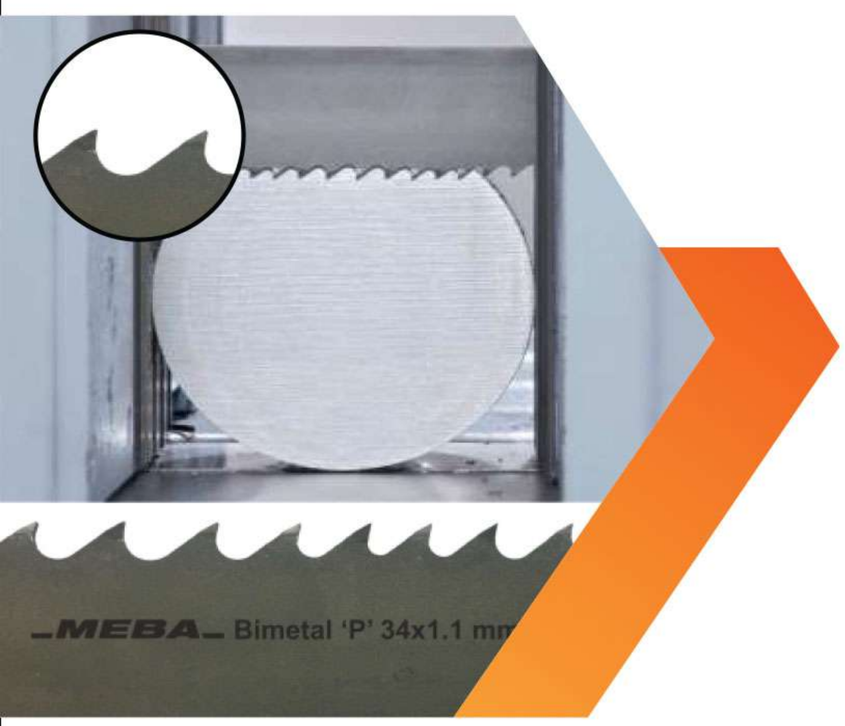
MEBA
sawing solutions.

RELIABLE ENGINEERING STORES
Work-holding Specialist

MEBA

BANDSAW BLADES

WE BUILD TO CUT YOUR COST



MEBA Bi-Metal P

M42

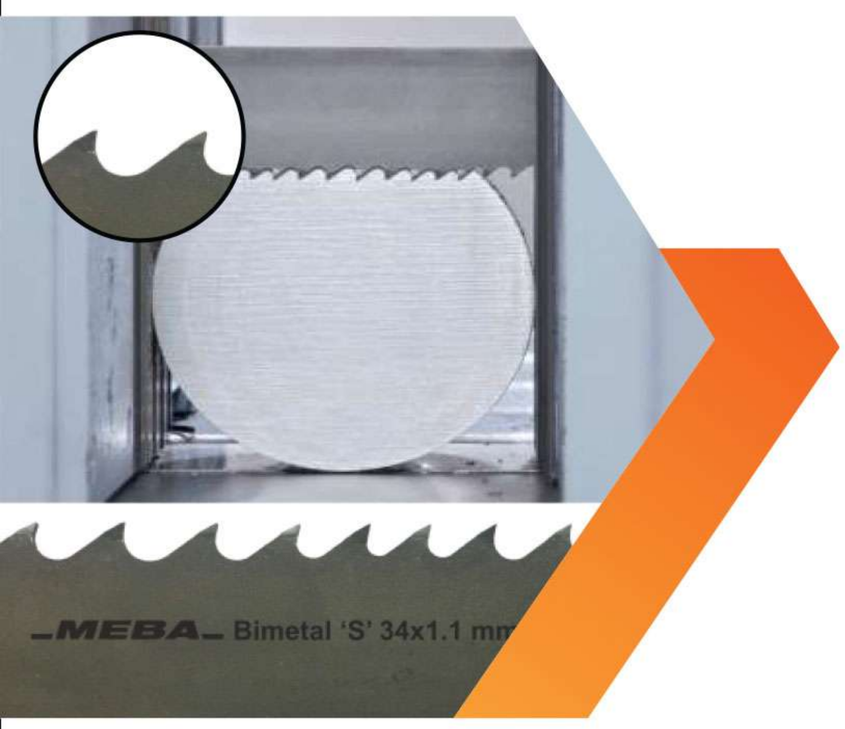
Non-ferrous metals-Aluminum, copper, brass.
Structural steel-columns, angles, I beam.
Steels-Low & medium carbon steel.

