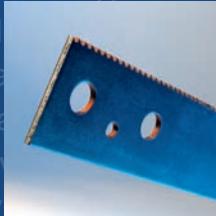
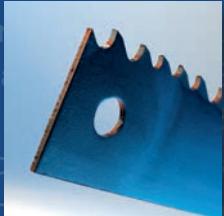


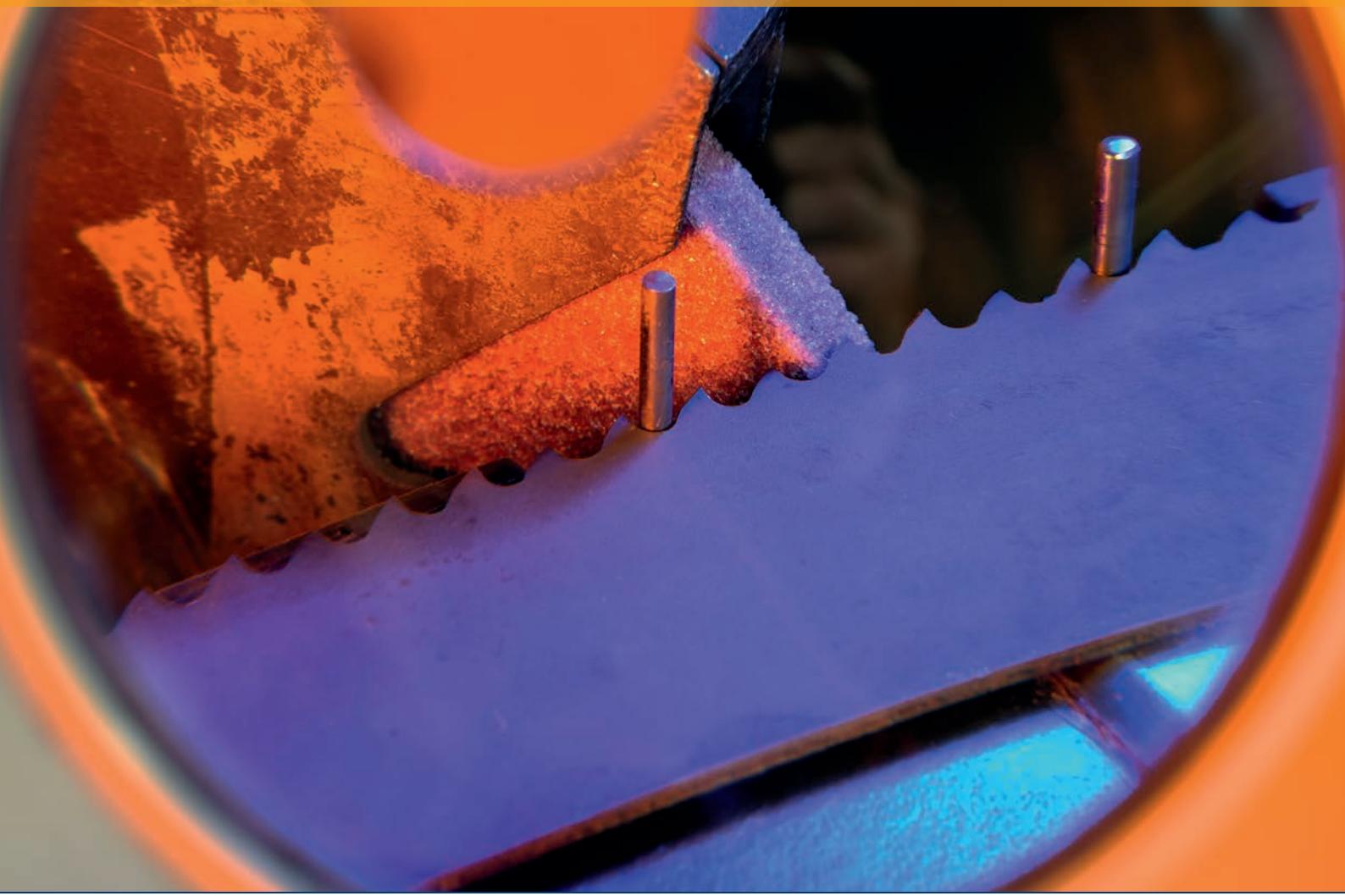


# Quality you can trust



**GUHEMA**





This name stands for **Made in Germany** – since 1867!

A family tradition, years of experience, ongoing research and development as well as sound technical knowledge are what we place at your disposal.

With our efficient organization, we are able to quickly respond to your individual demands at any time.

It goes without saying that we have been certified according to DIN EN ISO 9001:2000 since 1997.

All this means that: when opting for a GUHEMA product, you will always receive a perfect saw blade.



# Content



Power Hacksaw Blades

Page 5



Metal Compass Sawblades

Page 15



Sable and Special Sable Sawblades

Page 19



Hand Hacksaw Blades

Page 35



Hole Saws

Page 45



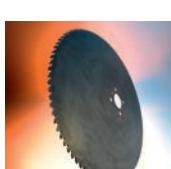
Metal Bandsaw Blades

Page 51



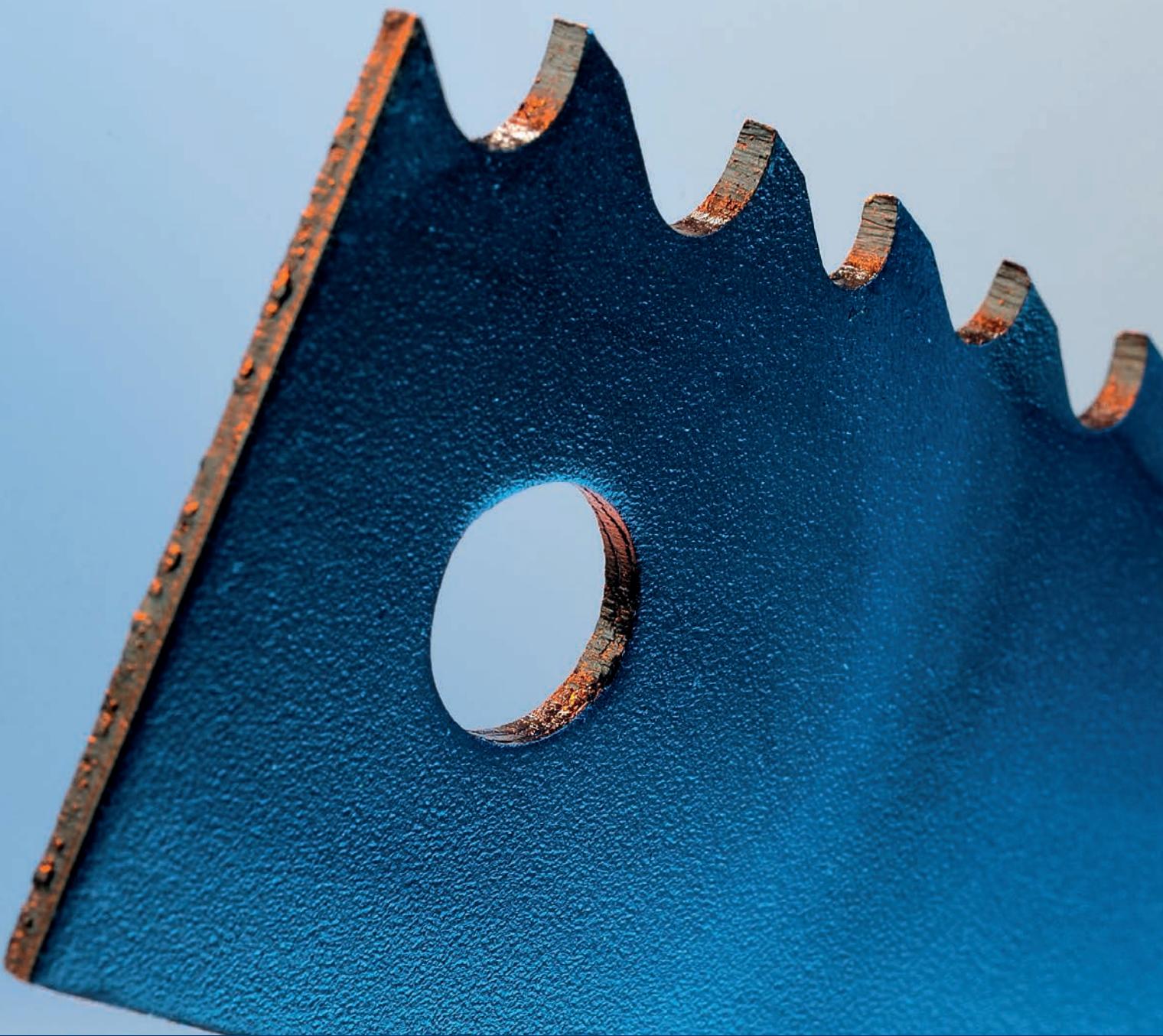
Jigsaw Blades

Page 65



Metal Cutting Circular Sawblades

Page 75



## Power Hacksaw Blades

---

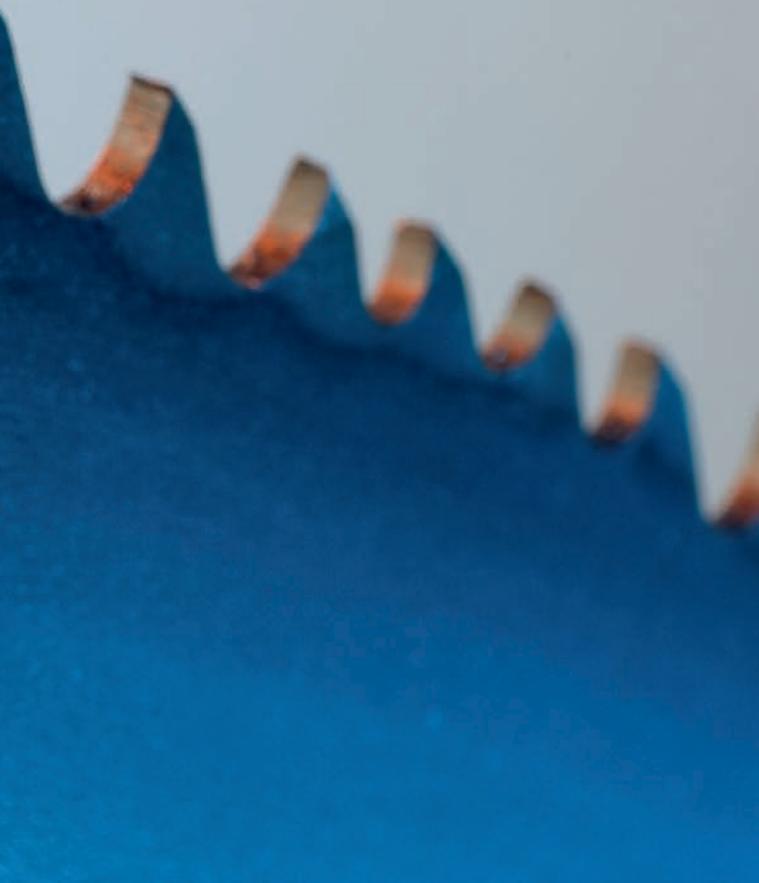
We guarantee that when purchasing a sawblade that bears the GUHEMA brand name, you will receive a state-of-the-art piece of machining technology. We also guarantee the adequate use pertaining to your production flow and a long tool life of sawblade and machine, even if used permanently and in a heavy-duty fashion.



We produce power hacksaw blades for all power saw types on the market. Our range includes standard versions as well as Kasto clampings and sawblades made of bi-metal.

True to the motto:

We deliver the specific power hacksaw blade that will lead to the optimal sawing result in accordance with your requirements!



# Power Hacksaw Blades

## Materials, qualities and application areas

Our pursuit of the perfect sawing quality already begins with the selection of our starting materials, as these form the starting point for our top of the line products – materials that are not classified as "very good" do not pass our incoming goods inspection.

At GUHEMA, first-rate raw materials form the basis for a precise, quick and economic sawing process with

- long life and short cutting times
- a long tool life
- optimal protection for your sawing machine

We offer matching qualities for various application areas

### GUHEMA Super-HSS

M2 Grade (Material No. 1.3343)

For materials up to a tensile strength of 1100 N/mm<sup>2</sup>

### GUHEMA Brilliant

M35 Grade (Material No. 1.3243)

For extremely hard materials up to 1300 N/mm<sup>2</sup> such as austenitic steels and steels with a high chromium-nickel content

### GUHEMA Bi-lastic

M2 Cutting Grade (Material No. 1.3343) on a special steel back

For materials up to a tensile strength of 1100 N/mm<sup>2</sup>

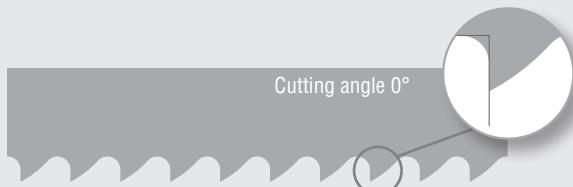
## Choosing the right tooth form

Only the correct tooth form provides our GUHEMA power hacksaw blades with the perfect bite.

We offer:

### Normal Teeth

For universal, general-purpose usage



### Positive Teeth

That cut austenitic, tough steels



### Variable Positive Teeth

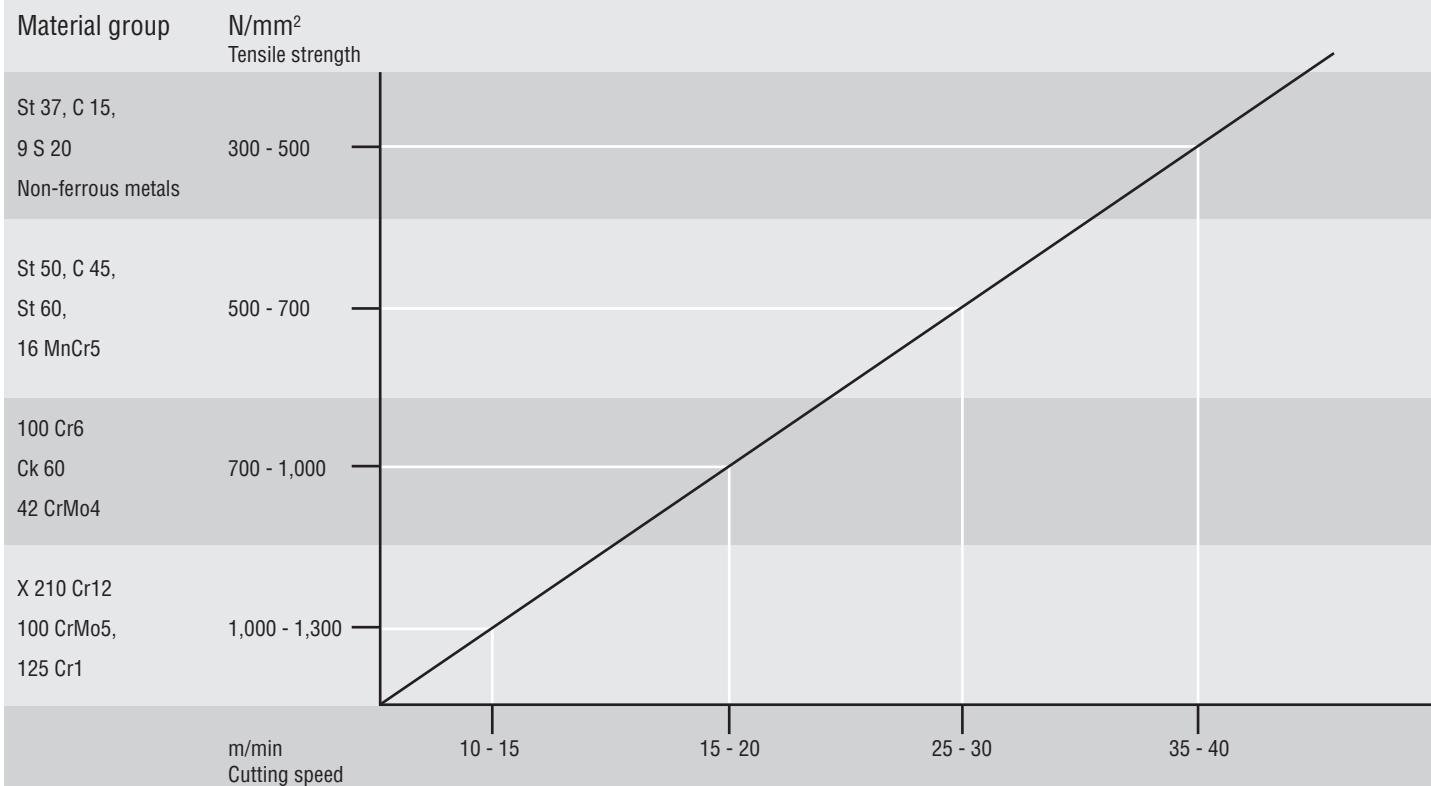
GUHEMA FUTURE that leaves no wish unfulfilled  
as far as a power hacksaw blade is concerned



## Our recommendations for a long service life

When using GUHEMA power hacksaw blades, we recommend only a few, but very important rules concerning the workpiece and sawblade in order to achieve optimal cutting results:

- Never start sawing on a corner.
- Always saw with a running cooling system.
- Firmly clamp the workpiece so that it sits tightly and cannot be twisted.
- A new power hacksaw blade has to be run in. Reduce the cutting pressure by about 50% during the run-in period.
- Remove any mineral residue that may be present on the workpiece.
- Check the sawblade tension from time to time.
- Change your metal sawblade early! Best indicator: significant increase of cutting time.
- Maintain your metal sawblade in accordance with the manufacturer's instructions.
- Adjust the cutting pressure, the cutting speed and the tooth number to the workpiece. The following diagram as well as the table can serve orientation purposes.
- When using "Positive Teeth" and "Future", start with approx. 50% of the conventional pressure. When the sawblade has entered the material with its full width, the pressure has to be continuously increased without a buzzing sound becoming audible.



**Rule of thumb:** 
$$\frac{\text{Cutting speed}}{2 \times \text{stroke distance (m)}} = \text{number of strokes / min.}$$

Cutting data recommendation for solid material in a normally annealed state for GUHEMA power hacksaw blades based on a stroke length of 200 mm.

Reduce cutting pressure for pipes and profiles depending on the wall thickness.

