

DIN-HSS-SAW BLADES



DIN-HSS

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CONTACT

ATA
IDA Business & Technology Park,
Killygarry, Cavan, Co. Cavan,
H12 DK46,
Ireland

Tel: +353 49 435 2138
Fax: +353 49 432 6298
Email: ask@atagroup.ie

atagroup.com

ONLINE



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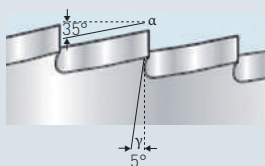
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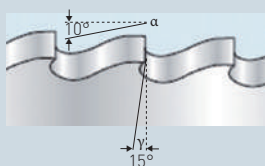
5 5000**A**

DIN 1837A blades comes with fine teeth and tooth shape form A.

Main field of application:

- This shape is mostly used for fine slotting and cutting works (micro-mechanics and jewellery).
- Excellent also for screw slotting.
- For cutting and slotting thin walled profiles and short chipping work pieces made of steel, cast iron, non ferrous metals, plastics.

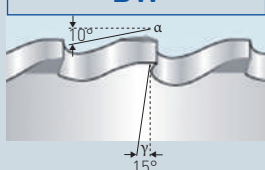
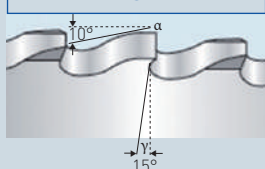
Maximum recommended cutting depth approx. 3 mm

5 5001**B**

DIN 1838B blades comes with rough teeth and tooth form B.

Main field of application:

- The most widely used universal toothing for slotting and cutting thick walled profiles and solid material **from 3 mm**.
- In general for cutting long chipping work pieces made of steel, cast iron, non ferrous metals.

5 5002**BW****C**

DIN 1838C blades comes with rough teeth and tooth form B additionally, depending on the diameter, alternative top beveled (tooth shape BW) or with precut and finishing cut tooth (tooth shape C).

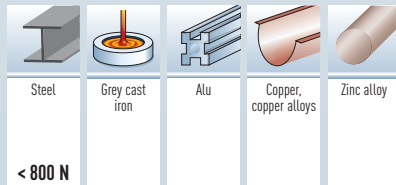
This tooth forms reduce cutting forces and thus allow a significantly increased cutting performance compared to DIN 1838B

Main field of application:

- For slotting and cutting thick, up to very thick profiles from 3 mm.
- Especially excellent for cutting solid material **from 3 mm**.
- In general for slotting and cutting long chipping work pieces made of steel, cast iron, non ferrous metals.



APPLICATION



Metal-circular saw blades according DIN 1840, type N are for medium hard metals and steels up to 800 N/mm². For particularly tough and hard and tough materials we recommend type 'H' (Price and delivery time on request). For very soft and tough materials we recommend type 'W' (Price and delivery time on request).

Recommended cutting data for HSS-DIN 1840 Typ 'N' circular saws

Materials		V _c (m/min) Cutting speed	f _z (mm/z) Feed per tooth
Steel	< 500 N/mm ²	25 - 50	0.02 - 0.04
	< 800 N/mm ²	15 - 30	0.02 - 0.03
Cast Iron		15 - 25	0.02 - 0.05
Aluminium Solid		400 - 800	0.03 - 0.10
Aluminium Profile		800 - 1600	0.02 - 0.05
Bronze		200 - 400	0.02 - 0.06
Copper		160 - 200	0.02 - 0.05
Brass		200 - 400	0.02 - 0.04
Zinc Alloy		30 - 100	0.02 - 0.08

Determination of cutting speed V_c

$$V_c \text{ (m/min)} = \frac{D \cdot \pi \cdot n}{1000}$$

Determination of feed rate V_f

$$V_f \text{ (mm/min)} = f_z \cdot n \cdot Z$$

Determination of revolution speed n

$$n \text{ (min}^{-1}\text{)} = \frac{V_c \cdot 1000}{D \cdot \pi}$$

f_z (mm/z) = Feed per tooth
 D (mm) = Saw blade diameter
 Z = Number of teeth
 n (min⁻¹) = rpm

