

1. Saw blades

Saw blades

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Saw blades with brazed carbide (HM) tips designed for professional machining of solid soft, hard and glued wood, other wood-based materials, plastics and aluminum alloys. Saw blades are used for longitudinal, cross and angular cutting, formatting and grooving. They have been designed for specialist machines to guarantee optimal efficiency with requested cutting quality.

The tools are designed and manufactured with properly chosen blade geometry, with or without shear angle and optional chip flow. Wide range of teeth types allows to optimize machining efficiency. Additionally, saw blades for multi-blade machines are equipped with wiper knives which guarantee smooth surface, eliminate chip blocking and minimize material burning.

Saw blade bodies are produced from the highest quality steel in a special shaping technology, properly selected for the machining process and material as well as type of work, parameters and conditions prevailing during the machining, in order to guarantee proper and stable work of the tool both in standard and extreme conditions. Various blade types have various carbide types characterized with proper hardness, resilience, abrasion resistance and intergranular corrosion. It allows for precise choice of proper carbide for the type of material and machining.

All types of saw blades are manufactured on modern CNC machines of world-renowned producers, which guarantee high accuracy and precision of the produced tools. Very strict interoperational and final control does not accept any tools which do not meet high tolerance and production standards. The construction and production remains in accordance with all points of safety standard EN/PN-847-1 concerning tools for mechanical woodworking.

The *Saw blades* chapter includes only example types of drills with their basic dimensions. On special request, we can (after obtaining proper information) suggest, design and produce any type saw blade for the required type of machining, material, parameters and conditions of work. Offered saw blades diameters range between D=80 and D=800 mm. Time of production usually doesn't exceed 10 working days.

Orders should include:

- outer diameter (D) or diameters range,
- bore diameter (d) and number of key ways or driver holes,
- number of teeth (z) or spindle rotation speed and feed speed,
- cutting depth (H),
- type of machined material,
- flange diameter.



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Pictograms

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solid dry softwood



solid dry hardwood



solid wet softwood



solid wet hardwood



solid frozen wood



coniferous wood



deciduous wood



chipboard



plywood



laminated board



glued wood



LDF board



MDF board



HDF board



light alloys



plastics



drywall



construction board



sandwich panels



profiles



flat surface



longitudinal cut



cross cut



cross and longitudinal cut



angular cut



cutting in stack



cutting with scoring saw blade



scoring saw blade



saw blade for grooves



single cut



multi-rip saw blade



mechanical feed



manual feed



saw blade with noise reduction



saw blade without noise reduction



carbide



stellite

- product available on stock
- + approximate production time 9 days

Tooth configuration

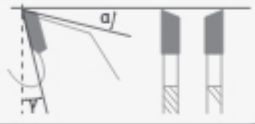
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GM

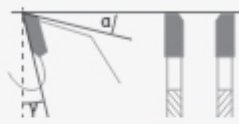
flat

GAM

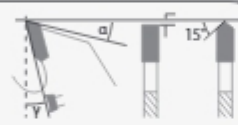
flat with chamfers on both sides

GS

alternate top bevel

GSM

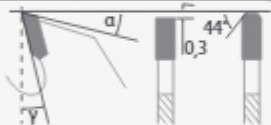
top bevel

GL/GD

hollow / inverted-v + flat

GT

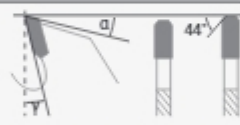
top bevel, right

GA

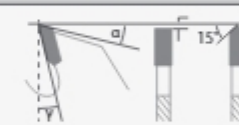
triple-chip + flat

GW

top bevel, left

GA/GA

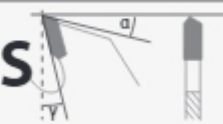
triple-chip

GD

inverted-v + flat

GM-B

barrel-flat

GF/GS

alternate top bevel with chamfer

GR/GM

conical-flat

GD/GA

inverted-v + triple-chip

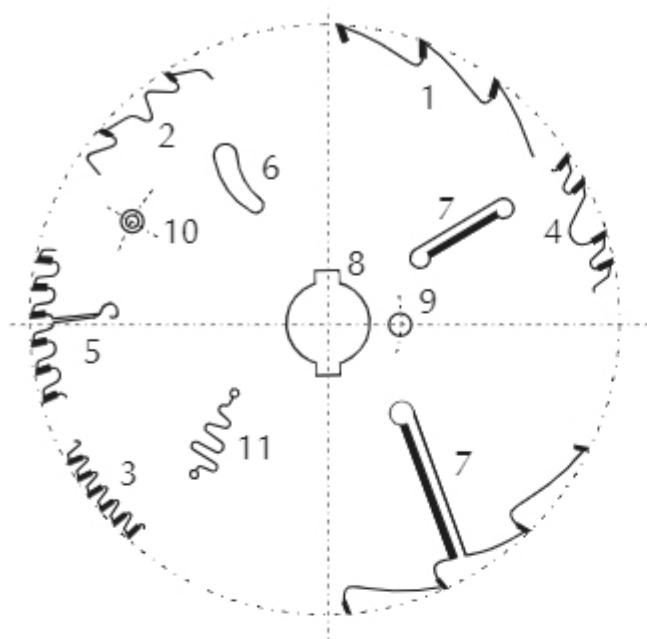
GR/GS

conical-alternate bevel

GV

V-top

Construction



1. Tothing with positive hook angle.
2. Tothing with positive hook angle and feed limiter.
3. Tothing with negative hook angle.
4. Tothing with irregular pitch.
5. Laser compensation slot.
6. Cooling hole (removing heat).
7. Carbide wiper knife.
8. Keyway.
9. Driver hole.
10. Fixing holes.
11. Laser noise-reduction cuts.

Flange

Recommended flange diameters for respective dimensions of saw blades and scorers.

Outer diameter (mm)	Central bore diameter (mm)	Flange diameter	
		minimum (mm)	maximum (mm)
100	20	50	50
125	20	50	50
125	30	60	60
150	30	80	80
180	30	80	90
200	30	90	100
250	30	90	110
300	30	100	120
350	30	110	130
400	30	120	140
450	30	120	150
500	30	130	160
550	30	140	170
600	30	150	180
650	30	160	200
700	30	180	220

Recommended flange diameters for respective dimensions of multi-rip saw blades.

Outer diameter (mm)	Central bore diameter (mm)	Flange diameter	
		minimum (mm)	maximum (mm)
225	40	80	80
225	60	90	120
250	40	90	110
250	60	100	120
250	80	100	120
300	60	100	120
300	80	100	120
300	90	110	130
350	60	100	120
350	80	110	130
350	90	120	140
400	60	110	130
400	80	120	150
400	100	130	160
450	80	120	150
450	100	130	160
500	70	120	150
500	100	130	160
500	150	190	220

Cutting speed

1

Cutting speed depending on the kind of machined material.

Workpiece material	Cutting speed (m/s)
Soft wood	60÷100
Wet soft wood	70÷100
Hard wood	50÷90
Chipboard	60÷80
MDF	60÷80
Hardboard	50÷80
Softboard	60÷100
Plywood	50÷80
Light alloys	40÷60
Plastics	50÷80

Basic formula for determining cutting speed V_c

$$V_c = \frac{\pi \times D \times n}{60.000} \text{ (m/s)}$$

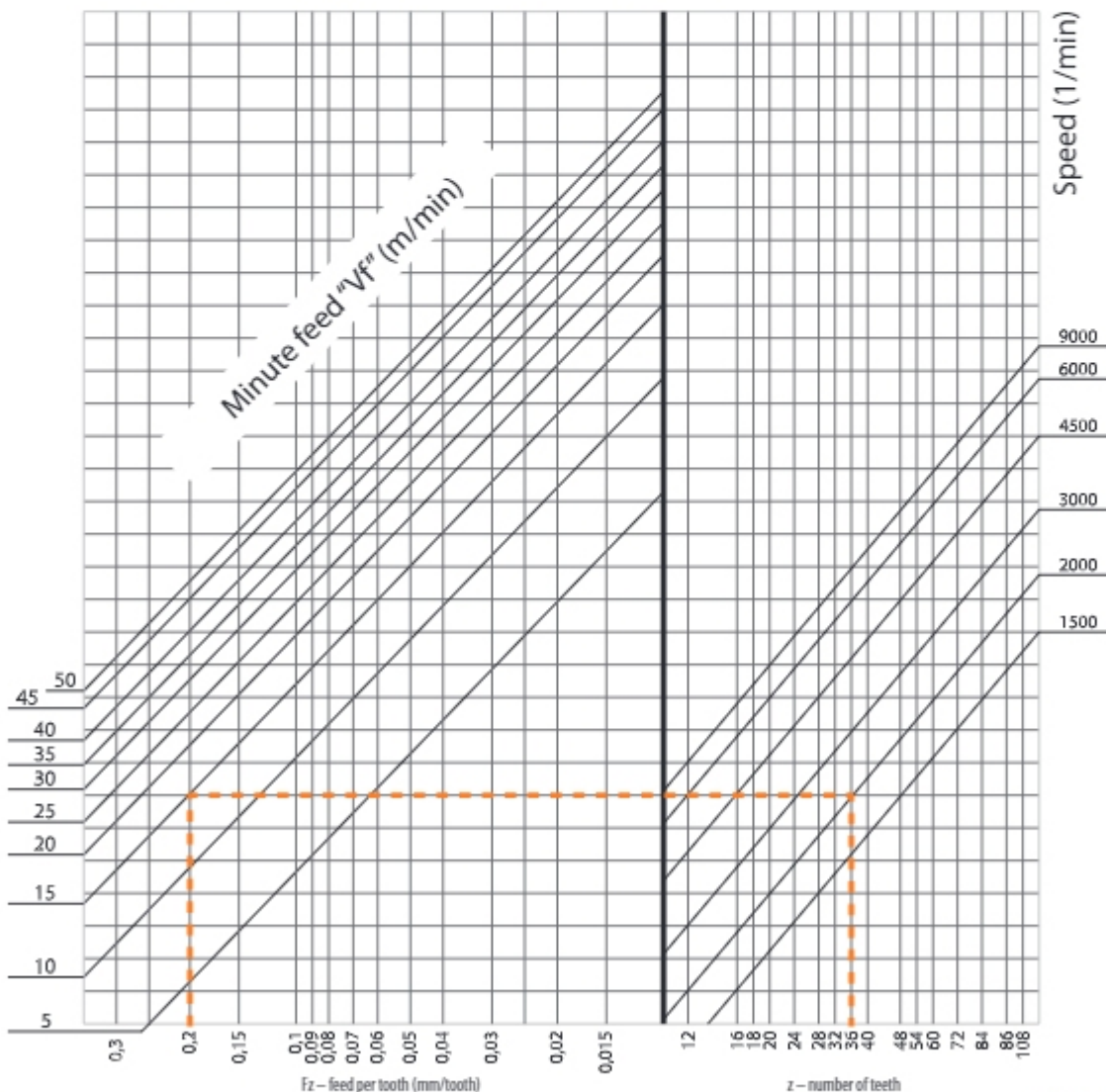
D - tool diameter (mm)

n - spindle speed (r.p.m.)

Determining rotational speed of saw blades and scorers for given cutting speed and tool diameter.

D mm \ n min ⁻¹	2.000	2.500	4.500	5.600	8.000	10.000	13.000
Ø 100	11	15	24	29	42	52	68
Ø 125	13	18	29	37	52	65	85
Ø 150	16	22	35	44	63	78	102
Ø 200	21	29	47	59	84	104	
Ø 250	26	37	59	73	104		
Ø 300	32	44	71	88	125		
Ø 315	33	46	74	92			
Ø 350	37	51	82	102			
Ø 400	42	58	94	117			
Ø 450	47	66	106				
Ø 500	52	73	117				

Determining F_z and V_f depending on rotation and teeth number of a saw blade.



Cutting parameters

Feed

V_f (m/min) F_z (mm/tooth)

$$V_f = \frac{F_z \times n \times z}{1.000}$$

$$F_z = \frac{P_m \times 1000}{n \times z}$$

F_z - feed per tooth (mm/tooth), V_f - minute feed (m/min), n - speed (rpm), z - number of teeth

Example:

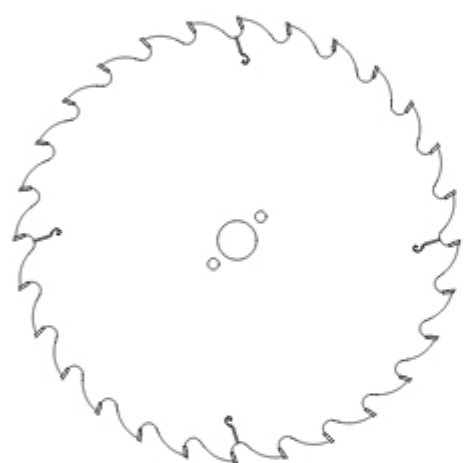
$z=36$

$n=2000$ (1/m)

$V_f=15$ (m/min)

$F_z=0,2$ (mm)

PI-501 EVO2



Saw blade with flat teeth (GM), type **PI-501 EVO2** with carbide tips, designed for longitudinal cutting of dry wood (soft and hard).

Special body coating technology prevents the resin from sticking to the blade and reduces saw blade – wood friction.

Type of cut: single, longitudinal.

Material: dry wood, soft and hard.



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ		
P0100930-2	PI-501 EVO2	225	2,3	1,6	60	3/10/74	16	18°	GM	+
P0101000-2	PI-501 EVO2	250	2,6	1,9	30	2/10/60	18	18°	GM	•
P0101001-2	PI-501 EVO2	300	3,2	2,1	30	2/10/60	20	18°	GM	•
P0101002-2	PI-501 EVO2	300	3,2	2,1	30	2/10/60	30	18°	GM	•
P0101003-2	PI-501 EVO2	315	3,4	2,3	30	2/10/60	28	18°	GM	•
P0101004-2	PI-501 EVO2	350	3,6	2,6	30	2/10/60	24	18°	GM	•
P0101005-2	PI-501 EVO2	400	3,8	2,6	30	2/10/60	28	18°	GM	•
P0101006-2	PI-501 EVO2	450	4,0	2,9	30	2/10/60	32	18°	GM	•
P0101007-2	PI-501 EVO2	500	4,4	3,1	30	2/10/60	36	18°	GM	•

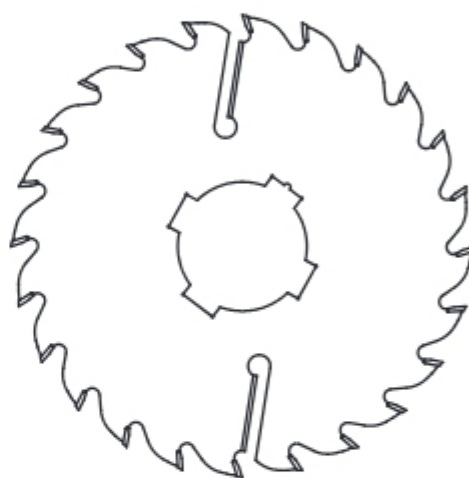
Multi-rip saw blade with flat teeth (GM), type **PI-503 EVO2** with carbide tips, with two open (+2) or two open and two closed (+4) wiper knives designed for longitudinal cutting of solid, dry wood (soft and hard) on a multi-saw blade machine.

Special body coating technology prevents the resin from sticking to the blade and reduces saw blade – wood friction.

Type of cut: longitudinal.

Material: solid wood, soft and hard.

PI-503 EVO2



GM

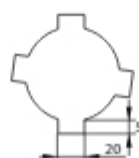


EVOLUTION 2



Catalogue number	Type	D mm	B mm	b mm	d mm	Keyways	z	γ		
P0300800-2	PI-503 EVO2	250	2,8	1,8	30	-	24+2	18°	GM	•
P0300801-2	PI-503 EVO2	250	2,8	1,8	70	4/20x5	24+2	18°	GM	•
P0300802-2	PI-503 EVO2	250	2,8	1,8	80	4/20x5	24+2	18°	GM	•
P0300803-2	PI-503 EVO2	300	3,2	2,1	30	-	18+4	18°	GM	•
P0300804-2	PI-503 EVO2	300	3,2	2,1	70	4/20x5	18+4	18°	GM	•
P0300805-2	PI-503 EVO2	300	3,2	2,1	80	4/20x5	18+4	18°	GM	•
P0300862-2	PI-503 EVO2	300	3,2	2,1	90	4/20x5	18+4	18°	GM	+
P0300806-2	PI-503 EVO2	315	3,5	2,3	70	4/20x5	18+4	18°	GM	•
P0300807-2	PI-503 EVO2	315	3,5	2,3	80	4/20x5	18+4	18°	GM	•
P0300808-2	PI-503 EVO2	350	3,5	2,3	30	-	24+4	18°	GM	•
P0300809-2	PI-503 EVO2	350	3,5	2,3	70	4/20x5	24+4	18°	GM	•
P0300810-2	PI-503 EVO2	350	3,5	2,3	80	4/20x5	24+4	18°	GM	•

Two pairs of angularly displaced key ways are meant to place the set in a way to maximally lower the cutting force during work.



Key ways dimensions in catalogue PI-503 EVO2 saw blades. Other dimensions available on request. When ordering saw blades PI-503 EVO2 with non-standard central bore, quantity and dimensions of key ways must be given.

