

# BLADES BORN & BRED IN SWEDEN





*Every Håkansson Sågblad blade embodies the highest level of Swedish quality and decades of blade making innovation and expertise. They make all kinds of sawing applications faster, smoother and more cost effective than ever.*

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# TOUGHNESS. STRENGTH. RELIABILITY. THEY'RE THE DNA OF EVERY HÅKANSSON SÅGBLAD BLADE.

For nearly a century we have been producing some of the world's highest quality and most innovative bandsaw blades. Whether for metal, wood, food or a wide range of other materials including plastic and even ice, they offer you the typical Swedish qualities of toughness, strength and reliability to ensure optimum productivity wherever you use them.



Today, from our base in Åmål in the west of Sweden, we export our blades all over the globe. Each one is the result of decades of experience, competence and professionalism using the best raw materials and cutting-edge production methods.

But the blade is just the start. With Håkansson Sågblad you also access a superior world of service. Our experts will help you with any sawing issues or challenges you face. And if you work with other materials, we can even design bandsaw blades specifically for your business needs. Whatever the material, the result will always be the most economical cut and maximum life length of the blade.

## Over 75 years in the making



It all started in 1890 when Lars Håkansson patented a new heat treating method while working for a leading Swedish steel mill. Blade making was in the Håkansson blood and after Lars retired his son Gustaf took over to become a master of the craft.

In 1944 Gustaf joined with his brother Bror to set up Håkansson Sågblad – the first manufacturer outside of the USA specializing in hard-edge flexible back bandsaw blades. In 1946 Gustaf pioneered the high frequency ('induction') technique for bandsaw blade hardening and a few years later established the True Set Technique™ too while also developing bandsaw blade milling machines.

Over the years, Håkansson Sågblad has continued to grow and is still the sole Swedish manufacturer of bi-metal bandsaw blades. We celebrated our 75th anniversary in 2019 but have our eyes fixed on the future as we constantly set new standards for bandsaw innovation and quality.



# MEETING EXPECTATIONS. *EXCEEDING* EXPECTATIONS.

## Quality policy

We want our customers to see us as the best possible partner in terms of quality. Our aim is not simply to meet but to exceed their expectations.



### We guarantee world-leading quality standards by:

- producing and marketing technically advanced products at competitive prices
- delivering the right products on time
- encouraging employees to strive for quality in everything they do
- providing staff with accurate information and training so that they can perform their tasks
- ensuring that the company, our employees and our customers work as a team
- promoting cooperation with suppliers to ensure high quality levels and reliable delivery times
- adhering to the requirements of our ISO 9001 certification



## Environmental policy

We focus strongly on our environmental impact in terms of emissions, waste and resource use. Meeting all applicable environmental laws we set ourselves the highest goals both internally and externally.



### Our commitment to a healthy environment means:

- we comply with strict Swedish environmental legislation and take our responsibilities seriously
- we strive for continuous improvement in line with quality requirements and customer demands
- we take a holistic view to business development embracing environmental concerns as well as economic and technological opportunities.
- we regularly evaluate business operations from an environmental perspective in order to find improvements
- we adhere to the requirements of our ISO 14001 certification



A close-up photograph of a hand holding a bandsaw blade. The blade is dark and has a complex, wavy pattern of teeth. The hand is wearing an orange glove. The background is a blurred industrial setting.

# **METAL CUTTING** **BANDSAW BLADES**



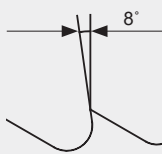


# ADVANTAGES WITH BI-METAL

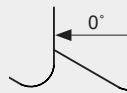
Bi-metal blades combine the advantages of a high speed steel cutting edge and the features of a highly fatigue resistant steel in the body of the blade. This contributes to long blade life, faster and more uniform cutting rates.

Håkansson Sågblad world-renowned heat-treatment experience gives us an excellent background to the development of this type of blade.

## PFV/PC



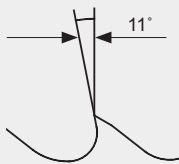
## FV



## M42 Allpower™

This is our most versatile band saw blade. It provides maximum production when cutting a variety of materials, from large profiles and solid materials to non-ferrous metals. Available in both positive and neutral tooth.

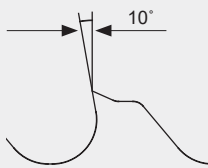
## PCV3



## M42 Commander™

For tough and demanding production cutting of tool steels, structural steels and difficult-to-cut materials. The specially designed tooth gives optimal chip flow and increased cutting speed when cutting solid materials.

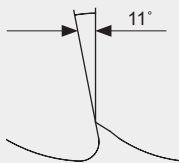
## PXV



## M42 Powermax™

This unique tooth profile is specially developed for pipes, beams, tubes and profiles. The reinforced tooth works extremely well when bundle cutting.

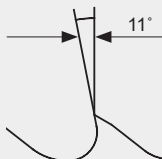
## POV2



## M42 Opimizer™

For production cutting of heavy sections in stainless, titanium and cobalt based materials. A special tooth profile provides maximum chip ejection.

