



Benxi Tool Co., Ltd

Products Details

New Version

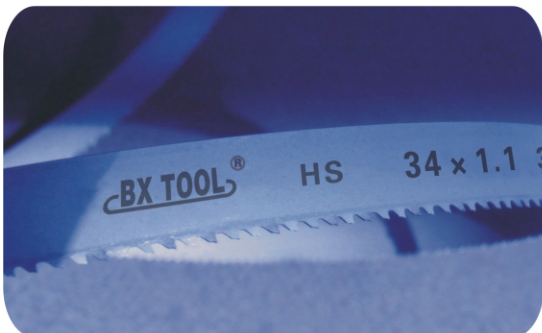
Which Blade Do You Prefer



**Carbide Tipped Band
Saw Blade**



**M51 Bi-metal Band
Saw Blade**



**HS Bi-metal Band
Saw Blade**



**M42 Bi-metal Band
Saw Blade**

M42-B

M42-X

M42-C

M42-D

What Products Do You Prefer

Carbide Tipped Band Saw Blade

- High Nickel Chrome Alloys
- Ti / Titanium Alloys
- Heat Resistant steels
- High Temperature Alloy Steels
- Aluminum, and for high speed cutting of Aluminum Alloys
- Other cutting application that M42 blade cannot be used



M51 Bi-metal Band Saw Blade

- Titanium / Titanium Alloys
- Alloy Tool Steels
- Other hard cutting materials
- Stainless Steels
- High Speed Steels



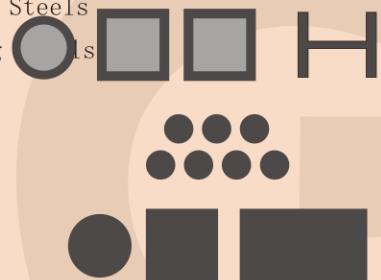
HS Bi-metal Band Saw Blade

- Tool Steels
- Abrasive Tool Steels
- Stainless Steels



M42 Bi-metal Band Saw Blade

- Stainless Steels
- Die Steels
- Bearing Steels
- Structural Steels
- Quality Carbon Steels
- Other Metal and Non Metal Materials
- Alloy Tool Steels
- Spring Steels
- Copper
- Graphite
- Aluminum



We also can produce Neutral Brand and customer requested brand!!

Which Kind of Materials Do You Cut?




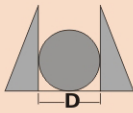
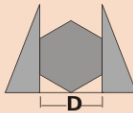
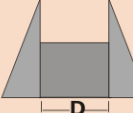
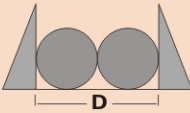
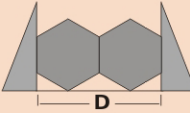
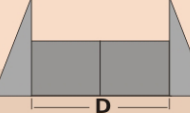
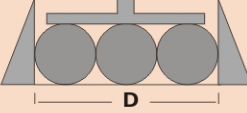
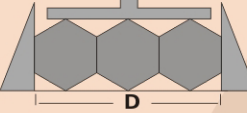
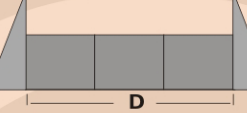
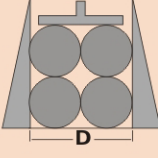
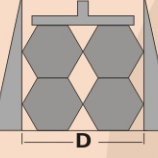
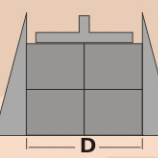
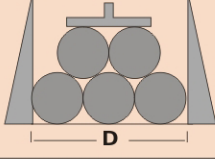
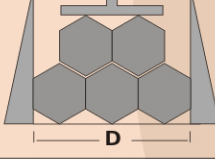
(Choose our band saw brand)

Steel Name	Normal Grade for Cutting Materials	Brand
Carbon Steel	20#, 25#, 45#, 50#, 60#, 70#, 75#, 80#, 90#..	M42
Structural Steel	Q235(A3) , Q345..	M42
Alloy Steel	20Cr, 40Cr, 35CrMo, 42CrMo, 16Mn, 25Mn..	M42
Tool Steel	W16, W10, W18..	HS
Die Steel	Cr12, 9SiCr, 5CrMnMo, SM45, H13..	M42
Stainless Steel	304,316,2Cr13,3Cr13..	M51 M42 HS
High-temperature Alloy Steel and Hard Cutting Materials	GH1015, GH1035, GH2018..	Carbide Tipped Band Saw Blade
	Titanium Alloy,Nickel-base Alloy, Process Hardening Stainless Steel, Surface Hardened Steel	Carbide Tipped Band Saw Blade

What Do You Want to Cut?

