Honsberg®

Qualität, Tradition und Fortschritt

Quality, Tradition and Progress

Tiekstra Techniek
Metaalbewerkingsmachines en toebehoren

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Quality, tradition and progress for over 200 years

Quality, tradition and progress merge at Honsberg. Already in 1798 the Honsberg brothers started to produce metal and wood cutting saw blades in Remscheid, the German centre for tool industry. Since 1987 Honsberg Metallsägen GmbH - as an independent company - is specialised in the development, production, distribution and service of metal bandsaw blades world-wide.

Research and development by Honsberg has always been ongoing and we have been foremost in producing and refining bimetal and tungsten carbide products to meet the increasing customer demands for high quality cutting tools at competitive pricing.

Today we supply 1st class cutting solutions for all possible metal cutting tasks. Our customers rely on our permanent high quality level confident that saw blades produced under the Honsberg brand meet even highest demands regarding precision, reliability and permanent product control. All items are therefore produced to ISO 9001 standards.

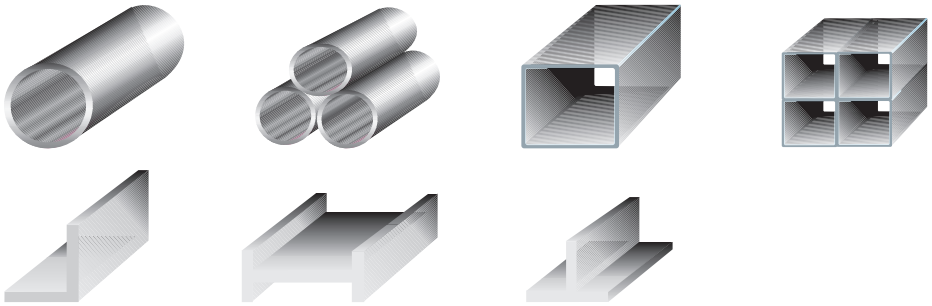
Based on this, today Honsberg Metallsägen as a global player is one of the biggest suppliers for metal cutting saw blades. Leading companies rely on the productivity of the Honsberg products and the service of the Honsberg team. Permanent research and development will guarantee to reach top quality results in bandsaw blade technique together with our customers also in the future.

Extra / Flexback

No. 061 / Carbon Steel Bandsaw Blades

Flexible bandsaw blade made out of one piece of chrome alloyed carbon steel with a pin point carbide structure and a teeth hardness of approx. 64 HRc. The areas of application are the cutting of non-alloyed low strength steels on light-weight bandsaw machines or verticals.

Area of application



For cutting of non alloyed low strength steels

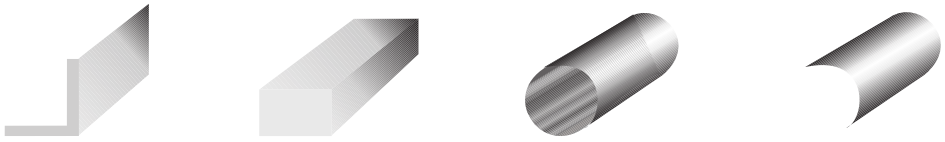
Specification Honsberg Extra										
Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi								
mm	Inches	2	3	4	6	8	10	14	18	24
6 x 0,65	1/4 x .025			K	S/K	S	S	S	S	S
8 x 0,65	5/16 x .025			K	S/K	S	S	S	S	S
10 x 0,65	3/8 x .025		K	K	S/K	S	S	S	S	S
13 x 0,65	1/2 x .025		K	K	S/K	S	S	S	S	S
16 x 0,80	5/8 x .032		K	S/K	S	S	S	S	S	S
20 x 0,80	3/4 x .032		K	K	S	S	S	S	S	S
25 x 0,90	1 x .035	K	K	S/K	S	S	S	S		S

Super / Hardback

Carbon Steel Bandsaw Blades / No. 062

Bandsaw blade made out of one piece of alloyed and tempered carbon steel with a pin point structure and a teeth hardness of approx. 66 HRc. Higher wear resistance and higher cutting parameters are a result of the tempered backing material with a hardness of approx. 43 HRc.