## POV2 PCV3

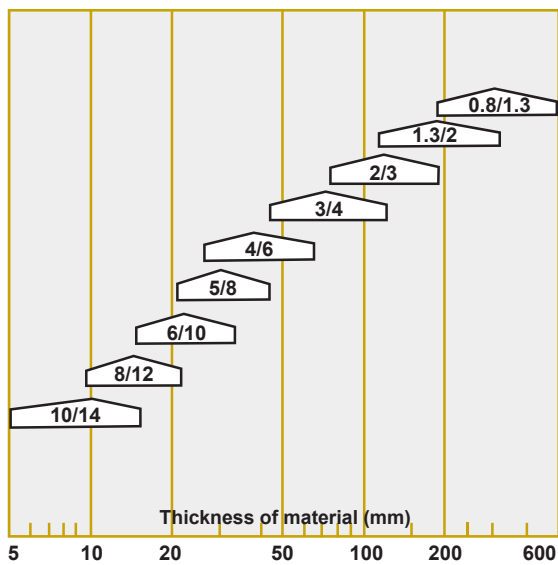


## M51 Performer™

A premium band saw blade for very difficult-to-cut material. The tooth tips are made of HSS M51 material. The blade's extra heavy set and deep gullet provides an increased cutting rate and it has an overall high heat and wear resistance.

# RECOMMENDED TOOTH PITCH

## Solid work piece



This diagram is a guide to help you choose the correct tooth pitch when cutting solid work pieces. The very best choice is where the tooth pitch-area is at its widest.

When cutting soft materials such as wood, plastics, aluminum etc. choose a two-step coarser tooth pitch.

## Tooth settings

### Raker set (RS)

One tooth is set to the right, the next to the left and the third is straight.

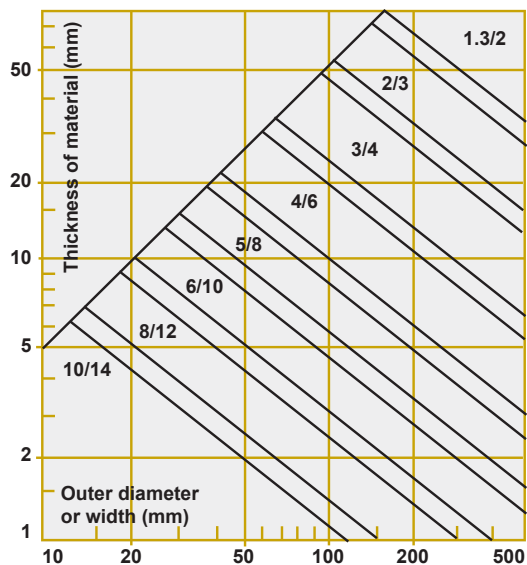
### Alternate set (AS)

This setting has one tooth set to the right, the following to the left, the next to the right and so on.

### Alternate rake (AR)

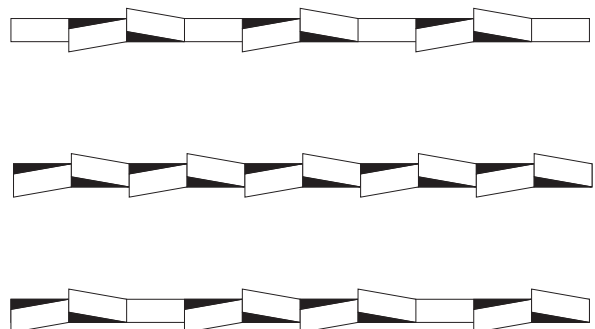
A group of AS set teeth is followed by a straight tooth.

## Pipes and profiles



This diagram is a guide to help you choose the correct tooth pitch when cutting pipes and profiles. The very best choice is in the area where a line from the outer diameter crosses a line from the thickness of the material.

When cutting profiles, choose the tooth pitch where the line from the width of the profile crosses the line from the material thickness of the profile.





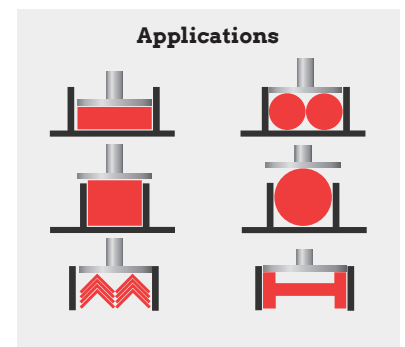
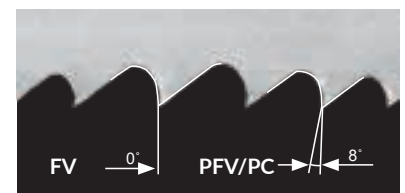
## ALLPOWER™

All-round blades that are well suited to different cutting methods and most materials such as tool steel, graphite, aluminum and stainless steel.



