce the blades with Stellite- sawtips.

YOU ARE WELCOME WITH YOUR INQUIRY!

BLADE FACTS

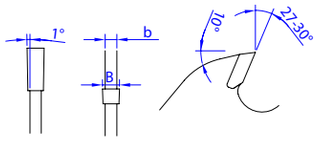
A carbide tipped blade is a precision tool that requires careful maintenance to ensure a long service life and good performance throughout its life.
The blade must be re-sharpened at the right time, i.e. when the cut surface becomes unacceptable. This usually happens when the tip edge radius exeeds 0,1 mm , or when the cutting edge becomes chipped. Normally a carbide tipped blade can be re-sharpened 20-25 times depending on the size of the carbide tips.
Clean the blade regularly to remove the coating of chips and resin that sticks to cutting edges, gullets and saw-body. The coating increases the friction as well as the temperature and causes the blade to run hot and twist. The increased wear may in the worst case cause the blade to crack. We recommend the usage of Swedex cleaning agent, an efficent and environmental friendly solution.



27AA44R

Ripping saw blade for HewSaw. Can be supplied with the surface finishing "oxide coating".

D	B	b	c	z	RS	info
251	3,6	2,4	55	18+3	50	Middle blade
251	3,6	2,4	55	18+3	50	Outer blade



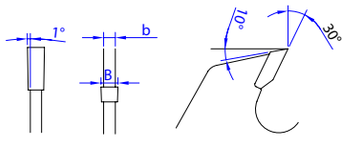
30AA46R

Ripping saw blade for HewSaw. Can be supplied with the surface finishing "oxide coating".

D	B	b	c	z	RS	info
351	3,6	2,4	70	24+2	50	Middle blade
351	3,6	2,4	70	24+2+2	50+40	Middle blade
351	3,6	2,4	70	24+2	50	Outer blade
351	3,6	2,4	70	24+2+2	50+40	Outer blade
351	3,8	2,6	70	24+2	50	Middle blade
351	3,8	2,6	70	24+2+2	50+40	Middle blade
351	3,8	2,6	70	24+2	50	Outer blade
351	3,8	2,6	70	24+2+2	50+40	Outer blade
351	4,0	2,8	70	24+2	50	Middle blade
351	4,0	2,8	70	24+2+2	50+40	Middle blade
351	4,0	2,8	70	24+2	50	Outer blade
351	4,0	2,8	70	24+2+2	50+40	Outer blade
351	4,4	3,2	70	24+2	50	Middle blade

30AA46R

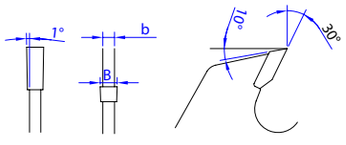
SAWMILL-
RIPPING BLADES HEWSAW VESITO



30AA36R

Ripping saw blade for HewSaw. Can be supplied with the surface finishing "oxide coating".

D	B	b	c	z	RS	info
351	3,6	2,4	70	30+2+2	50+40	Outer blade
351	4,0	2,8	70	30+2+2	50+40	Middle blade
351	4,2	3,0	70	30+2+2	50+40	Middle blade



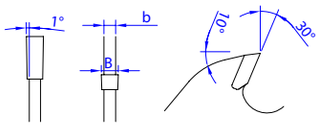
30AAXXR

Ripping saw blade for HewSaw. Can be supplied with the surface finishing "oxide coating".

D	B	b	c	z	RS	info
401	4,0	2,8	99	24+2+2	65+65	Middle blade
401	4,0	2,8	99	24+2+2	65+65	Outer blade
450	4,4	3,0	99	24+2	70	
450	4,4	3,0	99	24+4	70+60	
450	4,2	2,8	spl.	33+3	65	
450	4,2	2,8	spl.	33+3+3	60+50	
450	4,8	3,6	spl.	33+3+3	65+65	

SAWMILL- RIPPING BLADES

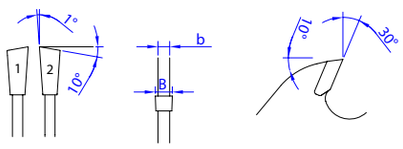
30AA46



Ripping saw blade for Ari/Vislanda. Can also be delivered with trapezoidal teeth (EA) or alterning teeth (BA).

D	B	b	c	z
700	4,0	2,0	spl2 alt. Can Drive	48
700	4,2	2,8	spl2 alt. Can Drive	48
700	4,4	4,4	spl2 alt. Can Drive	48

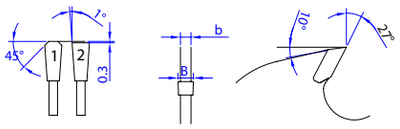
30BA34



Ripping saw blade for Heinola.

D	B	b	c	z
600	3,6	2,4	180	54

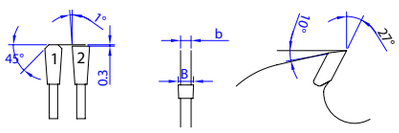
27EA39



Ripping green wood, soft and hard. Maximum cutting depth 150 mm.

D	B	b	z
500	4,0	2,8	40
560	4,4	3,0	44
610	4,4	3,0	48
650	4,4	3,0	52
700	4,4	3,0	56

27EA39T2

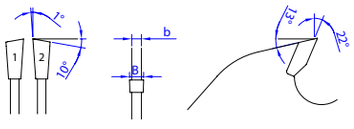


Ripping green wood, soft and hard. Small kerf. Maximum cutting depth 120 mm.

D	B	b	z
500	3,5	2,5	40
560	3,5	2,5	44
610	3,5	2,5	48
650	4,0	2,8	52
700	4,0	2,8	56

22BA30

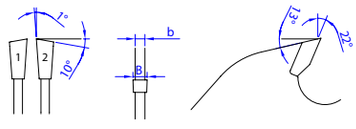
22BA30



Ripping dry wood. maximum cutting depth 120 mm.

D	B	b	z
500	4,0	2,8	50
560	4,4	3,0	56
610	4,4	3,0	60
650	4,4	3,0	64
700	4,4	3,0	72

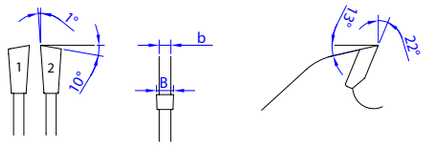
22BA30T2



Ripping dry wood. Small kerf.. Maximum cutting depth 80 mm.

D	B	b	z
500	3,5	2,5	50
560	3,5	2,5	56
610	3,5	2,5	60
650	4,0	2,8	64
700	4,0	2,8	72

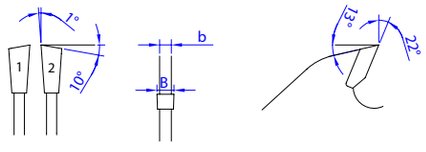
22BA26



Ripping dry wood. maximum cutting depth 100 mm.

D	B	b	z
500	4,0	2,8	60
560	4,4	3,0	64
610	4,4	3,0	72
650	4,4	3,0	78
700	4,4	3,0	84

22BA26T2



Ripping dry wood. Small kerf. Maximum cutting depth 70 mm.

D	B	b	z
500	3,5	2,5	60
560	3,5	2,5	64
610	3,5	2,5	72
650	4,0	2,8	78
700	4,0	2,8	84

SAWMILL-
DOUBLE ARBOR MACHINES

Swedex manufactures a wide range of saw blades for different types of double arbor machines, e.g.

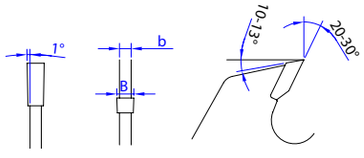
LINCK, EWD, SAB, HEINOLA, SÖDERHAMN, ARI/VISLANDA etc.

In the table below you´ll find a sample of saw blades we produce. All the saw blades are adjusted to suit the specific sawmachine and/or the customer´s requirements.

Can be made with the surface finishing "oxide coating".

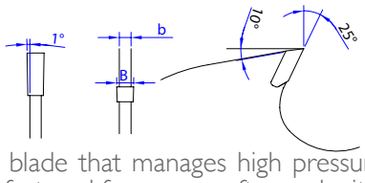
Contact us for further information and offer.

SP



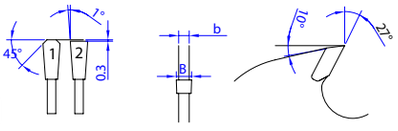
	D	B	b	c	z
Söderhamn	435	4,0	2,8	spl	24+2+2
Linck	440	4,2	2,8	150	30+2+2
Linck	460	4,6	3,0	120	24+2+2
Linck	470	3,8	2,4	150	42+2+2
Linck	480	4,4	3,2	150	30+2+2
Linck	480	4,7	3,5	150	22+2+2+2
Söderhamn	485	4,4	3,2	spl	28+2+2
Linck	500	4,4	2,8	140	36+2+2
Linck	520	4,6	3,0	150	24+2+2
Linck	540	4,6	3,2	150	24+2+2+2
Linck	540	4,6	3,2	150	30+2+2
Heinola	556	3,6	2,4	260	36+3
Heinola	556	4,2	2,8	160	32+2+2
Heinola	556	5,3	3,9	130	36+3+3
EWD	560	5,0	3,8	160	24+3+3
Linck	560	4,4	3,0	150	36+2+2+2
EWD	560	4,6	3,2	160	42+3+3
Linck	580	5,9	4,3	150	28+2+2+2
SAB	590	5,9	4,3	150	28+2+2+2

25AA79R



A stable saw blade that manages high pressure. The blade is manufactured for green, soft wood with a large cutting depth. The blade has big gullets.

D	B	b	z	RS	flange	cut. depth
300	4,0	2,8	12+2+2	40+40	90	90
350	4,2	2,8	14+2+2	50+40	90	100
380	4,2	2,8	16+2+2	50+50	90	110
400	4,2	2,8	16+2+2	60+50	100	120
450	4,4	3,0	18+2+2	70+60	120	140
500	4,6	3,2	20+2+2	70+70	130	150
560	4,6	3,2	22+2+2+2	70+50+50	130	180



27EA60

Ripping green wood. Large diameter. Can be delivered with carbide metal, HW, (EA) and Stellite (BA). - excludes packaging.

D	B	b	z
800	4,4	3,0	42
900	4,4	3,0	48
1000	4,6	3,2	52
1100	5,0	3,6	56
1200	5,0	3,6	62

CONVENTIONAL

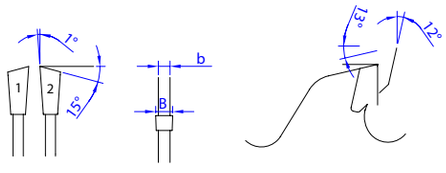
Conventional ripping saw blade with large diameter. Pre-sharpened and pre-set. - excludes packaging.

D	b	z
800	3,0	60
900	3,0	60
1000	3,2	60/70
1100	3,6	60/70
1200	3,6	60/70

SAWMILL-EDGING BLADES

22AA27R

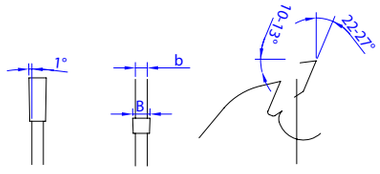
CATECH



Surface finishing "oxide coated" (to reduce friction and coating on the saw blade).

D	B	b	c	z	
500	5	3,5	spl 2/ Can drive	60	**12BA26**

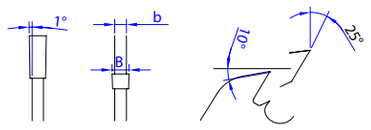
SÖDERHAMN



Surface finishing "oxide coated" (to reduce friction and coating on the saw blade).
Also avaliable as Stellite tipped.

D	B	b	c	z	PH	
400*	5,2	3,8	146	40+4	6/13/172	**27AA31R**
400	5,0	3,6	140	46+4	6/13/172	**22AA27R**
400	5,0	3,6	72	40+4	4/14/140	**27AA31R**

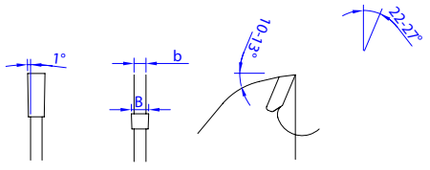
AHLSTRÖM



Surface finishing "oxide coated" (to reduce friction and coating on the saw blade).

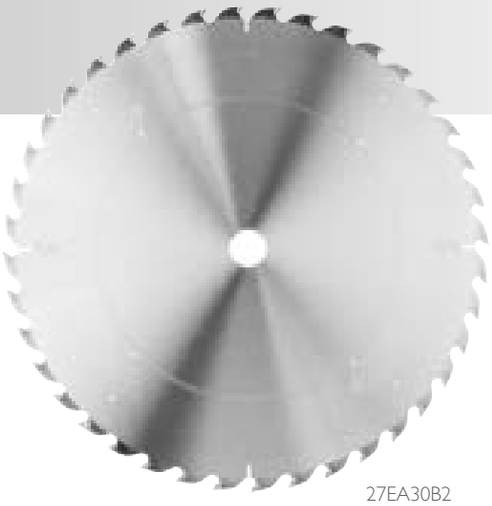
D	B	b	c	z	PH	
350	5,0	3,6	150	36	2/12/170	**25AA30**
350	5,0	3,6	150	56	2/12/170	**24AA19**

27AA39RK



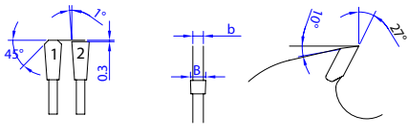
Edging saw blade with 2 or 4 wiper slots, suitable for green, soft wood with high feed. State information about centre-bore and pin-hole when ordering. Can also be delivered with trapezoidal teeth (EA) or alternating teeth (BA). HW or Stellite.