Material Description	TPI for material dimensions					Cutting pressure	Cutting speed depending on material strength		Blade/Grade	Tooth form
	up to 30 mm	50 mm	100 mm	200 mm	above 200 mm		Strokes / min	m / min		
<b>unalloyed steels / structural steels, case hardening steels, such as St37-C10-C15 St50-St60</b>	10-8 10-8	8-6 8-6	6-4 6-4	4-3 4-3	2-1.5 2-1.5	low to medium	60-100 60-100	24-40 24-40	Super HSS Super HSS	normal normal
<b>Quenched and tempered steels, such as C35-C45-C60 CK45-40MN4 34CrNiMo6-42CrMo4</b>	14-10 14-10 14-10	8-6 8-6 8-6	6-4 6-4 6-4	4-3 4-3 4-3	2 2 2	medium medium medium	55-80 55-80 45-50	22-32 22-32 18-20	Super HSS Super HSS Super HSS	normal normal normal
<b>Alloyed carbon steels, such as 125Cr1-115CrV3-100CrMo5 X210Cr12</b>	14-10 14-10	8-6 8-6	6-4 6-4	4-3 4-3	2 2	medium medium	40-60 25-40	16-24 10-16	Super HSS Super HSS	normal normal
<b>High-speed steels, such as ABC III-DMo 5 EMo 5 V 3-B18</b>	10-8 14-10	8-6 8-6	6-4 6-4	4-3 4-3	2 2	medium & higher	25-40 25-35	10-16 10-14	Super HSS Brilliant	normal normal
<b>Stainless steels, such as V2A-V4A</b>	14-10	8-6	6-4	4-3	2	Special provision	25-37	10-15	Brilliant	Positive
<b>Special alloys, such as Hastelloy-Inconel Nimonic-Titanium</b>	10-8 10-8	8-6 8-6	6-4 6-4	4-3 4-3	2 2	Special provision	20-25 10-13	8-10 4-5	Brilliant Brilliant	Positive Positive
<b>AMPCO 18-20</b>	10-8	8-6	6-4	4-3	2	medium	45-50	18-20	Brilliant	normal
<b>AMPCO 21-26</b>	10-8	8-6	6-4	4-3	2	medium	40-45	16-18	Brilliant	normal
<b>Cast steel</b>	14-10	8-6	6-4	4-3	2	medium	50-70	20-28	Super HSS	normal
<b>Cast iron</b>	14-10	8-6	6-4	4-3	2	medium	50-70	20-28	Super HSS	normal
<b>Special bronzes</b>	10-8	8-6	6-4	4-3	2	medium-high	50-62	20-25	Brilliant	normal
<b>Non-ferrous metals</b> Aluminium bronze brass	8	6	4	3	2	low	80-120	32-48	Super HSS	normal

### Application range for our GUHEMA Future metal hacksaw blades:

8/10 TPI .....	Material thicknesses of	8-30 mm
6/8 TPI .....	Material thicknesses of	20-50 mm
4/6 TPI .....	Material thicknesses of	50-100 mm
3/4 TPI .....	Material thicknesses of	70-150 mm
2/3 TPI .....	Material thicknesses over	150 mm

## Our recommendation for coarse tooth patterns (toothing)

### Alternating cross-grinding

Use your advantage with our lateral ground-in rake you will get the cleanest cutting results. Premature teeth breaking is prevented by the ground-in rake and a lower burdening of sawblade and machine results from the chip disposal → both metal hacksaw blades and machine live longer.

We will gladly produce the lateral ground-in rake up to 6 TPI for you upon request. Contact us!



## Are you having trouble sawing? – We've got the answers!

### Teeth breaking?

Possible causes:

- Too low number of teeth selected. At least three teeth should be engaged simultaneously; this also applies to tubes and profiles.
- You started sawing on a corner.
- Workpiece has been clamped incorrectly.

### Blade breaking?

Possible causes:

- The cutting channel has been pressed together and blocks the sawblade.
- Incorrect blade tension.
- Selected toothing is too coarse for the workpiece.
- Cutting pressure too high.
- Worn pilot bearings in the machine.

### Premature dulling of the teeth?

Possible causes:

- Selected toothing is too fine.
- Selected cutting speed too high for the workpiece.
- Too high pressure (increased tooth load) or too low pressure (teeth grinding on the workpiece instead of lifting a chip).
- Inadequate/misaligned sawblade cooling.
- Incorrect sawblade grade selected.
- No sawblade lifting during return travel.

### Unwanted course of the sawblade?

Possible causes:

- Incorrect blade tension.
- Insufficient workpiece clamping.
- Cutting pressure too high.
- Worn pilot bearings in the machine.

### No matching answer?

Then talk to an expert! Contact our application consulting at +49 (0) 2191 88 67-20



GUHEMA Super-HSS  
 DMo 5 / 1.3343 - M2 **BSD...**  
 GUHEMA Brilliant  
 EMo 5 Co 5 / 1.3243 - M35 **BSE...**

### TPI

Dimensions in mm: B x S L		Code Number	Normal Teeth Positive Teeth									Variable Positive Teeth					$\varnothing$ in mm
2 ...C	3 ...E		4 ...G	6 ...H	8 ...I	10 ...J	14 ...L	18 ...N	22 ...O	2/3 ...T	3/4 ...U	4/6 ...V	6/8 ...W	8/10 ...Ü			
20 x 1.25	300	...2301...					HSS •									6.0	
25 x 1.25	300	...2302...				HSS •	HSS •	HSS •	HSS •							8.5	
	350	...2352...				HSS •	HSS •	HSS •	HSS •							8.5	
	400	...2402...				HSS •	HSS •	HSS •	HSS •							8.5	
25 x 1.50	300	...3302...		•	•	•	•	•	•				•	•		8.5	
	350	...3352...		•	•	•	•	•	•				•	•		8.5	
	400	...3402...	•	•	•	•	•	•	•				•	•		8.5	
30 x 1.50	350	...3354...	•	•	•	•	•	•	•				•	•		8.5	
	400	...3404...	•	•	•	•	•	•	•				•	•		8.5	
	450	...3454...	•	•	•	•	•	•	•				•	•		8.5	
30 x 2.00	350	...4354...	•	•	•	•	•	•	•				•	•		8.5	
	400	...4404...	•	•	•	•	•	•	•				•	•		8.5	
	450	...4454...	•	•	•	•	•	•	•				•	•		8.5	
35 x 2.00	350	...4356...	•	•	•	•	•	•	•				•	•		10.5	
	400	...4406...	•	•	•	•	•	•	•				•	•		10.5	
	450	...4456...	•	•	•	•	•	•	•				•	•		10.5	
	475	...4476...	•	•	•	•	•	•	•				•	•		10.5	
40 x 2.00	400	...4409...	•	•	•	•	•	•	•				•	•		10.5	
	450	...4459...	•	•	•	•	•	•	•				•	•		10.5	
	500	...4509...	•	•	•	•	•	•	•				•	•		10.5	
	550	...4559...	•	•	•	•	•	•	•				•	•		10.5	
45 x 2.00	450	...4451...	•	•	•	•	•	•	•				•	•		12.5	
	500	...4501...	•	•	•	•	•	•	•				•	•		12.5	
	550	...4551...	•	•	•	•	•	•	•				•	•		12.5	
45 x 2.50	500	...5501...	•	•	•	•	•	•	•				•	•		12.5	
	550	...5551...	•	•	•	•	•	•	•				•	•		12.5	
	575	...5571...	•	•	•	•	•	•	•				•	•		12.5	
50 x 2.50	500	...5504...	•	•	•	•	•	•	•				•	•		12.5	
	550	...5554...	•	•	•	•	•	•	•				•	•		12.5	
	575	...5574...	•	•	•	•	•	•	•				•	•		12.5	
	600	...5604...	•	•	•	•	•	•	•				•	•		12.5	
	650	...5654...	•	•	•	•	•	•	•				•	•		12.5	
	700	...5704...	•	•	•	•	•	•	•				•	•		12.5	
55 x 2.50	700	...5707...	•	•	•	•	•	•	•				•	•		12.5	
60 x 2.50	625	...5628...	•	•	•	•	•	•	•				•	•		12.5	
60 x 3.00	650	...6658...	HSS •	HSS •	HSS •											12.5	
	700	...6708...	HSS •	HSS •	HSS •											12.5	
	750	...6758...	HSS •	HSS •	HSS •											12.5	
70 x 3.00	800	...6801...	HSS •	HSS •	HSS •											17.0	
110 x 3.00	950	...6954...	HSS •	HSS •	HSS •											18.5	

• = recommended toothing range

HSS = only available as GUHEMA Super-HSS



- GUHEMA Super-HSS
- DMo 5 / 1.3343 - M2 BKD...
- GUHEMA Brilliant
- EMo 5 Co 5 / 1.3243 - M35 BKE...

The fast path to our Article No.  
Grade + Code Number (Dimension) + TPI  
Example: BKD + 2201 + L = BKD2201L

Dimensions in mm: B x S		Code Number	TPI										$\varnothing$ in mm			
			2 ...C	3 ...E	4 ...G	6 ...H	8 ...I	10 ...J	14 ...L	18 ...N	22 ...O	2/3 ...T	3/4 ...U	4/6 ...V	6/8 ...W	8/10 ...Ü
20 x 1.25	200	....2201...								HSS •						5.0
30 x 1.50	300	....3304...		•	•	•	•	•	•	•		•	•	•		8.5
30 x 2.00	300	....4304...		•	•	•	•	•	•	•		•	•	•		8.5
32 x 1.50	350	....3355...		•	•	•	•	•	•	•		•	•	•		8.5
	400	....3405...		•	•	•	•	•	•	•		•	•	•		8.5
	450	....3455...		•	•	•	•	•	•	•		•	•	•		8.5
32 x 2.00	350	....4355...		•	•	•	•	•	•			•	•	•	•	8.5
	400	....4405...		•	•	•	•	•	•			•	•	•	•	8.5
	450	....4455...		•	•	•	•	•	•			•	•	•	•	8.5
36 x 1.50	350	....3357...		•	•	•	•	•	•			•	•	•	•	8.5
36 x 2.00	350	....4357...		•	•	•	•	•	•			•	•	•	•	8.5
	400	....4407...		•	•	•	•	•	•			•	•	•	•	8.5
	450	....4457...		•	•	•	•	•	•			•	•	•	•	8.5
40 x 2.00	450	....4459...		•	•	•	•	•				•	•	•		8.5
	500	....4509...		•	•	•	•	•				•	•	•		8.5
45 x 2.00	550	....4551...		•	•	•	•	•				•	•	•		10.5
48 x 2.50	500	....5503...		•	•	•	•	•				•	•	•		10.5
50 x 2.00	500	....4504...		•	•	•	•	•				•	•	•		10.5
	600	....4604...	•	•	•	•	•					•	•	•		10.5
50 x 2.50	500	....5504...	•	•	•	•	•					•	•	•		10.5
	575	....5574...	•	•	•	•	•					•	•	•		10.5
	600	....5604...	•	•	•	•	•					•	•	•		10.5
52 x 2.50	575	....5575...	•	•	•	•	•					•	•	•		10.5
	600	....5605...	•	•	•	•	•					•	•	•		10.5
55 x 2.50	650	....5657...	•	•	•	•	•					•	•	•		10.5
	700	....5707...	•	•	•	•	•					•	•	•		10.5
63 x 3.50	850	....7859...	HSS •	HSS •	HSS •											13.5
126 x 3.00	1000	....6005...	HSS •	HSS •	HSS •											2x12.5
126 x 3.50	1000	....7005...	HSS •	HSS •	HSS •											2x12.5
144 x 3.50	1160	....7167...	HSS •	HSS •												2x12.5

• = recommended toothing range

HSS = only available as GUHEMA Super-HSS



GUHEMA Bi-lastic

Teeth made of DMo 5 / 1.3343 - M2



Standard dimensions

BSF...



For Kasto machines

BKF...



The fast path to our Article No.

Grade + Code Number (Dimension) + TPI

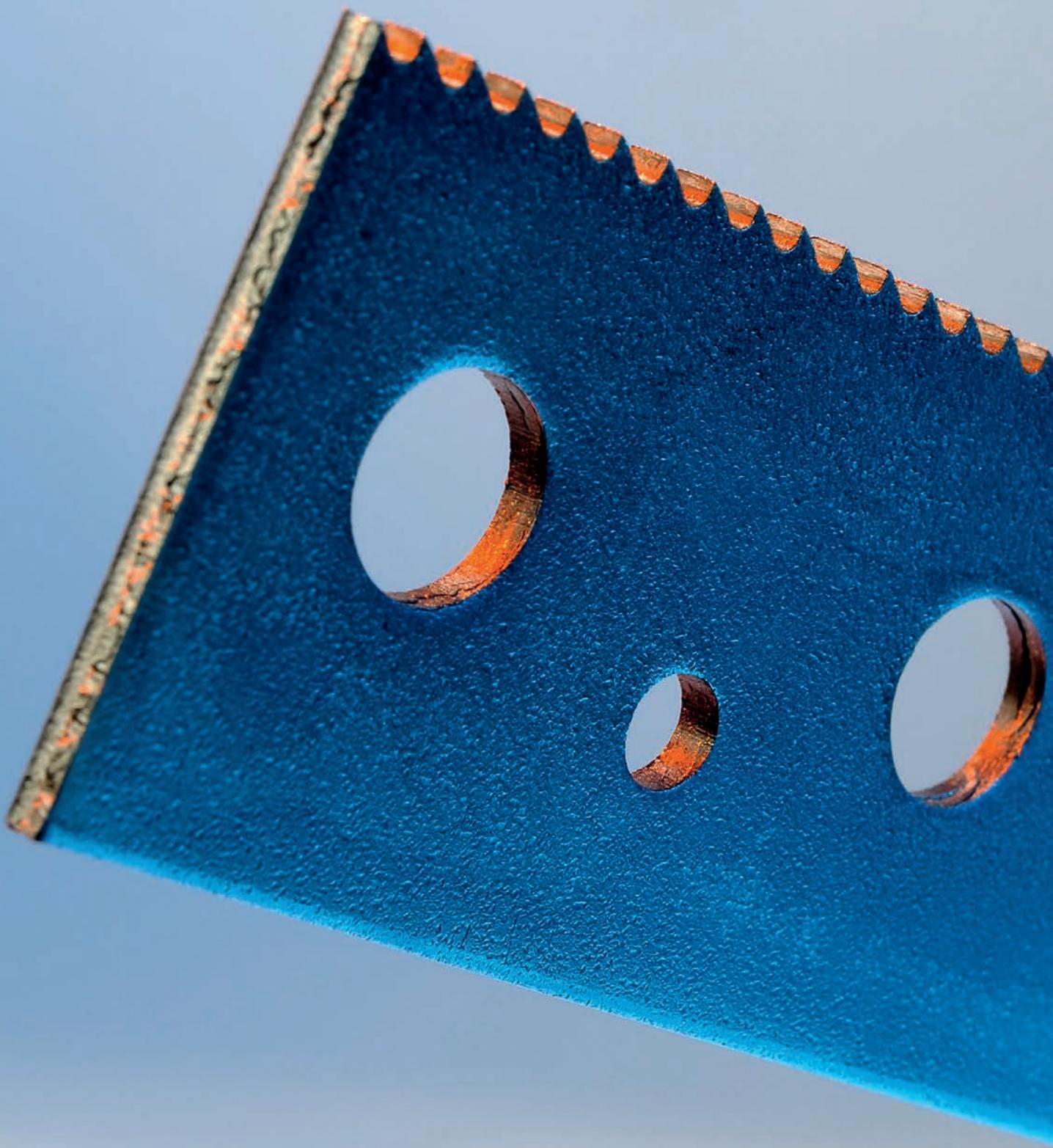
Example: BSF + 2302 + J = BSF2302J

## TPI

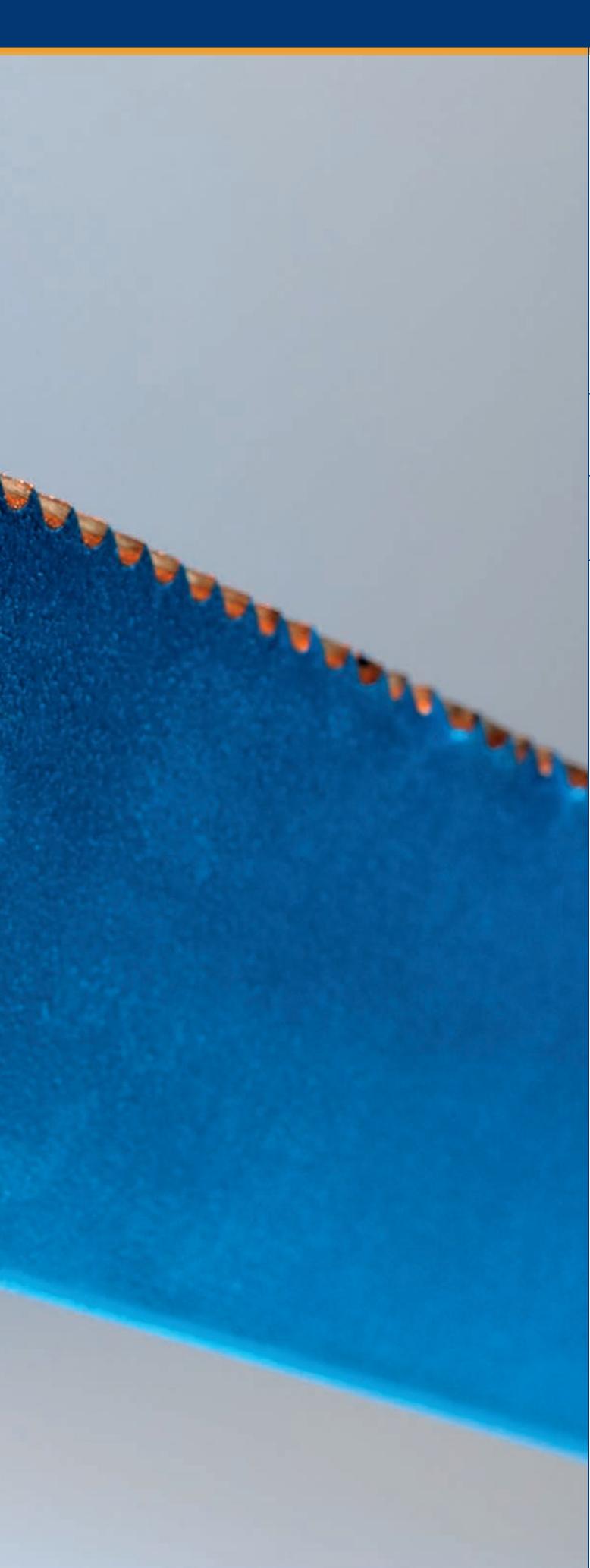
Dimensions in mm: B x S	L	Code Number	Normal Teeth Positive Teeth										Variable Positive Teeth					Standard ø in mm	Kasto ø in mm
			2 ...C	3 ...E	4 ...G	6 ...H	8 ...I	10 ...J	14 ...L	18 ...N	22 ...O	2/3 ...T	3/4 ...U	4/6 ...V	6/8 ...W	8/10 ...Ü			
25 x 1.25	300	...2302...						•	•	•	•						8.5	8.5	
	350	...2352...						•	•	•	•						8.5	8.5	
	400	...2402...					•	•	•	•	•						8.5	8.5	
	425	...2422...				•	•	•	•	•	•				•	•	8.5	8.5	
32 x 1.60	300	...3305...		•	•	•	•	•	•	•					•	•	8.5	8.5	
	350	...3355...		•	•	•	•	•	•	•					•	•	8.5	8.5	
	400	...3405...		•	•	•	•	•	•	•					•	•	8.5	8.5	
38 x 1.90	350	...4358...		•	•	•	•	•	•						•		10.5	8.5	
	400	...4408...		•	•	•	•	•	•						•	•	10.5	8.5	
	450	...4458...		•	•	•	•	•	•						•	•	10.5	8.5	
	500	...4508...		•	•	•	•	•	•						•	•	10.5	10.5	
	550	...4558...		•	•	•	•	•	•						•		10.5	10.5	
45 x 2.25	450	...5451...		•	•	•	•	•	•						•	•	10.5	10.5	
	500	...5501...		•	•	•	•	•	•						•	•	10.5	10.5	
	525	...5521...		•	•	•	•	•	•						•	•	10.5	10.5	
	550	...5501...		•	•	•	•	•	•						•	•	10.5	10.5	
50 x 2.50	500	...5504...	•	•	•	•	•	•	•						•	•	12.5	10.5	
	550	...5554...	•	•	•	•	•	•	•						•	•	12.5	10.5	
	575	...5574...	•	•	•	•	•	•							•	•	12.5	10.5	
	600	...5604...		•	•	•	•	•							•	•	12.5	10.5	
	650	...5654...	•	•	•	•	•								•	•	12.5	10.5	
	700	...5704...	•	•	•	•	•								•	•	12.5	10.5	

• = recommended toothing range





# Metal Compass Sawblades



GUHEMA metal compass sawblades, manufactured to deliver the best cutting performance, suitable for all standard compressed air, hydraulic and electric compass saw machines. We also manufacture special dimensions according to our customer's requirements in addition to our standard products.

