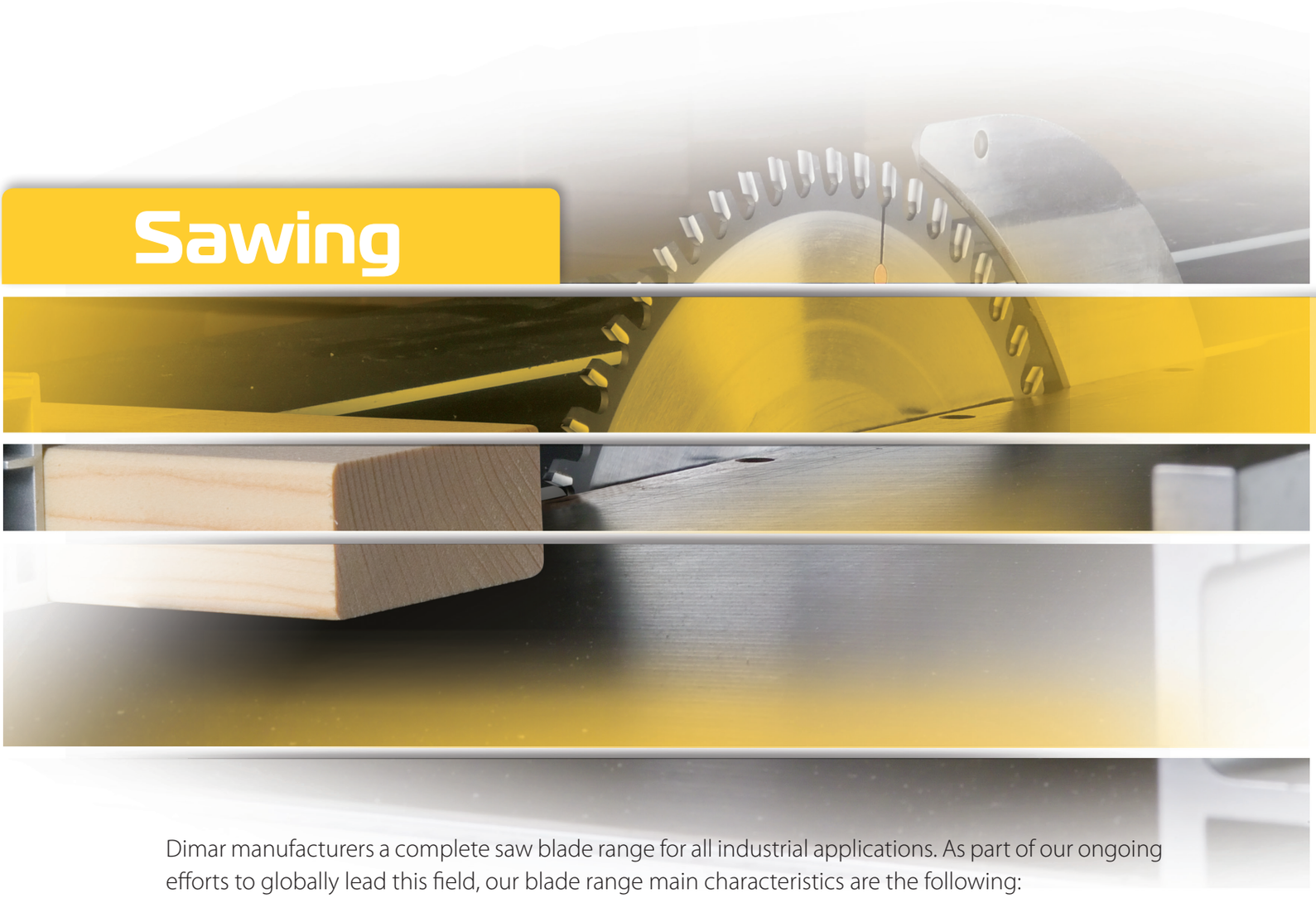
Sawing



Dimar manufacturers a complete saw blade range for all industrial applications. As part of our ongoing efforts to globally lead this field, our blade range main characteristics are the following:

- Advanced grades of carbide to suit cutting requirements
- Made by fully Automatic, precise grinding machines.
- Distinctive technology ensuring straightening, balancing & tension.
- Coating, derived from Micro Technology of Electro static process.

All of the above lead to Max. performance, extra ordinary cutting quality & proved longer life time.

Sawing **INDEX**

Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

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Solid Wood | Boards | Plastic | Aluminum | Metal

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Sawing

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Solid Wood


Boards

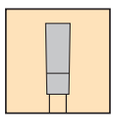

Plastic


Aluminum

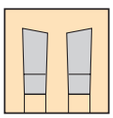

Metal

Technical Information

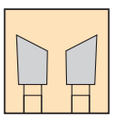
Grinding Type



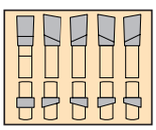
Flat top (FT)
For cutting soft and hard wood along the grain (Ripping).



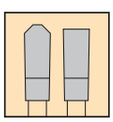
Alternate top bevel (ATB)
For: 1. cross cutting of soft and hard wood
2. cutting plywood and veneered boards



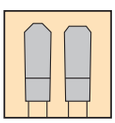
Higher alternate top bevel
For chip free cutting on a table saw of melamine coated boards.



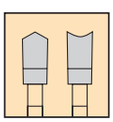
Alternate Combination of Top & Face bevel.



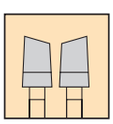
Triple chip (TCG)
For cutting man made particle boards coated and non coated.



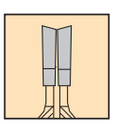
Trapez Trapez Grinding (TTG)
For cutting Thick particle boards Material with or without Coating.



Hollow ground (HG)
For: 1. cross cutting of soft and hard wood.
2. cutting plywood and veneered boards.
3. cutting man made particle coated board.s
4. cutting plastic boards.



ATB cone form (Conical) for scoring application.



Adjustable alternate top bevel
For Scoring application.

Sawing


Solid Wood


Boards


Plastic

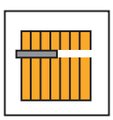

Aluminum


Metal

Technical Information

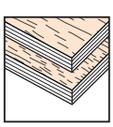
Application:

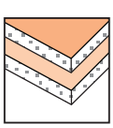

Cutting solid wood along the grain.

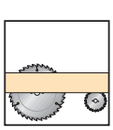

Cutting solid wood across the grain.

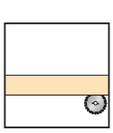

Across & along.
Cutting along and across the grain of solid wood panel materials.

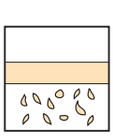

Solid Wood

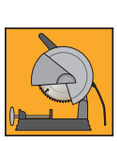

Laminate board (plywood)
Single board or stacked.


Coated particle board (Chip board MDF, HDF) Single board or stacked.

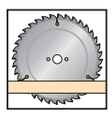

Saw blades for panel sizing machines.

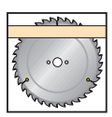

Scoring saws for table saw or panel sizing machines.


Hogging saw blades scoring saws and segments for hogging units.


Saw blades for metal cutting machines.

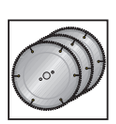
Additional Options


Negative hook angle.
Include 0 deg .
For over arm machines.


Positive hook angle for table saw machines.

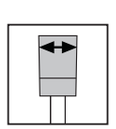
Balancing
Unique balancing procedure according to ISO 1940 performed on special dedicated balancing machines, for best performance as a result of minimal vibrations.

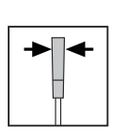

Dynamic straightness
Fully automated high performance dynamic operation for straightening the saw, assuring long-lasting straightness, life-time and cutting quality.


Can be used for multi rip sawing operation.
For single and double spindle machines.


Chip limiter body design for hand feed operation.


Wipers included to prevent locking the saw body by the wood with or without chip limiters.


Thick kerf for shoulder cut and tilted angle cut .


kerf engery saving and wood yield by reducin ing widths.


Wet
Cutting wet wood


Low vibration body design

Sawing


Solid Wood


Boards


Plastic


Aluminum


Metal

Material Type	Application	Grinding Type	Hook Angles	Additional Opptions
Solid Wood				
Boards				
Plastic				
Aluminum				
Metal				

Sawing


Solid Wood

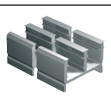

Boards


Plastic

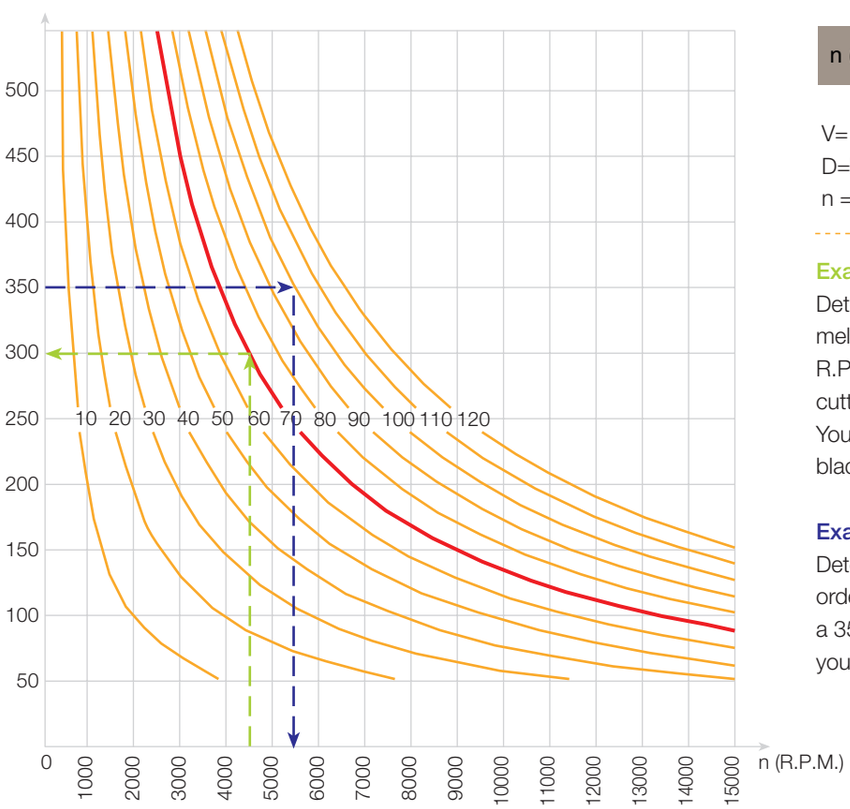

Aluminum


Metal

Determining Cutting Speed

Material		Cutting Direction	Cutting speed in(m/sec
 **Natural wood**	Soft Wood	along across	60 -100 61 -100
	Hard Wood	along across	62 -100 63 -100
	Veneers	along across	64 -100 65 -100
 **Boardes**	Plywoods		50 -80
	MDF		60 -100
	Particle Board With Pvc Coating		60 -80
	Particle Board With Melamine Coating		61 -80
	Particle Board With Veneer Coating		62 -80
	High Pressure Laminated Particle Board		63 -80
	Soft Fiber Board		70 -100
	Cemented Bonded Board		50 -80
	Hard Paper / Hard Fiber		45 -70
 **Plastic**	Duroplastic Board, Corian		15 -50
	High Pressure Laminated Bakelite		30 -70
	Thermoplastic Profiles		50 -80
 **Aluminum**	Aluminum Profiles		40 -70

Determining Saw Blade Diameter or R.P.M.



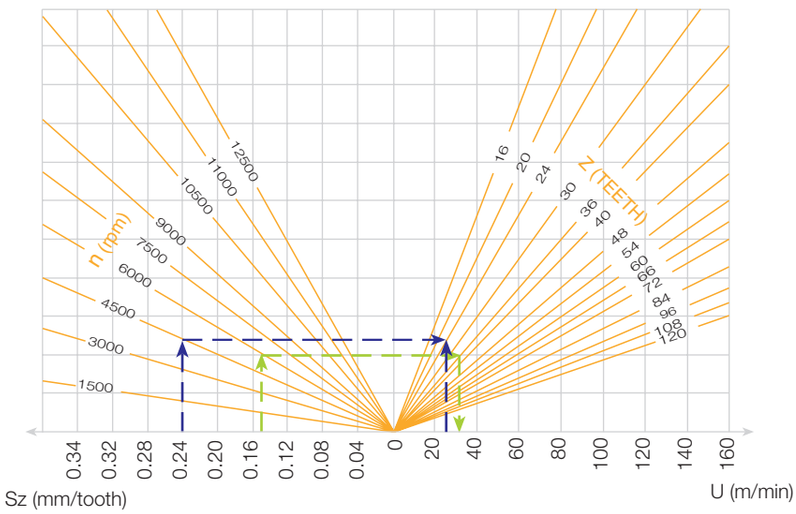
$$n\ (rpm) = \frac{1000 \cdot 60 \cdot V}{\pi \cdot D}$$

V= Speed $\frac{M}{sec}$
D=Diameter mm
n = Spindle R.P.M.

Example 1:
Determining the saw diameter to cut melamine coated chipboard with a 4500 R.P.M. diameter saw blade with 70 m/s cutting speed.
You should use a 300mm diameter saw blade.

Example 2:
Determining the r.p.m. to the machinery in order to cut at a speed of 100m/sec with a 350m saw.
you should work with 5,500 R.P.M.