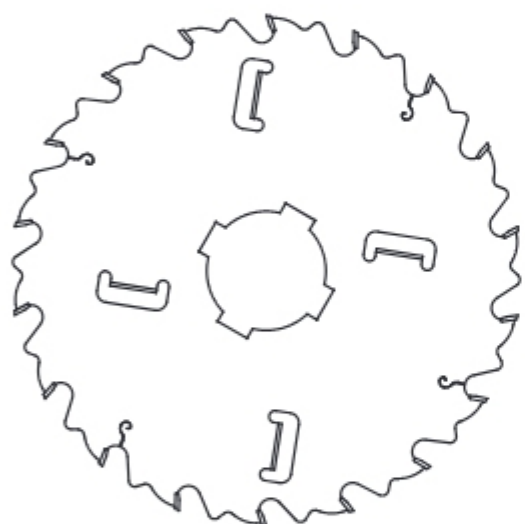
PI-502 EVO2

Multi-rip saw blade with feed limiter and flat teeth (GM), type **PI-502 EVO2** with carbide tips, with two open (+2) or two open and two closed (+4) wiper knives designed for longitudinal cutting of solid, dry wood (soft and hard) on a multi-saw blade machine.

Special body coating technology prevents the resin from sticking to the blade and lowers the blade-wood friction.

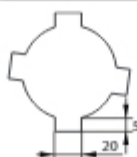
Type of cut: longitudinal.

Material: dry wood, soft and hard.



Catalogue number	Type	D mm	B mm	b mm	d mm	Keyways	z	γ		
P0200301-2	PI-502 EVO2	250	2,4	1,6	70	4/20x5	16+2	18°	GM	+
P0200302-2	PI-502 EVO2	300	2,8	1,8	70	4/20x5	18+4	18°	GM	+
P0200303-2	PI-502 EVO2	300	2,8	1,8	80	4/20x5	18+4	18°	GM	+
P0200304-2	PI-502 EVO2	350	3,0	2,0	70	4/20x5	20+4	18°	GM	+
P0200305-2	PI-502 EVO2	350	3,0	2,0	80	4/20x5	20+4	18°	GM	+

Two pairs of angularly displaced key ways are meant to place the set in a way to maximally lower the cutting force during work.



Key ways dimensions in catalogue PI-502 EVO2 saw blades. Other dimensions available on request. When ordering saw blades PI-502 EVO2 with non-standard central bore, quantity and dimensions of key ways must be given.

Upgraded increased life saw blade type **PI-510 EVO2** with flat (GM) or alternate top bevel (GS) carbide teeth, with two open (+2) or two open and two or four closed (+4, +6) wiper slots designed for longitudinal cutting of wet, soft (conifer) wood on a multi-saw blade machine.

Special body coating technology prevents the resin from sticking to the blade and lowers the blade-wood friction.

Type of cut: longitudinal, multi-saw blade machine.

Material: wet, soft (coniferous) wood.

PI-510 EVO2



GM



GS

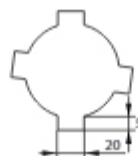


EVOLUTION 2



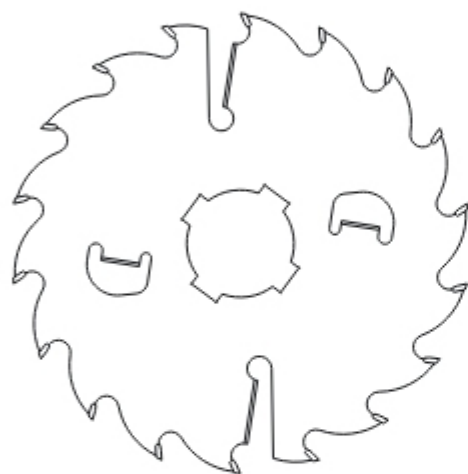
Catalogue number	Catalogue number	Type	D mm	B mm	b mm	d mm	Keyways	z	γ
P1004000-2	GM • P1004050-2	GS + PI-510 EVO2	250	3,1	1,8	70	4/20x5	16+2	23°
P1004001-2	GM • P1004051-2	GS + PI-510 EVO2	250	3,1	1,8	70	4/20x5	20+2	23°
P1004002-2	GM • P1004052-2	GS + PI-510 EVO2	300	3,4	2,1	70	4/20x5	18+4	23°
P1004003-2	GM • P1004053-2	GS + PI-510 EVO2	300	3,4	2,1	80	4/20x5	18+4	23°
P1004004-2	GM • P1004054-2	GS + PI-510 EVO2	315	3,9	2,6	80	4/20x5	18+4	23°
P1004005-2	GM • P1004055-2	GS + PI-510 EVO2	350	3,9	2,6	70	4/20x5	18+4	23°
P1004006-2	GM • P1004056-2	GS + PI-510 EVO2	350	3,9	2,6	80	4/20x5	18+4	23°
P1004007-2	GM • P1004057-2	GS + PI-510 EVO2	350	3,9	2,6	90	4/20x5	18+4	23°
P1004008-2	GM • P1004058-2	GS + PI-510 EVO2	350	3,9	2,6	70	4/20x5	24+4	23°
P1004009-2	GM • P1004059-2	GS + PI-510 EVO2	350	3,9	2,6	80	4/20x5	24+4	23°
P1004010-2	GM • P1004060-2	GS + PI-510 EVO2	400	4,0	2,7	70	4/20x5	18+6	23°
P1004011-2	GM • P1004061-2	GS + PI-510 EVO2	400	4,0	2,7	80	4/20x5	18+6	23°
P1004012-2	GM • P1004062-2	GS + PI-510 EVO2	400	4,0	2,7	70	4/20x5	24+4	23°
P1004157-2	GM + P1004158-2	GS + PI-510 EVO2	450	4,5	3,1	50	4/20x5	18+6	23°
P1004013-2	GM • P1004063-2	GS + PI-510 EVO2	450	4,5	3,1	70	4/20x5	18+6	23°
P1004014-2	GM • P1004064-2	GS + PI-510 EVO2	450	4,5	3,1	80	4/20x5	18+6	23°
P1004159-2	GM + P1004160-2	GS + PI-510 EVO2	450	4,5	3,1	50	4/20x5	24+6	23°
P1004161-2	GM + P1004162-2	GS + PI-510 EVO2	500	4,5	3,1	50	4/20x5	18+6	23°
P1004015-2	GM • P1004065-2	GS + PI-510 EVO2	500	4,5	3,1	70	4/20x5	20+6	23°
P1004163-2	GM + P1004164-2	GS + PI-510 EVO2	500	4,5	3,1	50	4/20x5	24+6	23°
	P1004343-2	GS • PI-510 EVO2	630	6,0	4,1	70	4/20x5	18+6	23°

Two pairs of angularly displaced key ways are meant to place the set in a way to maximally lower the cutting force during work.



Key ways dimensions in catalogue PI-510 EVO2 saw blades. Other dimensions available on request. When ordering saw blades PI-510 EVO2 with non-standard central bore, quantity and dimensions of key ways must be given.

PI-510 EVO2



Upgraded multi-rip saw blades, type **PI-510 EVO2** with flat teeth (GM) with increased body thickness for stabilizing work of sets working in difficult conditions. Saw blades should be installed in extreme positions of the set to stabilize the blades working inside.

Special body coating technology prevents the resin from sticking to the blade and lowers the blade-wood friction.

Type of cut: longitudinal, multi-saw blade machine.

Material: wet, soft (coniferous) wood.

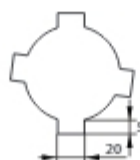


GM



Catalogue number	Type	D mm	B mm	b mm	d mm	Keyways	z	γ		
P1004020-2	PI-510 EVO2	250	4,4	3,1	70	4/20x5	16+2	23°	GM	•
P1004021-2	PI-510 EVO2	300	4,4	3,1	70	4/20x5	16+4	23°	GM	•
P1004022-2	PI-510 EVO2	350	5,0	3,6	70	4/20x5	18+4	23°	GM	•
P1004023-2	PI-510 EVO2	350	5,0	3,6	80	4/20x5	18+4	23°	GM	+
P1004024-2	PI-510 EVO2	350	5,0	3,6	90	4/20x5	18+4	23°	GM	•
P1004025-2	PI-510 EVO2	400	5,2	3,6	70	4/20x5	18+6	23°	GM	•
P1004026-2	PI-510 EVO2	400	5,2	3,6	80	4/20x5	18+6	23°	GM	•
P1004027-2	PI-510 EVO2	450	5,5	4,1	70	4/20x5	18+6	23°	GM	•
P1004028-2	PI-510 EVO2	450	5,5	4,1	80	4/20x5	18+6	23°	GM	+
P1004029-2	PI-510 EVO2	500	5,5	4,1	70	4/20x5	20+6	23°	GM	•

Two pairs of angularly displaced key ways are meant to place the set in a way to maximally lower the cutting force during work.



Key ways dimensions in catalogue PI-510 EVO2 saw blades. Other dimensions available on request. When ordering saw blades PI-510 EVO2 with non-standard central bore, quantity and dimensions of key ways must be given.

Upgraded increased life saw blade type **PI-517 EVO2** with flat (GM) or alternate top bevel (GS) carbide teeth, with two open (+2) or two open and two or four closed (+4, +6) wiper slots designed for longitudinal cutting of wet, soft and hard wood on a multi-saw blade machine.

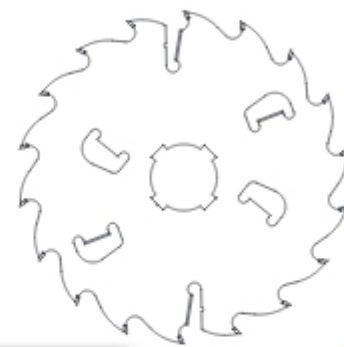
Special blade geometry together with new, hard carbide increases life of the blade which guarantees long work.

Special body coating technology prevents the resin from sticking to the blade and reduces the blade-wood friction.

Type of cut: longitudinal, multi-saw blade machine.

Material: wet, hard wood.

PI-517 EVO2



GM



GS

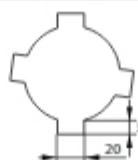


EVOLUTION 2



Catalogue number	Catalogue number	Type	D mm	B mm	b mm	d mm	Keyways	z	γ
P1701000-2	GM + P1701050-2	GS + PI-517 EVO2	250	3,4	2,2	70	4/20x5	16+2	20°
P1701001-2	GM • P1701051-2	GS + PI-517 EVO2	300	3,7	2,5	70	4/20x5	18+4	20°
P1701002-2	GM • P1701052-2	GS + PI-517 EVO2	300	3,7	2,5	80	4/20x5	18+4	20°
P1701003-2	GM + P1701053-2	GS + PI-517 EVO2	315	3,7	2,5	80	4/20x5	18+4	20°
P1701004-2	GM • P1701054-2	GS + PI-517 EVO2	350	4,0	2,7	70	4/20x5	18+4	20°
P1701005-2	GM • P1701055-2	GS + PI-517 EVO2	350	4,0	2,7	80	4/20x5	18+4	20°
P1701006-2	GM • P1701056-2	GS + PI-517 EVO2	350	4,0	2,7	90	4/20x5	18+4	20°
P1701007-2	GM • P1701057-2	GS + PI-517 EVO2	350	4,0	2,7	70	4/20x5	24+4	20°
P1701008-2	GM + P1701058-2	GS + PI-517 EVO2	350	4,0	2,7	80	4/20x5	24+4	20°
P1701009-2	GM • P1701059-2	GS + PI-517 EVO2	400	4,2	2,8	70	4/20x5	18+6	20°
P1701010-2	GM • P1701060-2	GS + PI-517 EVO2	400	4,2	2,8	80	4/20x5	18+6	20°
P1701011-2	GM • P1701061-2	GS + PI-517 EVO2	400	4,2	2,8	70	4/20x5	24+6	20°
P1701012-2	GM • P1701062-2	GS + PI-517 EVO2	450	4,7	3,3	70	4/20x5	18+6	20°
P1701013-2	GM • P1701063-2	GS + PI-517 EVO2	450	4,7	3,3	80	4/20x5	18+6	20°
P1701014-2	GM + P1701064-2	GS + PI-517 EVO2	500	4,7	3,3	70	4/20x5	20+6	20°
P1701015-2	GM + P1701065-2	GS + PI-517 EVO2	500	4,7	3,3	80	4/20x5	20+6	20°
P1701247-2	GM •	PI-517 EVO2	500	5,2	3,3	70	4/20x5	20+6	20°
	P1701120-2	GS • PI-517 EVO2	630	6,2	4,1	70	4/20x5	18+6	20°

Two pairs of angularly displaced key ways are meant to place the set in a way to maximally lower the cutting force during work.



Key ways dimensions in catalogue PI-517 EVO2 saw blades. Other dimensions available on request. When ordering saw blades PI-517 EVO2 with non-standard central bore, quantity and dimensions of key ways must be given.

PI-515 EVO2



Upgraded multi-rip saw blades, type **PI-515 EVO2** with flat (GM) or alternate top bevel (GS) teeth and carbide tips, designed for longitudinal cutting of wet, soft wood with low feed (up to 10 m/min) on a multi-saw blade machine.

Special body coating technology prevents the resin from sticking to the blade and reduces the blade-wood friction.

Type of cut: longitudinal, multi-saw blade machine.

Material: wet, soft (coniferous) wood.



GM

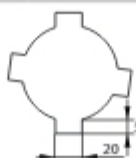


GS



Catalogue number			Catalogue number			Type	D mm	B mm	b mm	d mm	Keyways	z	γ
P1500400-2	GM	+	P1500450-2	GS	+	PI-515 EVO2	250	3,4	1,9	70	4/20x5	10+2	23°
P1500401-2	GM	•	P1500451-2	GS	+	PI-515 EVO2	300	3,6	2,3	70	4/20x5	10+4	23°
P1500402-2	GM	•	P1500452-2	GS	+	PI-515 EVO2	300	3,6	2,3	80	4/20x5	10+4	23°
P1500403-2	GM	•	P1500453-2	GS	+	PI-515 EVO2	350	3,9	2,6	70	4/20x5	10+4	23°
P1500404-2	GM	•	P1500454-2	GS	+	PI-515 EVO2	350	3,9	2,6	80	4/20x5	10+4	23°
P1500405-2	GM	•	P1500455-2	GS	+	PI-515 EVO2	400	4,0	2,7	70	4/20x5	12+4	23°
P1500406-2	GM	•	P1500456-2	GS	+	PI-515 EVO2	400	4,0	2,7	80	4/20x5	12+4	23°
P1500407-2	GM	•	P1500457-2	GS	+	PI-515 EVO2	450	4,5	3,1	70	4/20x5	14+6	23°
P1500408-2	GM	•	P1500458-2	GS	•	PI-515 EVO2	500	5,0	3,6	70	4/20x5	14+6	23°

Two pairs of angularly displaced key ways are meant to place the set in a way to maximally lower the cutting force during work.



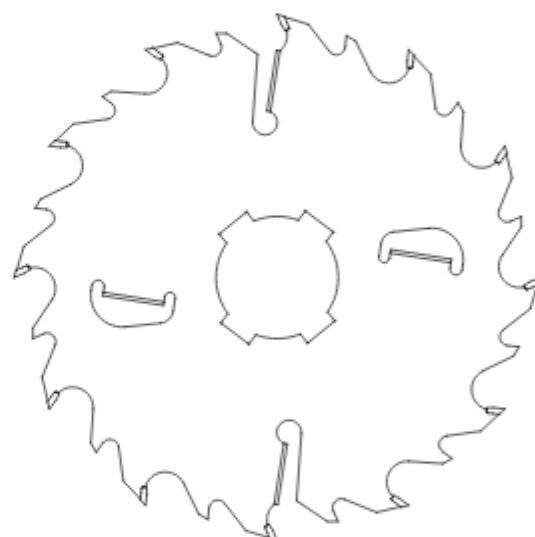
Key ways dimensions in catalogue PI-515 EVO2 saw blades. Other dimensions available on request. When ordering saw blades PI-515 EVO2 with non-standard central bore, quantity and dimensions of key ways must be given.

Upgraded multi-rip saw blades, type **PI-510W EVO2** with flat (GM) or alternate top bevel (GS) carbide teeth with two open and two closed or four closed (+4, +6) wiper knives designed for longitudinal cutting of solid, wet wood on a multi-saw blade machine. Additionally, PI-510W EVO2 saw blades are equipped with chip remover which cools down and stabilises the blade in the material. Wolf tooth geometry allows for regrounding the blades on machines of old type. Special EVO2 gas coating technology prevents the resin from stocking to the blade and reduces saw blade-wood friction.

Type of cut: longitudinal, multi-saw blade machine.

Material: wet, soft (coniferous) wood.

PI-510W EVO2



GM



GS



EVOLUTION 2



Catalogue number	Type	D mm	B mm	b mm	d mm	Keyways	z	γ	
P1005010-2	PI-510W EVO2	300	3,4	2,1	70	4/20x5	12+4	23°	GS •
P1005300-2	PI-510W EVO2	300	3,7	2,5	70	4/20x5	12+4	23°	GS •
P1005330-2	PI-510W EVO2	300	4,2	2,8	70	4/20x5	12+4	23°	GS •
P1004492-2	PI-510W EVO2	350	3,9	2,6	70	4/20x5	14+4	23°	GM •
P1004239-2	PI-510W EVO2	350	3,9	2,6	70	4/20x5	14+4	23°	GS •
P1004493-2	PI-510W EVO2	350	3,9	2,6	80	4/20x5	14+4	23°	GM +
P1005331-2	PI-510W EVO2	350	4,2	2,8	70	4/20x5	14+4	23°	GS •
P1005301-2	PI-510W EVO2	400	4,2	2,8	70	4/20x5	14+4	23°	GS •
P1003933-2	PI-510W EVO2	600	6,0	4,1	80	4/20x5	18+6	23°	GM •
P1005332-2	PI-510W EVO2	630	6,2	4,1	70	4/20x5	18+6	23°	GS •

PI-508 EVO2



EVOLUTION 2



GM



Saw blades with feed limiter and flat teeth (GM), type **PI-508 EVO2** with carbide tips, designed for longitudinal cutting of dry wood (soft and hard).

