HERBA

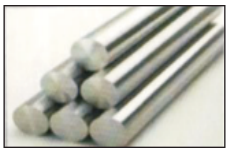
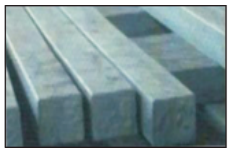
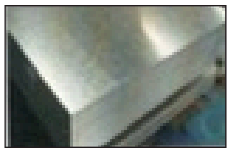
IN ONE CONTINENT OVER 15 MARKETS

BANDSAW – BLADES FOR CNC MACHINES

GOLD H42 - EXTREME

Specially designed tooth geometry with positive rake angle.

H42 EXTREME

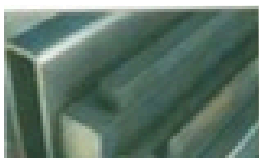
S. No.	SIZE IN MM	CONSTANT TPI	VARIABLE TPI
1	20 x 0.90	-	4/6
2	27 x 0.90	4,6	3/4, 4/6
3	34 x 1.10	4,6	3/4, 4/6
4	41 x 1.30	2,4,6	3/4, 4/6

Cutting Application : Low alloy steel and Unalloyed tool steel.

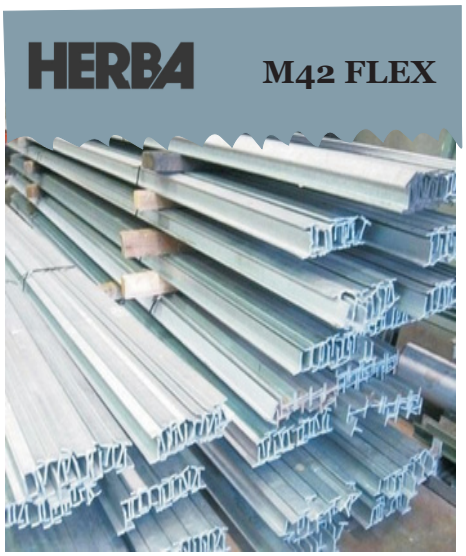
GOLD M42-FLEX

Specially designed tooth geometry having strong tooth for absorbing shocks due to interrupted cut.

FLEX


S. No.	SIZE IN MM	CONSTANT TPI	VARIABLE TPI
1	20 x 0.90	-	4/6, 5/8, 5/7
2	27 x 0.90	-	2/3, 3/4, 4/5, 5/8, 5/7
3	34 x 1.10	-	2/3, 3/4, 4/5, 5/8, 5/7
4	41 x 1.30	-	2/3, 3/4, 4/5, 5/8
5	54 x 1.60	-	4/6, 3/4, 2/3
6	67 x 1.60	-	2/3, 3/4

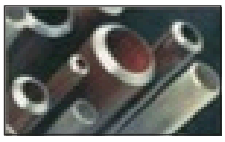
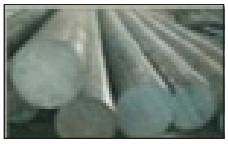


Cutting Application : Bundle cutting for pipes, Tubing and Structural steel.

GOLD M42 - PREMIUM

Specially designed tooth geometry with positive rake angle having additional relief angle and deep gullet.

M42 - PREMIUM

S. NO.	SIZE IN MM	CONSTANT TPI	VARIABLE TPI
1	20 x 0.90	-	3/4, 4/6
2	27 x 0.90	-	2/3, 3/4, 4/6
3	34 x 1.10	-	2/3, 3/4, 4/6
4	41 x 1.30	-	2/3, 3/4, 4/6, 14/2
5	54 x 1.60	1.25	2/3, 3/4, 4/6, 1.4/2, 0.75/1.25
6	67 x 1.80	0.75, 1.25	2/3, 3/4, 0.75/1.25, 1.4/2
7	80 x 1.60	1.25, 0.75	0.75/1.10, 2/3, 3/4, 0.75/1.25, 1.4/2, 0.75/1.10

CUTTING APPLICATION : STRUCTURAL STEELS, DEEP DRAWING STEEL, MACHINE STEEL. SPRING STEEL. MEDIUM ALLOY STEEL. NITRIDMG STEEL. STAINLESS STEEL.

GOLD M42- ULTIMA

Specially designed tooth geometry with extreme positive rake angle having additional relief angle and deep gullet for aggressive cutting.