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				Art.	DIN 1837A	Art.	DIN 1838B	Art.	DIN 1838C
				5 5000		5 5001		5 5002	
Ø	Thickness	Bore	Hub		'A'		'B'		'BW' 'C'
20	0.20	5	10	% 5 5000 020 020	80 A	-	-	-	-
20	0.30	5	10	• 5 5000 020 030	64 A	-	-	-	-
20	0.40	5	10	-	-	-	-	-	-
20	0.50	5	10	• 5 5000 020 050	48 A	-	-	-	-
20	0.60	5	10	% 5 5000 020 060	48 A	-	-	-	-
20	0.80	5	10	% 5 5000 020 080	48 A	-	-	-	-
20	1.00	5	10	• 5 5000 020 100	40 A	-	-	-	-
20	1.20	5	10	% 5 5000 020 120	40 A	-	-	-	-
20	1.60	5	10	% 5 5000 020 160	40 A	-	-	-	-
20	2.00	5	10	• 5 5000 020 200	32 A	-	-	-	-
20	2.50	5	10	% 5 5000 020 250	32 A	-	-	-	-
20	3.00	5	10	% 5 5000 020 300	32 A	-	-	-	-
20	4.00	5	10	% 5 5000 020 400	24 A	-	-	-	-
25	0.20	8	12	• 5 5000 025 020	80 A	-	-	-	-
25	0.25	8	12	% 5 5000 025 025	80 A	-	-	-	-
25	0.30	8	12	% 5 5000 025 030	80 A	-	-	-	-
25	0.40	8	12	% 5 5000 025 040	64 A	-	-	-	-
25	0.50	8	12	% 5 5000 025 050	64 A	-	-	-	-
25	0.60	8	12	• 5 5000 025 060	64 A	-	-	-	-
25	0.80	8	12	• 5 5000 025 080	48 A	-	-	-	-
25	1.00	8	12	• 5 5000 025 100	48 A	-	-	-	-
25	1.20	8	12	-	-	-	-	-	-
25	1.60	8	12	% 5 5000 025 160	40 A	-	-	-	-
25	2.00	8	12	% 5 5000 025 200	40 A	-	-	-	-
25	2.50	8	12	% 5 5000 025 250	40 A	-	-	-	-
25	3.00	8	12	% 5 5000 025 300	32 A	-	-	-	-
25	4.00	8	12	-	-	-	-	-	-
25	5.00	8	12	% 5 5000 025 500	32 A	-	-	-	-
25	6.00	8	12	% 5 5000 025 600	24 A	-	-	-	-
32	0.20	8	14	% 5 5000 032 020	100 A	-	-	-	-
32	0.25	8	14	% 5 5000 032 025	100 A	-	-	-	-
32	0.30	8	14	% 5 5000 032 030	80 A	-	-	-	-
32	0.40	8	14	% 5 5000 032 040	80 A	-	-	-	-
32	0.50	8	14	-	-	-	-	-	-
32	0.60	8	14	% 5 5000 032 060	64 A	-	-	-	-
32	0.80	8	14	% 5 5000 032 080	64 A	-	-	-	-
32	1.00	8	14	-	-	-	-	-	-
32	1.20	8	14	% 5 5000 032 120	48 A	-	-	-	-
32	1.60	8	14	• 5 5000 032 160	48 A	-	-	-	-
32	2.00	8	14	• 5 5000 032 200	48 A	-	-	-	-
32	2.50	8	14	• 5 5000 032 250	40 A	-	-	-	-
32	3.00	8	14	• 5 5000 032 300	40 A	-	-	-	-
32	4.00	8	14	% 5 5000 032 400	40 A	-	-	-	-
32	5.00	8	14	% 5 5000 032 500	32 A	-	-	-	-
32	6.00	8	14	-	-	-	-	-	-
40	0.20	10	18	% 5 5000 040 020	128 A	-	-	-	-
40	0.25	10	18	% 5 5000 040 025	100 A	-	-	-	-
40	0.30	10	18	-	-	-	-	-	-
40	0.40	10	18	% 5 5000 040 040	100 A	-	-	-	-
40	0.50	10	18	• 5 5000 040 050	80 A	-	-	-	-
40	0.60	10	18	• 5 5000 040 060	80 A	-	-	-	-
40	0.80	10	18	% 5 5000 040 080	80 A	-	-	-	-
40	1.00	10	18	• 5 5000 040 100	64 A	-	-	-	-
40	1.20	10	18	• 5 5000 040 120	64 A	-	-	-	-

% Sale item. While stocks last.