Special body coating technology prevents the resin from sticking to the blade and reduces the blade-wood friction.

Type of cut: longitudinal, single.

Material: dry wood, soft and hard.



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
P0800150-2	PI-508 EVO2	300	3,2	2,1	30	2/10/60 + 2/7/42 + 2/9,5/46,5	14	18°	GM •
P0800228-2	PI-508 EVO2	300	3,2	2,1	30	2/10/60 + 2/7/42 + 2/9,5/46,5	20	18°	GM •
P0800151-2	PI-508 EVO2	350	3,6	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	16	18°	GM •
P0800278-2	PI-508 EVO2	350	3,6	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	24	18°	GM •
P0800152-2	PI-508 EVO2	400	3,8	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	18	18°	GM •
P0800229-2	PI-508 EVO2	400	3,8	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	28	18°	GM •
P0800153-2	PI-508 EVO2	450	4,0	2,9	30	2/10/60 + 2/7/42 + 2/9,5/46,5	20	18°	GM •
P0800230-2	PI-508 EVO2	450	4,0	2,9	30	2/10/60 + 2/7/42 + 2/9,5/46,5	32	18°	GM +
P0800264-2	PI-508 EVO2	500	4,0	2,9	30	2/10/60 + 2/7/42 + 2/9,5/46,5	36	18°	GM +

PI-508V EVO2



EVOLUTION 2



GS



Saw blades with feed limiter and alternate top bevel teeth (GS), type **PI-508V EVO2** with carbide tips, designed for longitudinal and cross cutting of dry, soft and hard wood.

Special laser cuts (V) reduce the noise by about a half.

Special body coating technology prevents the resin from sticking to the blade and reduces the blade-wood friction.

Type of cut: longitudinal and cross, single.

Material: dry wood, soft and hard.



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
P0800134-2	PI-508V EVO2	250	3,2	2,1	30	2/10/60 + 2/7/42 + 2/9,5/46,5	24	18°	GS •
P0800313-2	PI-508V EVO2	300	3,2	2,1	30	2/10/60 + 2/7/42 + 2/9,5/46,5	28	18°	GS •
P0800314-2	PI-508V EVO2	315	3,2	2,1	30	2/10/60 + 2/7/42 + 2/9,5/46,5	28	18°	GS •
P0800350-2	PI-508V EVO2	355	3,6	2,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	32	18°	GS •
P0800351-2	PI-508V EVO2	400	4,0	2,9	30	2/10/60 + 2/7/42 + 2/9,5/46,5	36	18°	GS •
P0800141-2	PI-508V EVO2	450	4,0	2,9	30	2/10/60 + 2/7/42 + 2/9,5/46,5	40	18°	GS •
P0800564-2	PI-508V EVO2	500	4,0	2,9	30	2/10/60 + 2/7/42 + 2/9,5/46,5	44	18°	GS •

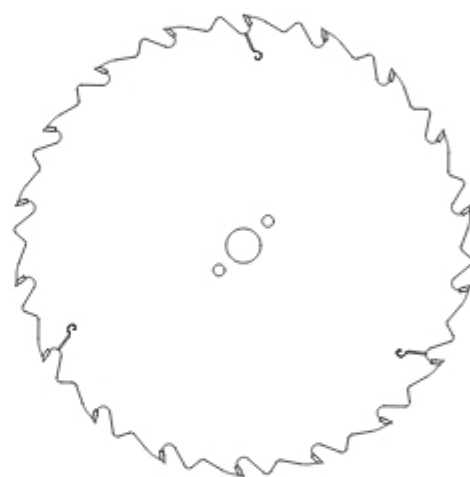
Saw blade with feed limiter and flat teeth (GM), type **PI-509 EVO2** with carbide tips, designed for longitudinal cutting of wet, soft (coniferous) wood.

Special body coating technology prevents the resin from sticking to the blade and reduces the blade-wood friction.

Type of cut: longitudinal, single.

Material: wet, soft (coniferous) wood.

PI-509 EVO2



GM

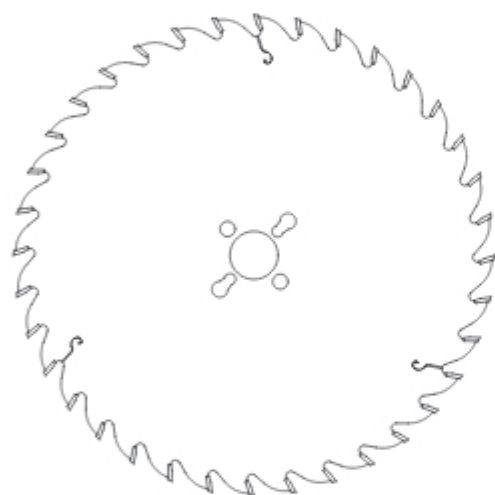


EVOLUTION 2



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
P0900100-2	PI-509 EVO2	300	3,6	2,3	30	2/10/60 + 2/7/42 + 2/9,5/46,5	14	23°	GM •
P0900101-2	PI-509 EVO2	350	3,9	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	16	23°	GM •
P0900102-2	PI-509 EVO2	400	4,0	2,7	30	2/10/60	18	23°	GM •
P0900103-2	PI-509 EVO2	450	4,5	3,1	30	2/10/60	20	23°	GM •

PI-511 EVO2



Saw blades with flat teeth (GM), type **PI-511 EVO2** with carbide tips, designed for longitudinal cutting of wet, hard wood.

Special body coating technology prevents the resin from sticking to the blade and reduces the blade-wood friction.

Type of cut: longitudinal, single.

Material: wet hard wood.



EVOLUTION 2



GM



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
P1100251-2	PI-511 EVO2	250	3,5	2,3	30	2/10/60 + 2/7/42 + 2/9,5/46,5	30	18°	GM •
P1100252-2	PI-511 EVO2	300	3,5	2,3	30	2/10/60 + 2/7/42 + 2/9,5/46,5	36	18°	GM •
P1100253-2	PI-511 EVO2	350	3,8	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	42	18°	GM •
P1100254-2	PI-511 EVO2	400	4,0	2,6	30	2/10/60	48	18°	GM +

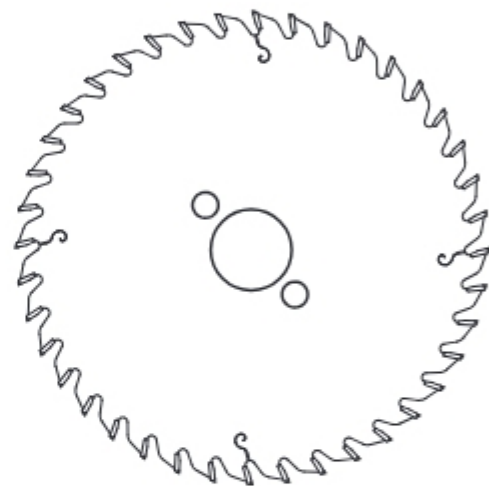
Saw blades for very precise cutting of solid wood, type **PI-513P EVO2** with special barrel-shaped tips (GM-B) smoothing the cut surface.

Saw blades PI-513P EVO2 have more precise body made in the new Premium technology, which together with improved blade geometry and optimal tensioning significantly increase life of the blade. Additionally, the new body coating EVO2 technology aims at reducing body roughness, increasing saw blade stiffness and stability which directly results in longer life of the tool.

Type of cut: very precise, longitudinal, single.

Material: solid dry, soft and hard wood.

PI-513P EVO2

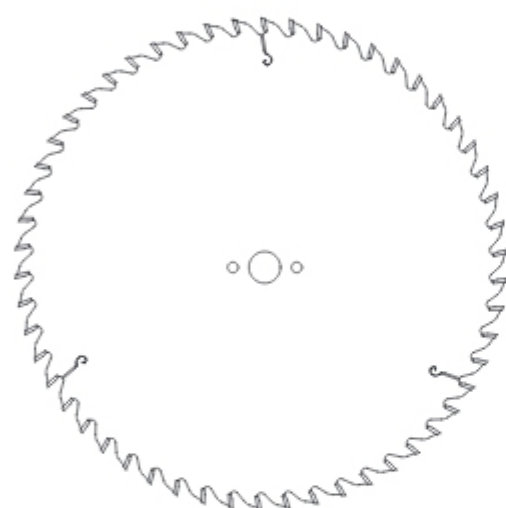


GM-B



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ		
SP1300500	PI-513P EVO2	250	3,0	2,0	60	3/10/74	32	20°	GM-B	+
SP1300501	PI-513P EVO2	300	3,2	2,2	60	3/10/74	36	20°	GM-B	+

PI-504V



Saw blades with medium teeth number and alternate top bevel teeth (GS), type **PI-504V** with carbide tips, designed for longitudinal cutting of glued wood as well as solid, dry wood, used on manual formatting machines and automatic lines.

Special laser cuts (V) reduce the noise by about a half.

Type of cut: longitudinal and cross, single.

Material: glued wood, solid dry wood.



GS



HM

Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	Y	
P0405001	PI-504V	250	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	40	10°	GS •
P0405002	PI-504V	300	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	48	10°	GS •
P0405003	PI-504V	350	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	54	10°	GS •
P0405004	PI-504V	400	3,5	2,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	48	10°	GS •
P0405005	PI-504V	400	3,5	2,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	60	10°	GS •
P0405006	PI-504V	450	3,8	2,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5	66	10°	GS +
P0405007	PI-504V	500	4,0	2,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5	72	10°	GS +

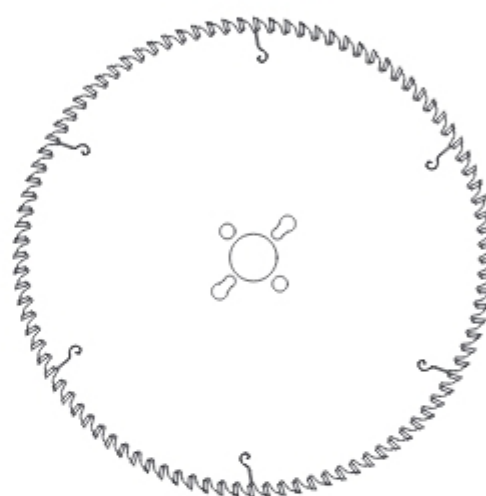
Saw blades with high teeth number and alternate top bevel teeth (GS), type **PI-505V** with carbide tips, designed for longitudinal cutting of glued wood, plywood and solid wood, used on manual formatting machines and automatic lines.

Special laser cuts (V) reduce the noise by about a half.

Type of cut: longitudinal and cross, single.

Material: glued wood, plywood, solid dry wood.

PI-505V

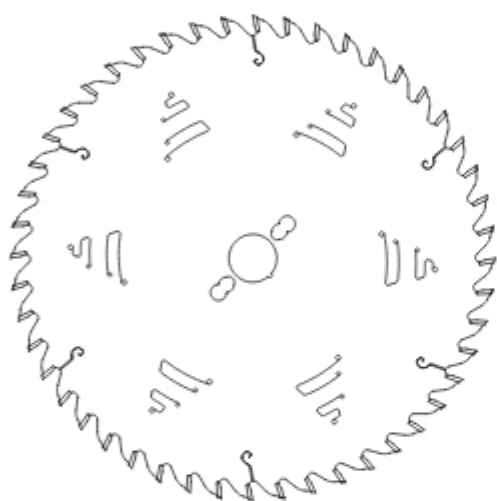


GS



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ		
P0505001	PI-505V	250	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	60	10°	GS	•
P0505002	PI-505V	250	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	80	10°	GS	+
P0505003	PI-505V	300	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	60	10°	GS	+
P0505004	PI-505V	300	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	72	10°	GS	•
P0505005	PI-505V	300	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	10°	GS	•
P0505006	PI-505V	315	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	72	10°	GS	•
P0505008	PI-505V	350	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	84	10°	GS	•
P0505009	PI-505V	350	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	108	10°	GS	•
P0505010	PI-505V	400	3,5	2,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	10°	GS	•
P0505011	PI-505V	400	3,5	2,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	120	10°	GS	+
P0505012	PI-505V	450	3,8	2,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5	108	10°	GS	+
P0505014	PI-505V	500	4,0	2,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5	120	10°	GS	+

PI-504VT Premium



GS



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
SP0405001	PI-504VT Premium	250	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	40	10°	GS •
SP0405002	PI-504VT Premium	300	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	48	10°	GS •
SP0405003	PI-504VT Premium	350	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	54	10°	GS •
SP0405004	PI-504VT Premium	400	3,5	2,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	48	10°	GS •
SP0405005	PI-504VT Premium	400	3,5	2,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	60	10°	GS •
SP0405006	PI-504VT Premium	450	3,8	2,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5	66	10°	GS •
SP0405007	PI-504VT Premium	500	4,0	2,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5	72	10°	GS •

Universal saw blades with high teeth number type **PI-505VT Premium**, alternate top bevel teeth (GS), with very hard carbide tips (T), designed for longitudinal and cross cutting of glued wood, plywood and chipboard used on manual formatting machines and automatic lines.

Special laser cuts (V) reduce the noise by about a half.

Type of cut: longitudinal and cross, single.

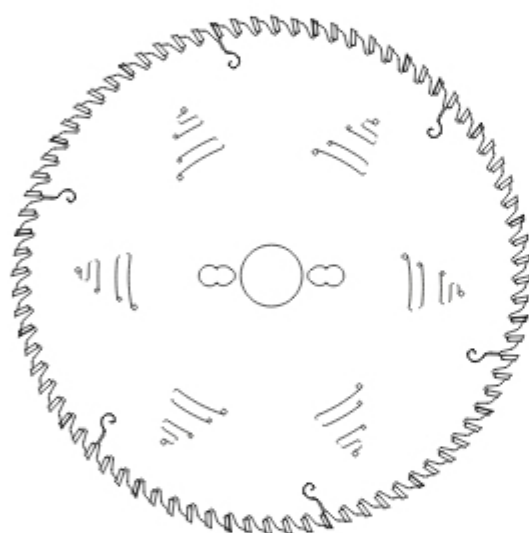
Material: plywood, laminated board, laminates, LDF, MDF.

PI-505VT Premium



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
SP0505001	PI-505VT Premium	250	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	60	10°	GS •
SP0505002	PI-505VT Premium	250	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	80	10°	GS •
SP0505003	PI-505VT Premium	300	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	60	10°	GS •
SP0505004	PI-505VT Premium	300	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	72	10°	GS •
SP0505005	PI-505VT Premium	300	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	10°	GS •
SP0505006	PI-505VT Premium	315	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	72	10°	GS •
SP0505007	PI-505VT Premium	315	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	100	10°	GS •
SP0505008	PI-505VT Premium	350	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	84	10°	GS •
SP0505009	PI-505VT Premium	350	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	108	10°	GS •
SP0505010	PI-505VT Premium	400	3,5	2,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	10°	GS •
SP0505011	PI-505VT Premium	400	3,5	2,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	120	10°	GS •
SP0505012	PI-505VT Premium	450	3,8	2,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5	108	10°	GS •
SP0505013	PI-505VT Premium	450	4,8	3,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	138	10°	GS •
SP0505014	PI-505VT Premium	500	4,0	2,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5	120	10°	GS •
SP0505015	PI-505VT Premium	500	4,8	3,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	144	10°	GS •

PI-605VT Premium



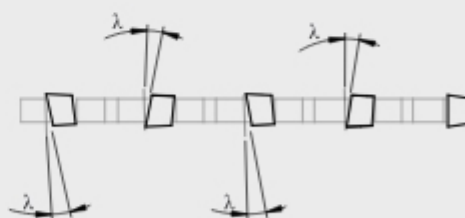
GS/GM



PI-605VT Premium universal saw blades with high number of COMBI type teeth with very hard carbide tips (T), designed for very precise longitudinal and cross cutting of soft and hard solid wood, plywood, laminates, various types of wood based board covered with paper, foil and veneer as well as cellular board on hand operated formatting machines and automatic lines.

Type of cut: single, cross and longitudinal.

Material: wood, glued wood, plywood, chipboard, laminated chipboard, MDF, paper and foil covered board, cellular board.



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
SP6050001	PI-605 VT Premium	250	3,0	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	80	15°	GS/GM •
SP6050002	PI-605 VT Premium	303	3,0	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	100	15°	GS/GM •
SP6050003	PI-605 VT Premium	350	3,0	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	100	15°	GS/GM •

Universal saw blades with hollow teeth (GŁ/GD), type **PI-507S** with super hard carbide tips (S), designed for precise longitudinal and cross cutting of chipboard, laminated board, laminates, LDF and MDF and other homogenous materials without a scoring saw.

Type of cut: precise longitudinal and cross, without a scoring saw, single.

Material: plywood, laminated board, laminates, LDF, MDF, other hard homogenous materials.



PI-507S



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
P0700203	PI-507S	250	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	48	10°	GŁ/GD +
P0700116	PI-507S	303	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	60	10°	GŁ/GD •
P0700121	PI-507S	303	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	60	-5°	GŁ/GD •
P0700068	PI-507S	350	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	72	10°	GŁ/GD •
P0700120	PI-507S	400	3,5	2,5	30	2/10/60	84	10°	GŁ/GD +

Increased life and noise reduced universal saw blades with hollow teeth (GŁ/GD), type **PI-507VS Plus** with super hard carbide tips (S), designed for precise longitudinal and cross cutting of chipboard, laminated board, laminates, LDF and MDF and other homogenous materials without a scoring saw.

