



RÖNTGEN®

GERMAN QUALITY - ENDURING PRECISION

BAND SAW BLADES PROGRAM

Product overview

**BAND SAW BLADES
FOR THE WORLD
AND BEYOND!**

HM-Titan



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RANGE OF APPLICATIONS

EXPLANATION OF ICONS

Due to the variety of our band saw blades, we are able to cover a wide range of applications. The following icons indicate which band saw blade fits best to your individual cutting job.



Thick-walled tube



Engine block



Thick-walled tubes & solid bar



Riser & Sprues



Round solids



Square solids



Plates



Saw stones



Wall and floor tiles



Aerated concrete/fibreboard



Back wave

HM-Titan

MU

- multi-chip geometry
- universal use, cutting of all common steel types up to a hardness of 1700 N/mm²
- tooth tips made of high-quality carbide
- backing material made of high alloyed spring steel
- particularly quiet and vibration free cutting with an optimized cutting surface due to precise ground geometry

APPLICATION AREAS



Teeth per inch

	0,85/1,15	1,1/1,6	1,5/2	1,8/2,2	2/3	3/4	
27 x 0,90						■	1 x .035
34 x 1,10					■	■	1 1/4 x .042
41 x 1,30			■		■	■	1 1/2 x .050
54 x 1,30			■		■	■	2 x .050
54 x 1,60		■	■	■	■	■	2 x .063
67 x 1,60	■	■	■	■			2 5/8 x .063
80 x 1,60		■					3 1/8 x .063

Width x thickness (mm) ■ Hook tooth

HM-Titan

forteC

- corresponds to the specification of HM-Titan MU with an additional forteC-coating for increasing cutting performance
- increase in performance of 10-30 % with the same tool life
- pre-honed cutting edges

APPLICATION AREAS



Teeth per inch

	0,85/1,15	1,1/1,6	1,5/2	1,8/2,2	2/3	3/4	
34 x 1,10					■	■	1 1/4 x .042
41 x 1,30			■		■	■	1 1/2 x .050
54 x 1,30			■		■		2 x .050
54 x 1,60		■	■		■		2 x .063
67 x 1,60	■	■	■	■			2 5/8 x .063
80 x 1,60	■	■					3 1/8 x .063

Width x thickness (mm) ■ Hook tooth

HM-Titan

Profile

Profile forteC

- PF-geometry
- cutting of all common steel types up to a hardness of 1900 N/mm²
- particularly suitable for thick-walled tubes/tough materials/special alloys
- Profile forteC: increase in performance of 10-30% with the same tool life with an additional forteC-coating
- Profile forteC: pre-honed cutting edges

APPLICATION AREAS



Teeth per inch

	0,85/1,15	1,1/1,6	1,5/2	1,8/2,2	2/3	3/4	
34 x 1,10					■	■	1 1/4 x .042
41 x 1,30			●		●	■ ●	1 1/2 x .050
54 x 1,30						●	2 x .050
54 x 1,60		●	■ ●		■ ●	■ ●	2 x .063
67 x 1,60			■ ●	■			2 5/8 x .063
80 x 1,60	●						3 1/8 x .063

Width x thickness (mm) ■ Profile ● Profile forteC

HM-Titan

SET nSET

- universal use, cutting of all common steel types up to a hardness of 1700 N/mm²
- the special set pattern causes a larger cutting channel, prevents the saw blade from binding in materials with residual stress (i.e. Inconel, Hastelloy or forged materials)
- also suitable for powerful sawing machines and less powerful machines not specially equipped for TCT-blades
- particularly suitable for large contact lengths
- available in step set (SET) and normal set (nSET)
- high performance band saw blade with special geometry

APPLICATION AREAS



Teeth per inch

	0,7/1,0	0,85/1,15	1,1/1,6	1,5/2	2/3	3/4	
27 x 0,90					●	●	1 x .035
34 x 1,10					■ ●	●	1 1/4 x .042
41 x 1,30				■ ●	■ ●	●	1 1/2 x .050
54 x 1,30				■ ●	●	●	2 x .050
54 x 1,60			●	■ ●	■ ●	●	2 x .063
67 x 1,60		■ ●	■ ●	■ ●			2 5/8 x .063
80 x 1,60	■	■ ●	■ ●				3 1/8 x .063
100 x 1,60	■						4 x .063

Width x thickness (mm) ■ SET ● nSET

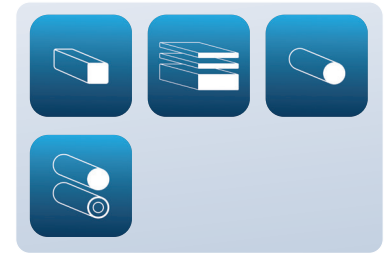
HM-Titan

B0

B0 forteC

- high performance band saw blade with special geometry
- cutting of hardened/inductive annealed and extremely hard materials > 50 HRC
- B0 is also suitable for use on machines with limited performance
- increase in performance of 10-30% with the same tool life with an additional forteC-coating

APPLICATION AREAS



Teeth per inch

	1,5/2	2/3	3/4	
27 x 0,90			■	1 x .035
34 x 1,10		■	■ ●	1 1/4 x .042
41 x 1,30	■	■	■ ●	1 1/2 x .050
54 x 1,30		■	■	2 x .050
54 x 1,60		■	■	2 x .063