ADVANTAGES : **General Purpose Grade**

AREAS OF APPLICATION : SOLID MATERIAL | SOLID BUNDLE

PRODUCT FEATURES : STANDARD TOOTH

PRODUCT ADVANTAGES : UNIVERSALLY APPLICABLE



MEBA Bi-Metal S

M42

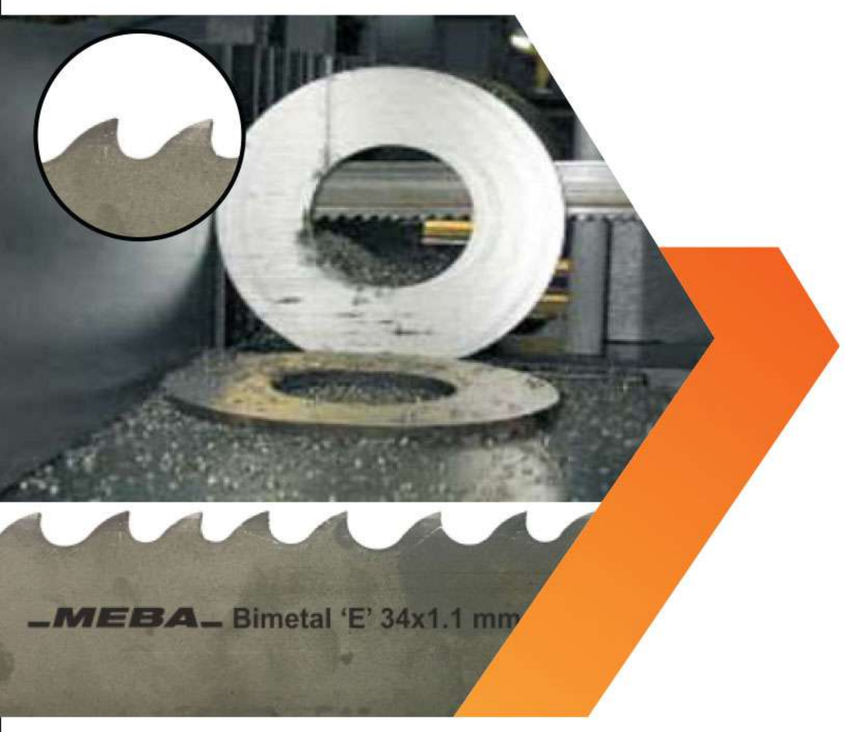
Non-ferrous metals-Aluminum, copper, brass.
Structural steel-columns, angles, I beam.
Steels-Low & medium carbon steel.