Thanks to new blade geometry saw blades type **PI-507VS Plus** are characterized by increased life and work efficiency. Special laser cuts (V) reduce the noise by about a half.

Type of cut: precise longitudinal and cross, without a scoring saw, single.

Material: plywood, laminated board, laminates, LDF, MDF, other hard homogenous materials.

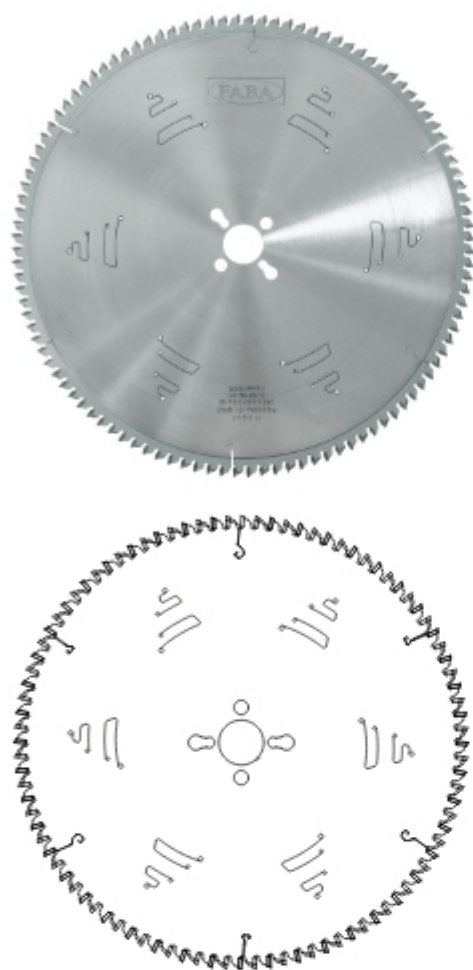


PI-507VS Premium



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
SP0700200	PI-507VS Premium	250	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	52	5°	GŁ/GD •
SP0700201	PI-507VS Premium	303	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	64	5°	GŁ/GD •
SP0700202	PI-507VS Premium	350	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	76	5°	GŁ/GD •

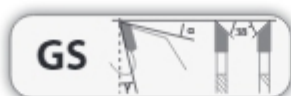
PI-512VT



Universal saw blades with alternate top bevel teeth with large bevel angle (GS=38°), type **PI-512 VT** with very hard carbide tips (T), designed for very precise (clean) cutting at an angle of solid wood and MDF without a scoring saw. Special laser cuts (V) reduce the noise by about a half.

Type of cut: precise, at an angle, longitudinal and cross, without a scoring saw.

Material: solid wood, MDF.



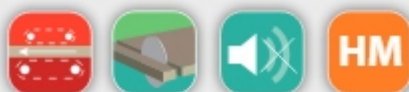
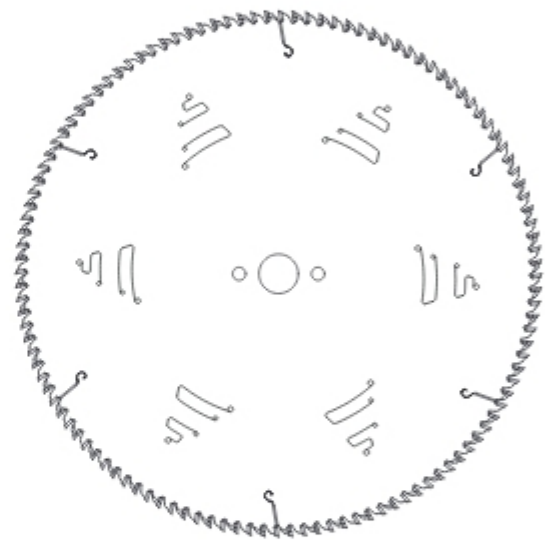
Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
P1200002-15	PI-512VT	250	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	80	-6°	GS •
P1200001-15	PI-512VT	300	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	-6°	GS •
P1200004-15	PI-512VT	350	3,5	2,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	108	-6°	GS •

Universal saw blades with alternate top bevel teeth with large bevel angle (GS=30°), type **PI-516V Premium** with hard carbide tips, designed for dynamic and clean cross cutting of solid wood on automatic lines. Special laser cuts (V) reduce the noise by about a half.

Type of cut: cross, dynamic, clean.

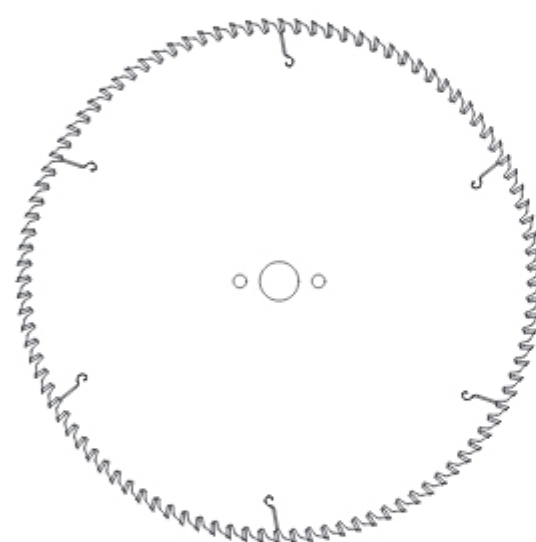
Material: solid wood, MDF.

PI-516V Premium



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
SP1601001	PI-516V Premium	400	3,5	2,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5 + 2/11/150	120	10°	GS •
SP1601002	PI-516V Premium	500	4,0	2,8	35	2/10/60	108	10°	GS •
SP1601003	PI-516V Premium	500	4,8	3,5	30	2/10/60	144	10°	GS •
SP1601004	PI-516V Premium	500	4,8	3,5	35	2/10/60	144	10°	GS •

PI-519 Premium



Universal saw blades with special V-top tooth shape (GV), type **PI-519** designed for dynamic and clean cutting across the grain of solid wood with very high feed speed on automatic lines.

Special tooth shape allows for precise and clean (without ripping) double-side formatting of furniture elements from solid (soft and hard) wood as well as glued wood.

Type of cut: cross, dynamic, clean.

Material: solid wood, plywood, glued wood.



GV



HM

Catalogue number	Type	D mm	B mm	b mm	d mm	z	γ		
SP1900001	PI-519 Premium	400	4,0	3,0	30	100	10°	GV	+
SP1900002	PI-519 Premium	450	4,8	3,5	30	100	10°	GV	+
SP1900003	PI-519 Premium	450	4,8	3,5	30	120	10°	GV	+
SP1900004	PI-519 Premium	500	5,0	3,5	30	144	10°	GV	•

Panel sizing saw blades with high teeth number and group triple-chip + flat teeth (GA), type **PI-506VT**, with very hard carbide tips (T), designed for single board cutting. Special laser cuts (V) reduce the noise by about a half.

Type of cut: cross and longitudinal, single.

Material: plywood, chipboard, laminated board, laminates, MDF.

PI-506VT



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ		
P0605001	PI-506VT	250	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	60	10°	GA	•
P0605002	PI-506VT	250	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	80	10°	GA	•
P0605003	PI-506VT	300	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	60	10°	GA	•
P0605005	PI-506VT	300	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	10°	GA	•
P0605007	PI-506VT	315	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	100	10°	GA	•
P0605009	PI-506VT	350	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	108	10°	GA	•
P0605011	PI-506VT	400	3,5	2,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	120	10°	GA	•

Increased life panel sizing saw blades type **PI-506VS Premium** with super hard carbide tips (S), designed for cutting chipboard, laminated board, MDF, HDF and other homogenous materials without impurities on manual formatting machines and automatic lines.

Optimal tensioning as well as new type of noise-reduction cuts noticeably increase stiffness and stability of the saw blade which has a direct effect on life of the tool.

Type of cut: cross and longitudinal, single.

Material: chipboard, laminated board, MDF, HDF.

PI-506VS Premium



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ		
SP0605002	PI-506VS Premium	250	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	80	10°	GA	•
SP0605003	PI-506VS Premium	300	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	60	10°	GA	•
SP0605005	PI-506VS Premium	300	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	10°	GA	•
SP0605007	PI-506VS Premium	315	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	100	10°	GA	•
SP0605009	PI-506VS Premium	350	3,2	2,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	108	10°	GA	•
SP0605011	PI-506VS Premium	400	3,5	2,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	120	10°	GA	•

PI-521VT



Panel sizing saw blades with medium teeth number and group triple-chip + flat teeth (GA), type **PI-521VT**, with very hard carbide tips (T), designed for rough cutting of chipboard, laminated board, LDF and MDF in stack. Special laser cuts (V) reduce the noise by about a half.

Type of cut: rough cutting, cross and longitudinal, in stack.

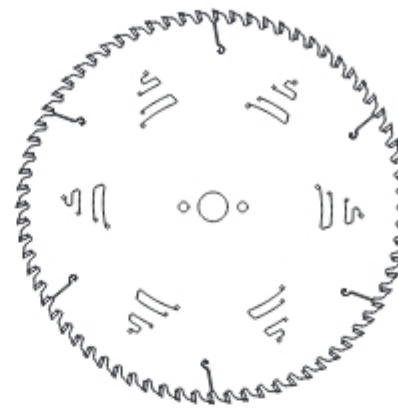
Material: chipboard, laminated board, LDF, MDF.



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
P2105001	PI-521VT	300	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	60	15°	GA +
P2105002	PI-521VT	300	4,4	3,2	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	60	15°	GA +
P2105003	PI-521VT	300	4,4	3,2	65	2/9/110	60	15°	GA +
P2105004	PI-521VT	300	4,4	3,2	80	4/8,5/100+2/7/110+2/14/110	60	15°	GA +
P2105005	PI-521VT	300	4,4	3,2	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA +
P2105006	PI-521VT	300	4,4	3,2	75	2/9/110	72	15°	GA +
P2105007	PI-521VT	305	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	60	15°	GA +
P2105008	PI-521VT	310	4,4	3,2	60	2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA +
P2105009	PI-521VT	320	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	60	15°	GA +
P2105010	PI-521VT	320	4,4	3,2	65	2/9/110+2/9/100	60	15°	GA +
P2105011	PI-521VT	320	4,4	3,2	75	3/13/95	60	15°	GA +
P2105012	PI-521VT	320	4,4	3,2	80	4/8,5/100+2/7/110+2/14/110	60	15°	GA +
P2105013	PI-521VT	330	4,4	3,2	50	4/13/80	60	15°	GA +
P2105014	PI-521VT	350	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA +
P2105015	PI-521VT	350	4,4	3,2	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA +
P2105016	PI-521VT	350	4,4	3,2	80	4/8,5/100+2/7/110+2/14/110	72	15°	GA +
P2105017	PI-521VT	355	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA +
P2105018	PI-521VT	355	4,4	3,2	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA +
P2105019	PI-521VT	355	4,4	3,2	65	2/9/110+2/9/100	72	15°	GA +
P2105020	PI-521VT	355	4,4	3,2	75	-	72	15°	GA +
P2105021	PI-521VT	355	4,4	3,2	80	2/9/130+2/19/120+2/14/110	72	15°	GA +
P2105022	PI-521VT	360	4,4	3,2	65	2/9/110	72	15°	GA +
P2105023	PI-521VT	370	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA +
P2105111	PI-521VT	380	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA +

PI-521VT

1



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	y		
P2105024	PI-521VT	380	4,4	3,2	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA	+
P2105025	PI-521VT	380	4,4	3,2	65	2/9/100+2/10/110	72	15°	GA	+
P2105026	PI-521VT	380	4,4	3,2	75	3/15/75+2/7/110	72	15°	GA	+
P2105027	PI-521VT	380	4,6	3,2	80	4/9/100+2/14/110	72	15°	GA	+
P2105028	PI-521VT	380	4,8	3,5	60	2/15/100+2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA	+
P2105029	PI-521VT	400	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42+ 2/13/94	72	15°	GA	+
P2105030	PI-521VT	400	4,4	3,2	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA	+
P2105031	PI-521VT	400	4,4	3,2	75	4/15/105+2/7/110	72	15°	GA	+
P2105032	PI-521VT	400	4,4	3,2	80	2/9/130+2/19/120+2/14/110	72	15°	GA	+
P2105033	PI-521VT	420	4,6	3,2	80	2/14/110+4/9/100	72	15°	GA	+
P2105034	PI-521VT	420	4,8	3,5	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA	+
P2105110	PI-521VT	430	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA	+
P2105035	PI-521VT	430	4,4	3,2	65	2/9/110	72	15°	GA	+
P2105036	PI-521VT	430	4,4	3,2	75	4/15/105+2/7/110	72	15°	GA	+
P2105037	PI-521VT	430	4,4	3,2	80	2/9/130+4/19/120+2/7/110+2/9/110+2/14/110+4/9/100	72	15°	GA	+
P2105038	PI-521VT	450	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA	+
P2105039	PI-521VT	450	4,4	3,2	80	2/9/100+2/10/130+4/19/120+2/7/110+2/14/110+4/9/100	72	15°	GA	+
P2105040	PI-521VT	450	4,8	3,5	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA	•
P2105041	PI-521VT	460	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA	+
P2105042	PI-521VT	470	4,4	3,2	75	4/15/105	72	15°	GA	+
P2105060	PI-521VT	470	4,8	3,5	70	4/11/130	72	15°	GA	+
P2105043	PI-521VT	480	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA	+
P2105044	PI-521VT	480	4,8	3,5	80	2/9/100+2/10/130+4/19/120+2/7/110+2/14/110+4/9/100	72	15°	GA	+
P2105045	PI-521VT	500	4,8	3,5	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA	+

PI-521VS Premium



Super LongLife panel sizing saw blades with medium teeth number and group triple-chip (GA), type **PI-521VS Premium**, with super-extra hard carbide tips, designed for cutting chipboard, laminated board, MDF, HDF and other homogenous materials without impurities in stack.

The construction of the saw blade includes extra longlife type of carbide produced in nanotechnology with addition of chromium and nickel, which, together with new improved blade geometry, has substantially increased life of the saw blade.

Additionally, optimal tensioning as well as new type of noise-reduction cuts noticeably increase stiffness and stability of the saw blade which has a direct effect on life of the tool.

Type of cut: cross and longitudinal, in stack.

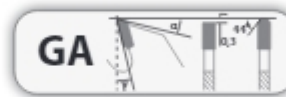
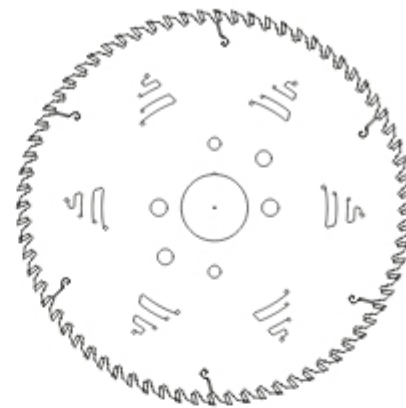
Material: chipboard, laminated board, MDF, HDF.