Area of application



For cutting low alloyed steels up to a tensile strength of approx. 22 HRc

Specification Honsberg Super

Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi							
mm	Inches	3	4	6	8	10	14	18	24
6 x 0,65	1/4 x .025		K	S/K	S	S	S	S	S
8 x 0,65	5/16 x .025			S/K	S	S	S	S	S
10 x 0,65	3/8 x .025		K	S/K	S	S	S	S	S
13 x 0,65	1/2 x .025	K	K	S/K	S	S	S	S	S
16 x 0,80	5/8 x .032	K	S/K	S	S	S	S		S
20 x 0,80	3/4 x .032		K	S	S	S	S	S	S
25 x 0,90	1 x .035	K	S/K	S/K	S	S	S		

Vision / Bimetal M42

No. 072 V / Bimetal Bandsaw Blades

Bimetal bandsaw blade made of ~4% high chrome alloyed backing material and a HSS cutting edge made of HSS M42 / material No. 1.3247 with a cobalt content of 8%. The teeth hardness of approx. 68 HRc combined with a tenacious backing material with highbending fatigue strength is ideal for the cutting of all common steels grades up to a hardness of approx. 45 HRc.

Area of application

For universal usage for mixed materials (solids and structurals) and diameters for all types of steel and machinery

Specification Standard Teeth - Honsberg Vision

Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi					
mm	Inches	3	4	6	8	10	14
6 x 0,65	1/4 x .025			K			
6 x 0,90	1/4 x .035			K		S	S
10 x 0,65	3/8 x .025			K			
10 x 0,90	3/8 x .035		K	K	S	S	S
13 x 0,65	1/2 x .025			K		S	S
13 x 0,90	1/2 x .035	K	K	K	S	S	S
20 x 0,90	3/4 x .035	K	K				S

Specification Vario Teeth - Honsberg Vision

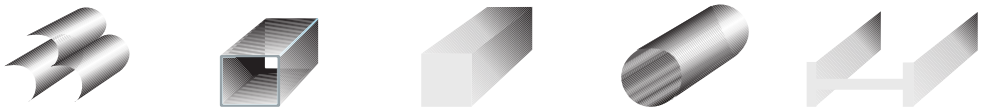
Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi				
mm	Inches	4/6	5/8	6/10	8/12	10/14
6 x 0,65	1/4 x .025					S
6 x 0,90	1/4 x .035					S
10 x 0,65	3/8 x .025					S
10 x 0,90	3/8 x .035					S
13 x 0,65	1/2 x .025			S	S	S
13 x 0,90	1/2 x .035					S
20 x 0,90	3/4 x .035	K	S	S	S	S

Spectra / Bimetal M42

Bimetal Bandsaw Blades / No. 072 S

Bimetal bandsaw blade made of ~4% high chrome alloyed backing material and a HSS cutting edge made of HSS M42 / material No. 1.3247 with a cobalt content of 8%. The teeth hardness of approx. 68 HRc combined with a tenacious backing material with highbending fatigue strength is ideal for the cutting of all common steels grades up to a hardness of approx. 45 HRc in all diameters. Honsberg Spectra is the cutting solution for universal usage of bimetal bandsaw blades with mixed materials and diameters for all types of steel and machinery.

Area of application



For universal usage for mixed materials (solids and structurals) and diameters for all types of steel and machinery

Specification Standard Teeth - Honsberg Spectra

Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi								
mm	Inches	0,75	1,25	2	3	4	6	8	10	14
27 x 0,90	1 1/16 x .035			K	K/S	K/S	K/S	S	S	S
34 x 1,10	1 3/8 x .042		K	K	K/S	K/S	S	S	S	
41 x 1,30	1 5/8 x .050		K	K	K	K				
54 x 1,30	2 1/8 x .050		K							
54 x 1,60	2 1/8 x .063		K	K	K					
67 x 1,60	2 5/8 x .063		K	K						
80 x 1,60	3 1/8 x .063	K	K							