Width x thickness (mm) ■ B0 ● B0 forteC

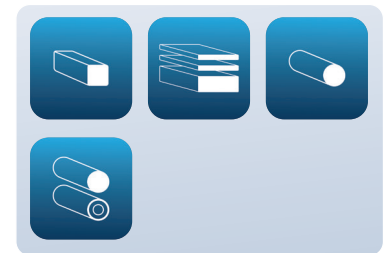
HM-Titan

MUSN

MUSN forteC

- high performance band saw blade with special geometry
- cutting of hardened/inductive annealed and extremely hard materials > 50 HRC
- MUSN requires for the use of heavy-duty sawing machines
- multi-chip geometry with additional special forteC coating to increase the cutting parameters
- increase in performance of 10-30% with the same tool life with an additional forteC-coating

APPLICATION AREAS



Teeth per inch

	1,5/2	2/3	3/4	
27 x 0,90			■	1 x .035
34 x 1,10		■	■ ●	1 1/4 x .042
41 x 1,30	■	■	■ ●	1 1/2 x .050

Width x thickness (mm) ■ MUSN ● MUSN forteC

SOLUTIONS FOR SPECIAL APPLICATIONS

RÖNTGEN back wave (RW)

The RÖNTGEN „RW“ is brought on the back edge of the ready welded loop. The wave reduces the effective contact length in the cutting channel. The shorter contact length reduces the cutting force required, resulting in increased saw blade tool life.



HM-Titan

ALU2

ALU3

APPLICATION AREAS



- VN-geometry/multi-chip geometry
- tooth tips made of wear resistant special carbide
- high alloyed spring steel strip for high blade speeds and feeds
- particularly suitable for blocks, plates, sprues, risers and manual feeds
- optimized cutting surfaces for plates- and block cutting applications
- optimized chip chamber profile for long engagement lengths

Teeth per inch

	2	3	0,85/1,15	0.9/1,2	1,1/1,6	1,5/2	2/3	
20 x 0,90		■						3/4 x .035
27 x 0,90		■ ●					■ ●	1 x .035
34 x 1,10	■ ●	■ ●				■ ●	■ ●	1 1/4 x .042
41 x 1,10					●	●		1 1/2 x .042
41 x 1,30					●	■ ●	■ ●	1 1/2 x .050
54 x 1,30				■		■ ●	■	2 x .050
54 x 1,60				■	■	■		2 x .063
80 x 1,60			■	■				3 1/8 x .063

Width x thickness (mm) ■ VN-geometry ● multi-chip geometry

HM-Titan

ALU SET

APPLICATION AREAS



- the special set pattern causes a larger cutting channel, prevents the saw blade from binding in materials with residual stress
- high alloyed spring steel strip for high blade speeds and feeds
- particularly suitable for manual feed

Teeth per inch

	2	3	
20 x 0,90		■	3/4 x .035
27 x 0,90		■	1 x .035
34 x 1,10	■	■	1 1/4 x .042

Width x thickness (mm) ■ Hook tooth

HM-Titan

FIT FIT SET

- multi-chip geometry
- high-performance band saw blade especially for sawing difficult-to-cut materials in the following material groups material groups: Stainless steel, nickel-based alloys and titanium
- newly developed, highly wear resistant carbide tooth tips in order to increase the performance features tool life, cutting quality, performance, and accuracy
- optimization of cutting costs
- backing strip made of high-alloyed spring steel

Teeth per inch

	0,85/1,15	1,1/1,6	1,5/2	1,8/2,2	2/3	3/4	
34 x 1,10					■		1 1/4 x .042
41 x 1,30			■ ●		■		1 1/2 x .050
54 x 1,30			■	■	■		2 x .050
54 x 1,60		■	■ ●	■	■	■	2 x .063
67 x 1,60	■	■ ●	■	■			2 5/8 x .063

Width x thickness (mm) ■ FIT ● FIT SET

APPLICATION AREAS



HM-Titan

TCO

- low cutting pressure, to ensure fatigue-free working environment manual feed
- lower temperature development increases lifetime of the blade
- for highly abrasive materials (e.g. Ytong, Poroton, perforated bricks or insulation boards)
- especially for the use in the construction industry with the dimension 27 x 0.9 mm
3 ZpZ for Band Saw Blade machines e.g. Zagro (UVB series); Lissmac (MBS series); Norton Clipper (CB series)

Teeth per inch

	3	
27 x 0,90	■	1 x .035

Width x thickness (mm) ■ TCO-tooth

APPLICATION AREAS



HM-Titan

Engine

- VN-geometry
- tooth tips made of wear resistant special carbide
- high alloyed spring steel strip for high blade speeds and feeds
- optimized tooth profile for sanded compo
- HM cutting material optimized for alloys with high silicon content
- highly flexible spring steel for high number of bending loads
- developed for abrasive, high silicon alloys
- also suitable for the use in graphite

Teeth per inch

	2	1,5/2	2/3	
27 x 0,90			■	1 x .035
34 x 1,10			■	1 1/4 x .042
41 x 1,30	■	■	■	1 1/2 x .050

Width x thickness (mm) ■ Hook tooth

APPLICATION AREAS



SAFETY INSTRUCTIONS

Endlessly welded RÖNTGEN saw bands are under tension when delivered. When opening the delivery form and placing the saw band on the sawing machine, the following safety measures must be observed:

- wear safety glasses
- wear work gloves
- wear safety shoes



Detailed safety instructions can be found in the operating instructions of the respective machine manufacturer or available upon request from RÖNTGEN.

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