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
SP2105001	PI-521VS Premium	300	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	60	15°	GA +
SP2105002	PI-521VS Premium	300	4,4	3,2	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	60	15°	GA +
SP2105003	PI-521VS Premium	300	4,4	3,2	65	2/9/110	60	15°	GA +
SP2105004	PI-521VS Premium	300	4,4	3,2	80	4/8,5/100+2/7/110+2/14/110	60	15°	GA +
SP2105005	PI-521VS Premium	300	4,4	3,2	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA +
SP2105006	PI-521VS Premium	300	4,4	3,2	75	2/9/110	72	15°	GA +
SP2105007	PI-521VS Premium	305	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	60	15°	GA •
SP2105008	PI-521VS Premium	310	4,4	3,2	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA +
SP2105009	PI-521VS Premium	320	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	60	15°	GA •
SP2105010	PI-521VS Premium	320	4,4	3,2	65	2/9/110+2/9/100	60	15°	GA •
SP2105011	PI-521VS Premium	320	4,4	3,2	75	3/13/95	60	15°	GA +
SP2105012	PI-521VS Premium	320	4,4	3,2	80	4/8,5/100+2/7/110+2/14/110	60	15°	GA +
SP2105013	PI-521VS Premium	330	4,4	3,2	50	4/13/80	60	15°	GA +
SP2105014	PI-521VS Premium	350	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA •
SP2105015	PI-521VS Premium	350	4,4	3,2	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA •
SP2105016	PI-521VS Premium	350	4,4	3,2	80	4/8,5/100+2/7/110+2/14/110	72	15°	GA +
SP2105017	PI-521VS Premium	355	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA •
SP2105018	PI-521VS Premium	355	4,4	3,2	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA •
SP2105019	PI-521VS Premium	355	4,4	3,2	65	2/9/110+2/9/100	72	15°	GA •
SP2105020	PI-521VS Premium	355	4,4	3,2	75	-	72	15°	GA •
SP2105021	PI-521VS Premium	355	4,4	3,2	80	2/9/130+2/19/120+2/14/110	72	15°	GA •
SP2105022	PI-521VS Premium	360	4,4	3,2	65	2/9/110	72	15°	GA +
SP2105023	PI-521VS Premium	370	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA +
SP2105111	PI-521VS Premium	380	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA +
SP2105024	PI-521VS Premium	380	4,4	3,2	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA •
SP2105025	PI-521VS Premium	380	4,4	3,2	65	2/9/100+2/10/110	72	15°	GA +
SP2105026	PI-521VS Premium	380	4,4	3,2	75	3/15/75+2/7/110	72	15°	GA +
SP2105027	PI-521VS Premium	380	4,6	3,2	80	4/9/100+2/14/110	72	15°	GA •

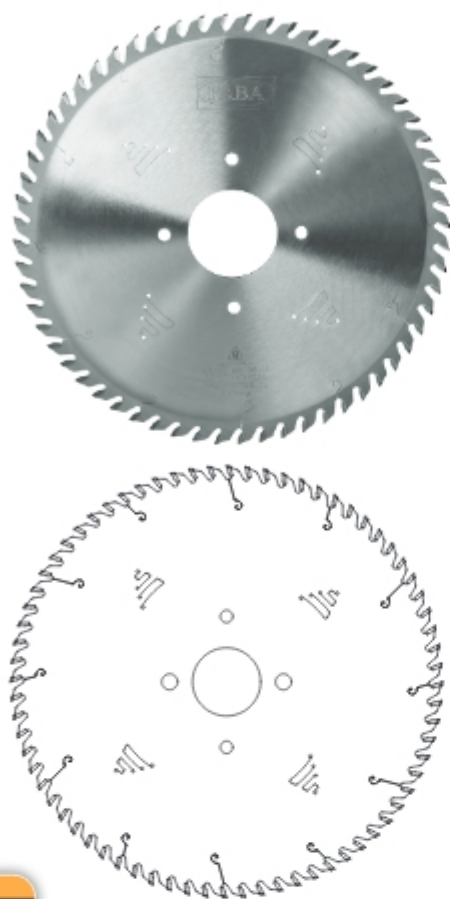
PI-521VS Premium

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Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	y	
SP2105028	PI-521VS Premium	380	4,8	3,5	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA •
SP2105029	PI-521VS Premium	400	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42+2/13/94	72	15°	GA •
SP2105030	PI-521VS Premium	400	4,4	3,2	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA •
SP2105031	PI-521VS Premium	400	4,4	3,2	75	4/15/105+2/7/110	72	15°	GA •
SP2105032	PI-521VS Premium	400	4,4	3,2	80	2/9/130+2/19/120+2/14/110	72	15°	GA •
SP2105033	PI-521VS Premium	420	4,6	3,2	80	2/14/110+4/9/100	72	15°	GA •
SP2105034	PI-521VS Premium	420	4,8	3,5	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA •
SP2105110	PI-521VS Premium	430	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA +
SP2105035	PI-521VS Premium	430	4,4	3,2	65	2/9/110	72	15°	GA +
SP2105036	PI-521VS Premium	430	4,4	3,2	75	4/15/105+2/7/110	72	15°	GA +
SP2105037	PI-521VS Premium	430	4,4	3,2	80	2/9/130+4/19/120+2/7/110+2/9/110+2/14/110+4/9/100	72	15°	GA •
SP2105038	PI-521VS Premium	450	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA •
SP2105039	PI-521VS Premium	450	4,4	3,2	80	2/9/100+2/10/130+4/19/120+2/7/110+2/14/110+4/9/100	72	15°	GA •
SP2105040	PI-521VS Premium	450	4,8	3,5	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA •
SP2105041	PI-521VS Premium	460	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA •
SP2105042	PI-521VS Premium	470	4,4	3,2	75	4/15/105	72	15°	GA +
SP2105060	PI-521VS Premium	470	4,8	3,5	70	4/11/130	72	15°	GA +
SP2105043	PI-521VS Premium	480	4,4	3,2	30	2/10/60+2/13/94+2/9/46+2/9,5/46,5+2/7/42	72	15°	GA •
SP2105044	PI-521VS Premium	480	4,8	3,5	80	2/9/100+2/10/130+4/19/120+2/7/110+2/14/110+4/9/100	72	15°	GA +
SP2105045	PI-521VS Premium	500	4,8	3,5	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	15°	GA +
SP2105046	PI-521VS Premium	520	4,8	3,5	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	18°	GA •
SP2105047	PI-521VS Premium	520	4,8	3,5	70	4/11/130	72	18°	GA +
SP2105061	PI-521VS Premium	570	4,8	3,5	60	2/19/120+2/11/115	60	18°	GA •
SP2105048	PI-521S Premium	600	5,8	4,0	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	72	18°	GA •
SP2105049	PI-521S Premium	620	6,2	4,0	40	2/13/115+2/13/140	60	18°	GA +
SP2105050	PI-521S Premium	670	5,8	4,5	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	60	18°	GA •
SP2105051	PI-521S Premium	720	6,5	4,5	40	2/14/114+2/14/140	60	18°	GA +
SP2105052	PI-521S Premium	730	6,2	4,5	60	2/9/110+2/10/80+2/11/85+2/14/100+2/11/115+2/19/120+2/14/125+2/11/148	60	18°	GA •

PI-521V NG



GA/GA



The New Generation of saw blades, **PI-521V NG** has been equipped with a new type of carbide tip. Superblade, **PI-521V NG** (New Generation) is designed for cutting multiple compact-type board, HDF, MDF, laminated board, chipboard and other homogenous materials.

The design of the blades includes super longlife carbide type produced in nanotechnology process with optimal chromium and nickel additions. It allows for obtaining high hardness with increased resistance to micro-chipping during work. The cutting surface retains its properties longer and is more resistant to breaking.

Super longlife carbide together with a new process of the saw blade's body production, have significantly increased its life. As a result, the blade's life has increased 2 up to 3 times, retaining the high quality of cutting during the whole life span of the blade.

Type of cut: cross and longitudinal, in stack.

Material: chipboard, laminated board, MDF, HDF.



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	Y	
SP2102100	PI-521V NG	305	4,4	3,2	30	2/10/60	60	15°	GA/GA +
SP2102101	PI-521V NG	320	4,4	3,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5 + 2/13/94	60	15°	GA/GA +
SP2102102	PI-521V NG	320	4,4	3,2	65	2/9/100 + 2/9/110	60	15°	GA/GA +
SP2102103	PI-521V NG	350	4,4	3,2	30	2/10/60	72	15°	GA/GA +
SP2102104	PI-521V NG	350	4,4	3,2	60	2/15/100	72	15°	GA/GA +
SP2102105	PI-521V NG	350	4,4	3,2	75	-	72	15°	GA/GA +
SP2102106	PI-521V NG	350	4,4	3,2	80	2/9/130 + 2/19/120 + 2/14/110	72	15°	GA/GA +
SP2102107	PI-521V NG	380	4,4	3,2	60	2/15/100 + 2/11/115 + 2/14/125	72	15°	GA/GA +
SP2102108	PI-521V NG	380	4,8	3,5	60	2/15/100 + 2/11/115 + 2/14/125	72	15°	GA/GA +
SP2102109	PI-521V NG	400	4,4	3,2	30	2/10/60	72	15°	GA/GA +
SP2102110	PI-521V NG	400	4,4	3,2	60	2/14/100	72	15°	GA/GA +
SP2102111	PI-521V NG	420	4,6	3,2	80	2/14/110 + 4/9/100	72	15°	GA/GA +
SP2102112	PI-521V NG	450	4,4	3,2	30	2/10/60	72	15°	GA/GA +
SP2102113	PI-521V NG	450	4,4	3,2	60	2/14/125 + 2/10/80 + 2/17/100	72	15°	GA/GA +
SP2102114	PI-521V NG	450	4,4	3,2	80	2/9/100 + 2/10/130 + 4/19/120 + 2/7/110	72	15°	GA/GA +
SP2102115	PI-521V NG	450	4,8	3,5	80	2/9/100 + 2/10/130 + 4/19/120 + 2/7/110	72	15°	GA/GA +
SP2102116	PI-521V NG	450	4,8	3,5	60	2/14/125 + 2/10/80 + 2/17/100	72	15°	GA/GA +
SP2102117	PI-521V NG	460	4,4	3,2	30	2/10/60 + 2/13/94	72	15°	GA/GA +

PI-405T

Set of adjustable scoring saw blades with flat teeth (GM), type **PI-405T** with very hard carbide tips (T), designed for scoring chipboard, laminated board, laminates, LDF and MDF on manual formatting machines and automatic lines.

Type of cut: concurrent scoring.

Material: chipboard, laminated board, MDF, plywood.

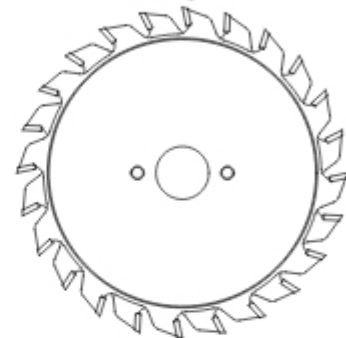
PI-405S

Set of increased life, adjustable scoring saw blades with flat teeth (GM), type **PI-405S** with super hard carbide tips (S), designed for scoring chipboard, laminated board, LDF, MDF and other homogenous materials on manual formatting machines and automatic lines.

Type of cut: scoring.

Material: chipboard, laminated board, MDF, HDF.

PI-405



Adjusting is made
by spacers as following:



0,05 mm - 1 pc
0,1 mm - 1 pc
0,2 mm - 2 pcs
0,3 mm - 1 pc

PI-405T



PI-405S



GM

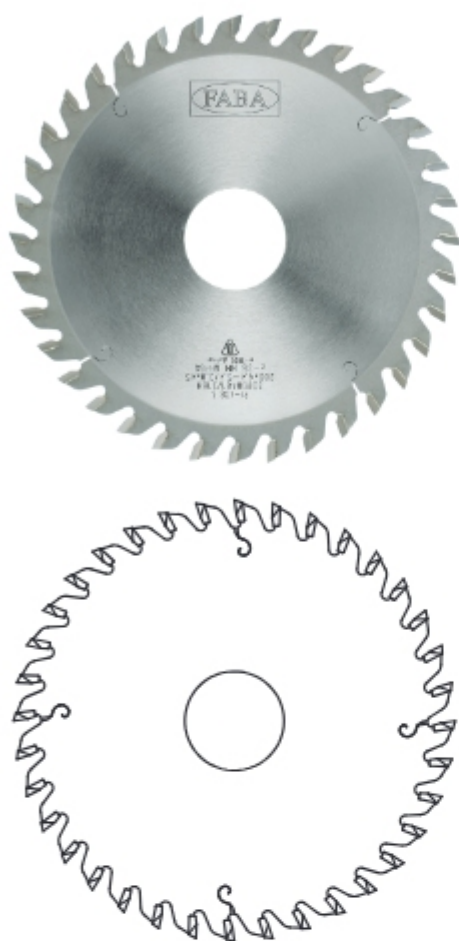


Catalogue number	Type	D mm	B/B ₂ mm ²	b mm	d mm	z	γ		
S0501001	PI-405S	80	2,8/3,6	1,0-2,2	20	2x10	12°	GM	•
S0501002	PI-405T	100	2,8/3,6	1,0-2,2	20	2x12	12°	GM	•
S0501003	PI-405T	100	2,8/3,6	1,0-2,2	22	2x12	12°	GM	•
S0501004	PI-405S	100	2,8/3,6	1,0-2,2	20	2x12	12°	GM	•
S0501005	PI-405S	100	2,8/3,6	1,0-2,2	22	2x12	12°	GM	•
S0501006	PI-405T	120	2,8/3,6	1,0-2,2	20	2x12	12°	GM	•
S0501007	PI-405T	120	2,8/3,6	1,0-2,2	22	2x12	12°	GM	•
S0500059	PI-405T	120	2,8/3,6	1,0-2,2	50	4/6,4/62	2x12	12°	GM +
S0501008	PI-405S	120	2,8/3,6	1,0-2,2	20	2x12	12°	GM	•
S0501009	PI-405S	120	2,8/3,6	1,0-2,2	22	2x12	12°	GM	•
S0500216	PI-405S	120	2,8/3,6	1,0-2,2	50	4/6,4/62	2x12	12°	GM +
S0501010	PI-405T	125	2,8/3,6	1,0-2,2	20	2x12	12°	GM	•
S0501011	PI-405T	125	2,8/3,6	1,0-2,2	22	2x12	12°	GM	•
S0501012	PI-405S	125	2,8/3,6	1,0-2,2	20	2x12	12°	GM	•
S0501013	PI-405S	125	2,8/3,6	1,0-2,2	22	2x12	12°	GM	•

Set of spacer rings for the tool

Catalogue number	Name	D (mm)	d (mm)	The set includes - spacer rings	
WHAP08160	Set of spacer rings	100 / 120 / 125	20 / 22	0,05x1; 0,1x1; 0,2x2; 0,3x1	•

PI-408T



Scoring saw blades with conical-flat (GR/GM) or conical-alternate bevel teeth (GR/GS), type **PI-408T** with very hard carbide tips (T), designed for scoring chipboard, laminated board, LDF and MDF on manual formatting machines and automatic lines.

Type of cut: scoring.

Material: plywood, chipboard, laminated board, MDF.



GR/GM



GR/GS



HM

Catalogue number	Type	D mm	B ₁ /B ₂ mm	b mm	d mm	z	
S0800600	PI-408T	100	3,1/4,3	2,5	20	24	GR/GM •
S0800601	PI-408T	100	3,1/4,3	2,5	22	24	GR/GM •
S0800249	PI-408T	120	3,1/4,3	2,5	20	24	GR/GM +
S0800002	PI-408T	125	2,8/3,6	2,2	20	24	GR/GM •
S0801600	PI-408T	125	2,8/3,6	2,2	20	24	GR/GS +
S0800014	PI-408T	125	3,1/4,3	2,5	20	24	GR/GM •
S0801601	PI-408T	125	3,1/4,3	2,5	20	24	GR/GS •
S0800602	PI-408T	125	3,1/4,3	2,5	22	24	GR/GM •
S0801602	PI-408T	125	3,1/4,3	2,5	22	24	GR/GS •
S0800402	PI-408T	200	6,2/7,2	4,5	45	36	GR/GS •

Increased life scoring saw blades with conical-flat (GR/GM) or conical-alternate bevel teeth (GR/GS), type **PI-408S** with super hard carbide tips (S), designed for scoring chipboard, laminated board, MDF and HDF and other homogenous materials on manual formatting machines and automatic lines.

Type of cut: scoring.

Material: chipboard, laminated board, MDF, HDF.



PI-408S



GR/GM



GR/GS



1

Catalogue number	Type	D mm	B ₁ /B ₂ mm	b mm	d mm	Driver holes	z	
S0800341	PI-408S	100	3,2/4,3	2,5	22	-	24	GR/GM •
S0800272	PI-408S	125	2,8/3,6	2,2	20	-	24	GR/GM •
S0801603	PI-408S	125	2,8/3,6	2,2	20	-	24	GR/GS +
S0800435	PI-408S	125	2,8/3,6	2,2	22	-	24	GR/GM •
S0801604	PI-408S	125	2,8/3,6	2,2	22	-	24	GR/GS +
S0800507	PI-408S	125	3,0/4,0	2,5	20	-	24	GR/GM •
S0801605	PI-408S	125	3,0/4,0	2,5	20	-	24	GR/GS +
S0800655	PI-408S	125	3,0/4,0	2,5	22	-	24	GR/GM •
S0801606	PI-408S	125	3,0/4,0	2,5	22	-	24	GR/GS +
S0800348	PI-408S	125	3,1/4,3	2,5	20	-	24	GR/GM •
S0801607	PI-408S	125	3,1/4,3	2,5	20	-	24	GR/GS •
S0800350	PI-408S	125	3,1/4,3	2,5	22	-	24	GR/GM •
S0801608	PI-408S	125	3,1/4,3	2,5	22	-	24	GR/GS •
S0802001	PI-408S	125	4,4/5,4	3,2	45	-	24	GR/GM +
S0801616	PI-408S	125	4,4/5,4	3,2	45	-	24	GR/GS +
S0800924	PI-408S	160	4,4/5,6	3,2	45	3/11/70	36	GR/GS +
S0800617	PI-408S	160	4,4/5,6	3,2	55	3/7/66 + 3/9/72	36	GR/GS •
S0802002	PI-408S	160	4,6/5,6	3,2	55	3/7/66 + 3/9/72	36	GR/GS +
S0802003	PI-408S	180	4,4/5,4	3,2	30	2/10/60 + 2/7/42	36	GR/GS •
S0802004	PI-408S	180	4,4/5,4	3,2	45	-	36	GR/GS •
S0800419	PI-408S	180	4,8/5,8	3,5	45	-	36	GR/GS •
S0802005	PI-408S	200	4,4/5,4	3,2	20	2/11/66	36	GR/GS •
S0802006	PI-408S	200	4,4/5,4	3,2	30	2/10/60	36	GR/GS •
S0802007	PI-408S	200	4,4/5,4	3,2	45	-	36	GR/GS •
S0802008	PI-408S	200	4,4/5,4	3,2	65	2/10/110 + 2/10/100	36	GR/GS •
S0802009	PI-408S	200	4,4/5,4	3,2	80	2/14/110	36	GR/GS •
S0800606	PI-408S	200	4,8/5,8	3,5	45	-	36	GR/GS •
S0801358	PI-408S	200	4,8/5,8	3,5	65	2/10/110 + 2/10/100	36	GR/GS +
S0801478	PI-408S	200	5,8/6,8	4,0	20	-	36	GR/GS +
S0800722	PI-408S	200	5,8/6,8	4,0	45	-	36	GR/GS •
S0801019	PI-408S	215	4,4/5,4	3,2	50	3/15/80 + 2/7/80	42	GR/GS +
S0801479	PI-408S	300	4,4/5,4	3,2	50	3/15/80	48	GR/GS +

PI-530



Saw blades with medium and high teeth number and triple-chip + flat teeth (GA), type **PI-530** with special carbide tips, designed for precise cutting of profiles and thin light alloy and plastics sheets on manual feed machines and automatic lines.