# Metal Compass Sawblades

## Materials, qualities and application areas

Our pursuit of the perfect sawing quality already begins with the selection of our starting materials, as these form the starting point for our top of the line products – materials that are not classified as "very good" do not pass our incoming goods inspection.

At GUHEMA, first-rate raw materials form the basis for a precise, quick and economic sawing process with

- long downtimes and short cutting times
- a long tool life
- optimal protection for your sawing machine

### GUHEMA Super-HSS

 M2 (Material No. 1.3343)

 For materials up to a tensile strength of 1100 N/mm<sup>2</sup>

Extreme stability despite the lack of tensile guidance

### GUHEMA Brilliant

 M35 (Material No. 1.3243)

 For machine use with extremely hard workpieces up to 1200 N/mm<sup>2</sup>

For austenitic steels and steels with a high chrome/nickel content

### GUHEMA Bi-lastic

 HSS cutter made of M2 (Material No. 1.3343)

 For materials up to a tensile strength of 1100 N/mm<sup>2</sup>

Special sawblades for public utility companies

## Our recommendations for a long service life

When using machine-guided GUHEMA metal compass sawblades, we recommend only a few, but very important rules concerning the workpiece and sawblade in order to achieve optimal cutting results:

- Never start sawing on a corner.
- Never forget the cooling of the sawblade.

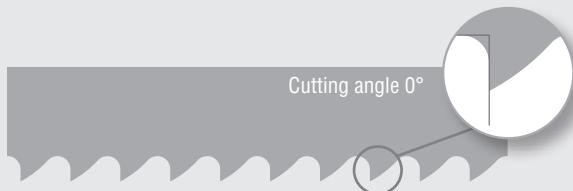
## Choosing the right tooth form

Only the correct tooth form provides our GUHEMA metal compass sawblades with the perfect bite.

We offer:

### Normal Teeth

For universal, general-purpose usage



### Positive Teeth

That cut austenitic, tough steels



### Variable Positive Teeth

GUHEMA FUTURE that leaves no wish unfulfilled  
as far as a metal compass sawblade is concerned





- GUHEMA Super-HSS  
 DMo 5 / 1.3343 - M2 ISD...
- GUHEMA Brilliant  
 EMo 5 Co 5 / 1.3243 - M35 ISE...

The fast path to our article no.  
 Grade + Code Number (Dimension) + TPI  
 Example: ISD + 3202 + I = ISD3202I

		TPI											Variable Positive Teeth				
Dimensions in mm: B x S		Code Number	Normal tooth Positive Teeth											Variable Positive Teeth			
2	3		4	6	8	10	14	16	18	22	3/4	4/6	6/8	8/10	...U	...V	...W
25 x 1.50	150	...3152...			•	•	•	•	•	•							•
	200	...3202...			•	•	•	•	•	•							•
	250	...3252...			•	•	•	•	•	•							•
	300	...3302...			•	•	•	•	•	•							•
	350	...3352...			•	•	•	•	•	•						•	•
	400	...3402...			•	•	•	•	•	•						•	•
	500	...3502...			•	•	•	•	•	•						•	•
	600	...3602...			•	•	•	•	•	•						•	•
25 x 2.00	300	...4302...			•	•	•	•	•	•							•
	400	...4402...			•	•	•	•	•	•							•
28 x 1.50	300	...3303...			•	•	•	•	•	•							•
	400	...3403...			•	•	•	•	•	•						•	•
	500	...3503...			•	•	•	•	•	•						•	•
	530	...3533...			•	•	•	•	•	•						•	•
28 x 2.00	200	...4203...			•	•	•	•	•	•							•
	500	...4503...			•	•	•	•	•	•						•	•
	600	...4603...			•	•	•	•	•	•						•	•
	770	...4773...			•	•	•	•	•	•						•	•
30 x 1.50	500	...3504...			•	•	•	•	•	•						•	•
	530	...3534...			•	•	•	•	•	•						•	•
30 x 2.00	530	...4534...			•	•	•	•	•	•						•	•
	600	...4604...			•	•	•	•	•	•						•	•
32 x 2.00	940	...4945...			•	•	•	•	•	•						•	•



- GUHEMA Bi-lastic  
 Teeth made of DMo 5 / 1.3343 - M2 ISF...

		TPI											Variable Positive Teeth				
Dimensions in mm: B x S x L		Code Number	Positive Teeth											Variable Positive Teeth			
2	3		4	6	8	10	14	16	18	22	3/4	4/6	6/8	8/10	...U	...V	...W
25 x 1.60	200	...3202...			•	•	•	•	•	•					•	•	•
	300	...3302...			•	•	•	•	•	•					•	•	•
	400	...3402...			•	•	•	•	•	•					•	•	•
	500	...3502...			•	•	•	•	•	•					•	•	•
32 x 1.60	400	...3405...			•	•	•	•	•	•					•	•	•
	500	...3505...			•	•	•	•	•	•					•	•	•
	600	...3605...			•	•	•	•	•	•					•	•	•
	700	...3705...			•	•	•	•	•	•					•	•	•
45 x 2.25	500	...5501...			•	•	•	•	•	•					•	•	•
	600	...5601...			•	•	•	•	•	•					•	•	•
	700	...5701...			•	•	•	•	•	•					•	•	•
	800	...5801...			•	•	•	•	•	•					•	•	•
	900	...5901...			•	•	•	•	•	•					•	•	•



# Sable and Special Sable Sawblades



No matter what type of powersaw you are operating, what material you are intending to separate, what the profile looks like or whether or not you have to "follow the curve" with your saw – GUHEMA sable and special sable sawblades meet all of your requirements.

# Sable Sawblades



GUHEMA Bi-lastic SSF...  
GUHEMA Bi-Co-lastic SSM...

- Sharply milled toothing  
• For the machining of sheet metal up to 1 mm of thickness

Toothing	Metal cutting area
32 TPI	< 1 mm

Sawblade length [mm]	100	150	200	225	250	290	150	200	225	250	290
Width x Thickness [mm]	19 x 0.90	19 x 1.27									
Code Number	...1101Q	...1151Q	...1201Q	...1221Q	...1251Q	...1291Q	...2151Q	...2201Q	...2221Q	...2251Q	...2291Q



GUHEMA Bi-lastic SSF...  
GUHEMA Bi-Co-lastic SSM...

- Sharply milled toothing  
• For the machining of sheet metal starting with 1 mm of thickness

Toothing	Metal cutting area
24 TPI	> 1 mm

Sawblade length [mm]	100	150	200	225	250	290	150	200	225	250	290
Width x Thickness [mm]	19 x 0.90	19 x 1.27									
Code Number	...1101P	...1151P	...1201P	...1221P	...1251P	...1291P	...2151P	...2201P	...2221P	...2251P	...2291P



GUHEMA Bi-lastic SSF...  
GUHEMA Bi-Co-lastic SSM...

- Sharply milled toothing  
• For the machining of metal/profiles with a wall thickness of 1.5 - 3 mm

Toothing	Metal cutting area
18 TPI	1.5 - 3 mm

Sawblade length [mm]	100	150	200	225	250	290	150	200	225	250	290
Width x Thickness [mm]	19 x 0.90	19 x 1.27									
Code Number	...1101N	...1151N	...1201N	...1221N	...1251N	...1291N	...2151N	...2201N	...2221N	...2251N	...2291N



**Bi-lastic**  
Made in Germany  
200 x 19 x 0.9 mm 14 ZpZ



2 - 4 mm

GUHEMA Bi-lastic **SSF...**  
 GUHEMA Bi-Co-lastic **SSM...**

- Sharply milled toothing
- For the machining of metal/profiles with a wall thickness of 2 - 4 mm

Toothing	Metal cutting area
14 TPI	2 - 4 mm

Sawblade length [mm]	100	150	200	225	250	290	150	200	225	250	290
Width x Thickness [mm]	19 x 0.90	19 x 1.27									
Code Number	...1101L	...1151L	...1201L	...1221L	...1251L	...1291L	...2151L	...2201L	...2221L	...2251L	...2291L



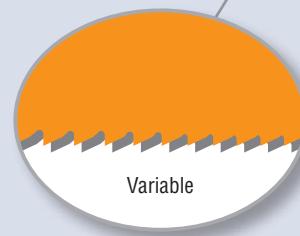
**Bi-lastic**  
Made in Germany  
200 x 19 x 0.9 mm 10-14 ZpZ



3 - 8 mm

GUHEMA Bi-lastic **SSF...**  
 GUHEMA Bi-Co-lastic **SSM...**

- Sharply milled, variable special toothing
- For the machining of metal/profiles with a wall thickness of 3 - 8 mm
- **Special blade for pallet repair**
- For the machining of wood with metal residues



Toothing	Metal cutting area
10 - 14 TPI	3 - 8 mm

Sawblade length [mm]	100	150	200	225	250	290	150	200	225	250	290
Width x Thickness [mm]	19 x 0.90	19 x 1.27									
Code Number	...1101Z	...1151Z	...1201Z	...1221Z	...1251Z	...1291Z	...2151Z	...2201Z	...2221Z	...2251Z	...2291Z



**Bi-lastic**  
Made in Germany  
200 x 19 x 0.9 mm 10 ZpZ



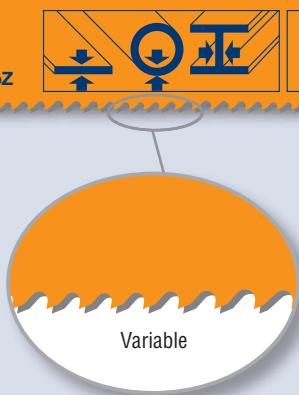
4 - 12 mm

GUHEMA Bi-lastic **SSF...**  
 GUHEMA Bi-Co-lastic **SSM...**

- For the machining of metal/profiles with a wall thickness of 4 - 12 mm
- For the machining of wood with metal residues and a clean cutting line

Toothing	Metal cutting area	Wood cutting area
		10 TPI
		4 - 12 mm
		< 60 mm

Sawblade length [mm]	100	150	200	225	250	290	150	200	225	250	290
Width x Thickness [mm]	19 x 0.90	19 x 1.27									
Code Number	...1101J	...1151J	...1201J	...1221J	...1251J	...1291J	...2151J	...2201J	...2221J	...2251J	...2291J



GUHEMA Bi-lastic SSF...  
GUHEMA Bi-Co-lastic SSM...

- Sharply milled, variable special toothing  
• For the machining of stainless steel  
• For the machining of metal/profiles with a wall thickness > 6 mm

Toothing	Metal cutting area
8 - 10 TPI	> 6 mm

Sawblade length [mm]	100	150	200	225	250	290	150	200	225	250	290
Width x Thickness [mm]	19 x 0.90	19 x 1.27									
Code Number	...1101Ü	...1151Ü	...1201Ü	...1221Ü	...1251Ü	...1291Ü	...2151Ü	...2201Ü	...2221Ü	...2251Ü	...2291Ü



GUHEMA Bi-lastic SSF...  
GUHEMA Bi-Co-lastic SSM...

- Sharply milled toothing  
• For the machining of metal/profiles with a wall thickness > 8 mm  
• For the machining of wood with metal residues  
• **Special blade for the refurbishment of old buildings**

Toothing	Metal cutting area	Wood cutting area
8 TPI	> 8 mm	< 70 mm

Sawblade length [mm]	100	150	200	225	250	290	150	200	225	250	290
Width x Thickness [mm]	19 x 0.90	19 x 1.27									
Code Number	...1101I	...1151I	...1201I	...1221I	...1251I	...1291I	...2151I	...2201I	...2221I	...2251I	...2291I



GUHEMA Bi-lastic SSF...  
GUHEMA Bi-Co-lastic SSM...

- Sharply milled toothing  
• **Special blade for window frame removal**  
• For the quick machining of wood with metal residues  
• For the machining of metal/profiles with a wall thickness > 10 mm

Toothing	Metal cutting area	Wood cutting area
6 TPI	> 10 mm	< 80 mm

Sawblade length [mm]	100	150	200	225	250	290	150	200	225	250	290
Width x Thickness [mm]	19 x 0.90	19 x 1.27									
Code Number	...1101H	...1151H	...1201H	...1221H	...1251H	...1291H	...2151H	...2201H	...2221H	...2251H	...2291H



 GUHEMA Bi-lastic **SSF...**  
 GUHEMA Bi-Co-lastic **SSM...**

-  • Special blade for drywall construction  
 • Plasterboard and dry wood  
 • Also separates metal inclusions

Toothing	Wood cutting area	Mineral cutting area
9 TPI	< 80 mm	Plasterboard

Sawblade length [mm]	100	150	200	225	250	290	150	200	225	250	290
Width x Thickness [mm]	19 x 0.90	19 x 1.27									
Code Number	...1101DZ	...1151DZ	...1201DZ	...1221DZ	...1251DZ	...1291DZ	...2151DZ	...2201DZ	...2221DZ	...2251DZ	...2291DZ



**CV-flex**  
 Made in Germany  
 225 x 19 x 1.27 mm

 GUHEMA CV-flex **SSV...**

-  • Convex cutter ground on both sides  
 • Cuts insulation material quickly and cleanly (mineral wool, styrodur, polystyrene, etc.)  
 • Paper / cardboard  
 • Leather  
 • Rubber  
 • Cuts in both directions (double-sided cutting)

Toothing
Shaft

Sawblade length [mm]	225	300
Width x Thickness [mm]	19 x 1.27	19 x 1.27
Code Number	...2221KD	...2301KD



 GUHEMA CV-flex **SSV...**

-  • Sharply milled toothing  
 • For the machining of hard and soft wood

Toothing	Wood cutting area
3 TPI	< 175 mm

Sawblade length [mm]	225	300
Width x Thickness [mm]	19 x 1.27	19 x 1.27
Code Number	...2221E	...2301E



Toothing	Wood cutting area
3 TPI	< 190 mm

### GUHEMA CV-flex

- Sharpened teeth
- For the aggressive machining of soft and hard wood with extended service life due to hardened teeth

Sawblade length [mm]	240
Width x Thickness [mm]	19 x 1.27
Order No.	SSV2241E



Toothing	Wood cutting area
4 - 5 TPI	< 190 mm

### GUHEMA CV-flex

- Sharpened teeth
- For the quick machining of soft wood with extended service life due to hardened teeth
- Cuts in both directions (double-sided cutting)

Sawblade length [mm]	240
Width x Thickness [mm]	19 x 1.27
Order No.	SSV2241V



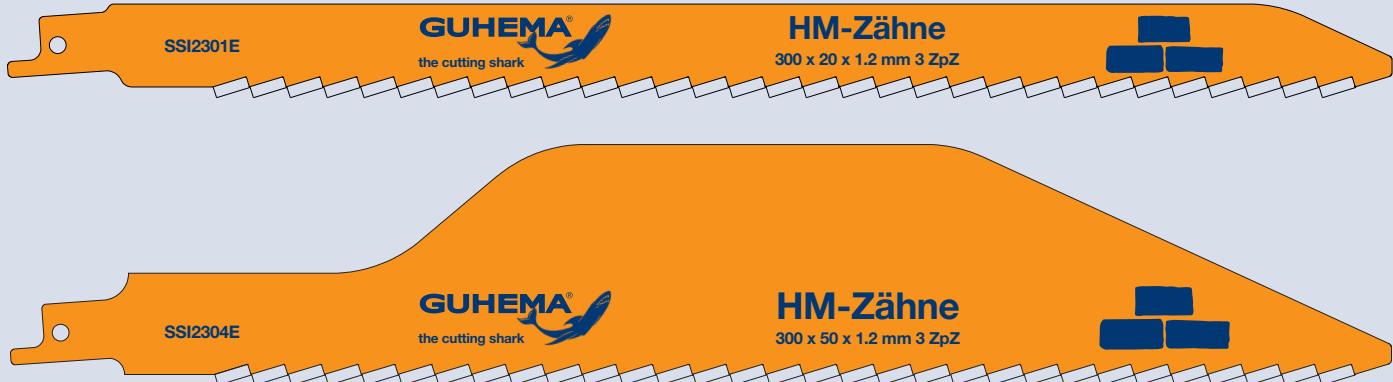
### GUHEMA HM-Teeth SSI...

- Cylindrical hard metal (carbide) toothing
- For cutting aerated concrete and gas concrete

Toothing

1.5 TPI

Sawblade length [mm]	235	300	400	300	450
Width x Thickness [mm]	20 x 1.2	20 x 1.2	20 x 1.2	50 x 1.2	50 x 1.2
Code Number	...2231B	...2301B	...2401B	...2304B	...2454B

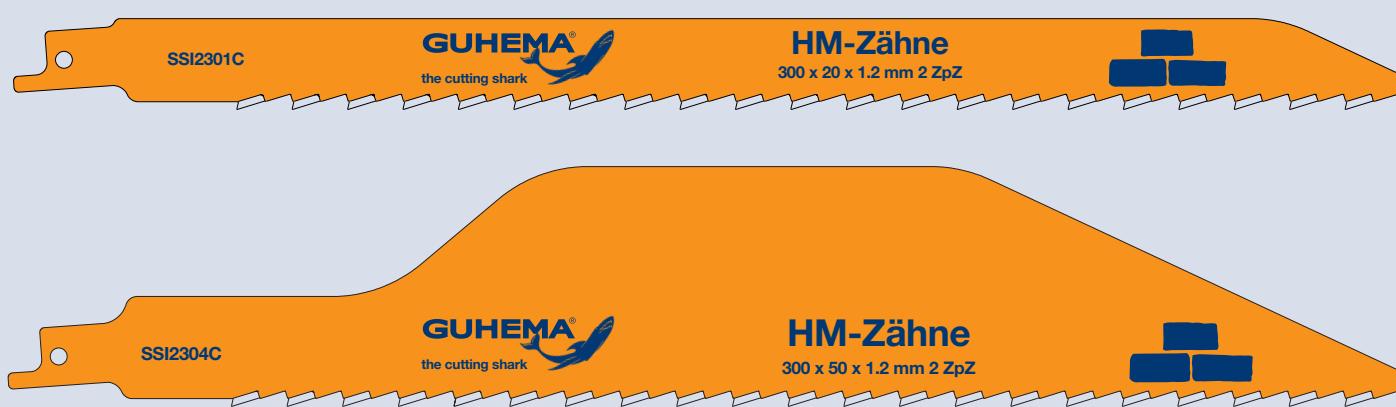

 GUHEMA HM-Teeth SSI...

- 
- Cylindrical hard metal (carbide) toothing
  - For cutting masonry, mortar and bricks
  - Also separates small metal inclusions

Toothing

3 TPI

Sawblade length [mm]	150	235	300	400	300	450
Width x Thickness [mm]	20 x 1.2	20 x 1.2	20 x 1.2	20 x 1.2	50 x 1.2	50 x 1.2
Code Number	...2151E	...2231E	...2301E	...2401E	...2304E	...2454E


 GUHEMA HM-Teeth SSI...

