

AMADA BAND SAW BLADES LINEUP



Cutting



Three-in-one total solution through Band saw machines, blades and cutting oils.

- A total manufacturer of Band saw machines, blades, and cutting oils

Amada makes full lines of Band saw machines, blades, and cutting oils to provide maximum possible sawing performance.

We are engaged not only in development and manufacture, but also in marketing and after-sales service.

Our customers' opinions are fed back directly to our development and manufacture to offer our customers the products that meet their specific sawing needs.

- Band Saw blade history and R&D

We started the manufacture and marketing of contour machines in 1955 and commercialized bi-metal blades in 1968.

We then innovated technologies in all areas of blade materials, shapes, and coatings and developed the high-performance carbide-tipped band saw blade series AXCELA in 2007.

The sawing know-how and latest sawing technologies accumulated over many years allow us to develop products to meet the sawing needs of our customers.

- Global supply system

Our saw blades are delivered to our customers throughout the world from manufacturing facilities in Japan, China, and Austria through an optimum supply network.

- Proposal of problem solutions

Technical centers are established in Japan, the USA, Germany, Thailand, and China to propose optimum solutions for the sawing problems of customers.

At the technical centers, customers can actually cut their products to experience the differences between conventional and proposed sawing technologies and can verify the performance of proposed solutions by simulation.



Production



Development



saw machines, blades and cutting oils.



Sales

Cutting oil

Service

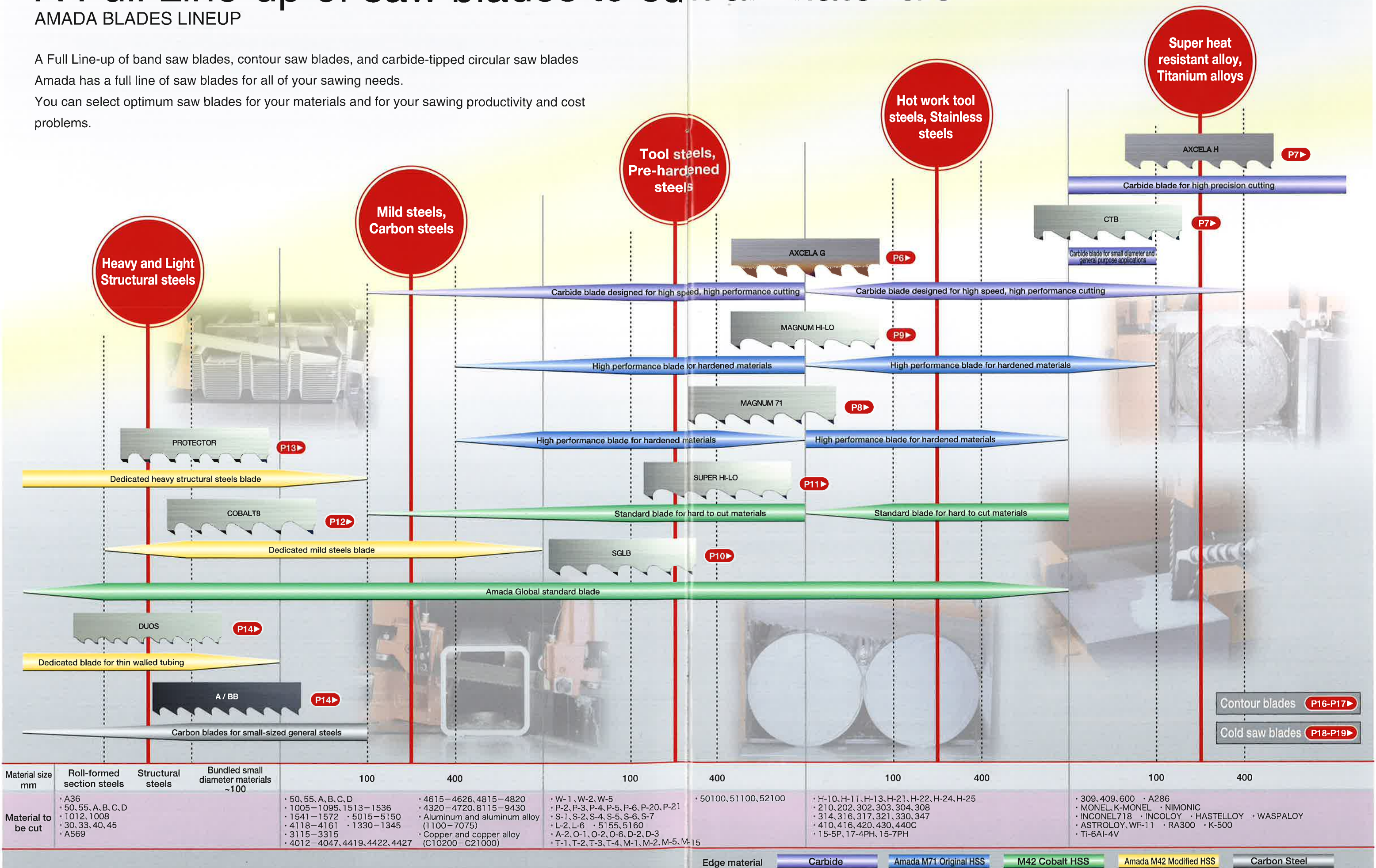
Blade



A Full Line-up of saw blades to suit all materials

AMADA BLADES LINEUP

A Full Line-up of band saw blades, contour saw blades, and carbide-tipped circular saw blades
Amada has a full line of saw blades for all of your sawing needs.
You can select optimum saw blades for your materials and for your sawing productivity and cost problems.