D	B	b	z
300	4,4	3,0	24+2
300	4,4	3,0	24+4
350	5,2	3,8	28+2
350	5,2	3,8	28+4
400	5,2	3,8	32+2
400	5,2	3,8	32+4
450	5,2	3,8	36+2
450	5,2	3,8	36+4
500	5,2	3,8	40+2
500	5,2	3,8	40+4



27EA30B2

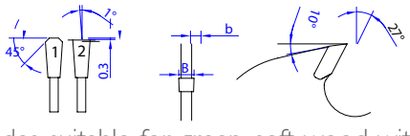
ARI



Surface finishing "oxide coated" (to reduce friction and coating on the saw blade).

D	B	b	c	z	PH	
450	5,0	3,6	80	44	I/16/112	**27EA30**
450	5,2	3,8	80	36+4	I/16/112	**27EA39R**

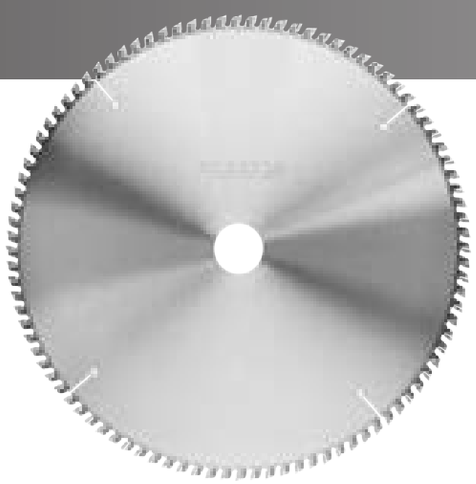
27EA30B2

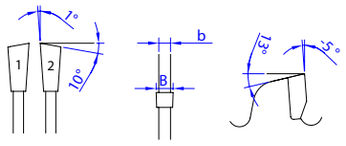


Edging saw blades suitable for green, soft wood with high feed. State information about centre-bore and pin-hole when ordering. Can also be delivered with straight teeth (AA) or alternating teeth (BA).

D	B	b	z
300	4,0	2,6	30
350	4,4	3,0	36
400	4,4	3,0	40
450	5,0	3,6	44
500	5,0	3,6	50
550	5,0	3,6	56
600	5,0	3,6	60

SAWMILL-
TRIM AND CROSS-CUT SAW BLADES

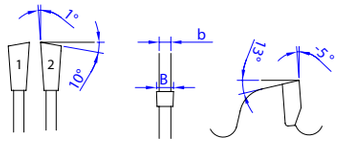




N5BA13D

Trimming saw blade for machines using down cut feed.
D=copper rivets.

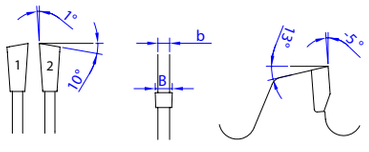
	D	B	b	z	cut- depth
Highline	400	3,5	2,5	96	16-50 mm
Highline	450	4,0	2,8	108	16-50 mm
Highline	500	4,0	2,8	120	16-50 mm



N5BA16D

Trimming saw blade for machines using down cut feed.
D=copper rivets.

	D	B	b	z	cut depth
Highline	400	3,5	2,5	80	16-100 mm
Highline	450	4,0	2,8	90	16-100 mm
Highline	500	4,0	2,8	100	16-100 mm

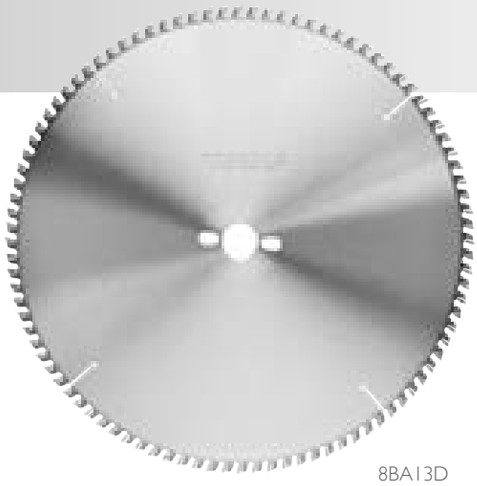


N5BA19D

Trimming saw blade for machines using down cut feed.
D=copper rivets.

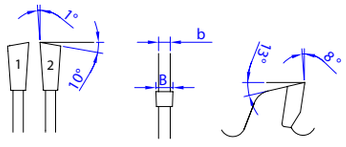
	D	B	b	z	cut. depth
Highline	400	3,5	2,5	64	16-150 mm
	450	4,0	2,8	72	16-150 mm
	500	4,0	2,8	80	16-150 mm

PH Combi/ see catalogue page 19.
Standard on this side´s products at diameter 400 mm when bore is 30 mm.



8BA13D

8BA13D

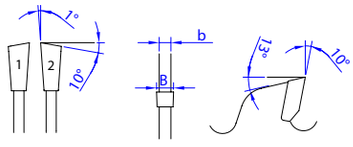


Trimming saw blade for machines using up cut feed.
D=copper rivets.

	D	B	b	z	cut. depth
Highline	400	3,5	2,5	96	16-50 mm
Highline	450	4,0	2,8	108	16-50 mm
Highline	500	4,0	2,8	120	16-50 mm

PH Combi/ see catalogue page 19.
Standard on this side´s products at diameter 400 mm when bore is 30 mm.

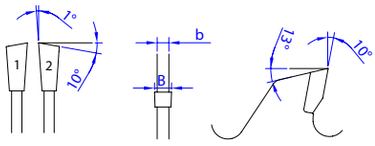
10BA16D



Trimming saw blade for machines using up cut feed.
D=copper rivets.

	D	B	b	z	cut. depth
Highline	400	3,5	2,5	80	16-100 mm
Highline	450	4,0	2,8	90	16-100 mm
Highline	500	4,0	2,8	100	16-100 mm

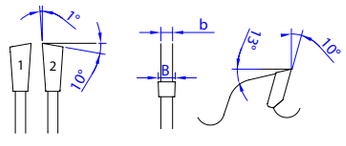
10BA19D



Trimming saw blade for machines using up cut feed.
D=copper rivets.

	D	B	b	z	cut. depth
Highline	450	4,0	2,8	72	16-150 mm
Highline	500	4,0	2,8	80	16-150 mm
Highline	560	4,4	3,0	90	16-150 mm
Highline	610	4,4	3,0	96	16-150 mm
	650	4,4	3,0	108	16-150 mm
	700	4,4	3,0	116	16-150 mm

10BA30



Cross-cutting saw blade for medium thick and thick dimensions.

	D	B	b	z
Highline	400	3,5	2,5	40
Highline	450	4,0	2,8	44
	500	4,0	2,8	50
	550	4,4	3,0	56

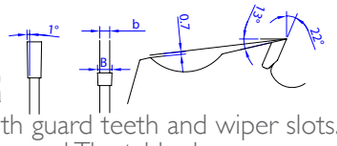
RIP SAW BLADES WITH WIPER SLOTS

22AA46SR

Swedex wiper slot blade is a multi-rip saw blade for demanding work. The wiper slots reduce the risk of getting stuck and the risk of the saw-body getting burned. The guard-tooth throws out loose cuttings and keeps the cutting groove clean. The blades can be used for sawing both green and dry wood. Adjustments of the tooth pitch can be made. Furthermore we produce saw blades with 3 wiper slots, blades with the wiper slots placed further in, blades with extra small kerf etc.
The wiper slot length depends on centre bore size and flange diameter. Please see chart to the right.

D	c-bore	RS length
160		25
180		25
200		25
225	≤70	35
225	>70	25
250	≤70	50
250	>70	35
280		50
300	≤70	60
300	>70	50
315	≤80	70
315	>80	60
350	≤100	70
350	>100	60
400		70

22AA46SR



Saw blades with guard teeth and wiper slots. For soft and hard solid wood. The table shows our recommended maximum cutting depth.

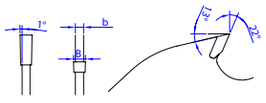
D	B	b	z	RS	cut. depth	max. flange
180	2,0	1,4	12+2	25	30	90
180	2,4	1,6	12+2	25	30	90
180	2,8	1,9	12+2	25	30	90
200	2,0	1,4	14+2	25	30	110
200	2,4	1,6	14+2	25	30	110
200	2,8	1,9	14+2	25	35	110
225	2,4	1,6	16+2	25	30	120
225	2,4	1,6	16+2	35	40	110
250	2,4	1,6	16+2	35	40	140
250	2,4	1,6	16+2	50	55	110
280	2,4	1,6	18+2	50	55	135
300	2,4	1,6	20+2	50	55	150
300	2,4	1,6	20+2	60	65	135
315	2,4	1,6	20+2	60	65	150
315	2,4	1,6	20+2	70	75	130
350	2,8	1,9	24+2	60	70	185
350	2,8	1,9	24+2	70	80	165
400	2,8	1,9	28+2	70	80	210

RIP SAW BLADES WITH WIPER SLOTS

2AA46R

D	c-bore	RS length
160		25
180		25
200		25
225	≤70	35
225	>70	25
250	≤70	50
250	>70	35
280		50
300	≤70	60
300	>70	50
315	≤80	70
315	>80	60
350	≤100	70
350	>100	60
400		70

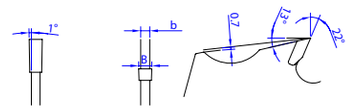
22AA46R



Saw blades with round back and wiper slots. For soft and hard solid wood. The table shows our recommended maximum cutting dept.

D	B	b	z	RS	cut. depth	max. flange
225	2,8	1,9	16+2	25	35	120
225	2,8	1,9	16+2	35	45	110
225	3,2	2,2	16+2	25	35	120
225	3,2	2,2	16+2	35	45	110
250	2,8	1,9	16+2	35	45	140
250	2,8	1,9	16+2	50	60	110
250	3,2	2,2	16+2	35	45	140
250	3,2	2,2	16+2	50	60	110
280	2,8	1,9	18+2	50	60	130
280	3,2	2,2	18+2	50	60	130
300	2,8	1,9	20+2	50	60	150
300	2,8	1,9	20+2	60	70	135
300	3,2	2,2	20+2	50	60	150
300	3,2	2,2	20+2	60	70	135
315	2,8	1,9	20+2	60	70	145
315	2,8	1,9	20+2	70	80	125
315	3,2	2,2	20+2	60	70	145
315	3,2	2,2	20+2	70	80	125
350	3,2	2,2	24+2	60	75	180
350	3,2	2,2	24+2	70	85	160
350	3,5	2,5	24+2	60	75	180
350	3,5	2,5	24+2	70	85	160
400	3,2	2,2	28+2	70	85	210
400	3,5	2,5	28+2	70	85	210

22AA39SR



Saw blades with guard teeth and wiper slots. For soft and hard solid wood. The table shows our recommended maximum cutting depth.

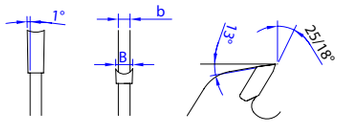
D	B	b	z	RS	cut depth	max.flange
200	2,0	1,4	16+2	25	30	110
200	2,5	1,8	16+2	25	30	110
225	2,0	1,4	18+2	25	30	130
225	2,5	1,8	18+2	35	40	110
250	2,5	1,8	20+2	35	45	140
250	2,8	2,0	20+2	50	60	110
280	2,8	2,0	22+2	50	60	130
300	2,8	2,0	24+2	60	70	135
300	2,8	2,0	24+2	70	80	115

SAW BLADES FOR MOULDERS

25AA25BO

Swedex has a wide assortment of saw blades for moulders along with a continuous development of new models within the area. Some of the blades are designed for a high feed speed and a long life time., while others are constructed for usage when the requirements of a smooth cutting surface is high. One example is the saw blade "SWEDEX EXTREME", which has reached an impressive life time of 200 000 running meters. Don´t hesitate to contact our specialists in order to optimize your own saw-application and to get the saw blade that suits your needs.

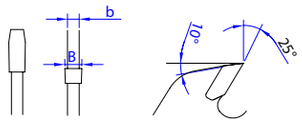
SWEDEX EXTREME



A saw blade with a special surface finishing for reduced friction. Hollow ground front. Maximum cutting depth 50 mm.

D	B	b	c	z
225	3,3	2,2	60	24
225	3,3	2,3	60	33
250	3,3	2,2	60	24
250	3,4	2,4	60	36

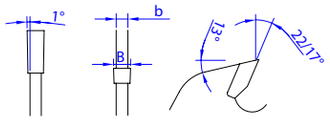
25AA25BO



The teeth have convex ground sides, which results in a very smooth cutting-surface. Surface finishing "oxide coated". Maximum cutting depth 50 mm.