ADVANTAGES : **Increase Cutting Accuracy and Wearability**

AREAS OF APPLICATION : SOLID MATERIAL | SOLID BUNDLE

PRODUCT FEATURES : STANDARD TOOTH

PRODUCT ADVANTAGES : UNIVERSALLY APPLICABLE



MEBA Bi-Metal E Plus

M42

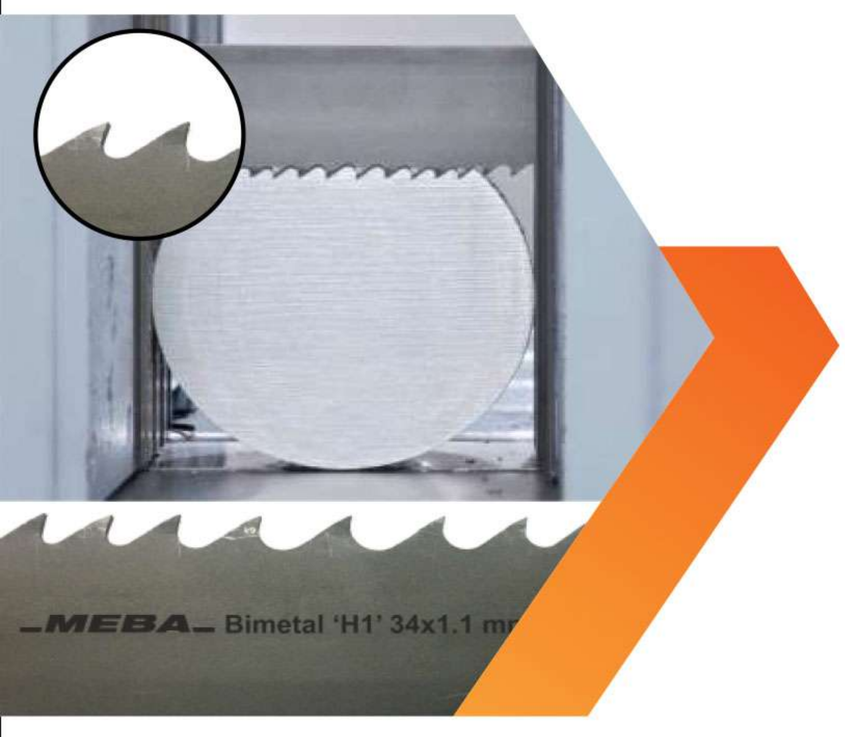
Structural steel-columns, angles, C channel, I beam.
Steels-Alloy steels, low & medium carbon steel.

ADVANTAGES : **For profiles and bundle cuts.**
For small and often changing workpiece dimensions

AREAS OF APPLICATION : TUBES AND PROFILES | SOLID BUNDLE

PRODUCT FEATURES : HOOK TOOTH

PRODUCT ADVANTAGES : COST REDUCTION | UNIVERSALLY APPLICABLE



MEBA Bi-Metal H1

M42

Ferrous & Non-Ferrous metals-Aluminum, copper, brass, steel. Steels-Alloy steels, high carbon steel

ADVANTAGES : **General Purpose Grade**

AREAS OF APPLICATION : SOLID MATERIAL | BEAMS | SOLID BUNDLE

PRODUCT FEATURES : STANDARD TOOTH

PRODUCT ADVANTAGES : UNIVERSALLY APPLICABLE

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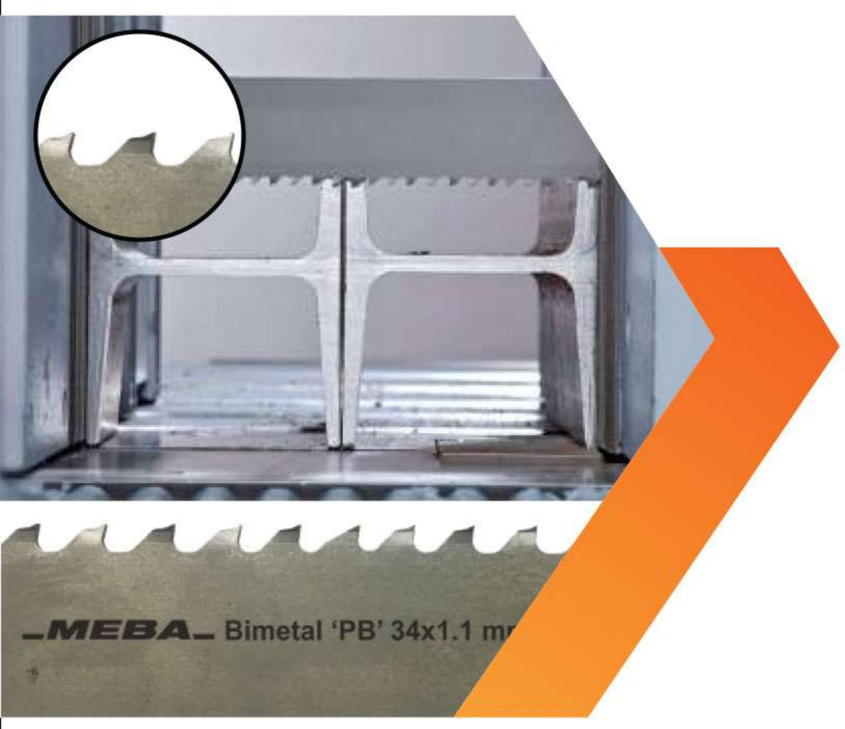