Specification Vario Teeth - Honsberg Spectra

Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi										
mm	Inches	0,75/ 1,25	1,1/ 1,6	1,5/ 2	2/3	3/4	4/5	4/6	5/6	5/8	6/10	8/12	10/14
27 x 0,90	1 1/16 x .035				K	K/S	K	K/S	K	S	S	S	S
34 x 1,10	1 3/8 x .042				K	K/S	K	K/S	K	S	S	S	
41 x 1,30	1 5/8 x .050			K	K	K/S	K	K/S		S	S	S	
54 x 1,30	2 1/8 x .050		K	K	K	K	K	K					
54 x 1,60	2 1/8 x .063	K	K	K	K	K	K	K	K				
67 x 1,60	2 5/8 x .063	K	K	K	K	K							
80 x 1,60	3 1/8 x .063	K	K	K	K								

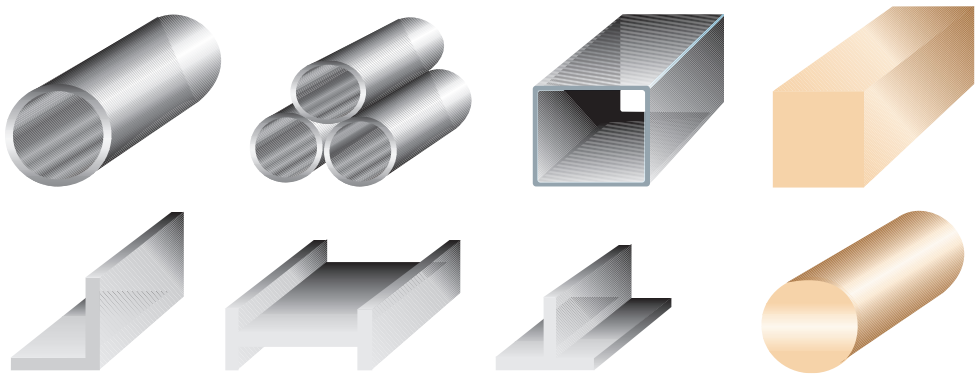
Secura / Bimetal M42

No. 072X / Bimetal Bandsaw Blades

Bimetal Bandsaw blade made of ~ 4% high chrome alloyed tenacious backing material and a HSS cutting edge made of HSS M42 / material No. 1.3247 with a cobalt content of 8% and a hardness of approx. 68 HRc.

The special Secura tooth and set geometry prevents the blade from binding in the cutting channel, f.e. heavy I beams and structurals. The ultimate service life is reached by its shock resistant tooth style which absorbs vibration typical for structural cutting best.

Area of application



Heavy structurals or non ferrous metals

Specification Honsberg Secura

Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi								
		FOR NON FERROUS METALS				*FOR HEAVY BEAMS & STRUCTURALS*				
mm	Inches	1,25	2	3	4	2/3	3/4	4/6	5/7	8/11
13 x 0,90	1/2 x .035			X	X					
20 x 0,90	3/4 x .035			X						
27 x 0,90	1 1/16 x .035		X	X	X		X	X	X	X
27 x 1,10	1 1/16 x .042		X							
34 x 1,10	1 3/8 x .042	X	X	X		X	X	X	X	
41 x 1,30	1 5/8 x .050					X[1)]	X[1)]	X	X	
54 x 1,60	2 1/8 x .063					X	X	X		
67 x 1,60	2 5/8 x .063					X	X	X		

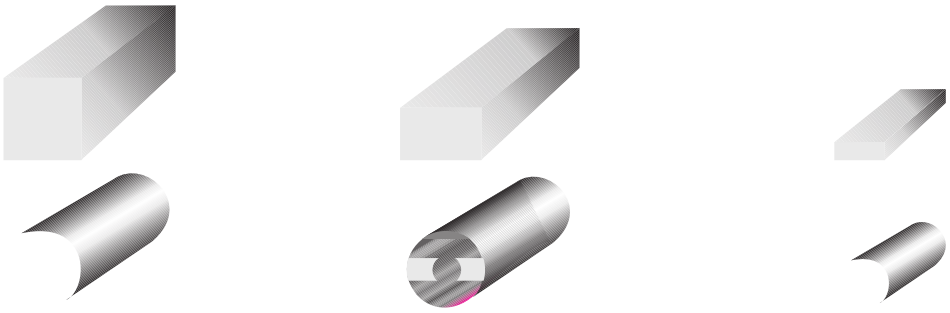
[1)] also available with extra heavy set

