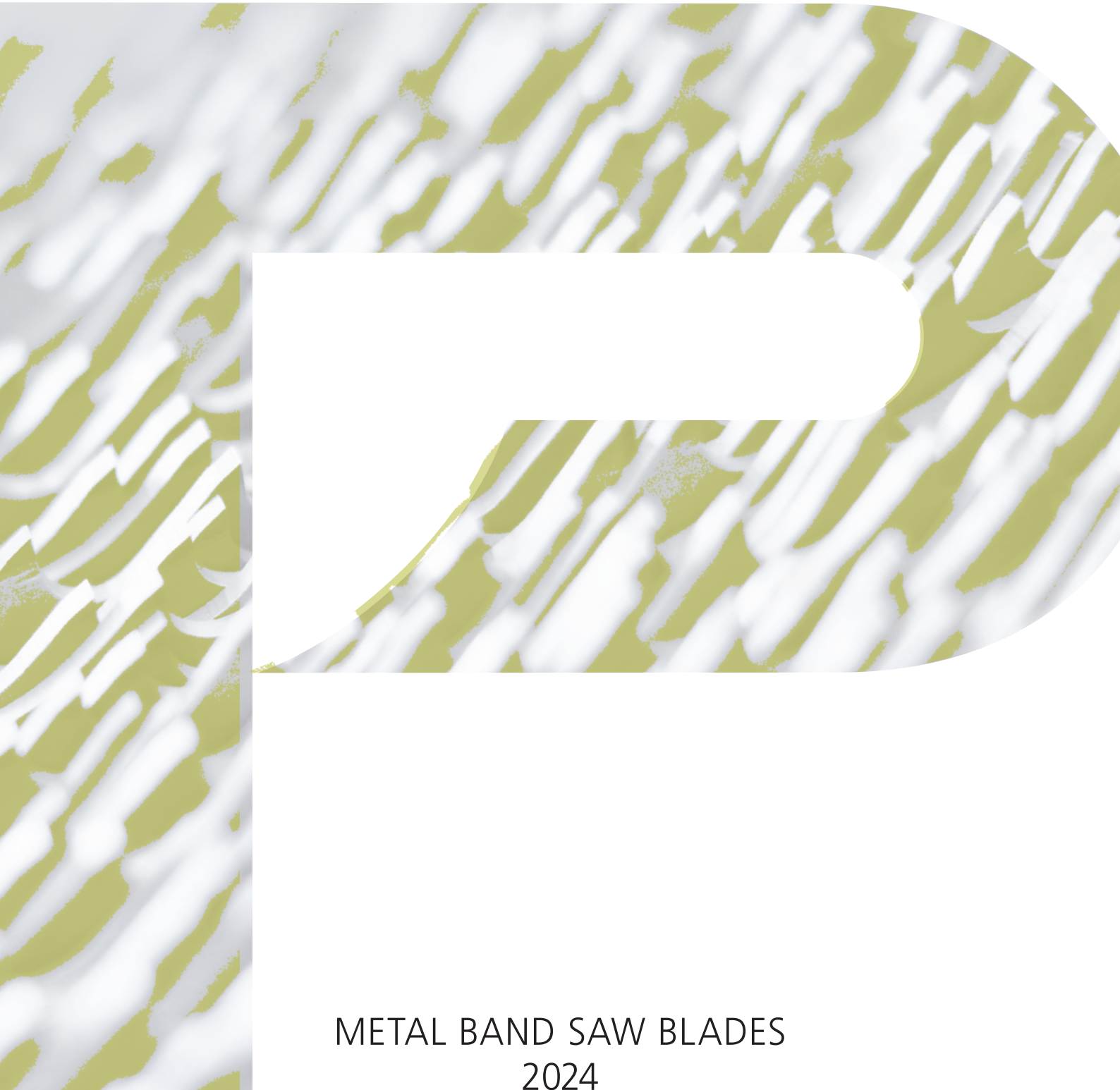


PONTUS

CUTTING PERFORMANCE



METAL BAND SAW BLADES
2024

INTRODUCTION

PONTUS, headquartered in Remscheid, Germany, is a highly specialized company for sawing solutions to all your cutting needs. We offer Band Saw Blades for almost all materials and all machines on the market.

Whether you are machining mild steel or high-alloyed exotic materials, PONTUS delivers the right blade.

At PONTUS we care

Accuracy is a top priority for us. Every step in the production process is carefully monitored and controlled to secure a consistently high-quality product.

