

# MARATHON<sup>®</sup> M42

The All-Rounder for Small and Large Cross Sections



Product level 2

Hook tooth

Solid materials

Band width 13 x 0.65 - 80 x 1.6mm

Band width 1/2 x 0.025 - 3-1/8 x 0.063 Inch

## Product Information

### MARATHON<sup>®</sup> M42 – The All-Rounder for Small and Large Cross Sections

The MARATHON<sup>®</sup> M42 is the epitome of the economical band saw blade and stands for a broad application spectrum with consistently high quality.

The bimetal band saw blade for service-oriented customers is optimized for more complex performance and support requirements in the sawing process, such as those required for industrial applications.

The high quality features of MARATHON<sup>®</sup> M42 are now even more flexible in applications thanks to the expansion of the product line and are thus available for small cross-sections up to large solid materials.

The superfinishing of the band saw blade and the sharp cutting edges increase the blade-life and improve the quality of the cut. The fine band surface protects the machine's guides and increases fatigue strength.

### Application Range

#### Application

- Industrial applications

- Medium-sized to large work pieces
- All metals up to 1000 N/mm<sup>2</sup> tensile strength
- Solid material
- Single, layer and bundle cutting
- Mixed operation

#### Advantages

- Long blade-life and high productivity due to excellent product characteristics
- Less frequent blade changes due to broad application spectrum
- Low noise levels due to highly smooth and quiet running
- Lower material allowances required due to straight cuts
- Reduced post-processing due to finer cutting surface
- Significant costs per cut savings

#### Features

- M42 cutting edge
- Rake angle: positive (hooktooth)
- Constant or variable tooth pitch with standard setting

- High precision in straightness and planeness of the strip

## Technical Data (1/2)

Dimensions		Tooth pitch in tpi					
Width x thickness		variable					
mm	Inch	5 - 8	4 - 6	3 - 4	2 - 3	1.4 - 2	1 - 1.4
13 x 0.65	1/2 x 0.025						
13 x 0.90	1/2 x 0.035						
20 x 0.90	3/4 x 0.035						
20 x 1.10	3/4 x 0.042						
27 x 0.90	1-1/16 x 0.035	K	K	K	K		
34 x 1.10	1-3/8 x 0.042	K	K	K	K	K	
41 x 1.10	1-5/8 x 0.042		K	K	K	K	
41 x 1.30	1-5/8 x 0.050	K	K	K	K	K	
54 x 1.30	2-1/8 x 0.050		K	K	K	K	
54 x 1.60	2-1/8 x 0.063		K	K	K	K	K
67 x 1.60	2-5/8 x 0.063		K	K	K	K	K
80 x 1.60	3-1/8 x 0.063			K	K	K	K
Contact length	[mm]	30-60	50-100	80-160	150-300	250-550	500-1000
	[Inch]	1.2-2.4	2-3.9	3.1-6.3	5.9-11.8	9.8-21.6	19.7-39.4

K = Hook tooth

## Technical Data (2/2)

Dimensions		Tooth pitch in tpi				
Width x thickness		variable	constant			
mm	Inch	0.75 - 1.25	6	4	3	1.25
13 x 0.65	1/2 x 0.025		K	K		
13 x 0.90	1/2 x 0.035		K	K	K	
20 x 0.90	3/4 x 0.035		K	K	K	
20 x 1.10	3/4 x 0.042				K	
27 x 0.90	1-1/16 x 0.035				K	
34 x 1.10	1-3/8 x 0.042					K
41 x 1.10	1-5/8 x 0.042					
41 x 1.30	1-5/8 x 0.050					
54 x 1.30	2-1/8 x 0.050					
54 x 1.60	2-1/8 x 0.063					
67 x 1.60	2-5/8 x 0.063	K				
80 x 1.60	3-1/8 x 0.063	K				
<b>Contact length</b>	<b>[mm] [Inch]</b>	700-1400 27.6-55.1	50-80 2-3.1	80-120 3.1-4.7	120-200 4.7-7.9	300-800 11.8-31.5

K = Hook tooth

## Materials Overview



- Case-hardening steels, spring steels and ball-bearing steels
- Rust-proof and acid-resistant steels (ferretic)
- Nitrided steel, high-speed steel and tool steel
- Construction, deep-drawn and machining steels
- Carbon steels, and quenched and tempered steels
- Cast iron
- Aluminium / aluminium alloys
- Non-ferrous metals