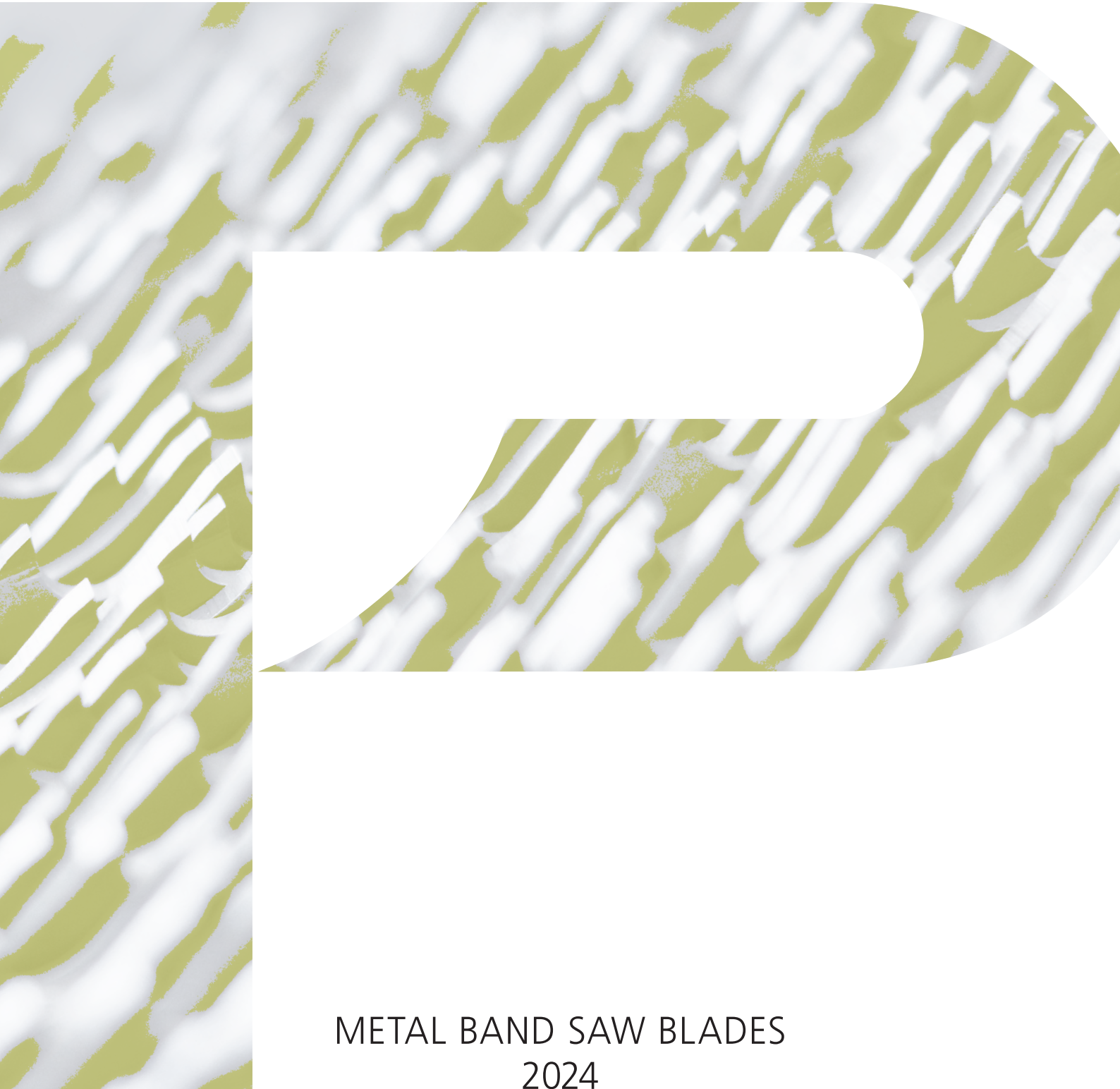


# PONTUS

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CUTTING PERFORMANCE



METAL BAND SAW BLADES  
2024

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## INTRODUCTION

PONTUS, headquartered in Remscheid, Germany, is a highly specialized company for sawing solutions to all your cutting needs. We offer Band Saw Blades for almost all materials and all machines on the market.

