

MARATHON® SW M42

Special design for cutting applications with residual stress materials



Product level 2

Hook tooth

Solid materials and profiles

Band width 34 x 1.1 - 67 x 1.6mm

Band width 1-5/8 x 0.050 - 2-5/8 x 0.063 Inch

Product Information

MARATHON® SW M42 – Special designs for cutting applications with residual stress material

MARATHON® SW M42 has an extra wide set that prevents jamming of the band saw blade when cutting materials with residual stress.

The bimetal band saw blade is particularly impressive for its high performance when sawing solid materials and profiles with residual stresses. The all-rounder for a wide range of applications makes sawing particularly economical.

Special set width SW: The extra wide set achieves the free cut of the band saw blade so that there is more clearance to prevent jamming due to decreasing material residual stress.

Application Range

Application

- Work pieces with residual stress

- Metals up to 1000 N/mm² tensile strength

Advantages

- No jamming in the cutting channel with material residual stresses
- Cost savings due to less frequent blade changes and straight cuts
- Excellent cutting quality due to highly smooth and quiet running
- High performance
- Less post-processing due to low burr formation

Features

- Extra wide set and variable tooth pitch
- M42 tooth edge with positive rake angle
- Insensitive to jamming in the event of residual stresses in the material

Technical Data

Dimensions		Tooth pitch in tpi			
Width x thickness		variable			constant
mm	Inch	4 - 6	3 - 4	2 - 3	1.25
34 x 1.10	1-3/8 x 0.042	K			K
41 x 1.30	1-5/8 x 0.050	K	K	K	
54 x 1.60	2-1/8 x 0.063		K	K	
67 x 1.60	2-5/8 x 0.063		K	K	
Contact length	[mm]	50-100	80-170	150-300	300-800
	[Inch]	2-3.9	3.1-6.7	5.9-11.8	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