Safe transportation is ensured. Your product will be protected against corrosion and carefully packed to reach you in perfect condition.

This is where the actual life cycle of the product begins. After running in, the Band Saw Blade develops its full performance capability over a long service life. Cut after cut, it delivers excellent value for money.

At PONTUS support goes beyond the product. Our team will advise you on the right blade selection and the appropriate cutting data from our extensive experience database and will help you with any questions you may have about the application.

The PONTUS product range

The PONTUS M42 and M51 Bi-Metal product range extends from the milled, SK and SB types to the precision ground SX, EX types, which enable extremely accurate cuts in even the hardest and toughest materials.

For high-speed and applications in special environments, our Carbide Tipped Band Saw Blades with triple and multi chip geometry are the next level.

A large part of our article groups can be optionally upgraded with our special coating for the highest demands. This further extends the service life at extremely high cutting speeds and feed rates.

Your PONTUS team



Product	Page
SK 10	5
EK 15	5
SK 07	6
SP 07	6
SCP	6
ECP	6
SX 10	7
EX 15	7
SB 10	8
SB 07	8
TTG	9
TTS	9
TDN	9
TVM	10
TMF	10
TMP	10
TSS	11
TSB	11
WP 00	11



How to break-in a new Band Saw Blade:

A proper break-in procedure of the new Band Saw Blade will ensure longer blade life. The following break-in instructions round up the sharp tooth edges and will prevent tooth breakages and crooked cuts.

BI-METAL

1. Set the Band Saw Blade speed according the material to cut.
2. Feed reduction of 50 % for around 10-15 minutes or 300-500 cm².
3. Gradually increasing the feed rate up to 100%.
4. If any vibrations occur slightly reduce the blade speed or slightly increase the blade feed rate.

CARBIDE

1. During the first 20-30 minutes, depending on the material, set the cutting speed to 25-30 m/min. and feed rate to 3-5 mm/min.
2. If any vibrations occur slightly reduce the blade speed or slightly increase the blade feed rate.

Recommendation for tooth selection

Solid material

Cross section mm	Teeth per inch (Tpi)
> 550	0,75/1,25
380 - 750	1/1,3
250 - 550	1,4/2
120 - 350	2/3
80 - 140	3/4
60 - 110	4/6
40 - 70	5/7 5/8
30 - 60	6/10
20 - 40	8/11 8/12
up to 25	10/14

Thin walled profiles

Wall thickness mm	Diameter in mm						
	20	40	60	80	100	120	150
2	14	14	14	14	14	14	10/14
3	14	14	14	14	10/14	10/14	8/11 8/12
4	14	14	10/14	10/14	8/11 8/12	8/11 8/12	6/10
5	14	10/14	10/14	8/11 8/12	8/11 8/12	6/10	6/10
6	14	10/14	8/11 8/12	8/11 8/12	6/10	6/10	5/7 5/8
8	14	8/11 8/12	6/10	6/10	5/7 5/8	5/7 5/8	5/7 5/8
10	-	6/10	6/10	5/7 5/8	5/7 5/8	5/7 5/8	-

These data are valid only for single cuts. If two or more profiles are cut side by side, the tables apply considering the double wall thickness.