### M42 Allpower™ A versatile blade

- Our most popular all-round blade
- Suitable for production as well as non-production cutting
- Produced from HSS M42 steel and known for its consistency
- The popular choice from workshops to heavy industrial cutting
- A large variety of pitches available
- Tooth set AR



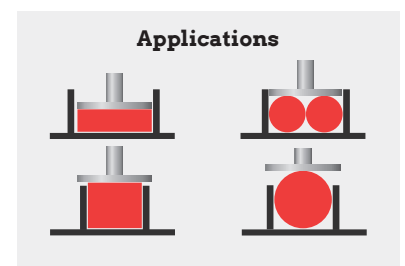
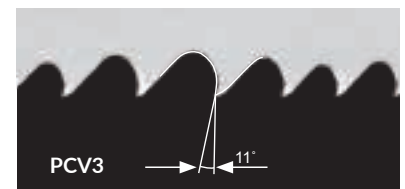
## COMMANDER™

Specially designed tooth shape with improved chip removal and the possibility of increased cutting speed.



### M42 Commander™ When high production is required

- The best choice for high rates of production
- Specially designed for optimal chip flow and increased cutting rate
- High wear resistance
- Produced from HSS M42 steel suitable for solid and tough materials

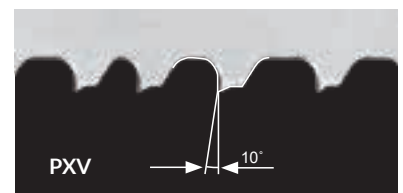


# M42 BI-METAL

Bi-metal blades combine the advantages of a high speed cutting edge and the features of a highly fatigue resistant steel in the body of the blade. This contributes to long blade life, faster and more uniform cutting rates. Our M42 bi-metal blades are made of the highest speed steel quality Cobalt M42 and are well suited to different cutting methods and most materials such as; tool steel, graphite, aluminum and stainless steel.

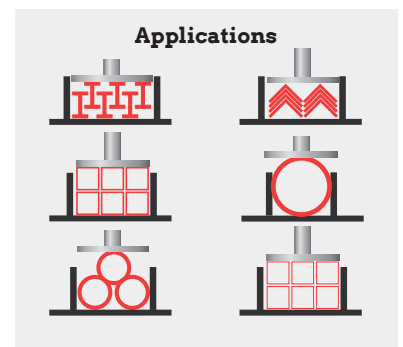
## POWERMAX™

Unique tooth profile specially developed for pipes and profiles.



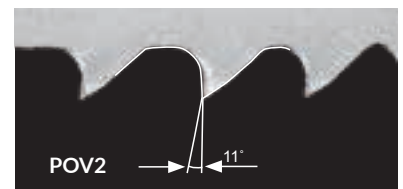
### M42 Powermax™ With a unique tooth design

- A completely different type of blade with a unique tooth design and setting pattern
- Results in high performance for interrupted cuts in structural steels like tubes, profiles and beams
- Shock resistant, reduces vibrations, noise level and tooth breakage
- Especially suitable for bundle cutting in one or multiple layers
- Tooth set AR



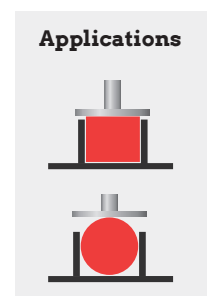
## OPTIMIZER™

For production creation in coarse homogeneous workpieces in stainless, Hastelloy, titanium or cobalt-based materials.



### M42 Optimizer™ For tough and demanding production

- Specially designed tooth for improved chip flow
- For tough and demanding production cutting
- Fast cutting of wide cross sections of ferrous and non-ferrous metals
- High heat and wear resistance
- Increased blade life when sawing in material that can harden if not consistently penetrated
- Tooth set AR
- For difficult to cut materials
- Higher cutting rate



# M51 BI-METAL

Our M51 bi-metal blades are made using a high-alloy backing material and an HSS M51 tooth tip.



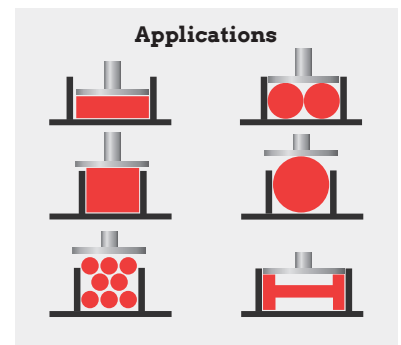
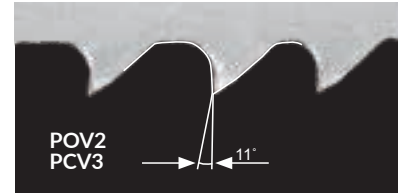
## PERFORMER™

Premium quality for extra hard-to-work materials.



### M51 Performer™ A higher toughness

- M51 HSS tooth
- Heavy set
- High wear and heat resistance
- Long and reliable tool life
- High shock resistance
- For difficult to cut materials
- Higher cutting rate
- Tooth set AR



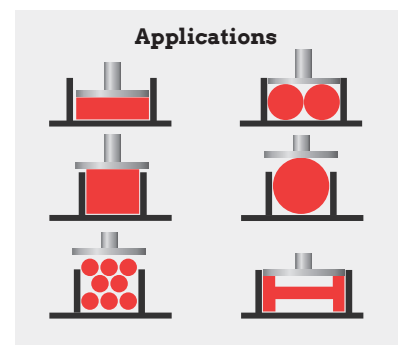
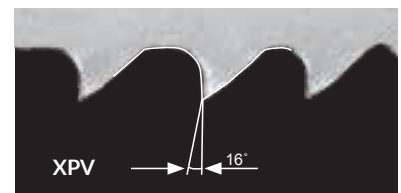
## PERFORMER X™

Premium quality with an extra heavy set for extremely hard to work materials.



