

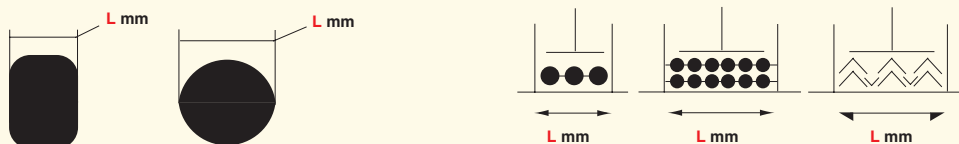
LAMES DE SCIES A RUBAN :

CONSEILS D'UTILISATION POUR SCIES POUR METAUX

ADVICE FOR USE OF METAL CUTTING BAND SAW / RATSCHLÄGE FÜR DEN GEBRAUCH VON METALLSÄGEN
 CONSEJOS DE USO PARA SIERRA DE METAL / CONSIGLI D'USO PER LAMA A NASTRO PER METALLI

CHOIX DU PAS

Pitch choice - Wahl der Zahnteilung - Elección del paso - Scelta del passo



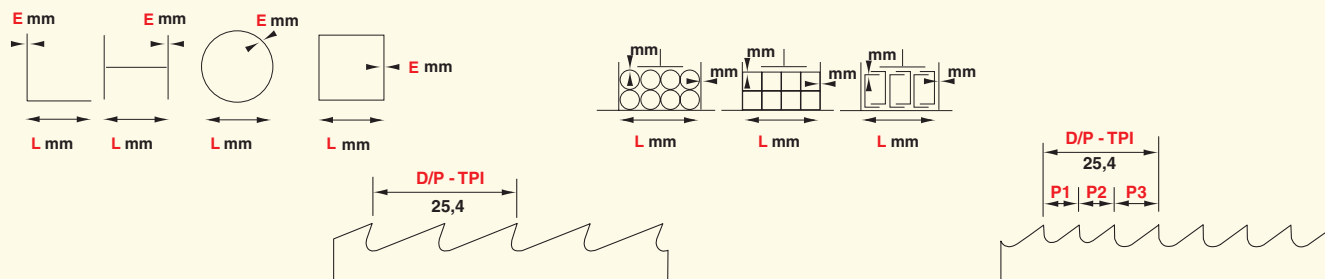
SECTIONS PLEINES

Full section - Alle Abmessungen - Sección lлена - Sezioni pieni

L mm	D/P - TPI	L mm	D/P - TPI
< 10 mm	14	< 25 mm	10/14
10 - 30 mm	10	15 - 40 mm	8/12
30 - 50 mm	8	25 - 50 mm	6/10
50 - 80 mm	6	35 - 70 mm	5/8
80 - 120 mm	4	40 - 90 mm	5/6
120 - 200 mm	3	50 - 120 mm	4/6
200 - 400 mm	2	80 - 180 mm	3/4
300 - 700 mm	1.25	130 - 350 mm	2/3
> 600 mm	0.75	150 - 450 mm	1,5/2
		220 - 600 mm	1/2
		200 - 600 mm	1,1/1,6
		> 500 mm	0,75/1,25

TUBES ET PROFILES

Pipes and profiles - Tuben und Profile - Tubos y perfiles - Tubi e profilati



E	L 20	40	60	80	100	120	150	200	300	500
2	14	14	14	14	14	14	10/14	10/1	8/12	6/10
3	14	14	14	10/14	10/1	10/1	8/12	8/12	6/10	5/8
4	10/14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	5/8	4/6
5	10/14	8/12	8/12	8/12	6/10	6/10	5/8	5/8	4/6	4/6
6	8/12	8/12	6/10	6/10	5/8	5/8	5/6	5/6	4/6	3/4
8	8/12	6/10	6/10	6/10	5/8	5/8	5/6	5/6	4/6	3/4