MEBA Bi-Metal PB

M42

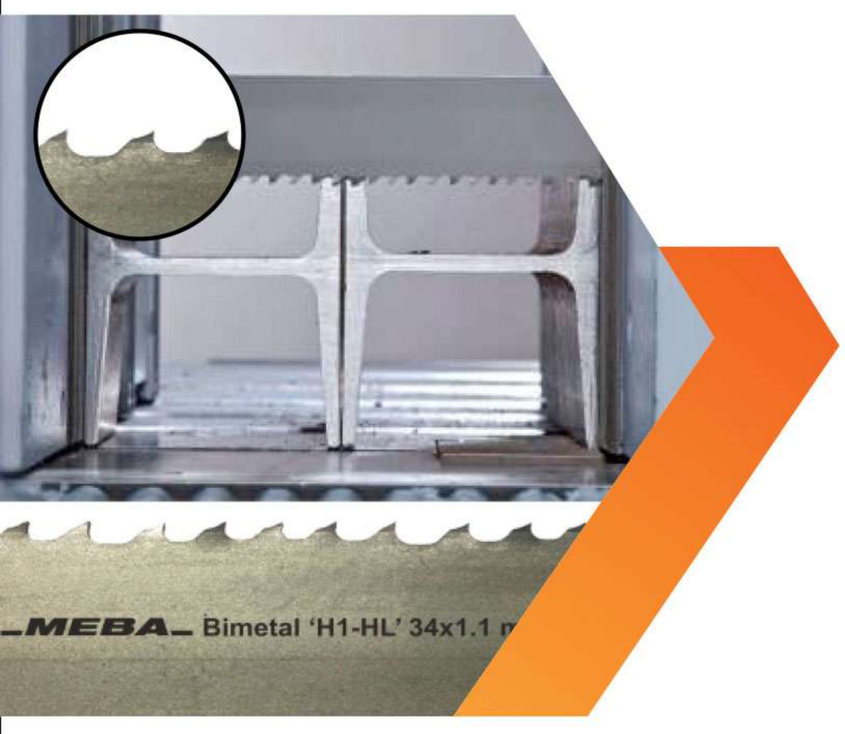
Structural steel-columns, angles, C channel, I beam.
Steels-Alloy steels, low & medium carbon steel.

ADVANTAGES : High tool life at cutting of hollow Sections & bad supported I-beam for bundle cuts, H-beams