### M51 Performer X™ Extra heavy set

- M51 HSS tooth
- Extra heavy set
- High wear and heat resistance
- Long and reliable tool life
- High shock resistance
- Suitable for high-alloy materials
- Improved chip flow
- Higher cutting rate
- Tooth set AR





## **RAPID CT10**

Specially designed for different types of steel and offering better chip separation for faster cutting.

### **Rapid CT10**

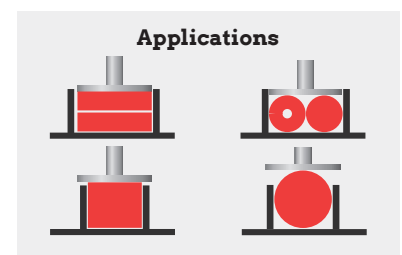
- Carbide tipped bandsaw blade for cutting tool steels, high speed steels and stainless steels
- The unique tooth geometry results in better chip separation, low noise and high cutting rates
- For faster cutting and excellent finish

## **RAPID CT20**

The unique setting of the CT20 makes it ideal for older machines liable to vibration.

### **Rapid CT20**

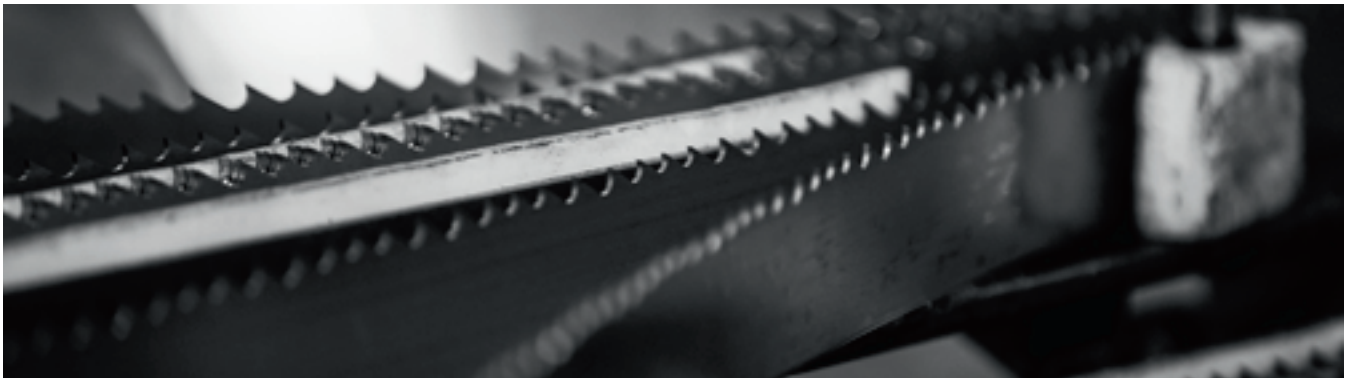
- Carbide tipped bandsaw blade with unique setting
- For cutting materials with residual stress
- Suitable for titanium, titanium alloys, and Ni-Cr based alloys
- Ideal for wider / thicker profiles





# CT CARBIDE

Blades tipped with Tungsten Carbide offer many advantages when cutting high hardness materials. They are more durable than conventional blades resulting in longer life and less time spent changing blades. In addition, they retain their sharpness better to give high performance for longer.



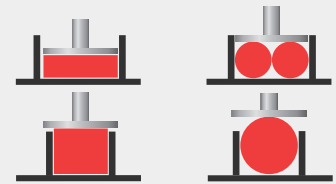
## RAPID CT30

Designed for long life especially when cutting non-ferrous materials including aluminum.

### Rapid CT30

- Carbide tipped bandsaw blade developed for cutting non-ferrous materials and especially aluminum
- The fatigue resistant alloyed steel backing withstands severe mechanical stress due to the high cutting speeds and feeds
- For high productivity and long blade life

#### Applications



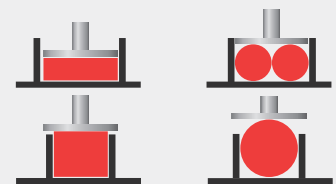
## RAPID CT40

The ideal blade for hardened and tempered or induction hardened materials.

### Rapid CT40

- Carbide tipped bandsaw blade with special design developed for cutting hardened and tempered or induction hardened materials
- For cutting materials with hardness between 50-60 HRc

#### Applications



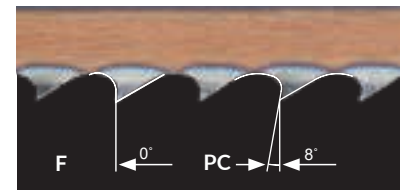
# **WOOD CUTTING** **BANDSAW BLADES**





## SILCO™

Suitable for sawing in wood, aluminium, brass, bronze, copper, lead, zinc, graphite, fiberglass, plastic and other non-ferrous materials.