Determining Number of Teeth / Finding Feed Rate



Example 1:

Determining Feed Rate

Solid wood - chip size 0.15

r.p.m. - 6000

Number of teeth - 36

You should use Feed Rate - 32m/min

Example 2:

Determining number of teeth

Solid wood - chip size 0.24

r.p.m. - 4500

Feed - 22m/min

Therefore the number of teeth - 24

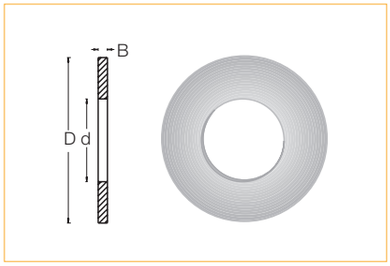
Saw Blade Flanges

Saw Blade Diameter	30mm	40mm	60mm	80mm	100mm	120mm	150mm
180 = <190	50/40	80/60	80/60	-	-	-	-
190 = <300	80/60	80/60	80/60	120/90	140/110	-	-
300 = <400	120/90	120/90	120/90	120/90	140/110	160/130	200/160
400 = <450	120/90	120/90	120/90	140/110	140/110	160/130	200/160
450 = <550	140/110	140/110	140/110	140/110	140/110	160/130	200/160
550 = <630	160/130	160/130	160/130	160/130	160/130	160/130	200/160
630 = <800	200/160	200/160	200/160	200/160	200/160	200/160	200/160

The size of the flange is determined by the saw blade diameter and bore diameter

Recommended Feed Rates Sz (mm/tooth)

Meterial	
Solid wood	0.10 - 0.20
Chipboard and plywood	0.05 - 0.25
Boards with plastic lamination	0.03 - 0.06
Boards veneered on both sides	0.03 - 0.08
Hardboard	0.03 - 0.08
Duroplastic boards	0.02 - 0.05
Thermoplastic boards	0.05 - 0.08



Saw Blade Bushings

Code No.	D	d	B	Code No.	D	d	B
1929280	19	15.9	1.8	1929185	30	19	1.8
1929125	20	12.7	1.6	1929240	30	19.05	1.8
1929030	20	13	1.6	1929090	30	20	1.8
1929040	20	15	1.8	1929230	30	22	1.8
1929200	20	16	1.8	1929120	30	25	1.8
1929210	22	19	1.8	1929220	30	25.4	1.8
1929050	22	20	1.8	1929165	32	15.9	1.8
1929175	25	16	1.8	1929290	32	16	1.8
1929100	25	20	1.8	1929250	32	20	1.8
1929260	25.4	16	1.8	1929130	32	25	1.8
1929170	25.4	18	1.8	1929150	32	25.4	1.8
1929270	25.4	19	1.8	1929135	32	30	1.8
1929145	25.4	20	1.8	1929105	35	20	1.8
1929110	30	12	1.8	1929140	35	30	1.8
1921040	30	12.7	1.8	1929295	38	32	1.8
1929080	30	15	1.8	1929190	40	25	1.8
1929160	30	15.9	1.8	1929195	40	30	1.8
1929180	30	16	1.8	1929297	40	32	1.8

Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

Technical Information

D COAT™

This technology of electrostatic coating provides thinner, yet stronger coating along with unified thickness over the body & teeth. Further, it reduces friction during operation enabling longer cutting time & power reduction.

The coating will protect the body from rust & resin while offering blade's longer life due to the protection of key properties at the saw body.

The coating is environmental friendly – we do not utilize any harmful chemicals.

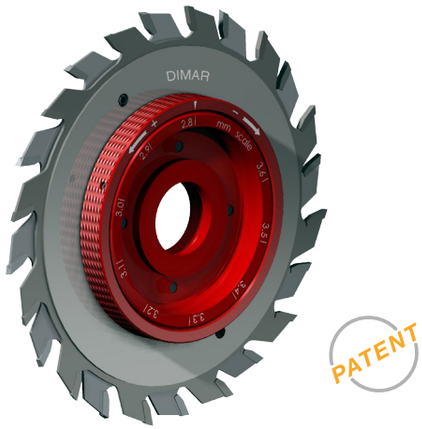
D LEADER™

Unique patent scoring saw allowing quick adjusting by using a dial. Adjustment can be done while scoring saw is mounted on a machine.

Removes the need for measuring, testing & adjusting to obtain a correct width as well as eliminates the need for spacers rings.

Fully adjustable increments of 0.1mm, adjustable kerf size starts from 2.8mm to 3.6mm. Also available in 120mm & 125mm diameter with 20 or 25mm bore.

It has been designed to use with a majority of available machines.



Dmax™ Technical Information

Dmax™ Range Of Saw Blades

Dimar's DMAX™ range of saw blades provide Max. performance & longer product life time.

Dmax™ Carbides & Grinding

We use micro grain carbides for superior wear resistance. Teeth's surface quality is at the highest level to ensure maximum sharpness of the cutting edge.

Dmax™ Saw's Body Properties

The straightening of the saw is carried out with an assistance of advanced automated technology which does not involve human touch as well as not leaving hammering marks. An automated operation adjusts the tension on the saw body to make it suitable for cutting boards & exotic wood.

Dmax™ Balancing

Static balancing is carried out on each saw to maintain the stability of the saw and produce a clean cut.

DMAX™

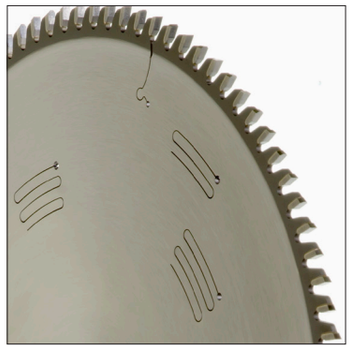
Unique, long life saw cutting blade made for chipboard & playwood cutting with/without coating. Teeth produced from special micro-grain quality carbide, thus durable against wear while working with abrasive material. It is intended for table saw & panel sizing machines. It's straightening maintained for a long period due to unique method which does not harm the structure of the saw body steel. With the use of static balancing, increased stability is ensured to preserve the machine bearings.

DMAX™+

Unique, long life saw cutting blade for cutting MDF, HDF (coated/uncoated) as well as high quality clean chipboard. Teeth are produced from special ultra-micro-grain quality carbide which is highly durable against erosion while working with such materials. This saw type is intended for table saw & panel sizing machines. It's straightening maintained for a long period due to unique method which does not harm the structure of the saw body steel. With the use of static balancing, increased stability is ensured to preserve the machine bearings.

DTOP™

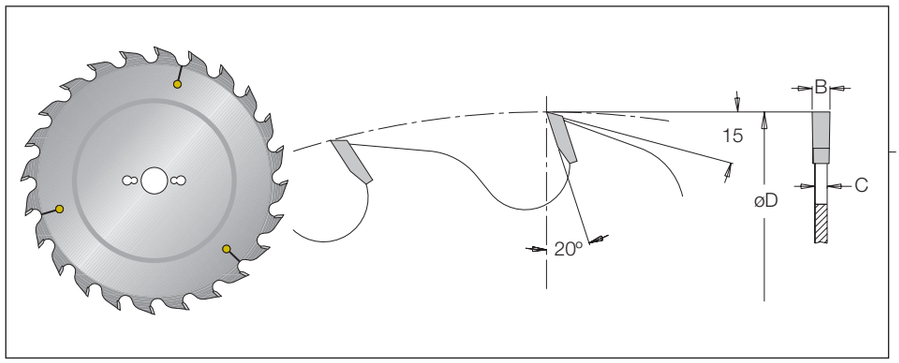
Saw blade for cutting laminated chipboards and MDF.
The saw teeth produced from special micro-grain quality carbide that is durable against erosion when working with abrasive materials.
The geometry of the grinding angles (5° hook angle) aims to make it suitable for hand feed working with such materials.
Saw body has been designed to reduce vibration & noise of the saw contributing to a more stable and clean cutting. The saw is straightened with a unique method which does not harm the structure of the saw body steel. Usage of static balancing ensures greater stability to preserve the bearings of the machine.

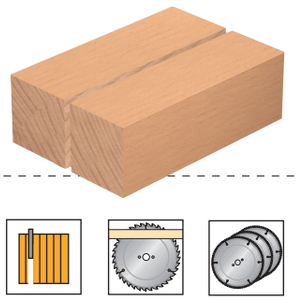


Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

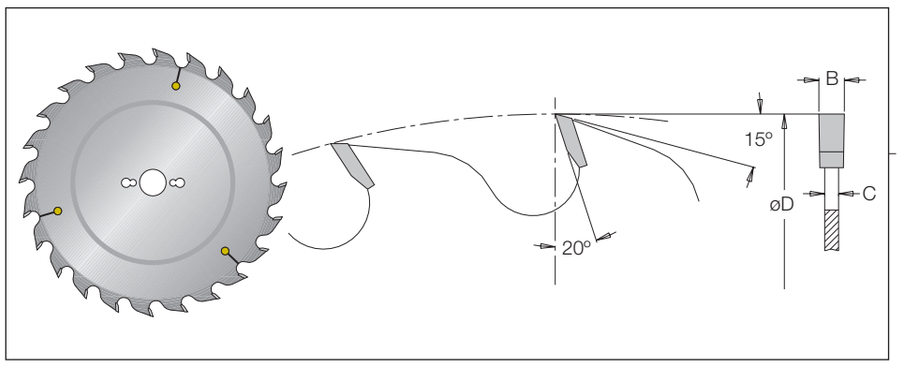
MF - Rip Saw Blade

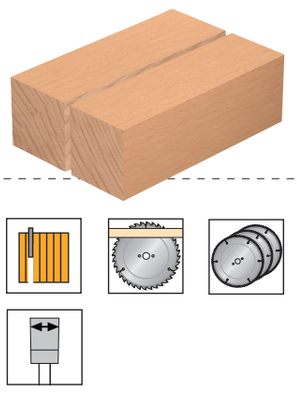




øD	Teeth	Code No.	B	c	n	m/min	ød
250	20	90100306	3.2	2.2	4500-7600	14-23	30
	24	90100406	3.2	2.2	4500-7600	16-27	30
300	24	90100506	3.2	2.2	3800-6300	14-23	30
	24	90100500	3.2	2.2	3800-6300	17-28	70
	30	90100606	3.2	2.2	3800-6300	17-28	30
350	28	90100706	3.5	2.5	3200-5400	13-23	30
400	32	90100806	3.5	2.5	2800-4500	13-22	30
450	32	90100846	4.0	2.8	2500-4000	12-19	30
500	36	90100856	4.4	3.0	2200-3500	12-19	30

MFT - Rip Saw Blade



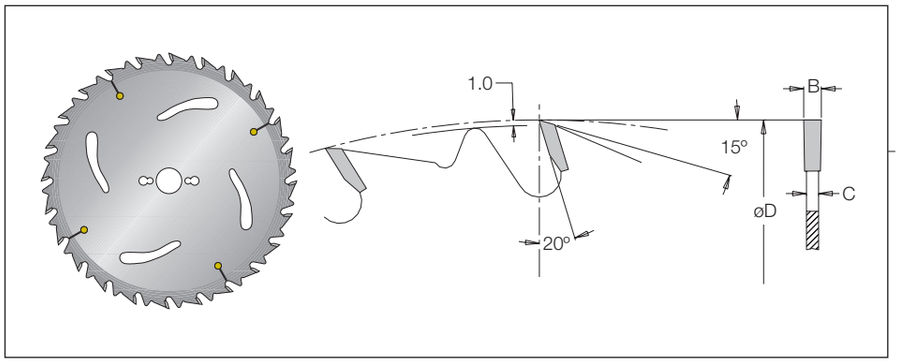


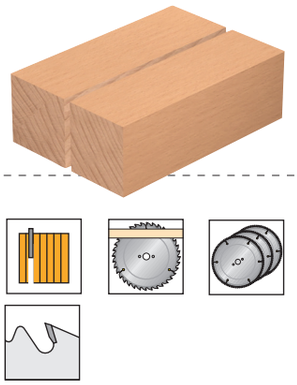
øD	Teeth	Code No.	B	c	n	m/min	ød
300	24	90120306	4.4	2.8	3800-6300	14-23	30
350	28	90120506	4.4	2.8	3200-5400	13-23	30
400	32	90121106	4.0	3.0	2800-4500	13-22	30
	32	90120906	4.4	3.0	2800-4500	13-22	30

Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

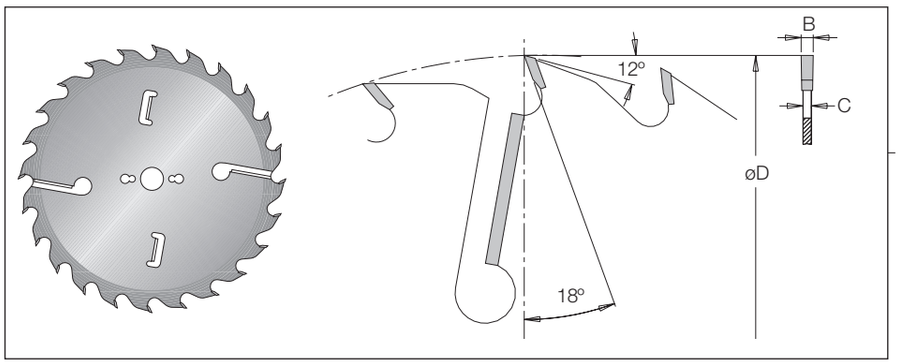
MFG - Rip Saw Blade

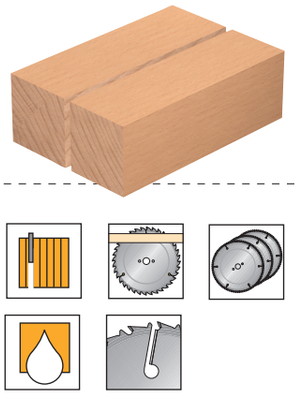




øD	Teeth	Code No.	B	c		n	m/min	ød
250	20	90100906	3.2	2.2	-	4500-7600	14-23	30
	24	90100956	3.2	2.2	-	4500-7600	16-27	30
300	24	90101006	3.2	2.2	-	3800-6300	14-23	30
	24	90101000	3.2	2.2	2/20x6	3800-6300	14-23	70
	28	90101046	3.2	2.2	-	3800-6300	16-26	30
	28	90101040	3.2	2.2	2/20x6	3800-6300	16-26	70
350	28	90101106	3.5	2.5	-	3200-5400	13-23	30
	32	90101136	3.5	2.5	-	3200-5400	15-26	30
400	18	90101146	3.5	2.5	-	2800-4500	8-12	30
	28	90101156	3.5	2.5	-	2800-4500	12-19	30
450	40	90101166	4.0	2.8	-	2500-4000	15-24	30
500	44	90101186	4.4	3.0	-	2200-3500	15-23	30