Special laser cuts (V) reduce the noise by about a half.

Type of cut: cross and longitudinal.

Material: light alloys and plastics.



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ		
P3000654	PI-530	200	2,2	1,6	32	-	100	-6°	GA	•
P3000181	PI-530	216	3,2	2,6	30	2/10/60	64	-6°	GA	•
P3000450	PI-530	250	2,6	2,0	30	2/10/60 + 2/7/42 + 2/9,5/46,5	100	-6°	GA	•
P3000001	PI-530	250	3,2	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	60	-6°	GA	•
P3000002	PI-530	250	3,2	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	80	-6°	GA	•
P3000003	PI-530	300	3,2	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	72	-6°	GA	•
P3000051	PI-530V	300	3,2	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	-6°	GA	•
P3000382	PI-530	300	3,2	2,6	32	2/12/64	96	-6°	GA	•
P3000114	PI-530	330	3,2	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	102	-6°	GA	•
P3000005	PI-530	350	3,8	3,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	84	-6°	GA	•
P3000006	PI-530	350	3,8	3,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	108	-6°	GA	•
P3000043	PI-530	350	3,8	3,2	32	2/10/60	108	-6°	GA	•
P3000007	PI-530	400	3,8	3,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	-6°	GA	•
P3000008	PI-530	400	3,8	3,2	30	2/10/60	120	-6°	GA	•
P3000392	PI-530	400	3,8	3,2	32	2/12/64	96	-6°	GA	•
P3000314	PI-530	400	3,8	3,2	32	2/12/64	120	-6°	GA	•
P3000377	PI-530	500	4,6	4,0	30	2/10/60 + 2/10/70	120	-6°	GA	•

PI-530 Premium type saw blades with increased life, stiffness and body stability designed for precise longitudinal and cross cutting of solid materials from light alloys and plastics, working on manual feed machines and automatic lines.

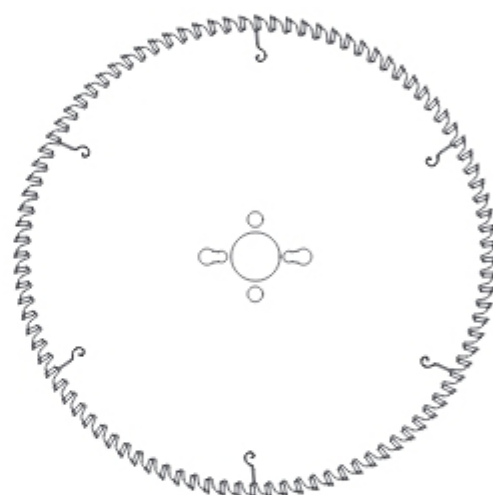
PI-530 type saw blades with high number of group triple chip + flat (GA) teeth and special carbide tips.

Type of cut: single, cross and longitudinal.

Material: light alloys and plastics.

PI-530 Premium

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GA



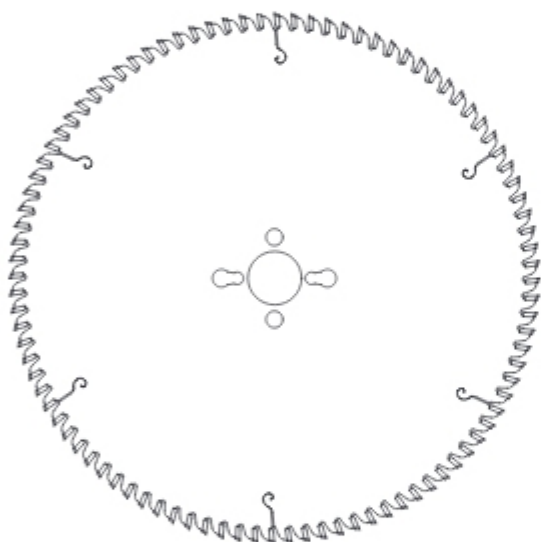
Cat. num.	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
SP3006006	PI-530V Premium	300	3,2	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	72	-6°	GA •
SP3006007	PI-530V Premium	300	3,2	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	-6°	GA •
SP3006009	PI-530V Premium	300	3,2	2,6	32	2/12/64	96	-6°	GA •
SP3006013	PI-530 Premium	350	3,6	3,0	30	2/10/60 + 2/7/42 + 2/9,5/46,5	108	-6°	GA •
SP3006014	PI-530 Premium	350	3,6	3,0	32	2/10/63 + 2/10/60	108	-6°	GA •
SP3006018	PI-530 Premium	400	3,6	3	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	-6°	GA •
SP3006019	PI-530 Premium	400	3,6	3	32	2/10/60 + 2/12/64	96	-6°	GA •
SP3006020	PI-530 Premium	400	3,6	3	30	2/10/60 + 2/7/42 + 2/9,5/46,5 + 2/11/70	120	-6°	GA •
SP3006021	PI-530 Premium	400	3,6	3	32	2/10/60 + 2/12/64	120	-6°	GA •
SP3006026	PI-530 Premium	420	3,8	3,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	-6°	GA •
SP3006029	PI-530 Premium	450	4,2	3,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	102	-6°	GA •
SP3006030	PI-530 Premium	450	4,2	3,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	120	-6°	GA •
SP3006033	PI-530 Premium	500	4,2	3,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5 + 2/11/70	120	-6°	GA •
SP3006034	PI-530 Premium	500	4,4	3,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5 + 2/11/70	120	-6°	GA +
SP3006038	PI-530 Premium	550	4,4	3,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5 + 2/11/70	132	-6°	GA •

PI-531

Saw blades with high teeth number and triple-chip + flat teeth (GA), type **PI-531** with special carbide tips, designed for precise cutting of solid materials from light alloys and plastics on automatic feed machines.

Type of cut: cross and longitudinal.

Material: light alloys and plastics.



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
P3100002	PI-531	250	3,2	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	80	5°	GA •
P3100004	PI-531	300	3,2	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	5°	GA •
P3100005	PI-531	330	3,2	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	102	5°	GA +
P3100007	PI-531	350	3,2	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	108	5°	GA •
P3100008	PI-531	400	3,8	3,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	5°	GA •
P3101250	PI-531	500	4,0	3,4	30	2/10/60 + 2/10,5/70	120	5°	GA +
P3102105	PI-531	500	4,0	3,4	32	2/12/64	120	5°	GA +

PI-531 Premium type saw blades with increased life, stiffness and body stability designed for precise longitudinal and cross cutting of solid materials from light alloys and plastics, working on manual feed machines and automatic lines.

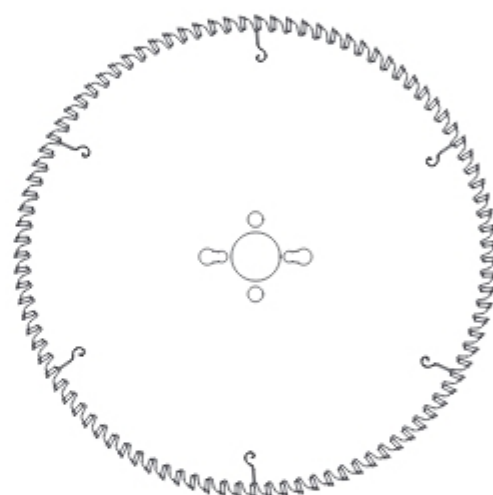
PI-531 type saw blades with high number of group triple chip + flat (GA) teeth and special carbide tips.

Type of cut: single, cross and longitudinal.

Material: light alloys and plastics.

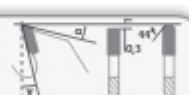
PI-531 Premium

1



HM

GA



AL

PCV



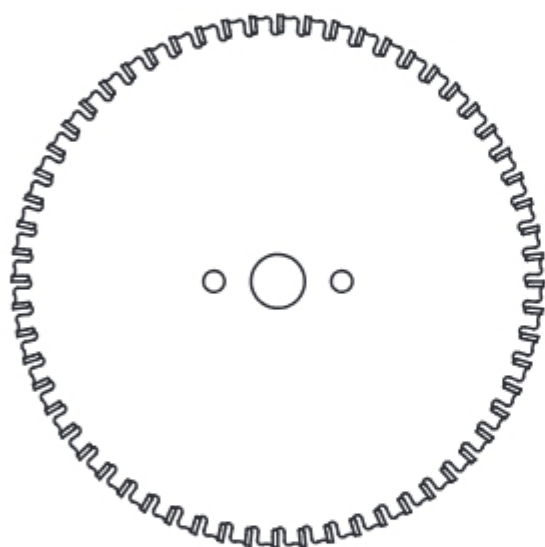
Cat. num.	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
SP3106007	PI-531V Premium	300	3,2	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	5°	GA •
SP3106009	PI-531V Premium	300	3,2	2,6	32	2/12/64	96	5°	GA •
SP3106011	PI-531 Premium	350	3,2	2,6	30	2/10/60 + 2/7/42 + 2/9,5/46,5	108	5°	GA •
SP3106012	PI-531 Premium	350	3,2	2,6	32	2/10/63 + 2/10/60	108	5°	GA •
SP3106023	PI-531 Premium	400	3,8	3,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	5°	GA •
SP3106026	PI-531 Premium	420	3,8	3,2	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	5°	GA •
SP3106027	PI-531 Premium	450	4	3,4	30	2/10/60 + 2/7/42 + 2/9,5/46,5	102	5°	GA •
SP3106028	PI-531 Premium	450	4	3,4	30	2/10/60 + 2/7/42 + 2/9,5/46,5	120	5°	GA •
SP3106031	PI-531 Premium	500	4	3,4	30	2/10/60 + 2/7/42 + 2/9,5/46,5	120	5°	GA •
SP3106032	PI-531 Premium	500	4	3,4	32	2/11/60 + 2/11/70	120	5°	GA •
SP3106034	PI-531 Premium	500	4,4	3,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5	120	5°	GA +
SP3106036	PI-531 Premium	550	4	3,4	30	2/10/60 + 2/7/42 + 2/9,5/46,5 + 2/11/70	132	5°	GA •
SP3106037	PI-531 Premium	550	4	3,4	32	2/11/60 + 2/11/70	132	5°	GA •

PI-535

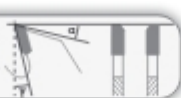
Saw blades with top bevel teeth (GSM), type **PI-535** with special carbide tips, designed for precise cutting of steel, non-ferrous metals, sandwich panels and others.

Type of cut: cross and longitudinal.

Material: steel, non-ferrous metals, sandwich panels, copper alloys, pipes, profiles, angle bars, flat bars, cable closures, metal sheets.



GSM



HM

Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	n _{max}	γ		
P3500023	PI-535	235	2,2	1,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5	48	1800	0°	GSM	+
P3500001	PI-535	250	2,2	1,8	25,4	2/10/60	60	1800	0°	GSM	+
P3500002	PI-535	250	2,2	1,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5	60	1800	0°	GSM	•
P3500003	PI-535	300	2,2	1,8	25,4	2/10/60	60	1500	0°	GSM	+
P3500004	PI-535	300	2,2	1,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5	60	1500	0°	GSM	+
P3500005	PI-535	300	2,2	1,8	25,4	2/10/60	80	1500	0°	GSM	+
P3500006	PI-535	300	2,2	1,8	30	2/10/60 + 2/7/42 + 2/9,5/46,5	80	1500	0°	GSM	+
P3500007	PI-535	350	2,4	2,0	25,4	2/10/60	96	1500	0°	GSM	+
P3500008	PI-535	350	2,4	2,0	30	2/10/60 + 2/7/42 + 2/9,5/46,5	96	1500	0°	GSM	+

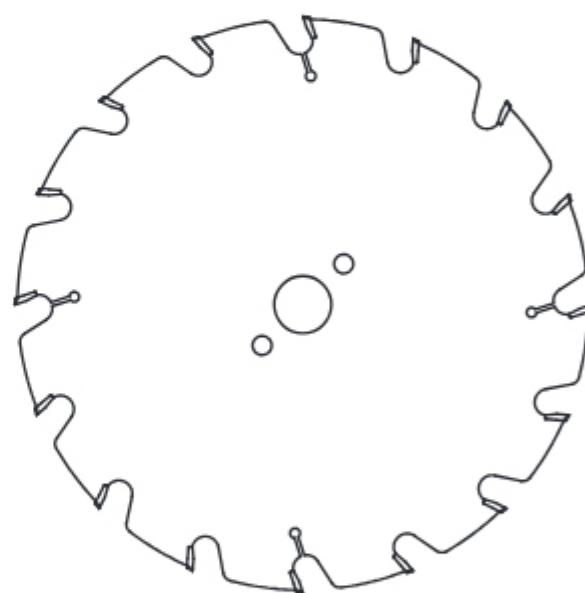
Saw blades with small teeth number and flat teeth with chamfers on both sides (GAM), type **PI-550 EVO2** with carbide tips, designed for cutting gypsum-plaster boards, construction boards, solid wood contaminated with sand, concrete, ferrous intrusions.

Special body coating technology prevents the resin from sticking to the blade and reduces the blade-wood friction.

Type of cut: cross and longitudinal.

Material: gypsum-plaster boards, construction boards, solid wood, contaminated wood-based materials.

PI-550 EVO2



GAM

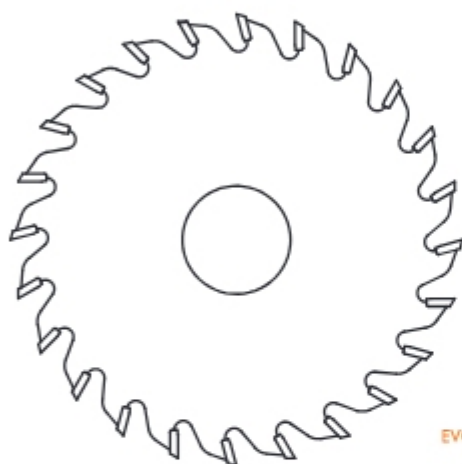


K-G

BUD

Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ	
P5000001-2	PI-550 EVO2	300	3,2	2,1	30	2/10/60 + 2/7/42 + 2/9,5/46,5	16	18°	GAM •
P5000002-2	PI-550 EVO2	350	3,5	2,5	30	2/10/60 + 2/7/42 + 2/9,5/46,5	20	18°	GAM •
P5000003-2	PI-550 EVO2	400	3,8	2,8	30	2/10/60	24	18°	GAM •
P5000004-2	PI-550 EVO2	450	4,0	3,0	30	2/10/60	28	18°	GAM •
P5000005-2	PI-550 EVO2	500	4,0	3,0	30	2/10/60	32	18°	GAM •

PI-401 EVO2



GM



GS



Scoring saw blades with flat teeth (GM) and alternate top bevel teeth (GS), type **PI-401 EVO2** with carbide tips, designed for scoring and grooving in solid wood on manual formatting machines and automatic lines.

Special body coating technology prevents the resin from sticking to the blade and reduces the blade-wood friction.

Type of cut: scoring, grooving.

Material: solid wood.

Catalogue number	Type	D mm	B mm	b mm	d mm	z	γ		
S0100002	PI-401 EVO2	100	3,2	2,2	30	18	15°	GS	•
S0100004	PI-401 EVO2	100	3,4	2,2	22	18	15°	GS	•
S0100003	PI-401 EVO2	100	3,4	2,2	30	18	15°	GS	•
S0100005	PI-401 EVO2	100	4,0	3,0	30	18	15°	GM	•
S0100010	PI-401 EVO2	125	2,5	1,8	30	12	15°	GS	•
S0100011	PI-401 EVO2	125	3,0	2,0	30	12	15°	GS	•
S0100013	PI-401 EVO2	125	3,2	2,2	30	12	15°	GS	•
S0100023	PI-401 EVO2	125	3,4	2,2	30	24	15°	GS	•
S0100025	PI-401 EVO2	125	3,4	2,2	30	36	10°	GS	•
S0100018	PI-401 EVO2	125	4,0	3,0	30	12	15°	GM	•
S0100052	PI-401 EVO2	125	4,0	3,0	30	24	15°	GM	•
S0100019	PI-401 EVO2	125	5,0	3,5	30	12	15°	GM	•
S0100020	PI-401 EVO2	125	6,0	4,0	30	12	15°	GM	•
S0100021	PI-401 EVO2	125	8,0	5,0	30	12	15°	GM	•

PI-401T

Scoring saw blades type **PI-401T** with very hard carbide tips (T), designed for scoring and grooving in boards on manual formatting machines and automatic lines.

Type of cut: scoring, grooving.

Material: plywood, chipboard, laminated board, MDF.

PI-401S

Increased life scoring saw blades type **PI-401S** with super hard carbide tips (S), designed for scoring and grooving in boards and homogenous materials without impurities on manual formatting machines and automatic lines.

Type of cut: scoring, grooving.

Material: chipboard, laminated board, MDF, HDF.