AREAS OF APPLICATION : BEAMS, TUBES & PROFILES

PRODUCT FEATURES : REINFORCED HOOK TOOTH, SETTING

PRODUCT ADVANTAGES : VIBRATION & NOISE REDUCTION, WEAR RESISTANCE, COST REDUCTION



MEBA Bi-Metal H1-HL

M42

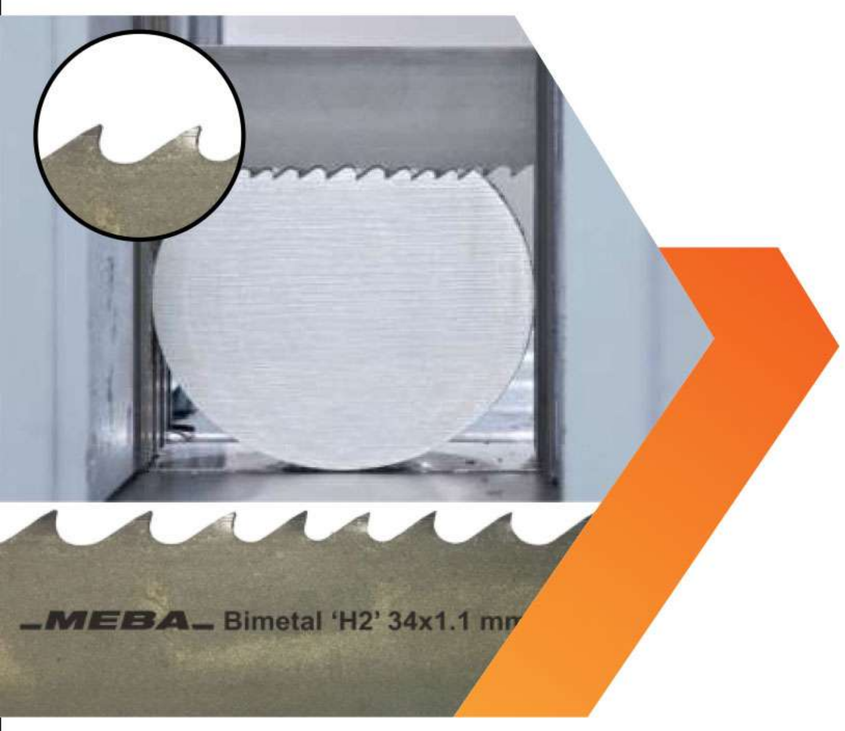
Ferrous & Non-Ferrous metals-Aluminum, copper, Titanium, steel. Cast Iron-Grey cast iron wrought iron Steels-Alloy steels, high carbon steel.

ADVANTAGES : Specially developed positive tooth Profile for sawing more easily with Reduced feed force

AREAS OF APPLICATION : SOLID MATERIAL, SOLID BUNDLE

PRODUCT FEATURES : GROUNDED TOOTH

PRODUCT ADVANTAGES : PERFORMANCE, PRECISION, COST REDUCTION



MEBA Bi-Metal H2

M51

Ferrous & Non-Ferrous metals-Aluminum, copper, titanium, steel. Cast iron-grey cast iron, white cast iron, wrought iron Steels-Alloy steels, high carbon steel.

ADVANTAGES : General Purpose Grade

AREAS OF APPLICATION : SOLID MATERIAL, SOLID BUNDLE

PRODUCT FEATURES : STANDARD TOOTH

PRODUCT ADVANTAGES : PERFORMANCE, WEAR RESISTANCE, COST REDUCTION

MEBA Bi-Metal H2-HL

M51

Ferrous metals-Chromium, nickel, titanium, steel. Steels-Alloy steels, low-medium & high carbon steel.

ADVANTAGES : High tool life at cutting of hollow Sections & bad supported I-beam for bundle cuts, H-beams

AREAS OF APPLICATION : SOLID MATERIAL, SOLID BUNDLE

PRODUCT FEATURES : GROUNDED TOOTH

PRODUCT ADVANTAGES : PERFORMANCE, WEAR RESISTANCE, COST REDUCTION

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BANDSAW MACHINES- ROUTINE CHECKS

Check Regularly:

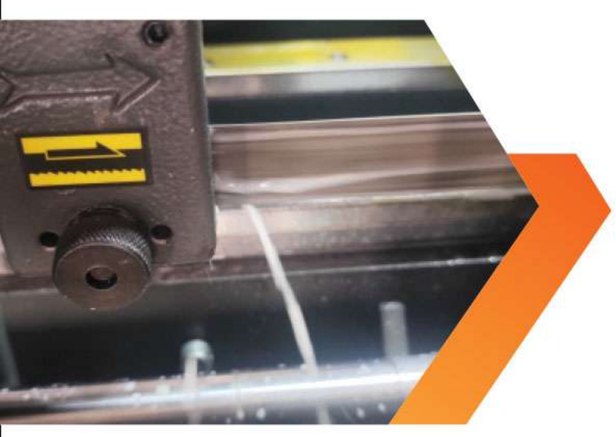
- Proper Working Of Chip Brush
- Coolant Level And Correct Concentration
- Alignment And Wear Condition Of Blade Guides
- Blade Tension (As Per Specification)
- Blade Cutting Speed

COOLANT / CUTTING FLUID

Coolant Helps In Cooling And Chip Removal During Cutting.

Important Points:

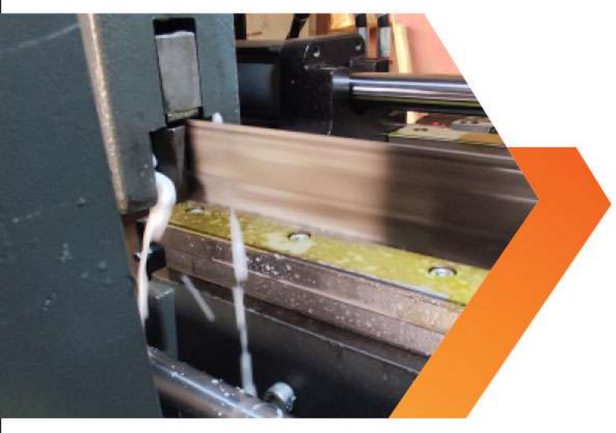
- Use Cutting Fluid Suitable For The Specific Application
- Maintain Recommended Concentration Level



WORKPIECE HANDLING

Important Points:

- Ensure The Workpiece Is Firmly Clamped (No Vibration Or Movement)
- Avoid Using Band Damaged Or Deformed Materials
- Keep Blade Guide As Close As Possible To The Workpiece For Better Accuracy



START-UP GUIDELINES

Important Points:

- Follow Proper Start-up Procedure
- Use Recommended Cutting Parameter For Longer Blade Life

RECOMMENDED TEETH PER INCH (TPI) FOR BANDSAW BLADES

Teeth Per Inch For Solid Material

Cutting in (mm)	TEETH PER INCH (TPI)							
	10/14	8/12	6/10	5/8	4/6	3/4	2/3	1.4/2
0-20	■							
20-50		■						
25-60			■					
35-80				■				
50-100					■			
80-150						■		
120-350							■	
250-600								■

Teeth Per Inch For Angle / Channel / Pipe

D (mm) / S (mm)	TEETH PER INCH (TPI)								
	20	40	60	80	100	150	200	300	500
2	10/14	10/14	10/14	10/14	10/14	10/14	10/14	10/14	8/12
3	10/14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	6/10
4	10/14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	4/6
5	10/14	10/14	10/14	8/12	6/10	6/10	5/8	4/6	4/6
6	10/14	10/14	8/12	8/12	6/10	5/8	5/8	4/6	4/6
8	10/14	8/12	6/10	6/10	6/10	5/8	5/8	4/6	4/6
10		6/10	6/10	5/8	5/8	4/6	4/6	4/6	3/4
12		6/10	5/8	4/6	4/6	4/6	4/6	3/4	3/4
15				4/6	4/6	3/4	3/4	3/4	2/3
20				4/6	4/6	3/4	3/4	3/4	2/3
30				3/4	3/4	3/4	2/3	2/3	2/3
50						2/3	2/3	2/3	1.4/2
75							2/3	1.4/2	1.4/2
100								1.4/2	1.4/2

When you clamp 2 or more tubes placed side by side, use above list with the double wall thickness (S).

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