D	B	b	c	z
225	3,4	2,4	60	28
250	3,4	2,4	60	36

22/17AA15

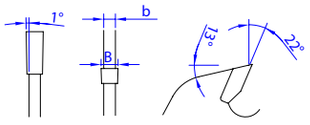


The teeth have a special front grinding (bevelled) for a better cutting result. Surface finishing "oxide coated". Maximum cutting depth 30 mm.

D	B	b	c	z
225	3,5	2,4	60	48
250	3,5	2,4	60	54

22AA39

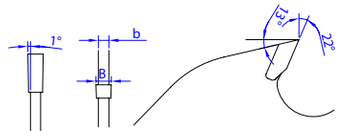
SAW BLADES FOR MOULDERS



22AA19

Ripping in moulders with normal surface requirements. Maximum cutting depth 30 mm.

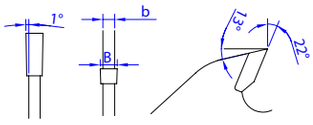
D	B	b	c	z
225	3,2	2,2	60	36
250	3,2	2,2	60	40



22AA39

Ripping in moulders with lower feed speed.

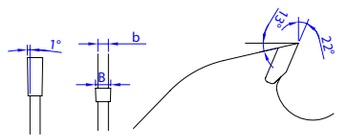
D	B	b	c	z
225	3,2	2,2	60	18
250	3,2	2,2	60	20



22AA26

Ripping in moulders with normal surface requirements. Maximum cutting depth 50 mm.

D	B	b	c	z
225	3,2	2,2	60	28
250	3,2	2,2	60	30



22AA39B2

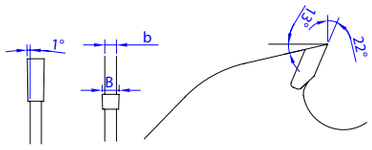
Ripping in moulders with lower feed speed.

D	B	b	c	z
180	3,2	2,2	14	

RIPPING BLADES

22AA39

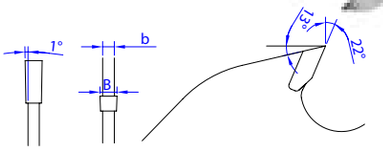
PH Combi/ see catalogue page 19.
Standard on this side´s products at diameter 250-400 mm when bore is 30 mm.



22AA39

Ripping saw blade for solid wood. Rough ripping. Maximum cutting depth 150 mm.
Can also be delivered with trapezoidal teeth (EA).

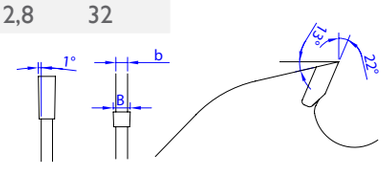
D	B	b	z
150/160	2,8	1,9	12
180	2,8	1,9	14
200	2,8	1,9	16
225	3,2	2,2	18
250	3,2	2,2	20
280	3,2	2,2	22
300	3,2	2,2	24
315	3,2	2,2	24
350	3,5	2,5	28
400	3,5	2,5	32
450	4,0	2,8	36



22AA39B2

The same as 22AA39 bur more stable. Can also be used as an outer blade. Maximum cutting depth 150 mm.
Can be delivered with trapezoidal teeth (EA).

D	B	b	z
180	3,2	2,2	14
200	3,2	2,2	16
225	3,5	2,5	18
250	3,5	2,5	20
280	3,5	2,5	22
300	3,5	2,5	24
350	4,0	2,8	28
400	4,0	2,8	32



22AA39T2

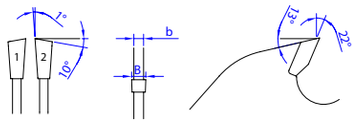
Thin kerf. The same as 22AA39 but with smaller kerf. Maximum cutting depth 120 mm. Can also be delivered with trapezoidal teeth (EA).

D	B	b	z
160	2,4	1,6	12
180	2,4	1,6	14
200	2,4	1,6	16
225	2,8	1,9	18
250	2,8	1,9	20
280	2,8	1,9	22
300	2,8	1,9	24
350	3,2	2,2	28
400	3,2	2,2	32
450	3,5	2,5	36

22BA26

For ripping of hard and soft wood. Alternately beveled teeth are recommended for hard wood. Can also be used for multi-rip sawing. Additionally we produce blades with a guard-tooth. For larger diameters see ripping blades for sawmills.

22BA30

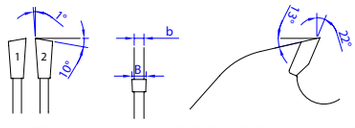


Ripping saw blade for hard and soft wood. Also suitable for multi-rip sawing of dry, planed wood. Maximum cutting depth 120 mm.

D	B	b	z
160	2,8	1,9	16
180	2,8	1,9	18
200	2,8	1,9	20
225	3,2	2,2	22
250	3,2	2,2	24
280	3,2	2,2	28
300	3,2	2,2	30
350	3,5	2,5	36
400	3,5	2,5	40
450	4,0	2,8	44

PH Combi/ see catalogue page 15.
Standard on this side´s products at diameter 250-400 mm when bore is 30 mm.

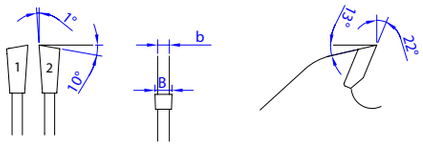
22BA30T3



Ripping saw blade. The same as 22BA30 but with extra small kerf.
Maximum cutting depth 60 mm.

D	B	b	z
160	2,0	1,3	16
180	2,0	1,3	18
200	2,0	1,3	20
225	2,4	1,6	22
250	2,4	1,6	24
280	2,4	1,6	28
300	2,4	1,6	30
350	2,8	1,9	36
400	2,8	1,9	40

22BA26



Ripping saw blade with closer tooth pitch. Suitable for both hard and soft wood. Maximum cutting depth 100 mm.

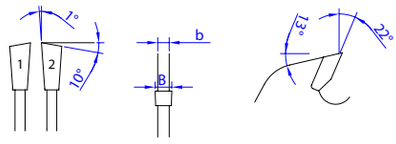
D	B	b	z
160	2,8	1,9	18
180	2,8	1,9	20
200	2,8	1,9	24
216	2,8	1,9	24
225	3,2	2,2	28
250	3,2	2,2	30
300	3,2	2,2	36
350	3,5	2,5	42
400	3,5	2,5	48
450	4,0	2,8	56

UNIVERSAL BLADES

22BA19

PH Combi/ see catalogue page 19.
Standard on this side´s products at diameter 250-400 mm when bore is 30 mm.

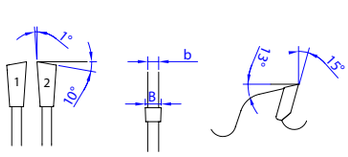
22BA19



Universal blade. Normal kerf. For ripping of hard and soft wood. Maximum cutting depth 70 mm.

	D	B	b	z
	150/160	2,8	1,9	24
	180	2,8	1,9	28
	200	2,8	1,9	32
	225	3,2	2,2	36
	250	3,2	2,2	40
	280	3,2	2,2	44
Highlin	300	3,2	2,2	48
	315	3,2	2,2	48
Highlin	350	3,5	2,5	56
Highlin	400	3,5	2,5	64
	450	4,0	2,8	72
	500	4,0	2,8	80
	550	4,4	3,0	90
	600	4,4	3,0	96

15BA16T2



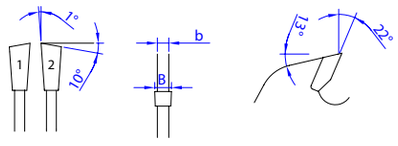
Universal saw blade. For ripping as well as cross-cutting of hard and soft wood and thin boards. Maximum cutting depth 50 mm.

D	B	b	z
180	2,4	1,6	36
200	2,4	1,6	40
250	2,8	1,9	50
300	2,8	1,9	60
350	3,2	2,2	70
400	3,2	2,2	80

UNIVERSAL BLADES

22BA19T3

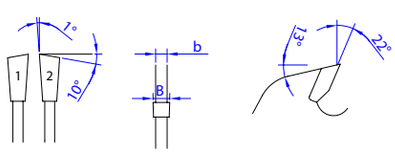
PH Combi/ see catalogue page 19.
Standard on the article R,RM and RT at diameter 250-400 mm when bore is 30 mm.



22BA19T3

Universal saw blade. Extra small kerf. Very low cutting resistance. is used for edge trimming in thin dimensions. Maximum cutting depth 30 mm.

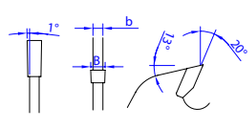
D	B	b	z
125	2,0	1,3	20
150/160	2,0	1,3	24
180	2,0	1,3	28
200	2,0	1,3	32
225	2,4	1,6	36
250	2,4	1,6	40
300	2,4	1,6	48
315	2,4	1,6	48
350	2,8	1,9	56
400	2,8	1,9	64



22BA19T2

Universal blade. Small kerf. For ripping of hard and soft wood. Maximum cutting depth 50 mm.

	D	B	b	z
	150/160	2,4	1,6	24
	180	2,4	1,6	28
	200	2,4	1,6	32
	225	2,8	1,9	36
	250	2,8	1,9	40
	280	2,8	1,9	44
Highline	300	2,8	1,9	48
	315	2,8	1,9	48
Highline	350	3,2	2,2	56
Highline	400	3,2	2,2	64
	450	3,5	2,5	72
	500	3,5	2,5	80
	550	3,5	2,5	90
	600	3,5	2,5	96



20AA19T4

Universal saw blade. Extremely small kerf. Double sided hub.
Note! Limited cutting depth. PH not standard.

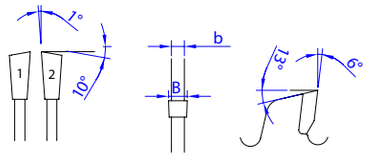
D	B	b	max cut. depth	z
160	1,5	0,9/1,9	22	24
180	1,5	0,9/1,9	26	28
200	1,5	0,9/1,9	30	32
250	1,5	0,9/2,2	37	40
300	1,5	0,9/2,5	44	48
350	1,8	1,2/2,5	52	56
400	1,8	1,2/2,5	60	64

6EA10

Blades for cross-cutting of wood and for trimming and panel sizing of chipboards, coated and non-coated boards.

PH Combi/ see catalogue page 19.
Standard on this side´s products at diameter 250-400 mm when bore is 30 mm.

6BA10

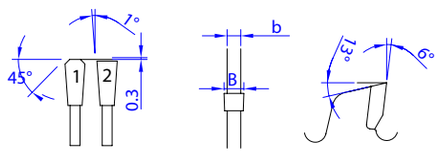


Extra close-toothed trimming saw blade for laminated materials and plastics. For use when a good surface finish is required, including wood. Equipped with Swedex Long-life teeth for maximum wear resistance and extra long lifetime. For abrasive materials we recommend trapezoidal teeth (EA). Maximum cutting depth 50 mm.

** Can be manufactured with 8 degree negative rake angle.*

	D	B	b	z
	150/160	2,8	1,9	48
	180	2,8	1,9	56
	200	2,8	1,9	64
	216*	2,8	1,9	64
	220	3,2	2,2	72
	225	3,2	2,2	72
	250*	3,2	2,2	80
Highline	300	3,2	2,2	96
	330	3,5	2,5	104
Highline	350	3,5	2,5	112
Highline	400	3,5	2,5	120
	450	4,0	2,8	144
	500	4,0	2,8	160
	550	4,4	3,0	168
	600	4,4	3,0	176

6EA10

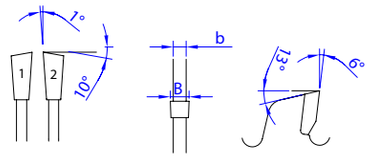


Extra close-toothed trimming saw blade for abrasive materials. For laminates and plastics. For use when a good surface finish is required. Equipped with Swedex Long-life teeth for maximum wear resistance and extra long lifetime. Maximum cutting depth 50 mm.

D	B	b	z
250	3,2	2,2	80
300	3,2	2,2	96
350	3,5	2,5	112
400	3,5	2,5	120
450	4,0	2,8	144
500	4,0	2,8	160

6EA10

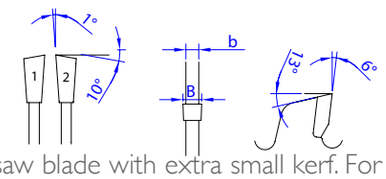
PH Combi/ see catalogue page 19. Standard on this side´s products at diameter 250-400 mm when bore is 30 mm.



6BA10T2

Extra-close toothed trimming saw blade with small kerf. For laminates and plastics. For use when a good surface finish is required. Equipped with Swedex Long-life teeth for maximum wear resistance and extra long lifetime. Maximum cutting depth 30 mm.

