

# Metal slitting saws

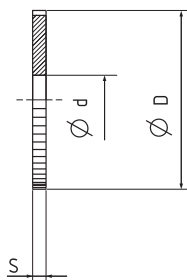


722910

722913

- CZ** Pilové kotouče | na kovy
- DE** Metallkreissägeblätter
- RU** Фрезы отрезные

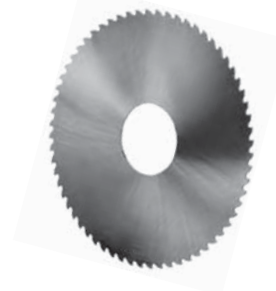
	Material	a <sub>q</sub>	v <sub>c</sub>	f <sub>z</sub>
P.1	≤ 600 N/mm <sup>2</sup>	1xS	25 - 50	0,03 - 0,06
P.2	≤ 850 N/mm <sup>2</sup>	1xS	15 - 30	0,03 - 0,04
P.3	≤ 1100 N/mm <sup>2</sup>	1xS	10 - 15	0,02 - 0,03
P.4	≤ 900 N/mm <sup>2</sup>	1xS	10 - 20	0,02 - 0,03
P.5	≤ 1100 N/mm <sup>2</sup>	1xS	10 - 15	0,02 - 0,03
P.6	> 1100 N/mm <sup>2</sup>	1xS	5 - 10	0,01 - 0,03
K.1	≤ 820 N/mm <sup>2</sup>	1xS	15 - 25	0,04 - 0,05
K.2	> 800 N/mm <sup>2</sup>	1xS	15 - 25	0,04 - 0,05
N.1	≤ 400 N/mm <sup>2</sup>	1xS	500 - 1000	0,03 - 0,07
N.2	≤ 600 N/mm <sup>2</sup>	1xS	120 - 200	0,03 - 0,06
N.4	≤ 800 N/mm <sup>2</sup>	1xS	100 - 400	0,04 - 0,06



For shallow grooves we recommend using product 722910  
For deeper grooves we recommend using product 722913.

**7229**

**7229**



D	S	d H 7	Z		722910	722913	D	S	d H 7	Z		722910	722913
			722910	722913						722910	722913		
20	0,15	5	80		.0200015		32	0,4	8	80		.0320040	
20	0,2	5	80		.0200020		32	0,5	8	80		.0320050	
20	0,25	5	64		.0200025		32	0,6	8	64		.0320060	
20	0,3	5	64		.0200030		32	0,7	8	64		.0320070	
20	0,4	5	64		.0200040		32	0,8	8	64		.0320080	
20	0,5	5	48		.0200050		32	0,9	8	64		.0320090	
20	0,6	5	48		.0200060		32	1	8	64		.0320100	
20	0,7	5	48		.0200070		32	1,2	8	48		.0320120	
20	0,8	5	48		.0200080		32	1,5	8	48		.0320150	
20	0,9	5	48		.0200090		32	1,6	8	48		.0320160	
20	1	5	40		.0200100		32	2	8	48		.0320200	
20	1,2	5	40		.0200120		32	2,5	8	40		.0320250	
20	1,5	5	40		.0200150		32	3	8	40		.0320300	
20	1,6	5	40		.0200160		32	4	8	40		.0320400	
20	2	5	32		.0200200		40	0,2	10	128		.0400020	
20	2,5	5	32		.0200250		40	0,25	10	100		.0400025	
20	3	5	32		.0200300		40	0,3	10	100		.0400030	
25	0,15	8	80		.0250015		40	0,4	10	100		.0400040	
25	0,2	8	80		.0250020		40	0,5	10	80		.0400050	
25	0,25	8	80		.0250025		40	0,6	10	80		.0400060	
25	0,3	8	80		.0250030		40	0,7	10	80		.0400070	
25	0,4	8	64		.0250040		40	0,8	10	80		.0400080	
25	0,5	8	64		.0250050		40	0,9	10	80		.0400090	
25	0,6	8	64		.0250060		40	1	10	64		.0400100	
25	0,7	8	64		.0250070		40	1,2	10	64		.0400120	
25	0,8	8	48		.0250080		40	1,6	10	64		.0400160	
25	0,9	8	48		.0250090		40	2	10	48		.0400200	
25	1	8	48		.0250100		40	2,5	10	48		.0400250	
25	1,2	8	48		.0250120		40	3	10	48		.0400300	
25	1,3	8	48		.0250150		50	0,2	13	128	48	.0500020	.0500020
25	1,6	8	40		.0250160		50	0,25	13	128	48	.0500025	.0500025
25	2	8	40		.0250200		50	0,3	13	128	48	.0500030	.0500030
25	2,5	8	40		.0250250		50	0,4	13	100	48	.0500040	.0500040
25	3	8	32		.0250300		50	0,5	13	100	48	.0500050	.0500050
32	0,15	8	100		.0320015		50	0,6	13	100	48	.0500060	.0500060
32	0,2	8	100		.0320020		50	0,7	13	100	48	.0500070	.0500070
32	0,25	8	100		.0320025		50	0,8	13	80	40	.0500080	.0500080
32	0,3	8	80		.0320030		50	0,9	13	80	40	.0500090	.0500090