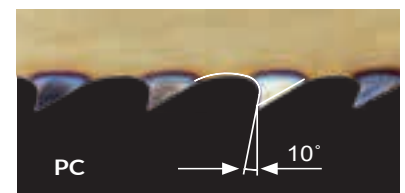


### Silco™

- Suitable for cutting wood, aluminum, brass, bronze, cast iron, copper, lead, zinc, graphite, fiberglass, plastic, cork and other non-ferrous metals
- Manufactured from high silicon steel
- High quality, flexibility and performance make the blade ideal for friction cutting
- Hardened tooth tip/flexible back
- Tooth set AR

## SILCO LOG™

Bandsaw blades specially made for log sawing in mobile sawmills.



### Silco LOG™

- Our most popular saw blade for portable sawmills
- Carbon steel with hardened teeth
- Produced from the best raw material with high silicon content
- Tooth set RS

\*Available in selected markets, please contact Håkansson Sågblad for availability.

# CARBON STEEL

Suitable for cutting not only wood but also aluminum, brass, bronze, copper, lead, zinc, graphite, fiberglass, plastic, cork and other non-ferrous metals.

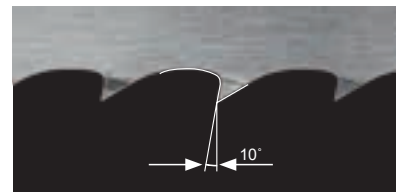
## SILVER LOG\*

Blades with hardened edges ideal for timber and pallet production.



### Silver Log PC

- Ground tooth with edge hardening for timber and pallet production
- Suitable for portable sawmills and pallet resaw



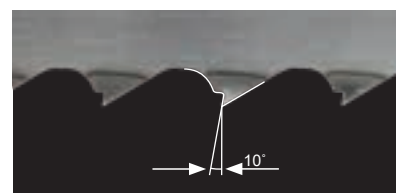
## SILVER LOG DUST REMOVER\*

Blade with unique tooth profile which reduces dust and increases cutting speed.



### Silver Log dust remover

- Ground tooth with edge hardening for cutting timber and boards
- Unique tooth profile for optimal dust removal
- Reduces the risk of mold
- Low setting for minimal waste and dust



## SILCO HOBBY

Extra thin and flexible bandsaw blades for small bandsaw machines with a small wheel diameter.

### Silco Hobby

- Extra flexible blade
- Specially designed for small bandsaw machines with small diameter wheels
- Tooth set AR

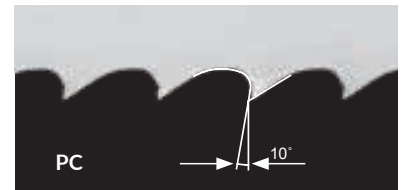
# HSS BLADES

All the performance advantages of a bi-metal blade including long life and high speed cutting in specially manufactured HSS blades for log pulling.



**M42 LOG™ HSS**

Perfect for portable sawing operations where speed is as high a priority as convenience.



### M42 Log™ A longer run time

- For portable sawmills
- The suitable choice where high production is required
- Specially designed for optimal chip flow and increased cutting rate
- High wear resistance
- HSS edge for longer run time between regrinding
- Tooth set RS





## **PRIMECUT®**

For all types of fresh or frozen meat.

### **Primecut®** **Longer blade life**

- For cutting all types of fresh or frozen meat, including bones
- Manufactured from best strip steel available
- Special sharp tooth that easily cuts through all types of meat and bones
- Minimum of material waste
- Longer blade life



## **SEACUT®**

### **Seacut®** **Minimum of material waste**

- For cutting frozen fish
- Manufactured from best strip steel available
- Special sharp tooth that easily cuts through all types of frozen fish
- Minimum of material waste
- Longer blade life