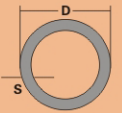
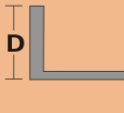
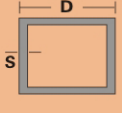

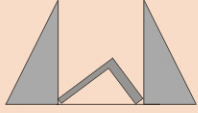
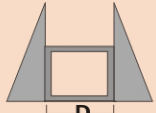
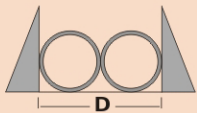
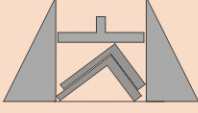
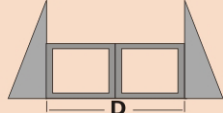
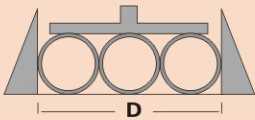

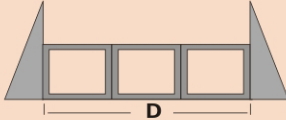
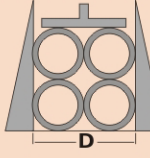
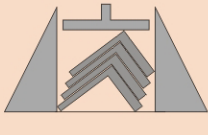
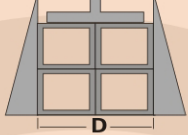
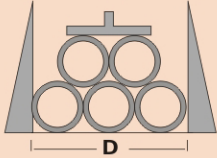
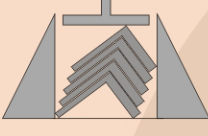

(for solid materials)

D(mm)	TPI
≤30	5/8T
30-90	4/6T
100-200	3/4T
200-300	2/3T
300-500	1/1.25T
>500	0.75/1.25T

 Round Bar	 Hexagonal Bar	 Square Steel
		
		
		
		
		

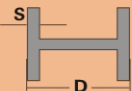


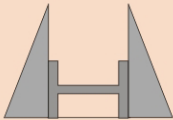

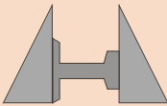
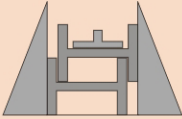
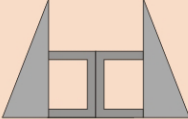
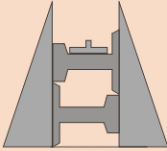
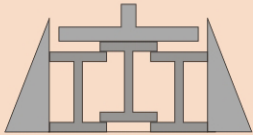
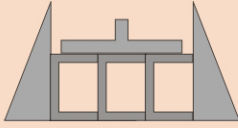
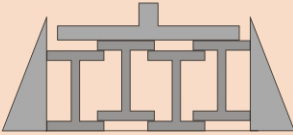
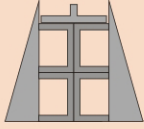
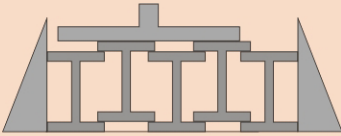
What Do You Want to Cut?

(for tubes and profiles)

 Pipes	 L Shaped Steel	 Square Tubes
		
		
		
		
		

What Do You Want to Cut?

(for tubes and profiles)

 H Shaped Steel	 Channel-section Steel	 Rail Steel
		
		
		
		
		

What Do You Want to Cut? (for tubes and profiles)

The diameter of 20mm							
Wall Thickness(MM)	2-8						
TPI	14T						
The diameter of 40mm							
Wall Thickness(MM)	2-8	3-6	8	10-12			
TPI	14T	10/14T	8/12T	6/10T			
The diameter of 60mm							
Wall Thickness(MM)	2	3-5	6	8-10	12		
TPI	14T	10/14T	8/12T	6/10T	5/8T		
The diameter of 80mm							
Wall Thickness(MM)	2	3-6	8	10	12-20	30	
TPI	14T	8/12T	6/10T	5/8T	4/6T(T)	3/4T	
The diameter of 100mm							
Wall Thickness(MM)	2	3-4	5-8	10	12-20	30	
TPI	10-14T	8/12T	6/10T	5/8T	4/6T(T)	3/4T	
The diameter of 150mm							
Wall Thickness(MM)	2	3	4-5	6-8	12-20	15-30	50
TPI	10-14T	8/12T	6/10T	5/8T	4/6T(T)	3/4T	2/3T
The diameter of 200mm							
Wall Thickness(MM)	2	3-4	5-8	10-12	15-20	30-75	
TPI	10-14T	6/10T	5/8T	4/6T(T)	3/4T	2/3T	
The diameter of 300-400mm							
Wall Thickness(MM)	2	3	4	5-10	12-20	30-75	75-100
TPI	10-14T	6/10T	5/8T	4/6T(T)	3/4T	2/3T	1.4/2.0T
The diameter of 500mm							
Wall Thickness(MM)	2	3	4-8	10-12	15-30	50-75	100-150
TPI	8-12T	6/10T	4/6T(T)	3/4T(T)	2/3T	1.4/2.0T	0.75/1.25T