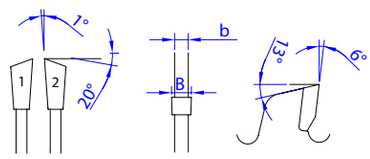
	D	B	b	z
	150/160	2,4	1,6	48
	180	2,4	1,6	56
	200	2,4	1,6	64
	250	2,8	1,9	80
Highline	300	2,8	1,9	96
Highline	350	3,2	2,2	112
Highline	400	3,2	2,2	120



6BA10T3

Cross-cutting saw blade with extra small kerf. For thin plastic profiles, plexiglass etc. Maximum cutting depth 20 mm.

	D	B	b	z
	126	2	1,3	40
	150/160	2,0	1,3	48
	180	2,0	1,3	56
	200	2,0	1,3	64
	250	2,4	1,6	80
Highline	300	2,4	1,6	96
Highline	350	2,8	1,9	112
Highline	400	2,8	1,9	120

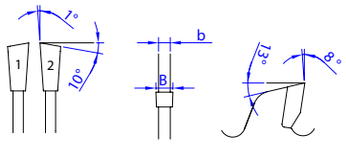


DIMTER FAST CUT/ 6BA11

Close-toothed saw blade for "Opti cut" saws. Extra stable saw-body. Differentiated tooth pitch along with copper rivets in the slots.

D	B	b	c-bore	z
450	4,8	3,5	30	128
500	4,8	3,5	30	144
600	4,8	3,5	30	170

8BA13



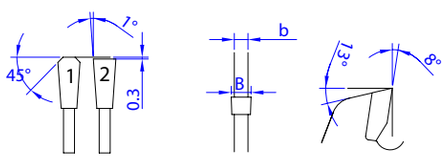
8BA13

Close-toothed trimming saw blade for veneered and laminated materials. For use when a good surface finish is required, including wood. Maximum cutting depth 75 mm. Can be delivered with Long-life carbide teeth.

*Can be manufactured with 8 degree negative rake angle.
* Can be manufactured with 5 degree negative rake angle.

	D	B	b	z
	125	2,8	1,9	30
	150/160	2,8	1,9	36
	180	2,8	1,9	42
	200	2,8	1,9	48
	216*	2,8	1,9	48
	220	3,2	2,2	56
	225	3,2	2,2	56
	250**	3,2	2,2	60
Highline	300	3,2	2,2	72
	330	3,5	2,5	80
Highline	350	3,5	2,5	84
	370	3,5	2,5	90
Highline	400	3,5	2,5	96
	450	4,0	2,8	108
	500	4,0	2,8	120
	550	4,4	3,0	132
	600	4,4	3,0	144

See page. 20-21 (neg. rake angle, large diameter.)

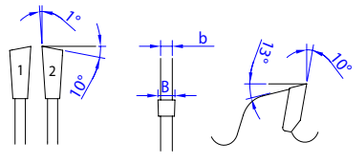


8EA13

The same as 8BA13 but for abrasive materials. Trapezoidal teeth (EA). Equipped with Swedex Long-life teeth.

D	B	b	z
250	3,2	2,2	60
300	3,2	2,2	72
315	3,2	2,2	80
350	3,5	2,5	84
400	3,5	2,5	96
450	4,0	2,8	108
500	4,0	2,8	120

10BA16



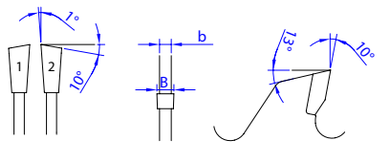
Trimming and panel sizing saw blade. Standard blade for the carpentry and furniture industry. Is used for the non-coated and one-side-coated boards. Maximum cutting depth 100 mm. Can be delivered with long-life carbide teeth.

* Can be manufactured with 5 degree negative rake angle.

D	B	b	z
150/160	2,8	1,9	30
180	2,8	1,9	36
200	2,8	1,9	40
250	3,2	2,2	50
300	3,2	2,2	60
315	3,2	2,2	60
350	3,5	2,5	70
400*	3,5	2,5	80
450*	4,0	2,8	90
500*	4,0	2,8	100
550	4,4	3,0	108
600	4,4	3,0	120

See page. 20-21 (neg. rake angle, large diameter.)

10BA19E**

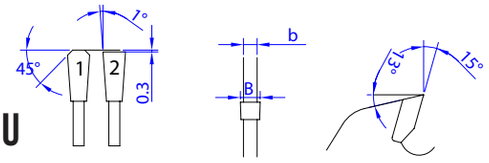


Trimming and panel sizing saw blade for fibreboards, plasterboards, chipboards etc. Maximum cutting depth 125 mm.
*Can be manufactured with 5 degree negative rake angle.
*As from diameter 300 mm with laser dampened saw body.

D	B	b	z
180	2,8	1,9	28
200	2,8	1,9	32
225	3,2	2,2	36
250	3,2	2,2	40
300*	3,2	2,2	48
330	3,5	2,5	52
350*	3,5	2,5	56
380	3,5	2,5	60
400*	3,5	2,5	64

PANEL SIZING BLADES
HORIZONTAL SAWS

For horizontal panel sizing saws with scribing unit. Used for panel sizing and trimming of laminated and non-laminated boards.



15EAXXU

Panel sizing saw blade for horizontal saws with scribing unit. The blade has laser dampened saw-body and is equipped with Long-life carbide teeth. This results in a longer time between resharpenings.

D	B	b	z
300	4,0	2,8	48
300	4,4	3,2	48
350	4,0	2,8	56
350	4,4	3,2	56
355	4,4	3,2	56
380	4,4	3,2	48
380	4,4	3,2	60
400	4,4	3,2	48
400	4,0	2,8	64
400	4,4	3,2	60
410	4,4	3,2	72
420	4,6	3,2	48
420	4,4	3,2	52
420	4,4	3,2	60
420	4,6	3,2	72
420	4,8	3,5	72
430	4,4	3,2	60
430	4,4	3,2	72
450	4,4	3,2	56
450	4,4	3,2	60
450	4,4	3,2	72
450	4,8	3,5	72
460	4,4	3,2	72
480	4,8	3,5	72
500	4,4	3,2	48
500	4,4	3,2	60
500	4,4	3,2	72
500	4,8	3,5	48
500	4,8	3,5	60
500	4,8	3,5	72
510	4,8	3,5	72
520	4,8	3,5	60
520	4,8	3,5	84
530	5,8	4,0	60
530	5,2	3,5	60
540	4,8	3,5	84
550	5,2	3,5	48
550	5,5	3,8	48
550	5,5	3,8	60
565	5,2	3,5	48
565	5,2	3,5	60
565	5,0	3,5	72
565	5,2	3,5	48
570	4,8	3,5	60
580	5,5	4,0	60
600	5,5	3,8	54
600	5,8	4,0	60
600	5,8	4,0	72
620	6,2	4,2	60
670	5,8	4,2	42
670	5,8	4,2	60
670	6,2	4,2	72
670	6,5	4,9	60
680	6,2	4,2	60
700	7,0	5,0	60
720	6,4	4,4	60
730	6,2	4,2	60

What can I do to obtain better cutting surface finish?
-Choose a sawblade with more teeth.
-Use a higher peripheral speed.
-Select a saw blade with different tooth shape.
-Check flanges and distances.
-Condition of the spindle bearings.

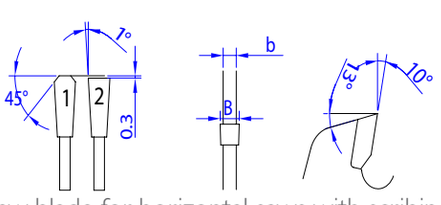
The blade is very noisy, especially when idling, why?
-The blade goes to oscillation (self-vibration)
-Change number of teeth and diameter.
-Adjust the speed of revolution if possible.
-You can also choose a sound absorbing sawblade, a coating of sound absorbing material on the inside of the safety cover.

How to avoid chip outs on the bottom side of the material?
-Use a saw blade with more teeth.
-The saw blade is positioned too high above the material.
-Some special grindings and angles may help.

Why does the saw blade wobble when warm?
-During cutting the saw blade becomes warm, especially in the periphery, which causes the blade to expand and stretch. We can add slots for improved blade properties to meet a specific customer´s needs.

How to avoid the blade chopping when cutting aluminium?
-When using manual feed, a negaive rake angle results in a softer cut.
-Positive rake angle is recommended if automatic feed is used. A blade with more teeth results in a softer cutting.

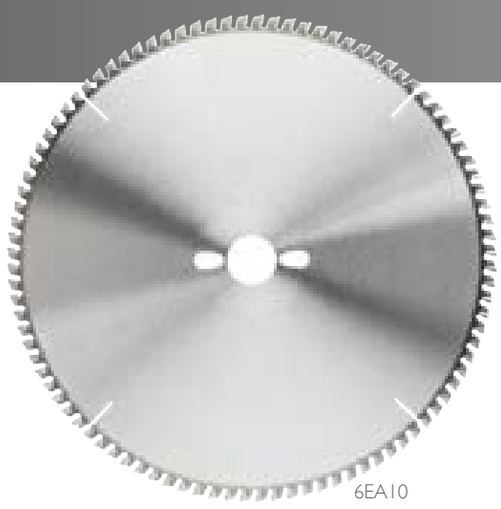
10EAXXU



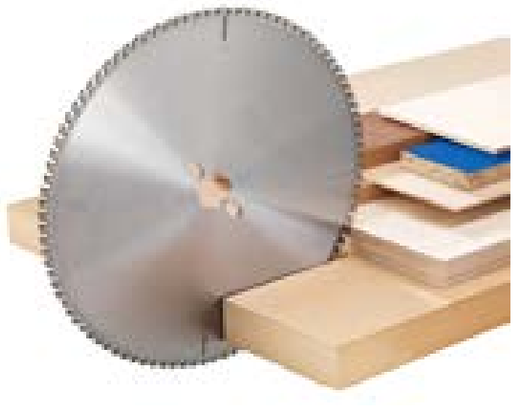
Panel sizing saw blade for horizontal saws with scribing unit. The blade has a laser dampened saw-body and is equipped with Long-life carbide teeth. This results in a longer time between resharpenings.

D	B	b	z
300	4,0	2,8	60
300	4,4	3,2	60
300	4,4	3,2	72
305	4,4	3,2	60
320	4,4	3,2	60
320	4,4	3,2	72
330	4,4	3,2	72
350	4,0	2,8	70
350	4,4	3,2	72
355	4,4	3,2	72
370	4,4	3,2	72
380	4,8	3,5	72
380	4,8	3,5	84
380	4,8	3,5	96
380	4,4	3,2	72
400	4,4	3,2	72
400	4,8	3,5	72
400	4,0	2,8	80

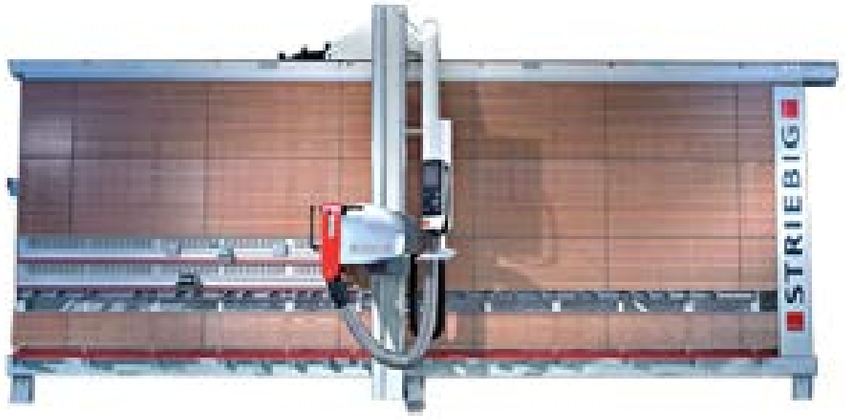
PANEL SIZING BLADES-
VERTICAL SAWS



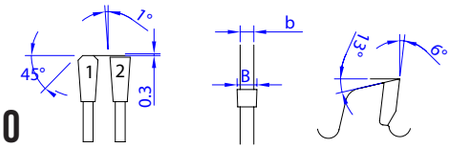
6EA10



For vertical panel sizing saws e.g. Holzher ,Striebig etc. For laminated or varnished boards.



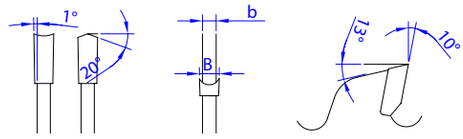
PH Combi/ see catalogue page 19. Standard on this side products at diameter 250-400 mm when bore is 30 mm.



6EA10

Panel sizing saw blade for vertical saws. Long-life teeth. Small tooth pitch. For panel sizing of coated or non-coated boards. Maximum cutting depth 25 mm.

D	B	b	c	z
220	3,2	2,2	30	72
250	3,2	2,2	30	80
300	3,2	2,2	30	96
350	3,5	2,5	30	108



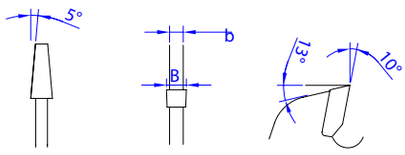
10EAXH16

Panel sizing saw blade for vertical saws. For panel sizing of laminated or varnished boards with high requirements of the cutting surface. Hollow ground front.