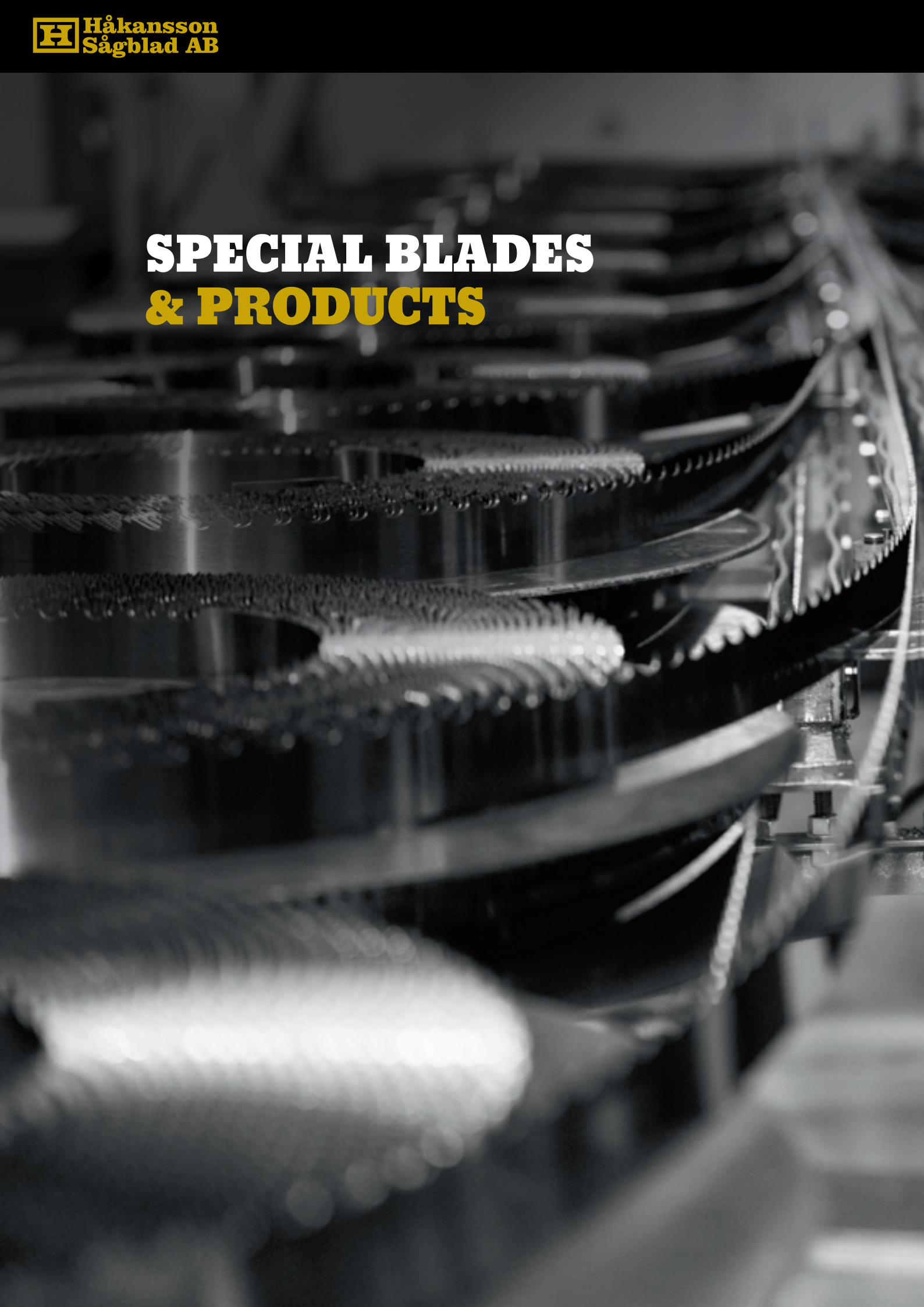


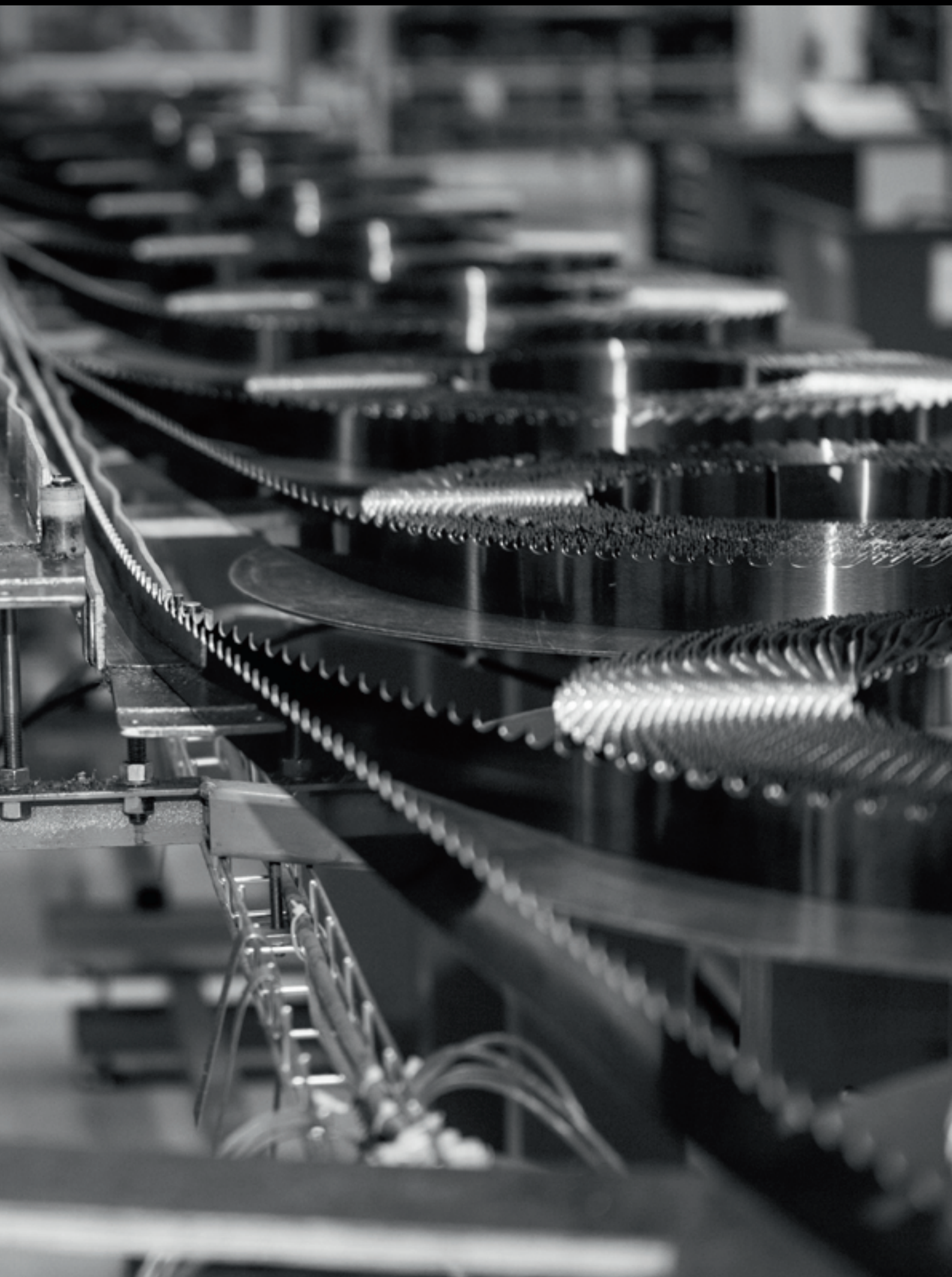


# FOOD CUTTING BANDSAW BLADES



# **SPECIAL BLADES** **& PRODUCTS**





# BAND KNIVES

## BAND KNIVES

Different edges designed to tackle different foods and materials with a clean and efficient cut.



### Straight edge

- For cutting soft and fibrous type of material
- It produces a smooth finish without tearing or producing ragged edges



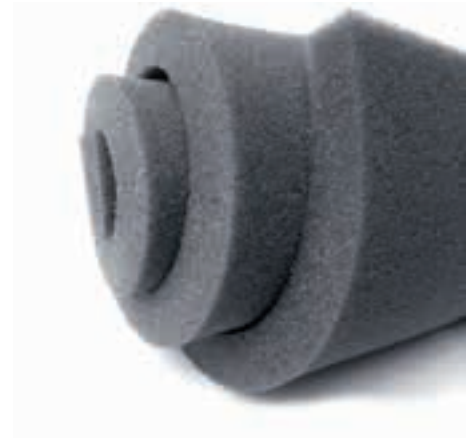
### Wavy edge

- For cutting cellulose sponge, bread, cake, rubber, seals, gaskets, leather, soft aluminum, corrugated stock, buffing wheels



### Scallop edge

- For cutting same material as wavy edge. Faster cutting performance, but somewhat rougher finish



# CARBIDE GRIT

Used for extremely hard material that cannot be cut using normal saw blades.

## CARBIDE GRIT-SE

Used for extremely hard materials that ordinary saw blades cannot handle.



### Carbide Grit - Straight edge Carbide grains soldered in place

- Instead of teeth, this saw blade has carbide grains soldered in place
- Used for extremely hard material that cannot be cut using normal saw blades
- Suitable for glass, fiberglass, titanium and nickel alloys
- Higher cutting rate
- Tooth set AR

## CARBIDE GRIT-GE

Used for extremely hard materials that ordinary saw blades cannot handle.



### Carbide Grit - Gulletted edge Suitable for composites

- Instead of teeth, this saw blade has carbide grains soldered in place
- Used for extremely hard material that cannot be cut using normal saw blades