MFM - Multi Rip Saw Blade





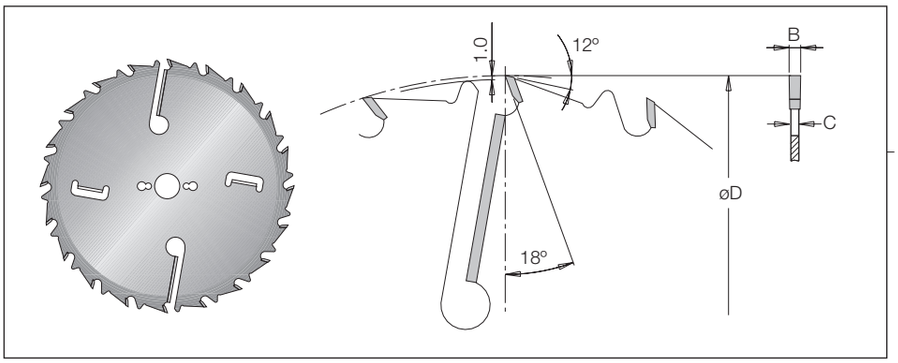
øD	Teeth	Code No.	B	c		n	m/min	ød
250	18+2	90400106	3.2	2.2		4500-7600	12-21	30
	18+2	90400100	3.2	2.2	4/20x5	4500-7600	12-21	70
300	20+2+2	90400306	3.2	2.2	-	3800-6300	11-19	30
	20+2+2	90400300	3.2	2.2	2/20x5	3800-6300	11-19	70
350	24+2+2	90400506	3.5	2.5	-	3200-5400	12-19	30
	24+2+2	90400500	3.5	2.5	2/20x5	3200-5400	12-19	70

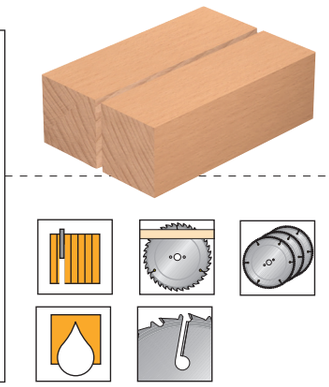
⚠ Wet and dry wood.
With rakers to prevent the wood from making contact with the saw body.

Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

MFGM - Rip Saw Blade

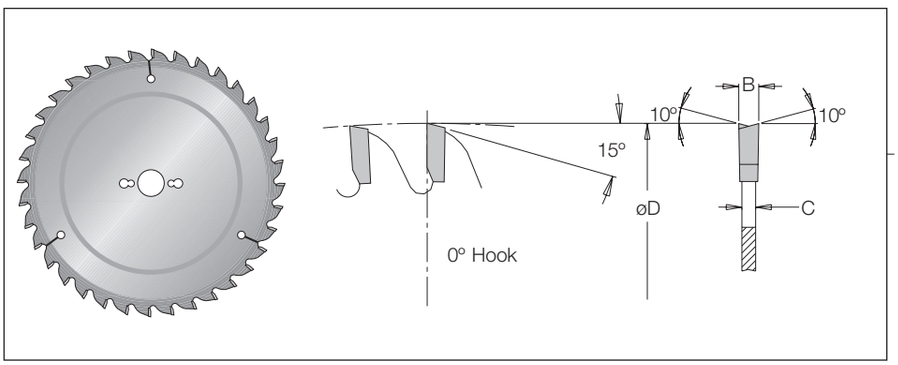


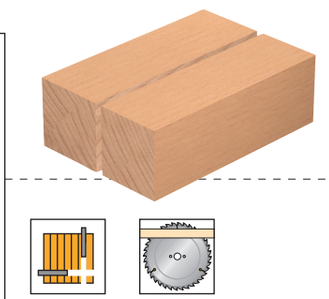


øD	Teeth	Code No.	B	c	n	m/min	ød
300	20+2+2	90400356	3.2	2.2	3800-6300	11-19	30
350	24+2+2	90400556	3.5	2.5	3200-5400	12-19	30

⚠ With rakers to prevent the wood from making contact with the saw body.

MWO - Cross Cut Saw Blade

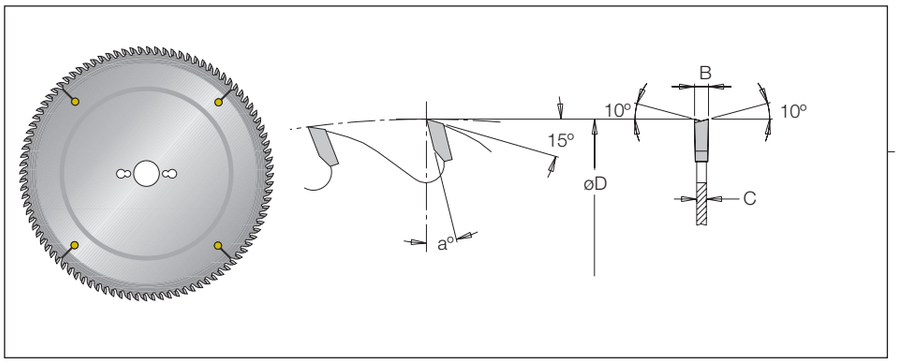


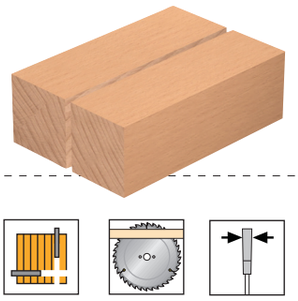


øD	Teeth	Code No.	B	c	n	m/min	ød
250	24	90801106	3.4	2.4	4500-7600	16-27	30
	42	90801206	3.4	2.4	4500-7600	28-48	30
300	36	90801306	3.8	2.8	3800-6300	21-34	30
350	42	90801506	4.2	2.8	3200-5400	20-34	30
400	48	90801706	4.2	3.0	2800-4500	20-32	30

⚠ Meant for over arm machine.

MWD - Trimming & Cross Cut Thin Kerf Saw Blade



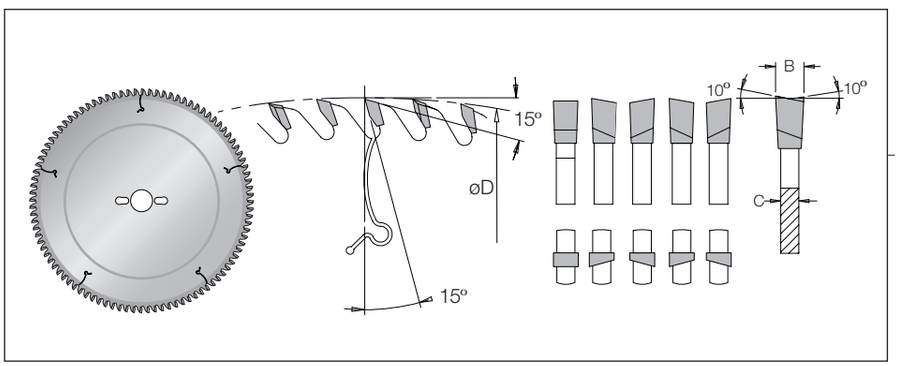


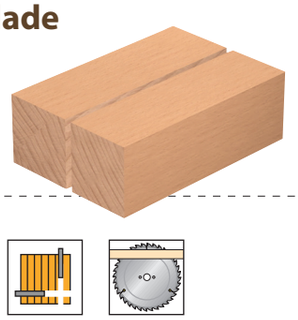
øD	Teeth	Code No.	B	c	a°	n	m/min	ød
150	24	90130106	2.3	1.6	15°	7600-12000	27-43	30
150	48	90131206	2.3	1.6	10°	6300-10000	51-82	30
180	30	90130206	2.3	1.6	15°	6300-10000	28-45	30
200	34	90130306	2.3	1.6	15°	5700-9000	29-46	30
200	64	90131406	2.3	1.6	10°	4700-7600	51-83	30
	80	90131476	2.3	1.6	5°	4700-7600	64-103	30
230	34	90130406	2.3	1.6	15°	4900-8300	25-42	30
250	40	90130506	2.3	1.6	15°	4500-7600	27-46	30
250	80	90131476	2.3	1.6	10°	3800-6100	52-83	30
	100	90131606	2.3	1.6	5°	3800-6100	65-104	30
300	48	90130606	2.3	1.6	15°	3800-6300	27-45	30
300	96	90131706	2.3	1.6	10°	3100-5000	51-82	30
350	54	90130706	2.3	1.6	15°	3200-5400	26-44	30
350	108	90131806	2.3	1.6	10°	2700-4300	50-79	30
380	48	90130806	2.7	2.0	15°	3000-5000	22-36	30
380	100	90131906	2.7	2.0	10°	2500-4000	43-68	30

Manufacturing Technology:

Dynamic
Straightness

CFCC - Trimming & Cross Cut for Hard & Exotic Wood Saw Blade



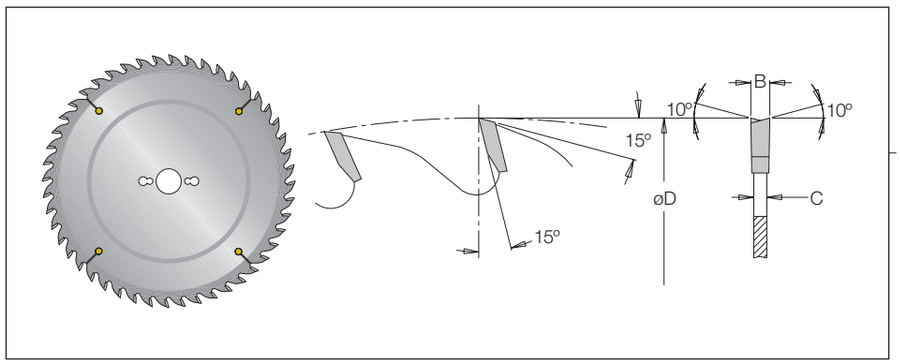


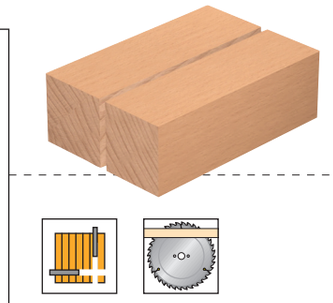
øD	Teeth	Code No.	B	c	n	m/min	ød
300	100	96035306	3.0	2.2	3800-6300	27-45	30
300	120	96035356	3.0	2.2	3800-6300	27-45	30

Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

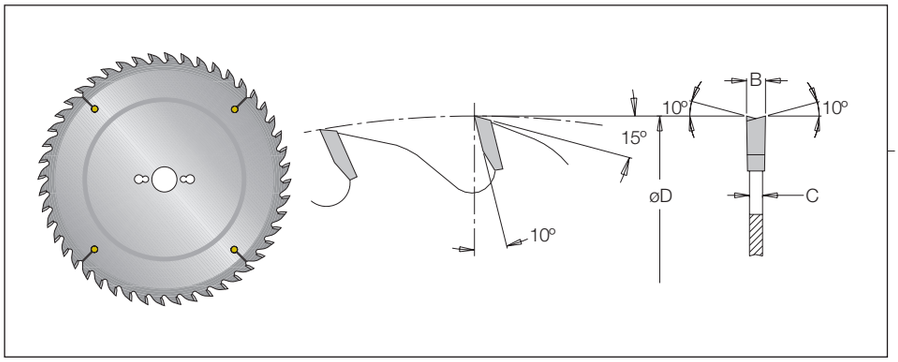
MW - Trimming & Cross Cut Saw Blade

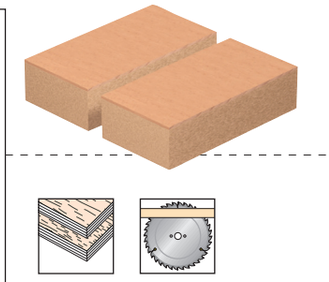




øD	Teeth	Code No.	B	c	n	m/min	ød
100	30	9010330Z	2.2	1.6	Max 4,500		12
125	24	90102103	3.0	2.0	Max 4,500		20
	30	90103403	3.0	2.0	Max 4,500		20
132	20	90101223	2.6	1.6	Max 4,500		20
150	24	90102206	3.0	2.0	6300-10100	26-41	30
160	24	9010221E	2.6	1.6	6300-10100	26-41	16
165	18	90101203	2.8	1.8	6300-10100	26-41	20
170	24	90102223	2.6	1.6	5300-8400	26-41	20
180	24	90101306	3.0	2.0	5300-8400	23-38	30
	30	90102306	3.0	2.0	5300-8400	27-43	30
184	24	9010131E	2.8	1.8	5300-8400	26-41	16
	30	9010232E	2.8	1.8	5300-8400	26-41	16
190	24	90101333	2.8	1.8	5300-8400	26-41	20
200	24	90101406	3.0	2.0	4700-7600	21-32	30
	34	90102406	3.0	2.0	4700-7600	27-44	30
210	24	90101416	2.8	1.8	4700-7600	26-41	30
216	24	90101426	2.8	1.8	4700-7600	26-41	30
220	24	90101456	3.0	2.0	5200-8500	19-31	30
	34	90102436	3.0	2.0	4500-7600	25-40	30
230	24	90101506	3.0	2.0	4300-6900	26-41	30
	40	90102506	3.0	2.0	4300-6900	26-41	30
240	24	90101596	3.0	2.0	4300-6900	26-41	30
250	30	90101606	3.2	2.2	3800-6100	20-34	30
	40	90102606	3.2	2.2	3800-6100	26-41	30
	48	90102636	3.2	2.2	3800-6100	31-50	30
300	36	90101706	3.2	2.2	3800-6300	21-34	30
	48	90102706	3.2	2.2	3100-5000	25-41	30
350	36	90101796	3.5	2.5	3200-5400	17-29	30
	42	90101806	3.5	2.5	3200-5400	20-34	30
	54	90102806	3.5	2.5	2700-4300	25-39	30
400	48	90101906	3.5	2.5	2800-4500	20-32	30
	60	90102906	3.5	2.5	2300-3800	23-39	30
450	54	90102006	4.0	2.8	2500-4000	20-32	30
	66	90103006	4.0	2.8	2100-3300	24-37	30
500	60	90102056	4.4	3.0	2200-3500	20-32	30
	72	90103206	4.4	3.0	1900-3000	23-37	30