D	B	b	c	z
220	3,2	2,2	30	42
250	3,2	2,2	30	50
303	3,2	2,2	30	60
350	3,2	2,2	30	70
400	3,5	2,5	30	80
450	3,9	2,8	30	90
500	3,9	2,8	30	100

10RA19

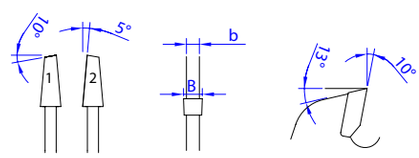
10RA19



Scoring saw blade with straight teeth with conical sides (RA). Is delivered with Long-life carbide tips.

D	B	b	z
105	3,2/4,2	2,2	20
105	3,5/4,5	2,2	20
125	3,2/4,2	2,2	20
125	3,5/4,5	2,5	20
125	3,8/4,8	2,8	20
125	4,4/5,4	3,2	20
150	4,4/5,4	3,2	24
160	3,2/4,2	2,2	24
160	3,5/4,5	2,5	24
160	3,8/4,8	2,8	24
160	4,4/5,4	3,2	24
180	4,4/5,4	3,2	28
200	4,0/5,0	3,2	32
200	4,4/5,4	3,2	32

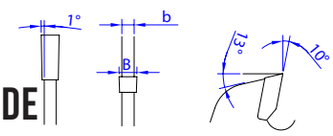
10RABA



Scoring saw blade with alternately bevelled teeth with conical sides (RABA). Can also be supplied with straight teeth (AA), Is equipped with Long-life tips as standard.

D	B	b	z
120	4,4-5,4	2,8	24
125/127	4,4-5,4	3,0	24
140	4,4-5,4	3,0	28
150	4,4-5,4	3,0	36
160	4,4-5,4	3,0	36
180	4,4-5,4	2,8	36
200	4,4-5,4	3,2	36
200	4,6-5,6	3,5	36
200	5,0-6,0	3,5	36
200	5,5-6,5	3,5	36
200	5,8-6,8	3,5	36
200	6,2-7,2	4,2	36
215	4,4-5,4	3,2	42
280	4,4-5,4	3,5	48
300	4,8-5,6	3,2	72
300	4,4-5,4	3,5	48
320	4,8-6,0	3,5	48

SPLIT SCORING BLADE



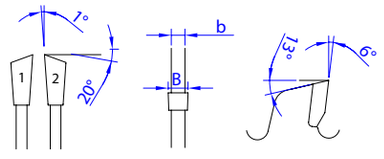
Adjustable to suit the kerf of the main saw blade. Straight teeth (AA). Shims are included.

D	B	z
100	2,8-3,6	2x12
120	2,8-3,6	2x12

SAW BLADES FOR TENONERS

SCORING BLADES

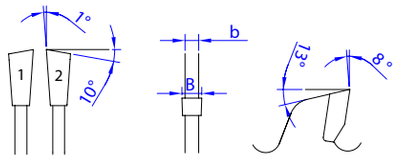
Scoring saw blade equipped with Long-life cart tips. Is used for scoring of coated and non-coa boards.



6BA10B2

Scoring saw blade for tenoners. Manufactured with Long-life carbide tips.

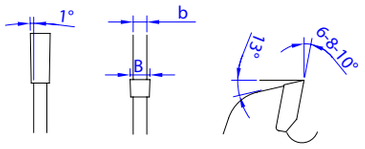
D	B	b	z
125	3,2	2,2	40
150	3,2	2,2	48
180	3,2	2,2	56
200	3,2	2,2	64



8BA13B2

Scoring saw blade for tenoners. Manufactured with Long-life carbide tips.

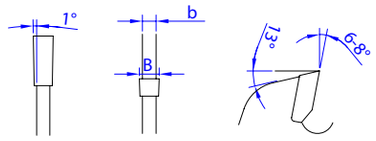
D	B	b	z
125	3,2	2,2	30
150	3,2	2,2	36
180	3,2	2,2	42
200	3,2	2,2	48



LEUCO

Scoring saw blade for Leuco S-system. Manufactured with Long-life carbide tips. Can also be delivered with right hand beveled (CA), left hand beveled (DA) or alternately beveled (BA) teeth.

D	B	b	c	z	PH	
180	3,2	2,2	50	56	3/22/80	**6AA10**
180	3,2	2,2	50	42	3/22/80	**8AA13**
180	3,2	2,2	50	36	3/22/80	**10AA16**



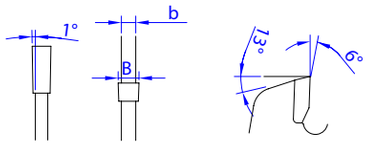
HOMAG

Scoring saw blade for Homag, Brandt, IMA. Manufactured with Long-life carbide tips. Can also be delivered with right hand bevelled (CA), left hand bevelled (DA) or alternately bevelled (BA) teeth.

	D	B	b	c	z	FH	
180	3,2	2,2	65	56	6/7/90/10,5L		**6AA10**
180	3,2	2,2	65	56	6/7/90/10,5R		**8AA13**
180	3,2	2,2	65	42	6/7/90/10,5L		**6AA10**
180	3,2	2,2	65	42	6/7/90/10,5R		**8AA13**

SAWBLADES FOR TENONERS

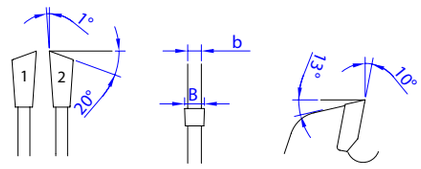
HOGGER BLADES



LEUCO

For panel saw blade of laminated or non-laminated boards. Manufactured with Long-life carbide tips. Right hand bevelled (CA) or left hand bevelled (DA) teeth.

D	B	b	c	z	FH	
200	4,0	2,8	80	´64-4	4/6,5/140-L	6AA10
200	4,0	2,8	80	´64-4	4/6,5/140-R	6AA10
220	4,0	2,8	80	´64-4	6/6154-L	6AA11
220	4,0	2,8	80	´64-4	6/6154-R	6AA11
250	4,0	2,8	80	´78-6	6/6,5/200L	6AA10
250	4,0	2,8	80	´78-6	6/6,5/200R	6AA10
250	4,0	2,8	80	´78-6	6/6,5/200L	6AA10
250	4,0	2,8	100	´78-6	6/6,5/200R	6AA10

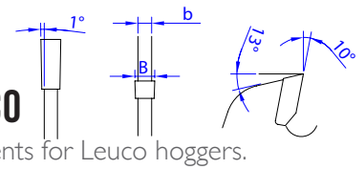


10CA/DA16

Trim saw blade for edge trimming. Manufactured with Long-life carbide tips. Right hand bevelled (CA) or left hand bevelled (DA) tetth.

D	B	b	c	z	PH
100	3,2	2,2	32	20	2/4/52
100	3,2	2,2	32	20	2/4/52

SEGMENTS

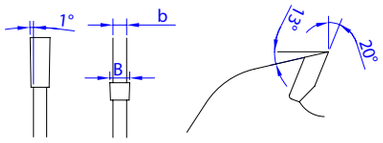


LEUCO

Segments for Leuco hoggers.

	D	B	z
Standard	6,0	2,8	4,0
High	6,0	2,8	4,0

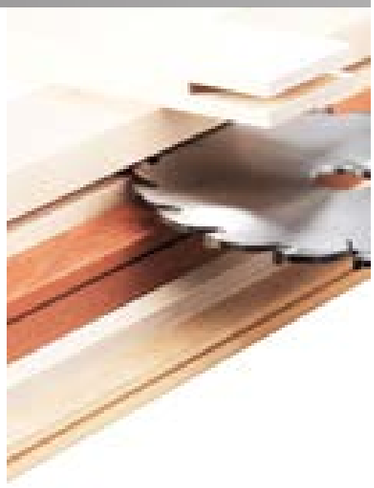
20AA26



20AA26

Groove-cutting saw blade for wood, chipboards and non-ferrous metals with moderate feeding speeds. Grindings to a smaller kerf, (between the standard dimensions listed below) is possible.

D	B	b	z
100	1,5	1,0	12
100	2,0	1,3	12
100	2,5	1,5	12
100	3,0	2,0	12
100	3,5	2,5	12
100	4,0	3,0	12
100	4,5	3,5	12
100	5,0	4,0	12
100	6,0	4,0	12
125	1,5	1,0	16
125	2,0	1,3	16
125	2,5	1,5	16
125	3,0	2,0	16
125	3,5	2,5	16
125	4,0	3,0	16
125	4,5	3,5	16
125	5,0	4,0	16
125	6,0	4,0	16
150	1,5	1,0	18
150	2,0	1,3	18
150	2,5	1,5	18
150	3,0	2,0	18
150	3,5	2,5	18
150	4,0	3,0	18
150	4,5	3,5	18
150	5,0	4,0	18
150	6,0	4,0	18

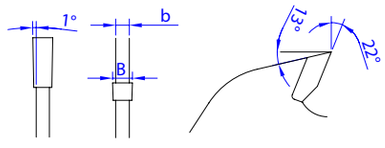


D	B	b	z
180	1,5	1,0	18
180	2,0	1,3	18
180	2,5	1,5	18
180	3,0	2,0	18
180	3,5	2,5	18
180	4,0	3,0	18
180	4,5	3,5	18
180	5,0	4,0	18
180	6,0	4,0	18
180	6,5	4,0	18
200	1,5	1,0	18
200	2,0	1,3	18
200	2,5	1,5	18
200	3,0	2,0	18
200	3,5	2,5	18
200	4,0	3,0	18
200	4,5	3,5	18
200	5,0	4,0	18
200	6,0	4,0	18
225	4,0	3,0	18
225	4,5	3,5	18
225	5,0	4,0	18
225	6,0	4,0	18
225	7,0	4,0	18
250	4,5	3,5	20
250	6,0	4,0	20
250	8,0	6,0	20
280	6,0	4,0	22
300	6,0	4,0	24
300	8,0	6,0	24
300	10,0	8,0	24

20AA26

20AA26MAN

FOR GROOVING AND SCORING IN SOFT- AND HARDWOOD, BOARDS AND FIBER MATERIAL (MDF) WITHOUT COATING.
ACCEPTED FOR MANUAL FEED BY AGAINST FEED.
RPM RECOMMENDATION:

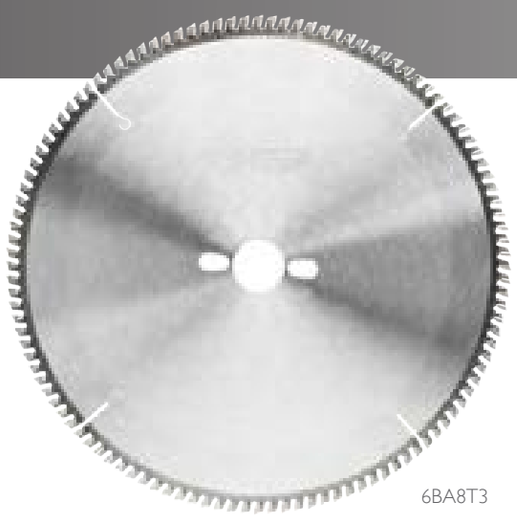


D	Min rpm	Max rpm
100	7800	13513
125	6200	10770
150	5300	9042
180	4300	7518
200	3900	6706
225	3400	6096
250	3050	5436
300	2600	4572

D	B	b	z
100	1,5	1,0	12
100	2,0	1,3	12
100	2,5	1,5	12
100	3,0	2,0	12
100	3,5	2,5	12
100	4,0	3,0	12
100	4,5	3,5	12
100	5,0	4,0	12
100	6,0	4,0	12
125	1,5	1,0	16
125	2,0	1,3	16
125	2,5	1,5	16
125	3,0	2,0	16
125	3,5	2,5	16
125	4,0	3,0	16
125	4,5	3,5	16
125	5,0	4,0	16
125	6,0	4,0	16
150	1,5	1,0	18
150	2,0	1,3	18
150	2,5	1,5	18
150	3,0	2,0	18
150	3,5	2,5	18
150	4,0	3,0	18
150	4,5	3,5	18
150	5,0	4,0	18
150	6,0	4,0	18

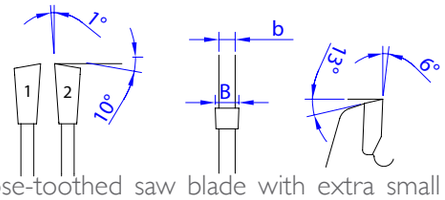
D	B	b	z
180	1,5	1,0	18
180	2,0	1,3	18
180	2,5	1,5	18
180	3,0	2,0	18
180	3,5	2,5	18
180	4,0	3,0	18
180	4,5	3,5	18
180	5,0	4,0	18
180	6,0	4,0	18
180	6,5	4,0	18
200	1,5	1,0	18
200	2,0	1,3	18
200	2,5	1,5	18
200	3,0	2,0	18
200	3,5	2,5	18
200	4,0	3,0	18
200	4,5	3,5	18
200	5,0	4,0	18
200	6,0	4,0	18
225	4,0	3,0	18
225	4,5	3,5	18
225	5,0	4,0	18
225	6,0	4,0	18
225	7,0	4,0	18
250	4,5	3,5	20
250	6,0	4,0	20
250	8,0	6,0	20
280	6,0	4,0	22
300	6,0	4,0	24
300	8,0	6,0	24
300	10,0	8,0	24

SAW BLADES FOR PLASTICS



6BA8T3

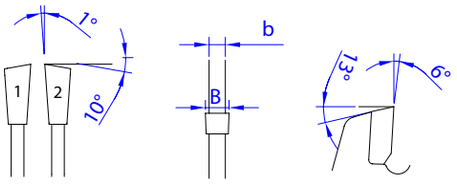
6BA6T3



Extremely close-toothed saw blade with extra small kerf. For very thin hard plastics.. Can also be delivered with alternately bevelled teeth with chamfer (BAE). PH Combi. Surface finishing "oxide coated".