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CONTACT INFORMATION

For more information please call +353 49 435 2138 or send an email to ask@atagroup.ie

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				1242		1242		1242	
				Art. 5 5000	DIN 1837A  'A'	Art. 5 5001	DIN 1838B  'B'	Art. 5 5002	DIN 1838C  'BW' 'C'
Ø	Thickness	Bore	Hub						
40	1.60	10	18	• 5 5000 040 160	64 A	-	-	-	-
40	2.00	10	18	• 5 5000 040 200	48 A	-	-	-	-
40	2.50	10	18	% 5 5000 040 250	48 A	-	-	-	-
40	3.00	10	18	-	-	-	-	-	-
40	4.00	10	18	-	-	-	-	-	-
40	5.00	10	18	% 5 5000 040 500	40 A	-	-	-	-
40	6.00	10	18	% 5 5000 040 600	40 A	-	-	-	-
50	0.20	13	32	% 5 5000 050 020	128 A	-	-	-	-
50	0.30	13	25	-	-	-	-	-	-
50	0.40	13	25	% 5 5000 050 040	100 A	-	-	-	-
50	0.50	13	25	• 5 5000 050 050	100 A	% 5 5001 050 050	48 B	-	-
50	0.60	13	25	• 5 5000 050 060	100 A	% 5 5001 050 060	48 B	-	-
50	0.80	13	25	• 5 5000 050 080	80 A	• 5 5001 050 080	40 B	-	-
50	1.00	13	25	• 5 5000 050 100	80 A	• 5 5001 050 100	40 B	% 5 5002 050 100	40 BW
50	1.20	13	25	• 5 5000 050 120	80 A	% 5 5001 050 120	40 B	% 5 5002 050 120	40 BW
50	1.60	13	25	• 5 5000 050 160	64 A	% 5 5001 050 160	32 B	% 5 5002 050 160	32 BW
50	2.00	13	25	• 5 5000 050 200	64 A	-	-	% 5 5002 050 200	32 BW
50	2.50	13	25	% 5 5000 050 250	64 A	% 5 5001 050 250	32 B	% 5 5002 050 250	32 C
50	3.00	13	25	-	-	% 5 5001 050 300	24 B	% 5 5002 050 300	24 C
50	4.00	13	25	• 5 5000 050 400	48 A	% 5 5001 050 400	24 B	% 5 5002 050 400	24 C
50	5.00	13	25	% 5 5000 050 500	48 A	% 5 5001 050 500	24 B	% 5 5002 050 500	24 C
50	6.00	13	25	% 5 5000 050 600	40 A	% 5 5001 050 600	20 B	% 5 5002 050 600	20 C
63	0.25	16	32	-	-	-	-	-	-
63	0.30	16	32	-	-	-	-	-	-
63	0.40	16	32	% 5 5000 063 040	128 A	-	-	-	-
63	0.50	16	32	• 5 5000 063 050	128 A	• 5 5001 063 050	64 B	-	-
63	0.60	16	32	• 5 5000 063 060	100 A	% 5 5001 063 060	48 B	-	-
63	0.80	16	32	• 5 5000 063 080	100 A	• 5 5001 063 080	48 B	-	-
63	1.00	16	32	• 5 5000 063 100	100 A	% 5 5001 063 100	48 B	% 5 5002 063 100	48 BW
63	1.20	16	32	% 5 5000 063 120	80 A	% 5 5001 063 120	40 B	% 5 5002 063 120	40 BW
63	1.50	16	32	• 5 5000 063 150	80 A	-	-	-	-
63	1.60	16	32	• 5 5000 063 160	80 A	• 5 5001 063 160	40 B	% 5 5002 063 160	40 BW
63	2.00	16	32	• 5 5000 063 200	80 A	% 5 5001 063 200	40 B	% 5 5002 063 200	40 BW
63	2.50	16	32	• 5 5000 063 250	64 A	% 5 5001 063 250	32 B	% 5 5002 063 250	32 C
63	3.00	16	32	• 5 5000 063 300	64 A	% 5 5001 063 300	32 B	-	-
63	4.00	16	32	-	-	% 5 5001 063 400	32 B	% 5 5002 063 400	32 BW
63	5.00	16	32	% 5 5000 063 500	48 A	% 5 5001 063 500	24 B	% 5 5002 063 500	32 BW
63	6.00	16	32	-	-	% 5 5001 063 600	24 B	% 5 5002 063 600	24 C
80	0.30	22	36	• 5 5000 080 030	160 A	-	-	-	-
80	0.40	22	36	• 5 5000 080 040	160 A	-	-	-	-
80	0.50	22	36	• 5 5000 080 050	128 A	• 5 5001 080 050	64 B	-	-
80	0.60	22	36	• 5 5000 080 060	128 A	% 5 5001 080 060	64 B	-	-
80	0.80	22	36	• 5 5000 080 080	128 A	-	-	-	-
80	1.00	22	36	• 5 5000 080 100	100 A	• 5 5001 080 100	48 B	% 5 5002 080 100	48 BW
80	1.20	22	36	• 5 5000 080 120	100 A	% 5 5001 080 120	48 B	% 5 5002 080 120	48 BW
80	1.50	22	36	• 5 5000 080 150	100 A	-	-	-	-
80	1.60	22	36	• 5 5000 080 160	100 A	• 5 5001 080 160	48 B	-	-
80	2.00	22	36	• 5 5000 080 200	80 A	• 5 5001 080 200	40 B	% 5 5002 080 200	40 BW
80	2.50	22	36	• 5 5000 080 250	80 A	• 5 5001 080 250	40 B	% 5 5002 080 250	40 C
80	3.00	22	36	• 5 5000 080 300	80 A	% 5 5001 080 300	40 B	% 5 5002 080 300	40 BW
80	4.00	22	36	• 5 5000 080 400	64 A	-	-	% 5 5002 080 400	32 BW
80	5.00	22	36	% 5 5000 080 500	64 A	% 5 5001 080 500	32 B	% 5 5002 080 500	32 BW
80	6.00	22	36	% 5 5000 080 600	64 A	% 5 5001 080 600	32 B	% 5 5002 080 600	32 C
100	0.50	22	40	• 5 5000 100 050	160 A	• 5 5001 100 050	80 B	-	-