BAND SAW BLADES

AXCELA G

Carbide blade designed for high speed, high performance cutting

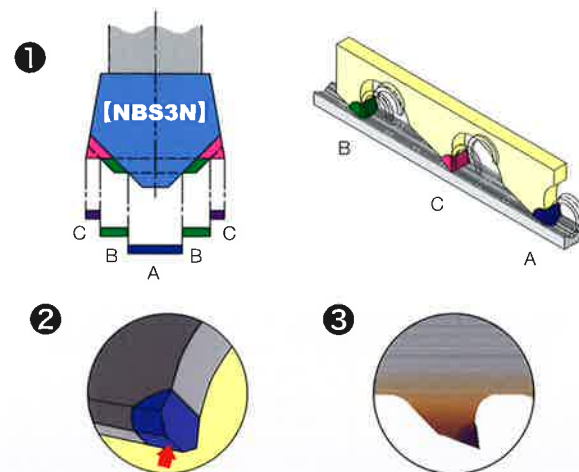
Carbide

Capable of cutting hard-to-cut materials

- Carbide blade providing unparalleled high speed sawing of special steels.
- Excellent multi-purpose blade for production sawing of mixed materials and grades.



Tooth type : Variable gullet, Kerf-dispersal, Dove tail tooth shape
Edge material : Carbide+(EXCOAT-DP)
Hardness : 1600HV+(Film 2800HV)
Wear resistance : ★★★★★
Chipping resistance : ★★★★★



- 1 Kerf-dispersal tooth shape**
Decisively reduces cutting resistance of high alloy steels.
- 2 Tooth tip microchamfer**
Delivers ultra-high cutting rates and reduces tooth chipping.
- 3 EXCOAT-DP**
Super levels of hardness, high resistance to temperatures, strengthened coating adhesion technology.

Applicability

Mild steels, carbon steels			Tool steels, pre-hardened steels			Hot work tool steels, stainless steels			Super heat resistant alloy, titanium alloys		
~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~
●	●	●	●	●	●	●	●	●	●	●	●
AXCELA G											
AXCELA H											

Line-up of products

Name		AXCELA G			AXCELA H		
Type		NBS3N	NBN3N	NBN2N	NCG1S	NSS1N	NSR1N
Coating		EXCOAT-DP	EXCOAT-DP	TiN	Non	Non	Non
Tooth type		Kerf-dispersal type	Dove tail type	Dove tail type	Kerf-dispersal FST-5 teeth pattern	FST-3 teeth pattern	FST-6 teeth pattern
Blades width mm	Blades thickness mm	Pitch					
41	1.3	0.9/1.1	1.4/1.6	1.8/2	0.5/0.8	0.9/1.1	1.4/1.6
54	1.3						
67	1.6						
80	1.6						

● : Standard item ▲ : Separate order required (standard specs) WS : Wide set specification available (helps eliminate blade pinching) WSΔ : WS specifications requiring separate order
※ G-NBN2N: TiN coating (2300HV)
※ WSΔ of H-NCG1S is an optional tooth shape.
※ Separate line-up for blade with tough backing material. Please ask for details.

AXCELA H

Carbide blade for high precision cutting

Carbide

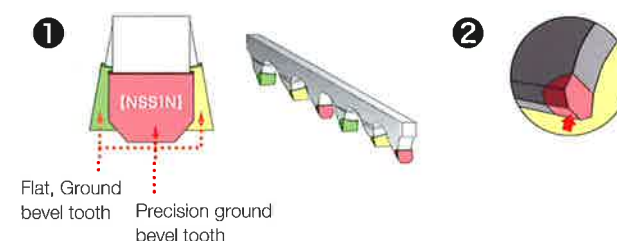
Powerful for cutting very difficult-to-cut materials

- Superior performing blade in operations where premature tooth wear has been an issue. Especially effective on titanium alloys, and Nickel alloys.
- Wide Set (WS) Line-up: reduced blade pinching and significantly improved sawing in wide cross section profiles of hard to cut materials.

- 1 Flat-Set type and Triple-chip tooth profile (FST tooth geometry)**
Dependable sawing on highly abrasive materials.
- 2 Sharp-Edge tooth tip (Sharpest tooth form)**
Increased tooth penetration on hardened materials.
- 3 Utilizing a new and improved grade of carbide chip**
Optimized blade material with improved resistance to wear.



Tooth type : FST
Edge material : Carbide
Hardness : 1650HV
Wear resistance : ★★★★★
Chipping resistance : ★★★★★



CTB

Carbide blade for small diameter and general purpose applications

Carbide

Capable of cutting High-hardness material.(HV400 or more)

- Line-up of fine pitch of carbide blades for general purpose cutting of small diameter, hardened steels.
- Can be fitted on 27mm width bandsaw machines.

- 1 Adoption of carbide tips**
Best suited for hard materials difficult to cut with conventional high-speed steel blades
- 2 Highly accurate tooth tip cutting**
Finished with extremely high accuracy by providing Amada's unique grinding on the tooth rake face, back face and both sides at tooth tip.

* As the tooth tip of the CTB blade is finished with extra sharpness, it is recommended to use at the saw blade speed of 40m/min. or less.