E	L 40	60	80	100	120	150	200	300	500
10	6/10	5/8	5/8	5/8	5/6	5/6	4/6	3/4	3/4
12	5/8	5/8	5/6	5/6	5/6	4/6	3/4	3/4	3/4
15	5/8	5/8	5/6	4/6	4/6	4/6	3/4	2/3	2/3
20	-	4/6	4/6	4/6	3/4	3/4	2/3	2/3	2/3
30	-	-	3/4	3/4	3/4	3/4	2/3	2/3	2/3
50	-	-	-	-	-	2/3	2/3	2/3	2/3
>50	-	-	-	-	-	-	1,5/2	1,5/2	1,5/2

CONDITIONS DE COUPE A OBSERVER

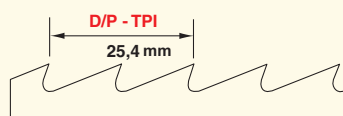
Cutting conditions to be followed - Schneid-Bedingungen, die zu beachten sind
 Condiciones de corte a respetar - Condizioni di taglio da eseguire

Matières	Vitesse en m/min.	Vitesse de rendement en cm ² /min. (sur la base du diamètre)					
		25	50	75	100	150	200
Materials Material	Speed in m/min Geschwindigkeit in m/min	Full output speed in cm ² /min Geschwindigkeits-Leistung in cm ² /min. (auf den Durchmesser basiert)					
Materias	Velocidad en m/min.	Rendimiento de velocidad en cm ² /min. (sobre la base del diametro)					
Materie	Velocità in m/min	Velocità di rendimento in cm ² / min (sulla base del diametro)					
Acier de construction Building steels Stahlkonstruktion Acero de construcción Acciaio di costruzione	80 - 90	25 - 35	40 - 50	50 - 60	55 - 70	70 - 90	75 - 85
Acier à revenu Annealed steels Gehärteter Stahl Acero a revenido Acciaio a rivenimento	45 - 75	20 - 25	25 - 35	30 - 40	35 - 50	40 - 60	40 - 60
Acier à outil non allié Non allied steel for tools Stahl für nicht-legiertes Werkzeug Acero a herramienta no aleado Acciaio ad utensile non alleato	40 - 60	20 - 25	25 - 35	30 - 35	30 - 40	40 - 50	40 - 50
Acier à outil allié, Acier rapide Allied steels and speed steel Stahl für legiertes Werkzeug, Schnell-Stahl Acero a herramienta no aleado y acero rápido Acciaio ad utensile alleato, acciaio rapido	30 - 40	15 - 20	20 - 25	25 - 30	30 - 35	30 - 35	30 - 35
INOX*	20 - 35	10 - 15	15 - 20	15 - 20	15 - 20	15 - 20	15 - 20
Aciers réfractaires et résistants à hautes températures Refractory and high temperature strength steel Feuerfestes Stahl, widerstandfest bei hohen Temperaturen Aceros refractarios y resistentes a altas temperaturas Acciaio refrattario e resistente ad alte temperature	15 - 25	5 - 10	5 - 10	7 - 13	5 - 15	5 - 15	5 - 15

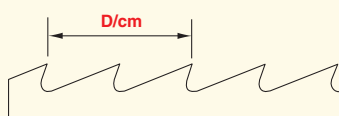
CONVERSIONS DES DENTURES

Tooth conversions - Umwandlungen der Zahnformen - Conversiones de dientes - Conversione delle dentature

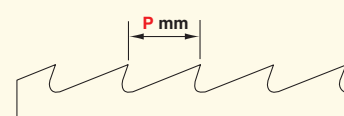
Dts/Pouce -	1.25	2	3	4	6	8	10	14	18	24	32
Dts/cm -	0.5	0.8	1.2	1.6	2.5	3.2	4	6	8	10	12
Pas - Pitch - Teilung - Paso - Passo	20	12.5	8.5	6.3	4.2	3.1	2.5	1.8	1.4	1	0.8



- Dts / pouce
- Teeth per Inch
- Zähne/Zoll
- Dientes por pulgada
- Denti / pollice



- Dts / cm
- Teeth per cm
- Zähne/cm
- Dientes por cm
- Denti / cm



- Pas
- Pitch
- Teilung
- Paso
- Passo