- 
- Rectangular hard metal (carbide) toothing
  - **Construction Site Professional (Allrounder)**
  - For cutting masonry and limestone
  - Also achieves good results when cutting aerated concrete

Toothing

2 TPI

Sawblade length [mm]	150	235	300	400	300	450
Width x Thickness [mm]	20 x 1.2	20 x 1.2	20 x 1.2	20 x 1.2	50 x 1.2	50 x 1.2
Code Number	...2151C	...2231C	...2301C	...2401C	...2304C	...2454C



#### GUHEMA HM-Teeth SSI...

- Rectangular hard metal (carbide) toothing
- For cutting hollow blocks and limestone

Toothing

4 TPI

Sawblade length [mm]	150	235	300	400	300	450
Width x Thickness [mm]	20 x 1.2	20 x 1.2	20 x 1.2	20 x 1.2	50 x 1.2	50 x 1.2
Code Number	...2151G	...2231G	...2301G	...2401G	...2304G	...2454G



#### GUHEMA HM-Teeth SSI...

- Rectangular hard metal (carbide) toothing
- **Construction Site Professional Plus (Allrounder)**
- For cutting masonry and limestone
- Achieves good results when cutting aerated concrete
- Extra strong tooth body for an even straighter cutting path

Toothing

2 TPI

Sawblade length [mm]	235	300	450
Width x Thickness [mm]	40 x 1.2	40 x 1.2	40 x 1.2
Code Number	...2239C	...2309C	...2459C

## Special Sable Sawblades



### GUHEMA Bi-lastic

-  • Sharply milled toothing  
 • For the machining of sheet metal up to 1 mm of thickness  
 • Extra wide and strong sawblade for straight cuts

Toothing	Metal cutting area
32 TPI	< 1 mm

Sawblade length [mm]	150	200	250	290	150	200	250	290
Width x Thickness [mm]	25 x 0.90	25 x 0.90	25 x 0.90	25 x 0.90	25 x 1.27	25 x 1.27	25 x 1.27	25 x 1.27
Order No.:	SRF1152Q	SRF1202Q	SRF1252Q	SRF1292Q	SRF2152Q	SRF2202Q	SRF2252Q	SRF2292Q



### GUHEMA Bi-lastic

-  • Sharply milled toothing  
 • For the machining of sheet metal starting with 1 mm of thickness  
 • Extra wide and strong sawblade for straight cuts

Toothing	Metal cutting area
24 TPI	> 1 mm

Sawblade length [mm]	150	200	250	290	150	200	250	290
Width x Thickness [mm]	25 x 0.90	25 x 0.90	25 x 0.90	25 x 0.90	25 x 1.27	25 x 1.27	25 x 1.27	25 x 1.27
Order No.:	SRF1152P	SRF1202P	SRF1252P	SRF1292P	SRF2152P	SRF2202P	SRF2252P	SRF2292P



### GUHEMA Bi-lastic

- Sharply milled toothing  
 • For the machining of metal/profiles with a wall thickness of 1.5 - 3 mm  
 • Extra wide and strong sawblade for straight cuts

Toothung	Metal cutting area
18 TPI	1.5 - 3 mm

Sawblade length [mm]	150	200	250	290	150	200	250	290
Width x Thickness [mm]	25 x 0.90	25 x 0.90	25 x 0.90	25 x 0.90	25 x 1.27	25 x 1.27	25 x 1.27	25 x 1.27
Order No.:	SRF1152N	SRF1202N	SRF1252N	SRF1292N	SRF2152N	SRF2202N	SRF2252N	SRF2292N



### GUHEMA Bi-lastic

- Sharply milled toothing  
 • For the machining of metal/profiles with a wall thickness of 2 - 4 mm  
 • Extra wide and strong sawblade for straight cuts

Toothung	Metal cutting area
14 TPI	2 - 4 mm

Sawblade length [mm]	150	200	250	290	150	200	250	290
Width x Thickness [mm]	25 x 0.90	25 x 0.90	25 x 0.90	25 x 0.90	25 x 1.27	25 x 1.27	25 x 1.27	25 x 1.27
Order No.:	SRF1152L	SRF1202L	SRF1252L	SRF1292L	SRF2152L	SRF2202L	SRF2252L	SRF2292L



### GUHEMA Bi-lastic

- For the machining of metal/profiles with a wall thickness of 4 - 12 mm  
 • For the machining of wood with metal residues and a clean cutting line  
 • Extra wide and strong sawblade for straight cuts

Toothung	Metal cutting area	Wood cutting area
10 TPI	4 - 12 mm	< 60 mm

Sawblade length [mm]	150	200	250	290	150	200	250	290
Width x Thickness [mm]	25 x 0.90	25 x 0.90	25 x 0.90	25 x 0.90	25 x 1.27	25 x 1.27	25 x 1.27	25 x 1.27
Order No.:	SRF1152J	SRF1202J	SRF1252J	SRF1292J	SRF2152J	SRF2202J	SRF2252J	SRF2292J



**Bi-lastic**  
Made in Germany  
200 x 25 x 0.9 mm 8 ZpZ



> 8 mm

### GUHEMA Bi-lastic

- Sharply milled toothing
- For the machining of metal/profiles with a wall thickness > 8 mm
- For the machining of wood with metal residues
- Special blade for the refurbishment of old buildings
- Extra wide and strong sawblade for straight cuts

Toothing	Metal cutting area	Wood cutting area
8 TPI	> 8 mm	< 70 mm

Sawblade length [mm]	150	200	250	290	150	200	250	290
Width x Thickness [mm]	25 x 0.90	25 x 0.90	25 x 0.90	25 x 0.90	25 x 1.27	25 x 1.27	25 x 1.27	25 x 1.27
Order No.:	SRF1152I	SRF1202I	SRF1252I	SRF1292I	SRF2152I	SRF2202I	SRF2252I	SRF2292I



**Bi-lastic**  
Made in Germany  
200 x 25 x 0.9 mm 6 ZpZ



> 10 mm

### GUHEMA Bi-lastic

- Sharply milled toothing
- Special blade for window frame removal
- For the quick machining of wood with metal residues
- For the machining of metal/profiles with a wall thickness > 10 mm
- Extra wide and strong sawblade for straight cuts

Toothing	Metal cutting area	Wood cutting area
6 TPI	> 10 mm	< 80 mm

Sawblade length [mm]	150	200	250	290	150	200	250	290
Width x Thickness [mm]	25 x 0.90	25 x 0.90	25 x 0.90	25 x 0.90	25 x 1.27	25 x 1.27	25 x 1.27	25 x 1.27
Order No.:	SRF1152H	SRF1202H	SRF1252H	SRF1292H	SRF2152H	SRF2202H	SRF2252H	SRF2292H

# Special Sable Sawblades



## GUHEMA Bi-lastic

- Sharply milled toothing  
• For the machining of sheet metal up to 1 mm of thickness  
• Extra wide and strong sawblade for straight cuts

Toothing	Metal cutting area
32 TPI	< 1 mm

Sawblade length [mm]	150	210	235	260	300	150	210	235	260	300
Width x Thickness [mm]	25 x 0.90	25 x 1.27								
Order No.:	SFF1152Q	SFF1212Q	SFF1232Q	SFF1262Q	SFF1302Q	SFF2152Q	SFF2212Q	SFF2232Q	SFF2262Q	SFF2302Q



## GUHEMA Bi-lastic

- Sharply milled toothing  
• For the machining of sheet metal starting with 1 mm of thickness  
• Extra wide and strong sawblade for straight cuts

Toothing	Metal cutting area
24 TPI	> 1 mm

Sawblade length [mm]	150	210	235	260	300	150	210	235	260	300
Width x Thickness [mm]	25 x 0.90	25 x 1.27								
Order No.:	SFF1152P	SFF1212P	SFF1232P	SFF1262P	SFF1302P	SFF2152P	SFF2212P	SFF2232P	SFF2262P	SFF2302P

SFF1212N


**Bi-lastic**  
 Made in Germany  
 210 x 25 x 0.9 mm 18 ZpZ


1,5 - 3 mm

 GUHEMA Bi-lastic

- 
- Sharply milled toothing
  - For the machining of metal/profiles with a wall thickness of 1.5 - 3 mm
  - Extra wide and strong sawblade for straight cuts

Toothing

Metal cutting area

18 TPI

1.5 - 3 mm

Sawblade length [mm]	150	210	235	260	300	150	210	235	260	300
Width x Thickness [mm]	25 x 0.90	25 x 1.27								
Order No.:	SFF1152N	SFF1212N	SFF1232N	SFF1262N	SFF1302N	SFF2152N	SFF2212N	SFF2232N	SFF2262N	SFF2302N

SFF1212L


**Bi-lastic**  
 Made in Germany  
 210 x 25 x 0.9 mm 14 ZpZ


2 - 4 mm

 GUHEMA Bi-lastic

- 
- Sharply milled toothing
  - For the machining of metal/profiles with a wall thickness of 2 - 4 mm
  - Extra wide and strong sawblade for straight cuts

Toothing

Metal cutting area

14 TPI

2 - 4 mm

Sawblade length [mm]	150	210	235	260	300	150	210	235	260	300
Width x Thickness [mm]	25 x 0.90	25 x 1.27								
Order No.:	SFF1152L	SFF1212L	SFF1232L	SFF1262L	SFF1302L	SFF2152L	SFF2212L	SFF2232L	SFF2262L	SFF2302L

SFF1212J


**Bi-lastic**  
 Made in Germany  
 210 x 25 x 0.9 mm 10 ZpZ


4 - 12 mm

 GUHEMA Bi-lastic

- 
- For the machining of metal/profiles with a wall thickness of 4 - 12 mm
  - For the machining of wood with metal residues and a clean cutting line
  - Extra wide and strong sawblade for straight cuts

Toothing

Metal cutting area

Wood cutting area

10 TPI

4 - 12 mm

&lt; 60 mm

Sawblade length [mm]	150	210	235	260	300	150	210	235	260	300
Width x Thickness [mm]	25 x 0.90	25 x 1.27								
Order No.:	SFF1152J	SFF1212J	SFF1232J	SFF1262J	SFF1302J	SFF2152J	SFF2212J	SFF2232J	SFF2262J	SFF2302J



### GUHEMA Bi-lastic



- Sharply milled toothing
- For the machining of metal/profiles with a wall thickness > 8 mm
- For the machining of wood with metal residues
- Extra wide and strong sawblade for straight cuts

Toothung	Metal cutting area	Wood cutting area
8 TPI	> 8 mm	< 70 mm

Sawblade length [mm]	150	210	235	260	300	150	210	235	260	300
Width x Thickness [mm]	25 x 0.90	25 x 1.27								
Order No.:	SFF1152I	SFF1212I	SFF1232I	SFF1262I	SFF1302I	SFF2152I	SFF2212I	SFF2232I	SFF2262I	SFF2302I



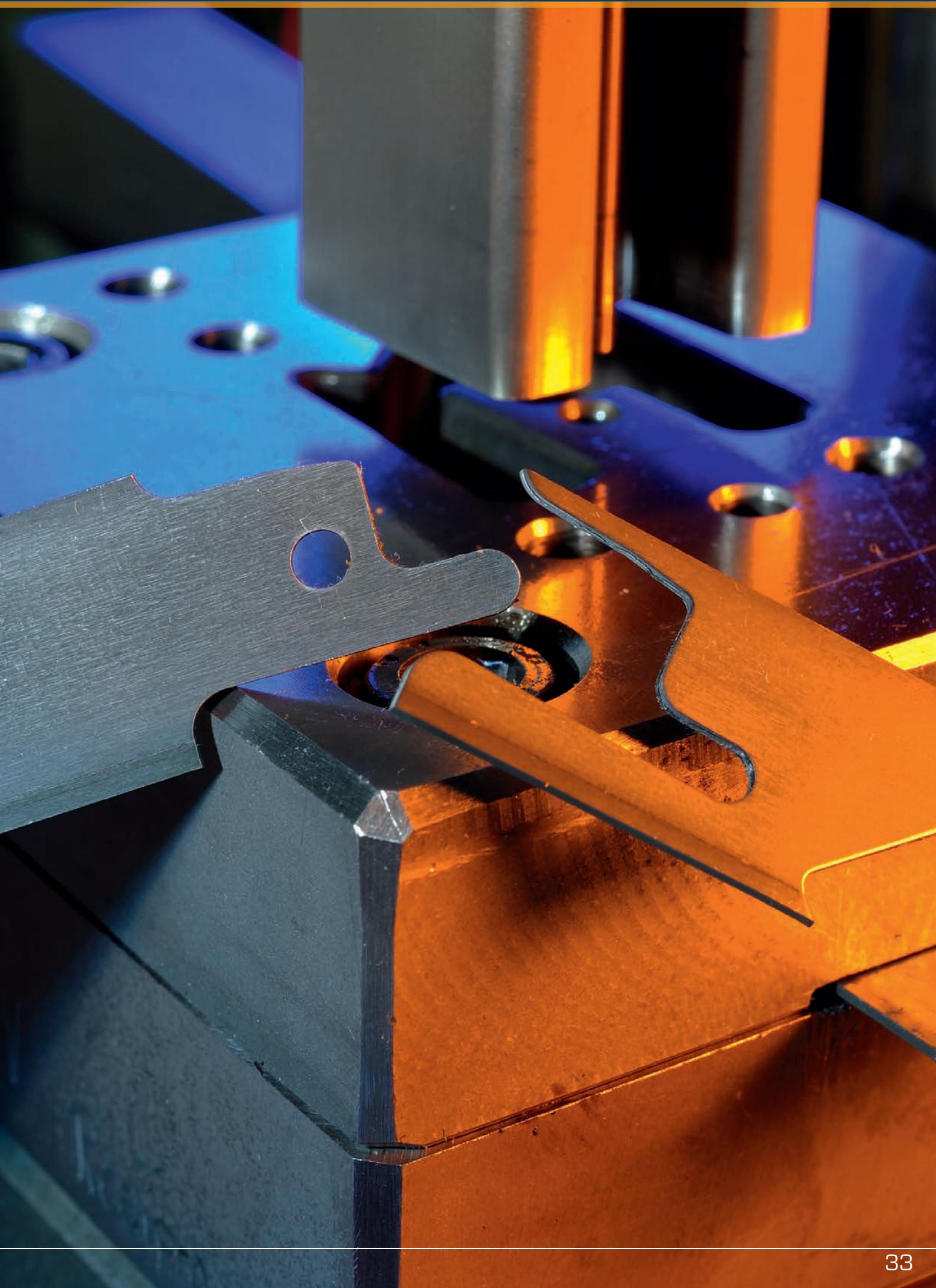
### GUHEMA Bi-lastic

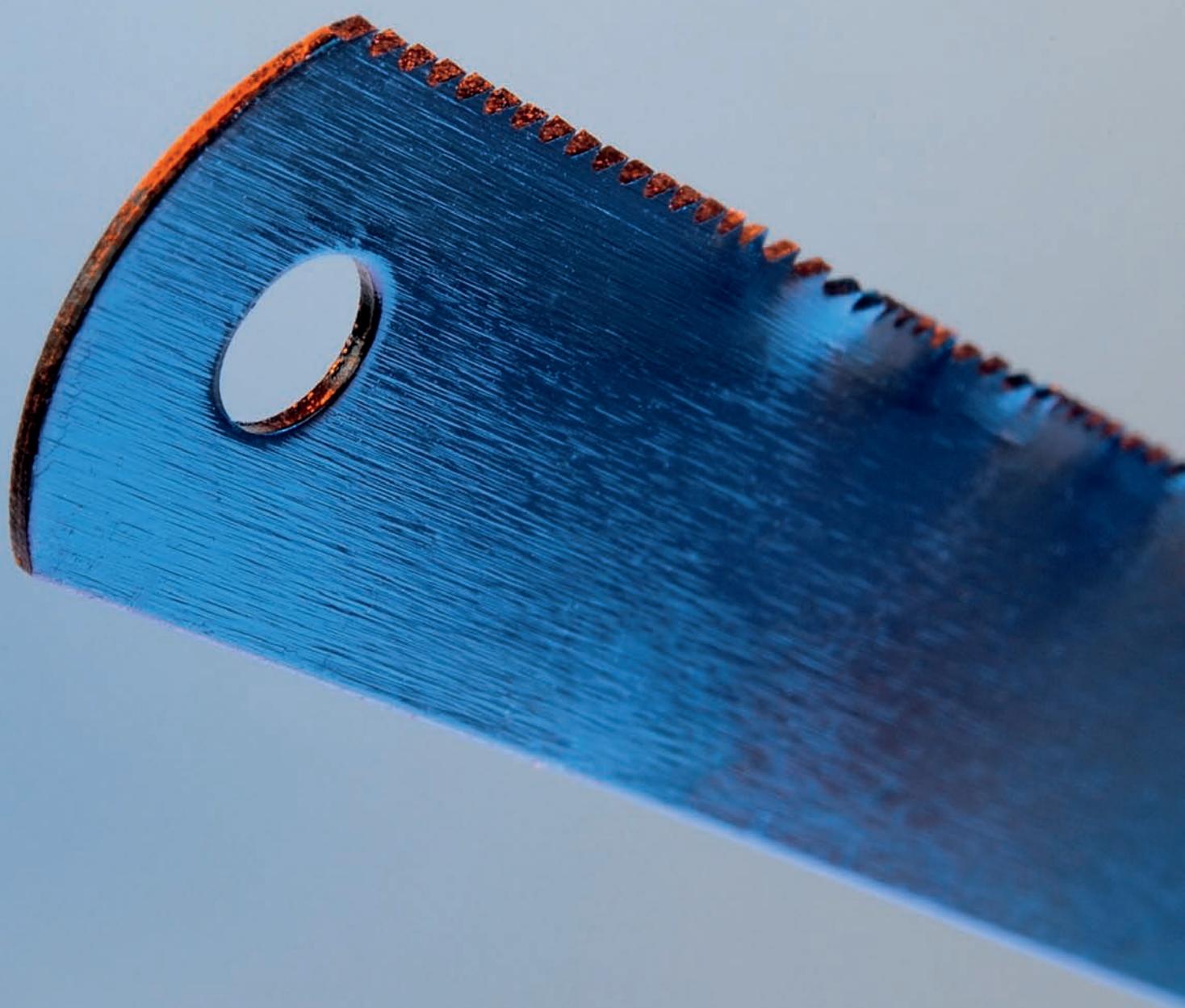


- Sharply milled toothing
- For the quick machining of wood with metal residues
- For the machining of metal/profiles with a wall thickness > 10 mm
- Extra wide and strong sawblade for straight cuts

Toothung	Metal cutting area	Wood cutting area
6 TPI	> 10 mm	< 80 mm

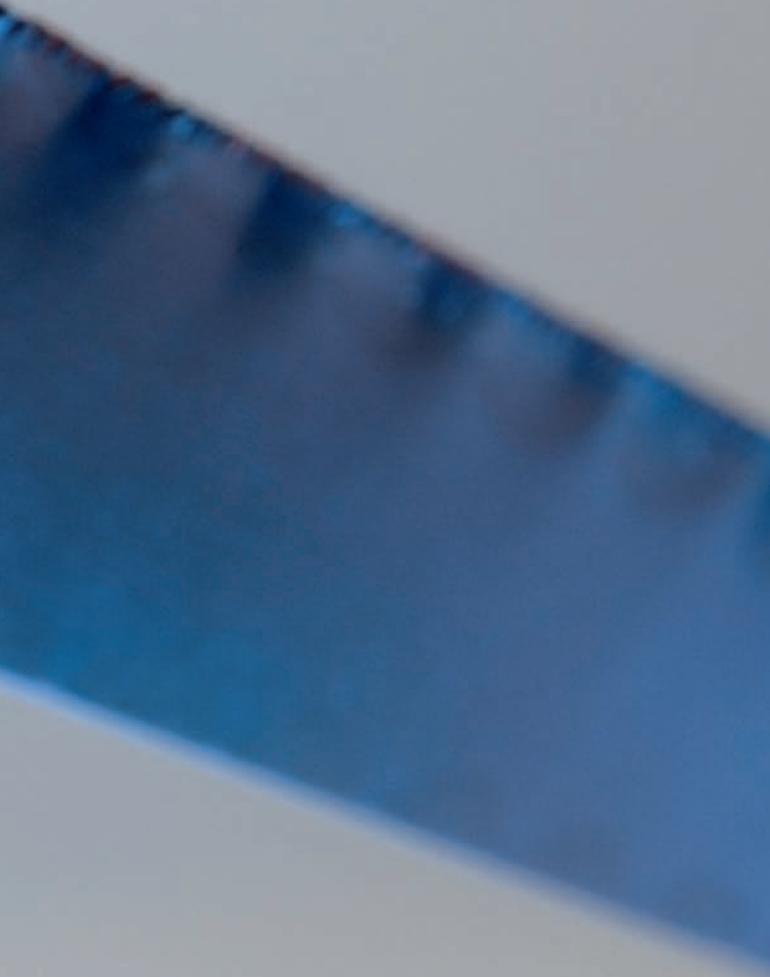
Sawblade length [mm]	150	210	235	260	300	150	210	235	260	300
Width x Thickness [mm]	25 x 0.90	25 x 1.27								
Order No.:	SFF1152H	SFF1212H	SFF1232H	SFF1262H	SFF1302H	SFF2152H	SFF2212H	SFF2232H	SFF2262H	SFF2302H





# Hand Hack-saw Blades

GUHEMA hand hacksaw blades stand for the highest quality due to their precision, reliability and high fracture resistance – as can be expected from a product MADE IN GERMANY.



