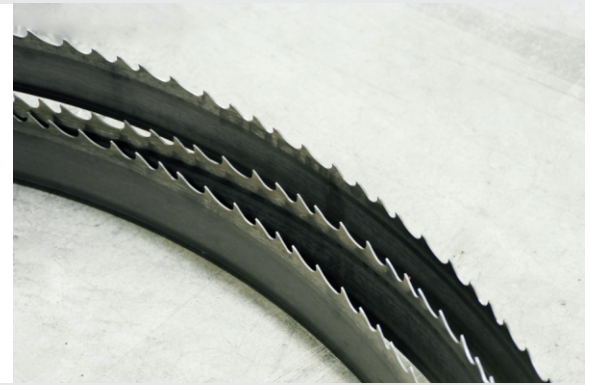


Band saw blade **bite duraflex M42** is a band for universal use for cutting metallic and non-ferrous materials within the whole range of quality classes up to the hardness 45 Hrc, with HSS-M42 cutting tips. The high wear resistance of the saw blade results from the very hard and evenly distributed carbides in the tooth tips, formed during the hardening and tempering proces.

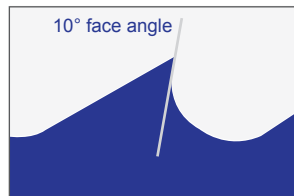
**Bite duraflex M42** is in standard with variable tooth edge spacing. Tooth edge spacing is different repeating periodically. This modern band design allows for a bigger cutting range when one band type is being used, with the capability to eliminate vibrations due to the tooth edge striking the material and thus to achieve a clean smooth cut and a longer life.



## Available tooth pitch

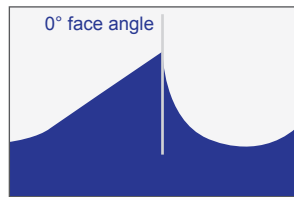
	0,75 / 1,25	1,1 / 1,6	1,5 / 2	2 / 3	3 / 4	4 / 6	5 / 8	6 / 10	8 / 12	10 / 14
13 0,65								■ ZDT	■ ZDT	■ ZDT
20 0,9						■ PDT	■ ZDT	■ ZDT	■ ZDT	■ ZDT
27 0,9				■ PDT	■ PDT	■ PDT	■ ZDT	■ ZDT	■ ZDT	■ ZDT
34 1,1				■ PDT	■ PDT	■ PDT	■ ZDT	■ ZDT	■ ZDT	
41 1,3			■ PDT	■ PDT	■ PDT	■ PDT	■ ZDT	■ ZDT		
54 1,3		■ PDT	■ PDT	■ PDT	■ PDT	■ PDT				
54 1,6	■ PDT	■ PDT	■ PDT	■ PDT	■ PDT	■ PDT				
67 1,6	■ PDT	■ PDT	■ PDT	■ PDT	■ PDT					
80 1,6	■ PDT	■ PDT	■ PDT	■ PDT						

## Tooth Form



### PDT - 10° positive face angle

The hook tooth has a positive cutting angle of 10°. This tooth form is particularly well suited for solid, thick-walled tubes and all higher-grade alloy material.



### ZDT - 0° face angle

The normal tooth has a cutting angle of 0°. It is suitable for material with a high carbon content (such as cast iron), for material with small cross sections and for thin-wall profiles and tubes.

## Tooth selection for profiles



Wall thickness of material (mm)	Tooth pitch
0 - 4	10/14
3 - 6	8/12
6 - 9	6/10
9 - 13	5/8
12 - 16	4/6
16 - 22	3/4
20 - 35	2/3
30 - 85	1,5/2
40 - 80	1,1/1,6
80 - 200	0,75/1,25

## Tooth selection for solid materials



Solid material diameter (mm)	Tooth pitch
0-25	10/14
15-40	8/12
25-50	6/10
35-70	5/8
50-120	4/6
80-180	3/4
130-350	2/3
150-400	1,5/2
200-600	1,1/1,6
500-2000	0,75/1,25