Thick walled profiles

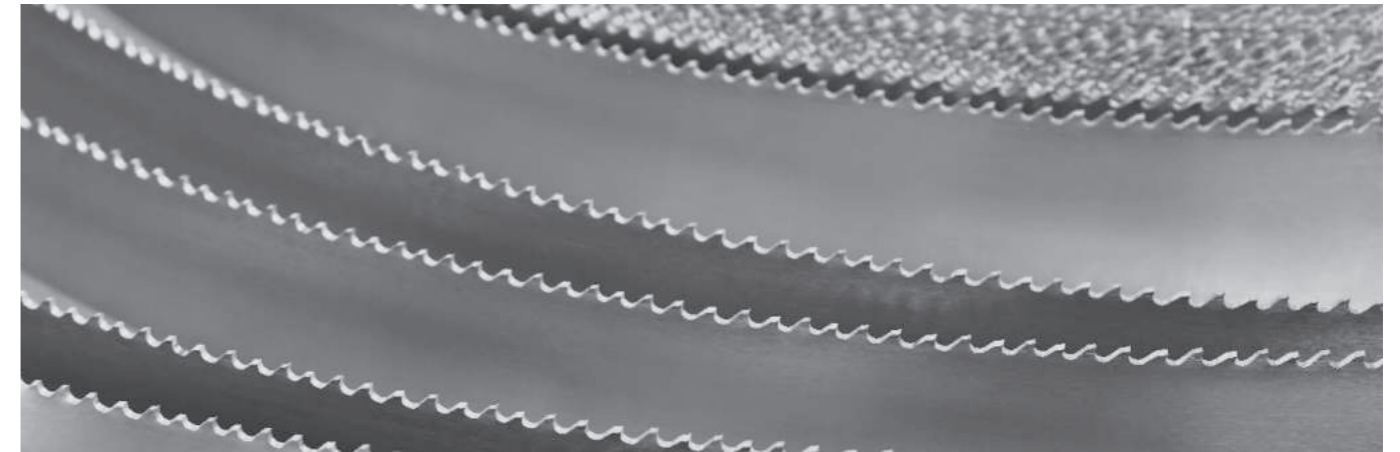
Wall thickness mm	Diameter in mm							
	80	100	120	150	200	300	500	750
10	-	-	-	4/6	4/6	4/6	3/4	2/3
15	4/6	4/6	4/6	4/6	4/6	3/4	2/3	2/3
20	4/6	4/6	4/6	4/6	3/4	3/4	2/3	2/3
30	4/6	4/6	4/6	3/4	3/4	2/3	2/3	2/3
50	-	-	3/4	3/4	2/3	2/3	2/3	1,4/2
80	-	-	-	-	2/3	2/3	1,4/2	1,4/2
100	-	-	-	-	-	2/3	1,4/2	1,4/2

Delivery lengths for Bi-Metal coils

PONTUS Bi-Metal Band Saw Blades are supplied as endless welded loops to fit your band saw machines, or in coils.

Coils can be delivered in different coil lengths. Please notice that the minimum order quantities refer to the production length.

Width	Coil length
6 - 13 mm	30+76 m
20 - 34 mm	100 m
41 mm	80 m
54 - 67 mm	90 m
80 mm	40 m



- Classic tooth geometry to suit all your general-purpose needs
- Variable tooth design for a wider range of material sizes
- M42 HSS tooth tip for long and reliable performance

M42

SK 10

Dimensions		Teeth per inch													
mm	inch	0,75/1,25	1,4/2	2/3	3	3/4	4	4/6	6	5/8	6/10	8/12	10/14	14	18
6 x 0,90	1/4 x 0,035														
10 x 0,90	3/8 x 0,035														
13 x 0,65	1/2 x 0,025														
13 x 0,90	1/2 x 0,035														
20 x 0,90	3/4 x 0,035														
27 x 0,90	1 x 0,035														
34 x 1,10	1 1/4 x 0,042														
41 x 1,30	1 1/2 x 0,050														
54 x 1,30	2 x 0,050														
54 x 1,60	2 x 0,063														
67 x 1,60	2 5/8 x 0,063														
80 x 1,60	3 x 0,063														



M51

EK 15

Dimensions		Teeth per inch							
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3	3/4	4/6	5/8	
27 x 0,90	1 x 0,035								
34 x 1,10	1 1/4 x 0,042								
41 x 1,30	1 1/2 x 0,050								
54 x 1,60	2 x 0,063								
67 x 1,60	2 5/8 x 0,063								
80 x 1,60	3 x 0,063								

- Classic tooth geometry to suit all your general-purpose needs
- Variable tooth design for a wider range of material sizes
- M51 HSS tooth tip for improved wear resistance



M42		SK 07				
Dimensions		Teeth per inch				
mm	inch	2/3	3/4	4/6	5/7	8/11

- Robust tooth geometry that provides excellent shock resistance
- Modified gullet design to reduce vibration
- Progressive tooth set pattern to avoid material pinching

20 x 0,90	3/4 x 0,035			•	•	•
27 x 0,90	1 x 0,035		•	•	•	•
34 x 1,10	1 1/4 x 0,042	•	•	•	•	
41 x 1,30	1 1/2 x 0,050	•	•			



M42		SP 07	
Dimensions		Teeth per inch	
mm	inch	2/3	3/4

- The powerhouse for machining large profiles and beams
- Extended blade life due to robust tooth design even in bundle cutting with chip nests
- Extra wide set prevents jamming in materials with high residual stress

41 x 1,30	1 1/2 x 0,050	•	•
54 x 1,60	2 x 0,063	•	•
67 x 1,60	2 5/8 x 0,063	•	



M42		SCP			
Dimensions		Teeth per inch			
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3