# Metal slitting saws



722910

722913

- CZ** Pilové kotouče | na kovy
- DE** Metallkreissägeblätter
- RU** Фрезы отрезные

	Material	a <sub>e</sub>	v <sub>c</sub>	f <sub>z</sub>
P.1	≤ 600 N/mm <sup>2</sup>	1xS	25 - 50	0,03 - 0,06
P.2	≤ 850 N/mm <sup>2</sup>	1xS	15 - 30	0,03 - 0,04
P.3	≤ 1100 N/mm <sup>2</sup>	1xS	10 - 15	0,02 - 0,03
P.4	≤ 900 N/mm <sup>2</sup>	1xS	10 - 20	0,02 - 0,03
P.5	≤ 1100 N/mm <sup>2</sup>	1xS	10 - 15	0,02 - 0,03
P.6	> 1100 N/mm <sup>2</sup>	1xS	5 - 10	0,01 - 0,03
K.1	≤ 820 N/mm <sup>2</sup>	1xS	15 - 25	0,04 - 0,05
K.2	> 800 N/mm <sup>2</sup>	1xS	15 - 25	0,04 - 0,05
N.1	≤ 400 N/mm <sup>2</sup>	1xS	500 - 1000	0,03 - 0,07
N.2	≤ 600 N/mm <sup>2</sup>	1xS	120 - 200	0,03 - 0,06
N.4	≤ 800 N/mm <sup>2</sup>	1xS	100 - 400	0,04 - 0,06

**7229**

**7229**

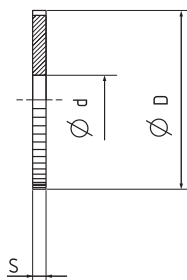
For shallow grooves we recommend using product 722910  
For deeper grooves we recommend using product 722913.

