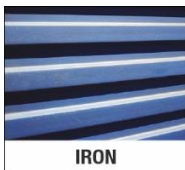
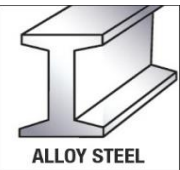


ECEF TECHNICAL SPECIFICATIONS

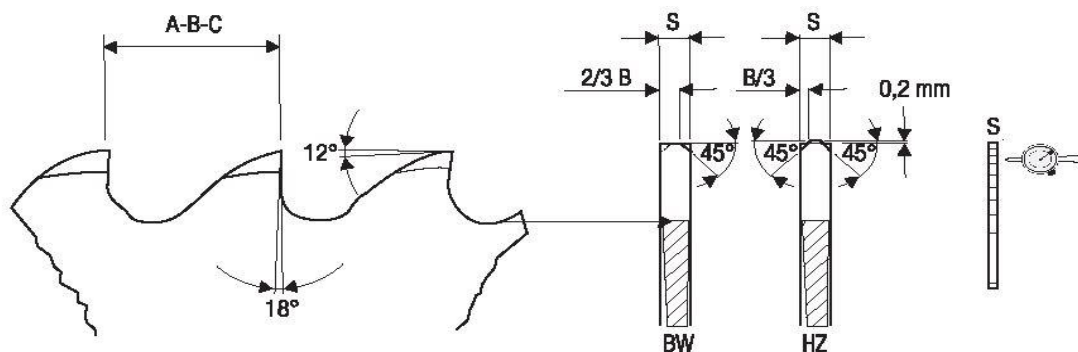
CIRCULAR SAW BLADES

FAMILY CLASSIFICATION	04160						
DESCRIPTION	HSS CIRCULAR SAW BLADE - AISI M2 DM 05 STEEL - STEAM TREATED FOR CUTTING METALS AND STEEL						
PRODUCT IMAGE							
BLADE SIZES	200	225	250	275	300	315	350
TEETH NUMBER	110-130-160	120-140-180	128-160-200	140-180-220	160-180-220	160-200-240	180-200-280
CENTRAL HOLE	32 mm						
KIND OF STEEL	DM05						
COMPOSITION	C 0,90 - Si 0,20 - Mn 0,20 - Cr 4,00 - Mo 5,00 - W 6,40 - V 1,90 C=Carbon - Si=Silicon - Mn=Manganese - Cr=Chrome - Mo=Molybdenum - W=Tungsten - V=Vanadium						
HARDENING TEMP.	1180°-1230°						
HARDNESS	63 - 65 HRC						
MANUFACTURING PROCESS	Cold blanking and milling/grinding of the teeth. Geometric shape with computerized system (CAO), that grants quality control and product homogeneity.						
SHARPENING	2 DIFFERENT TOOTH PROFILES; HZ and BW 3 DIFFERENT DISTANCES OF THE TEETH: A- COARSE TOOTHING - for solid bars cut B- MEDIUM TOOTHING - for cutting on solids and profiles C- FINE TOOTHING - for cutting on profiles						
SURFACE TREATMENT	black finish by steam oxidation						
WORK PIECE MATERIALS	IRON - LIGHT STEEL - LIGHT ALLOY STEEL - METALS METALS WITH RESISTANCE $R \leq 600 \text{ N/mm}^2$     						
REFERENCE TOOL	For CUTTING MACHINES with slow speed and 2 speed variator. The circular saws blades have 6 drag holes in addition to the central hole for each type of machine: 2 holes 8 mm distant from each other 45 mm - 2 holes 9 mm (distance 50 mm) - 2 holes 11 mm (distance 63 mm) -						
PACKAGE	IN SINGLE CARDBOARD BOX						

ECEF TECHNICAL SPECIFICATIONS

CIRCULAR SAW BLADES

FAMILY CLASSIFICATION 04160

TECHNICAL
DRAWING OF THE
TEETH DETAIL

CUTTING SPEED CONVERSION TABLE - ROUND/MINUTE - DIAMETER

Work piece material	Feed speed Mt/sec.	Cutting speed Mt/minute	
Steel R<500 N/mm ²	15÷25	70÷100	
Steel R<800 N/mm ²	10÷15	25÷35	
Steel R<1000 N/mm ²	5÷10	30÷40	
Steel R<1400 N/mm ²	5÷7	15÷25	
Stainless steel	5÷7	25÷35	
Cast Iron	10÷15	50÷70	
Aluminum	20÷40	70÷150	
Brass e bronze	20÷40	70÷150	
Copper	20÷40	70÷150	
Plastic	20÷50	100÷200	

PERSONAL SECURITY WARNINGS*Always use safety glasses**In case of loud noise wear ear protection**Always wear protective gloves*