- Aggressive tooth geometry to improve penetration in work-hardening applications
- Variable set and hi-lo tooth pattern for added penetration while reducing vibration
- High Chrome premium backer for a long blade life

41 x 1,30	1 1/2 x 0,050			•	•
54 x 1,60	2 x 0,063		•	•	•
67 x 1,60	2 5/8 x 0,063	•	•	•	
80 x 1,60	3 x 0,063	•	•		



M51		ECP			
Dimensions		Teeth per inch			
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3

- Aggressive tooth geometry to improve penetration in work-hardening applications
- Variable set and hi-lo tooth pattern for added penetration while reducing vibration
- M51 HSS tooth tip for improved wear resistance

34 x 1,10	1 1/4 x 0,042				•
41 x 1,30	1 1/2 x 0,050			•	•
54 x 1,60	2 x 0,063		•	•	•
67 x 1,60	2 5/8 x 0,063	•	•	•	
80 x 1,60	3 x 0,063	•	•	•	



M42		SX 10				
Dimensions		Teeth per inch				
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3	3/4

- The powerhouse with ground tooth tips for robust performance in versatile applications on steels and non-ferrous metals up to 1400 N/mm2 tensile strength
- Excellent cutting surfaces and precise cuts

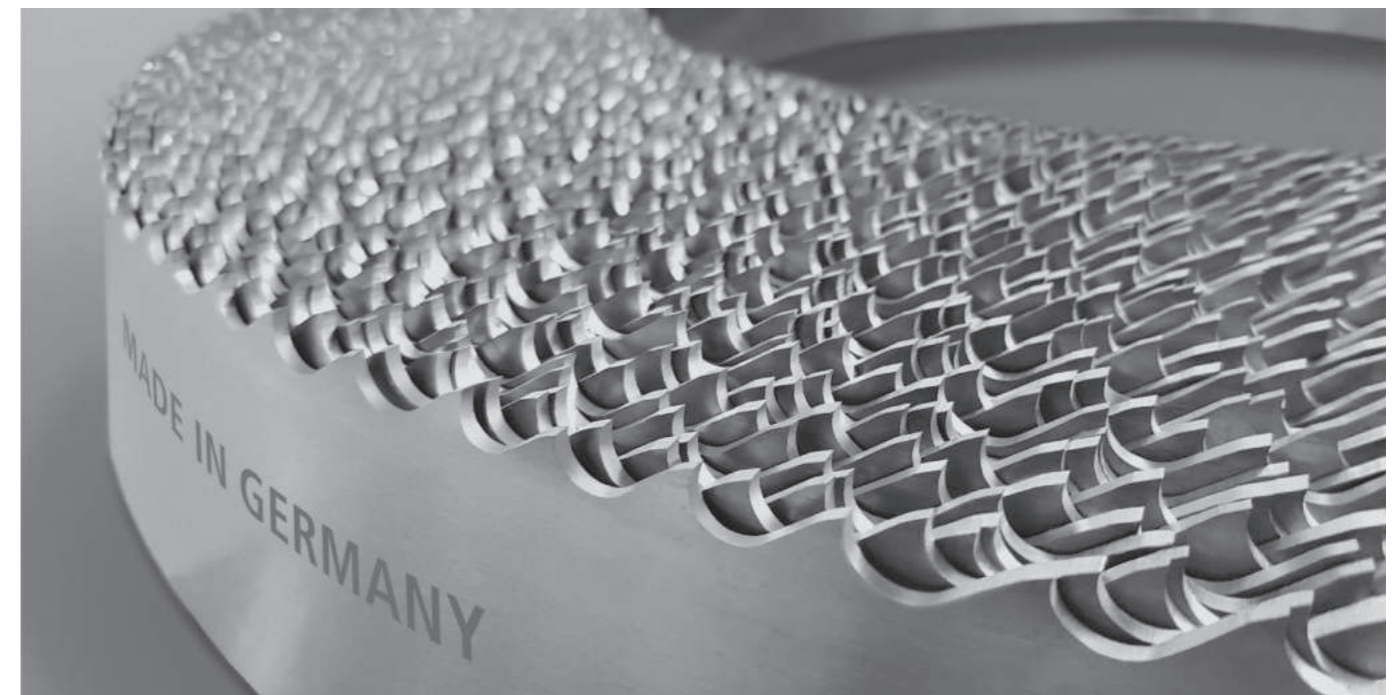
27 x 0,90	1 x 0,035				•	•
34 x 1,10	1 1/4 x 0,042			•	•	•
41 x 1,30	1 1/2 x 0,050			•	•	•
54 x 1,30	2 x 0,050			•	•	•
54 x 1,60	2 x 0,063	•		•	•	•
67 x 1,60	2 5/8 x 0,063	•	•	•	•	•
80 x 1,60	3 x 0,063	•	•	•		