D	S	d H 7	Z		722910	722913	D	S	d H 7	Z		722910	722913
			722910	722913						722910	722913		
50	1	13	80	40	.0500100	.0500100	100	3,5	22	80	40	.1000350	.1000350
50	1,2	13	80	40	.0500120	.0500120	100	4	22	80	40	.1000400	.1000400
50	1,5	13	80	40	.0500150	.0500150	100	5	22	80	40	.1000500	.1000500
50	1,6	13	64	32	.0500160	.0500160	100	6	22	64	32	.1000600	.1000600
50	2	13	64	32	.0500200	.0500200	125	0,5	22	160	80	.1250050	.1250050
50	2,5	13	64	32	.0500250	.0500250	125	0,6	22	160	80	.1250060	.1250060
50	3	13	48	24	.0500300	.0500300	125	0,7	22	160	80	.1250070	.1250070
50	4	13	48	24	.0500400	.0500400	125	0,8	22	160	80	.1250080	.1250080
50	5	13	48	24	.0500500	.0500500	125	0,9	22	160	80	.1250090	.1250090
63	0,25	16	160	64	.0630025	.0630025	125	1	22	160	80	.1250100	.1250100
63	0,3	16	128	64	.0630030	.0630030	125	1,2	22	128	80	.1250120	.1250120
63	0,4	16	128	64	.0630040	.0630040	125	1,5	22	128	80	.1250150	.1250150
63	0,5	16	128	64	.0630050	.0630050	125	1,6	22	128	64	.1250160	.1250160
63	0,6	16	100	48	.0630060	.0630060	125	2	22	128	64	.1250200	.1250200
63	0,7	16	100	48	.0630070	.0630070	125	2,5	22	100	64	.1250250	.1250250
63	0,8	16	100	48	.0630080	.0630080	125	3	22	100	48	.1250300	.1250300
63	0,9	16	100	48	.0630090	.0630090	125	3,2	22	100	48	.1250320	.1250320
63	1	16	100	48	.0630100	.0630100	125	3,5	22	100	48	.1250350	.1250350
63	1,2	16	80	40	.0630120	.0630120	125	4	22	100	48	.1250400	.1250400
63	1,5	16	80	40	.0630150	.0630150	125	5	22	80	40	.1250500	.1250500
63	1,6	16	80	40	.0630160	.0630160	125	6	22	80	40	.1250600	.1250600
63	2	16	80	40	.0630200	.0630200	150	1	22	160	80	.1500100	.1500100
63	2,5	16	64	32	.0630250	.0630250	150	1,2	22	128	80	.1500120	.1500120
63	3	16	64	32	.0630300	.0630300	150	1,5	22	128	80	.1500150	.1500150
63	3,5	16	64	32	.0630350	.0630350	150	1,6	22	128	80	.1500160	.1500160
63	4	16	64	32	.0630400	.0630400	150	2	22	100	64	.1500200	.1500200
63	5	16	48	24	.0630500	.0630500	150	2,5	22	100	64	.1500250	.1500250
63	6	16	48	24	.0630600	.0630600	150	3	22	100	48	.1500300	.1500300
80	0,3	22	160	64	.0800030	.0800030	150	3,5	22	100	48	.1500350	.1500350
80	0,4	22	160	64	.0800040	.0800040	150	4	22	100	48	.1500400	.1500400
80	0,5	22	128	64	.0800050	.0800050	150	4,5	22	100	48	.1500450	.1500450
80	0,6	22	128	64	.0800060	.0800060	150	5	22	80	40	.1500500	.1500500
80	0,7	22	128	64	.0800070	.0800070	150	6	22	80	40	.1500600	.1500600
80	0,8	22	128	64	.0800080	.0800080	160	1	32	160	80	.1600100	.1600100
80	0,9	22	128	64	.0800090	.0800090	160	1,2	32	160	100	.1600120	.1600120
80	1	22	100	48	.0800100	.0800100	160	1,5	32	160	100	.1600150	.1600150
80	1,2	22	100	48	.0800120	.0800120	160	1,6	32	160	80	.1600160	.1600160
100	0,4	22	160	80	.1000040	.1000040	160	2	32	128	64	.1600200	.1600200
100	0,5	22	160	80	.1000050	.1000050	160	2,5	32	128	64	.1600250	.1600250
100	0,6	22	160	80	.1000060	.1000060	160	3	32	128	64	.1600300	.1600300
100	0,7	22	160	64	.1000070	.1000070	160	3,5	32	128	64	.1600350	.1600350
100	0,8	22	128	64	.1000080	.1000080	160	4	32	100	48	.1600400	.1600400
100	0,9	22	128	64	.1000090	.1000090	160	4,5	32	100	48	.1600450	.1600450
100	1	22	128	64	.1000100	.1000100	160	5	32	100	48	.1600500	.1600500
100	1,2	22	128	64	.1000120	.1000120	160	6	32	100	48	.1600600	.1600600
100	1,5	22	128	48	.1000150	.1000150	200	1	32	200	100	.2000100	.2000100
100	1,6	22	100	48	.1000160	.1000160	200	1,2	32	200	80	.2000120	.2000120
100	2	22	100	48	.1000200	.1000200	200	1,5	32	200	80	.2000150	.2000150
100	2,5	22	100	48	.1000250	.1000250	200	1,6	32	200	80	.2000160	.2000160
100	3	22	80	40	.1000300	.1000300	200	1,8	32	160	80	.2000180	.2000180