What Size Do You Need

TPI	tooth form	M42							
		13 × 0.6	19 × 0.9	27 × 0.9	34 × 1.1	41 × 1.3	54 × 1.6	67 × 1.6	80 × 1.6
		1/2 × 0.025	3/4 × 0.035	1 × 0.035	1 1/4 × 0.042	1 1/2 × 0.050	2 × 0.063	2 5/8 × 0.063	3 5/8 × 0.063
12/16	N ■	■		■					
14	N ■	■	■	■					
10/14	N ■	■	■	■					
8/12	N ■	■	■	■					
6/10	N ■		■	■					
6	N ■	■		■					
5/8	N ■		■	■	■				
5/8	NR ■			■	■				
4/6	N ■			■					
4/6	NR ■		■	■	■	■			
4/6	NR ■			■	■	■			
4/6	NR ■			■	■				
4	N ■			■	■				
3/4	N ■			■					
3/4	NR ■		■	■	■	■			
3/4	NR ■			■	■	■	■		
3/4	BR ■				■				
3/4	NR ■			■	■				
3/4	NR ■					■			
3/4	BR ■			■	■				
3/4	BR ■								
2/3	NR ■			■			■		
2/3	BR ■					■			
2/3	NR ■				■				
2	NR ■			■			■		
1.4/2.0	BR ■					■	■	■	
1.4/2.0	BR ■					■			
1/1.5	BR ■							■	
1.25	BR ■					■	■	■	
1/1.25	BR ■					■	■	■	
1/1.25	BR ■					■	■	■	
0.75/1.25	BR ■						■	■	■

Special teeth form is available to meet your requirements.

What Size Do You Need

TPI	tooth form	M51				
		27 × 0.9	34 × 1.1	41 × 1.3	54 × 1.6	67 × 1.6
		1 × 0.035	1 1/4 × 0.042	1 1/2 × 0.050	2 × 0.063	2 5/8 × 0.063
4/6	NR ■	■				
3/4	N ■	■				
3/4	NR ■	■	■	■		
3/4	NR ■	■	■	■		
3/4	NR ■		■			
2/3	NR ■				■	
2	NR ■				■	
1.4/2.0	BR ■			■	■	
1.4/2.0	BR ■					■
1/1.5	BR ■					■
1.25	BR ■				■	■
1/1.25	BR ■			■	■	■
1/1.25	BR ■			■	■	■
0.75/1.25	BR ■				■	■

TPI	tooth form	CARBIDE					
		27 × 0.9	34 × 1.1	41 × 1.3	54 × 1.6	67 × 1.6	80 × 1.6
		1 × 0.035	1 1/4 × 0.042	1 1/2 × 0.050	2 × 0.063	2 5/8 × 0.063	3 5/8 × 0.063
3/4	BR ■	●▲	●▲	●▲	●▲		
2/3	BR ■	●▲	●▲	●▲	●▲		
1.4/2.0	BR ■		●▲	●▲	●▲	●▲	●▲
1/1.25	BR ■				●▲		●▲
0.75/1	BR ■				●▲	●▲	●▲

- --Normal Tooth(constant or variable pitch) (NT)
- --Back Angle Tooth(BT)
- --Turtle Back Tooth(TT)
- --Protective Tooth(PT)
- --Flat Gullet Tooth(FT)
- --Combine Tooth(CT)

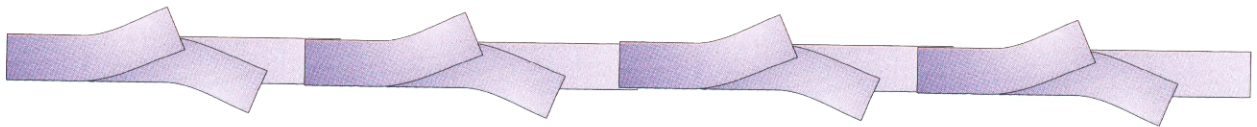
- N --Null Raker
- NR--Normal Raker
- BR--Bigger Raker

- --Setting Tooth
- ▲ --Non-setting Tooth

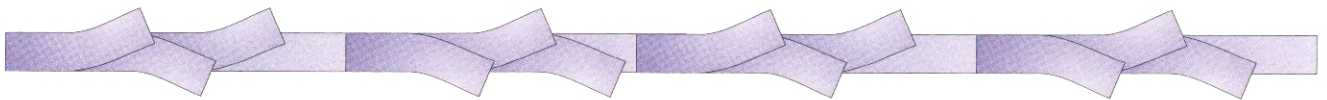
Special teeth form is available to meet your requirements.

