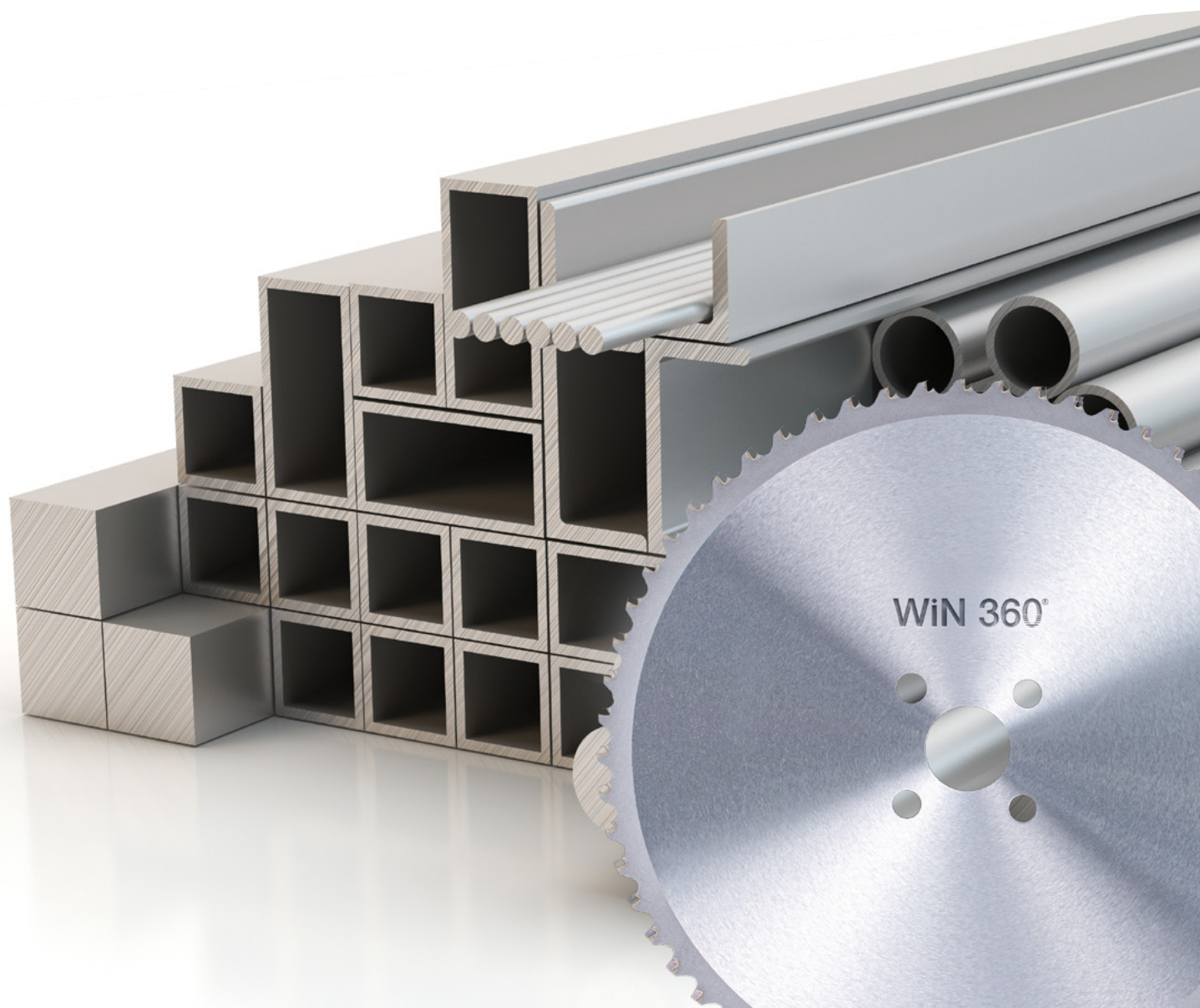


The WiN 360[®] Series

Circular Saw Blade Selection

By WIKUS Nordic AB



The WiN 360® Series

Your high-performance Cermet and TCT + PVD circular saw blade selection.