Whether you are machining mild steel or high-alloyed exotic materials, PONTUS delivers the right blade.

### At PONTUS we care

Accuracy is a top priority for us. Every step in the production process is carefully monitored and controlled to secure a consistently high-quality product.

Safe transportation is ensured. Your product will be protected against corrosion and carefully packed to reach you in perfect condition.

This is where the actual life cycle of the product begins. After running in, the Band Saw Blade develops its full performance capability over a long service life. Cut after cut, it delivers excellent value for money.

At PONTUS support goes beyond the product. Our team will advise you on the right blade selection and the appropriate cutting data from our extensive experience database and will help you with any questions you may have about the application.

### The PONTUS product range

The PONTUS M42 and M51 Bi-Metal product range extends from the milled, SK and SB types to the precision ground SX, EX types, which enable extremely accurate cuts in even the hardest and toughest materials.

For high-speed and applications in special environments, our Carbide Tipped Band Saw Blades with triple and multi chip geometry are the next level.

A large part of our article groups can be optionally upgraded with our special coating for the highest demands. This further extends the service life at extremely high cutting speeds and feed rates.

Your PONTUS team



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## How to break-in a new Band Saw Blade:

A proper break-in procedure of the new Band Saw Blade will ensure longer blade life. The following break-in instructions round up the sharp tooth edges and will prevent tooth breakages and crooked cuts.

### BI-METAL

1. Set the Band Saw Blade speed according the material to cut.
2. Feed reduction of 50 % for around 10-15 minutes or 300-500 cm<sup>2</sup>.
3. Gradually increasing the feed rate up to 100%.
4. If any vibrations occur slightly reduce the blade speed or slightly increase the blade feed rate.

### CARBIDE

1. During the first 20-30 minutes, depending on the material, set the cutting speed to 25-30 m/min. and feed rate to 3-5 mm/min.
2. If any vibrations occur slightly reduce the blade speed or slightly increase the blade feed rate.

## Recommendation for tooth selection

### Solid material

Cross section mm	Teeth per inch (Tpi)
> 550	0,75/1,25
380 - 750	1/1,3
250 - 550	1,4/2
120 - 350	2/3
80 - 140	3/4
60 - 110	4/6
40 - 70	5/7   5/8
30 - 60	6/10
20 - 40	8/11   8/12
up to 25	10/14

### Thin walled profiles

Wall thickness mm	Diameter in mm						
	20	40	60	80	100	120	150
2	14	14	14	14	14	14	10/14
3	14	14	14	14	10/14	10/14	8/11   8/12
4	14	14	10/14	10/14	8/11   8/12	8/11   8/12	6/10
5	14	10/14	10/14	8/11   8/12	8/11   8/12	6/10	6/10
6	14	10/14	8/11   8/12	8/11   8/12	6/10	6/10	5/7   5/8
8	14	8/11   8/12	6/10	6/10	5/7   5/8	5/7   5/8	5/7   5/8
10	-	6/10	6/10	5/7   5/8	5/7   5/8	5/7   5/8	-

These data are valid only for single cuts. If two or more profiles are cut side by side, the tables apply considering the double wall thickness.