M42- ULTIMA



S. NO.	SIZE IN MM	CONSTANT TPI	VARIABLE TPI
1	27 x 0.90	-	2/3
2	34 x 1.10	-	2/3
4	41 x 1.30	-	2/3
5	54 x 1.60	-	2/3
6	67 x 1.60	-	2/3

Cutting Application : Deep drawing steel, Spnng steel. Case hardened steel. Nitridmg steel. Tool steel. Quenched & Tempered steel and Hot work steel.

MEAT BLADE

STAINLESS STEEL MEAT BLADES
Designed to achieve coast effective processing and hygienic practices that minimizes microbiel combinetion for both frozen end fresh Meet,

SR. NO	SIZE IN MM	CONSTANT TPI
1	16 * 0.5	3,4
2	19*0.5	3,4
3	20 *05	3,4

WOOD CUTTING BLADES

WOOD BLADES	

TOOTH SELECTION CHART

FOR ROUND SOLID BAR

Diameter in mm	5	10	15	20	25	30	50	75	100	150	200	300	500	700	800	900	1000	1100	1200
TEETH PER INCH/25 MM	10/14	8/12	6/10	5/8	4/6	3/4	2/3	1.4/2	1.25	0.75/1.25									

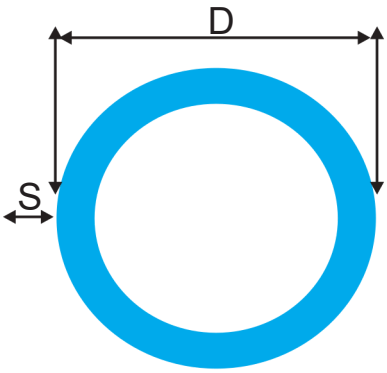
FOR SQUARE / RECTANGLE SOLID

Width in mm	5	10	15	20	25	30	50	75	100	150	200	250	300	400	500	700	800	900	1000	1100	1200
TEETH PER INCH/25 MM	10/14	8/12	6/10	5/8	4/6	3/4	2/3	1.4/2	1.25	0.75/1.25											

FOR STRUCTURALS

Wall Thickness in mm	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	20	25	30	40	50
TEETH PER INCH/25 MM	10/14	8/12	6/10	5/8	4/6	3/4	2/3													

TOOTH SELECTION CHART FOR CUTTING OF PIPES /TUBES



D = Diameter
S= Wall Thickness

D(mm)	20	40	60	80	100	120	150	200	300	400	500	600	700
S(mm)	Tooth pitch (TPI)												
2	1	14	14	14	14	14	10-14	10-14	8-12	8-12	6-10	6-10	5-8
3	4	14	10-14	10-14	10-14	10-14	8-12	8-12	6-10	6-10	5-8	5-8	5-8
4	1	14	10-14	10-14	8-12	8-12	8-12	8-12	5-8	5-8	4-6	4-6	4-6
5	4	10-14	10-14	10-14	8-12	8-12	8-12	6-10	5-8	5-8	4-6	4-6	3-4
6	1	10-14	10-14	8-12	8-12	8-12	8-12	5-8	5-8	4-6	4-6	4-6	3-4
8	4	10-14	10-14	8-12	8-12	6-10	6-10	5-8	4-6	4-6	4-6	3-4	3-4
10	1	8-12	6-10	6-10	6-10	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4
12	4	8-12	6-10	6-10	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4	3-4
15	1	8-12	6-10	5-8	5-8	4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3
20	4		6-10	5-8	4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3	2-3
30	1			4-6	4-6	4-6	3-4	3-4	3-4	2-3	2-3	2-3	2-3
50	4					3-4	3-4	3-4	2-3	2-3	2-3	2-3	2-3
75								2-3	2-3	2-3	2-3	2-3	1.4-2
100									2-3	2-3	1.4-2	1.4-2	1.4-2
150									2-3	1.4-2	1.4-2	1.4-2	
200										1.4-2	1.4-2	1.4-2	

BLADE BREAK-IN EXTREMELY IMPORTANT

The extremely sharp tooth tip and edges of new blades must be broken-in before applying full feed pressure to the blade.
A good analogy is that of writing with a freshly sharpened wooden pencil.

RECOMENDED PROCEDURE

- Maintain proper blade speed for the material to be cut.
- Reduce blade feed pressure or feed rate by 50% for the first 300 to 500 square cm of material cut
- Gradually increase feed pressure or feed rate after break-in to full pressure or rate.