- Suitable for composites, ceramics, wire, tires and hardened steels

# **USING OUR BANDSAW BLADES**





### **How to break in a bandsaw blade**

To achieve long blade life for any blade, it is important to break it in correctly.

#### **Bi-metal bandsaw blade**

Operate your new blade initially at 50% full feed rate for about 15 minutes. After that the feed rate may be slowly increased up to full speed.

#### **Carbide tipped bandsaw blade**

Operate initially at 75% full cutting speed and 50% feed rate for about 15 minutes. The cutting speed and feed rate can then slowly be increased up to the full rate.

# HOW TO ADJUST YOUR SAW

## Before operating the saw, check the following

- Consult our cutting chart for recommended feed and speed
- Teeth must be pointing in the right direction
- Check guides of bandsaw machine, also clearance between the guides and blade
- Hold material securely
- Check oil concentration of the coolant



## Recommended Band Tension

### Bi-metal M42

- up to an including 34 mm (1 3/4") in width
- from 41 mm (1 1/2") and wider

### Tension (metric)

- 1 800 - 2 500 kg/cm<sup>2</sup>
- 2 100 - 2 800 kg/cm<sup>2</sup>

### Tension (english)

- 25 000 - 35 000 PSI
- 30 000 - 40 000 PSI

### Silco, Silco-Log

1 000 - 1 400 kg/cm<sup>2</sup>

15 000 - 20 000 PSI

### Primecut and Hobby

1 400 - 1 800 kg/cm<sup>2</sup>

20 000 - 25 000 PSI

As a general rule of thumb, the higher end of the tension range should be used when the guide arms are further apart and the lower end of the range when the arms are closer together.