### Thick walled profiles

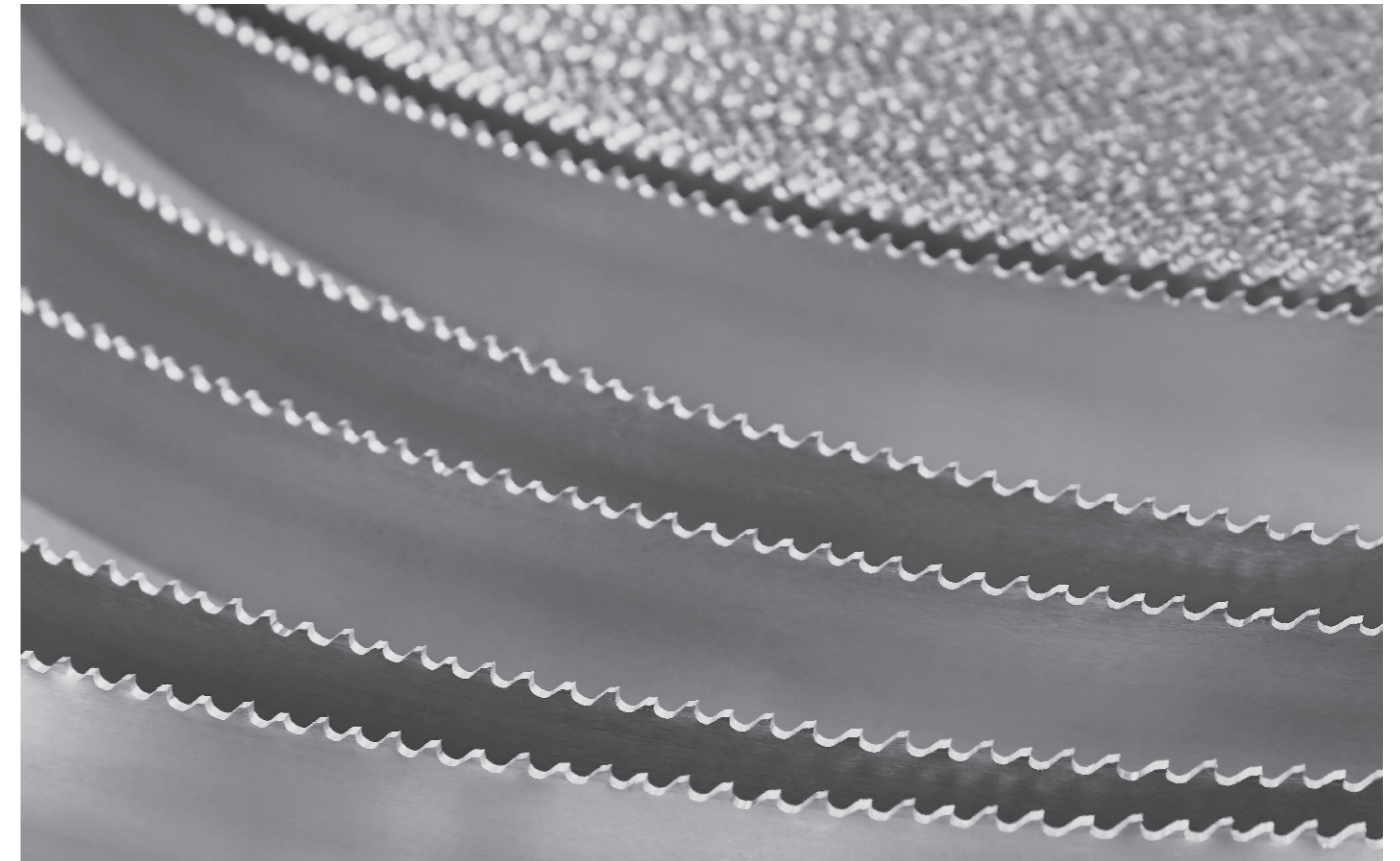
Wall thickness mm	Diameter in mm							
	80	100	120	150	200	300	500	750
10	-	-	-	4/6	4/6	4/6	3/4	2/3
15	4/6	4/6	4/6	4/6	4/6	3/4	2/3	2/3
20	4/6	4/6	4/6	4/6	3/4	3/4	2/3	2/3
30	4/6	4/6	4/6	3/4	3/4	2/3	2/3	2/3
50	-	-	3/4	3/4	2/3	2/3	2/3	1,4/2
80	-	-	-	-	2/3	2/3	1,4/2	1,4/2
100	-	-	-	-	-	2/3	1,4/2	1,4/2

### Delivery lengths for Bi-Metal coils

PONTUS Bi-Metal Band Saw Blades are supplied as endless welded loops to fit your band saw machines, or in coils.

Coils can be delivered in different coil lengths. Please notice that the minimum order quantities refer to the production length.

