



www.sande.cl

SANDE S.A.



600 600 0900



The above picture may not be
an exact representation of the product

Especificaciones técnicas sujetas a alteraciones sin previo aviso.

STERK CINTA SIERRA "PREMIUM"

BS1018-4/6 RF712-5/8

Premium

1. For universal use with excellent quality and high-cost performance.
2. Adopt a special tooth design, which is conducive to improving the cutting rate and guarantees chip removal smoothly.
3. Premium high-speed steel for tooth material, excellent abrasion resistance and red-hardness, excellent sawing and lifespan.

Application

Application is universal, meeting the sawing of various ordinary or some hard-to-cut materials.

- | | | |
|---------------------|--------------------|-------------------|
| ■ Non-ferrous Metal | ■ Structural Steel | ■ Die Steel |
| ■ Cast Iron | ■ Alloy Steel | ■ Tool Steel |
| ■ Carbon Steel | ■ Bearing Steel | ■ Stainless Steel |

27x0.9x3280	4/6, 5/8, 6/10	BS-1018B
19x0.9x2362	5/8, 6/10, 8/12	BS-712N





SANDE S.A.



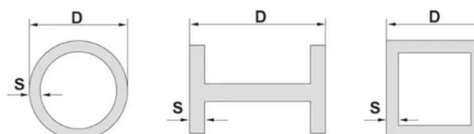
How to choose TPI

Tube and profiles material

D(mm) S(mm)	20	40	60	80	100	150	200	300	500
	TPI								
2	14	14	14	14	10/14	10/14	10/14	10/14	8/12
3	14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	6/10
4	14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	4/6
5	14	10/14	10/14	8/12	6/10	6/10	5/8	4/6	4/6
6	14	10/14	8/12	8/12	6/10	5/8	5/8	4/6	4/6
8	14	8/12	6/10	6/10	6/10	5/8	5/8	4/6	4/6
10		6/10	6/10	5/8	5/8	4/6	4/6	4/6	3/4
12		6/10	5/8	4/6	4/6	4/6	4/6	3/4	3/4
15				4/6	4/6	3/4	3/4	3/4	2/3
20				4/6	4/6	3/4	3/4	3/4	2/3
30				3/4	3/4	3/4	2/3	2/3	2/3
50						2/3	2/3	2/3	1.4/2.0
75							2/3	1.4/2.0	1.4/2.0
100								1.4/2.0	0.75/1.25
150									0.75/1.25

Solid material

Dia. of workpiece (mm)	TPI
≤30	8/12 , 6/10 , 8
30-50	6/10 , 5/8 , 6
50-100	4 , 3/4 , 4/6
100-200	3/4 , 2/3
200-300	2/3T , 2 , 1.4/2.0
300-500	1.25 , 1/1.25 , 1.4/2.0
≥500	0.75/1.25 , 1/1.25



- Choose the TPI according to the Dia and wall Thickness of material.
- For two or more material, add up all wall thickness.

How to adjust the cutting performance according to the chips characteristics

Blade speed and down-feed can be quickly diagnosed by observing chips. If the cutting parameters are properly adjusted the chips are thin, curled, warm and of a silver color.

 <p>Burned heavy chips Reduce feed and/ speed</p>	 <p>Too thin or powdered chips Increase feed</p>	 <p>Thin, curled, warm and of a silver color</p>
--	---	---

Blade speed and feed rate depend on the grade and shape of the material to be cut. General rule is that the harder material the lower speed and feed. For cutting tubes and shapes the blade must run faster than while cutting solid sections.

Brake-In procedure: It is generally recommended to brake in each new blade during first use to extends the tool life and provides better cutting surface. Brake-in procedure is nothing more than cutting with reduced twice down-feed for 15 minutes at least.

Specifications subject to change without notice