PI-401



PI-401T

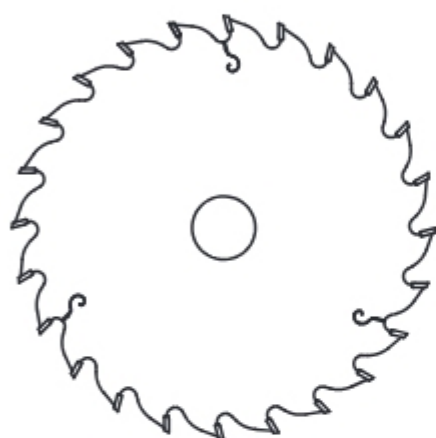


PI-401S



Catalogue number	Type	D mm	B mm	b mm	d mm	z	γ		
S0100717	PI-401T	125	3,2	2,2	20	36	10°	GS	•
S0100850	PI-401T	125	3,2	2,2	30	36	10°	GS	•
S0100263	PI-401T	125	3,4	2,2	20	24	15°	GS	•
S0100200	PI-401T	125	3,4	2,2	20	36	10°	GS	•
S0100673	PI-401S	125	3,4	2,2	20	36	10°	GS	•
S0100596	PI-401T	125	3,4	2,2	22	36	10°	GS	•
S0101288	PI-401S	125	3,4	2,2	22	36	10°	GS	•

PI-402 EVO2



Scoring saw blades with flat teeth (GM) and alternate top bevel teeth (GS), type **PI-402 EVO2** with carbide tips, designed for scoring and grooving in solid wood on manual formatting machines and automatic lines.

Special body coating technology prevents the resin from sticking to the blade and reduces the blade-wood friction.

Type of cut: scoring, grooving, splitting.

Material: solid wood.



GM



GS



HM

Catalogue number	Type	D mm	B mm	b mm	d mm	z	γ	
S0200001	PI-402 EVO2	150	2,8	2,0	30	24	15°	GS •
S0200002	PI-402 EVO2	150	3,0	2,0	30	36	10°	GS •
S0200003	PI-402 EVO2	150	3,2	2,2	30	36	10°	GS •
S0200232	PI-402 EVO2	150	3,2	2,2	40	36	10°	GS •
S0200004	PI-402 EVO2	150	3,4	2,2	30	36	10°	GS •
S0200006	PI-402 EVO2	150	4,0	3,0	30	36	10°	GM •
S0200011	PI-402 EVO2	160	3,2	2,2	30	36	10°	GS •
S0201855	PI-402 EVO2	200	3,0	2,0	40	24	15°	GS •
S0200014	PI-402 EVO2	200	3,2	2,2	30	24	15°	GS •
S0200015	PI-402 EVO2	200	3,2	2,2	30	36	15°	GS •
S0200249	PI-402 EVO2	200	3,2	2,2	40	36	15°	GS +
S0200077	PI-402 EVO2	200	4,0	3,0	30	48	15°	GS •

PI-402T

Scoring saw blades type **PI-402T** with very hard carbide tips (T), designed for scoring, grooving and cutting boards on manual formatting machines and automatic lines.

Type of cut: scoring, grooving, splitting.

Material: plywood, chipboard, laminated board, MDF.

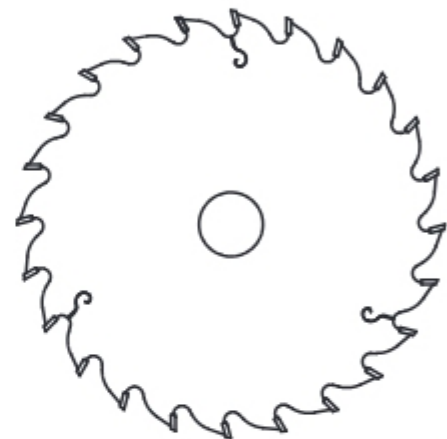
PI-402S

Increased life scoring saw blades type **PI-402S** with super hard carbide tips (S), designed for scoring, grooving and cutting boards and homogenous materials without impurities on manual formatting machines and automatic lines.

Type of cut: scoring, grooving, splitting.

Material: chipboard, laminated board, MDF, HDF.

PI-402



PI-402T

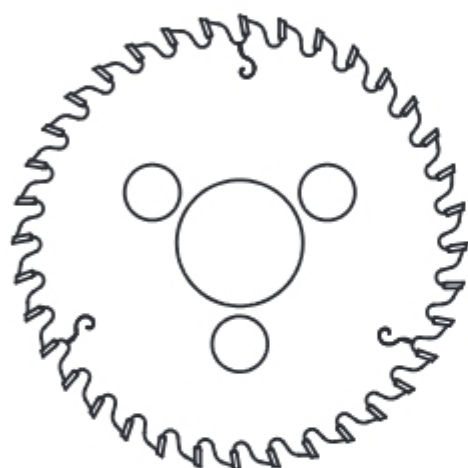


PI-402S



Catalogue number	Type	D mm	B mm	b mm	d mm	z	γ	
S0200031	PI-402T	150	3,2	2,2	30	36	10°	GS •
S0201043	PI-402T	150	4,0	3,0	30	36	10°	GM •
S0200697	PI-402S	150	4,0	3,0	30	36	10°	GM •
S0203575	PI-402T	150	5,0	3,5	30	36	10°	GM •
S0201799	PI-402T	150	6,0	4,0	30	36	10°	GM •
S0200243	PI-402T	150	8,0	5,0	30	36	10°	GM •
S0201110	PI-402T	200	3,0	2,0	30	48	15°	GS •
S0200516	PI-402T	200	3,2	2,2	30	48	15°	GS •
S0201124	PI-402T	200	3,2	2,2	30	60	10°	GS •

PI-403



PI-403T



PI-403S



PI-403T

Scoring saw blades with flat teeth (GM), type **PI-403T** with very hard carbide tips (T), designed for cutting boards on automatic lines with pneumatic clamping systems.

Type of cut: cross and longitudinal.

Material: plywood, chipboard, laminated board, MDF.

PI-403S

Increased life scoring saw blades with flat teeth (GM), type **PI-403S** with super hard carbide tips (T), designed for cutting boards and homogenous materials without impurities on automatic lines with pneumatic clamping systems.

Type of cut: cross and longitudinal.

Material: chipboard, laminated board, MDF, HDF.



Catalogue number	Type	D mm	B mm	b mm	d mm	Driver holes	z	γ		
S0300001	PI-403T	180	3,2	2,2	50	3/22/80	36	10°	GM	+
S0300002	PI-403T	180	3,2	2,2	50	3/22/80	48	10°	GM	+
S0300029	PI-403S	180	3,2	2,2	50	3/22/80	48	10°	GM	+
S0300005	PI-403T	200	3,2	2,2	50	3/22/80	60	10°	GM	+

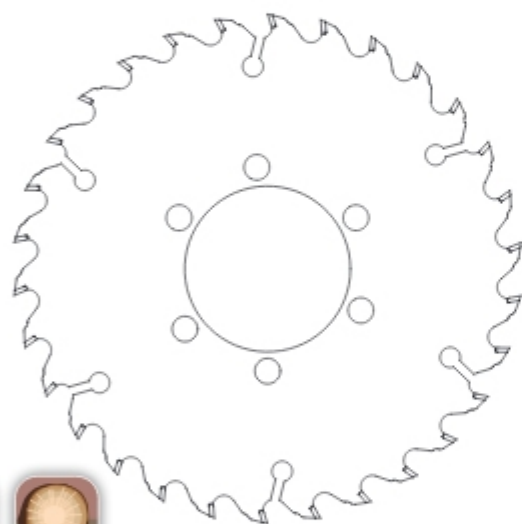
Special saw blades

Thin saw blades designed for 2-spindle automatic splitting lines and special saw blades, rings and hogger segments designed for high performance automatic saw mill lines. The saw blades are manufactured from the highest quality steel using a special technology, adapted to the type of machining (pre-sawing, formatting, splitting), kind of material (frozen, wet or dry wood) and parameters and conditions during cutting in order to guarantee proper work of the saw blade in extremely difficult conditions.

The chapter "Special saw blades" includes only example proposals of saw blades with standard dimensions. On request we can suggest and produce a proper saw blade for the needed type of machining, material as well as parameters and conditions prevailing during work.

Thin saw blades	1.48
Spline & CanDrive	1.50
Saw blades for HewSaw	1.51
Special multi-rip saw blades	1.52
Conical saw blades	1.53
Recessed multi-rip saw blades	1.54
Recessed saw blades for HewSaw	1.55
Recessed ring-saw blades	1.56
Ring-saw blades	1.57

Thin saw blades



GM



GS



Special thin saw blades with straight (GM) or alternate top bevel (GS) teeth and hard, properly chosen carbide tips, designed for splitting solid wood (lamellas) on 2-spindle high-efficiency automatic splitting lines.

Construction of the saw blade guarantees high splitting efficiency with high quality of lamellas and, at the same time, minimizing waste by reducing kerf thickness.

Special body coating technology prevents the resin from sticking to the blade and lowers the blade-wood friction.

Type of cut: longitudinal.

Material: solid dry wood, soft and hard.

Type	D mm	B mm	b mm	d mm	z		
PI-501	180	1,3	0,9	50	32	GM/GS	+
PI-501	200	1,3	0,9	65	30	GM/GS	+
PI-501	200	1,4	1,0	90	32	GM/GS	+
PI-501	200	1,8	1,2	90	32	GM/GS	+
PI-501	200	2,0	1,4	90	32	GM/GS	+
PI-501	225	1,4	1,0	70	32	GM/GS	+
PI-501	225	1,6	1,2	70	32	GM/GS	+
PI-501	225	1,8	1,2	70	32	GM/GS	+
PI-501	250	1,4	1,0	70	36	GM/GS	+
PI-501	250	1,6	1,2	70	36	GM/GS	+
PI-501	250	2,0	1,4	70	36	GM/GS	+

Special thin saw blades with wiper knives and with straight (GM) or alternate top bevel (GS) teeth and hard, properly chosen carbide tips, designed for splitting solid wood (lamellas) on 1 or 2-spindle high-efficiency automatic splitting lines.

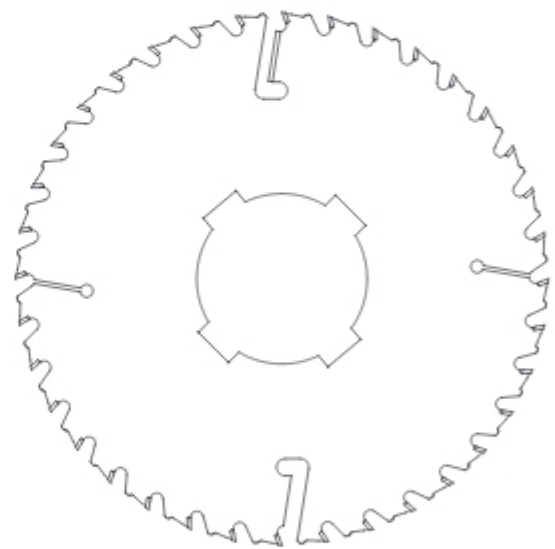
Construction of the saw blade guarantees high splitting efficiency with high quality of lamellas and, at the same time, minimizing wastes by reducing kerf thickness.

Special body coating technology prevents the resin from sticking to the blade and lowers the blade-wood friction.

Type of cut: longitudinal.

Material: solid dry wood, soft and hard.

Thin saw blades with wiper knives



GM



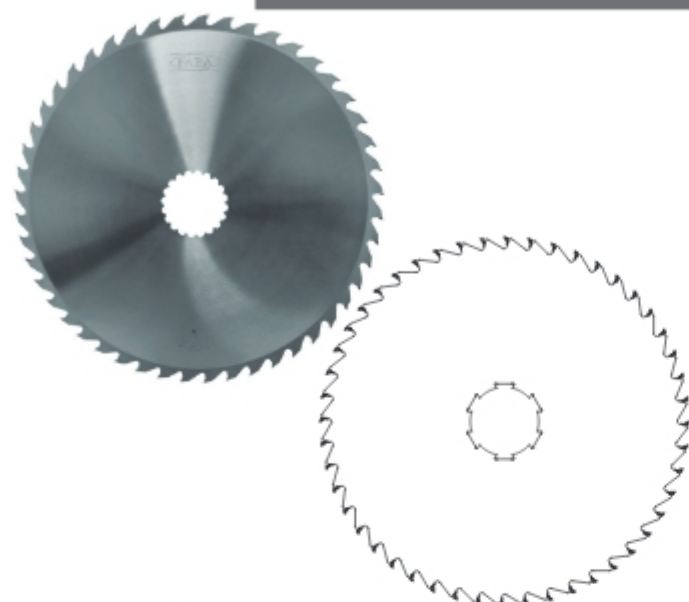
Type	D mm	B mm	b mm	d mm	z		
PI-502	200	1,8	1,2	60	16+2	GM	+
PI-502	225	1,8	1,2	60	20+4	GM	+
PI-502	225	2,0	1,4	65	20+4	GM	+
PI-502	225	2,2	1,4	60	20+4	GM	+
PI-502	250	1,8	1,2	80	36+2	GM	+
PI-502	250	2,0	1,4	60	24+4	GM	+
PI-502	325	2,0	1,6	60	42+4	GM	+

Spline & CanDrive

Special saw blades with the central bore type Spline & Can-Drive with flat (GM) or alternate top bevel (GS) teeth. Saw blades with hard, properly chosen carbide or stellite tips designed for cutting fresh (wet and frozen) wood. Ripping saw blades are equipped with special design of chip breaker, to guarantee optimal work efficiency of the tool.

Type of cut: longitudinal.

Material: solid wet wood (soft and hard), frozen wood.



GM



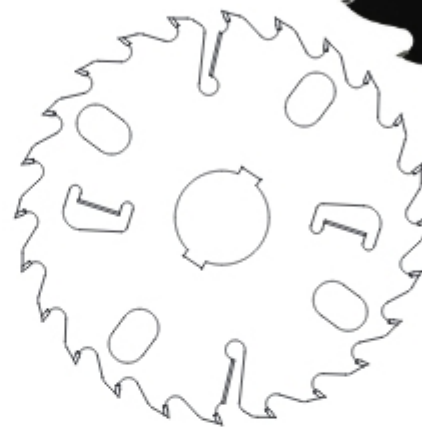
Type	D mm	B mm	b mm	d mm	z		
PI-501	428	3,4	2,4	Spline or Can Drive	30	GM	+
PI-501	500	3,4	2,2	Spline or Can Drive	36	GS	+
PI-501	500	3,4	2,6	Spline or Can Drive	36	GS	+
PI-501	500	4,8	3,5	Spline or Can Drive	48	GM	+
PI-501	500	5,0	3,5	Spline or Can Drive	48	GM	+
PI-501	500	5,0	3,5	Spline or Can Drive	60	GM	+
PI-501	508	3,4	2,4	Spline or Can Drive	36	GM	+
PI-501	508	3,4	2,4	Spline or Can Drive	42	GM	+
PI-501	508	3,8	2,4	Spline or Can Drive	48	GM	+
PI-501	508	3,8	2,4	Spline or Can Drive	60	GM	+
PI-501	600	4,0	2,8	Spline or Can Drive	48	GM	+
PI-501	610	4,2	2,8	Spline or Can Drive	40	GM	+
PI-501	660	4,6	3,0	Spline or Can Drive	18	GM	+
PI-501	660	4,0	2,6	Spline or Can Drive	24	GM	+
PI-501	660	4,6	4,0	Spline or Can Drive	32	GM	+
PI-501	700	4,0	2,8	Spline or Can Drive	42	GM	+
PI-501	700	4,0	2,8	Spline or Can Drive	48	GM	+
PI-501	700	4,2	2,8	Spline or Can Drive	42	GM	+
PI-501	700	4,2	2,8	Spline or Can Drive	48	GM	+
PI-501	700	4,4	3,0	Spline or Can Drive	48	GM	+
PI-501	710	4,2	2,8	Spline or Can Drive	48	GM	+
PI-501	710	4,2	2,8	Spline or Can Drive	56	GM	+
PI-501	720	4,4	3,0	Spline or Can Drive	48	GM	+
PI-501	800	4,2	2,8	Spline or Can Drive	56	GM	+

Special multi-rip saw blades with straight teeth (GM) and hard, properly chosen carbide or stellite tips. Saw blades with wiper knives or wiper knives and special holes enabling the blade to work in a set with a formatting cutter, designed for longitudinal cutting of wood on high-efficiency automatic HewSaw sawmill lines produced by Veisto. Special body coating technology prevents the resin from sticking to the blade and lowers the blade-wood friction.

Type of cut: longitudinal.

Material: solid wet wood (soft and hard), frozen wood.

Saw blades for HewSaw



Machine	Type	D mm	B mm	b mm	d mm	z			
Hew Saw	PI-510	251	3,6	2,4	55	18+3	GM	L/R	+
Hew Saw	PI-510	251	4,0	2,8	55	18+3	GM	L/R	+
Hew Saw	PI-510	351	2,8	1,8	70	30+4	GM	L/R	+
Hew Saw	PI-510	351	3,3	2,1	70	30+4	GM	L/R	+
Hew Saw	PI-510	351	3,6	2,4	70	30+4	GM	L/R	+
Hew Saw	PI-510	351	3,8	2,6	70	24+4	GM	L/R	+
Hew Saw	PI-510	351	3,8	2,6	70	30+4	GM	L/R	+
Hew Saw	PI-510	351	4,0	2,8	70	24+4	GM	L/R	+
Hew Saw	PI-510	351	4,0	2,8	70	30+2	GM	L/R	+
Hew Saw	PI-510	351	4,0	2,8	99	30+4	GM	L/R	+
Hew Saw	PI-510	401	4,0	2,8	70	24+4	GM	L/R	+
Hew Saw	PI-510	401	4,0	2,8	99	40+2	GM	L/R	+
Hew Saw	PI-510	450	3,9	2,6	99	30+6	GM	L/R	+
Hew Saw	PI-510	450	4,2	2,8	200	36+3	GM	L/R	+
Hew Saw	PI-510	450	4,4	3,1	99	30+6	GM	L/R	+
Hew Saw	PI-510	450	4,6	3,0	115	28+4	GM	L/R	+
Hew Saw	PI-510	450	5,0	3,4	115	24+4	GM	L/R	+
Hew Saw	PI-510	450	5,4	4,1	99	24+6	GM	L/R	+
Hew Saw	PI-510	451	3,8	2,4	99	28+4	GM	L/R	+
Hew Saw	PI-510	451	4,5	3,0	99	28+4	GM	L/R	+

Special multi-rip saw blades



GM



Special multi-rip saw blades with straight teeth (GM) and hard, properly chosen carbide or stellite tips, with wiper knives, designed for ripping wood on high-efficiency automatic machines such as HewSaw, Linck, EWD, Heinola, Ari-Vislanda, Soederhamn and others.