Width	Coil length
6 - 13 mm	30+76 m
20 - 34 mm	100 m
41 mm	80 m
54 - 67 mm	90 m
80 mm	40 m



- The classic with a wide range of applications for plannable cutting costs and reproducible results
- Extensive toothing selection with neutral and positive rake angle for all common material cross-sections

### M42

### SK 10

Dimensions		Teeth per inch													
mm	inch	0,75/1,25	1,4/2	2/3	3	3/4	4	4/6	6	5/8	6/10	8/12	10/14	14	18
6 x 0,90	1/4 x 0,035														
10 x 0,90	3/8 x 0,035														
13 x 0,65	1/2 x 0,025														
13 x 0,90	1/2 x 0,035														
20 x 0,90	3/4 x 0,035														
27 x 0,90	1 x 0,035														
34 x 1,10	1 1/4 x 0,042														
41 x 1,30	1 1/2 x 0,050														
54 x 1,30	2 x 0,050														
54 x 1,60	2 x 0,063														
67 x 1,60	2 5/8 x 0,063														
80 x 1,60	3 x 0,063														



M42		SK07				
Dimensions		Teeth per inch				
mm	inch	2/3	3/4	4/6	5/7	8/11

- The all-rounder with particularly strong tooth back for use in mixed operation
- Longer blade life
- Reduced blade changes
- Lower inventory costs

20 x 0,90	3/4 x 0,035			•	•	•
27 x 0,90	1 x 0,035		•	•	•	•
34 x 1,10	1 1/4 x 0,042	•	•	•	•	
41 x 1,30	1 1/2 x 0,050	•	•	•		
54 x 1,30	2 x 0,050		•	•		



M42		SP07 • SP07C COATED	
Dimensions		Teeth per inch	
mm	inch	2/3	3/4

- The powerhouse for machining large profiles and beams
- Extended blade life due to robust tooth design even in bundle cutting with chip nests
- Extra wide set prevents jamming in materials with high residual stress

54 x 1,60	2 x 0,063	••	••
67 x 1,60	2 5/8 x 0,063	••	••



M51		EK15						
Dimensions		Teeth per inch						
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3	3/4	4/6	5/8

- The high-performance Band Saw Blade for demanding materials up to 1700 N/mm<sup>2</sup> tensile strength
- Aggressive cutting angle enhances cutting performance

27 x 0,90	1 x 0,035				•	•	•	•
34 x 1,10	1 1/4 x 0,042				•	•	•	
41 x 1,30	1 1/2 x 0,050			•	•	•		
54 x 1,60	2 x 0,063		•	•	•			
67 x 1,60	2 5/8 x 0,063	•	•	•	•			
80 x 1,60	3 x 0,063	•	•	•				



SCP		SCPC COATED			
Dimensions		Teeth per inch			
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3

- The new limit pusher for high-performance cutting processes where conventional M42 qualities fall short
- Especially robust tooth design and newly developed aggressive tooth geometry
- Extra-large chip chamber volume for higher machining rates

41 x 1,30	1 1/2 x 0,050			•*	•*	•*	•*
54 x 1,60	2 x 0,063		••	•*	•*	•*	•*
67 x 1,60	2 5/8 x 0,063	•*	••	•*	•*		
80 x 1,60	3 x 0,063	•*	••				

\*available from Q1 2024



M42		SX10 • SX10C COATED				
Dimensions		Teeth per inch				
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3	3/4

- The powerhouse with ground tooth tips for robust performance in versatile applications on steels and non-ferrous metals up to 1400 N/mm<sup>2</sup> tensile strength
- Excellent cutting surfaces and precise cuts

27 x 0,90	1 x 0,035				•	•
34 x 1,10	1 1/4 x 0,042			•	•	•
41 x 1,30	1 1/2 x 0,050			••	••	••
54 x 1,30	2 x 0,050			••	••	••
54 x 1,60	2 x 0,063	••		••	••	••
67 x 1,60	2 5/8 x 0,063	••	••	••	••	
80 x 1,60	3 x 0,063	••	••	••		



M51		EX15 • EX15C COATED			
Dimensions		Teeth per inch			
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3

- The top-tier of high-performance Band Saw Blades with ground teeth and extremely aggressive tooth geometry for materials up to 1700 N/mm<sup>2</sup> tensile strength
- Bi-Metal Band Saw Blade delivering carbide level performance for heavy-duty cutting tasks on machines without carbide package
- Straight cuts with increased throughput, impressive machining rates and faster feeds

27 x 0,90	1 x 0,035				•
34 x 1,10	1 1/4 x 0,042				•
41 x 1,30	1 1/2 x 0,050			••	••
54 x 1,60	2 x 0,063		••	••	••
67 x 1,60	2 5/8 x 0,063	••	••	••	••
80 x 1,60	3 x 0,063	••	••	••	