Teeth Set Way

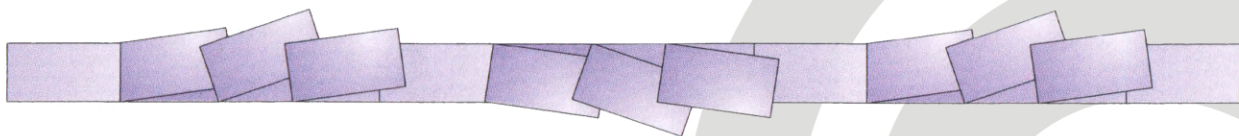
Standard Set









Right Left Set



Wavy Set



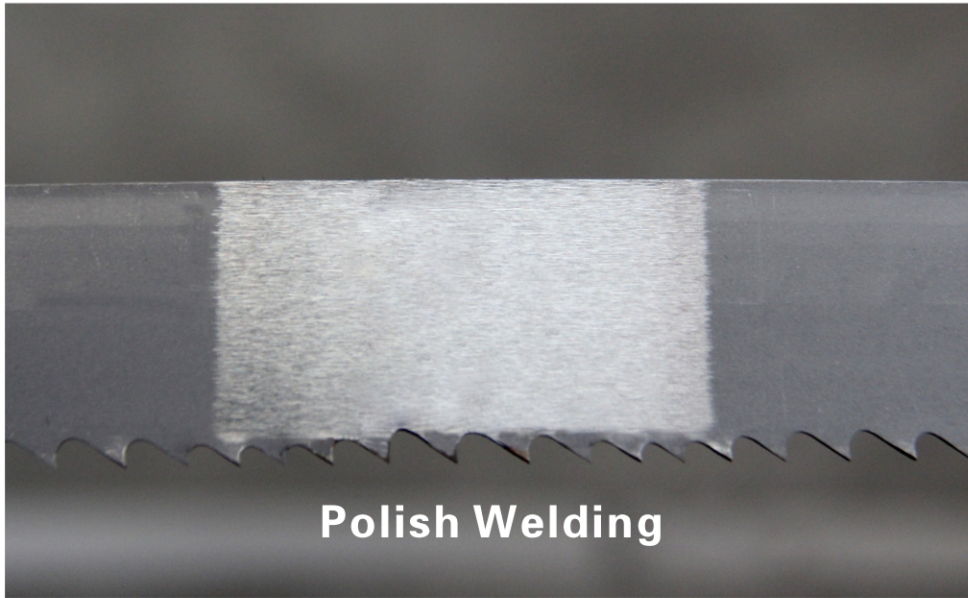
Paint Marks on Blade (for Coils)

CT		CT	27 × 0.9	2/3	NT	014A452CDE7501
M51		M51	27 × 0.9	4/6	TT	014A452CDE7501
HS		HS	34 × 1.1	3/4	PT	014A452CDE7501
M42-B		M42-B	27 × 0.9	4/6	TT	014A452CDE7501
M42-X		M42-X	27 × 0.9	4/6	PT	014A452CDE7501
M42-C		M42-C	27 × 0.9	3/4	FT	014A452CDE7501
Neutral		M42	27 × 0.9	4/6TT		014A452CDE7501

Paint Marks on Blade (for Welding Pieces)

CT	BX TOOL	CT	27 × 0.9	2/3	NT	014A452CDE7501	3505
M51	BX TOOL	M51	27 × 0.9	4/6	TT	014A452CDE7501	3505
HS	BX TOOL	HS	34 × 1.1	3/4	PT	014A452CDE7501	3505
M42-B	BX TOOL	M42-B	27 × 0.9	4/6	TT	014A452CDE7501	3505
M42-X	BX TOOL	M42-X	27 × 0.9	4/6	PT	014A452CDE7501	3505
M42-C	BX TOOL	M42-C	27 × 0.9	3/4	FT	014A452CDE7501	3505
Neutral		M42	27 × 0.9	4/6TT		014A452CDE7501	3505

Welding Part



Before



Now



Teeth Protect Plastic Cover

CT
(white)

BX TOOL

CT 27×0.9 2/3 NT 014A452CDE7501 3505

M51
(white)

BX TOOL

M51 27×0.9 4/6 TT 014A452CDE7501 3505

HS
(orange)

BX TOOL

HS 27×0.9 4/6 PT 014A452CDE7501 3505

M42-B
M42-X
M42-C
M42-D

BX TOOL

M42-X 27×0.9 4/6 TT 014A452CDE7501 3505

Neutral
(white)

M42 27×0.9 4/6 TT 014A452CDE7501 3505

The teeth protect plastic cover for neutral brand, you can choose one colour of above plastic covers.