# Hand Hacksaw Blades

## Hand Hacksaw Blades made of bi-metal

→ 12"/32 ZpZ  
Made in Germany

GUHEMA

**Bi-lastic**

bruchsicher

ARTIKEL  
ASF0300Q

 GUHEMA Bi-lastic [ASF...](#)  
 GUHEMA Bi-Co-lastic [ASM...](#)

- Sharply milled toothing
- Professional blade with "memory effect", which is unparalleled worldwide!
- Hardened to the point as part of a high-vacuum hardening process for maximum service life
- The hand hacksaw blade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Code Number	Toothing	Dimensions	Metal cutting area
...0300Q	32 TPI	300x13x0.6 mm	< 0.8 mm

→ 12"/24 ZpZ  
Made in Germany

GUHEMA

**Bi-lastic**

bruchsicher

ARTIKEL  
ASF0300P

 GUHEMA Bi-lastic [ASF...](#)  
 GUHEMA Bi-Co-lastic [ASM...](#)

- Sharply milled toothing
- Professional blade with "memory effect", which is unparalleled worldwide!
- Hardened to the point as part of a high-vacuum hardening process for maximum service life
- The hand hacksaw blade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Code Number	Toothing	Dimensions	Cutting area Metal
...0300P	24 TPI	300x13x0.6 mm	0.8 - 1.5 mm

→ 12"/22 ZpZ  
Made in Germany

GUHEMA

**Bi-lastic**

bruchsicher

ARTIKEL  
ASF03000

 GUHEMA Bi-lastic [ASF...](#)  
 GUHEMA Bi-Co-lastic [ASM...](#)

- Sharply milled toothing
- Professional blade with "memory effect", which is unparalleled worldwide!
- Hardened to the point as part of a high-vacuum hardening process for maximum service life
- The hand hacksaw blade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Code Number	Toothing	Dimensions	Cutting area Metal
...03000	22 TPI	300x13x0.6 mm	1 - 1.5 mm

→ 12°/18 ZpZ  
Made in Germany



## Bi-lastic

bruchsicher

ARTIKEL  
ASF0300N



GUHEMA Bi-lastic [ASF...](#)  
GUHEMA Bi-Co-lastic [ASM...](#)



- Sharply milled toothing
- Professional blade with "memory effect", which is unparalleled worldwide!
- Hardened to the point as part of a high-vacuum hardening process for maximum service life
- The hand hacksaw blade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Code Number	Toothing	Dimensions	Cutting area Metal
...0300N	18 TPI	300x13x0.6 mm	1.5 - 3.5 mm

→ 12°/18-32 ZpZ  
Made in Germany



## Bi-lastic

bruchsicher

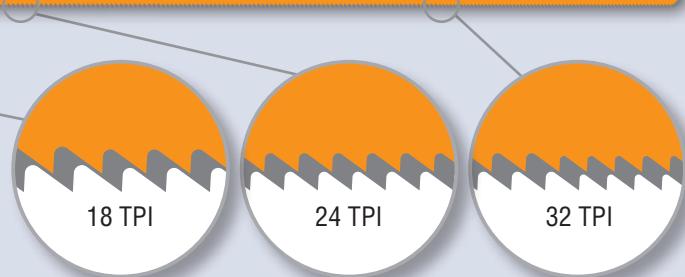
ARTIKEL  
ASF0300B



GUHEMA Bi-lastic [ASF...](#)  
GUHEMA Bi-Co-lastic [ASM...](#)



- Sharply milled progressive toothing
- Professional blade with "memory effect", which is unparalleled worldwide!
- Hardened to the point as part of a high-vacuum hardening process for maximum service life
- The hand hacksaw blade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>
- The progressive toothing is especially suitable for use as a universal blade while also facilitating the starts of sawing processes



Code Number	Toothing	Dimensions	Metal cutting area
...0300B	18 - 32 TPI	300x13x0.6 mm	1.5 - 3.5 mm

→ 12°/22/32 ZpZ  
Made in Germany



## Bi-lastic

bruchsicher

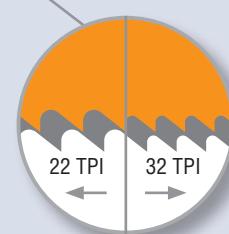
ARTIKEL  
ASF0300R



GUHEMA Bi-lastic [ASF...](#)  
GUHEMA Bi-Co-lastic [ASM...](#)



- Sharply milled first cut toothing
- Professional blade with "memory effect", which is unparalleled worldwide!
- Hardened to the point as part of a high-vacuum hardening process for maximum service life
- The hand hacksaw blade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>
- The first cut toothing facilitates the starting of sawing processes and reduces the risk of slipping off the cutting point



Code Number	Toothing	Dimensions	Cutting area Metal
...0300R	22/32 TPI	300x13x0.6 mm	1 - 1.5 mm

## Hand Hacksaw Blades made of high-speed steel

→ 12"/32 ZpZ  
Made in Germany



H.S.S. flex-allhard

ARTIKEL  
ASA0300Q

### GUHEMA H.S.S. flex-allhard

- Sharply milled toothing  
• Thoroughly hardened, for a maximum service life  
• Professional blade for easily machinable materials with a tensile strength of up to 900 N/mm<sup>2</sup>

Order No.	Toothing	Dimensions	Metal cutting area
ASA0300Q	32 TPI	300x13x0.6 mm	< 0.8 mm

→ 12"/24 ZpZ  
Made in Germany



H.S.S. flex-allhard

ARTIKEL  
ASA0300P

### GUHEMA H.S.S. flex-allhard

- Sharply milled toothing  
• Thoroughly hardened, for a maximum service life  
• Professional blade for materials that are difficult to machine with a tensile strength of up to 900 N/mm<sup>2</sup>

Order No.	Toothing	Dimensions	Metal cutting area
ASA0300P	24 TPI	300x13x0.6 mm	0.8 - 1.5 mm

→ 12"/18 ZpZ  
Made in Germany



H.S.S. flex-allhard

ARTIKEL  
ASA0300N

### GUHEMA H.S.S. flex-allhard

- Sharply milled toothing  
• Thoroughly hardened, for a maximum service life  
• Professional blade for materials that are difficult to machine with a tensile strength of up to 900 N/mm<sup>2</sup>

Order No.	Toothing	Dimensions	Metal cutting area
ASA0300N	18 TPI	300x13x0.6 mm	1.5 - 3.5 mm

→ 12"/32 ZpZ  
Made in Germany



**H.S.S.-flex**

ARTIKEL  
ASA0300QZ

 GUHEMA H.S.S.-flex

-  • Sharply milled toothing  
 • 3-zone hardening in an inductive machine, minimizes blade breakage.  
 • For workshop use with easily machinable materials of a tensile strength of up to 700 N/mm<sup>2</sup>

Order No.	Toothing	Dimensions	Metal cutting area
ASA0300QZ	32 TPI	300x13x0.6 mm	< 0.8 mm

→ 12"/24 ZpZ  
Made in Germany



**H.S.S.-flex**

ARTIKEL  
ASA0300PZ

 GUHEMA H.S.S.-flex

-  • Sharply milled toothing  
 • 3-zone hardening in an inductive machine, minimizes blade breakage.  
 • For workshop use with easily machinable materials of a tensile strength of up to 700 N/mm<sup>2</sup>

Order No.	Toothing	Dimensions	Metal cutting area
ASA0300PZ	24 TPI	300x13x0.6 mm	0.8 - 1.5 mm

→ 12"/18 ZpZ  
Made in Germany



**H.S.S.-flex**

ARTIKEL  
ASA0300NZ

 GUHEMA H.S.S.-flex

-  • Sharply milled toothing  
 • 3-zone hardening in an inductive machine, minimizes blade breakage.  
 • For workshop use with easily machinable materials of a tensile strength of up to 700 N/mm<sup>2</sup>

Order No.	Toothing	Dimensions	Metal cutting area
ASA0300NZ	18 TPI	300x13x0.6 mm	0.8 - 3.5 mm

## Hand Hacksaw Blades made of carbon steel

→ 12"/32 ZpZ      GUHEMA      CV-flex      ARTIKEL ASV0300Q

 GUHEMA CV-flex

 • Sharply milled toothing  
• 3-zone hardening in an inductive machine  
• For soft metals and plastics

Order No.	Toothng	Dimensions	Metal cutting area
ASV0300Q	32 TPI	300x13x0.6 mm	< 0.8 mm

→ 12"/24 ZpZ      GUHEMA      CV-flex      ARTIKEL ASV0300P

 GUHEMA CV-flex

 • Sharply milled toothing  
• 3-zone hardening in an inductive machine, minimizes blade breakage.  
• For soft metals and plastics

Order No.	Toothng	Dimensions	Metal cutting area
ASV0300P	24 TPI	300x13x0.6 mm	0.8 - 1.5 mm

→ 12"/18 ZpZ      GUHEMA      CV-flex      ARTIKEL ASV0300N

 GUHEMA CV-flex

 • Sharply milled toothing  
• 3-zone hardening in an inductive machine, minimizes blade breakage.  
• For soft metals and plastics

Order No.	Toothng	Dimensions	Metal cutting area
ASV0300N	18 TPI	300x13x0.6 mm	1.5 - 3.5 mm

## Double-edged hand hacksaw blades

→ 12°/24 ZpZ  
Made in Germany

**GUHEMA**

**Bi-lastic**

bruchsicher

**ARTIKEL**  
**ASF0302P**

### GUHEMA Bi-lastic

- Sharply milled toothing
- Professional blade, which is unparalleled worldwide!
- Hardened to the point as part of a high-vacuum hardening process for maximum service life
- The hand hacksaw blade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Order No.	Toothing	Dimensions	Metal cutting area
ASF0302P	24 TPI	300x25x0.6 mm	0.8 - 1.5 mm

→ 12°/22/32 ZpZ  
Made in Germany

**GUHEMA**

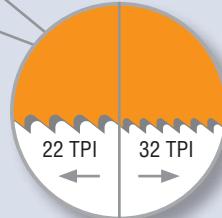
**Bi-lastic**

bruchsicher

**ARTIKEL**  
**ASF0302R**

### GUHEMA Bi-lastic

- Sharply milled toothing
- Professional blade, which is unparalleled worldwide!
- Hardened to the point as part of a high-vacuum hardening process for maximum service life
- The hand hacksaw blade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>
- The first cut toothing facilitates the starting of sawing processes and reduces the risk of slipping off the cutting point



Order No.	Toothing	Dimensions	Metal cutting area
ASF0302R	22/32 TPI	300x25x0.6 mm	1 - 1.5 mm

→ 12°/24 ZpZ  
Made in Germany

**GUHEMA**

**H.S.S. flex-allhard**

**ARTIKEL**  
**ASA1302P**

### GUHEMA H.S.S. flex-allhard

- Sharply milled toothing
- Thoroughly hardened, for a maximum service life
- Professional blade for easily machinable materials with a tensile strength of up to 900 N/mm<sup>2</sup>

Order No.	Toothing	Dimensions	Metal cutting area
ASA1302P	24 TPI	300x25x0.7 mm	0.8 - 1.5 mm

→ 12°/24 ZpZ

**GUHEMA**

**CV-flex**

**ARTIKEL**  
**ASV1302P**

### GUHEMA CV-flex

- Sharply milled toothing
- 3-zone hardening in an inductive machine, minimizes blade breakage.
- For soft metals and plastics

Order No.	Toothing	Dimensions	Metal cutting area
ASV1302P	24 TPI	300x25x0.8 mm	0.8 - 1.5 mm

# Metal Handsaw Bow



Order No.:

ASB3FM

## GUHEMA ASB

- The fibreglass-reinforced 2-component plastic handle fits perfectly in your hand
- The powder-coated, rectangular saw bow serves as a bladesaw magazine
- The sawblade can be clamped in while rotated by 90°
- Clamping key integrated into the handle shortens the saw bow to 400 mm

**Includes 1 GUHEMA bi-metal handsaw blade with 24 TPI (ASF0300P)**



Order No.:

ASB3FW

## GUHEMA ASB

- The fibreglass-reinforced 2-component plastic handle fits perfectly in your hand
- The powder-coated, rectangular saw bow serves as a bladesaw magazine
- The sawblade can be clamped in while rotated by 90°

**Includes 1 GUHEMA bi-metal handsaw blade with 24 TPI (ASF0300P)**



Order No.:

ASB3NS

## GUHEMA ASB

- Classic metal saw bow with wooden handle
- Powder-coated, rectangular tube
- The sawblade can be clamped in while rotated by 90°

**Includes 1 GUHEMA bi-metal handsaw blade with 24 TPI (ASF0300P)**





## Hole Saws



Steel, wood, aluminium, cast iron, plastics, non-ferrous metals, stainless steel thicker than 1 mm or fibreboards can be punctured by our saws in order to gain the perfect "look through". Our product range supports your undertakings with standards diameters from 14 to 210 mm.

# Hole Saws

## Materials, qualities and application areas

Precision, the result of our solid cover plate, long tool life and quiet operation, made possible by the variable toothing with its optimal chip removal - all these features distinguish our bi-metal hole saws. Our fine-toothed hole saws are ideal for thin-walled materials. Our hard-metal coated hole saws achieve the best results when it comes to mineral and composite materials. Our product range leaves no wish unsatisfied.



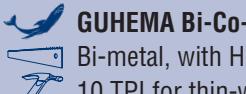
### GUHEMA Bi-Co-lastic HSM...

Bi-metal, with HSS cutter made of M42 (Material No. 1.3247)  
4/6 TPI, the "All-Rounder"

The fast path to our Article No.

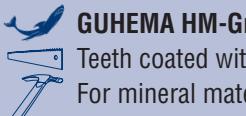
Grade + Ø + TPI

Example: HSM + 014 + V = HSM014V



### GUHEMA Bi-Co-lastic HSM...

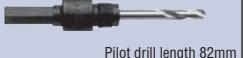
Bi-metal, with HSS cutter made of M42 (Material No. 1.3247)  
10 TPI for thin-walled material



### GUHEMA HM-Granulate HSH...

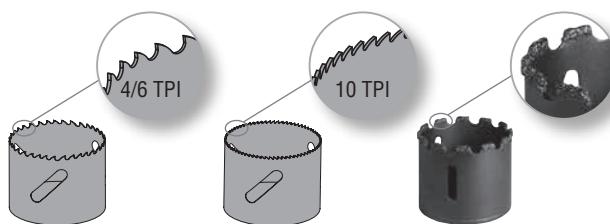
Teeth coated with carbide grit  
For mineral materials

## Centering units

Mounting shank	Hole saw 14 - 30 mm	Order No.	Hole saw 32 - 210 mm	Order No.
Round 6 mm	 Pilot drill length 82mm	HZARW6		
Hexagon 9.5 mm	 Pilot drill length 82mm	HZASW95	 Pilot drill length 82mm	HZASW95A
Hexagon 11 mm	 Pilot drill length 82mm	HZASW11	 Pilot drill length 82mm	HZASW11A
SDS mounting	 Pilot drill length 82mm	HZASDS1	 Pilot drill length 82mm	HZASDS2

## Accessories / Spare Parts

		Order No.
Extension for 11 mm hexagonal mounting		HZBV11
Ejection spring		HZBF
Allen screw		HZBS
Adapter used to fit the mountings for hole saws with 32-210 mm of diameter to a 14 to 30 mm hole saw		HZBA
Pilot drill 82 mm		HZBB82
Pilot drill 102 mm		HZBB102



$\varnothing$ in mm	Bi-Co-lastic 4/6 TPI ...V	Bi-Co-lastic 10 TPI ...J	HM-Granulate ...S
14	•		
16	•	•	•
17	•	•	
19	•	•	
20	•	•	•
21	•	•	
22	•	•	
23	•	•	
24	•	•	
25	•	•	•
27	•	•	
29	•	•	
30	•	•	
32	•	•	•
33	•		
35	•	•	
37	•		
38	•	•	
40	•	•	
41	•		
43	•		
44	•	•	•
46	•	•	
48	•	•	
51	•	•	•
52	•		
54	•	•	•
56	•		
57	•	•	
58	•		
59	•		