- The budget-friendly choice with a wide range of tooth profiles
- Versatile application for thin-walled profiles up to large solid material workpieces

### M42 SB 10

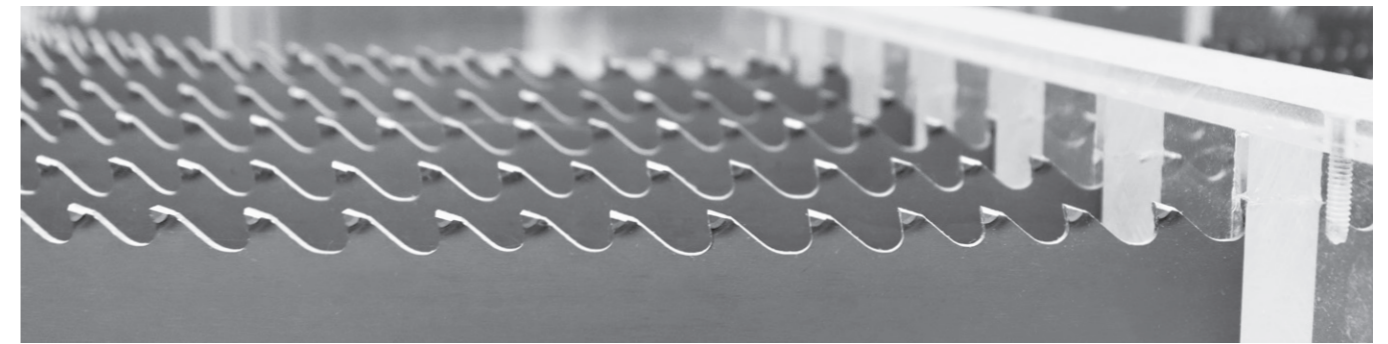
Dimensions		Teeth per inch									
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14
13 x 0,65	1/2 x 0,025							•	•	•	•
13 x 0,90	1/2 x 0,035							•	•	•	•
20 x 0,90	3/4 x 0,035						•	•	•	•	•
27 x 0,90	1 x 0,035				•	•	•	•	•	•	•
34 x 1,10	1 1/4 x 0,042			•	•	•	•	•	•	•	•
41 x 1,30	1 1/2 x 0,050			•	•	•	•				
54 x 1,30	2 x 0,050			•	•	•	•				
54 x 1,60	2 x 0,063	•		•	•	•	•				
67 x 1,60	2 5/8 x 0,063	•	•	•	•	•					
80 x 1,60	3 x 0,063	•	•	•							



### M42 SB07

Dimensions		Teeth per inch					
mm	inch	2/3	3/4	4/6	5/7	8/11	12/16
20 x 0,90	3/4 x 0,035				•	•	•
27 x 0,90	1 x 0,035		•	•	•	•	•
34 x 1,10	1 1/4 x 0,042		•	•	•		
41 x 1,30	1 1/2 x 0,050	•	•	•	•		
54 x 1,60	2 x 0,063	•	•	•			
67 x 1,60	2 5/8 x 0,063	•	•				

- The budget-friendly multitool with a robust tooth design for varying cutting tasks
- Saves inventory costs with extended tool life in mixed operations
- Reduced blade changes



### TTG • TTG C COATED

Dimensions		Teeth per inch			
mm	inch	0,75/1,25	1/1,5	1,4/2	2/3
41 x 1,30	1 1/2 x 0,050			••	••
54 x 1,60	2 x 0,063		••	••	••
67 x 1,60	2 5/8 x 0,063	••	••	••	••
80 x 1,60	3 x 0,063	••		••	

- The Carbide Tipped all-rounder with a robust triple chip geometry
- Consistent performance with changing materials



### TMQ • TMQC COATED

Dimensions		Teeth per inch				
mm	inch	0,75/1,25	1/1,5	1,4/2	2/3	3/4
27 x 0,90	1 x 0,035					•
34 x 1,10	1 1/4 x 0,042			•	•	•
41 x 1,30	1 1/2 x 0,050			••	••	••
54 x 1,30	2 x 0,050			••	••	
54 x 1,60	2 x 0,063	••	••	••	••	••
67 x 1,60	2 5/8 x 0,063	••	••	••	••	
80 x 1,60	3 x 0,063	••		••		