Tooth type : Standard and Set type
Edge material : Carbide
Hardness : 1600HV
Wear resistance : ★★★★★
Chipping resistance : ★★★★★

Applicability

Mild steels, carbon steels			Tool steels, pre-hardened steels			Hot work tool steels, stainless steels			Super heat resistant alloy, titanium alloys		
~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~
●	●	●	●	●	●	●	●	●	●	●	●
CTB											

Line-up of products

Blades width mm	Blades thickness mm	Pitch					
27	1.1	1.25	2	2.5	3	4	
34	1.3						
41	1.3						
54	1.6						
67	1.6						

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MAGNUM 71

High performance blade for hardened materials

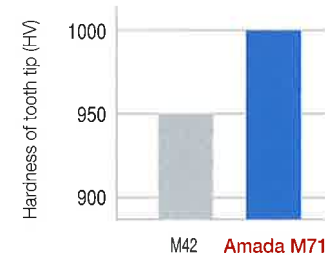
Amada M71

Best suited for small- to medium-sized difficult-to-cut materials, such as stainless steels and hot die steels

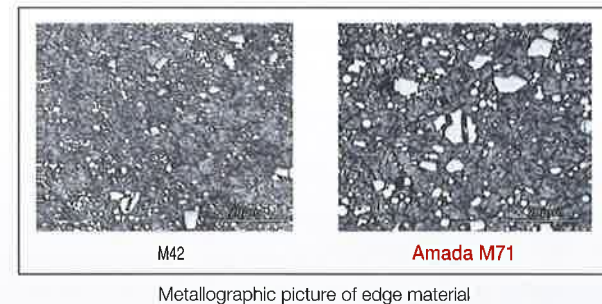
- M42: Recommended for cutting small to medium cross-sections of hardened and hard to cut materials.
- The adoption of M71 over M42 blade material significantly improves tooth tip wear resistance, substantially prolonging blade life.



Tooth type : Standard tooth shape
Edge material : Amada M71 HSS
Hardness : 1000HV
Wear resistance : ★★★★★
Chipping resistance : ★



- Adoption of Amada M71 high-speed steel**
Wear resistance is markedly improved by a cutting edge of the Amada M71 featuring 1000 HV or the highest hardness of cast high-speed tool steels.
- Unconventional idea**
The Amada M71 is our proprietary high-grade high-speed tool steel and contains huge carbides that break up huge carbides in the work material.



Applicability

☞ : Brake-in area/1000 cm

Mild steels, carbon steels			Tool steels, pre-hardened steels			Hot work tool steels, stainless steels			Super heat resistant alloy, titanium alloys		
~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~
●	●	●	●	●	●	●	●	●	●	●	●

Line-up of products

Blades width mm	Blades thickness mm	Pitch					
		0.75/1	1.1/1.5	1.5/2	2/3	3/4	4/6
27	0.9				●	●	●
34	1.1				●	●	▲
41	1.3				●	●	▲
54	1.6		●		●	▲	
67	1.6	▲	●		●	▲	
80	1.6	●	●				

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MAGNUM HI-LO

High performance blade for hardened materials

Amada M71

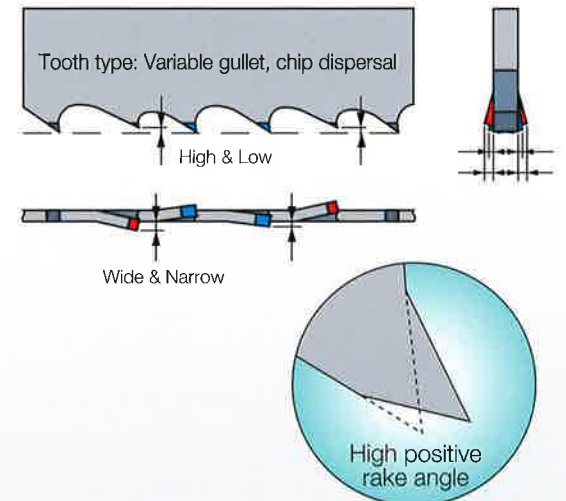
Best suited for medium- to large-sized difficult-to-cut materials, such as stainless steels and hot die steels

- It's has feature of SUPER HI-LO and MAGNUM 71, added unique tooth geometry for increased penetration and cutting performance on medium to large cross-sections of hardened steels.
- Highest quality HSS blade.



Tooth type : Variable gullet, chip dispersal
Edge material : AmadaM71 HSS
Hardness : 1000HV
Wear resistance : ★★★★★
Chipping resistance : ★

- Variable gullet depth for better chip disposal**
All tooth tips effectively work to reduce cutting resistance and ensure stable cutting of difficult-to-cut materials.
- Adoption of Amada M71 high-speed steel**
Wear resistance is markedly improved by a cutting edge of the Amada M71 featuring 1000 HV or the highest hardness of cast high-speed tool steels.
- Highly positive rake angle (special tooth shape)**
Enhanced ability of the saw blade to into hard materials



Applicability

☞ : Brake-in area/1000 cm

Mild steels, carbon steels			Tool steels, pre-hardened steels			Hot work tool steels, stainless steels			Super heat resistant alloy, titanium alloys		
~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~
●	●	●	●	●	●	●	●	●	●	●	●

Line-up of products

Blades width mm	Blades thickness mm	Pitch				
		0.75/1	1.1/1.5	1.5/2	2/3	3/4
34	1.1				●	●
41	1.3		▲		●	●
54	1.6		●	▲	●	
67	1.6		●	▲/WS△	▲	
80	1.6	▲	●/WS△			

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SGLB Amada Global standard blade

M42 Cobalt HSS

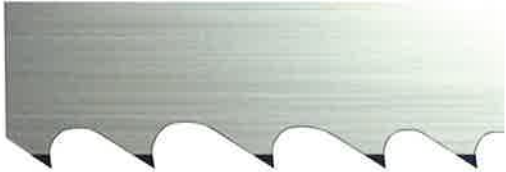
Adapted to a wide range of materials from general steels to difficult-to-cut materials

- Worldwide sales achievements and our most versatile, best-selling band saw blade.
- Ideal sawing for a wide range of material types, shapes, and sizes.