Package for Coils



CARBIDE TIPPED BAND SAW BLADE
<http://en.liontool.com.cn>

BX TOOL®

HIGH SPEED
 HIGH QUALITY
 HIGH EFFICIENCY

WARNING
 Use gloves!
 Gloves are to be worn to avoid the risk of burns or mechanical injuries.
 Use eye protection!
 A pair of safety spectacles with side protection should be sported to avoid the risk of injury to the eyes from flying particles.
 Warning against cut injury!
 The risk of suffering cut injuries exists when handling sharp-edged materials.

Passed ISO 9001:2008 Quality Management System Certification

M51 BI-METAL BAND SAW BLADE
<http://en.liontool.com.cn>

BX TOOL®

HIGH SPEED
 HIGH QUALITY
 HIGH EFFICIENCY

WARNING
 Use gloves!
 Gloves are to be worn to avoid the risk of burns or mechanical injuries.
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M42 BI-METAL BAND SAW BLADE
<http://en.liontool.com.cn>

BX TOOL®

HIGH SPEED
 HIGH QUALITY
 HIGH EFFICIENCY

WARNING
 Use gloves!
 Gloves are to be worn to avoid the risk of burns or mechanical injuries.
 Use eye protection!
 A pair of safety spectacles with side protection should be sported to avoid the risk of injury to the eyes from flying particles.
 Warning against cut injury!
 The risk of suffering cut injuries exists when handling sharp-edged materials.

Passed ISO 9001:2008 Quality Management System Certification

HS BI-METAL BAND SAW BLADE
<http://en.liontool.com.cn>

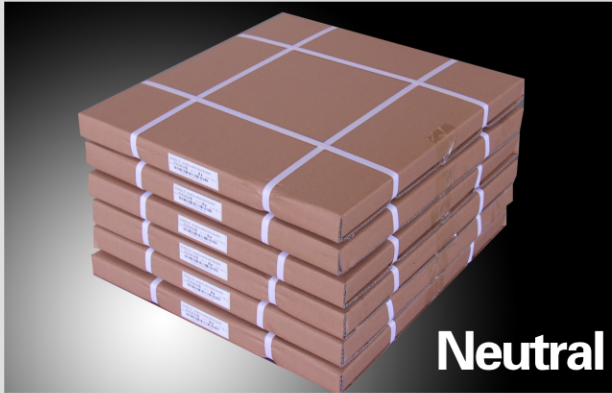
BX TOOL®

HIGH SPEED
 HIGH QUALITY
 HIGH EFFICIENCY

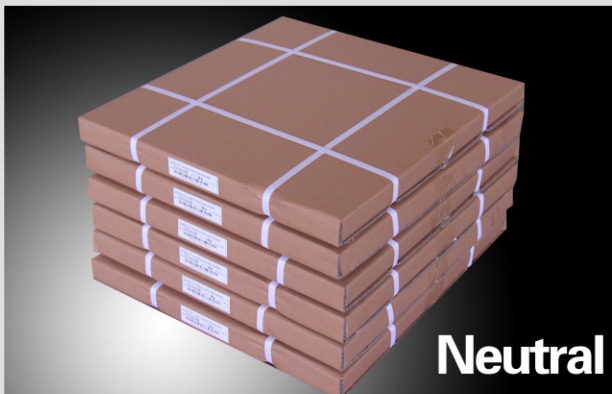
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Passed ISO 9001:2008 Quality Management System Certification