WIKUS Nordic offers a wide range of high-quality circular Cermet and Carbide tipped precision saw blades for cutting steel. The standard range includes dimensions from 250 – 460 mm and can be delivered with several tooth profiles depending on the cutting process. Same range applies as well for tube cutting blades.

We are happy to support you by providing the best product choice, cutting data and local technical service at your premises. And please feel free to challenge us with cases outside the standard range. Please see our team contact details at the bottom of this page.



WiN 360® INOX

Main Applications:

- for Stainless Steel
- for Solid Bars and Pipes



WiN 360® PVD

Main Applications:

- for Medium - and High Carbon Steel
- for Solid Bars



WiN 360® Cermet

Main Applications:

- for Low and Medium Carbon Steel
- for Solid Bars



WiN 360® Tube

Main Applications:

- for Steel
- for Tubes

Technical Data for all Cermet and TCT + PVD Circular Saw Blades

Our WiN 360® product range (*all dimensions in mm)

Diameter*	Kerf*	Body*	Bore*	Number of Teeth
250	2,0	1,75	32-40	54 - 60 - 72 - 80 - 100
285	2,0	1,75	32-40	54 - 60 - 72 - 80 - 100 - 110 - 120 - 140
315	2,5	2,25	32-40-50	48 - 50 - 54 - 60 - 72 - 80 - 90 - 100 - 110 - 120
350	2,6	2,25	32-40-50	60 - 70 - 76 - 80 - 90 - 100 - 120 - 130 - 144 - 150
350	2,7	2,50 / 2,25	32-40-50	60 - 70 - 76 - 80 - 90 - 100 - 120 - 130 - 144 - 150
360	2,6	2,25	40-50	40 - 50 - 60 - 72 - 80 - 90 - 100 - 110 - 120
400	2,6	2,25	40-50	60 - 80 - 100 - 120 - 140 - 150 - 160
420 / 425	2,7	2,25	40-50	50 - 60 - 72 - 80 - 90 - 100 - 120 - 140
460	2,7	2,25	40-50	40 - 50 - 60 - 70 - 72 - 80 - 90 - 100 - 120 - 140 - 150 - 160 - 180

Prices and Delivery time on request.



No minimum quantity order.

Transport cost for 1 piece in Germany 11 EUR.

If the order value is more than 1000 EUR, freight is free of charge.

Attention:

Please order the Circular Saw Blades by always specifying the necessary pinholes.

In case of any questions or inquiries please call us - we are glad to help!



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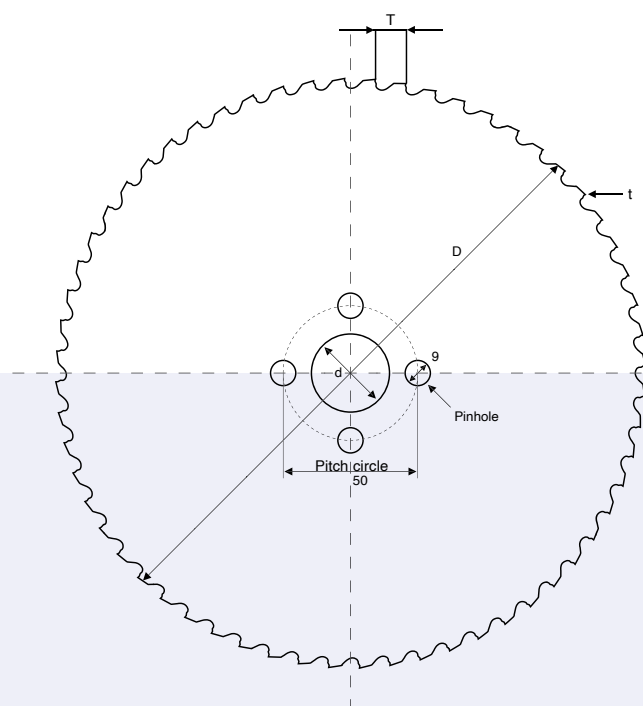


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Technical Characteristics of a Circular Saw Blade



D = Diameter of blade

d = Bore hole

S_1 = Width of cutting channel

S_2 = Thickness of blade body

T = Tooth pitch

t = Number of teeth



Example of pinhole

4 / 9 / 50

4 Pinholes

9 mm Diameter each

50 mm Pitch circle

How to choose the right number of teeth? Our recommendation.