Tooth type : Standard tooth shape
Edge material : M42 Cobalt HSS
Hardness : 950HV
Wear resistance : ★★
Chipping resistance : ★★

Standard tooth shape



Standard tooth shape used for a wide variety of products.
Suitable for cutting materials of a broad range from structural steel to hard-to-cut materials.

- Adoption of M42 cobalt high-speed steel
The cutting edge is made of the M42 to improve wear resistance.
- Amada's proprietary heat treating technology
A global standard blade to make the most of the performance of the cutting edge material.

Applicability

Structural steels	Bundled small diameter materials	Mild steels, carbon steels			Tool steels, pre-hardened steels			Hot work tool steels, stainless steels			Super heat resistant alloy, titanium alloys		
Thick wall H-beam	~100mm	~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~
WS type : Roll formed large size H-beam													

Line-up of products

Blades width mm	Blades thickness mm	Pitch								
		0.75/1	1.1/1.5	1.5/2	2/3	3/4	4/6	5/7	6/10	8/12
19	0.9					●	●	●	▲	▲
27	0.9				●	●	●	●	●	●
	1.1					●	▲			
34	1.1				●	●	●	●	●	▲
	1.3				▲	●	▲			
41	1.3		●	●	●/WS△	●/WS	●	●		
54	1.3		●		●	▲/WS△	●			
	1.6	●	●	●	●/WS△	●/WS	●			
67	1.6	●	●	●	●/WS	●/WS	▲			
80	1.6	●/WS△	●	●	▲					

● : Standard item ▲ : Separate order required (standard specs) WS : Wide set specification available (helps eliminate blade pinching) WS△ : WS specifications requiring separate order

SUPER HI-LO Standard blade for hard to cut material

M42 Cobalt HSS

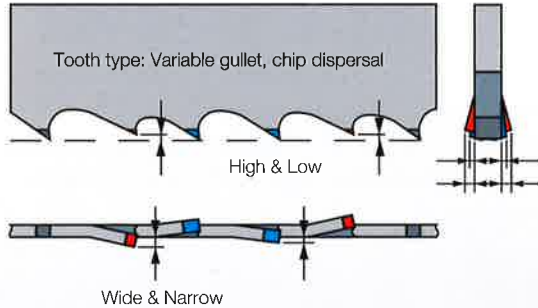
Adapted to cutting medium- to large-sized tool steels and stainless steels

- Recommended for medium to large cross section profiles of stainless steels, tool steels and hard to cut materials.
- Specially designed tooth geometry and gullet profile ensuring improved chip removal and enhanced performance on hard to cut materials.



Tooth type : Variable gullet, chip dispersal
Edge material : M42 Cobalt HSS
Hardness : 950HV
Wear resistance : ★★
Chipping resistance : ★★

- Variable gullet depth for better chip disposal
All tooth tips effectively work to reduce cutting resistance and ensure stable cutting of difficult-to-cut materials.
- Adoption of M42 cobalt high-speed steel
The cutting edge is made of the M42 to improve wear resistance.
- Optimum for large-sized mild steels
Best suited for cutting large-sized mild steels increasing in cutting difficulty



Variable tooth height is combined with variable tooth set to make the most of the performance of the M42 cobalt high-speed steel cutting edge.

Applicability

Mild steels, carbon steels			Tool steels, pre-hardened steels			Hot work tool steels, stainless steels			Super heat resistant alloy, titanium alloys		
~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~	~100mm	100~400mm	400mm~
WS type : Roll formed large size H-beam											

Line-up of products

Blades width mm	Blades thickness mm	Pitch				
		0.75/1	1.1/1.5	1.5/2	2/3	3/4
27	0.9				▲	●
34	1.1				●	●
41	1.3				●	▲
54	1.6		●		●	▲
67	1.6		●/WS△	▲	▲	▲
80	1.6	▲	●/WS△			

● : Standard item ▲ : Separate order required (standard specs) WS : Wide set specification available (helps eliminate blade pinching) WS△ : WS specifications requiring separate order

COBALT8

Dedicated mild steels blade

Amada Modified M42 HSS

Adapted to cutting structural steels and small- to medium-sized mild steels

- The adoption of a tooth profile with improved chip forming characteristics provides a high resistance to vibration and shock and delivers unequalled performance in sawing mild steels.
- Low cost sawing of mild steel.



1 Chip Curler Tooth Shape

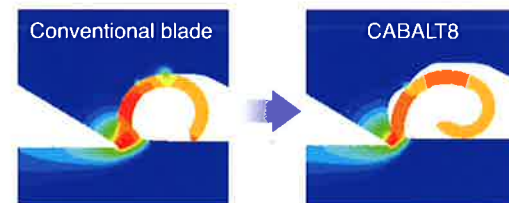
Improved chip removal and reduced the impact on the gullet.
Increased blade life.
Especially high performance for mild steel.

2 Original set pattern

Reduced noise and vibrations during the cutting.
Increased blade life and cutting performance.