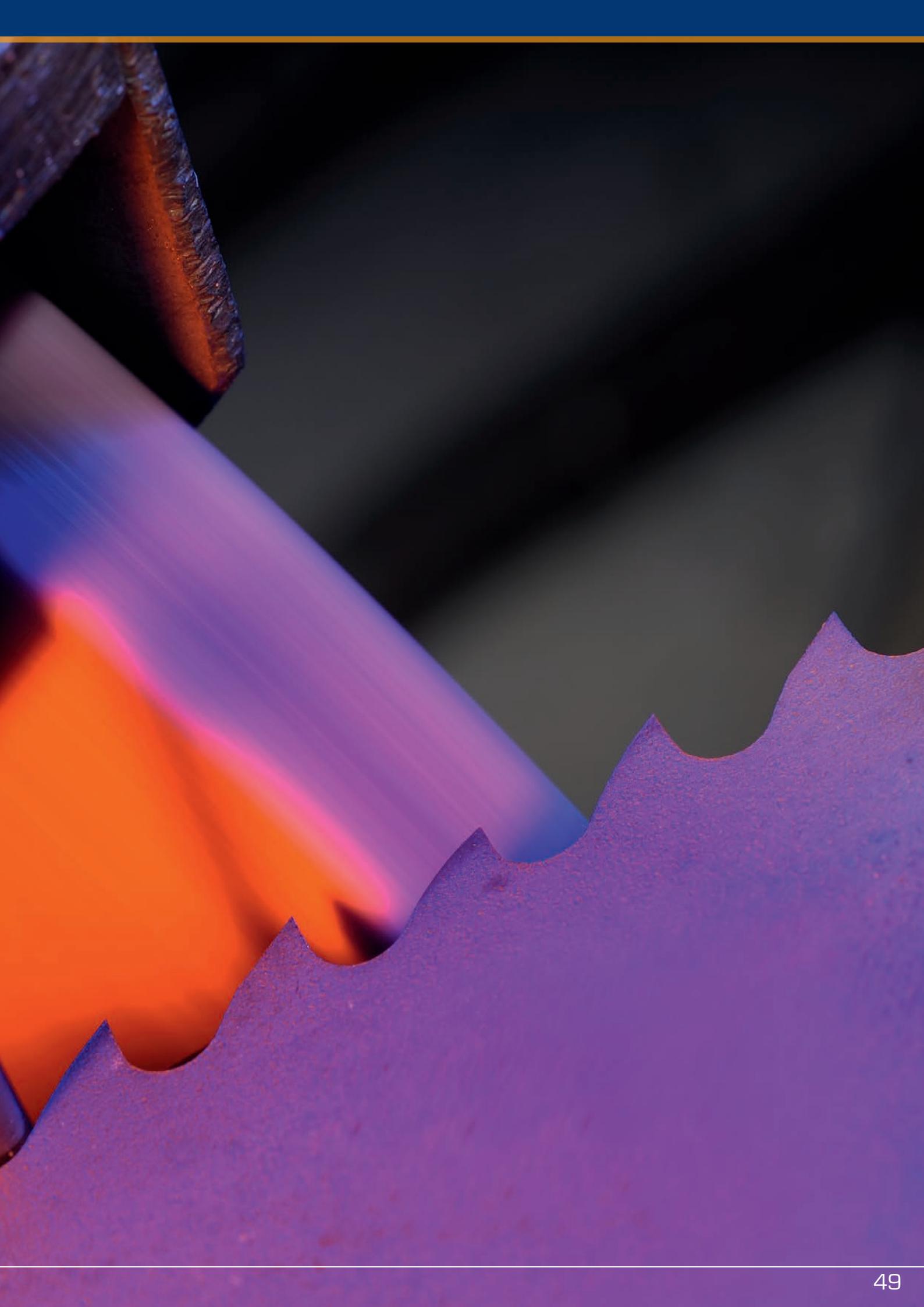
$\varnothing$ in mm	Bi-Co-lastic 4/6 TPI ...V	Bi-Co-lastic 10 TPI ...J	HM-Granulate ...S
60	•		•
64	•		•
65	•		•
67	•		
68	•		•
70	•		•
73	•		•
76	•		
79	•		
83	•		•
86	•		
89	•		
92	•		
95	•		
98	•		
102	•		•
105	•		•
108	•		
111	•		
114	•		
121	•		
127	•		•
133	•		
140	•		
146	•		
152	•		
160	•		
168	•		
177	•		
200	•		
210	•		

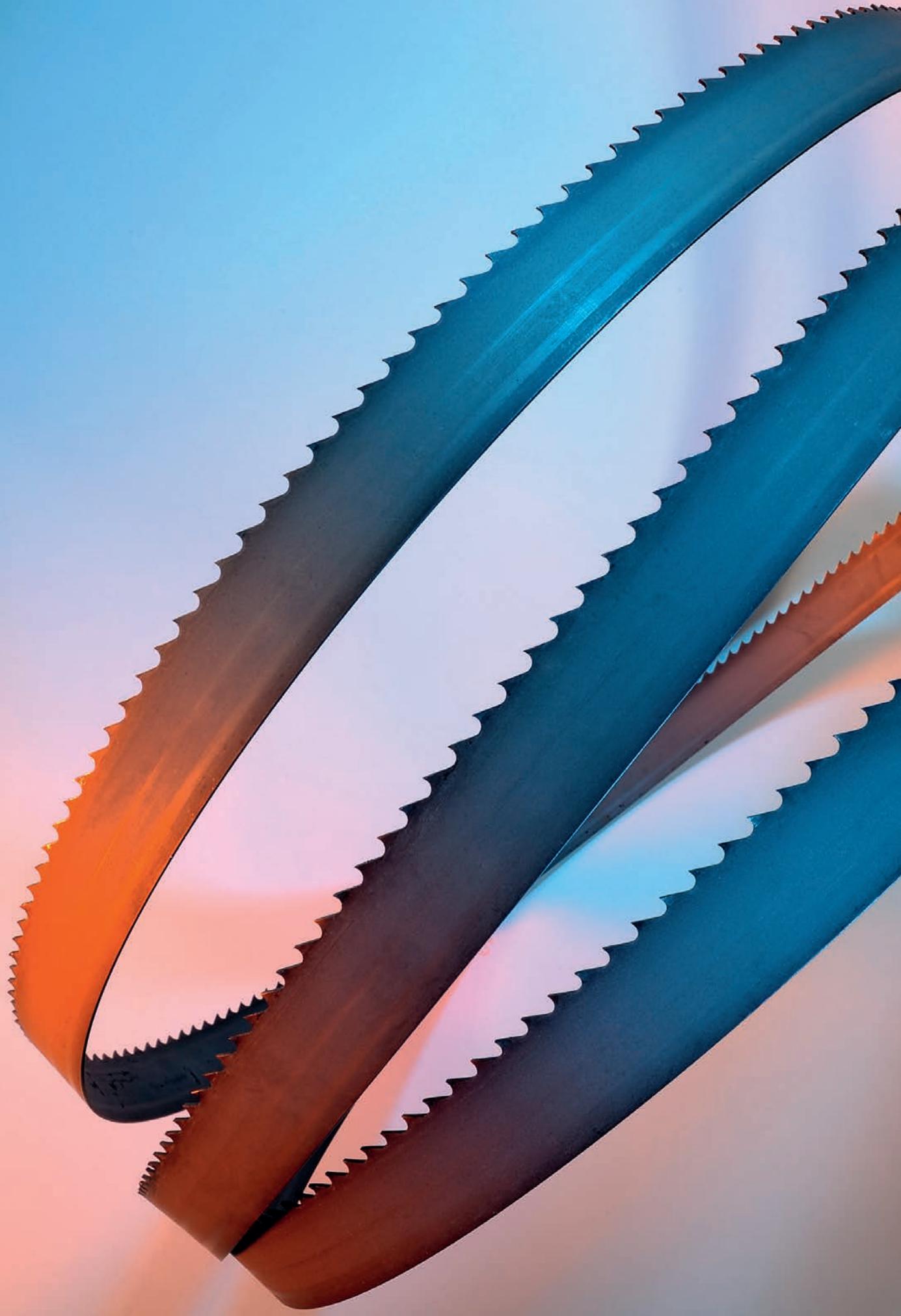
• = available toothing

## Our recommendations for a long service life

Please adjust your number of revolutions in accordance with the following recommendations in order to optimize the tool life of your hole saw and the cutting quality. Please do not forget the permanent cooling of the hole saw during the cutting process either.

Ø	NIRO	Cast iron	Steel	Non-ferrous metals	ALU-MINIUM	Ø	NIRO	Cast iron	Steel	Non-ferrous metals	ALU-MINIUM
14	300	400	580	790	900	70	60	80	125	160	185
16	275	365	550	730	825	73	60	80	120	160	180
17	250	330	500	665	750	76	55	75	115	150	170
19	230	300	460	600	690	79	55	70	110	140	165
20	220	290	440	580	670	83	50	70	105	140	155
21	210	280	425	560	630	86	50	65	100	130	150
22	195	260	390	520	585	89	45	65	95	130	145
23	195	260	390	520	570	92	45	60	95	120	140
24	185	245	370	495	555	95	45	60	90	120	135
25	175	235	350	470	525	98	45	60	90	120	135
27	160	215	325	435	480	102	40	55	85	110	130
29	150	200	300	400	450	105	40	55	80	110	120
30	145	190	285	380	425	108	40	55	80	110	120
32	140	180	275	360	410	111	40	50	80	100	120
33	135	175	268	345	390	114	35	50	75	100	105
35	125	165	250	330	375	121	35	45	70	90	95
37	120	160	240	315	360	127	30	40	65	85	90
38	120	160	240	315	360	133	30	40	65	85	90
40	110	145	220	290	330	140	30	35	65	80	85
41	105	140	210	280	315	146	30	35	60	80	85
43	100	135	205	270	305	152	25	35	55	75	85
44	95	130	195	250	295	160	25	35	55	75	85
46	95	125	190	250	285	168	25	35	55	75	85
48	90	120	180	240	270	177	20	30	50	70	80
51	85	115	170	230	255	200	20	30	50	70	80
52	80	110	165	220	245	210	20	30	45	70	80
54	80	105	160	210	240						
56	75	100	160	200	225						
57	75	100	150	200	225						
58	75	100	145	195	225						
59	75	100	145	195	225						
60	70	95	140	190	220						
64	65	90	135	180	205						
65	65	85	130	175	200						
67	65	85	130	170	195						
68	65	85	130	170	195						





# Metal Band-saw Blades

We guarantee that when purchasing a band-saw blade that bears the GUHEMA brand name, you will receive a state-of-the-art piece of machining technology. We also guarantee the adequate use pertaining to your production flow and a long tool life of bandsaw blade and machine, even if used permanently and in a heavy-duty fashion.



# Metal Bandsaw Blades

We produce three versions of metal bandsaw blades for you. The "carbon" grade for workshops, the bi-metal grade for workshops and manufacturing purposes as well as the hard metal variant for special applications.

True to the motto:

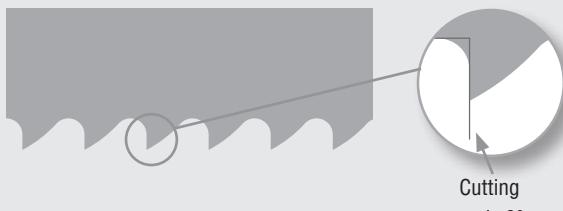
We deliver the metal bandsaw blades that will lead to the optimal sawing result in accordance with your specific requirements.

**Trust in our machining technology, if you wish to cut materials in an optimal manner**

In order to meet every one of your requirements, we have provided our material grades with the necessary range of tooth types:

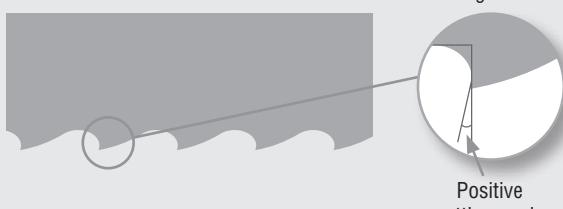
## Standard tooth (S)

This tooth geometry is provided with our No. 20 GUHEMA Kristall, No. 22 GUHEMA Kristall plus and No. 35 GUHEMA Bi-Co-lastic grades. This geometry is ideal for universal, general purpose use.



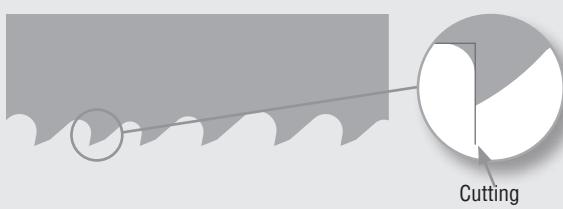
## Hook tooth (K)

This tooth geometry is available for our No. 20 GUHEMA Kristall, No. 22 GUHEMA Kristall plus and No. 35 GUHEMA Bi-Co-lastic grades. The areas of application of this geometry are the austenitic and stainless steels.



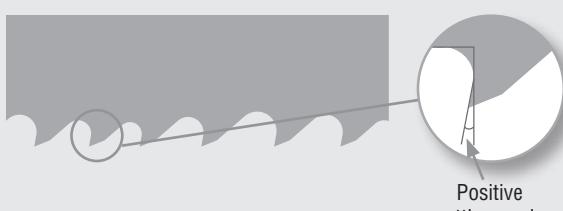
## Variable toothing (V)

The variable toothing is provided with the No. 35V GUHEMA Bi-Co-lastic grade. This V-tooth leads to an especially low-vibration cut and is suitable for bundle cutting as well as for solid materials. As the area of application for the metal bandsaw blades with V-toothing becomes significantly larger, the band changing times that would otherwise be necessary are prevented and thus the downtimes of the machine decrease. The reduced noise level at the workplace is a side effect of the variable toothing that is often praised by the workforce.



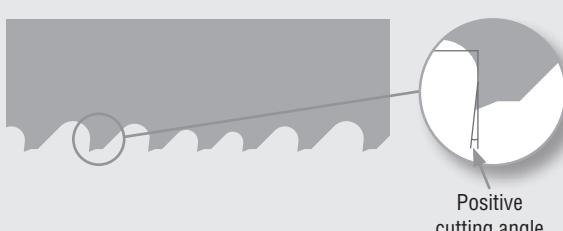
## Variable positive toothing (VP)

The VP-tooth is provided with the No. 35VP GUHEMA Bi-Co-lastic and No. 36VP GUHEMA Bi-Co-lastic plus grades. This variable positive toothing achieves maximum machining performance with a long tool life. Machining technology at the highest level



## Variable positive toothing with reinforced tooth backing (VP-D)

The variable special tooth form is provided with the No. 33VP-D GUHEMA Bi-Co-lastic and No. 34VP-D GUHEMA Bi-Co-lastic grades. The tooth design with the extra-strong tooth backing has been specifically developed for bundle cutting and profile as well as girder cutting. The positive cutting angle contributes to optimal chip formation and thus a clean cutting path.



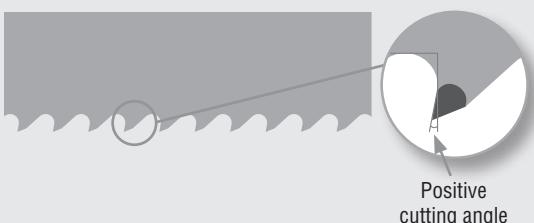
## Carbide grit coating

The carbide grit coated cutter is provided as a continuous variant with No. 40 GUHEMA HM-Granulate and as an intermittent variant with No. 41 GUHEMA HM-Granulate. This toothing succeeds where conventional saw teeth fail.



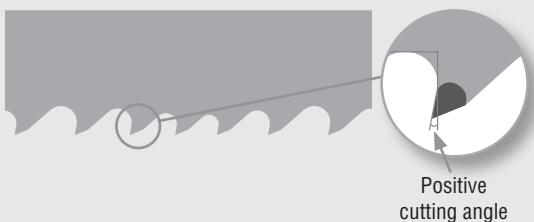
## Positive toothing (P-HM)

The positive toothing is provided with the No. 44p GUHEMA HM-Teeth and 45P GUHEMA HM-Teeth grades. This toothing has been developed to bridge the transition to the hard metal class. Abrasive workpieces as well as silted cast iron workpieces can be separated with this toothing.



## Variable positive toothing (VP-HM)

The variable positive toothing is provided with the No. 46VP GUHEMA HM-Teeth grade. The variable tooth sequence is constructed with ground hard metal teeth that are provided with pre- and finishing cutters. This toothing achieves the maximum cutting speed and maximum service life.



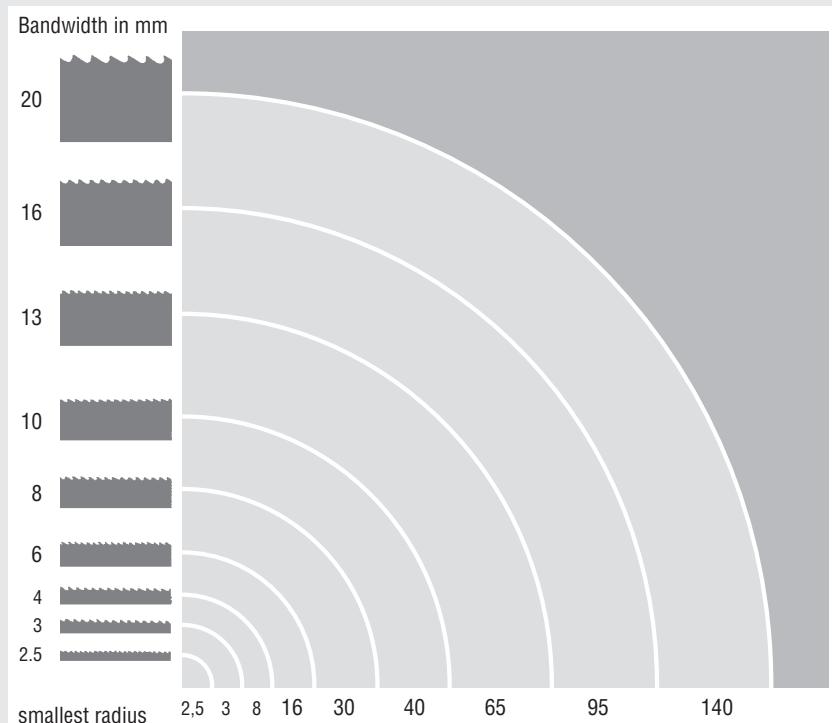
## Variable negative toothing (VN-HM)

The variable negative toothing is provided with the No. 47VN GUHEMA HM-Teeth grade. The negatively ground hard metal teeth allow for the machining of extremely hard workpieces. This special toothing is, for example, used for surface hardened shafts.



## Which bandsaw blade width do I need?

Generally speaking, you should choose the maximum bandwidth that is permissible for your machine. High stability of the band with high feed forces is the advantage of this. When using metal bandsaw blades for contour cuts, the width of the bandsaw blade depends on the smallest radius to be cut. The following graphic provides a visual aid when determining the sawblade width.



## **Our recommendations for a long service life right from the start**

When using GUHEMA metal bandsaw blades, we recommend only a few, but very important rules concerning the workpiece, machine and bandsaw blade in order to achieve optimal cutting results:

### **Running in process of bi-metal bandsaw blades**

Select the recommended cutting speed and reduce the feed speed to 50% of the recommended feed during the run-in period.

- In case of large cross-sections, keep this for 15 minutes.
- In case of small workpiece dimensions, you should machine around 300 cm<sup>2</sup> with this setting.

Reduce the cutting speed in case of vibration noise or machine vibrations.

After the run-in process, slowly increase the feed speed to the recommended cutting parameter.

The running-in of the bandsaw blade leads to an optimal cutting edge formation, where the edge radii are reduced to a minimum, which in turn causes the tooth geometry to be formed optimally.

### **Running-in of hard metal bandsaw blades**

For this purpose, set the cutting speed to 75% of the recommended speed and reduce the feed speed by approx. 50% of the recommended feed.

- In case of large cross-sections, keep this for 15 minutes.
- In case of small workpiece dimensions, you should machine around 300 cm<sup>2</sup> with this setting.

Avoid vibration noises or machine noises at all costs by further reducing the cutting speed.

After the run-in process, slowly increase the cutting speed to the recommended speed.

Now increase the feed speed to the recommended parameter.

The running-in of the bandsaw blade leads to an optimal cutting edge formation, where the edge radii are reduced to a minimum, which in turn causes the tooth geometry to be formed optimally.