Special body coating technology prevents the resin from sticking to the blade and lowers the blade-wood friction.

Type of cut: longitudinal.

Material: solid wet wood (soft and hard), frozen wood.



Machine	Type	D mm	B mm	b mm	d mm	z			
Linck	PI-510	360	3,6	2,2	150	20+4	GM	L/R	+
Linck	PI-510	410	4,0	2,6	150	20+4	GM	L/R	+
Söderhamn	PI-510	435	4,2	2,8	144,5	30+6	GM	L/R	+
Linck	PI-510	440	4,2	2,8	120	20+4	GM	L/R	+
Linck	PI-510	440	4,6	3,1	120	24+4	GM	L/R	+
Linck	PI-510	440	5,0	3,6	120	32+6	GM	L/R	+
Linck	PI-510	470	4,0	2,6	150	28+4	GM	L/R	+
Söderhamn	PI-510	485	4,5	3,3	144,5	24+6	GM	L/R	+
Linck	PI-510	490	4,6	3,1	120	32+6	GM	L/R	+
Linck	PI-510	490	5,0	3,6	120	32+6	GM	L/R	+
Linck	PI-510	505	4,6	3,1	120	24+4	GM	L/R	+
Linck	PI-510	520	3,6	2,2	150	28+6	GM	L/R	+
EWD	PI-510	520	4,2	2,9	160	36+6	GM	L/R	+
Linck	PI-510	540	3,6	2,4	300	30+3	GM	L/R	+
Linck	PI-510	540	4,2	3,1	225	30+6	GM	L/R	+
Linck	PI-510	540	4,6	3,3	150	24+4	GM	L/R	+
Linck	PI-510	540	5,0	3,6	150	30+6	GM	L/R	+
Hew Saw	PI-510	550	4,6	3,0	115	42+6	GM	L/R	+
Hew Saw	PI-510	550	5,2	3,4	115	30+6	GM	L/R	+
Heinola	PI-510	556	3,6	2,4	160/260	36+3	GM	L/R	+
Heinola	PI-510	556	3,6	2,4	160/260	42+3	GM	L/R	+
Heinola	PI-510	556	4,2	2,8	160/260	38+4	GM	L/R	+
Heinola	PI-510	556	4,6	3,2	160/260	30+6	GM	L/R	+
Heinola	PI-510	556	4,6	3,2	160/260	32+4	GM	L/R	+
Hew Saw	PI-510	600	3,9	2,6	99	42+6	GM	L/R	+
Hew Saw	PI-510	600	4,4	3,1	99	42+6	GM	L/R	+
Linck	PI-510	600	5,0	3,6	120	28+6	GM	L/R	+
Linck	PI-510	648	5,0	3,6	165	20+6	GM	L/R	+

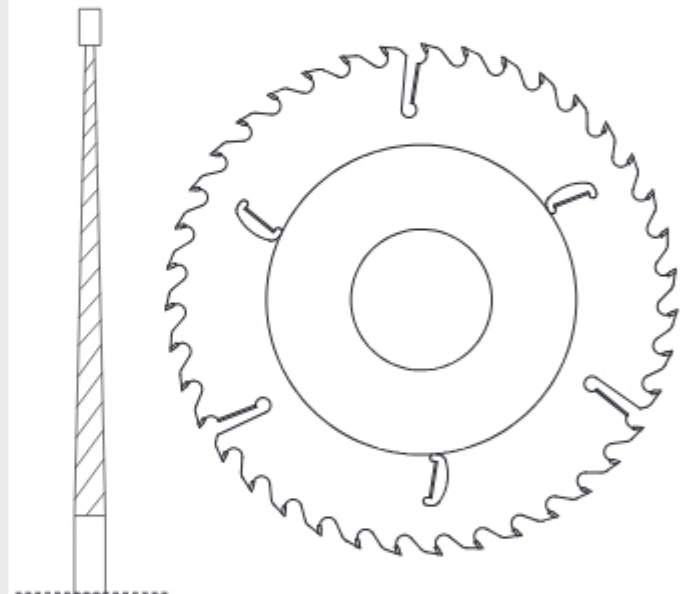
Special conical-shaped body saw blades with straight teeth (GM) and hard, properly chosen carbide or stellite tips, with or without wiper knives, designed for ripping wood on high-efficiency automatic sawmill lines.

Conical construction of the saw blade body guarantees high cutting efficiency and, at the same time, minimizing waste by reducing kerf thickness in spite of large diameters. Special body coating technology prevents the resin from sticking to the blade and lowers the blade-wood friction.

Type of cut: longitudinal.

Material: solid wet wood (soft and hard), frozen wood.

Conical saw blades



GM



Machine	Type	D mm	B mm	b-b ₁ mm	d mm	z			
Ar	PI-501	550	5,5	3,5-3,8	120	30	GM	L/R	+
Link	PI-510	390	3,4	2,0-2,6	150	34+4	GM	L/R	+
Link	PI-510	440	3,2	2,0-2,4	150	32+4	GM	L/R	+
Link	PI-510	515	3,6	2,2-2,6	150	42+4	GM	L/R	+
Link	PI-510	530	3,6	2,2-2,6	150	44+4	GM	L/R	+
Link	PI-510	530	3,8	2,4-2,8	150	44+4	GM	L/R	+
Link	PI-510	545	3,4	1,9-2,2	150	39+6	GM	L/R	+

Recessed multi-rip saw blades



Special recessed-body saw blades for multi-rip machines with straight teeth (GM) and hard, properly chosen carbide or stellite tips, with wiper knives, designed for longitudinal cutting of wood on high-efficiency automatic sawmill lines. Special recessed construction of the saw blade body guarantees high splitting efficiency and, at the same time, minimizing waste by reducing kerf thickness in spite of large diameters.



GM



Machine	D mm	B mm	b-b ₁ mm	d mm	z		↗	
Artiglio	450	5,0	3,0-7,2	60	36+4	GM	L/R	+
Linck	505	5,2	3,6-6,8	120	20+4	GM	L/R	+
Linck	505	5,2	3,6-6,8	120	28+4	GM	L/R	+
Linck	530	5,4	3,6-6,8	105	36+6	GM	L/R	+
Linck	540	4,4	2,8-5,0	150	30+6	GM	L/R	+
Linck	540	5,0	3,4-6,8	150	30+6	GM	L/R	+
Linck	540	5,5	4,0-7,0	150	24+6	GM	L/R	+
Linck	540	5,4	3,6-6,8	150	26+6	GM	L/R	+
Linck	550	5,2	3,5-6,8	150	26+6	GM	L/R	+
Linck	550	5,4	3,5-6,8	150	32+6	GM	L/R	+
Linck	580	5,2	3,8-6,8	140	26+6	GM	L/R	+
Artiglio	600	5,6	4,0-7,2	106	24+6	GM	L/R	+
Linck	620	5,6	3,9-6,8	170	28+6	GM	L/R	+
Heinola	620	5,4	4,2-6,5	160/260	40+4	GM	L/R	+
Heinola	620	4,6	3,4-6,5	160/260	40+4	GM	L/R	+
Linck	650	5,6	4,0-6,7	160	24+6	GM	L/R	+

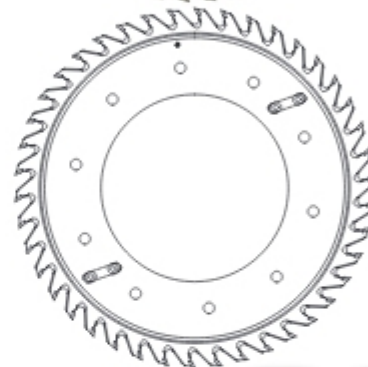
Special recessed-body saw blades with straight teeth (GM) and hard, properly chosen carbide or stellite tips, with or without wiper knives, designed for pre-sawing wood and formatting (D=252 and D=316) on high-efficiency automatic HewSaw sawmill lines produced by Veisto.

Special construction of the saw blade with properly directed chip flow achieved by shaping the gullet guarantees high work efficiency of the blades.

Type of cut: longitudinal.

Material: solid wet wood (soft and hard), frozen wood.

Recessed saw blades for HewSaw



GM



GW



GT

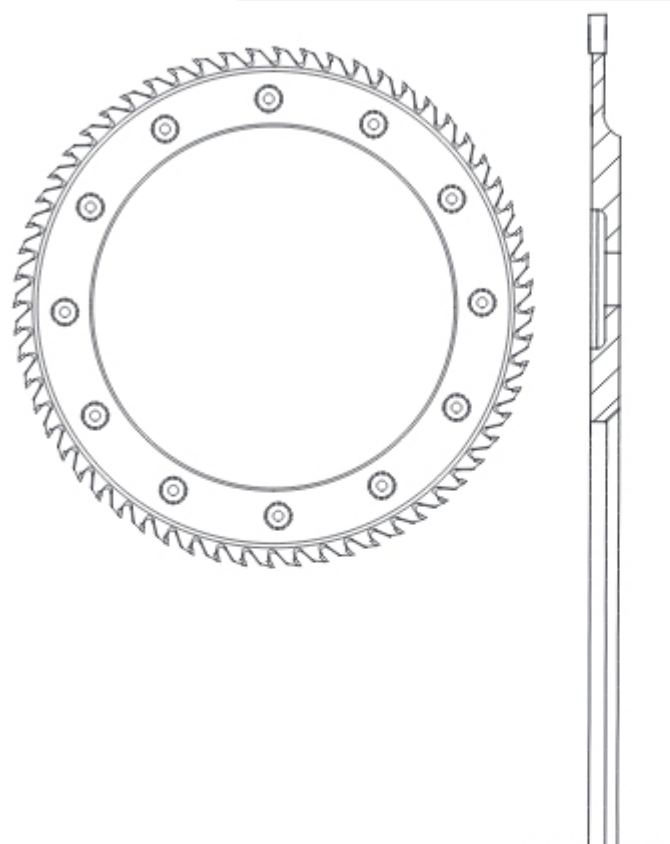


Machine	Type	D mm	B mm	b-b ₁ mm	d mm	z				
Hew Saw	PI-518	252	4,0	3,5–6,9	70/99	20	GM	L/R	CF	+
Hew Saw	PI-518	252	4,0	3,5–6,9	70/99	20	GT or GW	L/R	CF	+
Hew Saw	PI-518	252	4,0	3,5–6,9	70/99	22	GM	L/R	CF	+
Hew Saw	PI-518	252	4,0	3,5–6,9	70/99	22	GT or GW	L/R	CF	+
Hew Saw	PI-518	316	4,0	3,5–6,9	70	27	GM	L/R	CF	+
Hew Saw	PI-518	316	4,0	3,5–6,9	70	27	GT or GW	L/R	CF	+
Hew Saw	PI-518	345	3,8	2,9–10,7	144,2	36	GM	L/R	CF, KP	+
Hew Saw	PI-518	345	4,1	3,2–10,7	144,2	36	GM	L/R	CF, KP	+
Hew Saw	PI-518	345	4,5	3,6–10,7	144,2	36	GM	L/R	CF, KP	+
Hew Saw	PI-518	390	4,1	3,3–8,7	190	39	GM	L/R	CF, KP	+
Hew Saw	PI-518	390	4,3	3,3–8,7	190	39	GM	L/R	CF, KP	+
Hew Saw	PI-518	390	5,3	4,3–8,7	190	39	GM	L/R	CF, KP	+
Hew Saw	PI-518	460	4,0	3,1–8,7	240	42	GM	L/R	CF, KP	+
Hew Saw	PI-518	460	4,1	3,1–8,7	240	42	GM	L/R	CF, KP	+
Hew Saw	PI-518	460	4,5	3,3–8,7	240	42	GM	L/R	CF, KP	+

CF – with or without chip flow

KP – with or without special knives pockets

Recessed ring-saw blades



Recessed ring-saw blades with straight teeth (GM) and hard, properly chosen carbide or stellite tips, with wiper knives, designed for pre-sawing wood on high-efficiency automatic machines such as Ari/Heinola, AriVislanda, Söderhamn, Iggesund and others.

Special construction of the saw blade with properly directed chip flow achieved by shaping the gullet guarantees high work efficiency of the blades and, at the same time, minimizing waste by optimizing kerf thickness in spite of large diameters.

Type of cut: longitudinal.

Material: solid wet wood (soft and hard), frozen wood.



GM



Machine	D mm	B mm	b-b ₁ mm	d mm	z				
Söderhamn	625	4,0	3,2-6,0	480	48	GM	L/R	CF	+
Söderhamn	625	4,8	3,2-6,0	480	48	GM	L/R	CF	+
Söderhamn	650	4,0	3,2-6,0	480	48	GM	L/R	CF	+
Ari / Vislanda	660	3,7	2,5-7,0	460	60	GM	L/R	CF	+
Ari / Vislanda	660	4,1	3,0-7,0	460	60	GM	L/R	CF	+
Ari / Vislanda	660	4,5	3,5-7,0	460	60	GM	L/R	CF	+
Söderhamn	660	4,8	4,0-6,0	480	48	GM	L/R	CF	+
Ari / Vislanda	660	5,5	4,0-7,0	460	60	GM	L/R	CF	+
Söderhamn	710	4,4	3,3-6,0	560	64	GM	L/R	CF	+
Söderhamn	710	4,5	3,5-6,0	560	64	GM	L/R	CF	+
Söderhamn	720	4,0	3,2-6,0	560	60	GM	L/R	CF	+
Igesund	720	4,1	3,2-7,0	520	60	GM	L/R	CF	+
Ari / Heinola	720	5,6	4,0-7,0	460	72	GM	L/R	CF	+
Söderhamn	725	3,9	3,2-6,0	560	60	GM	L/R	CF	+
Söderhamn	725	4,7	3,2-6,0	560	60	GM	L/R	CF	+
Linck	730	4,5	3,5-6,0	586	64	GM	L/R	CF	+
Ari / Heinola	735	4,6	3,6-7,0	460	72	GM	L/R	WCF	+

CF – with or without chip flow

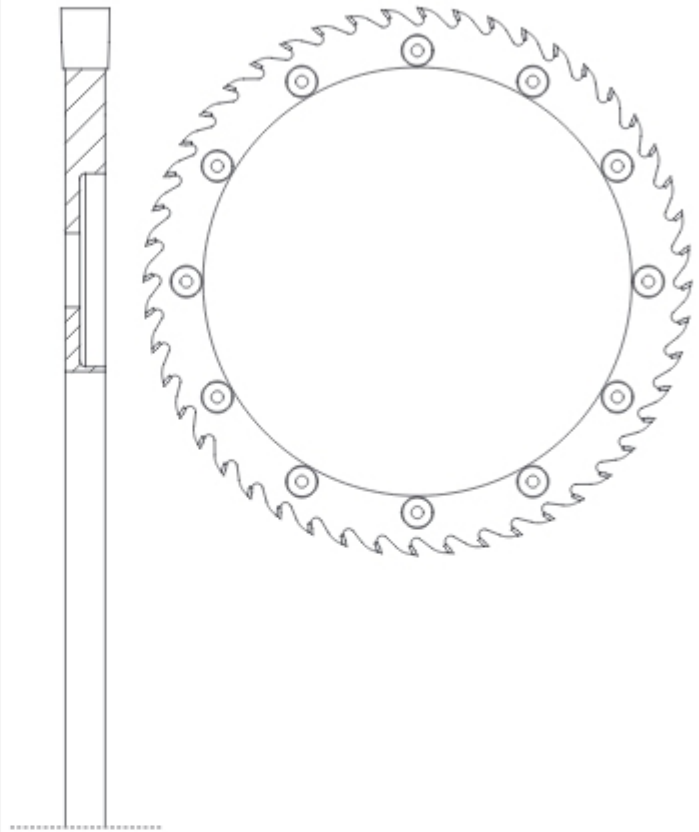
WCF – without chip flow only

Special ring-saw blades with straight teeth (GM) and hard, properly chosen carbide or stellite tips, with wiper knives, designed for pre-sawing wood on high-efficiency automatic sawmill lines.

Type of cut: longitudinal.

Material: solid wet wood (soft and hard), frozen wood.

Ring-saw blades



GM



Machine	D mm	B mm	b mm	d mm	z				
	510	7,0	6,0	320	44	GM	L/R	CF	+
	540	7,3	6,0	320	44	GM	L/R	CF	+
Ari / Vislanda	588	7,5	6,0	460	48	GM	L/R	CF	+
Ari / Vislanda	588	8,4	7,0	460	48	GM	L/R	CF	+
Ari / Vislanda	590	7,0	5,0	460	48	GM	L/R	CF	+
Ari / Vislanda	630	8,4	7,0	460	60	GM	L/R	CF	+
Ari / Slabber	650	7,8	6,6	460	48	GM	L/R	CF	+
Iggesund	650	8,0	7,0	520	60	GM	L/R	CF	+
Söderhamn	680	6,5	5,0	560	56	GM	L/R	CF	+
Söderhamn	700	8,4	6,0	560	60	GM	L/R	CF	+

CF – with or without chip flow