Tooth Type : Chip curler tooth shape
Edge material : Amada Modified M42 HSS
Hardness : 930HV
Wear resistance : ★★
Chipping resistance : ★★★★★



L R S L R L S R L S R L R S

Applicability

☞ : Brake-in area/1000 cut

Roll-formed section steels			Structural steels			Bundled small diameter materials	Mild steels, carbon steels		
Thin wall	C-shaped	Deck plate	Thick wall	H-beam	Channel	~100mm	~100mm	100~400mm	400mm~
									

Line-up of products

Blades width mm	Blades thickness mm	Pitch			
		2/3	3/4	4/6	5/7
27	0.9		●	●	●
34	1.1	●	●	●	●
41	1.3	●	●	●	●
54	1.6			●	

● : Standard item ▲ : Separate order required (standard specs) WS : Wide set specification available (helps eliminate blade pinching) WS△ : WS specifications requiring separate order

PROTECTOR

Dedicated heavy structural steels blade

Amada Modified M42 HSS

Prevention of tooth chipping when cutting structural steels

- Protector: featuring robust tooth geometry, highly effective against tooth loss due to excessive vibration and aggressive feed rates, provides superior cutting efficiency on structural steels.
- On select materials, no necessary break-in produce.



1 Protector tooth shape

A protector is added on the back of the tooth face to prevent the tooth from chipping.

2 Increased tooth tip strength

The tooth tips are made stronger to endure the impact caused during intermittent cutting and to achieve high cutting efficiency.

3 Wide set (WS) specification

A broaching style tool set pattern reduces the risk of blade pinching as compared with conventional blades.

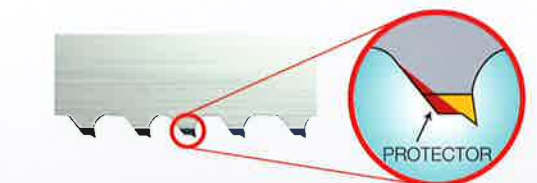


Tooth type : Protector tooth shape
Edge material : Amada Modified M42 HSS
Hardness : 900HV
Wear resistance : ★★
Chipping resistance : ★★★★★

Problem in cutting scene



Answer



Applicability

☞ : Brake-in area/1000 cut

Roll-formed section steels				Structural steels			Bundled small diameter materials		Mild steels, carbon steels		
Thin wall	C-shaped	Deck plate		Thick wall	H-beam	Channel	~100mm	~100mm	100~400mm	400mm~	
											
				WS type : Roll-formed large size H-beam							

Line-up of products

Blades width mm	Blades thickness mm	Pitch		
		2/3	3/4	4/6
27	0.9		●	●
34	1.1		●	●
41	1.3	▲/WS△	●/WS	●
54	1.3		▲/WS△	
	1.6	▲/WS	●/WS	●
67	1.6	▲/WS	▲/WS	▲

● : Standard item ▲ : Separate order required (standard specs) WS : Wide set specification available (helps eliminate blade pinching) WS△ : WS specifications requiring separate order

DUOS

Dedicated blade for thin walled tubing

Amada Modified M42 HSS

Best suited for cutting thin-walled tubes and light-gauge structural steels

- Special tooth construction applied with a unique set pattern provides unsurpassed performance on thin walled piping and light structural steels.
- Also effective in light duty band saw applications.

① HI-LO + twin set tooth shape

Two types of tooth shapes offer respective protection and prevent excessive penetration into the work material.

② Proprietary tooth tip shape

A positive rake angle improves cutting performance.

③ Adoption of first two-step relief angle for small pitch blades

The gullet capacity is increased to prevent chip clogging.



Tooth type : HI-LO Twin set tooth shape
Edge material : Amada Modified M42 HSS
Hardness : 900HV
Wear resistance : ★★
Chipping resistance : ★★★★★

Applicability

: Brake-in area/1000cut

Roll-formed section steels	Structural steels	Small diameter
Thin wall C-shaped 	H-beam Channel 	~100mm

Line-up of products

Blades width mm	Blades thickness mm	Pitch
19	0.9	●
27	0.9	●
34	1.1	●

● : Standard item

A/BB

Carbon Steel Band Saw Blades

Carbon Steel

Adapted to cutting small-sized general steels, steel castings, and nonferrous metals.

- Blade suitable for cutting general steel, cast iron and nonferrous metal materials with small diameters.
- BB refers to a carbon steel blade with improved body fatigue strength.

① Blade tooth tips made of AMADA's original special alloy tool steel

Blades still in use more than 35 years since their development with use of proprietary heat treatment.

② Carbon Steel Band Saw Blade

AMADA's proprietary heat treatment technology to give unparalleled toughness and hardness to carbon blades.



Tooth type : Standard tooth shape
Edge material : Special alloy tool steel
Hardness : 810HV
Wear resistance : ★
Chipping resistance : ★★

Applicability

: Brake-in area/1000cut

Roll-formed section steels	Structural steels	Bundled small diameter materials	Mild steels, carbon steels
Thin wall C-shaped Deck plate 	Thick wall H-beam Channel 	~100mm 	~100mm 100~400mm 400mm~

Line-up of products

Name		A						BB		
Blades width mm	Blades thickness mm	Pitch								
		2	3	4	6	8	10	3	4	6
25	0.9		●	●	●	●	●	●	●	●
32	1.1		●	●	●			●	●	●
38	1.2		●	●	●					

● : Standard item ▲ : Separate order required (standard specs) WS : Wide set specification available (helps eliminate blade pinching) WSΔ : WS specifications requiring separate order

Blade information**Edge material**

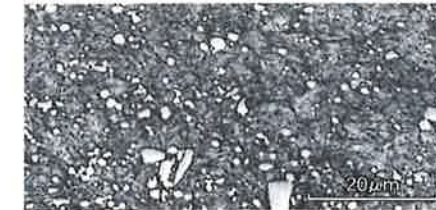
It is not necessarily true that the harder the edge, the longer the service life and the higher the efficiency. In case of cutting that involves high vibration and a large shock, edge material of high toughness are more advantageous because drop-off wear occurs before friction wear.