MW - Trimming & Cross Cut Saw Blade





øD	Teeth	Code No.	B	c	n	m/min	ød
105	30	90103353*	2.2	1.6	Max 4,500		20
125	40	90105203	3.0	2.0	Max 4,500		20
132	36	90103553	2.6	1.8	Max 4,500		20
140	30	90103453	2.8	1.8	Max 4,500		20
150	30	90103506	3.0	2.0	6300-10100	32-52	30
	36	90103606	3.0	2.0	6300-10100	39-62	30
	48	90105306	3.0	2.0	6300-10100	51-82	30
160	36	9010372E	2.6	1.6	6300-10100	32-52	16
	48	9010532E	2.6	1.6	6300-10100	32-52	16
170	48	90105633	2.8	1.8	5300-8400	26-41	20
180	42	90103806	3.0	2.0	5300-8400	38-60	30
	58	90105406	3.0	2.0	5300-8400	52-83	30
184	42	9010385E	2.8	1.8	5300-8400	26-41	16
190	36	90102353	2.8	1.8	5300-8400	26-41	20
	48	90103953	2.8	1.8	5300-8400	26-41	20
200	48	90104006	3.0	2.0	4700-7600	38-62	30
	64	90105506	3.0	2.0	4700-7600	51-83	30
210	34	90102416	2.8	1.8	4700-7600	26-41	30
	48	90104016	2.8	1.8	4700-7600	26-41	30
	64	90105436	2.8	1.8	4700-7600	26-41	30
216	48	90104116	2.8	1.8	4700-7600	26-41	30
	60	90105456	2.8	1.8	4700-7600	26-41	30
220	48	90104036	3.0	2.0	4300-6900	35-56	30
	64	90105596	3.0	2.0	4300-6900	47-75	30
230	48	90102556	3.0	2.0	4300-6900	26-41	30
	60	90105606	3.0	2.0	4300-6900	26-41	30

*Also available with 22 mm bore

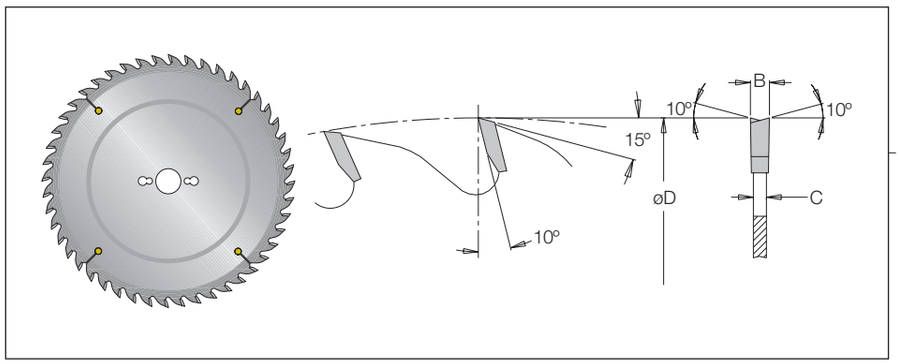
Manufacturing Technology:

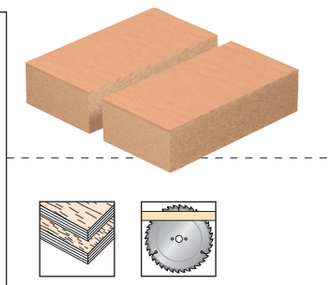
Dynamic Straightness Above 250 Diameter

Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

MW - Trimming & Cross Cut Saw Blade



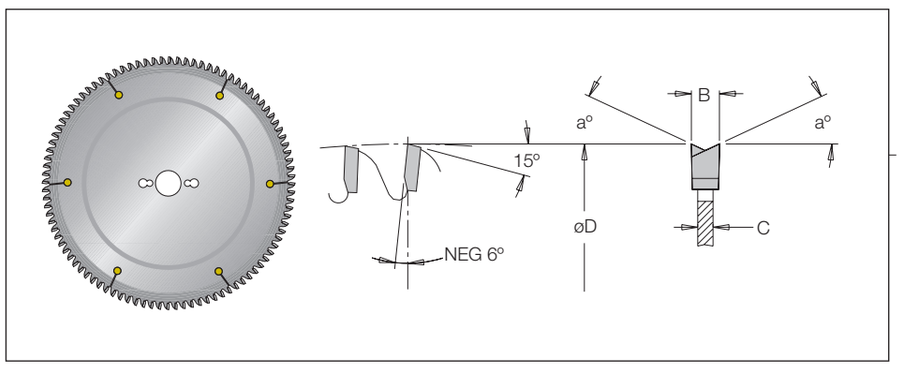


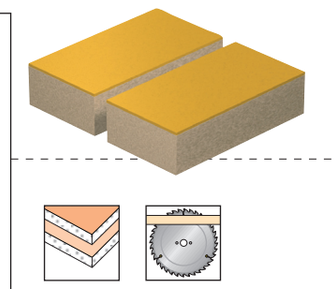
øD	Teeth	Code No.	B	c	n	m/min	ød
250	60	90104106	3.2	2.2	3800-6100	39-62	30
	80	90105706	3.2	2.2	3800-6100	52-83	30
300	60	90104206	3.2	2.2	3100-5000	32-51	30
	72	90104306	3.2	2.2	3100-5000	38-61	30
	96	90105806	3.2	2.2	3100-5000	51-82	30
350	72	90104406	3.5	2.5	2700-4300	33-53	30
	84	90104506	3.5	2.5	2700-4300	39-61	30
	108	90105906	3.5	2.5	2700-4300	50-79	30
400	96	90104606	3.5	2.5	2300-3800	38-62	30
	120	90106006	3.5	2.5	2300-3800	47-78	30
450	108	90104626	4.0	2.8	2100-3300	39-61	30
	132	90106036	4.0	2.8	2100-3300	47-74	30
500	120	90104636	4.4	3.0	1900-3000	39-61	30

Manufacturing Technology:

Dynamic Straightness Above 250 Diameter

MWTN - Trimming & Sizing Saw Blade



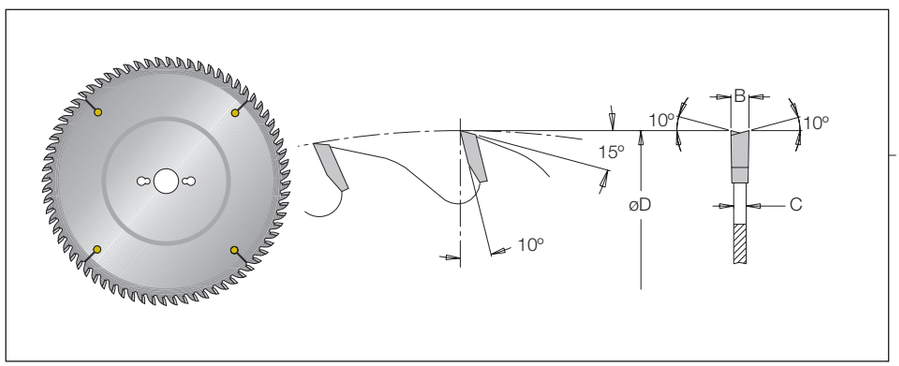


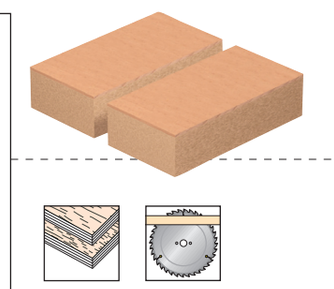
øD	Teeth	Code No.	B	c	a	n	m/min	ød
250	80	90302706	3.4	2.6	25°	5300-7600	21-30	30
300	96	90302816	3.0	2.2	35°	4400-6300	21-30	30
	96	90302806	3.4	2.6	25°	4400-6300	21-30	30
350	108	90302906	3.4	2.6	25°	3800-5400	21-29	30
400	120	90303006	4.0	3.2	25°	3300-4500	20-27	30

Manufacturing Technology:

Dynamic Straightness

DW - Trimming & Sizing Extended Life Saw Blade





øD	Teeth	Code No.	B	c	n	m/min	ød
250	60	95004106	3.2	2.2	3800-6100	39-62	30
	80	95005706	3.2	2.2	3800-6100	52-83	30
300	72	95004306	3.2	2.2	3100-5000	38-61	30
	96	95005806	3.2	2.2	3100-5000	51-82	30
350	72	95004406	3.5	2.5	2700-4300	33-53	30
	84	95004506	3.5	2.5	2700-4300	39-61	30
	108	95005906	3.5	2.5	2700-4300	50-79	30

Manufacturing Technology:

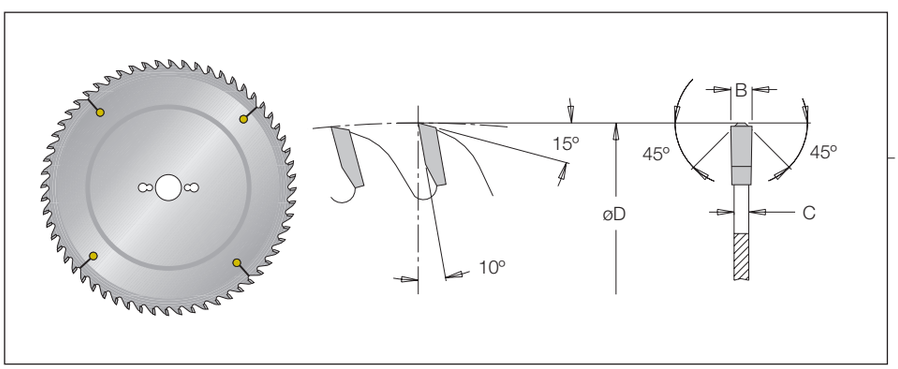
G6.3 Dynamic Balancing

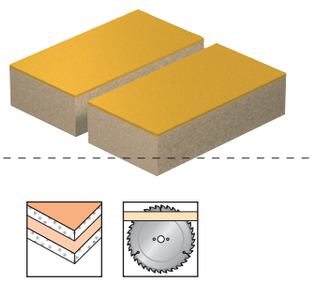
Dynamic Straightness

Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

MS - Trimming & Sizing Saw Blade





øD	Teeth	Code No.	B	c	n	m/min	ød
125	40	90106053	3.0	2.0	Max 4,500		20
140	48	90106043	2.8	1.8	Max 4,500		20
180	42	90104683	3.0	2.0	5300-8400	21-29	20
	58	90106076	3.0	2.0	5300-8400	21-29	30
190	48	90104693	2.8	1.8	5300-8400	26-41	20
	60	90106173	2.8	1.8	5300-8400	26-41	20
200	48	90104706	3.0	2.0	6600-9000	16-22	30
	64	90106086	3.0	2.0	6600-9000	21-29	30
210	64	90106116	2.8	1.8	4700-7600	26-41	30
216	48	90104716	2.8	1.8	4700-7600	26-41	30
	60	90106146	2.8	1.8	4700-7600	26-41	30
220	34	90102486	3.0	2.0	6000-8600	10-15	30
	64	90106126	3.0	2.0	6000-8600	19-28	30
230	60	90106096	3.0	2.0	5300-7600	19-28	30
240	64	90106186	3.0	2.0	5300-7600	19-28	30
250	40	90104756	3.2	2.2	5300-7600	11-15	30
	60	90104806	3.2	2.2	5300-7600	16-23	30
	80	90106106*	3.2	2.2	5300-7600	21-30	30
300	48	90102736	3.2	2.2	4400-6300	11-15	30
	60	90104856	3.2	2.2	4400-6300	13-19	30
	72	90104906*	3.2	2.2	4400-6300	16-23	30
	96	90106206*	3.2	2.2	4400-6300	21-30	30
350	54	90102856	3.5	2.5	3800-5400	10-15	30
	72	90104956	3.5	2.5	3800-5400	14-19	30
	84	90105006*	3.5	2.5	3800-5400	16-23	30
	108	90106306*	3.5	2.5	3800-5400	21-29	30
400	96	90105106*	3.5	2.5	3300-4500	16-22	30
	120	90106406*	3.5	2.5	3300-4500	20-27	30
450	108	90105156*	4.0	2.8	2900-4000	16-22	30