% Sale item. While stocks last.



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				Art.	DIN 1837A	Art.	DIN 1838B	Art.	DIN 1838C
				5 5000	 'A'	5 5001	 'B'	5 5002	 'BW' 'C'
100	0.60	22	40	• 5 5000 100 060	160 A	• 5 5001 100 060	80 B	-	-
100	0.80	22	40	• 5 5000 100 080	128 A	• 5 5001 100 080	64 B	-	-
100	1.00	22	40	• 5 5000 100 100	128 A	• 5 5001 100 100	64 B	% 5 5002 100 100	64 BW
100	1.20	22	40	% 5 5000 100 120	128 A	% 5 5001 100 120	64 B	% 5 5002 100 120	64 BW
100	1.50	22	40	-	-	-	-	-	-
100	1.60	22	40	-	-	% 5 5001 100 160	48 B	% 5 5002 100 160	48 BW
100	2.00	22	40	• 5 5000 100 200	100 A	• 5 5001 100 200	48 B	% 5 5002 100 200	48 BW
100	2.50	22	40	% 5 5000 100 250	100 A	-	-	% 5 5002 100 250	48 BW
100	3.00	22	40	• 5 5000 100 300	80 A	% 5 5001 100 300	40 B	% 5 5002 100 300	40 BW
100	4.00	22	40	• 5 5000 100 400	80 A	• 5 5001 100 400	40 B	% 5 5002 100 400	40 BW
100	5.00	22	40	% 5 5000 100 500	80 A	% 5 5001 100 500	40 B	% 5 5002 100 500	40 BW
100	6.00	22	40	-	-	% 5 5001 100 600	32 B	% 5 5002 100 600	32 BW
125	0.60	22	40	% 5 5000 125 060	160 A	• 5 5001 125 060	80 B	-	-
125	0.80	22	40	• 5 5000 125 080	160 A	% 5 5001 125 080	80 B	-	-
125	1.00	22	40	• 5 5000 125 100	160 A	• 5 5001 125 100	80 B	% 5 5002 125 100	80 BW
125	1.20	22	40	• 5 5000 125 120	128 A	• 5 5001 125 120	64 B	% 5 5002 125 120	64 BW
125	1.60	22	40	• 5 5000 125 160	128 A	% 5 5001 125 160	64 B	% 5 5002 125 160	64 BW
125	2.00	22	40	• 5 5000 125 200	128 A	• 5 5001 125 200	64 B	% 5 5002 125 200	64 BW
125	2.50	22	40	• 5 5000 125 250	100 A	% 5 5001 125 250	48 B	% 5 5002 125 250	48 BW
125	3.00	22	40	• 5 5000 125 300	100 A	% 5 5001 125 300	48 B	-	-
125	4.00	22	40	• 5 5000 125 400	100 A	% 5 5001 125 400	48 B	% 5 5002 125 400	48 BW
125	5.00	22	40	% 5 5000 125 500	80 A	% 5 5001 125 500	40 B	% 5 5002 125 500	40 BW
125	6.00	22	40	% 5 5000 125 600	80 A	% 5 5001 125 600	40 B	% 5 5002 125 600	40 BW
160	1.00	32	63	• 5 5000 160 100	160 A	• 5 5001 160 100	80 B	% 5 5002 160 100	80 C