Amada M42 Modified HSS



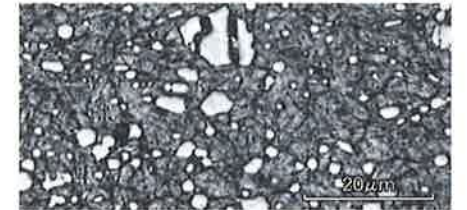
Amada's original matrix high-speed steel, produced based on M42 cobalt high-speed steel. With toughness greatly improved, this steel exhibits its greatest performance under cutting conditions involving vibration and shock.

M42 Cobalt HSS



M42 cobalt high-speed steel that provides superior wear resistance. Being treated with Amada's unique heat treatment technology, this steel exhibits a performance that is highest in the class. It is broadly suitable for cutting general steel through hard-to-cut materials.

Amada M71 Original HSS

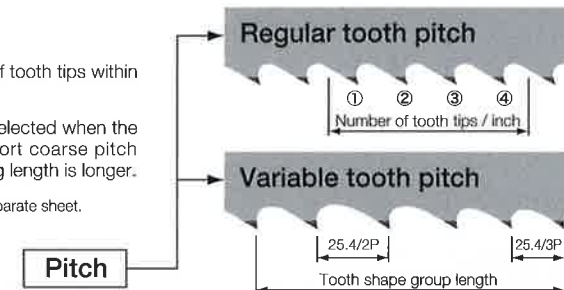


Original highest grade, high-speed steel, developed jointly with a leading steel manufacturer. This steel has hardness of 1000HV, which is the highest ever recorded in ingot high-speed steel. It is suitable for cutting hard-to-cut materials.

Selection**Pitch**

- Pitch is expressed by the number of tooth tips within one inch (25.4mm).
- Generally, a finer pitch should be selected when the cutting length is shorter and a more coarse pitch should be selected when the cutting length is longer.

※ See "Blade pitch selection guide" on separate sheet.



Tooth tips are located at equal intervals. The regular tooth pitch is expressed as "00P(00=number of teeth/inch)". The example shown on the left is 4P, and the tooth tip interval in this case is 25.4÷4P=6.35mm.

Multiple different pitches are combined within one inch. The variable tooth pitch is expressed by two figures such as "2/3P" in the example shown on the left. It means that the maximum tooth tip interval is equivalent to 2P in a tooth shape group (minimum unit of repetition) and that the minimum tooth interval is equivalent to 3P.

Use of this pitch can suppress vibration, and is applicable to cutting in wide range.

Blade pitch selection table by materials to be cut

		Maximum cutting length										
		Material to be cut										
		50	100	150	200	250	300	400	500	700	1000	(mm)
		2"	4"	6"	8"	10"	12"	16"	20"	28"	40"	(Inch)
HSS Bi-Metal Blades	Roll-formed section steels	6/10P		5/7P & 4/6P								
	Structural steel, Bundled tubes											
	Bundled small Diameter material, Mild steel			3/4P			2/3P	1.5/2P				
	Tool steel, Prehardened steel											
	Hot work die steel, Stainless steel											
Carbide Tipped Blades	Super heat resisting alloy							1.1/1.5P		0.75/1P		
	Mild steel			1.8/2P			1.4/1.6P				0.9/1.1P	
	Tool steel											
	Prehardened steel											

Note1 : It is recommended for optimum cutting to select a pitch to allow for 20 to 30 teeth to correspond to the cutting length.

Note2 : When cutting deformed material or like that varies in the cutting length suddenly, it is desirable that at least 2 teeth are in contact with the material constantly while cutting.

Note3 : The above table based on "SGLB" should be used as guide. Specific applicability varies somewhat depending on the characteristics of the blades. For example, 3/4P of "PROTECTOR" is capable of cutting materials in the range including 4/6P in the above table.

Cutting oils

Cutting oils are essential to cutting. Amada's original cutting oils offer a choice best suited for various applications based on blades, cutting environments and materials.

SD Soluble cutting fluid

- This cutting oil suitable for drilling and cutting has excellent defoaming and antiseptic properties. Its high lubricating ability accommodates heavy cutting.



18 liter can

Contour Blade

GLB contour

HSS Bi-Metal Contour Blade

Amada Modified M42 HSS

Bi-metal blade for contour machines

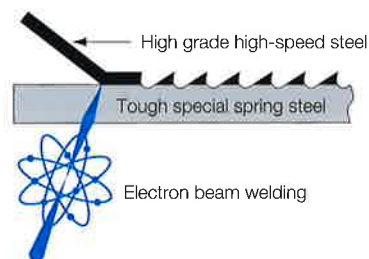
- A breakthrough for previously difficult to cut materials.
- No crooked cuts, no blade breakage and consistent quality cut finish.



- Teeth of the modified M42 high-speed tool steel are electron beam welded to the body of tough spring steel. The resultant bi-metal blade can cut materials difficult to cut with conventional blades, without breaking and bending. The bi-metal blade features an exceptionally long life.