- The universal talent with precision-ground multichip geometry
- Perfectly matched rake angle for exceptional tooth stability at high machining rates

### TTS • TTSC COATED

Dimensions		Teeth per inch				
mm	inch	0,75/1,25	1,4/2	2/3	3	3/4
20 x 0,90	3/4 x 0,035				•	
27 x 0,90	1 x 0,035			•	•	
34 x 1,10	1 1/4 x 0,042		•	•		•
41 x 1,30	1 1/2 x 0,050		••	••		••
54 x 1,30	2 x 0,050		••	••		
54 x 1,60	2 x 0,063	••	••	••		
67 x 1,60	2 5/8 x 0,063	••	••			
80 x 1,60	3 x 0,063	••	••			

- The professional with precisely set teeth
- Extended free cut prevents jamming in materials with significant residual stress
- Applicable on machines with and without carbide software



### TDN

Dimensions		Teeth per inch					
mm	inch	0,65/0,95	0,75/1,25	1,4/2	2/3	3	3/4

- The specialist for non-ferrous metals and graphite with triple chip geometry
- Cutting edges with the special grind

20 x 0,90	3/4 x 0,035					•	
27 x 0,90	1 x 0,035					•	•
34 x 1,10	1 1/4 x 0,042			•	•	•	•
41 x 1,30	1 1/2 x 0,050			•	•		•
54 x 1,30	2 x 0,050			•	•		
54 x 1,60	2 x 0,063	•		•	•		
67 x 1,60	2 5/8 x 0,063		•				
80 x 1,60	3 x 0,063	•	•				



### TMF • TMFC COATED

Dimensions		Teeth per inch					
mm	inch	0,75/1,25	1/1,5	1,4/2	2/3	3/4	

- The champion with complex multi chip geometry for highest demands
- Best performance rates in extremely difficult-to-machine materials up to 1900 N/mm<sup>2</sup> tensile strength
- Precision-ground teeth with aggressive rake angle

27 x 0,90	1 x 0,035				•	•	
34 x 1,10	1 1/4 x 0,042			•	•	•	
41 x 1,30	1 1/2 x 0,050			•	•	•	•
54 x 1,30	2 x 0,050			•	•		
54 x 1,60	2 x 0,063	•	•	•	•	•	•
67 x 1,60	2 5/8 x 0,063	•	•	•	•		
80 x 1,60	3 x 0,063	•		•			



### TMP

Dimensions		Teeth per inch		
mm	inch	1,4/2	2/3	3/4

- The expert for surface hardened workpieces
- Special blade with negative rake angle and multi chip geometry for highest cutting performance

27 x 0,90	1 x 0,035		•	•
34 x 1,10	1 1/4 x 0,042		•	•
41 x 1,30	1 1/2 x 0,050	•	•	•
54 x 1,60	2 x 0,050	•	•	•

#### Delivery lengths for Carbide Tipped Band Saw Blades

PONTUS Carbide Tipped Band Saw Blades are supplied as endless welded loops or in coils:

Width	Coil length
27 - 80 mm	50 m



### TSS

Dimensions		Teeth per inch
mm	inch	

- The confident choice for softer construction materials like aerated concrete, insulation boards, and insulating materials
- Set Carbide Tipped Band Saw Blade with wide clearance reduces jamming and buildup of deposits

27 x 0,90	1 x 0,035	•
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### TSB

Dimensions		Teeth per inch
mm	inch	

- The master for hard and abrasive construction materials like solid, engineered, and perforated bricks
- Vibration-free cutting with reduced force required due to high-performance, precision-ground tooth geometry
- Perfect cutting results

27 x 0,90	1 x 0,035	•
34 x 1,10	1 1/4 x 0,042	•



### WP00

Dimensions		Teeth per inch
mm	inch	

- The rustic for repair and dismantling of wooden pallets
- Special tooth geometry guarantees constant performance while sawing through nails and staples

34 x 1,10	1 1/4 x 0,042	•
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**PONTUS**

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CUTTING PERFORMANCE

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