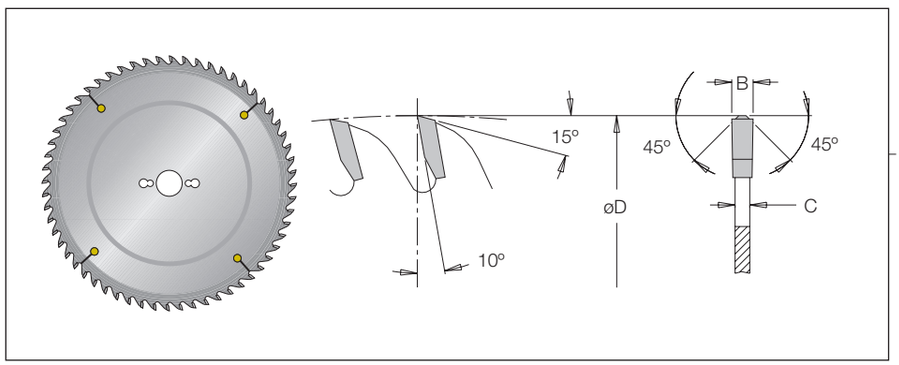
Manufacturing Technology:

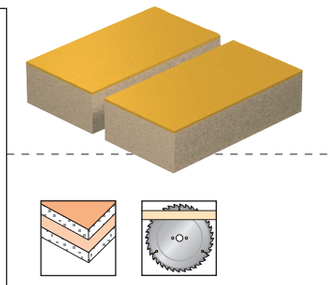
Dynamic Straightness*

Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

DS - Trimming & Sizing Extended Life Saw Blade





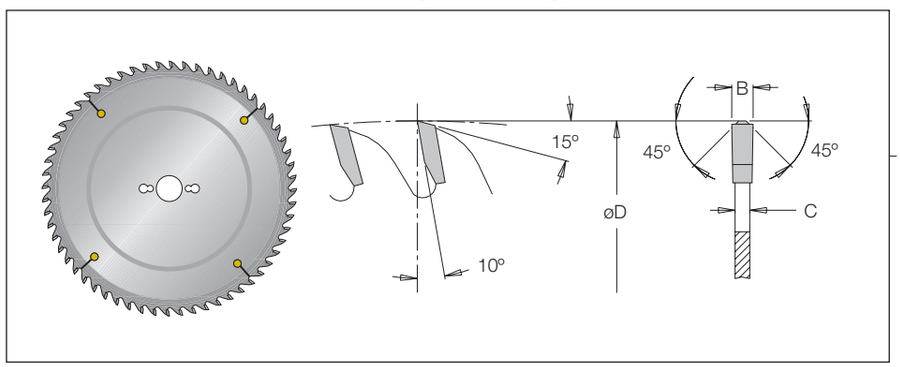
øD	Teeth	Code No.	B	c	n	m/min	ød
220	64	95006126	3.0	2.0	6000-8600	19-28	30
250	80	95006106	3.2	2.2	5300-7600	21-30	30
300	72	95004906	3.2	2.2	4400-6300	16-23	30
	96	95006206	3.2	2.2	4400-6300	21-30	30
350	72	95004956	3.5	2.5	3800-5400	14-19	30
	84	95005006	3.5	2.5	3800-5400	16-23	30
	108	95006306	3.5	2.5	3800-5400	21-29	30

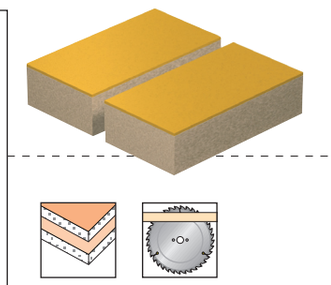
Manufacturing Technology:

G6.3 Dynamic Balancing

Dynamic Straightness

BS Trimming & Sizing Extended Life Saw Blade for MDF





øD	Teeth	Code No.	B	c	n	m/min	ød
300	96	97006206	3.2	2.2	4400-6300	21-30	30
350	84	97005006	3.5	2.5	3800-5400	21-29	30

Manufacturing Technology:

G6.3 Dynamic Balancing

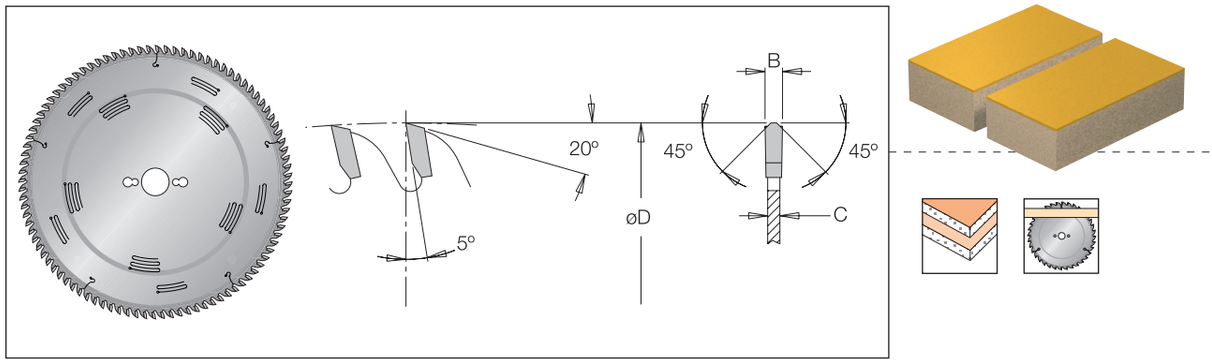
Dynamic Straightness

Also Available in TTG (Trapez Trapez Grinding).

Sawing

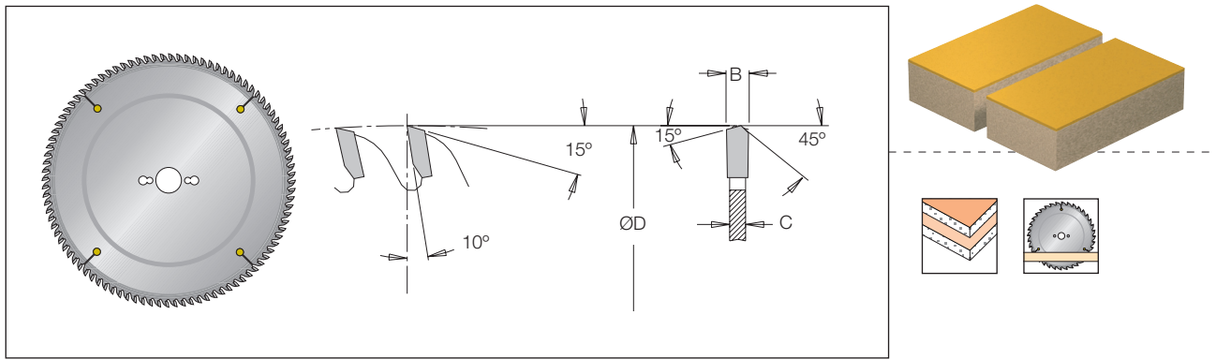
Solid Wood | Boards | Plastic | Aluminum | Metal

DSQ - Trimming & Sizing Extended Life & low Vibrasion Saw Blades



øD	Teeth	Code No.	B	c	n	m/min	ød
300	96	95406256	3.2	2.2	4400-6300	21-30	30

DX - Trimming & Sizing Extended Life Saw Blades



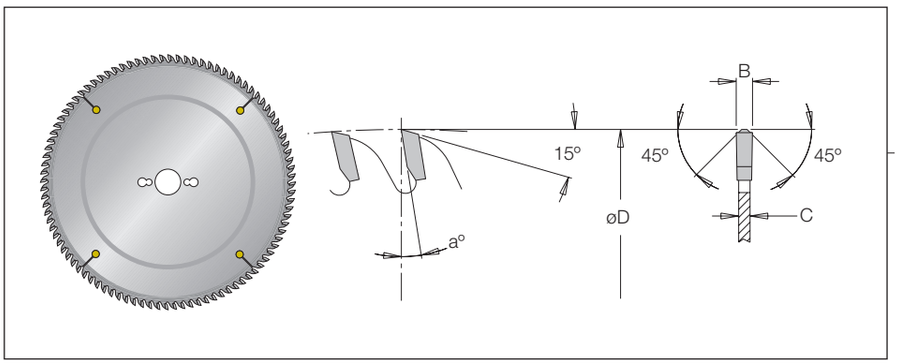
øD	Teeth	Code No.	B	c	n	m/min	ød
300	96	95005856	3.2	2.2	4400-6300	21-30	30

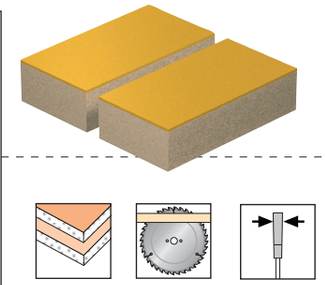
Manufacturing Technology:

G6.3 Dynamic Balancing

Dynamic Straightness

MSD - Trimming & Sizing Thin Kerf Saw Blade





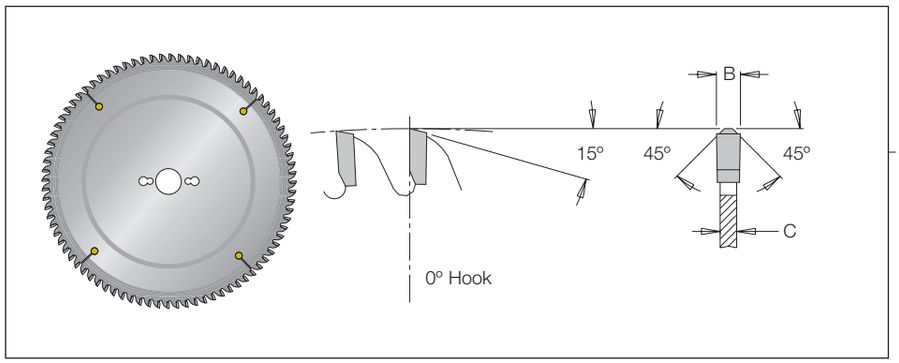
øD	Teeth	Code No.	B	c	a	n	m/min	ød
150	48	90131356	2.3	1.6	10°	8900-12000	21-29	30
200	64	90131556	2.3	1.6	10°	6600-9000	21-29	30
250	80	90131756	2.3	1.6	10°	5300-7600	21-30	30
	100	90131776	2.3	1.6	5°	5300-7600	27-38	30
300	96	90131856	2.3	1.6	10°	4400-6300	21-30	30

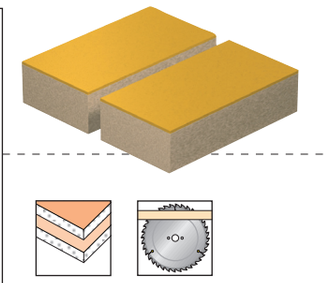
⚠ Use a flange whose diameter is half the diameter of the saw blade.

Manufacturing Technology:

Dynamic
Straightness
Diameter ranging
from 250

MSO - Trimming & Sizing Saw Blade





øD	Teeth	Code No.	B	c	n	m/min	ød
250	72	90141656	3.2	2.4	5300-7600	19-27	30
300	84	90141756	3.2	2.4	4400-6300	18-26	30
350	96	90141856	3.3	2.5	3800-5400	18-26	30
400	108	90141956	3.3	2.5	3300-4500	18-24	30

⚠ Meant for over- arm machine.

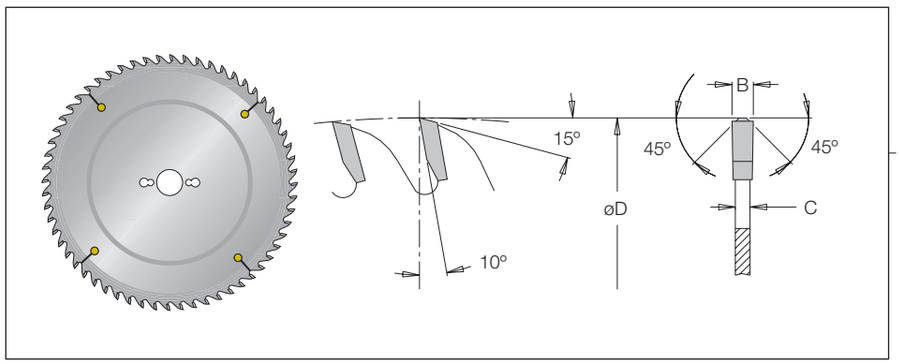
Manufacturing Technology:

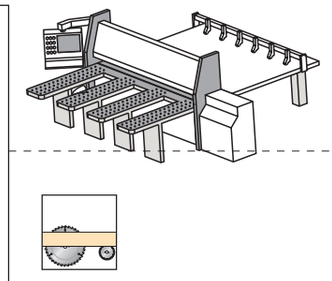
Dynamic
Straightness

Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

DST - Main Saw for Panel Sizing Laminated Boards Extended Life





Type	øD	Teeth	Code No.	B/c	ød	
Scher	400	72	95531296	4.25/3.2	30	
Panhans	305	60	95531056	4.4/3.0	30	
	355	72	95531156	4.4/3.0	30	
Giben	355	72	9553115T	4.4/3.0	75	
	400	72	9553130T	4.4/3.2	75	4/15/105
	430	72	9553150T	4.4/3.2	75	4/15/105
	430	96	9553155T	4.4/3.2	75	4/15/105
SCM	305	60	9553105U	4.4/3.0	80	2/14/110
	380	72	9553123U	4.8/3.5	80	2/14/110
	420	72	9553135U	4.4/3.2	80	2/14/110
Gabbiani	355	72	9553115U	4.4/3.0	80	4/9/100/2/14/110/2/7100
Holzma	355	72	9553115R	4.4/3.0	60	2/14/100
	380	72	9553123R	4.8/3.5	60	2/14/100
	420	72	9553135R	4.4/3.2	60	2/14/125-2/10/80
	450	72	9553160R	4.4/3.2	60	2/14/125-2/10/80
	450	72	9553170R	4.8/3.5	60	2/14/125-2/10/80
	500	60	9553185R	4.8/3.5	60	2/11/115
	500	72	9553195R	4.8/3.5	60	2/11/115
	520	72	9553205R	4.8/3.5	60	2/11/115-2/19/120
	600	72	9553301R	5.8/4.0	60	2/19/120-2/11/115