D	B	b	z
160	2,0	1,3	84
180	2,0	1,3	94
200	2,0	1,3	104
225	2,4	1,6	118
250	2,4	1,6	126
300	2,4	1,6	156
350	2,8	1,9	182
400	2,8	1,9	208

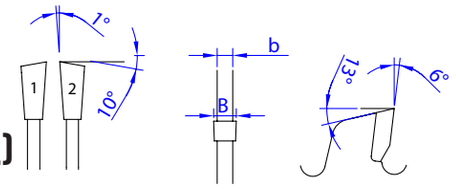
6BA8T3



Extremely close-toothed saw blade with extra small kerf. For very thin materials. Can also be delivered with alternately bevelled teeth with chamfer (BAE). PH Combi. Ist standard on diameter 250-400 mm.

D	B	b	z
150/160	2,0	1,3	60
180	2,0	1,3	72
200	2,0	1,3	80
225	2,4	1,6	90
250	2,4	1,6	100
300	2,4	1,6	116
350	2,8	1,9	144
400	2,8	1,9	160

6BA10(LL)



Extra close-toothed saw blade. For use when the requirement of a smooth cutting finish is paramount. Equipped with Swedex Long-life teeth for extra long lifetime. Can also be delivered with alternately bevelled teeth with chamfer (BAE).

	D	B	b	z
	150/160	2,8	1,9	48
	180	2,8	1,9	56
	200	2,8	1,9	64
	216	2,8	1,9	64
	220	3,2	2,2	72
	225	3,2	2,2	72
	250	3,2	2,2	80
Highline	300	3,2	2,2	90
Highline	330	3,5	2,5	104
Highline	350	3,5	2,5	112
Highline	400	3,5	2,5	120
Highline	450	4,0	2,8	144
	500	4,0	2,8	160
	550	4,4	3,0	168
	600	4,4	3,0	176

SAW BLADES FOR PLASTICS

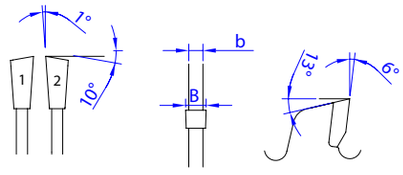
22BA30

PH Combi/ see catalogue page 19. Standard on this side´s products at diameter 250-400 mm when bore is 30 mm.

Swedex saw blades for plastics are ground with special angles to give a long lifetime along with a good cutting finish. Generally a saw blade with closer tooth pitch should be chosen when cutting thin materials.

Important! The saw blade should be placed about 10-15 mm above the material.

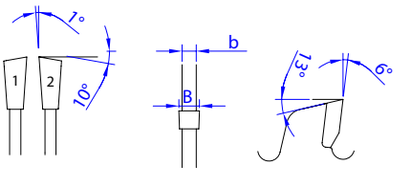
6BA10T2



Same as 6BA10 but with smaller kerf. Saves material and decreases the cutting resistance. Equipped with Swedex Long-life teeth for extra long lifetime. Can also be delivered with alternately bevelled teeth with chamfer (BAE).

	D	B	b	z
	150/160	2,4	1,6	48
	180	2,4	1,6	56
	200	2,4	1,6	64
	250	2,8	1,9	80
Highline	300	2,8	1,9	96
Highline	350	3,2	2,2	112
Highline	400	3,2	2,2	120

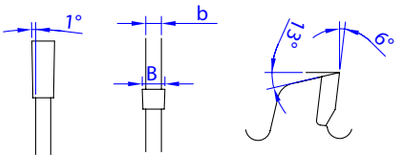
6BA10T3



Extra small kerf. Cross-cutting of thin plastic profiles, plexiglass, veneer etc. Can also be delivered with alternately bevelled teeth with chamfer (BAE).

D	B	b	z
150/160	2,0	1,3	48
180	2,0	1,3	56
200	2,0	1,3	64
250	2,4	1,6	80
300	2,4	1,6	96
350	2,8	1,9	112
400	2,8	1,9	120

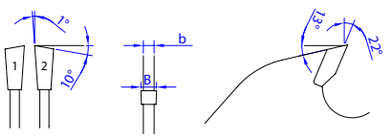
6AA10T4



Extremely small kerf. For cutting of thin plastics. Note! Limited cutting depth since the saw blade has a double sided hub.

D	B	b	såghöjd	z
160	1,5	1,0/1,9	22	48
180	1,5	1,0/1,9	26	56
200	1,5	1,0/1,9	30	64
250	1,5	1,0/2,2	37	80
300	1,5	1,0/2,2	44	96
350	1,8	1,2/2,5	52	112
400	1,8	1,2/2,5	60	120

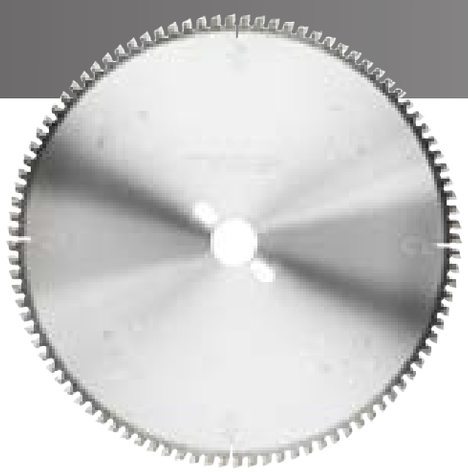
22BA30



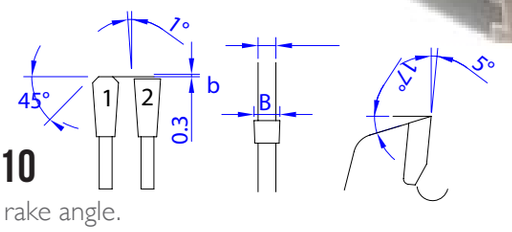
Saw blade for soft plastics like nylon, styrofoam, pvc etc.

D	B	b	z
300	3,2	2,2	30
350	3,5	2,5	36
400	3,5	2,5	40
450	4,0	2,8	44
500	4,0	2,8	50

SAW BLADES FOR NON-FERROUS METALS.

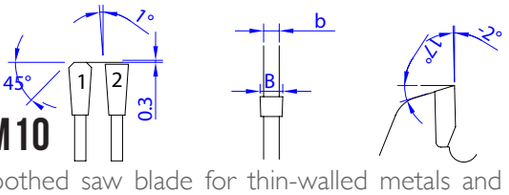


Sawblades for non-ferrous metals such as aluminium, copper and brass but also for plastic etc. The sawblades are manufactured with either positive or negative rake angle. Positive rake angle is used for automatic feed and negative rake angle for manual feed. For material thickness above 10 mm a positive rake angle might be preferable even when using manual feed.



5EAM10

Positive rake angle.

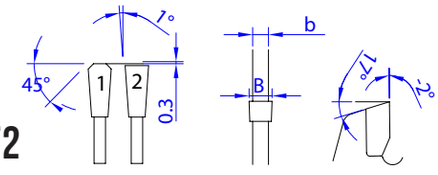


N2EAM10

Close-toothed saw blade for thin-walled metals and hard plastics. Differentiated tooth pitch. Laser dampened saw-body for decreased noise (as from D=300 and larger). Negative rake angle. Maximum material thickness 7 mm.

D	B	b	z
150/160	2,8	2,0	48
170	2,8	2,0	52
180	2,8	2,0	56
190	2,8	2,0	60
200	2,8	2,0	64
210	2,8	2,0	64
216	2,8	2,0	64
225	3,2	2,4	72
230	3,2	2,4	72
250	3,2	2,4	80
260	3,2	2,4	80
275	3,2	2,4	84
300	3,2	2,4	96
330	3,6	2,8	104
350	3,6	2,8	108
370/380	4,0	3,2	116
400	4,0	3,2	120
420	4,0	3,2	132
450	4,0	3,2	144
500	4,0	3,2	160

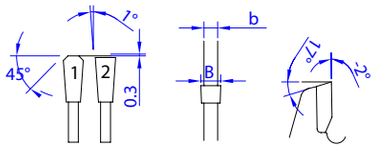
Highline



N2EAM6T2

Extremely close-toothed saw blade for thin-walled metals and hard plastics. Differentiated tooth pitch. Laser dampened saw-body for decreased noise (as from D=300 and larger). Negative rake angle. Maximum material thickness 3 mm. Surface finishing "oxide coated".

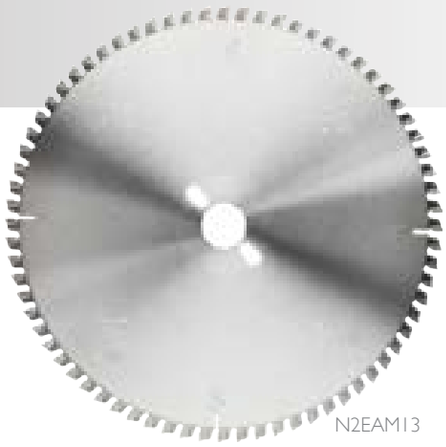
D	B	b	z
200	2,4	1,8	104
250	2,4	1,8	126
300	2,4	1,8	156



N2EAM8

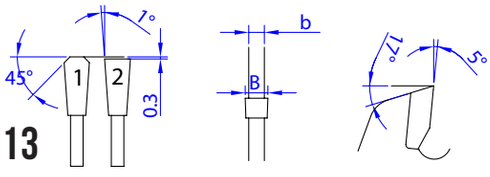
Extra close-toothed saw blade for thin-walled metals and hard plastics. Differentiated tooth pitch. Laser dampened saw-body for decreased noise (as from D=300 and larger). Negative rake angle. Maximum material thickness 5 mm.

D	B	b	z
200	2,8	2,0	80
216	2,8	2,0	80
250	2,8	2,0	100
300	2,8	2,0	120



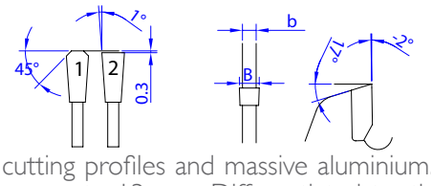
N2EAM13

PH Combi/ see catalogue page 19.
Standard on this side´s products at diameter 250-400 mm when bore is 30 mm.



5EAM13

Positive rake angle.

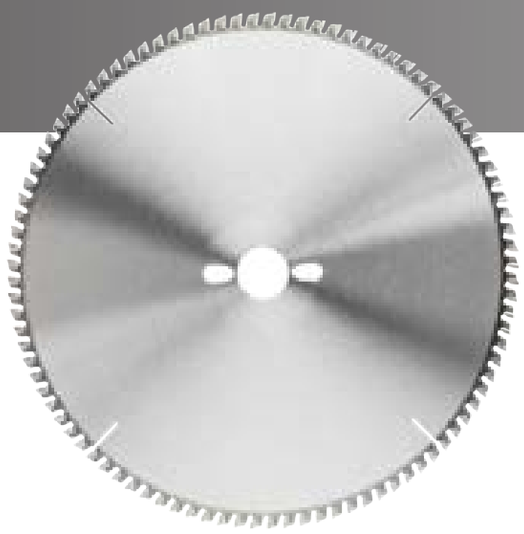


N2EAM13

Saw blade for cutting profiles and massive aluminium. Material thickness up to 13 mm. Differentiated tooth pith. Laser dampened saw-body for decreased noise (as from D=300 and larger). Negative rake angle.

	D	B	b	z
	102	2,8	2,0	24
	125	2,8	2,0	30
	150/160	2,8	2,0	36
	180	2,8	2,0	42
	200	2,8	2,0	48
	210	2,8	2,0	48
	216	2,8	2,0	48
	225	3,2	2,4	56
	250	3,2	2,4	60
	260	3,2	2,4	60
	275	3,2	2,4	64
	300	3,2	2,4	72
	330	3,6	2,8	80
Highline	350	3,6	2,8	84
	370/380	4,0	3,2	90
	400	4,0	3,2	96
	420	4,0	3,2	100
	450	4,0	3,2	108
	500	4,0	3,2	120
	550	4,4	3,4	132
	600	4,4	3,4	144
	650	4,4	3,4	160

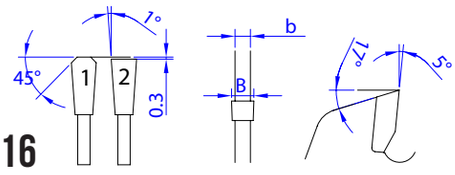
SAW BLADES FOR NON-FERROUS METALS.