■ ● ■ Solid materials cutting application

Ø Circular Saw Blade [mm]	Ø Material [mm] Number of teeth [mm]														
	10	20	30	40	50	60	70	80	90	100	110	120	130	140	150
250	100	100	100 / 80	80 / 60	60 / 54	54									
285	120	120	100	80	72 / 60	60	60								
315		120	100	80	80 / 60	60	60	60							
360			120	100	80	80 / 72	60 / 50	50	50						
420 / 425			140	120 / 100	100 / 80	80	60	60 / 50	50	50	50	50	50		
460				120	100	80	80	60	60 / 50	60 / 50	50	50	50 / 40	50 / 40	50 / 40

○ Pipes cutting application

Ø Circular Saw Blade [mm]	Wall thickness [mm]	Ø Material [mm] Number of teeth [mm]													
		20	30	40	50	60	70	80	90	100	110	120	130	140	150
250	2-3	100	100	100	100	100									
	3-6	100	100	100	100	80									
	6-12	80	80	80	80	72									
285	2-3	120	120	120	120	120	120								
	3-6	120	120	100	100	100	100								
	6-15		100	100	80	80	72								
315	2-3		120	120	120	120	120	100	100						
	4-8		100	100	100	80	80	80	72						
	6-15			100	80	80	72	72	72						
360	3-6		120	120	120	100	100	100	100	80					
	6-12			100	100	80	80	80	72	72					
	10-20				100	80	80	72	60	60					
420 / 425	3-6				120	120	120	100	100	100	100	80			
	6-12						100	100	80	80	80	80			
	10-20							80	80	80	60	60			
460	6-12							100	100	100	100	80	80	80	80
	10-20							100	100	80	80	80	80	60	60

Safety instructions

WIKUS Circular Saw Blades are high performance tools. The safety instructions are strictly to be followed when using the blades.

- Be careful, the optimal cutting speed may not comply with the maximum allowed cutting values of the blade and the cross related machine speed values.
- Select only saw blades that are suitable for material being machined and machine being operated.
- Only qualified and experienced persons who are familiar with the circular saw blades are permitted to use them.
- Proceed with extreme care when unpacking, packing and handling the circular saw blades (e.g. installing it in the machine). There is a risk of injury from extremely sharp cutting edges!
- When handling the circular saw blades, wearing safety gloves provides a more secure hold and further reduces the risk of injury.
- Observe the safety warnings for your machine. Comply with the safety regulations that apply in your country.
- Circular saw blades with cracked bodies must be replaced. Repair is not permitted.
- Circular saw blades with a combination design (saw teeth soldered in) with saw tooth dimensions smaller than 2 mm may no longer be used.
- Do not use tools with visible cracks or blunt or damaged cutting edges.
- When sawing, ensure that the machine's feed direction is the same as the tool's cutting direction.

→ Wear suitable personal protective equipment:

- Ear protection
- protective eye goggles
- dust mask for work that generates dust
- protective gloves for working with rough materials and for changing tools

Installation and mounting

- Circular Saw Blades must be clamped in such a way that they cannot come loose during operation.
- When assembling the circular saw blades, it must be ensured that the clamping takes place on the tool hub or the clamping surface of the tool, and that the cutting edges do not come into contact with one another or the fixed clamps.
- Retaining screws and nuts must be tightened using suitable keys, etc. and with the torque specified by the manufacturer.
- The clamping surfaces must be cleaned to remove contamination, grease, oil and water.
- Clamping screws must be tightened according to the manufacturer's operating instructions.
- Only securely installed rings, e.g. rings that have been pressed in or those that are held in position by an adhesive bond, may be used to adjust the hole diameter of circular saw blades to the spindle diameter of the machine. The use of loose rings is not permitted.

Environment

- Do not dispose accessories in the household waste. Recycle accessories and packaging. Observe applicable national regulations.

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