<b>Material group</b>	<b>Materials</b>	<b>Material number</b>	<b>Cutting speed [m/min]</b>		
			<b>Version 20-Series</b>	<b>Version 30-Series</b>	<b>Version 40-Series</b>
<b>Structural steels</b>	ST 27	1.0037	40-60	50-90	90-110
<b>Structural steels</b>	ST 52	1.005	30-50	60-80	80-100
<b>Case hardening steels</b>	C 10	1.0301	40-60	60-100	80-120
<b>Case hardening steels</b>	21 NiCrMo 2	1.6523	30-50	40-60	55-85
<b>Case hardening steels</b>	20 CrMo 5	1.7246	30-40	50-60	70-100
<b>Case hardening steels</b>	16 MnCr 5	1.7131	30-40	40-60	70-90
<b>Nitriding steels</b>	34 CrAlNi 7	1.8550		20-40	30-50
<b>Machining steels</b>	9 S 20	1.0711	50-70	80-110	100-150
<b>Quenched and tempered steels</b>	C 45	1.0503	40-60	50-80	80-110
<b>Quenched and tempered steels</b>	42 CrMo 4	1.7225	30-40	40-60	50-80
<b>Quenched and tempered steels</b>	34 CrNiMo 6	1.6582	30-40	40-60	50-80
<b>Ball bearing steels</b>	100 Cr 6	1.3505	20-30	40-60	70-90
<b>Spring steels</b>	50 CrV 4	1.8159	30-40	40-60	50-80
<b>unalloyed carbon steels</b>	C 80 W 1	1.1525	30-40	40-60	50-80
<b>alloyed carbon steels</b>	X 210 Cr 12	1.2080		20-40	30-50
<b>alloyed carbon steels</b>	X 155 CrVMo 12 1	1.2379	20-30	20-40	40-50
<b>alloyed carbon steels</b>	90 MnCrV 8	1.2842	20-30	20-40	50-60
<b>High-speed steels</b>	S 6-5-2	1.3343		30-50	30-50
<b>High-speed steels</b>	S 18-0-1	1.3355		30-50	30-50
<b>High-speed steels</b>	S 3-3-2	1.3333		30-50	50-60
<b>High-speed steels</b>	S 2-10-1-8	1.3247		25-40	40-50
<b>High-speed steels</b>	S 10-4-3-10	1.3207		25-40	40-50

Material group	Materials	Material number	Cutting speed [m/min]		
			Version 20-Series	Version 30-Series	Version 40-Series
High-temperature resistant steels	X 12 CrCoNi 21 20	1.4971		15-25	30-40
High-temperature resistant steels	X 20 CrMoWV 12 1	1.4935		30-40	40-50
Heat-resistant steels	X 15 CrNiSi 25 20	1.4841		15-25	30-40
Heat-resistant steels	X 12 NiCrSi 36 16	1.4864		15-25	30-40
stainless and acid-resistant steels	X 5 CrNi 18 9	1.4301		20-40	30-50
stainless and acid-resistant steels	X 10 CrNiMoTi 18 10	1.4571		20-40	30-50
stainless and acid-resistant steels	X 20 Cr 13	1.4021		20-40	30-50
quenched and tempered steels	1000 - 1200 N/mm <sup>2</sup>			20-40	30-50
quenched and tempered steels	1200 - 1400 N/mm <sup>2</sup>			20-40	30-50
quenched and tempered steels	1400 - 1600 N/mm <sup>2</sup>			15-25	25-35
Cast steel	GS 38	1.0420	30-40	40-70	70-90
Cast steel	GS 60	1.0558	30-40	40-60	70-90
Cast iron	GG 30	0.6030	30-40	40-60	50-80
Cast iron	GGG 50	0.7050	25-35	30-50	50-70
Aluminium alloy	Al Mg 3	3.3535		70-110	
Aluminium alloy	Al Mg 4.5 Mn	3.3547		70-110	
Tin bronze	CuSn 6	2.1020		70-110	
Aluminium bronze	CuAl 8	2.0920		40-70	



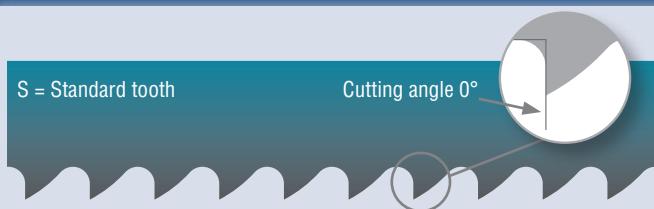
## Bandsaw Blades made of carbon steel

The fast path to our Article No.

Grade + Code Number + TPI

Example: NC20 + 0606 + L = NCO0606L

such as: NE20 + 0606 + L + Sawblade length = NE200606L02100



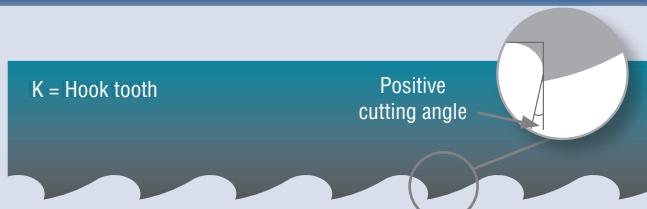
S = Standard tooth

Cutting angle 0°

No. 20 GUHEMA Kristall

Carbon steel (125 Cr 1)

- Hardened tooth bandsaw blade
- For unalloyed steels up to medium strengths



K = Hook tooth

Positive cutting angle

NC20... = rolls of 30.5 meters or manufacturing rolls

NE20... = completely welded

## TPI

Dimensions in mm: B x S	Code Number	3 ...E	4 ...G	6 ...H	8 ...I	10 ...J	14 ...L	18 ...N	22 ...O
6 x 0.65	...0606...			K	K	S	S	S	S
8 x 0.65	...0806...			K	K	S	S	S	S
10 x 0.65	...1006...		SK	SK	S	S	S	S	S
13 x 0.65	...1306...		SK	SK	S	S	S	S	
16 x 0.65	...1606...		S	SK	S	S	S	S	
16 x 0.80	...1608...		SK	SK	S	S	S	S	
20 x 0.80	...2008...	K	SK	S	S	S	S		
25 x 0.90	...2509...	K	SK	S	S	S	S		



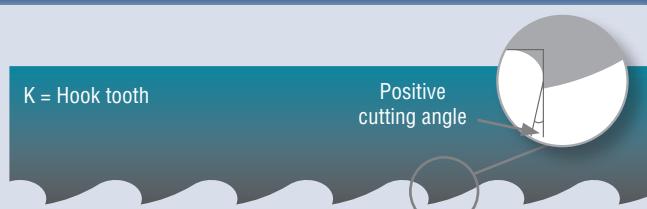
S = Standard tooth

Cutting angle 0°

No. 22 GUHEMA Kristall plus

Carbon steel (125 Cr 1)

- Tooth- and backing-hardened bandsaw blade
- For construction, machine and case hardening steels
- Workshop Master



K = Hook tooth

Positive cutting angle

NC22... = rolls of 30.5 meters or manufacturing rolls

NE22... = completely welded

## TPI

Dimensions in mm: B x S	Code Number	3 ...E	4 ...G	6 ...H	8 ...I	10 ...J	14 ...L	18 ...N	22 ...O
6 x 0.65	...0606...			K	K	S	S	S	S
8 x 0.65	...0806...			K	K	S	S	S	S
10 x 0.65	...1006...		SK	SK	S	S	S	S	S
13 x 0.65	...1306...		SK	SK	S	S	S	S	S
16 x 0.65	...1606...		SK	S	S	S	S		
16 x 0.80	...1608...		SK	S	S	S	S		
20 x 0.80	...2008...	K	SK	S	S	S	S		
25 x 0.90	...2509...	K	SK	S	S	S	S		

## Bandsaw Blades made of bi-metal

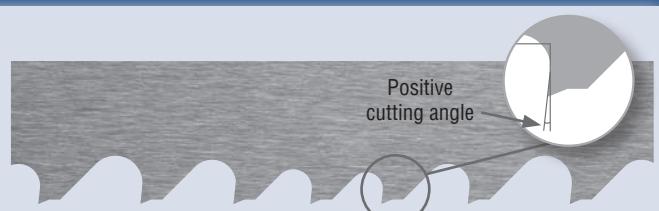
The fast path to our Article No.

Grade + Code Number + TPI

Example: NC35 + 2009 + L = NC352009L

such as: NE35 + 2009 + L + Sawblade length = NE352009L03800

-  No. 33VP-D GUHEMA Bi-Co-lastic
- M42 Grade (Material No. 1.3247)
- For profiles and tubes in bundles
- The special sewing prevents jamming of the bandsaw blade during the cuttingprocess



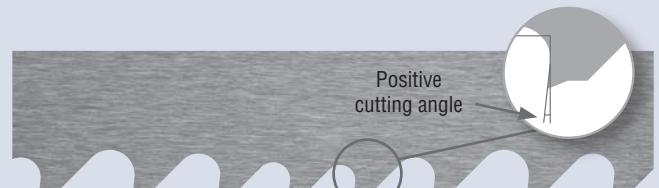
NC33... = rolls of 30.5 meters or manufacturing rolls

NE33... = completely welded

TPI

Dimensions in mm: B x S	Code Number	2-3 TPI ...T	3-4 ...U	4-6 ...V	5-8 ...W
20 x 0.90	...2009...				•
27 x 0.90	...2709...		•	•	•
34 x 1.10	...3411...	•	•	•	•
41 x 1.30	...4113...	•	•	•	

-  No. 34VP-D GUHEMA Bi-Co-lastic
- M42 Grade (Material No. 1.3247)
- For large profiles and girders



NC34... = rolls of 30.5 meters or manufacturing rolls

NE34... = completely welded

TPI

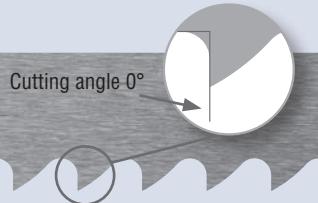
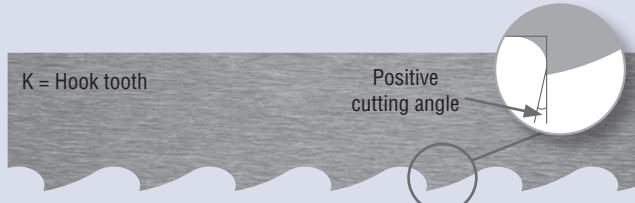
Dimensions in mm: B x S	Code Number	2-3 ...T	3-4 ...U	4-6 ...V
41 x 1.30	...4113...	•	•	•
54 x 1.60	...5416...	•	•	•
67 x 1.60	...6716...	•	•	

 S = Standard tooth

 K = Hook tooth

No. 35 GUHEMA Bi-Co-lastic  
M42 Grade (Material No. 1.3247)

- Wear-resistant tooth tips made of M42
- Especially suitable for thin to medium workpieces

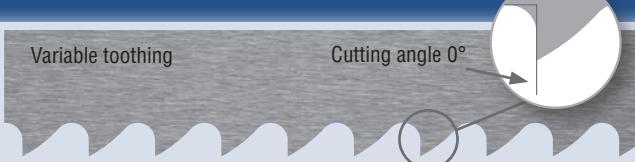



NC35... = rolls of 30.5 meters or manufacturing rolls  
NE35... = completely welded

TPI												
Dimensions in mm: B x S	Code Number	1.25 ...A	2 ...C	3 ...E	4 ...G	6 ...H	8 ...I	10 ...J	14 ...L	18 ...N		
6 x 0.90	...0609...					K		S	S			
10 x 0.90	...1009...				K	K		S	S			
13 x 0.65	...1306...					K		S	S	S		
13 x 0.90	...1309...			K	K	K		S	S			
20 x 0.90	...2009...			K	K	S	S	S	S			
27 x 0.90	...2709...			K	SK	S	S	S	S			
34 x 1.10	...3411...	K	K	K	S	S						
41 x 1.30	...4113...	K	K	K	S							
54 x 1.60	...5416...	K										
67 x 1.60	...6716...	K										

 No. 35V GUHEMA Bi-Co-lastic  
M42 Grade (Material No. 1.3247)

- Wear-resistant variable toothing made of M42
- Especially suitable for vibration-reduced sawing of thin to medium workpieces



Variable toothing  
Cutting angle 0°

NC35... = rolls of 30.5 meters or manufacturing rolls  
NE35... = completely welded

TPI							
Dimensions in mm: B x S	Code Number	3-4 ...U	4-6 ...V	5-8 ...W	6-10 ...X	8-12 ...Y	10-14 ...Z
10 X 0.90	...1009...						•
13 X 0.65	...1306...				•	•	•
13 X 0.90	...1309...				•	•	•
20 X 0.90	...2009...	•		•	•	•	•
27 X 0.90	...2709...	•	•	•	•	•	•
34 X 1.10	...3411...	•	•	•	•	•	
41 X 1.30	...4113...	•	•	•			
54 X 1.30	...5413...	•	•				

• = available toothing

The fast path to our Article No.

**Grade + Code Number + TPI**

Example: NC35 + 2009 + V = NC352009V

such as: NE35 + 2009 + V + Sawblade length = NE352009V03800

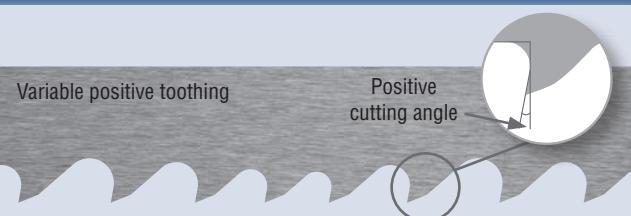


No. 35VP GUHEMA Bi-Co-lastic



M42 Grade (Material No. 1.3247)

- Wear-resistant variable positive toothing made of M42
- Especially suitable for vibration-reduced sawing of medium to large workpieces
- High machining performance and long tool life



Variable positive toothing      Positive cutting angle

NC35... = rolls of 30.5 meters or manufacturing rolls  
NE35... = completely welded

TPI								
Dimensions in mm: B x S	Code Number	0.75-1.25 ...*P	1.1-1.4 ...RP	1.4-2 ...SP	2-3 ...TP	3-4 ...UP	4-6 ...VP	5-8 ...WP
20 x 0.90	...2009...						•	
27 x 0.90	...2709...				•	•	•	•
34 x 1.10	...3411...				•	•	•	•
41 x 1.30	...4113...			•	•	•	•	•
54 x 1.30	...5413...			•	•	•	•	
54 x 1.60	...5416...	•	•	•	•	•	•	
67 x 1.60	...6716...	•	•	•	•	•	•	
80 x 1.60	...8016...	•	•					

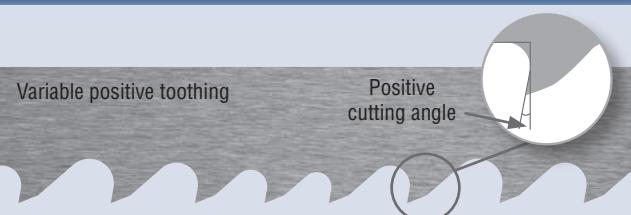


No. 36VP GUHEMA Bi-Co-lastic plus



M51 Grade (similar to Material No. 1.3207)

- Extremely wear-resistant variable positive toothing made of M51
- Especially suitable for vibration-reduced sawing of medium to large workpieces
- Significantly higher service life / cutting speed compared to M42 grade (GUHEMA No. 35 VP Bi-Co-lastic)
- Suitable for materials that are hard to machine



Variable positive toothing      Positive cutting angle

NC36... = rolls of 30.5 meters or manufacturing rolls  
NE36... = completely welded

TPI								
Dimensions in mm: B x S	Code Number	0.75-1.25 ...*P	1.4-2 ...SP	2-3 ...TP	3-4 ...UP	4-6 ...VP	4-6 ...WP	
27 x 0.90	...2709...			•	•			
34 x 1.10	...3411...			•	•			
41 x 1.30	...4113...		•	•	•			
54 x 1.60	...5416...	•	•	•	•			
67 x 1.60	...6716...	•	•	•				
80 x 1.60	...8016...	•	•					

• = available toothing

## Carbide grit coated bandsaw blades and carbide-tipped bandsaw blades

 No. 40 GUHEMA HM-Granulate

 Chrome alloyed carrier strip with carbide grit coating

-  • For abrasive and composite materials
- Especially suitable for cables and wires, ceramics, fibreglass as well as tires
- Succeeds where saw teeth fail



NC40... = rolls of 30.5 meters or manufacturing rolls

NE40... = completely welded

### TPI

Dimensions in mm: B x S	Code Number	Fine ...F	Standard ...S	Coarse ...G
10 x 0.6	...1006...	•		
13 x 0.6	...1306...	•		
20 x 0.8	...2008...		•	
25 x 0.9	...2509...		•	
32 x 1.1	...3211...		•	
38 x 1.1	...3811...			•

 No. 41 GUHEMA HM-Granulate

 Chrome alloyed carrier strip with carbide grit coating

-  • For abrasive and composite materials
- Especially suitable for cables and wires, ceramics, fibreglass as well as tires
- Succeeds where saw teeth fail
- The intermittent bandsaw blade enables chip removal even with a large chip volume



NC41... = rolls of 30.5 meters or manufacturing rolls

NE41... = completely welded

### TPI

Dimensions in mm: B x S	Code Number	Fine ...F	Standard ...S	Coarse ...G
10 x 0.6	...1006...	•		
13 x 0.6	...1306...	•		
20 x 0.8	...2008...		•	
25 x 0.9	...2509...		•	
32 x 1.1	...3211...		•	
38 x 1.1	...3811...			•

• = available toothings

The fast path to our Article No.

Grade + Code Number + TPI

Example: NC45 + 2009 + E = NC452009E

such as: NE45 + 2009 + E + Sawblade length = NE452009E03800

**No. 45P GUHEMA HM-Teeth**

Chrome alloyed carrier strip with hard metal teeth

- Tooth-set, hard metal coated bandsaw blade
- Your entry into the world of hard metal bandsaw blade technology
- Safely machines silted cast iron workpieces
- Achieves significantly longer service lifes as compared to a bandsaw blade made of bi-metal

NC45... = rolls of 30.5 meters or manufacturing rolls  
NE45... = completely welded

---

**TPI**

Dimensions in mm: B x S	Code Number	2 ...C	3 ...E	4 ...G
20 x 0.9	...2009...		•	
27 x 0.9	...2709...		•	•
34 x 1.1	...3411...		•	
41 x 1.3	...4113...	•	•	
54 x 1.6	...5416...	•		
67 x 1.6	...6716...	•		

**No. 46VP GUHEMA HM-Teeth**

Chrome alloyed carrier strip with hard metal teeth

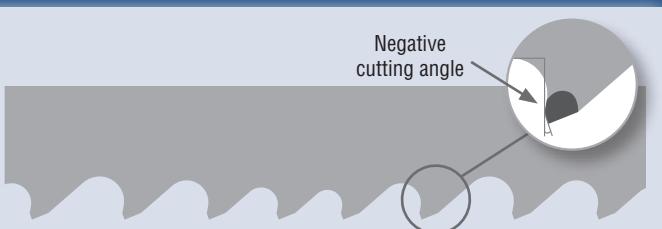
- Ground, hart metal coated bandsaw blade
- The ground sawteeth with pre- and finishing cutters allow for maximum service lifes and cutting speeds
- Designed for materials that are hard to machine and silted workpieces

NC46... = rolls of 30.5 meters or manufacturing rolls  
NE46... = completely welded

---

**TPI**

Dimensions in mm: B x S	Code Number	0.9/1.1 ...Ä	1.4/2 ...S	1.9/2.1 ...Ü	2/3 ...T	3/4 ...U
13 x 0.9	...1309...				•	•
20 x 0.9	...2009...				•	•
27 x 1.1	...2711...			•	•	•
34 x 1.1	...3411...	•	•	•	•	•
41 x 1.3	...4113...	•	•	•	•	•
54 x 1.6	...5416...	•	•		•	•
67 x 1.6	...6716...	•	•			
80 x 1.6	...8016...	•				•



No. 47VN GUHEMA HM-Teeth

 Chrome alloyed carrier strip with hard metal teeth

 • Ground, hart metal coated bandsaw blade

 • The ground sawteeth with pre- and finishing cutters allow for maximum service lifes and cutting speeds

 • Special tooth forms for the processing of extremely hard workpieces such as surface hardened shafts

NC47... = rolls of 30.5 meters or manufacturing rolls  
NE47... = completely welded

TPI			
Dimensions in mm: B x S	Code Number	2/3 ...T	3/4 ...U
27 x 1,1	...2711...	•	•
34 x 1,1	...3411...	•	•
41 x 1,3	...4113...	•	•
54 x 1,6	...5416...	•	•

• = available toothings



## Jigsaw Blades

No matter what material you are intending to separate, what the profile looks like or whether or not you have to "follow the curve" with your saw – our jigsaw blades meet all of your requirements.