Delta / Bimetal M42

Bimetal Bandsaw Blades / No. 073

Bimetal bandsaw blade made of ~4% high chrome alloyed tenacious backing material and a HSS cutting edge made of HSS M42 / material No. 1.3247 with a cobalt content of 8% and a hardness of approx. 68 HRc. This blade with an aggressive cutting angle of 16° positive (see also page 3) is designed to cut solids and thick walled tubes and structurals on 2-column and swing type machinery with low vibrations. The advantages of this blade are an easy cutting behavior with good chip formation and smooth cutting. All in all, this leads to an increase in life time compared to standard bimetal bandsaw blades.

Area of application



Designed to cut solids and thick walled tubes and structurals on 2-column and swing type machinery with low vibrations. Also most recommendable to cut non-ferrous materials.

Specification Honsberg Delta

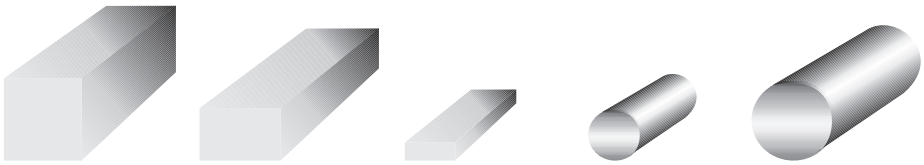
Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi				
mm	Inches	0,75/1,25	1,1/1,6	1,5/2	2/3	3/4
27 x 0,90	1 1/16 x .035					D
34 x 1,10	1 3/8 x .042			D	D	D
41 x 1,30	1 5/8 x .050			D	D	D
54 x 1,60	2 1/8 x .063		D	D	D	D
67 x 1,60	2 5/8 x .063	D	D	D	D	
80 x 1,60	3 1/8 x .063	D	D			

Master / Bimetal M42

No. 074 / Bimetal Bandsaw Blades

Bimetal bandsaw blade made of ~4% high chrome alloyed tenacious backing material and a HSS cutting edge made of HSS M42 / material No. 1.3247 with a cobalt content of 8% and a hardness of approx. 68 HRc. The cutting angle of 10° positive combined with a borazon ground Triple Tooth Concept with pre- and finishing cutters (see also page 3) leads to an aggressive cut which is recommended for higher alloyed materials.

Area of application



Suitable for cutting stainless steels, heat resistant alloys and titanium as solids on 2-column and block bandsaw machinery.

Specification Honsberg Master

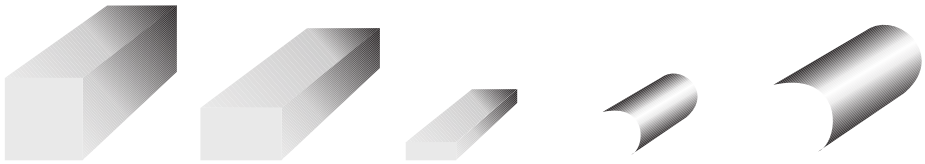
Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi								
mm	Inches	1,25	2	3	4	0,75/ 1,25	1,1/ 1,6	1,5/ 2	2/3	3/4
27 x 0,90	1 1/16 x .035			M	M					M
34 x 1,10	1 3/8 x .042		M	M	M				M	M
41 x 1,30	1 5/8 x .050	M		M				M	M	M
54 x 1,30	2 1/8 x .050							M		
54 x 1,60	2 1/8 x .063	M				M	M	M	M	M
67 x 1,60	2 5/8 x .063	M				M	M	M		
80 x 1,60	3 1/8 x .063					M				

Radial / Bimetal M42

Bimetal Bandsaw Blades / No. 075

Bimetal bandsaw blade made of ~4% high chrome alloyed tenacious backing material and a HSS cutting edge made of HSS M42 / material No. 1.3247 with a cobalt content of 8% and a hardness of approx. 68 HRc. Honsberg Radial is the world-wide leading solution for cutting high- and highest alloyed solids on low vibration 2-column bandsaw and block bandsaw machinery for production cutting. Honsberg engineers managed to merge the 16° positive cutting angle (see also page 3) with the reliable Triple Tooth Concept and a special set. The result is a highly aggressive cut behavior with excellent finish and highest cutting rates.