M51		EX 15			
Dimensions		Teeth per inch			
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3

- The top-tier of high-performance Band Saw Blades with ground teeth and extremely aggressive tooth geometry for materials up to 1700 N/mm2 tensile strength
- Bi-Metal Band Saw Blade delivering carbide-level performance for heavy-duty cutting tasks on machines without carbide package
- Straight cuts with increased throughput, impressive machining rates and faster feeds

27 x 0,90	1 x 0,035				•
34 x 1,10	1 1/4 x 0,042				•
41 x 1,30	1 1/2 x 0,050			•	•
54 x 1,60	2 x 0,063		•	•	•
67 x 1,60	2 5/8 x 0,063	•	•	•	•
80 x 1,60	3 x 0,063	•	•	•	





- The budget-friendly choice with a wide range of tooth profiles
- Versatile application for thin-walled profiles up to large solid material workpieces

M42

SB 10

Dimensions		Teeth per inch									
mm	inch	0,75/1,25	1/1,3	1,4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14
13 x 0,65	1/2 x 0,025							•	•	•	•
13 x 0,90	1/2 x 0,035							•	•	•	•
20 x 0,90	3/4 x 0,035						•	•	•	•	•
27 x 0,90	1 x 0,035				•	•	•	•	•	•	•
34 x 1,10	1 1/4 x 0,042			•	•	•	•	•	•	•	•
41 x 1,30	1 1/2 x 0,050			•	•	•	•				
54 x 1,30	2 x 0,050			•	•	•	•				
54 x 1,60	2 x 0,063	•		•	•	•	•				
67 x 1,60	2 5/8 x 0,063	•	•	•	•	•					
80 x 1,60	3 x 0,063	•	•	•							

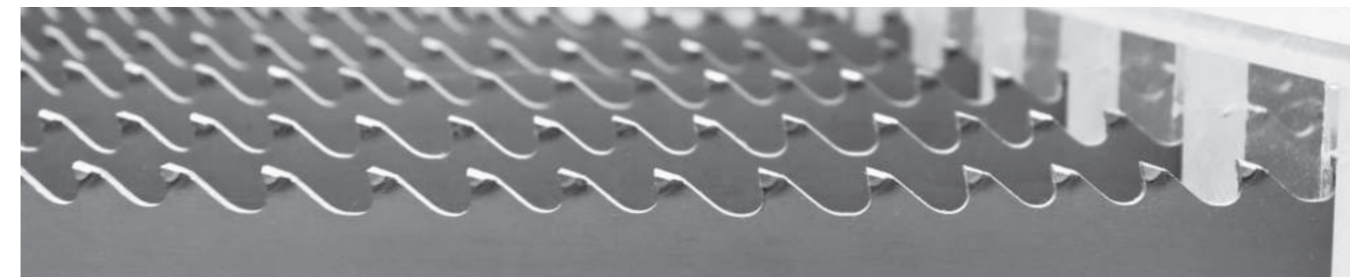


M42

SB07

Dimensions		Teeth per inch					
mm	inch	2/3	3/4	4/6	5/7	8/11	12/16
20 x 0,90	3/4 x 0,035				•	•	•
27 x 0,90	1 x 0,035		•	•	•	•	•
34 x 1,10	1 1/4 x 0,042		•	•	•		
41 x 1,30	1 1/2 x 0,050	•	•	•	•		
54 x 1,60	2 x 0,063	•	•	•			
67 x 1,60	2 5/8 x 0,063	•	•				

- The budget-friendly multitool with a robust tooth design for varying cutting tasks
- Saves inventory costs with extended tool life in mixed operations
- Reduced blade changes



TTG

Dimensions		Teeth per inch			
mm	inch	0,75/1,25	1/1,5	1,4/2	2/3
41 x 1,30	1 1/2 x 0,050			•	•
54 x 1,60	2 x 0,063		•	•	•
67 x 1,60	2 5/8 x 0,063	•	•	•	•
80 x 1,60	3 x 0,063	•		•	

- Robust Triple chip geometry for consistent performance
- Positive tooth angle with hi-lo tooth design for increased penetration
- Carbide grade developed for robust performance



