

PRIMAR[®] M42

The versatile option in Level-1 for small and medium-sized workpieces



- ⚙️ Product level 1
- 🔪 Standard or hook tooth
- Profiles + Solid materials
- ↕️ Band width 6 x 0.65 - 67 x 1.6mm
Band width 1/4 x 0.025 - 2-5/8 x 0.063 Inch

Product Information

The versatile option in Level-1 for small and medium-sized workpieces

With PRIMAR[®] M42 WIKUS is also setting standards in the bimetal Level-1 segment. The innovative production process guarantees good product properties and a good blade-life - and all of this with a versatile range of applications.

The cost per cut can be reduced, thanks to the high degree of process reliability. As a result of the super-finish, the optimised contours on the tooth cutting edges produce improved cutting surfaces.



Application Range

Applications

- small to medium-sized workpieces
- solids and profiles
- workshops and smaller industrial applications
- all metals up to 1000 N/mm² tensile strength

Features

- M42 tooth edge with customised rake angle
- optimised variable tooth pitch and standard tooth setting

Advantages at a glance



less frequent blade changes

thanks to universal field of application



good blade-life

thanks to new manufacturing processes



low operating noise

thanks to variable tooth pitch



good cutting surface

thanks to precise tooth setting



very good price-performance-ratio

in the Level-1 segment



QR code for ParaMaster[®] APP

When scanning the QR code on the blade with the [ParaMaster[®] App](#), the blade data are transmitted automatically.

Technical Data (1/3)

Dimensions		Tooth pitch in ZpZ					
Width x thickness		variable					
mm	Inch	10-14	8-12	6-10	5-8	4-6	3-4
6 x 0.65	1/4 x 0.025	S					
6 x 0.90	1/4 x 0.035	S					
10 x 0.90	3/8 x 0.035	S					
13 x 0.50	1/2 x 0.020						
13 x 0.65	1/2 x 0.025	S	S	S			
20 x 0.90	3/4 x 0.035	S	S	S	S	K	
27 x 0.90	1-1/16 x 0.035	S	S	S	S	K	K
34 x 1.10	1-3/8 x 0.042		S	S	S	K	K
41 x 1.30	1-5/8 x 0.042					K	K
54 x 1.30	2-1/8 x 0.050						K
54 x 1.60	2-1/8 x 0.063						K
67 x 1.60	2-5/8 x 0.063						
Contact length	[mm]	< 20	10-30	20-50	30-60	50-100	80-170
	[Inch]	< 0.8	0.4-1.2	0.8-2	1.2-2.4	2-3.9	3.1-6.7

S = Standard tooth

K = Hook tooth

K* = Wide set for non-ferrous metals

Technical Data (2/3)

Dimensions		Tooth pitch in ZpZ					
Width x thickness		variable			constant		
mm	Inch	2-3	1.4-2	1-1.4	18	14	6
6 x 0.65	1/4 x 0.025						
6 x 0.90	1/4 x 0.035						K
10 x 0.90	3/8 x 0.035						K
13 x 0.50	1/2 x 0.020					S	
13 x 0.65	1/2 x 0.025					S	
20 x 0.90	3/4 x 0.035				S		
27 x 0.90	1-1/16 x 0.035	K			S	S	
34 x 1.10	1-3/8 x 0.042	K					
41 x 1.30	1-5/8 x 0.042	K	K				
54 x 1.30	2-1/8 x 0.050	K					
54 x 1.60	2-1/8 x 0.063	K	K	K			
67 x 1.60	2-5/8 x 0.063	K	K	K			
Contact length	[mm]	150-300	250-550	500-1000	< 10	< 15	50-80
	[Inch]	5.9-11.8	9.8-21.6	19.7-39.4	< 0.4	< 0.6	2-3.1

S = Standard tooth

K = Hook tooth

K* = Wide set for non-ferrous metals

Technical Data (3/3)

Dimensions		Tooth pitch in ZpZ		
Width x thickness		constant		
mm	Inch	4	3	2
6 x 0.65	1/4 x 0.025			
6 x 0.90	1/4 x 0.035			
10 x 0.90	3/8 x 0.035	K		
13 x 0.50	1/2 x 0.020			
13 x 0.65	1/2 x 0.025			
20 x 0.90	3/4 x 0.035	K*	K*	
27 x 0.90	1-1/16 x 0.035	K*	K*	K*
34 x 1.10	1-3/8 x 0.042		K*	
41 x 1.30	1-5/8 x 0.042			
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			
Contact length	[mm]	80-120	120-200	200-400
	[Inch]	3.1-4.7	4.7-7.9	7.9-15.7

S = Standard tooth

K = Hook tooth

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Materials Overview



- Case-hardened 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