Manufacturing Technology:

G6.3 Dynamic Balancing

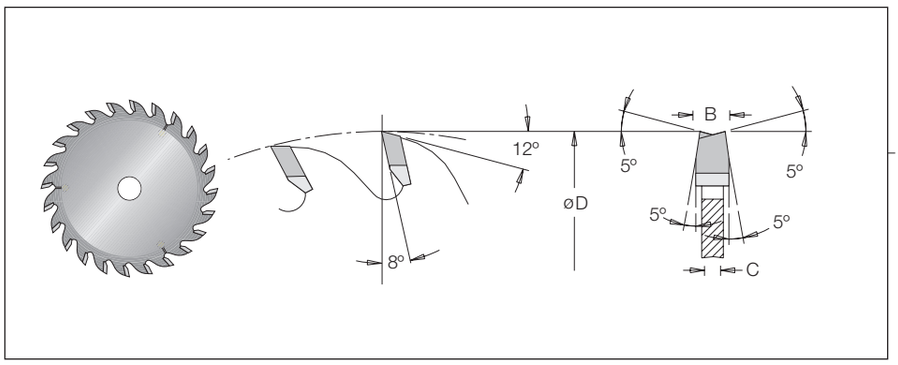
Dynamic Straightness

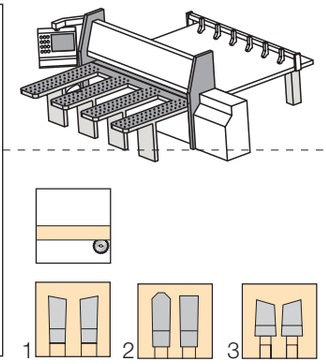
Also Available in TTG (Trapez Trapez Grinding).

Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

Scoring Saw, Extended Life



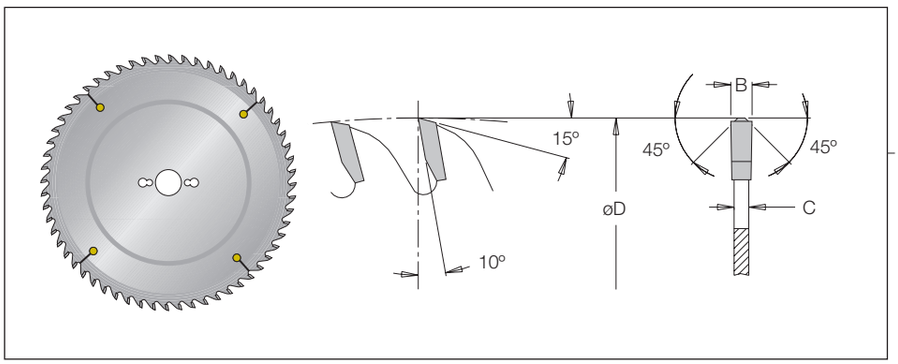


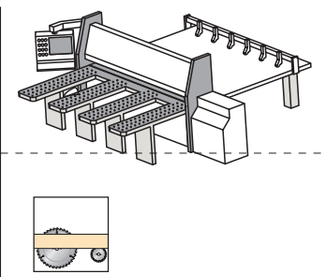
	øD	Teeth	Code No	B	c	ød		Grinding type
	400	72	95531306	4.4	3.2	30		2
	125	24	95600793	4.4-5.3	3.2	20		3
	125	24	95600793	4.4-5.3	3.2	20		3
	125	24	9560079M	4.4-5.3	3.2	45		3
	160	36	9560195M	4.4-5.3	3.2	45	3/11/70	3
	216	42	9560270N	4.4-5.3	3.2	50	3/15/80	3
	300	48	9560280N	4.4-5.3	3.2	50	3/15/80	3
	216	42	9560270N	4.4-5.3	3.2	50	3/15/80	3
	300	48	9560280N	4.4-5.3	3.2	50	3/15/80	3
	300	48	9560280N	4.4-5.3	3.2	50	3/15/80	3
	160	36	9560195C	4.4-5.3		55	3/7/66	3
	200	36	9560261U	4.-6.08		80	2/14/110	3
	160	36	9560195C	4.4-5.3		55	3/7/66	3
	160	36	9560195C	4.4-5.3	3.2	55	3/7/66	3
	200	36	9560265M	4.4		45		3
	200	36	9560261M	4.8-6.0	3.5	45		3
	180	30	9560216M	4.8-6.0	3.5	45		3
	340	108	9551109M	5	3.5	45		1
	200	36	9560261M	4.8-6.0	3.5	45		3
	340	108	9551109M	5	3.5	45		1
	200	36	9560261M	4.8-6.0	3.5	45		3
	200	36	9560261M	4.8-6.0	3.5	45		3
	340	108	9551109M	5	3.5	45		1
	200	36	9560268M	5.8-6.6	4.2	45		3
	200	36	95602653	4.4-5.3	3.2	20		3

Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

DST - Main Saw for Panel Sizing Laminated Boards Extended Life





Type	øD	Teeth	Code No.	B/c	ød	
Schelling	350	72	95531136	4.4/3.2	30	
	355	72	95531156	4.4/3.2	30	
	400	72	95531306	4.4/3.2	30	
	450	72	95531606	4.4/3.2	30	
	460	72	95531746	4.4/3.2	30	2/14/95
Selco	300	72	9553104S	4.4/3.2	65	2/9/110-2/9/100
	320	60	9553350S	4.4/3.2	65	2/9/110
	380	72	9553121U	4.4/3.5	80	4/19/120-2/9/130
	400	72	9553132U	4.4/3.2	80	4/19/120-2/9/130
	430	72	9553150U	4.4/3.2	80	4/19/120-2/9/130
	450	72	9553160U	4.4/3.2	80	4/19/120-2/9/130
	450	72	9553170U	4.8/3.5	80	4/19/120-2/9/130
Mayer	305	60	95531056	4.4/3.0	30	
	355	72	95531156	4.4/3.0	30	
	400	72	95531306	4.4/3.0	30	
SMA	355	72	9553115U	4.4/3.0	80	4/9/100-2/7/110-2/9/130

Manufacturing Technology:

G6.3 Dynamic Balancing

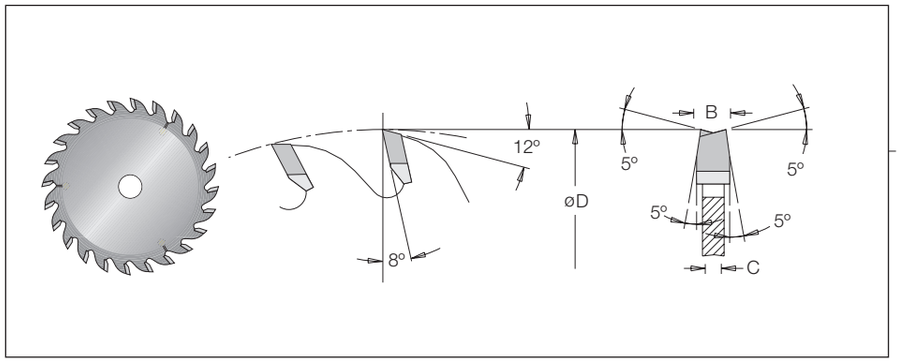
Dynamic Straightness

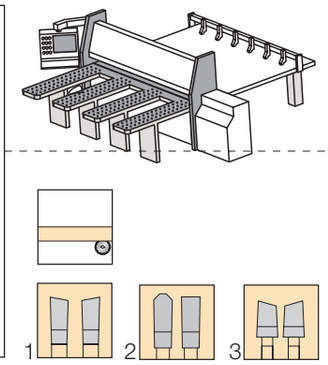
Also Available in TTG (Trapez Trapez Grinding).

Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

Scoring Saw, Extended Life



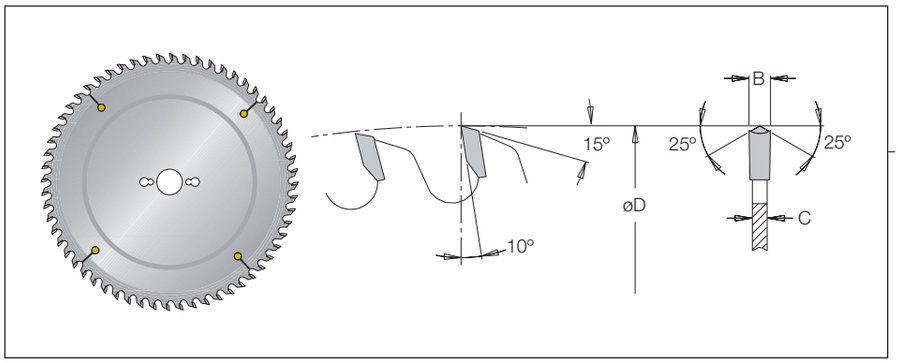


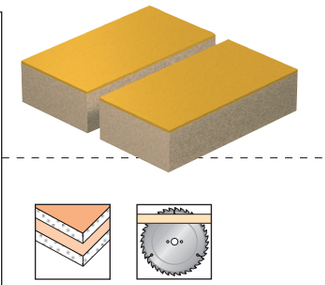
	øD	Teeth	Code No	B	c	ød		Grinding type
	150	24	95600883	4.4-5.3	3.2	20		3
	200	36	95602653	4.4-5.3	3.2	20		3
	200	36	9560265S	4.4-5.3	3.2	65	2/9/110	3
	200	36	9560265S	4.4-5.3	3.2	65	2/9/110	3
	300	72	9551106S	4.6	3.2	65	2/9/110	1
	300	72	9551106S	4.6	3.2	65	2/9/110	1
	200	36	9560265S	4.4-5.3	3.2	65	2/9/110	3
	300	72	9551106S	4.6	3.2	65	2/9/110	1
	200	36	9560265S	4.4-5.3	3.2	65	2/9/110	3
	300	72	9551106S	4.6	3.2	65	2/9/110	1
	200	36	9560265S	4.4-5.3	3.2	65	2/9/110	3
	300	72	9551106S	4.6	3.2	65	2/9/110	1
	300	72	9551106S	4.6	3.2	65	2/9/110	1
	200	36	9560261S	4.8-6.0	3.5	65	2/9/110	3

Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

MD - Trimming & Sizing Saw Blade





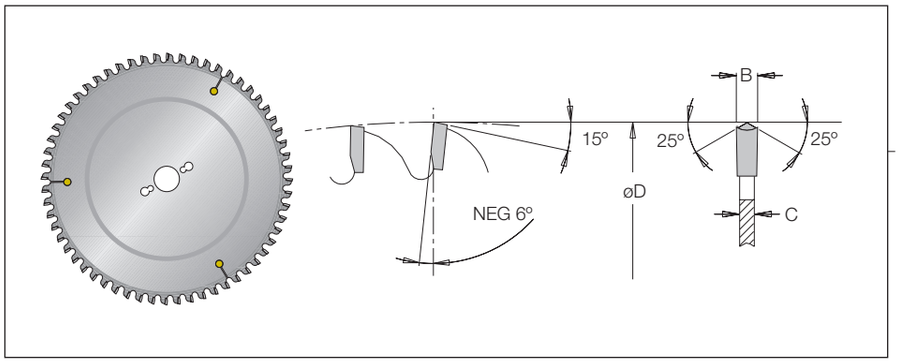
øD	Teeth	Code No.	B	c	n	m/min	ød
253	48	90110106	3.2	2.2	5200-7500	12-18	30
303	60	90110256	3.3	2.4	4400-6300	13-19	30
350	72	90110306	3.2	2.2	3800-5400	14-19	30

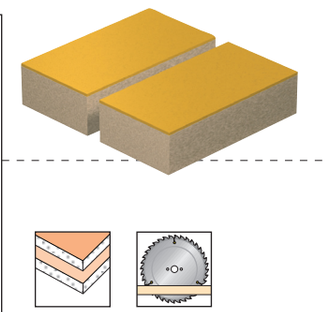
Manufacturing Technology:

G6.3 Dynamic Balancing

Dynamic Straightness

MDN - Trimming & Sizing Saw Blade





øD	Teeth	Code No.	B	c	n	m/min	ød
220	42	90110656	3.2	2.2	6000-8600	13-18	30
253	48	90110136	3.2	2.2	5200-7500	12-18	30
303	60	90110856	3.2	2.2	4400-6300	13-19	30

Manufacturing Technology:

G6.3 Dynamic Balancing

Dynamic Straightness

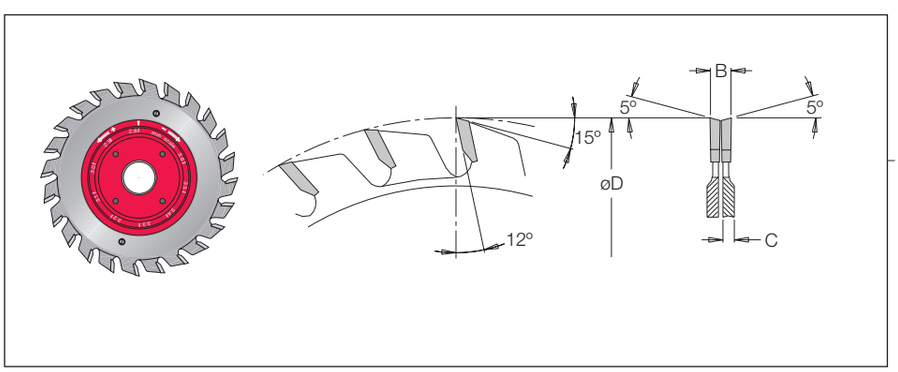
Adjustable Scoring System

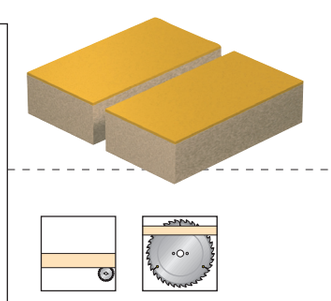
DLEADER™

Dimar takes the guesswork out of adjusting and re-adjusting scoring saw blades. The DLEADER™ system's patented adjustable scoring, eliminates the need for spacers, endless measuring, reassembling, testing and adjusting to obtain the required width.