Neutral Package

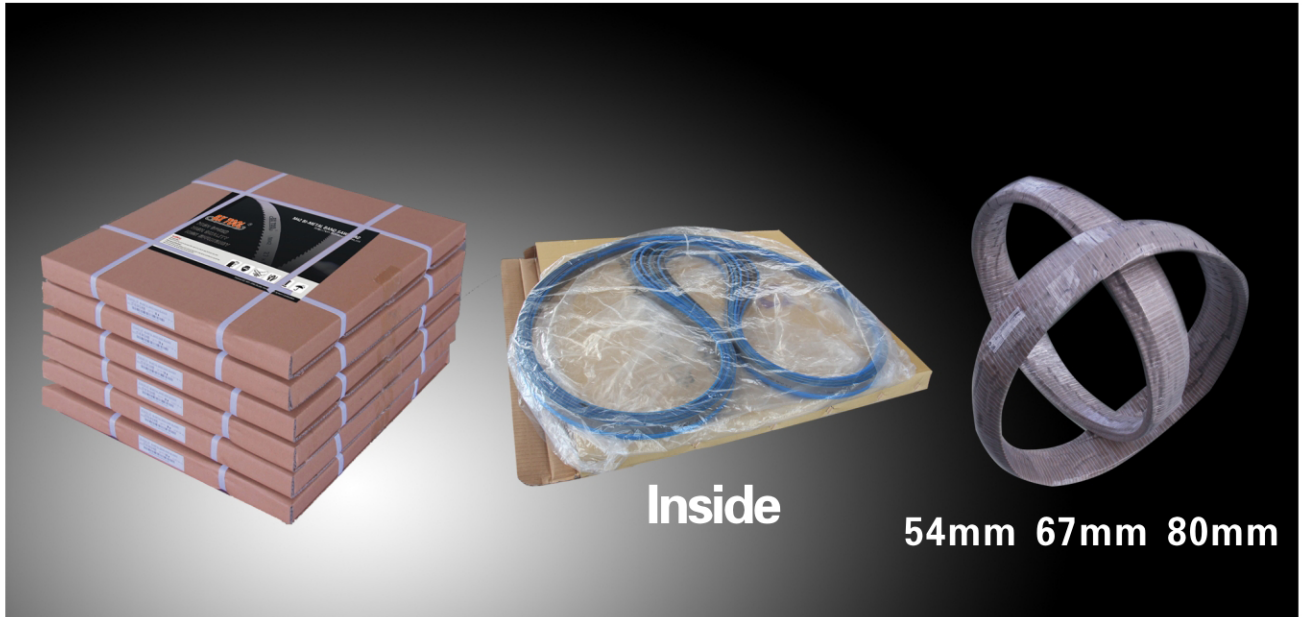


Coils



Welding Pieces

Package for Welding Pieces



CARBIDE TIPPED BAND SAW BLADE
<http://en.liontool.com.cn>

BX TOOL®

HIGH SPEED
 HIGH QUALITY
 HIGH EFFICIENCY

WARNING
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 Warning against cut injury!
 The risk of suffering cut injuries exists when handling sharp-edged materials.

Passed ISO 9001:2008 Quality Management System Certification

M51 BI-METAL BAND SAW BLADE
<http://en.liontool.com.cn>

BX TOOL®

HIGH SPEED
 HIGH QUALITY
 HIGH EFFICIENCY

WARNING
 Use gloves!
 Gloves are to be worn to avoid the risk of burns or mechanical injuries.
 Use eye protection!
 A pair of safety spectacles with side protection should be sported to avoid the risk of injury to the eyes from flying particles.
 Warning against cut injury!
 The risk of suffering cut injuries exists when handling sharp-edged materials.

Passed ISO 9001:2008 Quality Management System Certification

M42 BI-METAL BAND SAW BLADE
<http://en.liontool.com.cn>

BX TOOL®

HIGH SPEED
 HIGH QUALITY
 HIGH EFFICIENCY

WARNING
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 Gloves are to be worn to avoid the risk of burns or mechanical injuries.
 Use eye protection!
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 The risk of suffering cut injuries exists when handling sharp-edged materials.

Passed ISO 9001:2008 Quality Management System Certification

HS BI-METAL BAND SAW BLADE
<http://en.liontool.com.cn>

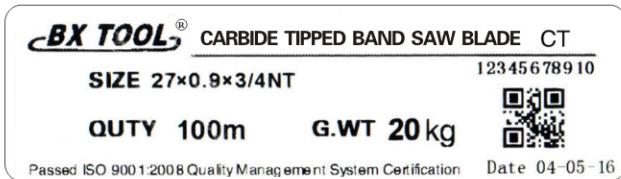
BX TOOL®

HIGH SPEED
 HIGH QUALITY
 HIGH EFFICIENCY

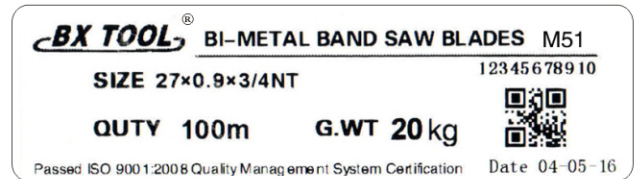
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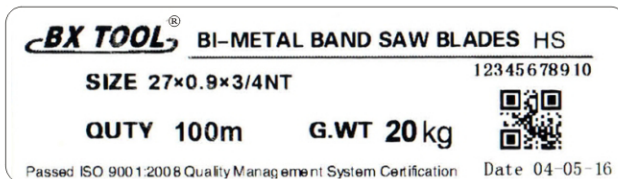
The Labels on Outside Package (for Coils)