The above tension ranges are supplied as guide for normal average cutting conditions. Insufficient blade tension can affect the cutting efficiency of the blade.

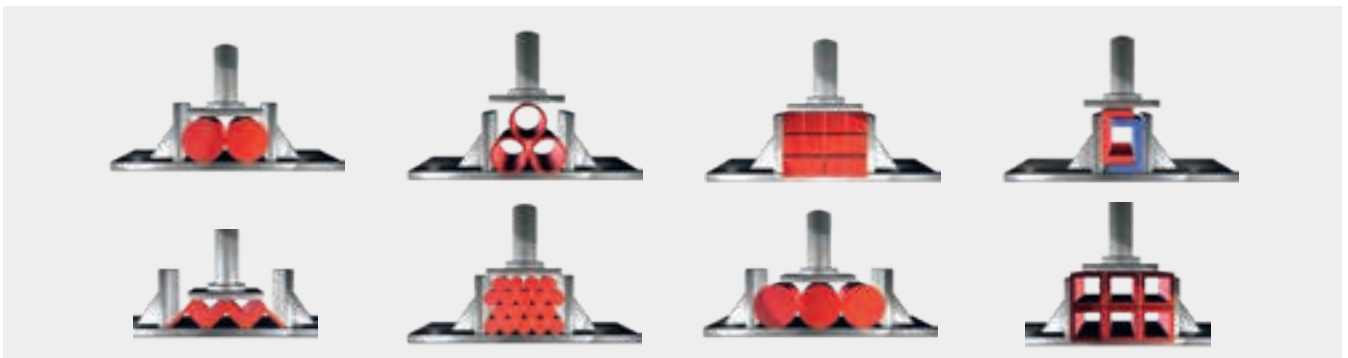




# HOW TO CLAMP

Recommendations for material clamping. The correct clamping of the material will considerably contribute to the performance of the sawing operation.

Please note the difference in clamping when using conventional bandsaw and double column horizontal machines.



## Tachometer

Digital tachometer showing the band speed in feet/min as well as m/min.



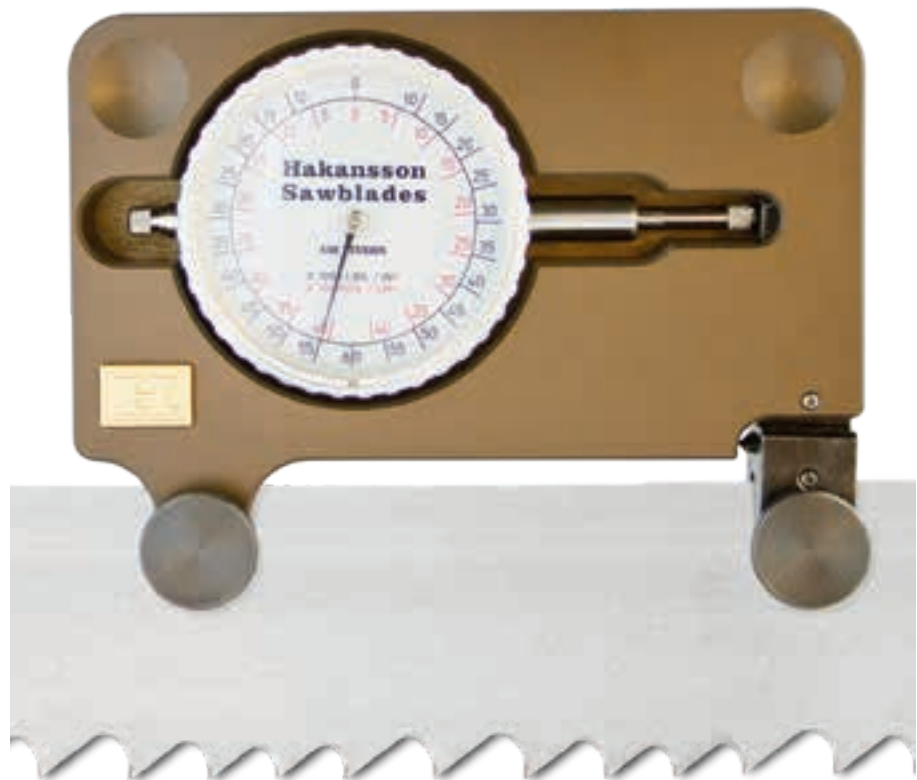
## Refractometer

Proper concentration of the cooling lubricants is of utmost importance for the cutting result.



## Tension Meter

Correct band tension is essential for straight cut and prolonged blade life.



# ACCESSORIES





### **Blades born & bred in Sweden**

With a history stretching back to 1890, Håkansson Sågblad is renowned in Sweden for its innovation and for producing the highest quality blades. And we remain the only Swedish manufacturer of bi-metal bandsaw blades. Whether for wood or metal, our products guarantee high efficiency, long life and reliable service. Today they are exported to over 73 countries in every corner of the world.