Area of application



New development for cutting high- and highest alloyed steels and alloys, nickel base superalloys on 2 column and block bandsaw machinery.

Specification Honsberg Radial

Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi				
mm	Inches	0,75/1,25	1,1/1,6	1,5/2	2/3	3/4
34 x 1,10	1 3/8 x .042			R	R	R
41 x 1,30	1 5/8 x .050			R	R	R
54 x 1,60	2 1/8 x .063		R	R	R	R
67 x 1,60	2 5/8 x .063	R	R	R		
80 x 1,60	3 1/8 x .063	R	R			

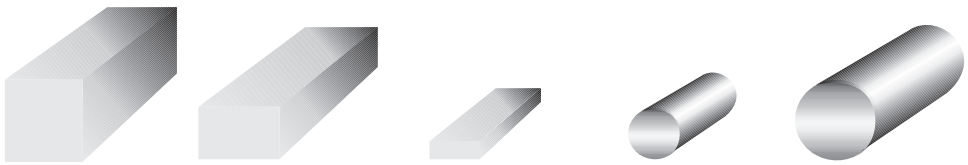
Duratec / Bimetal M51

No. 070 / Bimetal Bandsaw Blades

Bimetal bandsaw blade made of ~ 4% high chrome alloyed tenacious backing material and a HSS cutting edge made of HSS M51 / material No. 1.3207 with a cobalt and tungsten content of 10% each reaching a hardness of ~ 69 HRc.

The higher alloyed cutting edge is designed to cut high strength steel grades. Higher resistance against thermal and abrasive wear increases the service life especially cutting long cross sections.

Area of application



Designed to cut higher alloyed solids and tick walled tubes on low vibration machinery.

Specification Honsberg Duratec

Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi						
mm	Inches	0,75/ 1,25	1,1/1,6	1,5/2	2/3	3/4	4/5	4/6
27 x 0,90	1 1/16 x .035				K	K	K	K
34 x 1,10	1 3/8 x .042				K	K		K
41 x 1,30	1 5/8 x .050			K	K	K		K
54 x 1,60	2 1/8 x .063			K	K	K		K
67 x 1,60	2 5/8 x .063	K	K	K	K			
80 x 1,60	3 1/8 x .063	K						

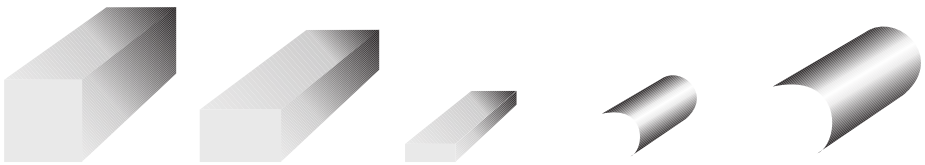
Aurum / Bimetal M51

Bimetal Bandsaw Blades / No. 078

Bimetal Bandsaw Blade made of ~ 4% high chrome alloyed tenacious backing material and a HSS cutting edge made of HSS M51 / material No. 1.3207 with a cobalt and tungsten content of 10% each reaching a hardness of ~ 69 HRc. Honsberg technicians merged the 16° positive cutting angle with a special setting and blade geometry to generate this high end blade in bimetal technique.

The higher alloyed cutting edge is designed to cut high strength steels grades. Higher resistance against thermal and abrasive wear increases the service life especially cutting long cross sections.

Area of application



Designed for cutting of high and highest steels and alloys, nickel base and super alloys up to 50 HRc on 2 column machinery. The product is 100% manufactured in the new HONSBERG NT DESIGN which guarantees lowest production tolerances to generate highest cutting rates and longest service life for professional endusers.