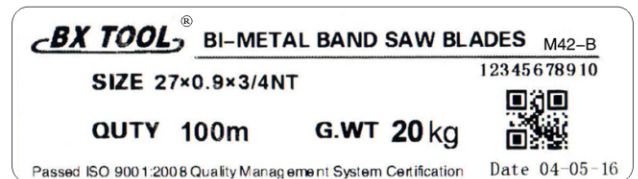
CT



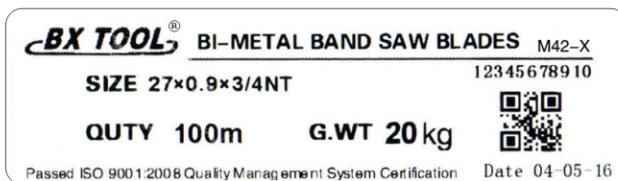
M51



HS



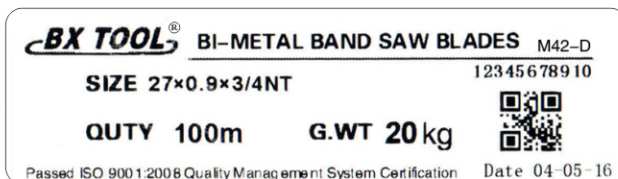
M42-B



M42-X



M42-C



M42-D



Neutral

The Labels on Outside Package (for Welding Pieces)

BX TOOL® CARBIDE TIPPED BAND SAW BLADE CT
 SIZE 27×0.9×3/4NT×3505 12345678910
 QUTY 10 pc G.WT 6 kg
 Passed ISO 9001:2008 Quality Management System Certification Date 04-05-16

CT

BX TOOL® BI-METAL BAND SAW BLADES M51
 SIZE 27×0.9×3/4NT×3505 12345678910
 QUTY 10 pc G.WT 6 kg
 Passed ISO 9001:2008 Quality Management System Certification Date 04-05-16

M51

BX TOOL® BI-METAL BAND SAW BLADES HS
 SIZE 27×0.9×3/4NT×3505 12345678910
 QUTY 10 pc G.WT 6 kg
 Passed ISO 9001:2008 Quality Management System Certification Date 04-05-16

HS

BX TOOL® BI-METAL BAND SAW BLADES M42-B
 SIZE 27×0.9×3/4NT×3505 12345678910
 QUTY 10 pc G.WT 6 kg
 Passed ISO 9001:2008 Quality Management System Certification Date 04-05-16

M42-B

BX TOOL® BI-METAL BAND SAW BLADES M42-X
 SIZE 27×0.9×3/4NT×3505 12345678910
 QUTY 10 pc G.WT 6 kg
 Passed ISO 9001:2008 Quality Management System Certification Date 04-05-16

M42-X

BX TOOL® BI-METAL BAND SAW BLADES M42-C
 SIZE 27×0.9×3/4NT×3505 12345678910
 QUTY 10 pc G.WT 6 kg
 Passed ISO 9001:2008 Quality Management System Certification Date 04-05-16

M42-C

BX TOOL® BI-METAL BAND SAW BLADES M42-D
 SIZE 27×0.9×3/4NT×3505 12345678910
 QUTY 10 pc G.WT 6 kg
 Passed ISO 9001:2008 Quality Management System Certification Date 04-05-16

M42-D

BI-METAL BAND SAW BLADES M42-X
 SIZE 27×0.9×4/6CT×3505 12345678910
 QUTY 10 pc G.WT 6 kg
 Date 04-05-16

Neutral

Final Package for Shipment



Package for Welding Pieces (Blade Length ≤ 3000 mm for Width 27mm and 19mm)



How to Choose Speed

Workpiece material	Specification Cutting paramete (mm)	27	34	41	54	67
Structural steel	Cutting speed m/min	70-80	60-70	50-60	45-50	40-50
	Cutting rate cm/min	50-60				
Middle/Low steel	Cutting speed m/min	65-80	55-70	50-65	40-55	
	Cutting rate cm/min	45-55				
Hardness and tempered steel	Cutting speed m/min	55-70	50-65	45-60	40-55	
	Cutting rate cm/min	40-50				
Bearing steel Spring steel tool steel	Cutting speed m/min	40-55		35-50	30-45	
	Cutting rate cm/min	30-40			25-35	
Die steel High speed tool steel	Cutting speed m/min	35-45	30-45	25-40		20-35
	Cutting rate cm/min	25-35			20-30	
Stainless steel Heat-resistant steel	Cutting speed m/min	35-45		25-40		20-35
	Cutting rate cm/min	20-30				
Aluminum alloys	Cutting speed m/min	80-150			60-80	
	Cutting rate cm/min	70-150				
Copper alloys	Cutting speed m/min	60-90			40-60	
	Cutting rate cm/min	45-50			30-40	
Profile steel	Cutting speed m/min	50-80			45-65	
	Cutting rate cm/min	40-70			30-50	