160	1.20	32	63	• 5 5000 160 120	160 A	• 5 5001 160 120	80 B	% 5 5002 160 120	80 C
160	1.60	32	63	• 5 5000 160 160	160 A	• 5 5001 160 160	80 B	% 5 5002 160 160	80 C
160	2.00	32	63	• 5 5000 160 200	128 A	% 5 5001 160 200	64 B	% 5 5002 160 200	64 C
160	2.50	32	63	-	-	% 5 5001 160 250	64 B	% 5 5002 160 250	64 C
160	3.00	32	63	• 5 5000 160 300	128 A	% 5 5001 160 300	64 B	% 5 5002 160 300	64 C
160	4.00	32	63	% 5 5000 160 400	100 A	% 5 5001 160 400	48 B	-	-
160	5.00	32	63	% 5 5000 160 500	100 A	% 5 5001 160 500	48 B	% 5 5002 160 500	48 C
160	6.00	32	63	% 5 5000 160 600	100 A	-	-	% 5 5002 160 600	48 C
200	1.00	32	63	% 5 5000 200 100	200 A	% 5 5001 200 100	100 B	% 5 5002 200 100	100 C
200	1.20	32	63	% 5 5000 200 120	200 A	• 5 5001 200 120	100 B	% 5 5002 200 120	100 C
200	1.60	32	63	• 5 5000 200 160	160 A	% 5 5001 200 160	80 B	% 5 5002 200 160	80 C
200	2.00	32	63	% 5 5000 200 200	160 A	% 5 5001 200 200	80 B	% 5 5002 200 200	80 C
200	2.50	32	63	% 5 5000 200 250	160 A	% 5 5001 200 250	80 B	% 5 5002 200 250	80 C
200	3.00	32	63	% 5 5000 200 300	128 A	% 5 5001 200 300	64 B	% 5 5002 200 300	64 C
200	4.00	32	63	% 5 5000 200 400	128 A	% 5 5001 200 400	64 B	% 5 5002 200 400	64 C
200	5.00	32	63	% 5 5000 200 500	128 A	% 5 5001 200 500	64 B	% 5 5002 200 500	64 C
200	6.00	32	63	% 5 5000 200 600	100 A	% 5 5001 200 600	48 B	% 5 5002 200 600	48 C
250	1.60	32	63	-	-	-	-	% 5 5002 250 160	100 C
250	2.00	32	63	-	-	-	-	% 5 5002 250 200	100 C
250	2.50	32	63	% 5 5000 250 250	160 A	-	-	-	-
250	3.00	32	63	% 5 5000 250 300	160 A	-	-	% 5 5002 250 300	80 C
250	4.00	32	63	-	-	% 5 5001 250 400	80 B	-	-
250	5.00	32	63	% 5 5000 250 500	128 A	% 5 5001 250 500	64 B	-	-
250	6.00	32	63	% 5 5000 250 600	128 A	% 5 5001 250 600	64 B	-	-
315	2.50	40	80	-	-	-	-	-	-
315	3.00	40	80	% 5 5000 315 300	200 A	-	-	-	-
315	4.00	40	80	-	-	-	-	-	-
315	5.00	40	80	% 5 5000 315 500	160 A	-	-	% 5 5002 315 500	-
315	6.00	40	80	-	-	-	-	-	-

% Sale item. While stocks last.