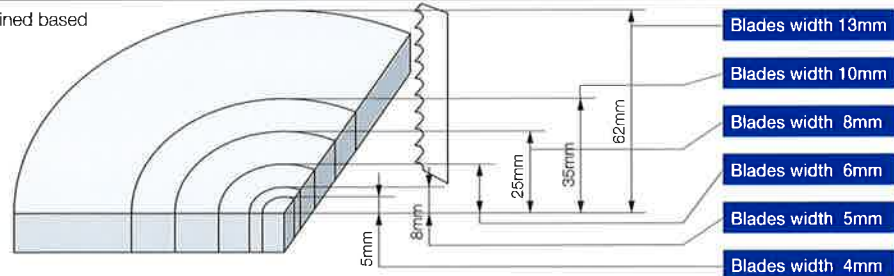
Edge material: Amada Modified M42 HSS
Hardness: 890HV



Applicability

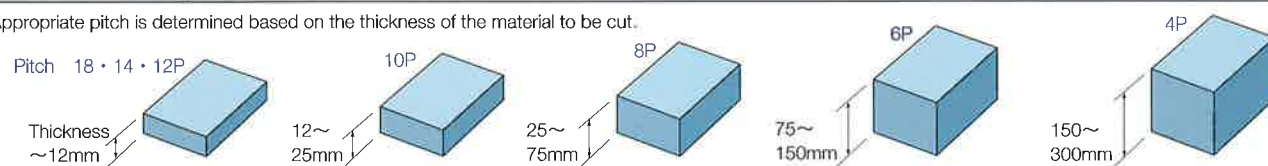
Selection of blades width

The work minimum radius is determined based on the blades width.



Selection of blades pitch

Appropriate pitch is determined based on the thickness of the material to be cut.



Line-up of products

Blades width mm	Blades thickness mm	Pitch							
		4	6	8	10	12	14	18	
3	0.64						●	●	
	0.9						●	●	
4	0.64						●	●	
	0.9				●	●	●	●	
5	0.64				●	●	●	●	
	0.9				●	●	●	●	
6	0.64		●	●	●	●	●	●	
	0.9		●	●	●	●	●	●	
8	0.64		●	●	●	●	●	●	
	0.9		●	●	●	●	●	●	
10	0.64	●	●	●	●	●	●	●	
	0.9	●	●	●	●	●	●	●	
13	0.64	●	●	●	●	●	●	●	
	0.9	●	●	●	●	●	●	●	

● : Standard item ▲ : Separate order required (standard specs) WS : Wide set specification available (helps eliminate blade pinching) WSΔ : WS specifications requiring separate order

A

Carbon Contour Blade

Carbon Steel

Available in many sizes and high versatility

- Unseen in other companies, an abundant arrangement of sizes of general purpose contour blades.
- Longest history and greatest achievements.

- Contour blade with the longest history and most impressive results among Amada's saw blades. Made of a propriety material and given special heat treatment. Available in so many sizes as unobtainable from other saw blade manufacturers and suitable for sawing not only metals but also wood and plastics.



Edge material: Special alloy tool steel
Hardness: 810HV

Applicability

Blades width mm	Blades thickness mm	Pitch									
		4	6	8	10	12	14	18	24	32	
3	0.64							●	●	●	
5	0.64				●	●	●	●	●	●	
6	0.64		●	●	●	●	●	●	●	●	
8	0.64		●	●	●	●	●	●	●	●	
10	0.64	●	●	●	●	●	●	●	●	●	
13	0.64	●	●	●	●	●	●	●	●	●	
16	0.82	●	●	●							
19	0.82	●	●	●							
25	0.9	●									

● : Standard item ▲ : Separate order required (standard specs) WS : Wide set specification available (helps eliminate blade pinching) WSΔ : WS specifications requiring separate order

DASH

Carbon Contour Blade

Carbon Steel

High performance carbon contour cutting saw blades

- Advanced contour blade made from special alloy tool steel and treated with a honing process.
- Excellent cut finish.

- It is special tooth form, is highly recommended for cutting die steel, tungsten, and other hard-materials of extra thickness.



Edge material : Special alloy tool steel
Hardness : 810HV

Line-up of products

Blades width mm	Blades thickness mm	Pitch							
		6	8	10	12	14	18	24	
3	0.64						●	●	
5	0.64			●	●	●	●	●	
6	0.64	●	●	●	●	●	●	●	
8	0.64	●	●	●	●	●	●	●	
10	0.64	●	●	●	●	●	●	●	
13	0.64	●	●	●	●	●	●	●	

● : Standard item ▲ : Separate order required (standard specs) WS : Wide set specification available (helps eliminate blade pinching) WSΔ : WS specifications requiring separate order



COLD SAW BLADES

TCB SERIES Cold saw blades

Amada Cold saw blades fully perform across a wide variety of applications ranging from low carbon steels to difficult to cut materials.

- Edge material (Tungsten carbide / Cermet) welded to a durable blade body, also featuring a unique tooth profile that provides dynamic chip removal, exceptional cutting efficiency, and longer blade life.



Size:

Blade diameter : 240~460mm

Thickness : 1.75~2.7mm

Number of teeth : 40~140

Applicability

Steel pipe	Machine structural carbon steel	Structural alloy steel	Special purpose steel
Tensile strength $\leq 800\text{N/mm}^2$ Vc $\leq 200\text{mm/min}$	Quantity of carbon 0.1 0.2 0.3 0.4 0.5 %		bearing steel 1.0% Stainless steel
	TCB-CR		TCB-SU
	TCB-CB		TCB-Ti
TCB-PT			TCB-TiSU
•STKS •STK •STKM •STKR	•SS400, S10C~45C •SCr, SCM415~440 •SNCM415~439 •SMn420~443	•S40C~58C •SCr, SCM440~445 •SNCM439~447 •SMn443	•SUJ2~5 •SUM •SUP •SUS304 etc.