Trouble Shoot and Solutions

Problems	Possible Causes	Solutions
Cut slanting	Badly running in, earlier teeth passivation	Properly running in at the beginning of blade using
	High speed and feed rate	Properly choose the cutting speed and feed by the material of workpiece
	Imporper cooling(Unnormal rate of liquid flow)	Properly amend the flow of cutting liquid and compounding oncentration
	Wrong choose TPI	Choose TPI by the diameter of workpiece
	Blade tesion too small(Imporper adjustment of blade tesion)	Properly adjust blade tension
	Saw guides arm too far apart	Choose the width of guides arm basic on the diameter of workpiece
	Jaw and workpiece are not tight	Adjust jaw tension of band saw machine
Broken teeth or loose teeth	New blade not run in and feed rate too high	Properly running in at the beginning of blade using
	Wrong choose TPI, chips block the gullet	Choose TPI by the diameter of workpiece
	At the beginning of cutting, blade not steady with workpiece. Teeth break by impact force during fast go down	Properly choose the cutting speed and feed by the material of workpiece
	There is slag inclusions in workpice	Change the workpiece or change another kurf
Chips block the gullet	Improper compounding oncentration of cutting liquid	Properly formulate the compounding oncentration of cutting liquid
	Problem with wire brush	Adjust wire brush or change the bursh
	Wrong choice of tooth type	Properly choose the tooth type by the shap and size of workpiece

Band Saw Balde Brands Application Introduction

BRANDS	M42-C (M42-D)		M42-X		M42-B		M51-B	
	Universal Use	Cutting Hard Series	Universal Use	Cutting Hard Series	Universal Use	Cutting Hard Series	Universal Use	Cutting Hard Series
Copper Aluminum, Non-ferrous metals	T1, H65, 1050		T1, H65, 1050		T1, H65, 1050			T1, H65, 1050
Carbon Steel	10, 20, 25, 35		10, 20, 25, 35	60, 70, 65Mn, 70Mn	30, 35, 40, 50	60, 70, 65Mn, 70Mn		
Structural Steel	Q235, Q195, Q345		Q235, Q195, Q345	Q235, Q195, Q345	Q235, Q195, Q345	Q235, Q195, Q345		
Low Alloy Steel	40Cr, 35CrMo (annealed)	40Cr, 35CrMo (tempering)	40Cr, 35CrMo (annealed)	40Cr, 35CrMo (tempering)	40Cr, 35CrMo (annealed)	40Cr, 35CrMo (tempering)		
Bearing Steel	GCr15, GCr20 (annealed)	GCr15, GCr20 (tempering)	GCr15, GCr20 (annealed)	GCr15, GCr20 (tempering, hot rolling)	GCr15, GCr20 (annealed)	GCr15, GCr20 (tempering)	GCr15, GCr20 (tempering)	
Die Steel	Cr12, H13, A2, D2 (annealed)	9Mn2V, Cr12Mo1V, DC53	Cr12, H13, A2, D2 (annealed)	9Mn2V, Cr12Mo1V, DC53 (tempering)	Cr12, H13, A2, D2	9Mn2V, Cr12Mo1V, DC53	9Mn2V, Cr12Mo1V, DC53 (forging)	9Mn2V, Cr12Mo1V, DC53 (forging)
Tool Steel	T8, T10, M2 (annealed)	W18Cr4V, M42, M2 (tempering)	T8, T10, M2 (annealed)	W18Cr4V, M42, M2 (tempering)	T8, T10, M2 (annealed)	W18Cr4V, M42, M2 (tempering)	W18Cr4V, M42, M2 (forging)	W18Cr4V, M42, M2 (forging)
Stainless Steel	304, 310, 410	316L, 310, 420 (solution treatment)	304, 310, 410	316L, 310, 420 (solution treatment)	304, 310, 410	316L, 310, 420 (solution treatment)	316L, 310, 420 (solution treatment)	316L, 2080, 18 (solution treatment)
Titanium Alloy						TA1, TA2, TA3	TA1, TA2, TA3	TA1, TA2, TA3, TA15, TB2
High Temperature Alloy							GH1015, GH1036, GH4169	GH1015, GH1036, GH4169
Hardened steel							45, 20CrMnTi, 42CrMo (surface hardened)	45, 20CrMnTi, 42CrMo (surface hardened)
Graphite	2390, 590, LC300-99.9	2390, 590, LC300-99.9	2390, 590, LC300-99.9	2390, 590, LC300-99.9	2390, 590, LC300-99.9	2390, 590, LC300-99.9	2390, 590, LC300-99.9	2390, 590, LC300-99.9

Available

Applicative

Inapplicable