- Adjusts easily
- Fits most machines
- Fits all blades in the width of 2.8 - 3.6mm
- Saves you time and money

DMAX™

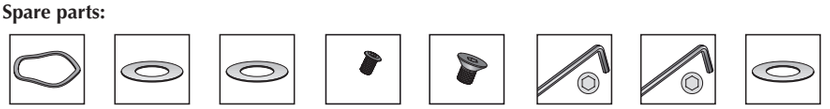




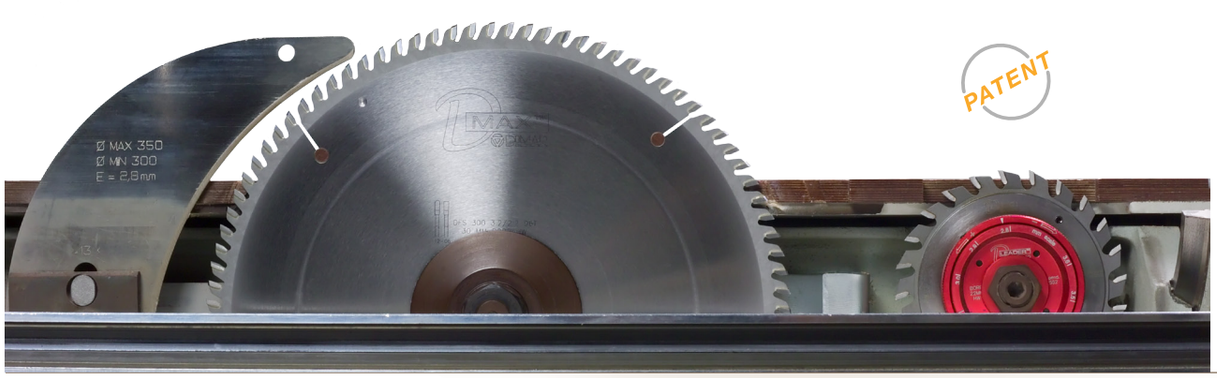
	øD	Code No.	B	Teeth	ød
Set 1	100	95610103**	2.8-3.6	24	20
Set 2	120	95620303	2.8-3.6	24	20
Set 3	120	95620304*	2.8-3.6	24	22
Set 4	125	95620403	2.8-3.6	24	20
Set 5	125	95620404*	2.8-3.6	24	22
Saw Blades R+L	100	9561010Z		12+12	
Saw Blades R+L	120	9561030Z		12+12	
Saw Blades R+L	125	9561040Z		12+12	

⚠ This system is suitable for most existing table-saw machines.
In cases where necessary, an appropriate fitting ring will be supplied.

Spare parts:



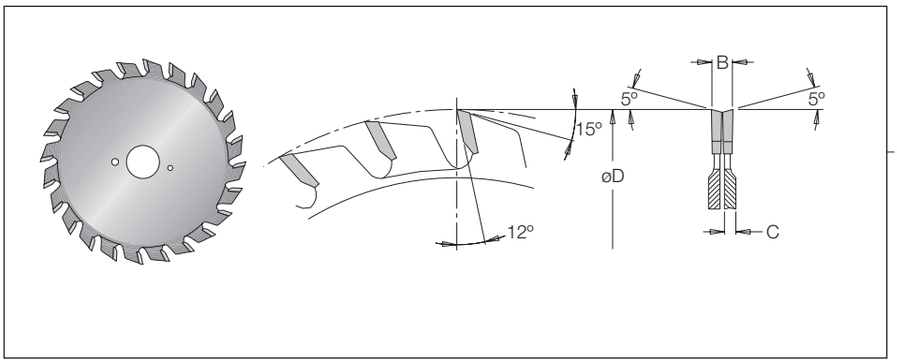
Spring ring	Washer	Washer*	Allen screw	Allen screw	Allen key	Allen key	Washer
#195 085 0	#196 352 3	#196 352 4	#193 035 1	#193 041 4	#194 102 0	#194 008 0	#192 570 0
D=75	D=35	D=35	M3x4.6	M4x6	S1.5	S2.5	D=35
#195 084 0**							
D=65							

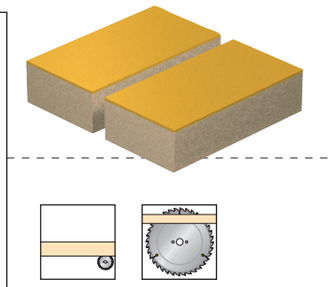


Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

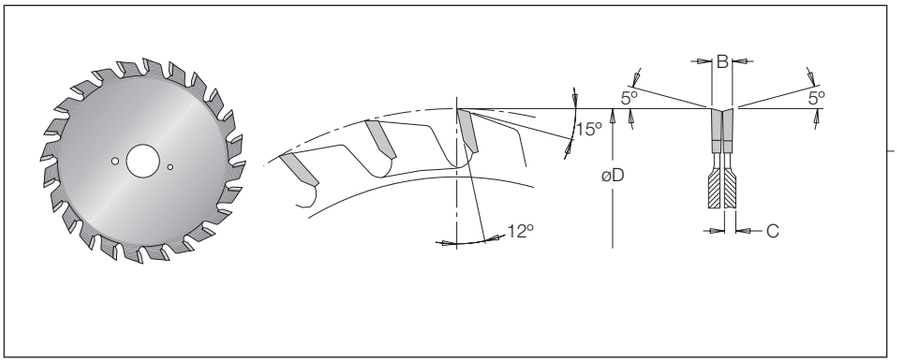
DVF - Adjustable Scoring Saw Blade, Extended Life

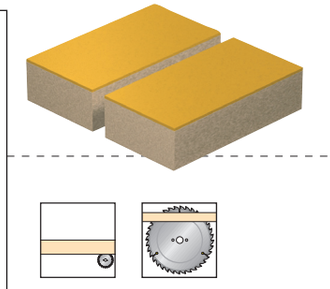




øD	Teeth	Code No.	B	Set Shims	c	ød
100	2x12	95600103	2.8 - 3.6	1920600	2.0	20
	2x12	95600104	2.8 - 3.6	1920600	2.0	22
120	2x12	95600303	2.8 - 3.6	1920600	2.0	20
	2x12	95600304	2.8 - 3.6	1920600	2.0	22
125	2x12	95600403	2.8 - 3.6	1920600	2.0	20
	2x12	95600404	2.8 - 3.6	1920600	2.0	22

MVF - Adjustable Scoring Saw Blade

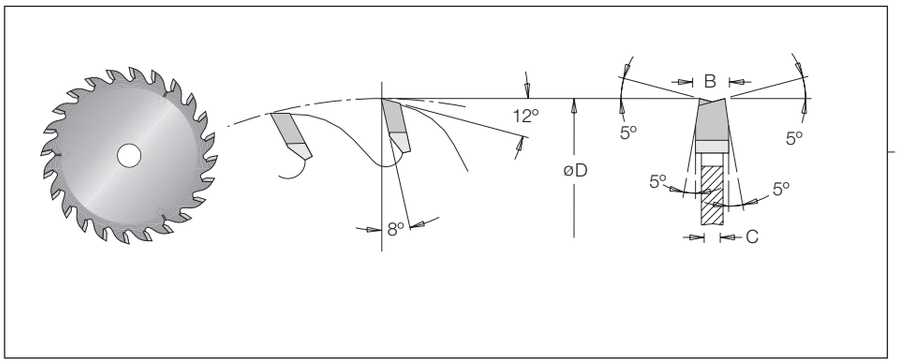


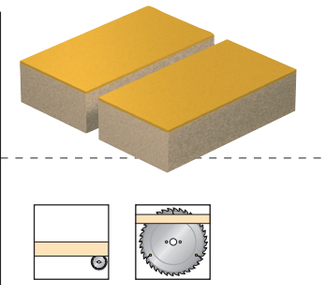


øD	Teeth	Code No.	B	Set Shims	c	ød
80	2x10	90600093	2.8 - 3.6	1920800	2.0	20
100	2x12	90600103	2.8 - 3.6	1920600	2.0	20
	2x12	90600104	2.8 - 3.6	1920600	2.0	22
120	2x12	90600303	2.8 - 3.6	1920600	2.0	20
	2x12	90600304	2.8 - 3.6	1920600	2.0	22
125	2x12	90600403	2.8 - 3.6	1920600	2.0	20
	2x12	90600404	2.8 - 3.6	1920600	2.0	22

Solid Wood | Boards | Plastic | Aluminum | Metal

DVK - Conic Scoring Saw, Extended Life

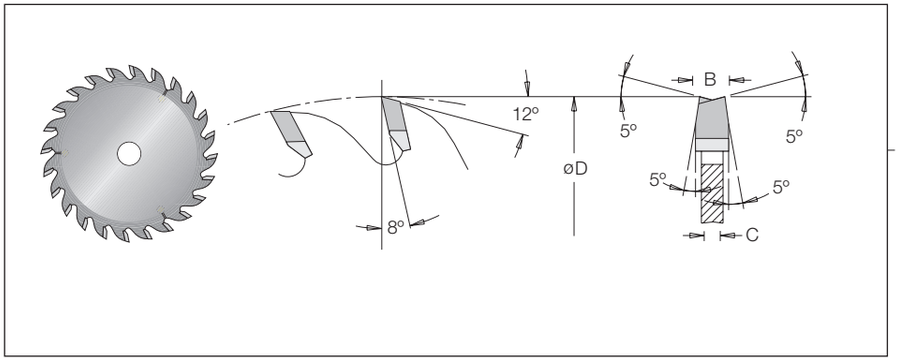


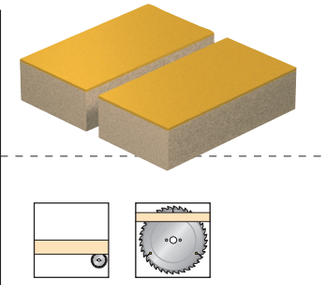


øD	Teeth	Code No.	B	c	ød
120	24	95600453	3.2-4.1	2.2	20
	24	95600454	3.2-4.1	2.2	22
125	24	95600693	3.2-4.1	2.8	20
	24	95600694	3.2-4.1	2.8	22
	24	95600793	4.4-5.3	3.2	20
	24	95600794	4.4-5.3	3.2	22

⚠ The cutting width can be adjusted by adjusting the cutting depth.

MVK - Conic Scoring Saw





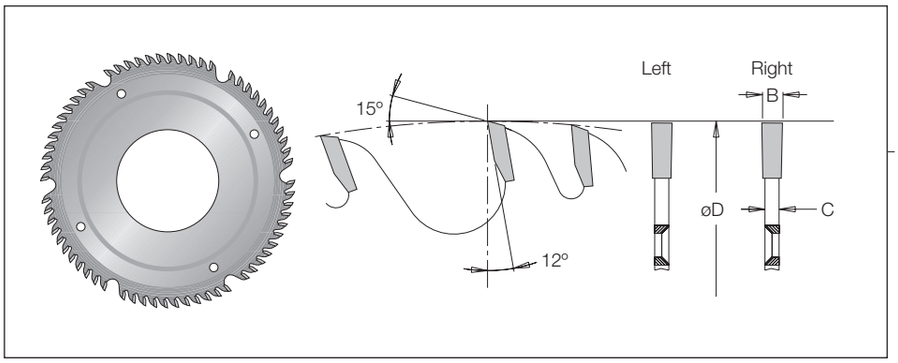
øD	Teeth	Code No.	B Main Saw	c	ød
100	20	90600413	3.2-4.1	2.2	20
	20	90600414	3.2-4.1	2.2	22
	20	90600513	3.0-4.1	2.2	20
	20	90600514	3.0-4.1	2.2	22
120	24	90600443	2.8-3.6	2.2	20
	24	90600444	2.8-3.6	2.2	22
	24	90600453	3.2-4.1	2.2	20
	24	90600454	3.2-4.1	2.2	22
125	24	90600693	3.2-4.1	2.8	20
	24	90600694	3.2-4.1	2.8	22

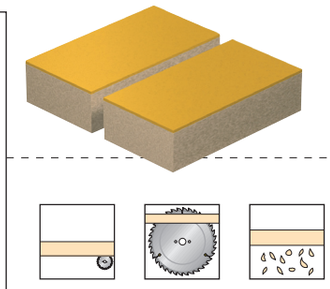
⚠ The cutting width can be adjusted by adjusting the cutting depth.