5EAM10

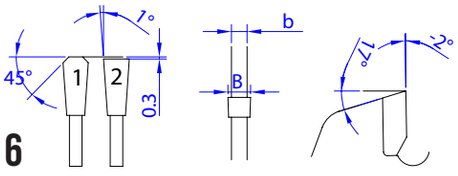
Saw blades for non-ferrous metals such as aluminium, copper and brass but also for plastic etc. The saw blades are manufactured with either positive or negative rake angle. Positive rake angle is used for automatic feed and negative rake angle for manual feed. For material thickness above 10 mm a positive rake angle might be preferable even when using manual feed.

PH Combi/ see catalogue page 19.
Standard on this side´s products at diameter 250-400 mm when bore is 30 mm.



5EAM16

Positive rake angle.

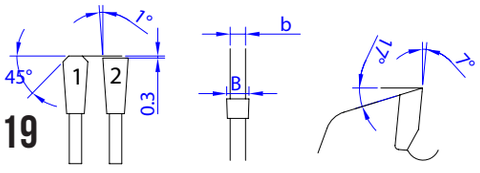


N2EAM16

Saw blade for cutting solid metals and profiles having thickness up to 20 mm. Differentiated tooth pitch. laser dampened saw-body for decreased noise (as D=300 and larger). Negative rake angle.

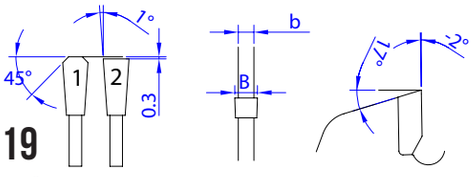
D	B	b	z
102	2,8	2,0	20
150/160	2,8	2,0	30
180	2,8	2,0	36
200	2,8	2,0	40
250	3,2	2,4	50
275	3,2	2,4	54
300	3,2	2,4	60
330	3,6	2,8	64
350	3,6	2,8	70
370/380	4,0	3,2	76
400	4,0	3,2	80
420	4,0	3,2	84
450	4,0	3,2	90
500	4,0	3,2	100
550	4,4	3,4	108
600	4,4	3,4	120

27EAM30B2



7EAM19

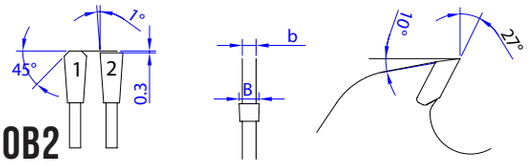
Positive rake angle.



N2EAM19

Saw blade for cutting solid metals, having material thickness of 30 mm and above. Differentiated tooth pitch. Laser dampened saw-body for decreased noise (as from D= 300 and larger). Negative rake angle.

D	B	b	z
200	2,8	2,0	32
216	2,8	2,0	32
225	3,2	2,4	36
250	3,2	2,4	40
275	3,2	2,4	44
300	3,2	2,4	48
330	3,6	2,8	54
350	3,6	2,8	56
370/380	4,0	3,2	60
400	4,0	3,2	64
420	4,0	3,2	68
450	4,0	3,2	72
500	4,0	3,2	80
550	4,4	3,4	90
600	4,4	3,4	96
650	4,4	3,4	108
700	4,4	3,4	116

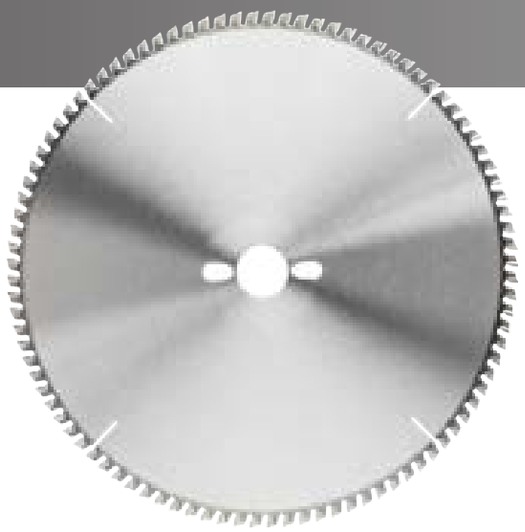


27EAM30B2

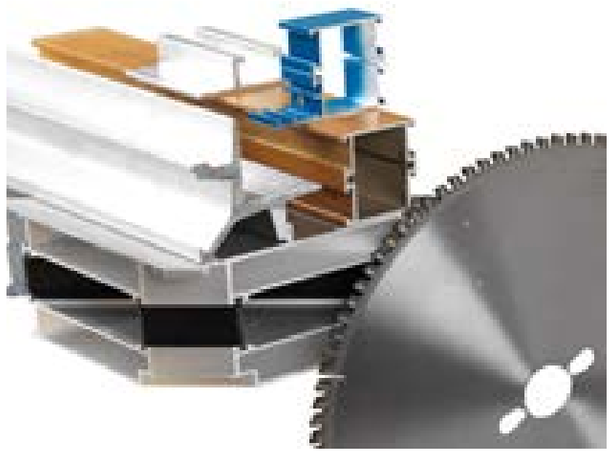
Saw blade for cutting ingots and solid metals, having material thickness of 25 mm and above. Differentiated tooth pitch. Laser dampened saw-body for decreased noise (as from D= 300 and larger). Positive rake angle.

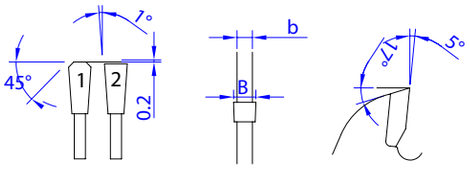
D	B	b	z
400	4,4	3,0	40
450	5,0	3,6	44
500	5,0	3,6	50
600	5,0	3,6	60
650	5,5	4,0	68
700	5,5	4,0	72

SAW BLADES
FOR NON-FERROUS METALS.



H5EAM10

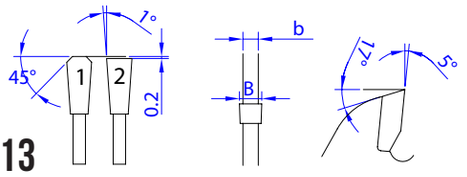




H5EAM10

Close-toothed saw blade for thin-walled metals and har plastics. Maximum material thickness 7 mm. Positive rake angle.

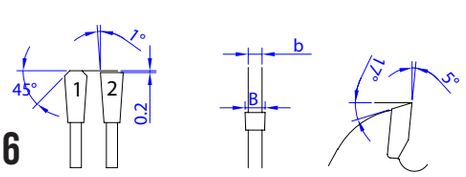
	D	B	b	z
Highline	370	4,0	3,2	114
Highline	400	4,0	3,2	120
Highline	420	4,0	3,2	132
Highline	450	4,0	3,2	144
Highline	500	4,0	3,2	160



H5EAM13

Saw blade for cutting profiles and massive aluminium. material thickness up to 13 mm. Positive rake angle.

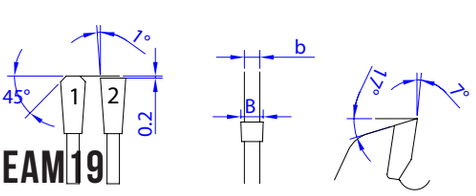
	D	B	b	z
Highline	370	4,0	3,2	76
Highline	400	4,0	3,2	80
Highline	420	4,0	3,2	84
Highline	450	4,0	3,2	90
Highline	500	4,0	3,2	100
Highline	550	4,4	3,4	108
Highline	600	4,4	3,4	120



H5EAM16

Saw blade for cutting solid metals and profiles having a thickness up to 20 mm. Positive rake angle.

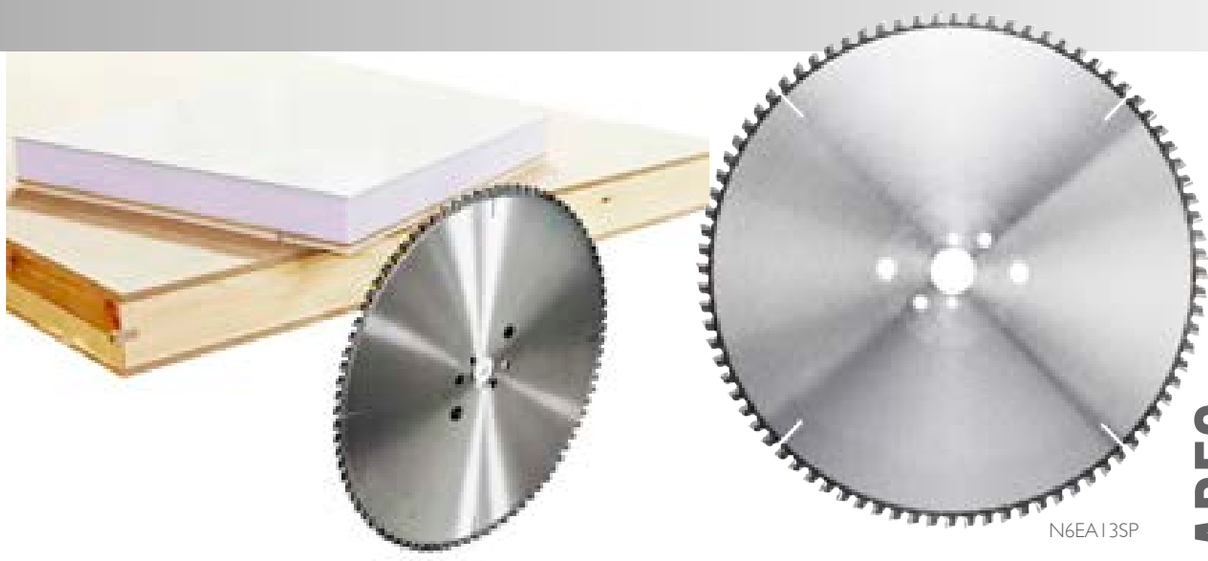
	D	B	b	z
Highline	370	4,0	3,2	90
Highline	400	4,0	3,2	96
Highline	420	4,0	3,2	100
Highline	450	4,0	3,2	108
Highline	500	4,0	3,2	120
Highline	550	4,4	3,4	132
Highline	600	4,4	3,4	144



H5EAM19

Saw blade for cutting solid metals. maximum material thicknes 30 mm. Positive rake angle.

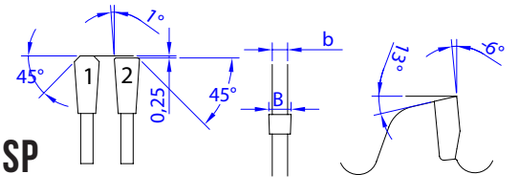
	D	B	b	z
Highline	370	4,0	3,2	60
Highline	400	4,0	3,2	64
Highline	420	4,0	3,2	68
Highline	450	4,0	3,2	72
Highline	500	4,0	3,2	80
Highline	550	4,4	3,4	90
Highline	600	4,4	3,4	96



N6EA13SP

SAW BLADES-
PANEL SIZING OF SANDWICH MATERIAL

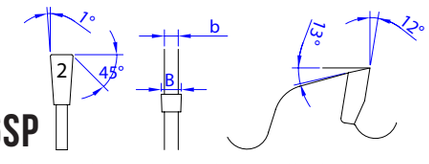
Special saw blade for cutting boards coated with one or two sides of thin sheet. The blades are aimed for special machines, e.g. panel sizing machines without scribing saw blades.



N6EA13SP

Special saw blade for cutting thin-walled sheets of steel, single sided or double sided coated on hard foam or similar. For machines where the material is firmly attached.

	D	B	b	z
	350	3,2	2,5	84
Highline	400	3,2	2,5	96
Highline	500	4	3,2	120



12EE16SP

Special saw blade for cutting thin-walled sheets of steel, single sided or double sided coated on hard foam or similar. For machines where the material is firmly attached.

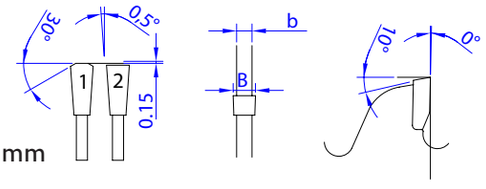
	D	B	b	z
Highline	500	4,2	3	96

STEEL CUTTING SAW BLADES

S13

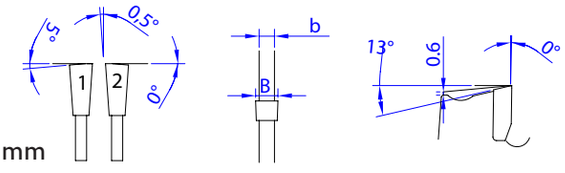
Swedex steel-cutting saw blades are equipped with a special carbide alloy suitable for cutting steel even without cooling. The saw blades with D= 305 mm are adaped for Jepson and similar machines. D=305, z=60 are mainly used for thicker materials while D=305, z= 80 siut thinner materials and stainless steel.

To have in mind when sawing stainless steel: The material is very abrasive, hence resharpening will have to take place more often. The feed speed should be as high as possible without risking the strength of the saw blade. The attrition time is proportional to the number times the tooth cuts through the material. The steel-cutting saw blade S13 is suitable for sheet-metal workers, plumbers, in machine shops etc. Can be used in a portable saw.



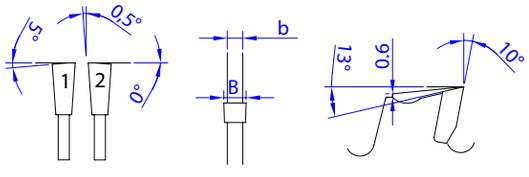
S13 125-230 mm

For cutting of non hardened steel.