Blade size (diameter) recommendation by material size.

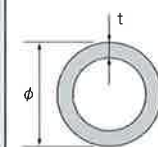
Unit : mm

Outer diameter	Inner diameter	Number of teeth Z	Minimum and maximum diameters of target materials														
			10	20	30	40	50	60	70	80	90	100	110	120	130	140	150
240	32	60															
		80															
250	32	54															
		72															
285	32	60															
		80															
	40	60															
		80															
360	40	60															
		80															
	50	60															
		80															
380	40	100															
		60															
		80															
460	50	100															
		40															
		60															

Blade pitch recommendation for pipes.

Unit : mm

		Outer diameter	Inner diameter
TCB-PT		285	32
			40
		140Z	120Z
Pipe diameter	$\phi 10$	—	—
	$\phi 20$	t 6.8	—
	$\phi 30$	t 3.1	t 9.3
	$\phi 40$	t 2.1	t 5.2
	$\phi 50$	t 1.6	t 3.7
	$\phi 60$	t 1.2	t 2.5
	$\phi 70$	t 1.0	t 2.3



Suitable for low and medium carbon steels

TCB-CR

- General-purpose carbide-tipped circular saw blade with excellent wear resistance and chip welding resistance.
- Can cut carbon and alloy steels with stable life and good quality.

Edge material : Cermet
Mist fluid : AML3
Dropping speed (1 drop) : 5 ~ 6s
Wear resistance : ★★★★★
Chipping resistance : ★★★★★



Outer diameter mm	Inner diameter mm	Thickness mm	Number of teeth Z					
			40	54	60	72	80	100
285	32	2.0			●			
	40	2.0			●		●	
360	40	2.6(2.5)			●		●	●
	50	2.6(2.5)			●		●	●
460	50	2.7	●		●			

Suitable for low and medium carbon steels

TCB-CB

- Circular saw blade with tough tips and suitable for cutting low- and medium-carbon steels.
- Excellent in chipping resistance and suited for cutting carbon and many other steels.

Edge material : Carbide
Mist fluid : AML3
Dropping speed (1 drop) : 5 ~ 6s
Wear resistance : ★★★★★
Chipping resistance : ★★★★★



Outer diameter mm	Inner diameter mm	Thickness mm	Number of teeth Z					
			40	54	60	72	80	100
285	32	2.0			●		●	
	40	2.0			●		●	
360	40	2.6(2.5)			●		●	●
	50	2.6(2.5)			●		●	●
460	50	2.7	●		●			

Stainless steels dedicated

TCB-SU

- Circular saw blade with tough tips and dedicated to cutting stainless steels.
- Chip sticking is reduced to prevent chip loading and tooth chipping.

Edge material : Carbide
Mist fluid : AML4
Dropping speed (1 drop) : 1 ~ 3s
Wear resistance : ★★★★★
Chipping resistance : ★★★★★



Outer diameter mm	Inner diameter mm	Thickness mm	Number of teeth Z					
			40	54	60	72	80	100
285	32	2.0			●		●	
	40	2.0			●		●	
360	40	2.6(2.5)			●		●	●
	50	2.6(2.5)			●		●	●
460	50	2.7	●		●			

Thin-walled tube dedicated

TCB-PT

- Circular saw blade with the number of teeth increased for stably cutting thin-walled pipes.
- Can prevent the deformation of the work material and the formation of burrs during the cutting process.

Edge material : Cermet
Mist fluid : AML6
Dropping speed (1 drop) : 2 ~ 5s
Wear resistance : ★★★★★
Chipping resistance : ★★★★★



Outer diameter mm	Inner diameter mm	Thickness mm	Number of teeth Z					
			60	80	120	130	140	160
285	32	2.0	●	●	●		●	
	40	2.0			●		●	
360	40	2.6(2.5)	●	●		●		●
	50	2.6(2.5)	●	●		●		●

Suitable for high carbon steels

TCB-Ti

- Circular saw blade with tough tips, coated, and suitable for cutting high-carbon steels with a carbon content of 0.4% or more.
- Combines chipping resistance with wear resistance and can provide stable life and good cut quality.

Edge material : Carbide + Coating
Mist fluid : AML3
Dropping speed (1 drop) : 5 ~ 6s
Wear resistance : ★★★★★
Chipping resistance : ★★★★★



Outer diameter mm	Inner diameter mm	Thickness mm	Number of teeth Z					
			40	54	60	72	80	100
285	40	2.0			●		●	
	40	2.6(2.5)			●		●	●
360	40	2.6(2.5)			●		●	●
	50	2.6(2.5)			●		●	●

Stainless steels dedicated

TCB-TiSU

- Coated circular saw blade dedicated to cutting stainless steels.
- The coating improves chip welding resistance and wear resistance and prolongs the blade life.

Edge material : Carbide + Coating
Mist fluid : AML4
Dropping speed (1 drop) : 1 ~ 3s
Wear resistance : ★★★★★
Chipping resistance : ★★★★★



Outer diameter mm	Inner diameter mm	Thickness mm	Number of teeth Z					
			40	54	60	72	80	100
285	32	2.0			●		●	
	40	2.0			●		●	
360	40	2.6(2.5)			●		●	●
	50	2.6(2.5)			●		●	●



Before using this product,
please read the operator's manual carefully and follow all applicable instructions.

※Product availability and product specification subject to change without notice at the discretion of the company.

※Some variation in materials and product specifications may occur according to sales areas.

※There may be differences in the specification that has been described in this catalog to the Amada products which are actually shipped. Please ask our staff for more detail.

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