Sawing

Solid Wood | Boards | Plastic | Aluminum | Metal

DFH - Hoggers Saw Blades, Extended Life

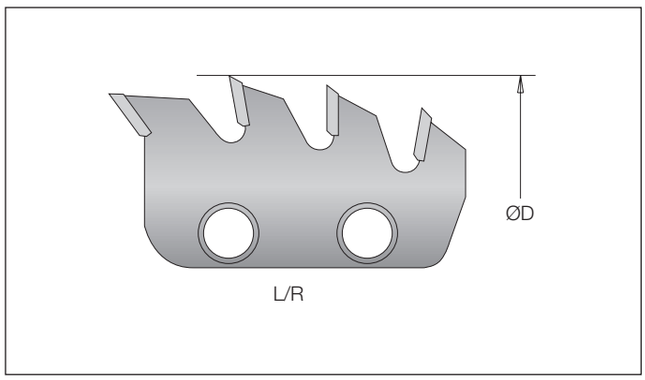




øD	Teeth	Code No. Right	Code No. Left	B	c	n	m/min	ød	
180	54	9570100S*	9570105S*	3.2	2.2	5300-8400	49-77	65	6 / 6.5 / 90
	54	9570103N*	9570107N*	3.2	2.2	5300-8400	49-77	50	3 / 22 / 80
200	40	9570110U	9570115U	4.0	2.8	4700-7600	32-52	80	4 / 6.5 / 140
	60	9570120U	9570125U	4.0	2.8	4700-7600	48-78	80	4 / 6.5 / 140
	60	9570121U	9570126U	4.0	2.8	4700-7600	48-78	80	8 / 6.5 / 155
250	48	9570130U	9570135U	4.0	2.8	3800-6100	31-50	80	6 / 6.5 / 200
	48	9570130Z	9570135Z	4.0	2.8	3800-6100	31-50	100	6 / 6.5 / 200
	72	9570140U	9570145U	4.0	2.8	3800-6100	47-75	80	6 / 6.5 / 200
	72	9570140Z	9570145Z	4.0	2.8	3800-6100	47-75	100	6 / 6.5 / 200

⚠ * Scoring for hogging.

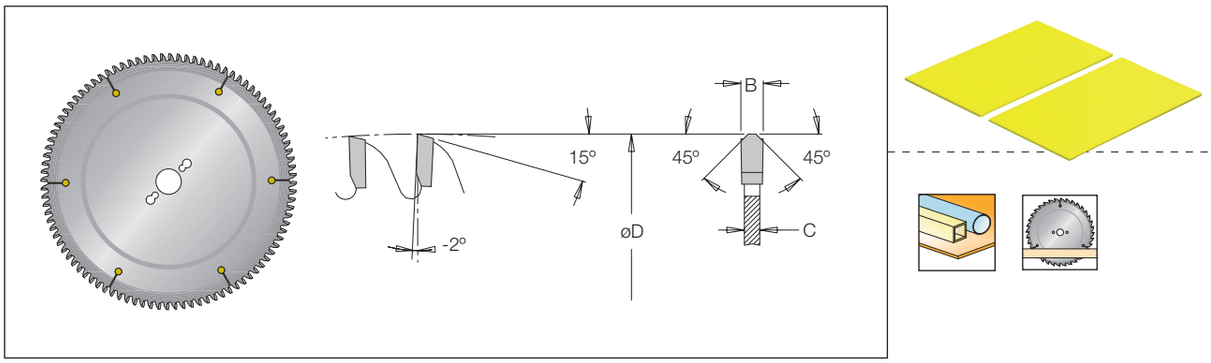
Segment for Hogger



Teeth	Code No.		
4	91108104	L/R	Suitable to segmented hogger diameter 200/250mm.

Solid Wood | Boards | Plastic | Aluminum | Metal

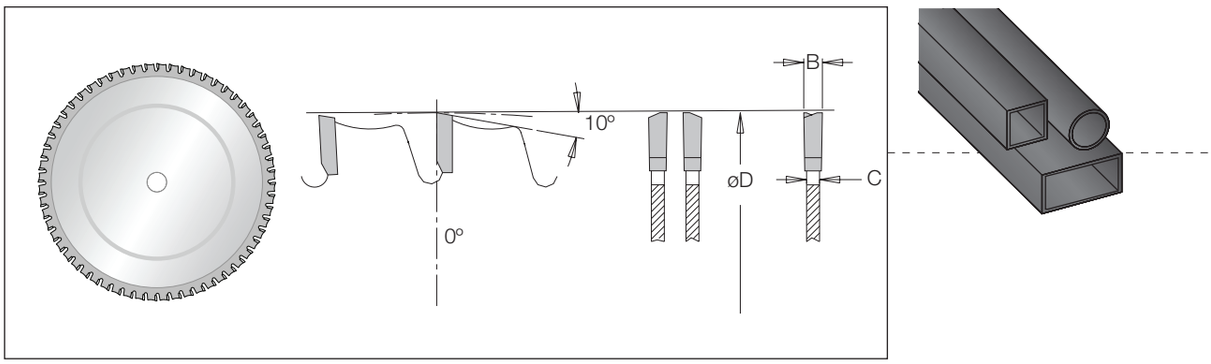
MUP - Plastic Trimming & Sizing Saw Blade



øD	Teeth	Code No.	B	c	ød
250	80	90107036	2.5	1.8	30
300	96	90107066	3.3	2.6	30
350	108	90107096	3.7	3.0	30

Manufacturing Technology:
Dynamic
Straightness

MZB - Metal Saw Blade

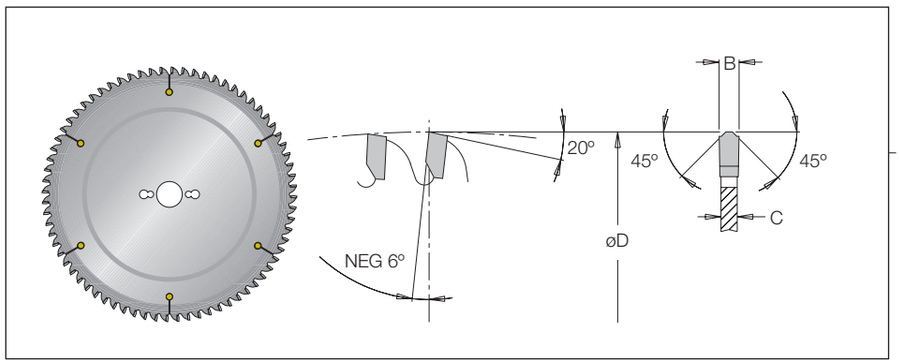


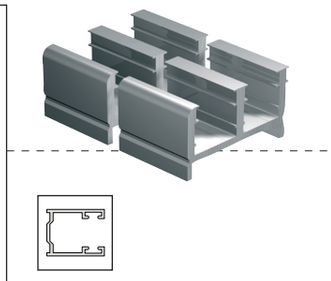
øD	Teeth	Code No.	B	c	n. Max.	ød
185	36	90209013	2.2	1.8	1,800	20.0
305	60	90210005	2.2	1.8	1,800	25.4
305	80	90210055	2.2	1.8	1,800	25.4
355	80	90210105	2.4	2.0	1,800	25.4

Sawing

Solid Wood | Boards | Plastic | **Aluminum** | Metal

MSAN - Aluminum Profiles Saw Blade





øD	Teeth	Code No.	B	c	n	m/min	ød
150	48	90202433	2.8	2.2	5000-8900	12-21	20
160	48	90202443	2.8	2.2	4700-8300	11-20	20
180	58	90202486	2.8	2.2	4200-7400	12-21	30
184	58	9020245E	2.8	2.2	4100-7200	12-21	16
	58	90202453	2.8	2.2	4100-7200	12-21	20
190	60	90202493	2.8	2.2	4000-7000	12-21	20
	60	90202496	2.8	2.2	4000-7000	12-21	30
200	48	90200706	2.8	2.2	3800-6600	9-16	30
	64	90202506	2.8	2.2	3800-6600	12-21	30
216	64	90202566	2.8	2.2	3500-6100	11-20	30
230	60	90202606	2.8	2.2	3300-5800	10-17	30
235	60	90202636	2.8	2.2	3200-5600	10-17	30
250	60	90200806	3.2	2.6	3000-5300	9-16	30
	80	90202706	3.2	2.6	3000-5300	12-21	30
	100	90202756	3.2	2.6	3000-5300	15-27	30
275	72	90200857	3.2	2.6	2700-4800	10-17	32
300	72	90200906	3.2	2.6	2500-4400	9-16	30
	96	90202806	3.2	2.6	2500-4400	12-21	30
330	80	90200957	3.2	2.6	2300-4000	9-16	32
	102	90202857	3.2	2.6	2300-4000	12-20	32
350	84	90201006	3.2	2.6	2100-3800	9-16	30
	108	90202906	3.2	2.6	2100-3800	11-21	30
380	100	90202956	2.8	2.2	2000-3500	10-18	30
400	96	90201106	3.8	3.2	1900-3300	9-16	30
	120	90203006	3.8	3.2	1900-3300	11-20	30
420	96	90203406	4.0	3.4	1800-3100	9-15	30
450	108	90204006	4.0	3.4	1600-2900	9-16	30
	120	90204106	4.0	3.4	1600-2900	10-17	30
500	120	90204206	4.4	3.8	1500-2600	9-16	30

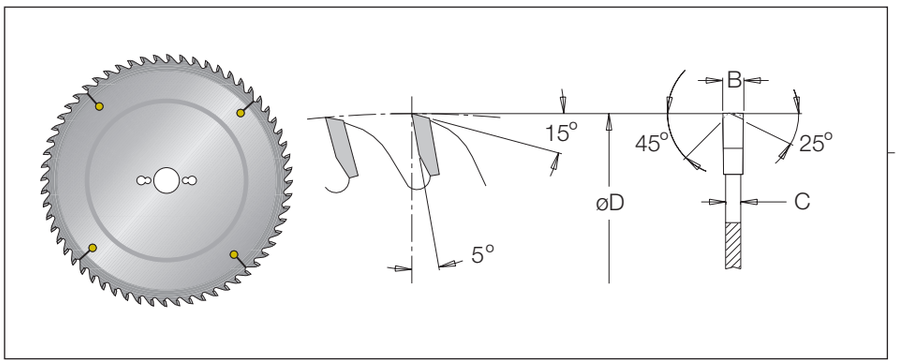
⚠ The material must be clamped firmly to the table on both sides during cutting operation.

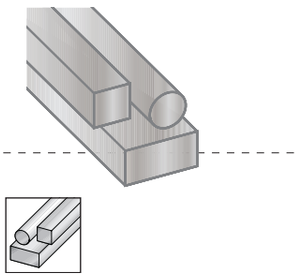
Manufacturing Technology:

G6.3 Dynamic Straightness Above 350 Diameter

Dynamic Straightness Above 250 Diameter

MTA - Aluminum Bars Saw Blade





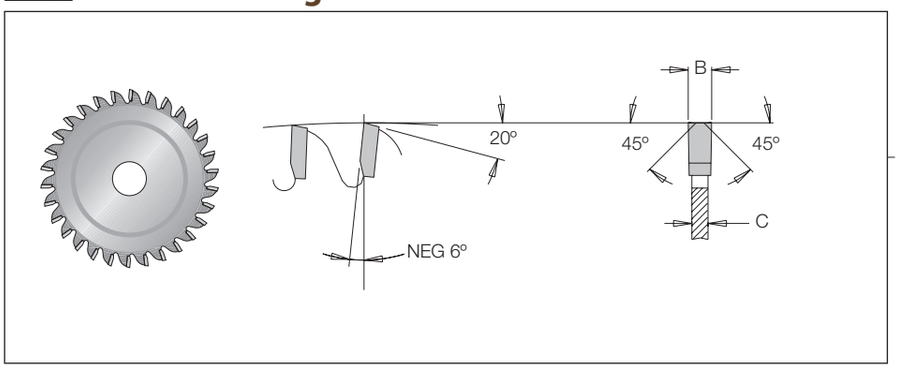
øD	Teeth	Code No.	B	C	n	m/min	ød
300	80	90254006	3.4	2.8	2500-4400	20-35	30
	60	90250106	3.4	2.8	2500-4400	15-25	30
350	100	90254306	3.6	3.0	2100-3800	21-38	30
	80	90250206	3.6	3.0	2100-3800	16-30	30
400	120	90254506	3.8	3.2	1900-3300	23-40	30
	80	90250306	3.8	3.2	1900-3300	15-26	30
450	100	90250406	4.0	3.4	1600-2900	16-29	30
	80	90256006	4.0	3.4	1600-2900	13-23	30
500	100	90250506	4.2	3.5	1500-2600	15-26	30
	80	90256036	4.2	3.5	1500-2600	12-20	30
550	120	90250606	4.4	3.8	1400-2400	16-28	30
	100	90256066	4.4	3.8	1400-2400	14-24	30

Manufacturing Technology:

G6.3 Dynamic Straightness Above 350 Diameter

Dynamic Straightness Above 250 Diameter

MHAN - Milling Saw Blade



øD	Teeth	Code No.	B	c	n	ød
100	24	90200511	3.9	3.2	7600-13000	15.87
	30	90200551	3.9	3.2	7600-13000	15.87
115	24	9020061A	3.9	3.2	6600-11600	22.2
	30	9020063A	3.9	3.2	6600-11600	22.2

To be used manually with mini grinder.
Used extensively in the boat building industry for milling, that is cleaning up, grooving of aluminum welds and cutting out welding tacks.