S13 240-700 mm

For cutting of non hardened steel.



S13 Stainless

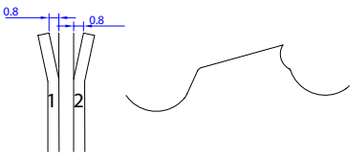
Saw blades with D=305 mm, z=80 and D355, z=84 are particularly recommended for cutting of stainless steel.

Art. S1335524.4-10

* Laser dampened saw body. The saw blade has laser cut slots filled wint sound absorbing mass.

D	B	b	z
125	2,0	1,6	30
136	2,0	1,6	32
150/160	2,0	1,6	36
165	2,0	1,6	36
180	2,0	1,6	42
200	2,0	1,6	48
216	2,0	1,6	48
230	2,0	1,6	54
240	2,2	1,8	60
250	2,2	1,8	60
305	2,2	1,8	60
305*	2,2	1,8	60
305	2,2	1,8	80
305*	2,2	1,8	80
355	2,6	2,2	84
355*	2,6	2,2	84
400	3,5	2,8	96
450	3,8	3,1	96
500	4,2	3,5	96
550	4,4	3,6	96
600	4,4	3,6	96
700	4,4	3,6	116

BRUSH CUTTER

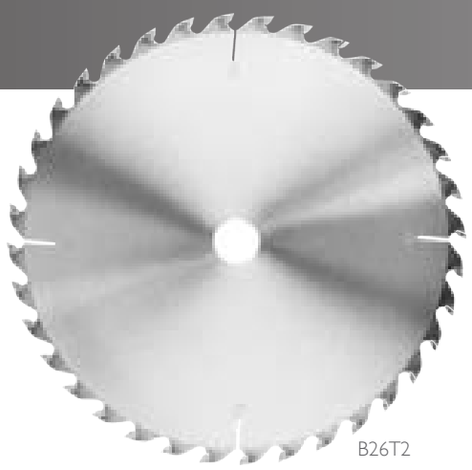


BRUSH CUTTER

Swedex brush cutter saw blade are suitable for the main occuring brush cutters on the market. The saw blades are side set and sharpened.

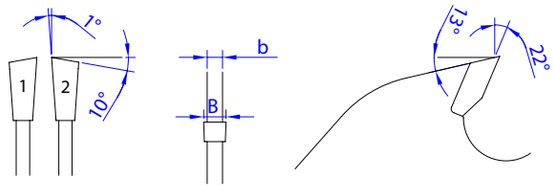
D	B	c	z
200	1,6	20,0	22
200	1,6	25,0	22
200	1,6	25,4	22
225	1,6	20,0	22
225	1,6	25,0	22
225	1,6	25,4	22

CONSTRUCTION SAW BLADES



B26T2

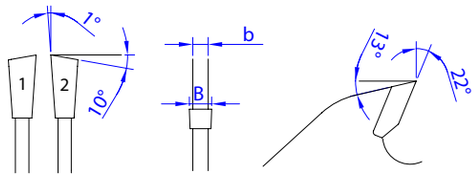
Swedex construction saw blades (for stationary site circular sawbenches) are made for professional use. We stock and supply sawblades for most of the exisitng construction saws on the market.



B31

Coarse-toothed saw blade for ripping and cross-cutting.
* Negative

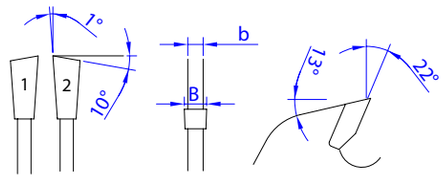
D	B	b	z
300	3,2	2,2	30
305*	3,2	2,2	32
315	3,2	2,2	30
350	3,5	2,5	36
400	3,5	2,5	40



B26T2

Normal toothed saw blade for ripping and cross-cutting.

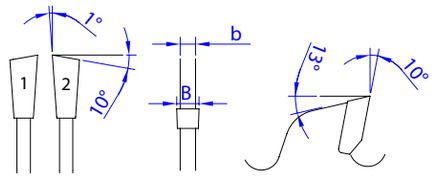
D	B	b	z
204	2,6	1,7	24
300	2,8	1,8	36
350	3,2	2,2	42
400	3,2	2,2	48



B19T2

Close-toothed saw blade for ripping and cross-cutting.
For high requirements of the cutting finish.

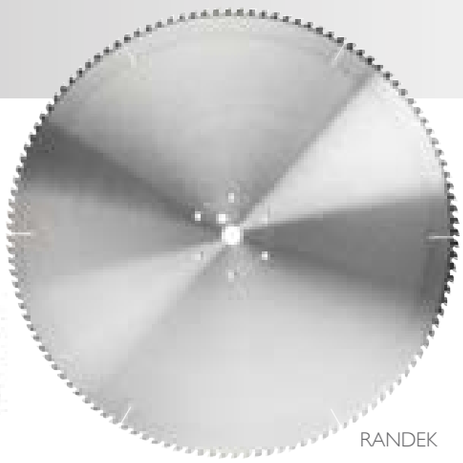
D	B	b	z
300	2,8	1,8	48
315	2,8	1,8	48
350	3,2	2,2	56
400	3,2	2,2	64



B16T2

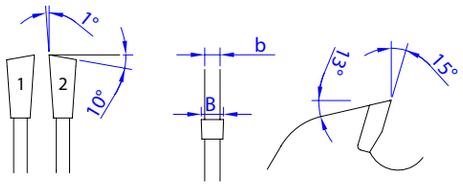
Close-toothed saw blade for ripping and cross-cutting.
For high requirements of the cutting finish.
* Negative

D	B	b	z
300	2,8	1,9	60
305*	2,8	1,9	60
350	3,2	2,2	70
400	3,2	2,2	80



RANDEK

RANDEK



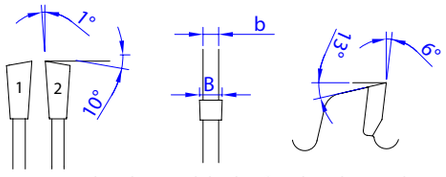
Swedex delivers saw blades to Randek-mashines. 15BA18Dsp is the standard we have in stock. If you need an other dimension contact us for quotation.

D	B	b	c	z
700	4,5	3,5	30	120

SAW BLADES FOR PORTABLE HANDSAWS

E10

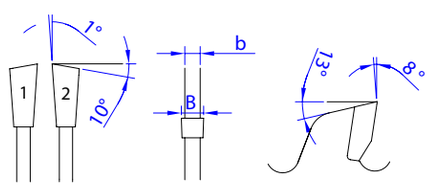
E10



Extra close-toothed saw blade for laminated material and plastics.

	D	B	b	z
	152	2,5	1,5	48
Highline	160	2,5	1,5	48
Highline	165	2,5	1,5	48
	170	2,5	1,5	56
	180	2,5	1,5	56
	184	2,5	1,5	56
	190	2,5	1,5	64
	200	2,5	1,5	64
	204	2,5	1,5	64
	210*	2,8	1,8	64
Highline	216*	2,8	1,8	64
	220	2,8	1,8	64
Highline	250*	2,8	1,8	80
	260	2,8	1,8	80

E13



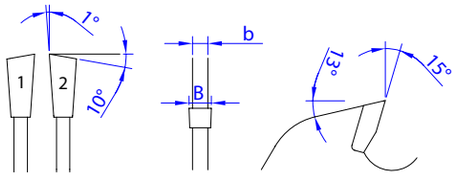
Close-toothed saw blade for parquet, laminated material, ledges and thin plastics.

	D	B	b	z
	125	2,5	1,5	30
	130	2,5	1,5	30
	140	2,5	1,5	36
	152	2,5	1,5	36
	160	2,5	1,5	36
	165	2,5	1,5	36
	170	2,5	1,5	42
	180	2,5	1,5	42
	184	2,5	1,5	42
	185	2,5	1,5	42
	190*	2,5	1,5	48
	200	2,5	1,5	48
	210*	2,8	1,8	48
Highline	216*	2,8	1,8	48
	220	2,8	1,8	56
	230	2,8	1,8	56
	235	2,8	1,8	56
	240	2,8	1,8	60
Highline	250*	2,8	1,8	60
Highline	255*	2,8	1,8	60
	260*	2,8	1,8	60

E19

Swedex manufactures saw blades for Electrical handsaws and battery machines to all machine-models on the market. We have a big assortment of these saw blades in stock.

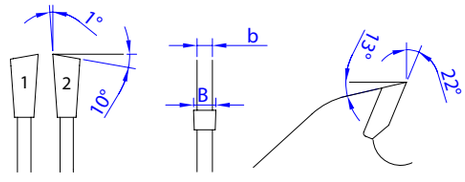
E19



Close-toothed saw blade for ripping and cutting of all kind of wood and boards. For high requirements of the cutting surface.

	D	B	b	z
	125	2,5	1,5	20
	130	2,5	1,5	20
	140	2,5	1,5	24
	152	2,5	1,5	24
	160	2,5	1,5	24
Highline	165	2,5	1,5	24
	170	2,5	1,5	28
	180	2,5	1,5	28
	184	2,5	1,5	28
	185	2,5	1,5	28
Highline	190*	2,5	1,5	32
	200	2,5	1,5	32
	210*	2,8	1,8	32
	216*	2,8	1,8	32
	220	2,8	1,8	36
	230	2,8	1,8	36
	235	2,8	1,8	36
	240	2,8	1,8	36
Highline	250*	2,8	1,8	40
	260	2,8	1,8	40

E26

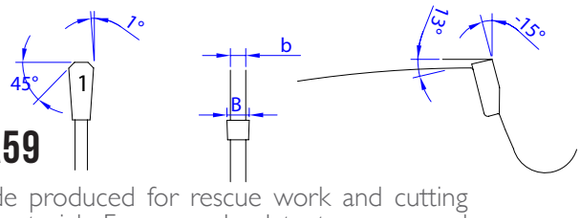


Normal-toothed saw blade for ripping and cutting of all kind of wood and boards.

	D	B	b	z
	125	2,5	1,5	16
	130	2,5	1,5	16
	140	2,5	1,5	16
	152	2,5	1,5	16
	160	2,5	1,5	16
Highline	165	2,5	1,5	16
	170	2,5	1,5	20
	180	2,5	1,5	20
	184	2,5	1,5	20
	185	2,5	1,5	20
Highline	190*	2,5	1,5	24
	200*	2,5	1,5	24
	210*	2,8	1,8	24
Highline	216*	2,8	1,8	24
	220	2,8	1,8	28
	230	2,8	1,8	28
	235	2,8	1,8	28
	240	2,8	1,8	30
Highline	250*	2,8	1,8	30
	260*	2,8	1,8	30
	250*	2,8	1,8	30

SAWBLADES FOR FIRE BRIGADES

N15KA59



N15KA59

Saw blade produced for rescue work and cutting in most materials. For example plate, tar paper and single thin iron profiles.

D	B	b	c	z
300	3,7	2,5	22,2	16
300	3,7	2,5	25,4	16
350	3,7	2,5	22,2	24
350	3,7	2,5	25,4	24

HOGGERS

Swedex produces low cost hoggers in different models. As the saw blades for the hoggers can be resharpened in ordinary saw blade grinding machines, this hogger gives low running coasts.

Contact us for an offer!

FOR GRINDERIES

Swedex provides all supplies you need for manufacturing, regrinding and reparation for your saw blades.

We are available for technical advising!

- Carbide
- Flux
- Teeth protection
- Silver braze
- Packaging
- Machines and tools

SWEDEX RESIN REMEDY

Do not forget to use a cleaning agent to effectivly remove resin fron your woodworking tools. Our cleaner is biodegradable and produced of ingredients from our natural cycle. The resin remedy can be bought in 5 or 10-liter canisters.

WHAT CAN I DO TO OBTAIN A BETTER CUTTING SURFACE FINISH?

-Choose a saw blade with more teeth.
-Use a higher peripheral speed.
-Select a saw blade with different tooth shape.
-Check flanges and distances.
-Condition of the spindle bearings.

THE BLADE IS VERY NOISY, ESPECIALLY WHEN IDLING, WHY?

-The blade goes into oscillation (self-vibration).
-Change number of teeth and diameter.
-Adjust the speed of revolution if possible.
-You can also choose a sound absorbing saw blade.
-A coating of sound absorbing material on the inside of the safety cover.

HOW TO AVOID CHIP OUTS ON THE BOTTOM SIDE OF THE MATERIAL?

-Use a saw blade with more teeth.
-The saw blade is positioned too high above the material.
-Some special grindings and angles may help.

WHY DOES THE SAW BLADE WOBBLE WHEN WARM?

-During cutting the saw blade becomes warm, especially in the periphery, which causes the blade to expand and stretch. We can add slots for improved blade properties to meet a specific customer's needs.

HOW TO AVOID THE BLADE CHOPPING WHEN CUTTING ALUMINIUM?

-When using manual feed, a negative hook angle results in a softer cut.
-Positive hook angle is recommended if automatic feed is used. A blade with more teeth results in a softer cutting.

NOTES

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SAW BLADES

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