TTS

Dimensions		Teeth per inch				
mm	inch	0,75/1,25	1,4/2	2/3	3	3/4
20 x 0,90	3/4 x 0,035				•	
27 x 0,90	1 x 0,035			•	•	•
34 x 1,10	1 1/4 x 0,042		•	•		•
41 x 1,30	1 1/2 x 0,050		•	•		•
54 x 1,30	2 x 0,050		•	•		
54 x 1,60	2 x 0,063	•	•	•		
67 x 1,60	2 5/8 x 0,063	•	•			
80 x 1,60	3 x 0,063	•	•			

- Modified triple chip geometry combined with set teeth
- Wide kerf to create excellent cut stability
- Robust performance in all machine types



TDN

Dimensions		Teeth per inch					
mm	inch	0,65/0,95	0,75/1,25	1,4/2	2/3	3	3/4
20 x 0,90	3/4 x 0,035					•	
27 x 0,90	1 x 0,035				•	•	•
34 x 1,10	1 1/4 x 0,042			•	•	•	•
41 x 1,30	1 1/2 x 0,050			•	•		•
54 x 1,30	2 x 0,050			•	•		
54 x 1,60	2 x 0,063		•	•	•		
67 x 1,60	2 5/8 x 0,063		•				
80 x 1,60	3 x 0,063	•	•				

- Triple chip design
- Carbide grade designed for high abrasion
- Developed for high-speed non-ferrous applications



TVM

Dimensions		Teeth per inch				
mm	inch	0,75/1,25	1/1,5	1,4/2	2/3	3/4

34 x 1,10	1 1/4 x 0,035				•	•
41 x 1,30	1 1/2 x 0,050			•	•	
54 x 1,60	2 x 0,063	•	•	•	•	
67 x 1,60	2 5/8 x 0,063	•	•	•		
80 x 1,60	3 x 0,063	•		•		

- High performance chrome backer with enhanced carbide grade for maximum performance
- Multi-chip geometry to provide faster cutting times
- High positive rake angle to increase penetration



TMF

Dimensions		Teeth per inch				
mm	inch	0,75/1,25	1/1,5	1,4/2	2/3	3/4

27 x 0,90	1 x 0,035				•	•
34 x 1,10	1 1/4 x 0,042			•	•	•
41 x 1,30	1 1/2 x 0,050			•	•	•
54 x 1,30	2 x 0,050			•	•	
54 x 1,60	2 x 0,063	•	•	•	•	•
67 x 1,60	2 5/8 x 0,063	•	•	•	•	
80 x 1,60	3 x 0,063	•		•		

- Multi-chip design
- Developed for fast band speeds
- High positive rake angle to increase penetration



TMP

Dimensions		Teeth per inch		
mm	inch	1,4/2	2/3	3/4

27 x 0,90	1 x 0,035		•	•
34 x 1,10	1 1/4 x 0,042		•	•
41 x 1,30	1 1/2 x 0,050	•	•	•
54 x 1,60	2 x 0,050	•	•	•

- Multi-chip design
- Developed for fast band speeds
- High positive rake angle to increase penetration

Delivery lengths for Carbide Tipped Band Saw Blades

PONTUS Carbide Tipped Band Saw Blades are supplied as endless welded loops or in coils:

Width	Coil length
27 - 80 mm	50 m



TSS

Dimensions		Teeth per inch
mm	inch	

27 x 0,90	1 x 0,035	•
-----------	-----------	---

- The confident choice for softer construction materials like aerated concrete, insulation boards, and insulating materials
- Set Carbide Tipped Band Saw Blade with wide clearance reduces jamming and buildup of deposits



TSB

Dimensions		Teeth per inch
mm	inch	

27 x 0,90	1 x 0,035	•
34 x 1,10	1 1/4 x 0,042	•

- The master for hard and abrasive construction materials like solid, engineered, and perforated bricks
- Vibration-free cutting with reduced force required due to high-performance, precision-ground tooth geometry
- Perfect cutting results



WP00

Dimensions		Teeth per inch
mm	inch	

34 x 1,10	1 1/4 x 0,042	•
-----------	---------------	---

- The rustic for repair and dismantling of wooden pallets
- Special tooth geometry guarantees constant performance while sawing through nails and staples



PONTUS

CUTTING PERFORMANCE

PONTUS GmbH Phone: +49 (0)2191 79303 - 30
Eisenstraße 1 Fax: +49 (0)2191 79303 - 5932
42859 Remscheid E-Mail: info@pontus-saw.com
GERMANY www.pontus-saw.com

MADE IN GERMANY