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

PRIMAR® M42 — The versatile tool for small and medium 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 an economical basic solution, PRIMAR® M42 is aimed at cost-conscious customers and is particularly suitable for use in workshops or smaller industrial plants. At the same time, the product offers a particularly favorable price-performance ratio.

An added bonus: PRIMAR® M42 is available in all common dimensions and tooth pitches, allowing the band saw blade to be used in all common band saws.

Applications

- Workshop and lighter industrial applications
- Small to medium cross-sections with diameters up to 900 mm
- Small lot sizes
- Solid materials and profiles

- All metals up to 1000 N/mm² tensile strength

Advantages

- Very good price-performance ratio in the level 1 segment
- Less frequent blade changes due to a wide range of applications and thus less downtime and waiting times
- Good blade-life thanks to new production procedure
- Low noise generation due to variable tooth pitch
- Good cutting surface due to precise set of the teeth

Features

- M42 tooth edge with customised rake angle
- Rake angle: positive (hook tooth)
- Rake angle: 0° (standard tooth)
- Constant or variable tooth pitch with standard setting

Technical Data (1/3)

Dimensions		Tooth pitch in tpi					
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 0.050					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]** **[Inch]**	< 20 < 0.8	10-30 0.4-1.2	20-50 0.8-2	30-60 1.2-2.4	50-100 2-3.9	80-170 3.1-6.7

S = Standard tooth

K = Hook tooth

*Wide set for non-ferrous metals

Technical Data (2/3)

Dimensions		Tooth pitch in tpi					
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	S	K
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 0.050	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]** **[Inch]**	150-300 5.9-11.8	250-550 9.8-21.6	500-1000 19.7-39.4	< 10 < 0.4	< 15 < 0.6	50-80 2-3.1

S = Standard tooth

K = Hook tooth

*Wide set for non-ferrous metals

Technical Data (3/3)

Dimensions		Tooth pitch in tpi		
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 0.050			
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			
Contact length	**[mm]** **[Inch]**	80-120 3.1-4.7	120-200 4.7-7.9	200-400 7.9-15.7

S = Standard tooth

K = Hook tooth

*Wide set for non-ferrous metals

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