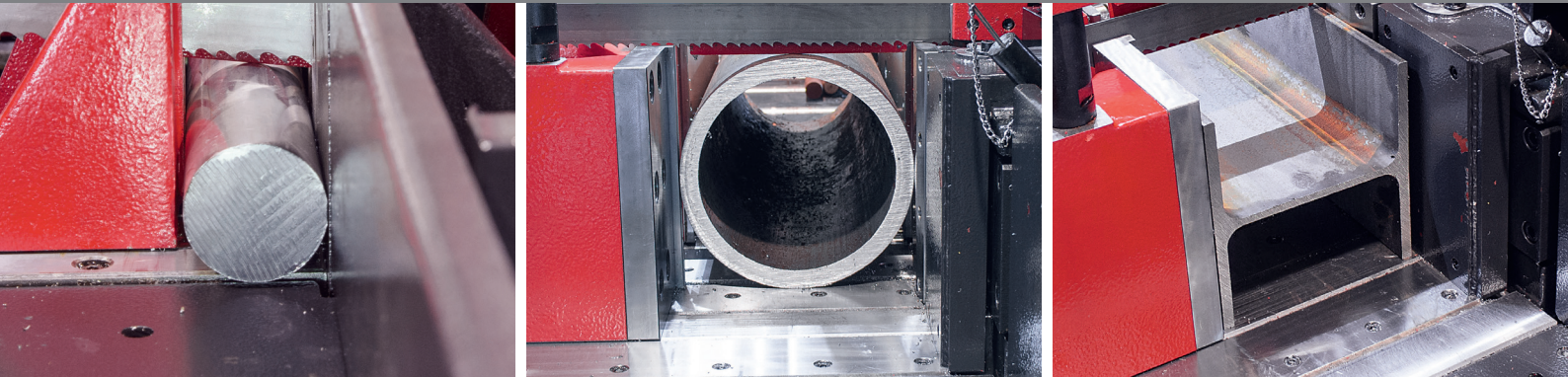


| Bimetal saw blade

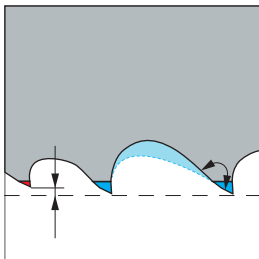
DUOS M42



AMADA MACHINE TOOLS EUROPE



| DUOS M42



Alternating tooth heights und enlarged chip space due to two-stage clearance angle

Developed for light workshop machines.
A wide variety of material can be sawed with high efficiency with the DUOS M42 9/11 toothing without changing the blade.

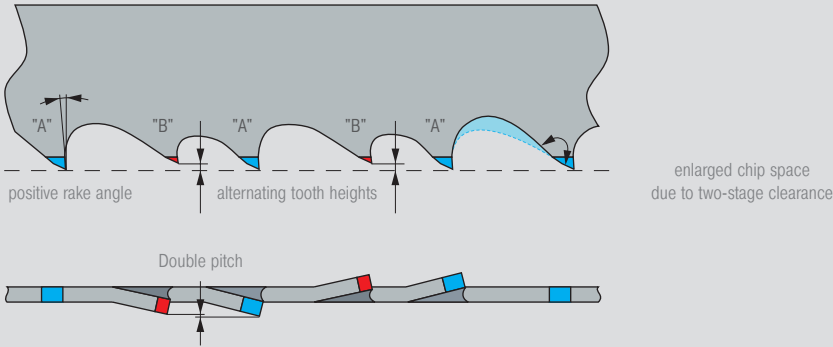
Properties

- special pitch
- different tooth heights
- positive rake angle
- enlarged chip space
- M42 cutting material

Advantages

- sawing a wide size spectrum without changing blades
- aggressive cutting behaviour for solid materials
- improved chip chip removal
- high cutting performance

DUOS M42



Solid material Comparatively small feed
 Only the "A" tooth is in the mesh, therefore effect is the same as coarse tooth pitch.

Profile Comparatively large feed
 "A" and "B" teeth are in the mesh, therefore effect is the same as fine tooth pitch.



Application materials – AMADA DUOS M42

Recommended	Suitable	Limited suitability*
Construction steel, heat-treated steel, cold-worked steel, cast steel	Hot-working steel, stainless steel,	High heat-resisting steel, ball-bearing steel

Construction steel

Heat-treated steel

Cold-worked steel

Hot-working steel

Stainless steel

Cast steel

Selection of the tooth pitch – AMADA DUOS M42 delivery forms

Height	Thickness	9/11
20	0.9	●
27	0.9	●
13	0.65	only as coil

High heat-resisting steel

Ball-bearing steel

Comment:

In the case of materials that cannot be sawed with this toothing, please use the "PROTECTOR M42" with 4/6 teeth per inch or 3/4 teeth per inch.

Recommended run-in time: 15 min

* With respect to application notes, please consult your AMADA sales representative