# Metal slitting saws

**CZ** Pilové kotouče | na kovy  
**DE** Metallkreissägeblätter  
**RU** Фрезы отрезные



Material	$a_e$	$v_c$	$f_z$
P.1 $\leq 600 \text{ N/mm}^2$	1xS	25 - 50	0,03 - 0,06
P.2 $\leq 850 \text{ N/mm}^2$	1xS	15 - 30	0,03 - 0,04
P.3 $\leq 1100 \text{ N/mm}^2$	1xS	10 - 15	0,02 - 0,03
P.4 $\leq 900 \text{ N/mm}^2$	1xS	10 - 20	0,02 - 0,03
P.5 $\leq 1100 \text{ N/mm}^2$	1xS	10 - 15	0,02 - 0,03
P.6 $> 1100 \text{ N/mm}^2$	1xS	5 - 10	0,01 - 0,03
K.1 $\leq 820 \text{ N/mm}^2$	1xS	15 - 25	0,04 - 0,05
K.2 $> 800 \text{ N/mm}^2$	1xS	15 - 25	0,04 - 0,05
N.1 $\leq 400 \text{ N/mm}^2$	1xS	500 - 1000	0,03 - 0,07
N.2 $\leq 600 \text{ N/mm}^2$	1xS	120 - 200	0,03 - 0,06
N.4 $\leq 800 \text{ N/mm}^2$	1xS	100 - 400	0,04 - 0,06

DIN 1837A
H
DIN 1838B
N
HSS

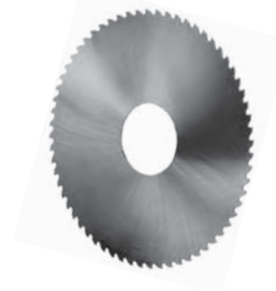
722910

722913

**7229**

**7229**

For shallow grooves we recommend using product 722910  
 For deeper grooves we recommend using product 722913.



D	S	d H 7	Z		722910	722913	D	S	d H 7	Z		722910	722913
			722910	722913						722910	722913		
200	2	32	160	80	.2000200	.2000200	250	4	32	160	80	.2500400	.2500400
200	2,5	32	160	80	.2000250	.2000250	250	4,5	32	160	80	.2500450	.2500450
200	3	32	160	64	.2000300	.2000300	250	5	32	128	64	.2500500	.2500500
200	3,5	32	128	64	.2000350	.2000350	250	5,5	32	128	64	.2500550	.2500550
200	4	32	128	64	.2000400	.2000400	250	6	32	128	64	.2500600	.2500600
200	4,5	32	128	64	.2000450	.2000450	275	1,75	32	200	100	.2750175	.2750175
200	5	32	128	64	.2000500	.2000500	275	2	32	200	100	.2750200	.2750200
200	5,5	32	128	64	.2000550	.2000550	275	2,5	32	160	80	.2750250	.2750250
200	6	32	128	48	.2000600	.2000600	275	3	32	160	80	.2750300	.2750300
225	1,5	32	200	80	.2250150	.2250150	275	3,5	32	160	80	.2750350	.2750350
225	1,6	32	200	80	.2250160	.2250160	285	2	32	200	100	.2850200	.2850200
225	1,8	32	200	80	.2250180	.2250180	300	2	32	200	100	.3000200	.3000200
225	2	32	160	80	.2250200	.2250200	300	2,5	32	200	80	.3000250	.3000250
225	2,5	32	160	80	.2250250	.2250250	300	3	32	200	80	.3000300	.3000300
225	3	32	160	64	.2250300	.2250300	300	3,5	40	200	80	.3000350	.3000350
225	3,5	32	160	64	.2250350	.2250350	315	2	40	200	100	.3150200	.3150200
225	4	32	128	64	.2250400	.2250400	315	2,5	40	200	100	.3150250	.3150250
250	1,5	32	200	100	.2500150	.2500150	315	3	40	200	100	.3150300	.3150300
250	1,6	32	200	100	.2500160	.2500160	315	4	40	160	80	.3150400	.3150400
250	2	32	200	100	.2500200	.2500200	315	4,5	40	160	80	.3150450	.3150450
250	2,5	32	160	80	.2500250	.2500250	315	5	40	160	80	.3150500	.3150500
250	3	32	160	80	.2500300	.2500300	315	6	40	160	80	.3150600	.3150600
250	3,5	32	160	80	.2500350	.2500350							

722910

P.1	P.2	P.3	P.4	P.5	P.6	K.1	K.2	M.1	M.2	M.3	N.4	N.1	N.2	N.3
-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----

722913

P.1	P.2	P.3	P.4	P.5	P.6	K.1	K.2	M.1	M.2	M.3	N.4	N.1	N.2	N.3
-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----