Specification Honsberg Aurum

Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi				
mm	Inches	0,75/1,25	1,1/1,6	1,5/2	2/3	3/4
34 x 1,10	1 1/3 x .042				•	•
41 x 1,30	1 5/8 x .050			•	•	
54 x 1,60	2 1/8 x .063		•	•	•	
67 x 1,60	2 5/8 x .063	•	•	•		
80 x 1,60	3 1/8 x .063	•	•	•		

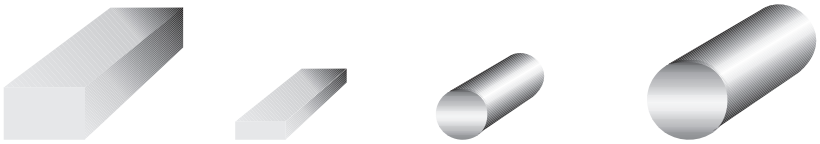
Sinus III TAP / TCT

No. 076-37 / Tungsten Carbide Bandsaw Blades

TCT bandsaw blade with the proven ~4% high chrome alloyed tenacious backing material and a carbide tipped, diamond ground tooth edge.

The special Sinus III grind creates a tooth design with multi chipping sections for production cutting with lowest vibrations. Hallmarks of this high tech blade are best finish, highest cutting rates, heat resistancy and long service life

Area of application



Designed for universal High Performance Cutting specially for tool, stainless and high speed steels.

Specification Honsberg Sinus III TAP

Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi				
mm	Inches	0,85/1,15	1,1/1,6	1,5/2	2/3	3/4
27 x 0,90	1 1/16 x .035				•	•
34 x 1,10	1 1/3 x .042			•	•	•
41 x 1,30	1 5/8 x .050			•	•	•
54 x 1,30	2 1/8 x .050	•		•	•	
54 x 1,60	2 1/8 x .063	•	•	•	•	
67 x 1,60	2 5/8 x .063	•	•	•		
80 x 1,60	3 1/8 x .063	•	•			

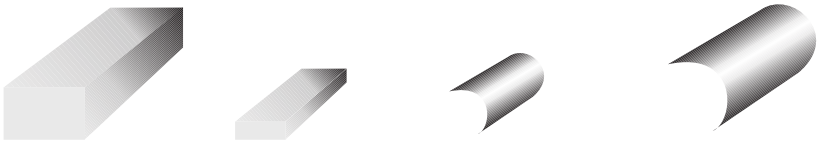
Sinus III TSA / TCT

Tungsten Carbide Bandsaw Blades / No. 076-33

TCT bandsaw blade with the proven ~4% high chrome alloyed tenacious backing material and a carbide tipped, diamond ground tooth edge.

The special Sinus III grind creates a tooth design with multi chipping sections for production cutting with lowest vibrations. Hallmarks of this high tech blade are best finish, highest cutting rates, heat resistancy and long service life.

Area of application



Designed for high speed cutting specially of large diameters of highest alloyed Cr, Ni, Ti steels grades and super alloys on High Speed Cutting machinery designed for TCT blades.

Specification Honsberg Sinus III TSA

Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi			
mm	Inches	0,85/1,15	1,1/1,6	1,5/2	2/3
34 x 1,10	1 1/3 x .042			•	•
41 x 1,30	1 5/8 x .050			•	•
54 x 1,30	2 1/8 x .050			•	
54 x 1,60	2 1/8 x .063	•	•	•	•
67 x 1,60	2 5/8 x .063	•	•	•	
80 x 1,60	3 1/8 x .063	•	•		

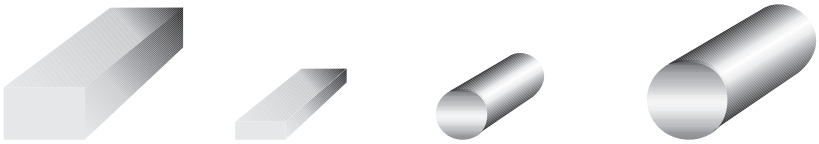
Sinus III TSN / TCT

No. 076-38 / Tungsten Carbide Bandsaw Blades

TCT bandsaw blade with the proven ~4% high chrome alloyed tenacious backing material and a carbide tipped, diamond ground tooth edge.

The special Sinus III grind creates a tooth design with multi chipping sections for production cutting with lowest vibrations. Hallmarks of this high tech blade are best finish, highest cutting rates, heat resistancy and long service life.

Area of application



Designed for hardened and tempered materials with hardness between 50-65 HRc.