# Jigsaw Blades



## GUHEMA CV-flex

- Conically ground blade body, teeth ground sharp
- Curve cutting blade with double-sided, clean cutting edge path
- Suitable for soft wood, plywood, fibreboard and coated plates
- Similar to Bosch: T 101 A0

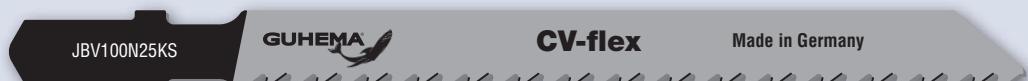
Order No.:	Tooth separation	Sawblade length	Wood cutting area
JBV077K14KS	1.4	77 mm	1.5 - 20 mm



## GUHEMA CV-flex

- Conically ground blade body, teeth ground sharp
- For clean, splinter-free cutting of all types of wood and plastics
- Impact cutting
- Similar to Bosch: T 101 BR

Order No.:	Tooth separation	Sawblade length	Wood cutting area
JBV100R25KS	2.5	100 mm	3 - 30 mm



## GUHEMA CV-flex

- Conically ground blade body, teeth ground sharp
- For clean, splinter-free cutting of all types of wood and plastics
- Similar to Bosch: T 101 B

Order No.:	Tooth separation	Sawblade length	Wood cutting area
JBV100N25KS	2.5	100 mm	3 - 30 mm



 GUHEMA CV-flex

-  • Tooth-set and milled teeth  
• For cutting all types of wood and plastics  
• Similar to Bosch: T 111 C

Order No.:	Tooth separation	Sawblade length	Wood cutting area
JBV100N30GN	3.0	100 mm	4 - 40 mm



 GUHEMA CV-flex

-  • Conically ground blade body, teeth ground sharp  
• For clean and quick cutting of all types of wood and plastics  
• Similar to Bosch: T 101 D

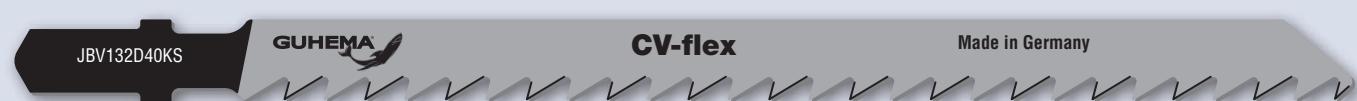
Order No.:	Tooth separation	Sawblade length	Wood cutting area
JBV100N40KS	4.0	100 mm	8 - 50 mm



 GUHEMA CV-flex

-  • Tooth-set and sharply ground teeth  
• For quick and rough cuts into all types of wood  
• Similar to Bosch: T 144 D

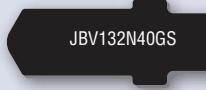
Order No.:	Tooth separation	Sawblade length	Wood cutting area
JBV100N40GS	4.0	100 mm	8 - 50 mm



 GUHEMA CV-flex

-  • Conically ground blade body, teeth ground sharp  
• For clean cutting of all types of wood and plastics  
• Extra thick for a straight cut  
• Similar to Bosch: T 301 DL

Order No.:	Tooth separation	Sawblade length	Wood cutting area
JBV132D40KS	4.0	132 mm	8 - 70 mm

 JBV132N40GS

GUHEMA

CV-flex

Made in Germany

 GUHEMA CV-flex

- 
- Tooth-set and sharply ground teeth
- 
- For quick and rough cuts into all types of wood
- 
- Similar to Bosch: T 344 D

Order No.:	Tooth separation	Sawblade length	Wood cutting area
JBV132N40GS	4.0	132 mm	8 - 80 mm

 JBF077N12GN

GUHEMA

Bi-lastic

Made in Germany

 GUHEMA Bi-lastic

- 
- Tooth-set and milled teeth
- 
- Made of bi-metal
- 
- For straight cuts in steel, stainless steel and non-ferrous metal
- 
- Similar to Bosch: T 118 AF

Order No.:	Tooth separation	Sawblade length	Metal cutting area
JBF077N12GN	1.2	77 mm	1.5 - 2.5 mm

 JBF077N20GN

GUHEMA

Bi-lastic

Made in Germany

 GUHEMA Bi-lastic

- 
- Tooth-set and milled teeth
- 
- Made of bi-metal
- 
- For straight cuts in steel, stainless steel and non-ferrous metal
- 
- Similar to Bosch: T 118 BF

Order No.:	Tooth separation	Sawblade length	Metal cutting area
JBF077N20GN	2.0	77 mm	2.5 - 6 mm

 JBF100N30GN

GUHEMA

Bi-lastic

Made in Germany

 GUHEMA Bi-lastic

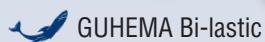
- 
- Tooth-set and milled teeth
- 
- Made of bi-metal
- 
- 
- Aluminium Professional**
- 
- Especially suited for aluminium and non-ferrous metals, also cuts plastic
- 
- Similar to Bosch: T 127 DF

Order No.:	Tooth separation	Sawblade length	Metal cutting area
JBF100N30GN	3.0	100 mm	3 - 15 mm

JBF132N10GN


**Bi-lastic**

Made in Germany



## GUHEMA Bi-lastic

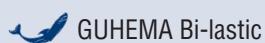
-  • Tooth-set and milled teeth  
 • Made of bi-metal  
**• Sandwich-Material Professional**  
 • For straight cuts in steel, stainless steel and non-ferrous metal  
 • Ideally suitable to cut profiles and tubes up to 80 mm  
 • Similar to Bosch: T 318 AF

Order No.:	Tooth separation	Sawblade length	Metal cutting area
JBF132N10GN	1.0	132 mm	1.2 - 2.5 mm

JBF132N18GN


**Bi-lastic**

Made in Germany



## GUHEMA Bi-lastic

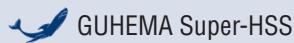
-  • Tooth-set and milled teeth  
 • Made of bi-metal  
 • Ideally suitable to cut profiles and tubes up to 80 mm  
 • For straight cuts in steel, stainless steel and non-ferrous metal  
 • Similar to Bosch: T 318 BF

Order No.:	Tooth separation	Sawblade length	Metal cutting area
JBF132N18GN	1.8	132 mm	2.3 - 6 mm

JBD055N12GN


**Super-HSS**

Made in Germany



## GUHEMA Super-HSS

-  • Tooth-set and milled teeth  
 • Ideal for curved cuts  
 • Similar to Bosch: T 218 A

Order No.:	Tooth separation	Sawblade length	Metal cutting area
JBD055N12GN	1.2	55 mm	1.5 - 2.5 mm

# Car Body Jigsaw Blades



Made in Germany

## GUHEMA Bi-lastic

- Sharply milled toothing
- Hardened to the point as part of a high-vacuum hardening process for maximum service life
- The sawblade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Order No.:	Toothing	Sawblade length	Metal cutting area
JSF0950Q	32 TPI	95 mm	< 1 mm



Made in Germany

## GUHEMA Bi-lastic

- Sharply milled toothing
- Hardened to the point as part of a high-vacuum hardening process for maximum service life
- The sawblade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Order No.:	Toothing	Sawblade length	Metal cutting area
JSF0950P	24 TPI	95 mm	> 1 mm



Made in Germany

## GUHEMA Bi-lastic

- Sharply milled toothing
- Hardened to the point as part of a high-vacuum hardening process for maximum service life
- The sawblade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Order No.:	Toothing	Sawblade length	Metal cutting area
JSF0950N	18 TPI	95 mm	1.5 - 3 mm



### GUHEMA Bi-Lastic

-  • Sharply milled toothing  
 • Hardened to the point as part of a high-vacuum hardening process for maximum service life  
 • The sawblade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Order No.:	Toothing	Sawblade length	Metal cutting area
JSF0950L	14 TPI	95 mm	2 - 4 mm



### GUHEMA Bi-lastic

-  • Sharply milled toothing  
 • Hardened to the point as part of a high-vacuum hardening process for maximum service life  
 • The sawblade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Order No.:	Toothing	Sawblade length	Metal cutting area
JLF0950Q	32 TPI	95 mm	< 1 mm



### GUHEMA Bi-lastic

-  • Sharply milled toothing  
 • Hardened to the point as part of a high-vacuum hardening process for maximum service life  
 • The sawblade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Order No.:	Toothing	Sawblade length	Metal cutting area
JLF0950P	24 TPI	95 mm	> 1 mm



### GUHEMA Bi-lastic

-  • Sharply milled toothing  
 • Hardened to the point as part of a high-vacuum hardening process for maximum service life  
 • The sawblade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Order No.:	Toothing	Sawblade length	Metal cutting area
JLF0950N	18 TPI	95 mm	1.5 - 3 mm



Made in Germany

### GUHEMA Bi-lastic

- Sharply milled toothing
- Hardened to the point as part of a high-vacuum hardening process for maximum service life
- The sawblade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Order No.:	Toothing	Sawblade length	Metal cutting area
JLF0950L	14 TPI	95 mm	2 - 4 mm



Made in Germany

### GUHEMA Bi-lastic

- Sharply milled toothing
- Hardened to the point as part of a high-vacuum hardening process for maximum service life
- The sawblade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Order No.:	Toothing	Sawblade length	Metal cutting area
JOF0950Q	32 TPI	95 mm	< 1 mm



Made in Germany

### GUHEMA Bi-lastic

- Sharply milled toothing
- Hardened to the point as part of a high-vacuum hardening process for maximum service life
- The sawblade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Order No.:	Toothing	Sawblade length	Metal cutting area
JOF0950P	24 TPI	95 mm	> 1 mm



Made in Germany

### GUHEMA Bi-lastic

- Sharply milled toothing
- Hardened to the point as part of a high-vacuum hardening process for maximum service life
- The sawblade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Order No.:	Toothing	Sawblade length	Metal cutting area
JOF0950N	18 TPI	95 mm	1.5 - 3 mm



Made in Germany

 GUHEMA Bi-lastic

- 
- Sharply milled toothing
  - Hardened to the point as part of a high-vacuum hardening process for maximum service life
  - The sawblade without compromise, made of bi-metal, achieves high performance with materials that are difficult to machine and with a tensile strength of up to 1100 N/mm<sup>2</sup>

Order No.:	Toothung	Sawblade length	Metal cutting area
JOF0950L	14 TPI	95 mm	2 - 4 mm



# Metal Cut- ting Circular Sawblades

Our metal cutting circular sawblades for circular saws (type saws) are all steam-tempered. This design optimizes the separation process by increasing the cutting performance even more, protects against the welding-on of chips and enables better absorption of the coolant and lubricants

# Metal Cutting Circular Sawblades

## Materials, qualities and application areas

Our two grades of high-speed steel are listed below:

### GUHEMA Super-HSS

 M2 Grade (Material No. 1.3343)

 The Workshop-Blade

### GUHEMA Brilliant

 M35 Grade (Material No. 1.3243)

 For stainless steels

## Tooth forms

If perfect cutting performance is desired, all factors have to be perfectly coordinated with one another. The tooth form plays a significant role in this regard. The following tooth types that are all manufactured in accordance with DIN 1840 are available to you:

### Curved tooth with alternating grinds (BW)



We recommend the curved tooth with alternating grinds for metal cutting circular sawblades and a fine teeth separation to saw tubes or profiles.

### Curved tooth with pre- and finishing cutter (HZ)



The curved tooth with pre- and finishing cutter is suitable for the sawing of steels on sawing machines and rotary transfer machines and is recommended for medium and coarse teeth separations.

## Our recommendations for a long service life

When using GUHEMA metal cutting circular sawblades, we recommend a number of very important rules concerning the workpiece, machine and sawblade in order to achieve optimal cutting results:

- Have your sawblade be sharpened on time, this way you avoid unclean cut surfaces and a dispersement of the cut. We would gladly do this for you.
- Clamp the circular sawblade into the machine facing the correct direction.
- When clamping the blade, ensure that there are no chips between the flange and the sawblade (will cause the cut to disperse). Please use the appropriate flange for the sawblade.
- If possible, clamp the workpiece to be machined via four points. Mind possible chips between the clamping jaws and the workpiece.
- Adjust the feed rate to the cutting speed.
- Significantly increase the service life of your metal cutting circular sawblade by cooling with the appropriate coolant at all times.

 GUHEMA Super-HSS  
OSD...  
M2 Grade (Material No. 1.3343)  
 The Workshop-Blade

 GUHEMA Brilliant  
OSE...  
M35 Grade (Material No. 1.3243)  
 For stainless steels

The fast path to our Article No.  
Grade + Code Number + Code Number 2 +  
Code Number 3  
Example: OSD + 5279 + G + BH = OSD5279GBH

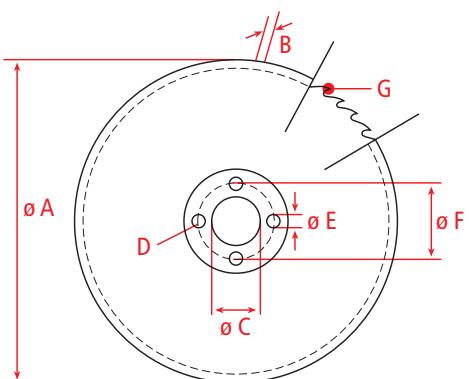
Ø/Thickness/Bore in mm:	Code Number 1	BW 3 mm	BW 4 mm	HZ 5 mm	HZ 6 mm	BW 7 mm	HZ 8 mm	HZ 9 mm	HZ 10 mm	HZ 12 mm	HZ 14 mm	NL in mm
200 1.75 32	...3205...	200	160	128	100							AD
225 2.00 32	...4225...	220	180	150	120		90					AD
	...4229...	220	180	150			90					BH
250 2.00 32	...4255...	240	200	160	128		100		80			AD
	...4259...	240	200	160	128		100		80			BH
2.50 32	...5255...		200	160	128		100					AD
	...5259...		200	160	120		100					BH
275 2.00 32	...4275...		220	180	144		110					AD
	...4279...	280	220	180	144		110					BH
2.50 32	...5275...		220	180	144		110					AD
	...5279...	280	220	180	144	120	110	96	84	72		BH
3.00 40	...6279...		220	180	144	120	110					BH
300 2.50 32	...5305...		240	200	160		120		100			AD
	...5309...		240	200	160		120		100			BH
315 2.50 32	...5315...		250	200	160		120					AD
	...5319...		250	200	160		120		100	80		BH
3.00 32	...6315...		250	200	160		120					AD
	...6319...		250	200	160		120		100	80		BH
350 3.00 32	...6355...		280	220	180		140		110			AD
	...6359...		280	220	180		140		110			BH
400 3.50 40	...7409...				200		160		128	100	80	FHB
	...7404...					180	160	140	128	100		I

## Code Number 2 Key Teeth Number

BW	HZ
160 = ...Q...	72 = ...A...
180 = ...R...	80 = ...B...
200 = ...S...	84 = ...C...
220 = ...U...	90 = ...D...
240 = ...V...	96 = ...E...
250 = ...W...	100 = ...F...
280 = ...X...	110 = ...G...
	120 = ...H...
	128 = ...I...
	140 = ...J...
	144 = ...K...
	150 = ...L...
	160 = ...M...
	180 = ...N...

## Code Number 3 Key Side Holes

2/8/45 = ...A...
2/8/55 = ...B...
2/9/50 = ...C...
2/11/63 = ...D...
2/12/64 = ...E...
2/15/80 = ...F...
4/9/50 = ...G...
4/12/64 = ...H...
4/15/80 = ...I...



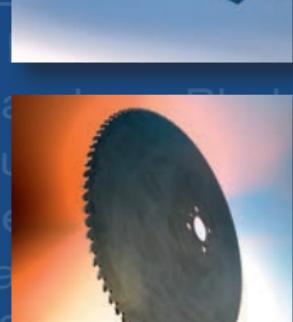
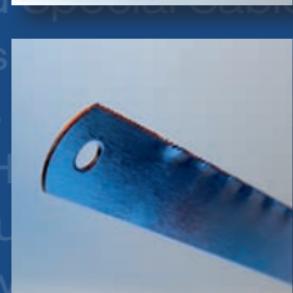
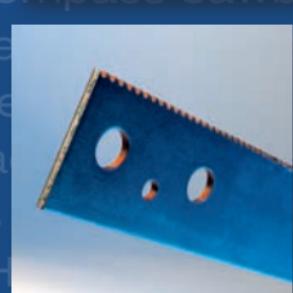
When ordering, please provide the following information:

- Article Number
- We also offer other dimensions, please specify:
  - A Diameter of the blade
  - B Blade thickness
  - C Main bore
  - D Number of side holes
  - E Hole diameter
  - F Pitch circle of the side holes
  - G Teeth separation or teeth number

## Notes



© All rights reserved by GUHEMA GmbH & Co. KG and may not be used without permission.



# Our grades at a glance



## GUHEMA CV-flex

Sawblades made of carbon steel

For soft/easily machinable materials



## GUHEMA Kristall & GUHEMA Kristall plus

Bandsaw blades made of carbon steel

For soft/easily machinable materials



## GUHEMA H.S.S.-flex

Hacksaw blades made of ABCIII (Material No. 1.3333)

Hardened teeth for easily machinable materials



## GUHEMA H.S.S. allhard-flex

Hacksaw blades made of ABCIII (Material No. 1.3333)

Teeth and blade bodies hardened for materials that are difficult to machine



## GUHEMA Super-HSS

Sawblades made of DMo 5 / M2 (Material No. 1.3343)

Serves as a universal sawblade



## GUHEMA Brilliant

Sawblades made of EMo 5 Co 5 / M35 (Material No. 1.3243)

Special sawblades for hard and tough materials



## GUHEMA Bi-lastic

Bi-metal sawblades with DMo 5 / M2 tooth tips

(Material No. 1.3343)

Bi-metal sawblades for various applications



## GUHEMA Bi-Co-lastic

- M42 bi-metal bandsaw blades with cobalt-alloyed tooth tips (Material No. 1.3247)

- Bi-metal sawblades with cobalt-alloyed tooth tips (Material No. 1.3299)

- Wear-resistant bandsaw blades/sawblades for a variety of applications

- Sawblades with high temperature resistant teeth



## GUHEMA Bi-Co-lastic plus

M51 bi-metal bandsaw blades with highly cobalt-alloyed tooth tips (Material No. 1.3207)

Extremely wear-resistant bi-metal bandsaw blades for special applications



## GUHEMA HM-Granulate

Sawblades/bandsaw blades with hard metal granulate soldered on as a cutting edge

Special bandsaw blades/sawblades for applications where the use of sawteeth would be disadvantageous



## GUHEMA HM-Teeth

Special sawblades/bandsaw blades with soldered hard metal as tooth tip

Special bandsaw blades/sawblades to separate workpieces that are difficult to machine as well as mineral materials



**GUHEMA GmbH & Co. KG**

Unterhützer Straße 10 – 12

D-42857 Remscheid

Phone: +49 (0) 21 91/88 67-0

Fax: +49 (0) 21 91/88 67-30

[www.guhema.com](http://www.guhema.com)

[info@guhema.com](mailto:info@guhema.com)