Specification Honsberg Sinus III TSN

Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi	
mm	Inches	2/3	3/4
27 x 0,90	1 1/16 x .035		•
34 x 1,10	1 1/3 x .042	•	•
41 x 1,30	1 5/8 x .050	•	•

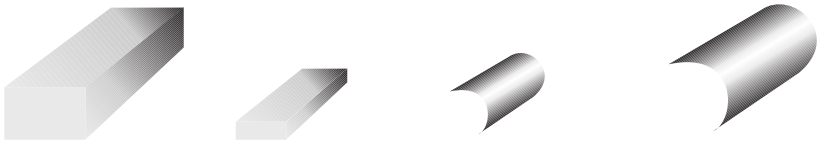
Sinus III TNF ALU / TCT

Tungsten Carbide Bandsaw Blades / No. 076-55

TCT bandsaw blade with the proven ~4% high chrome alloyed tenacious backing material and a carbide tipped, diamond ground tooth edge.

The special Sinus III grind creates a tooth design with multi chipping sections for production cutting with lowest vibrations. Hallmarks of this high tech blade are best finish, highest cutting rates, heat resistancy and long service life.

Area of application



Designed for non ferrous castings and foundry applications on vertical machinery and all kind of Aluminium cutting.

Specification Honsberg Sinus III TAP

Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi				
mm	Inches	2	3	0,85/1,15	1,1/1,6	1,5/2
20 x 0,90	3/4 x .035		•			
27 x 0,90	1 1/16 x .035		•			
34 x 1,10	1 1/3 x .042	•	•			•
41 x 1,30	1 5/8 x .050					•
54 x 1,30	2 1/8 x .050			•		•
54 x 1,60	2 1/8 x .063			•	•	•

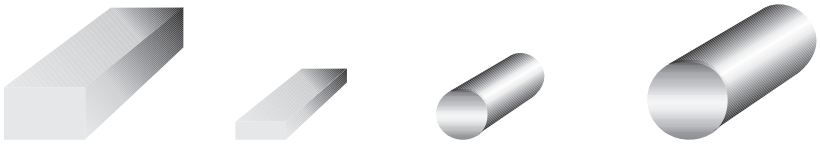
Sinus Black / TCT coated

No. 077-33 / Tungsten Carbide Bandsaw Blades

TCT bandsaw blade with the proven ~4% high chrome alloyed tenacious backing material and a carbide tipped, diamond ground tooth edge.

The special Sinus III grind creates a tooth design with multi chipping sections for production cutting with lowest vibrations. The precise diamond grind is uniquely coated to optimise heat conductivity leading to better chip flow. The results are an visible increase of service life and cutting rates compared to ordinary TCT bandsaw blades.

Area of application

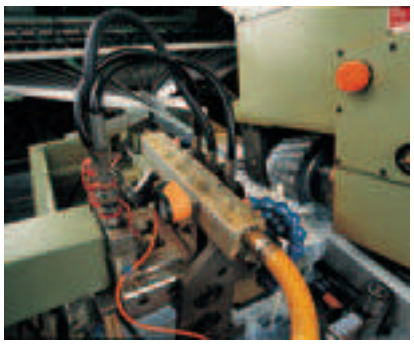


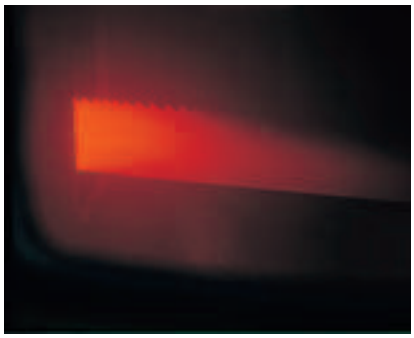
Designed for high speed cutting of highest alloyed Cr, Ni, Ti steels grades and super alloys on High Speed Cutting machinery designed for TCT blades. Recommended for endusers looking for the ultimate cutting experience.

Specification Honsberg Sinus Black

Size - Width x Thickness		Tooth Form - Pitches / Teeth per Inch / tpi			
mm	Inches	1,1/1,6	1,5/2	2/3	3/4
41 x 1,30	1 5/8 x .050		•	•	•
54 x 1,60	2 1/8 x .063	•	•	•	
67 x 1,60	2 5/8 x .063	•			

Honsberg®





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